PEGASUS®

SOH-300

INSTRUCTIONS
SOH-300 Series
Integrated sewing unit for hemming flat sleeves and/or bottoms.

CONTENTS

SOH
-300 Series
Integrated sewing unit for hemming
flat sleeves and/or bottoms

Installation

Installing the sewing machine

1. To install the sewing machine •Place the unit on the level surface of the floor.

4) Mount the machine head.

3) Place the cushion rubbers.

2) Draw out the machine rest board in the direction of the arrow.

1) Pull up the knob.

5) Place the V belt on the machine pulley.

6) Install the belt cover.

7) Install the moter cover.

2

Installing the accessories
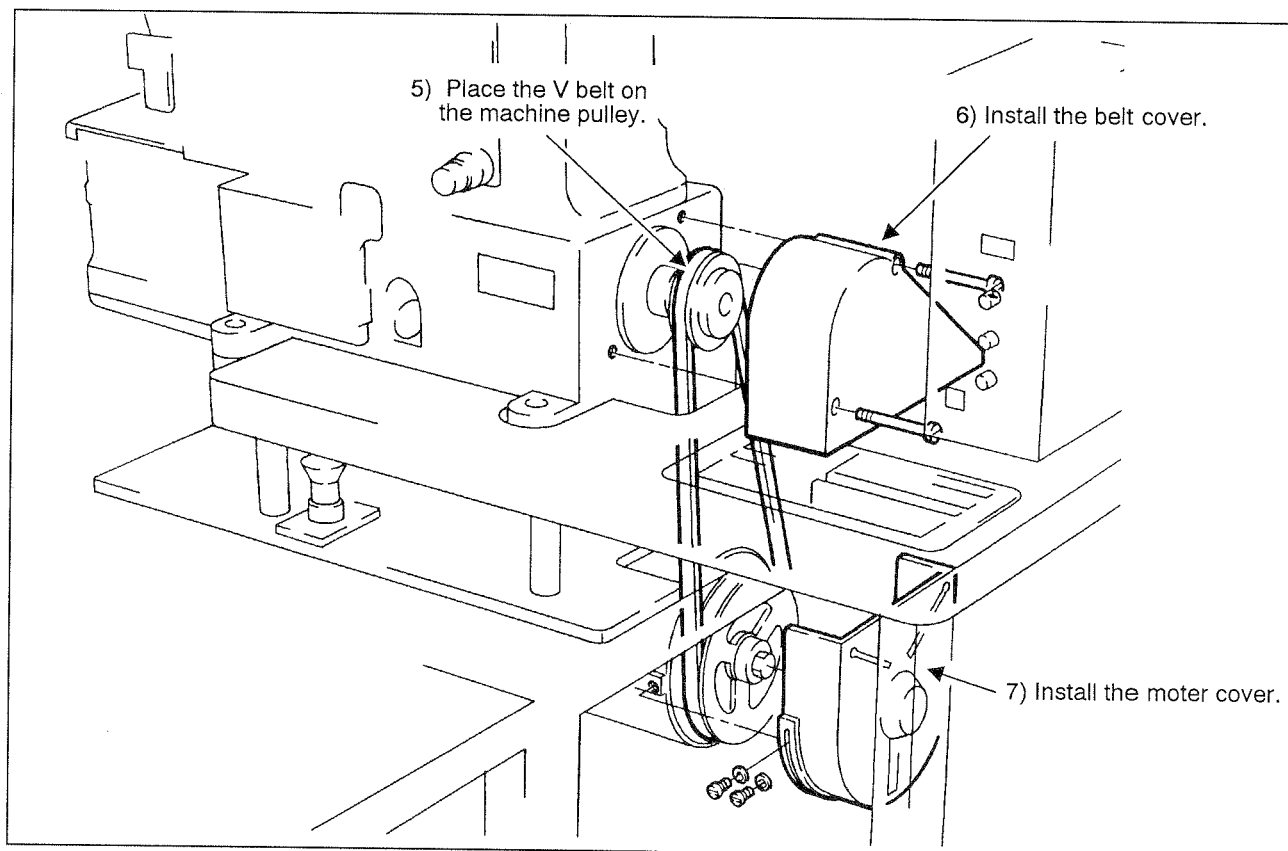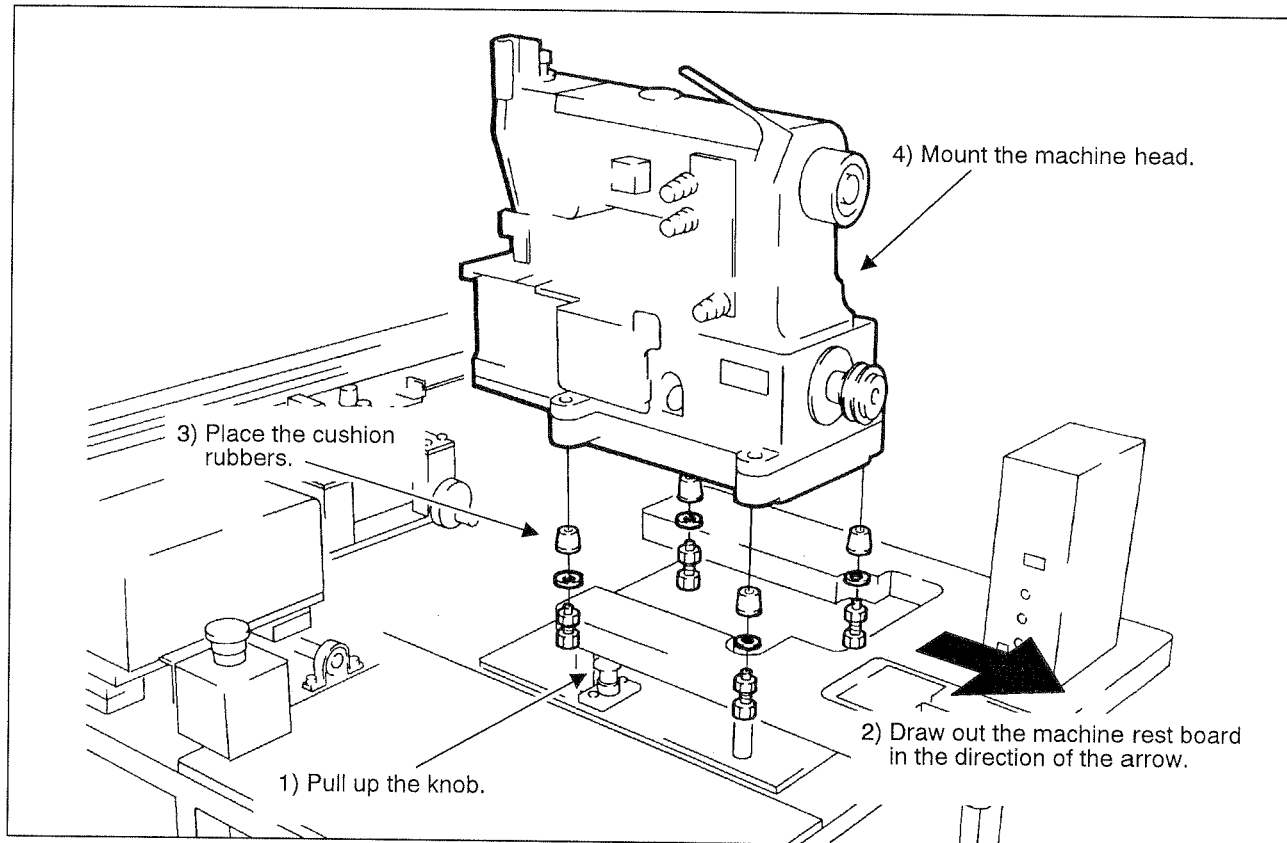
2. To install the positioner

Install the positioner. Refer to sequence ① to ⑤ (see below). Secure pin screw ① with nut ②.
Connect the plug. Refer to the wiring diagram on pages 8 and 9.
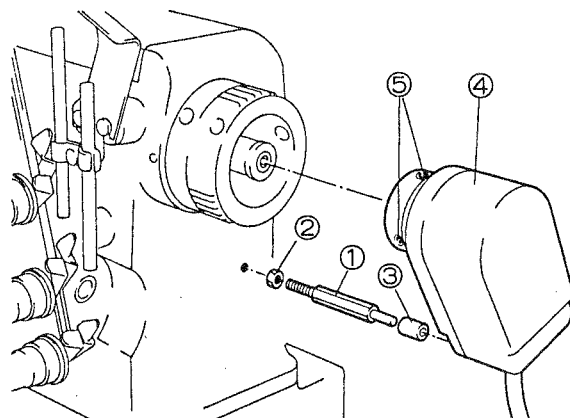
3. To install the body stacker sensor for the SOH-320

Connect the plug. Refer to the wiring diagram on page 9.

Set screws

Body stacker sensor
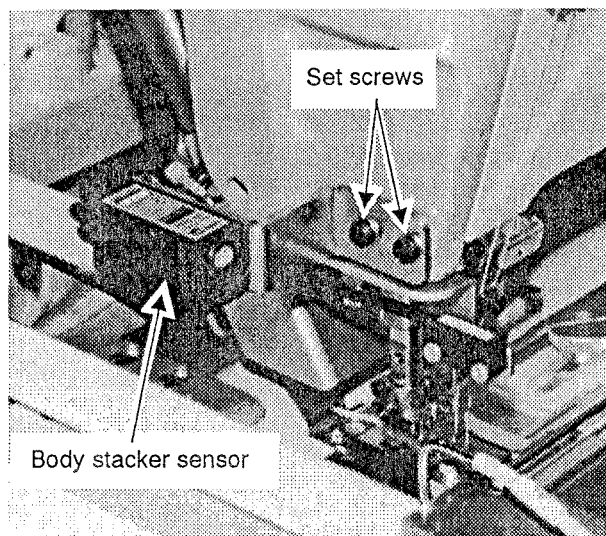
To install the sleeve stacker sensor (optional)

Connect the plug. Refer to the wiring diagram on pages 8 and 9.

Set screws

Sleeve stacker sensor
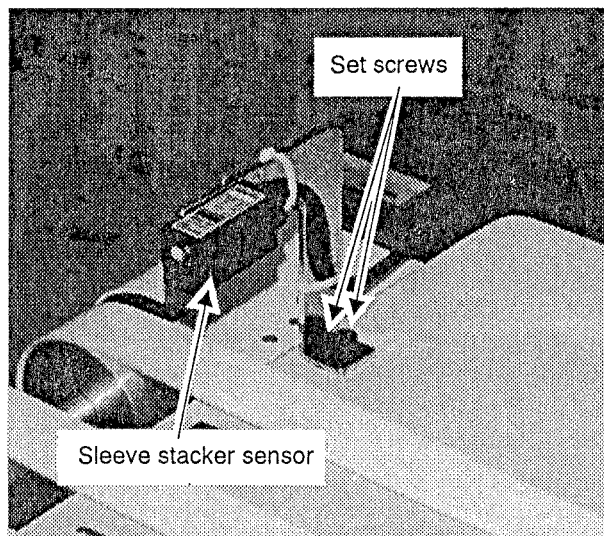
4. To install the foot lift cylinder

Install the foot lift cylinder. Refer to sequence ① to ④ shown below.
Connect the air line to ⑤. Refer to the air line connecting diagram on page 11.

3
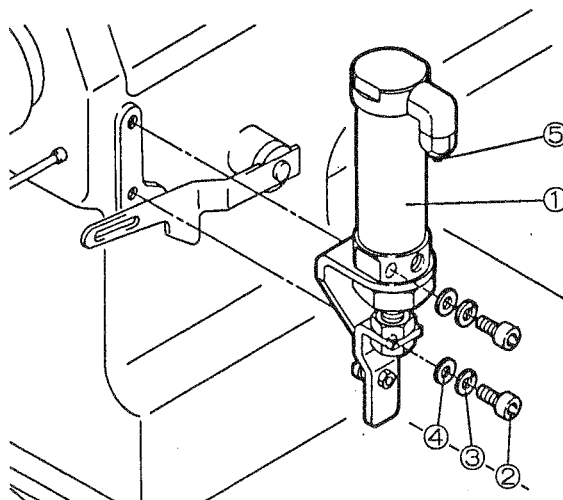
5.To connect the rotation detector relay cord
Connect the plug. Refer to the wiring diagram on pages 8 and 9.

Rotation detector
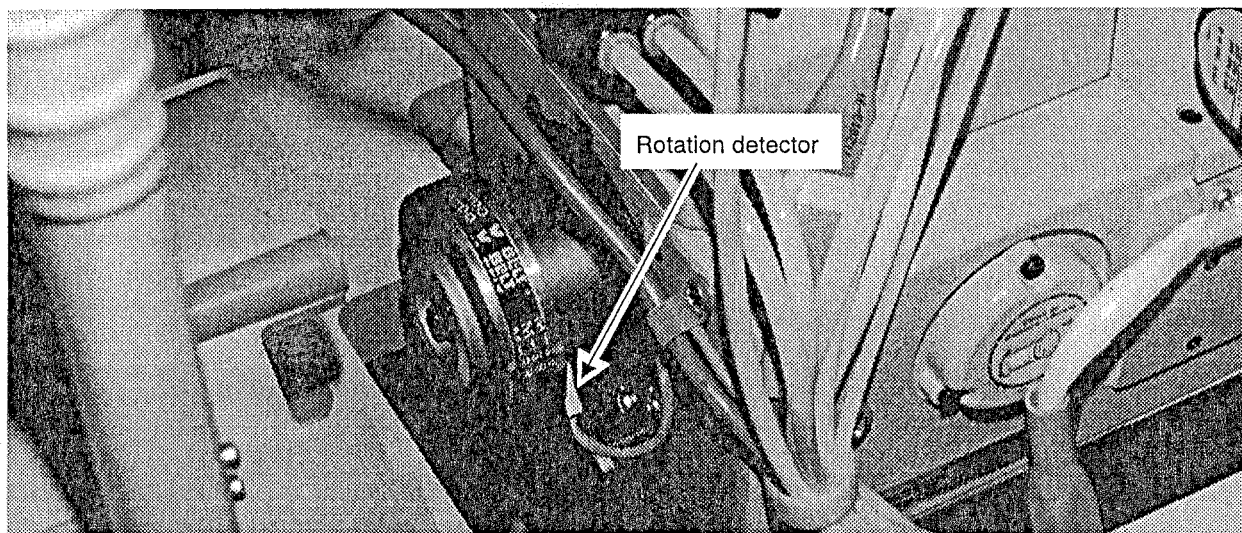
6.To connect the fabric (AT/SC) sensor relay cord
Connect the plug. Refer to the wiring diagram on pages 8 and 9.

Fabric (AT/SC) sensor
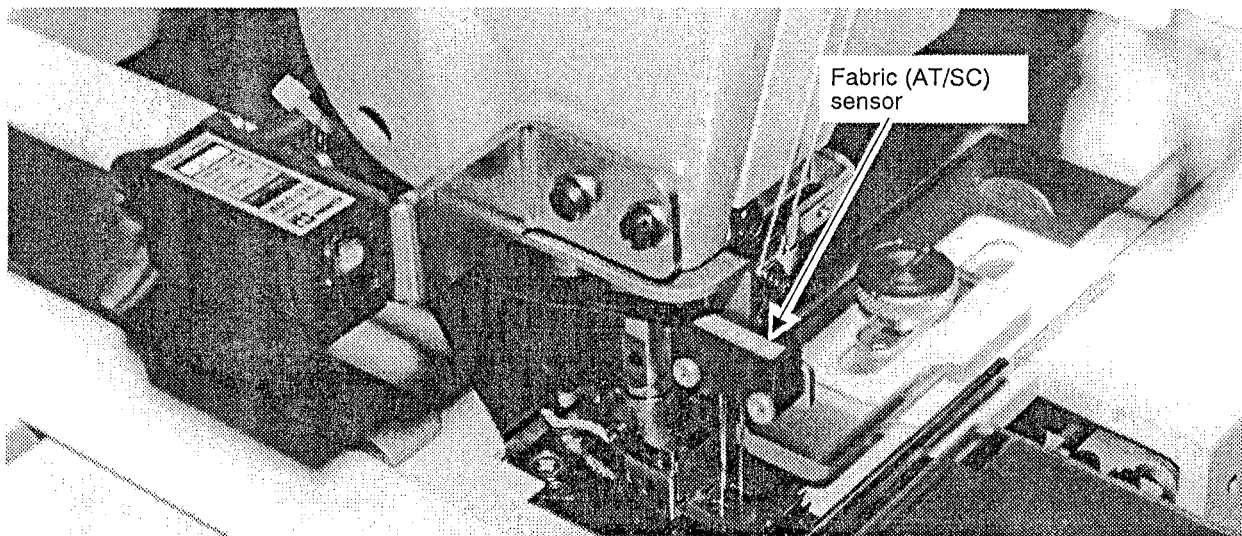
7.To install the controller
Connect the plug. Refer to the wiring diagram on pages 8 and 9.

Controller
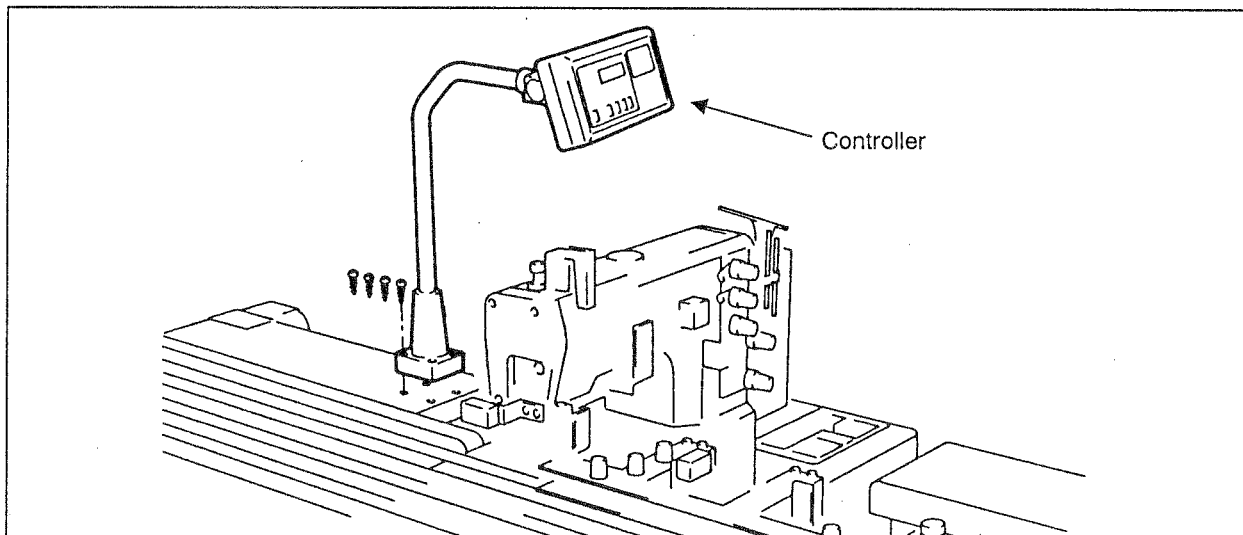
8. To install the thread stand

Thread stand
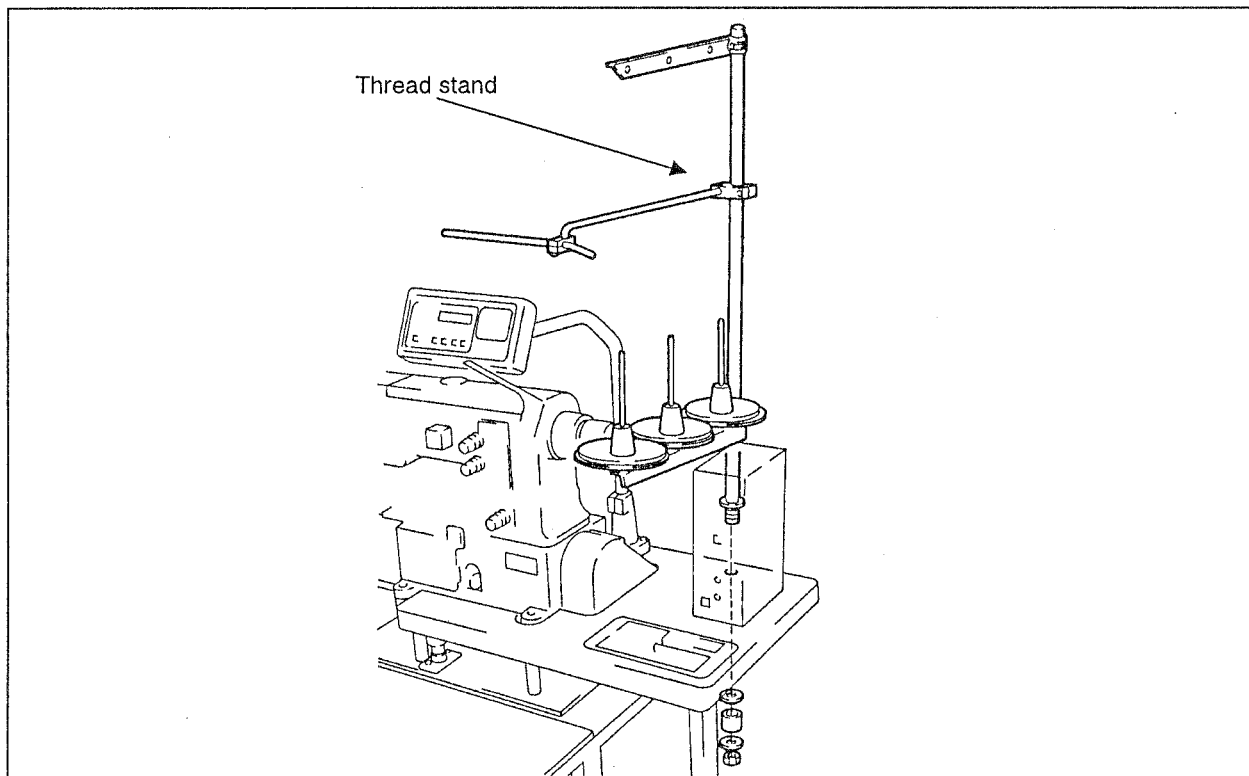
9. To install the TW device (optional)
Connect the plug. Refer to the wiring diagram on pages 8 and 9.

Sensors

Set screws
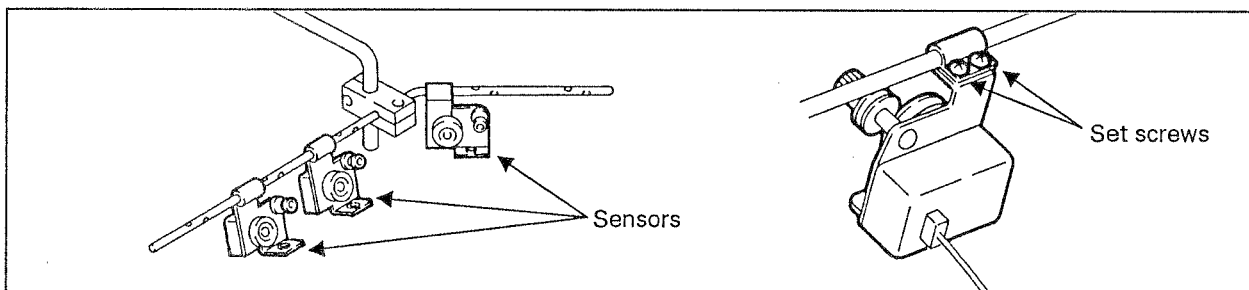
10. To adjust the height of the unit

Adjust the height of the unit so that it will be level with the ground.

Lock nut

Adjusting nut
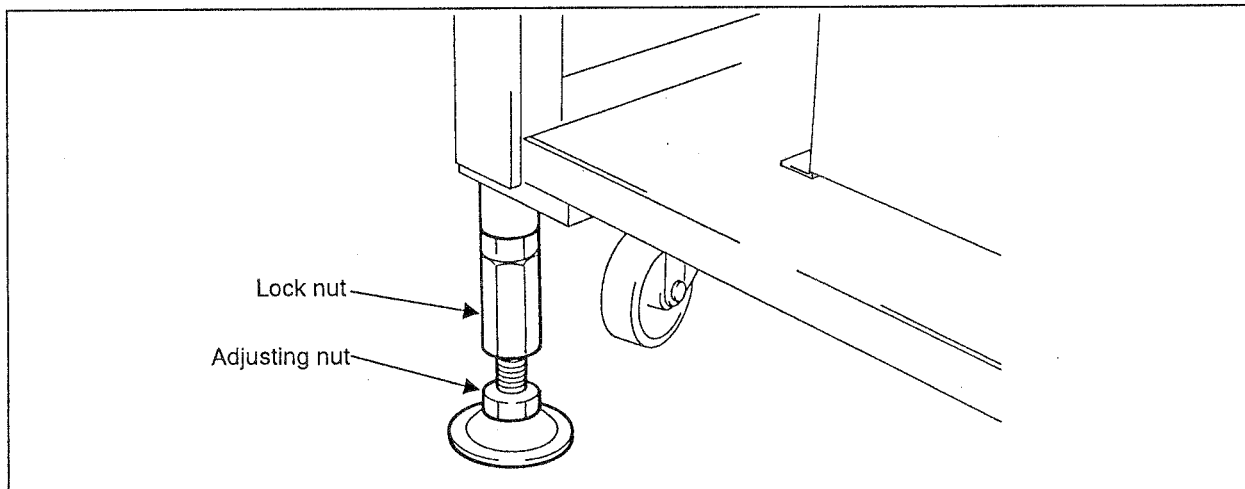
11. To install the body stacker for the SOH-320

Connect the air lines for the body stacker. Refer to the air line connecting diagram on page 11.
Adjust the height of the body stacker so that it will be flush with the unit.

Body stacker

Adjust the height (see No.10).
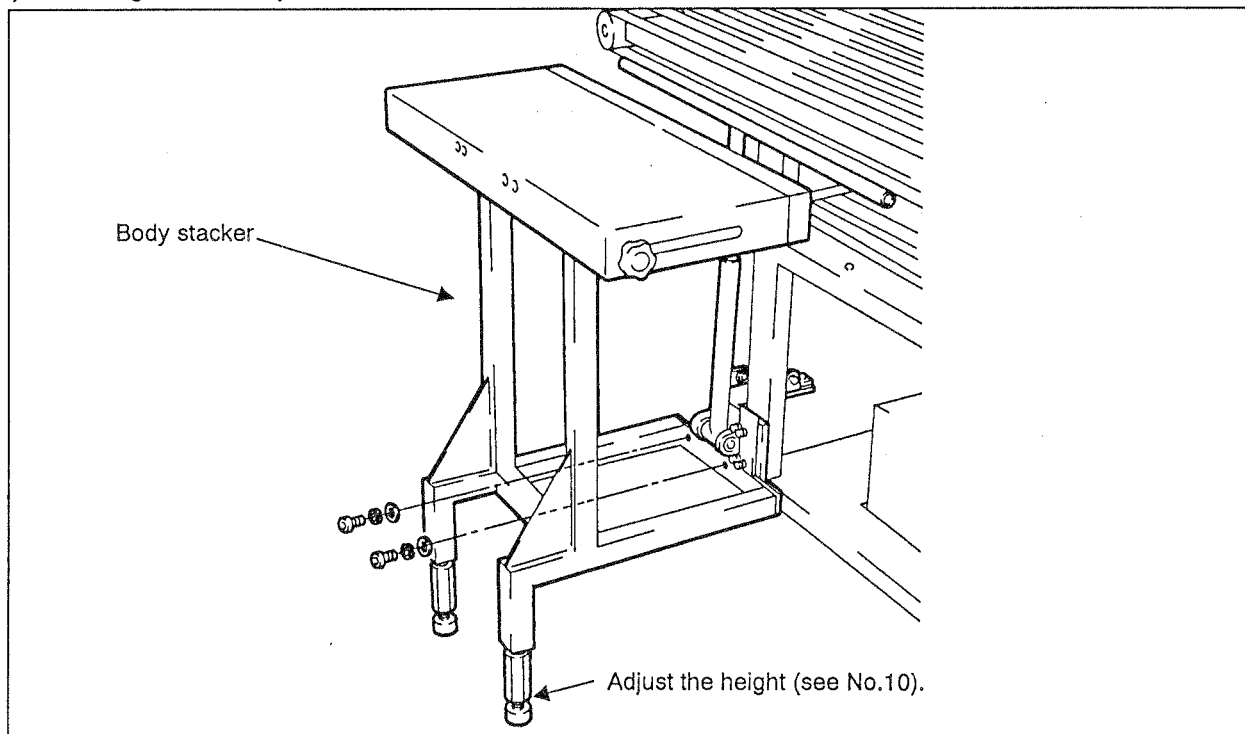
12. To connect the air lines for the dust drum

Connect the air lines for the dust drum. Refer to the air line connecting diagram on page 11.

6

13.To install the pillow cover and the fabric edge guide plate

1. Install the pillow cover.
2. Install the fabric edge guide plate.

Fabric edge guide plate

Set screws

Set screws

Pillow cover
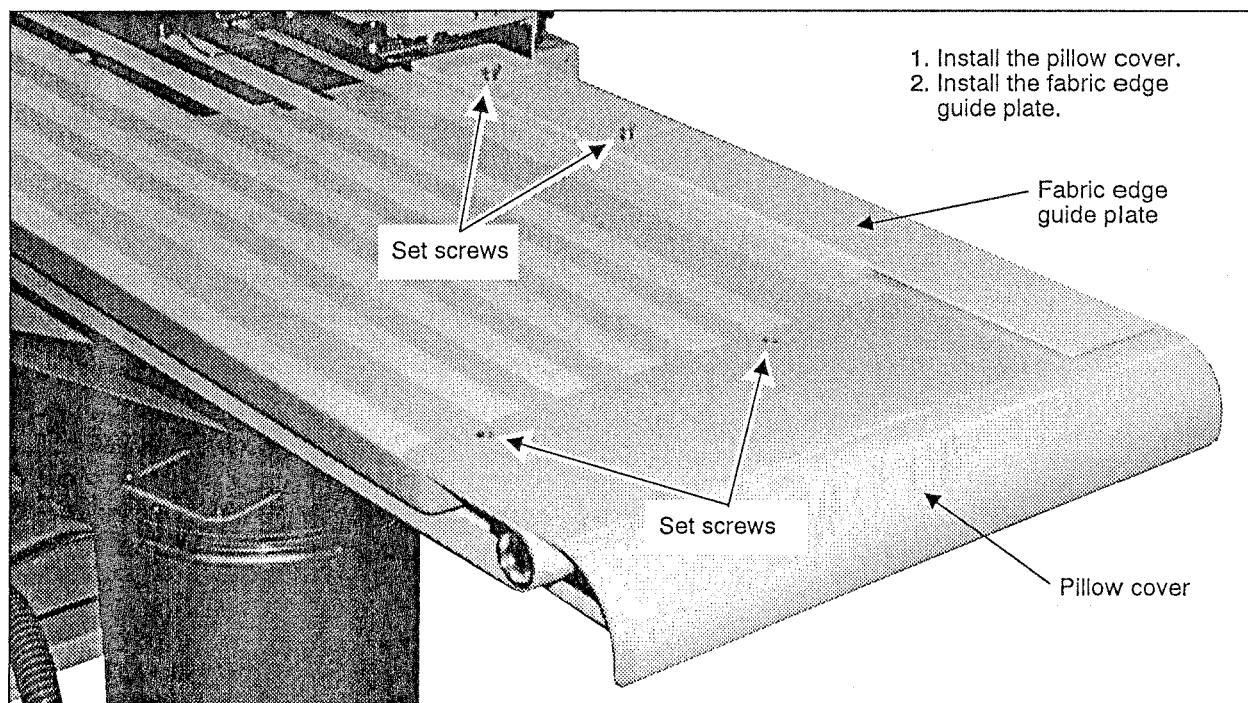
14.To connect the foot switches (green, black)

Foot switch (green)

Foot switch (black)

Connect the foot switch (black).

Connect the foot switch (green).

7
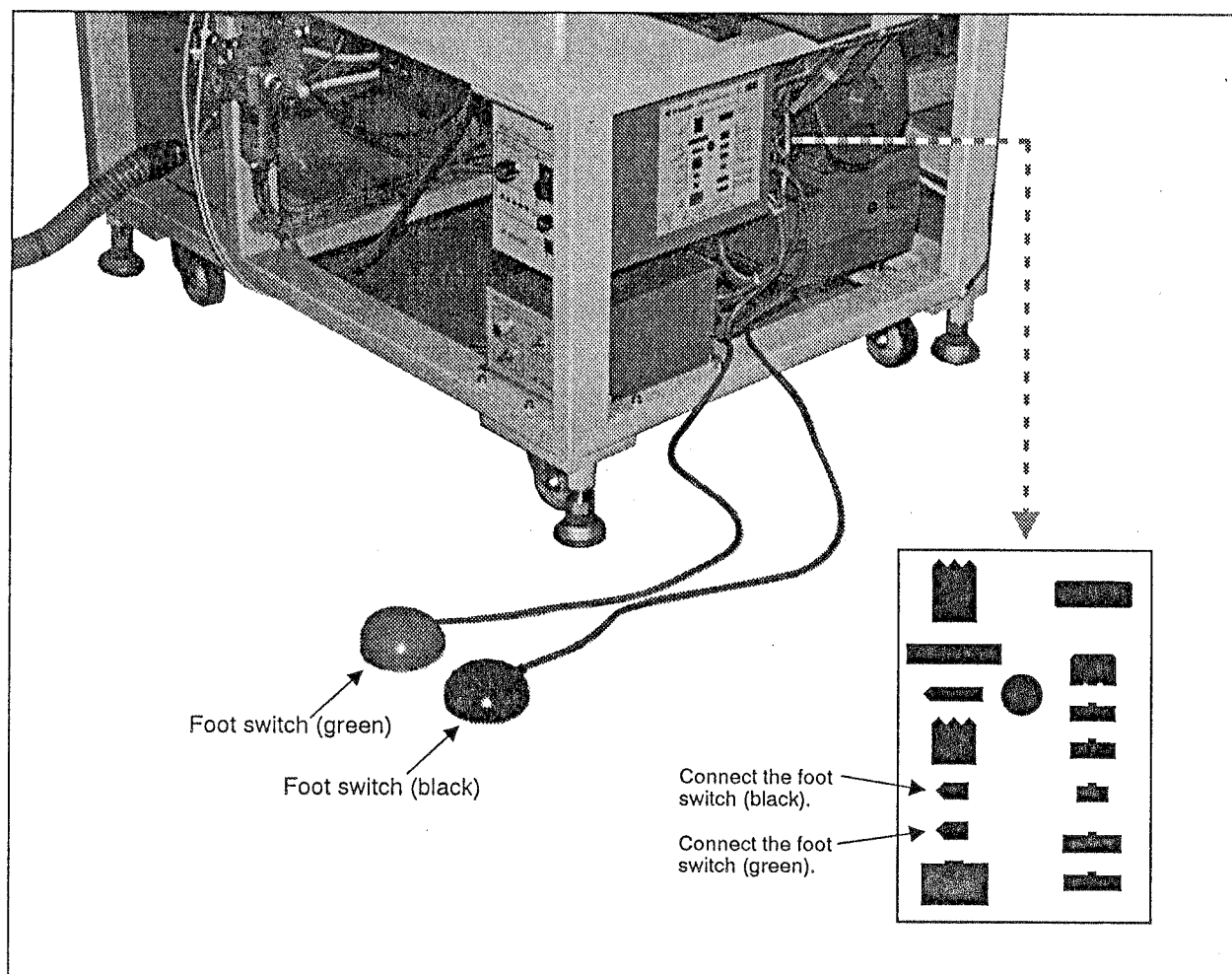
Wiring diagram (SOH-310)

⚠ The cords and connectors are color- and shape-coded.
Always shut off the power first and then connect the cords to the connectors while checking each color and shape.
See below.

To TW sensor

TW controller (optional)

Controller

Fabric feed belt drive motor

Sleeve stacker sensor (optional)

Positioner

Rotation detector

Safety switch

Emergency stop button

AT/SC sensor

Start sensor

Fabric trimmer drive motor

Solenoid valves (see page 10 for details)

Power box

Foot switch (black)

Foot switch (green)

Control box

Power relay box

Power switch for the unit

Machine motor

8

⚠ The cords and connectors are color‑ and shape‑coded.
Always shut off the power first and then connect the cords to the connectors while checking each color and shape.
See below.

To TW sensor

Fabric belt drive motor

Sleeve stacker sensor (optional)

Body stacker sensor

Controller

Positioner

Rotation detector

Safety switch

Emergency stop button

TW controller (optional)

AT/SC sensor

Start sensor

Fabric trimmer drive motor

Selection switches

Solenoid valves (see page 10 for details)

Power box

Foot switch (black)

Foot switch (green)

Control box

Power relay box

Machine motor

Power switch for the unit

9

Wiring diagram for the solenoid valves

⚠️ The cords and connectors are color- and shape-coded.
Always shut off the power first and then connect the cords to the connectors while checking each color and shape.
See below.

SOH — 310
Wiring diagram for the
solenoid valves

S1(optional)

SC Thread releaser	AT Cutter 1	ST Stacker 2	KS Thread chain suction		PL Foot lift	Air blower (front)	Air blower (front)	Air blower (back)
21 22	○ 19	14 15	13,25		12	6,7 11	1~5 9,10	8

Terminal board for the solenoid valves

1 C 2 C 3 C 4 C 5 C 6 C 7 C 8 C 9 C 10 C 11 C

White / Red   White / Red   Blue Brown   White Green   Purple Black   Gray Yellow   Red

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SOH — 320
Wiring diagram for
the solenoid valves

SOH — 321

SOH — 321 S1(optional)

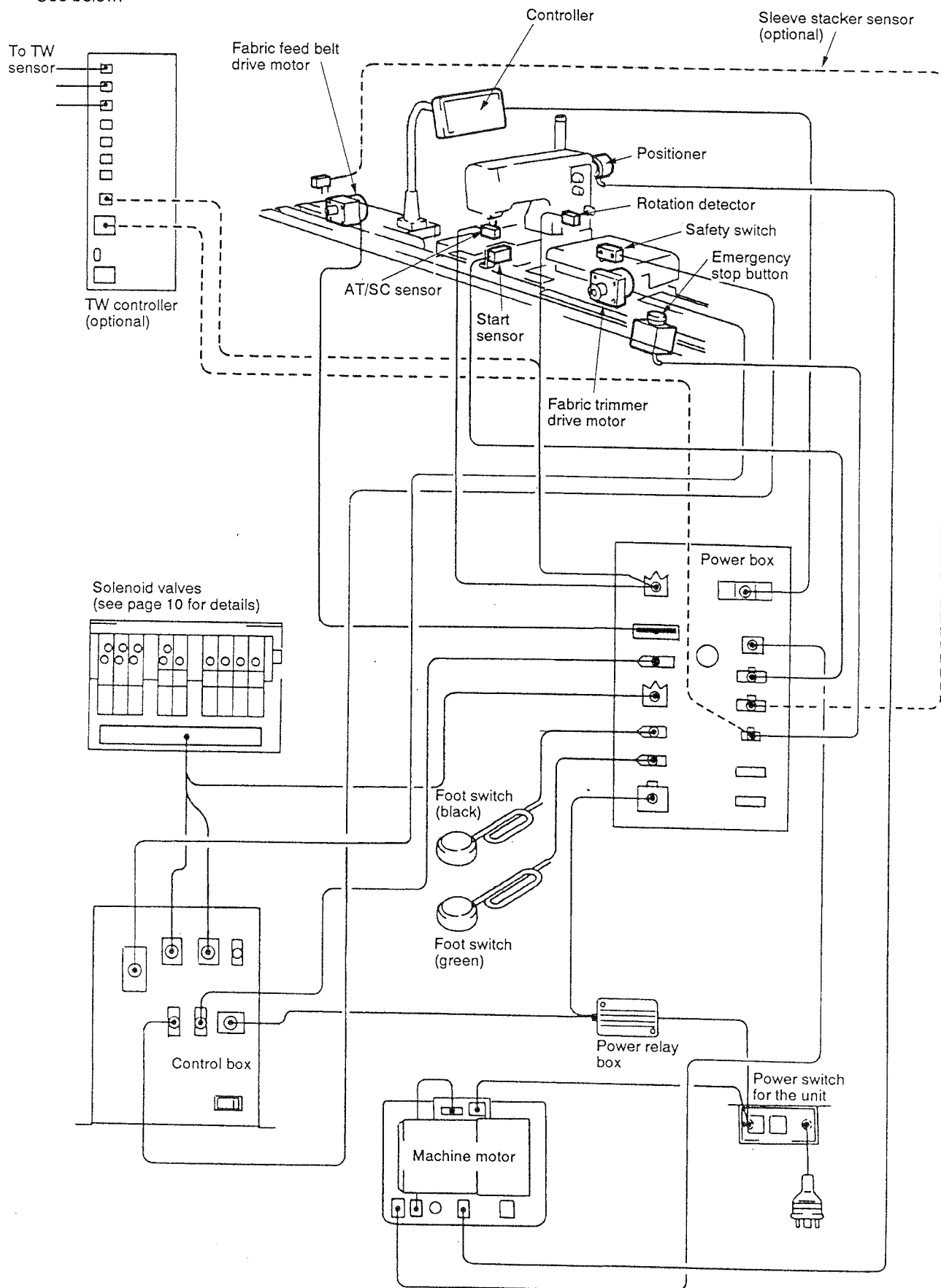| Stacker 1 Air blower	SC Thread releaser	AT Cutter 1	ST Stacker 1	ST Stacker 2	KS Thread chain suction		PL Foot lift	Air blower (front)	Air blower (front)	Air blower (back)
20	21 22	○ 19	16 17	14 15	13,25		12	6,7 11	1~5 9,10	8

Terminal board for the solenoid valves

1 C 2 C 3 C 4 C 5 C 6 C 7 C 8 C 9 C 10 C 11 C

To stacker selection switches

Red
White
Black

White / Red   White / Red   Red   Brown   Blue Brown   White Green   Purple Black   Gray Yellow   Red

⚠ Always turn off the power first and then connect the air lines (see below). Be sure to connect all the air lines before connecting them to the air source.

PL

⑫

⑲ AT

SC

Dust drum

Looper thread take-up

Speed controller

① ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ ⑩ ㉕

⑦

⑨
⑩

⑧

⑥

⑤

⑪

④
③
①

②

Speed controllers

Body stacker (ST1)

⑯
⑰

⑳

ST1
Air blower

S C / A T / S T 1   K S   P L   ② ⑦ ⑪ ⑩   ① ⑤ ⑨ ⑭   ⑧

To compressor

11

Air line connecting diagram
Sleeve stacker (optional)

⚠️ Always turn off the power first and then connect the air lines (see below). Be sure to connect all the air lines before connecting them to the air source.

Function of the air blowers
(cause of trouble)

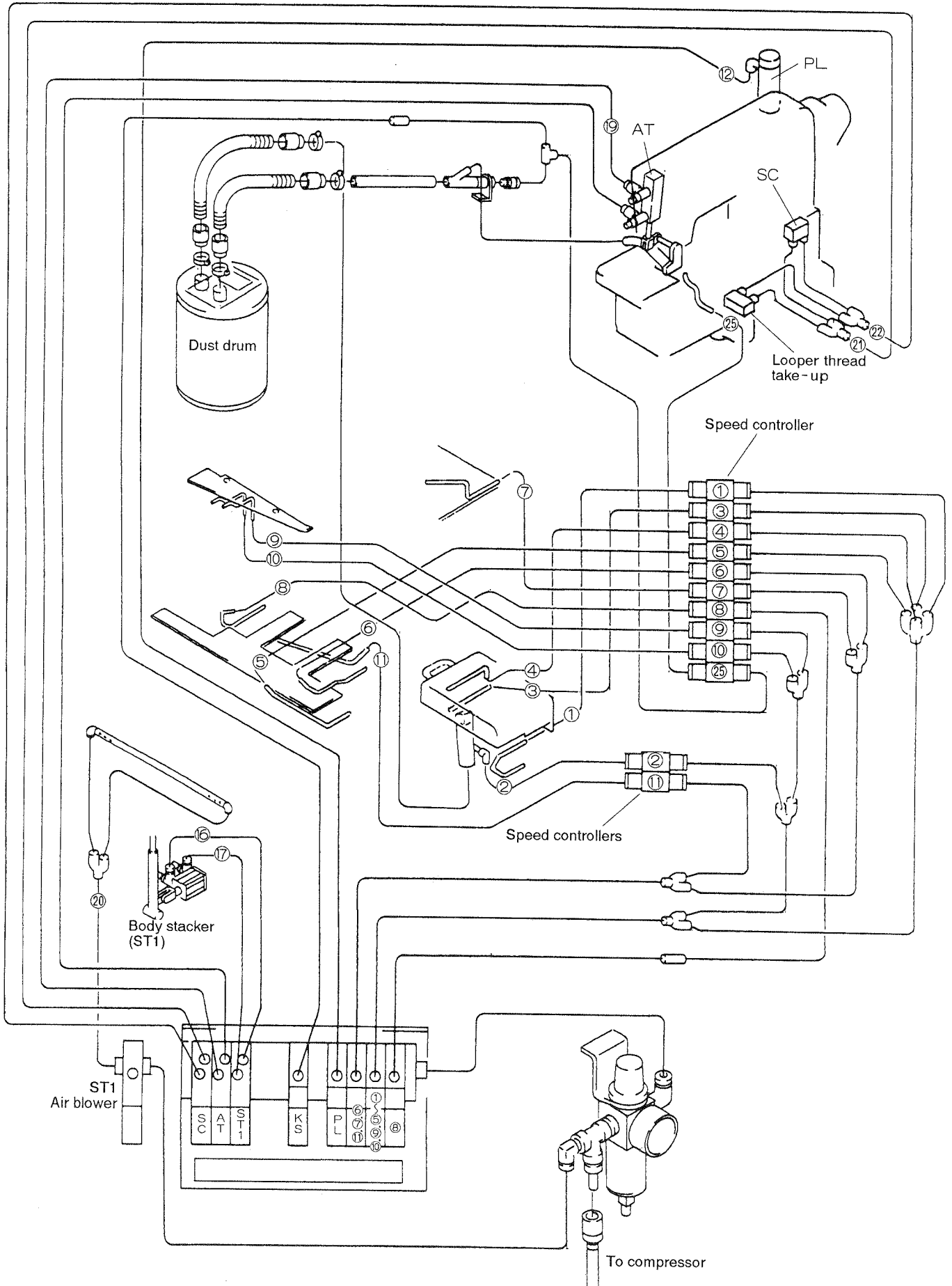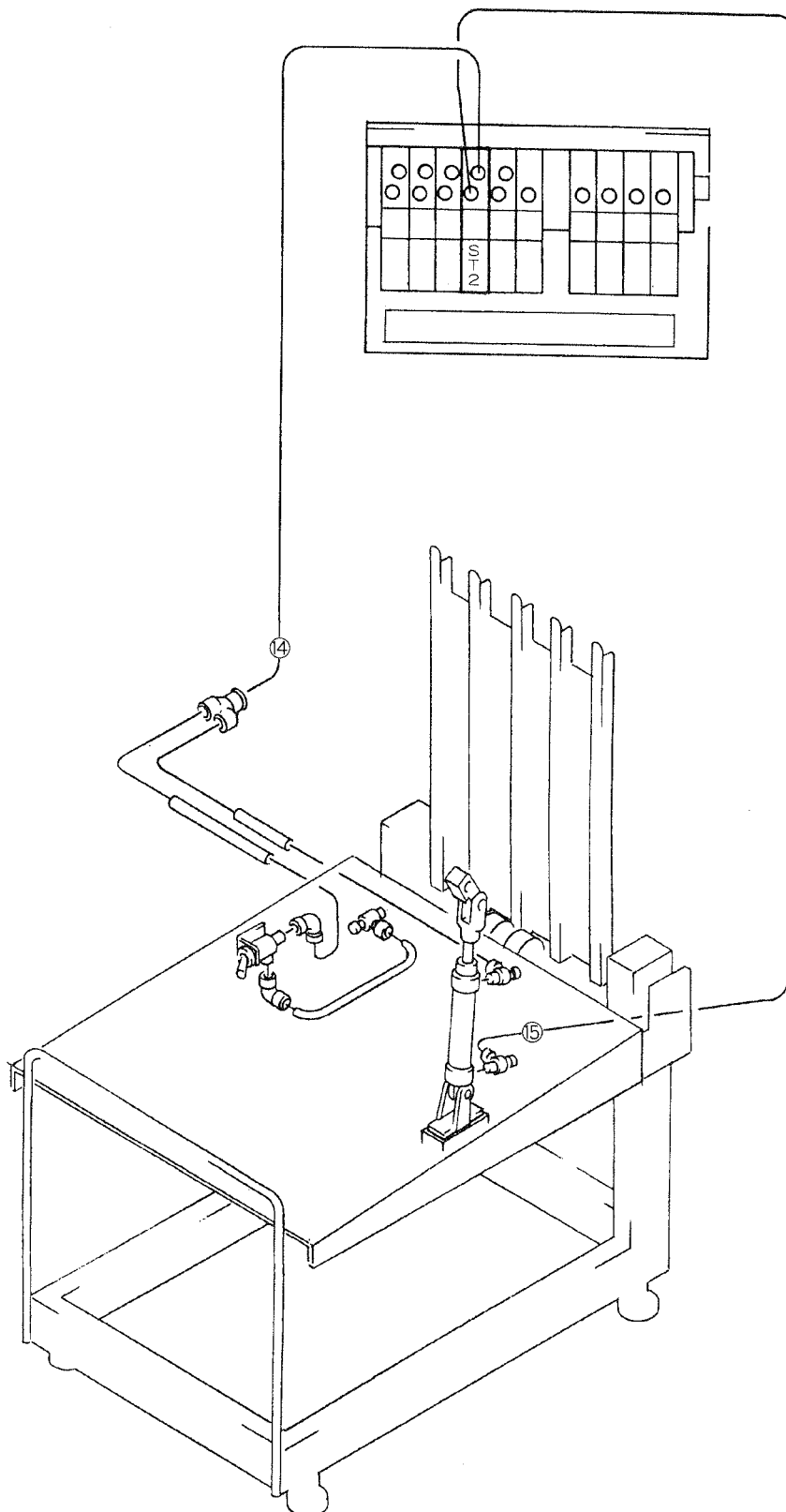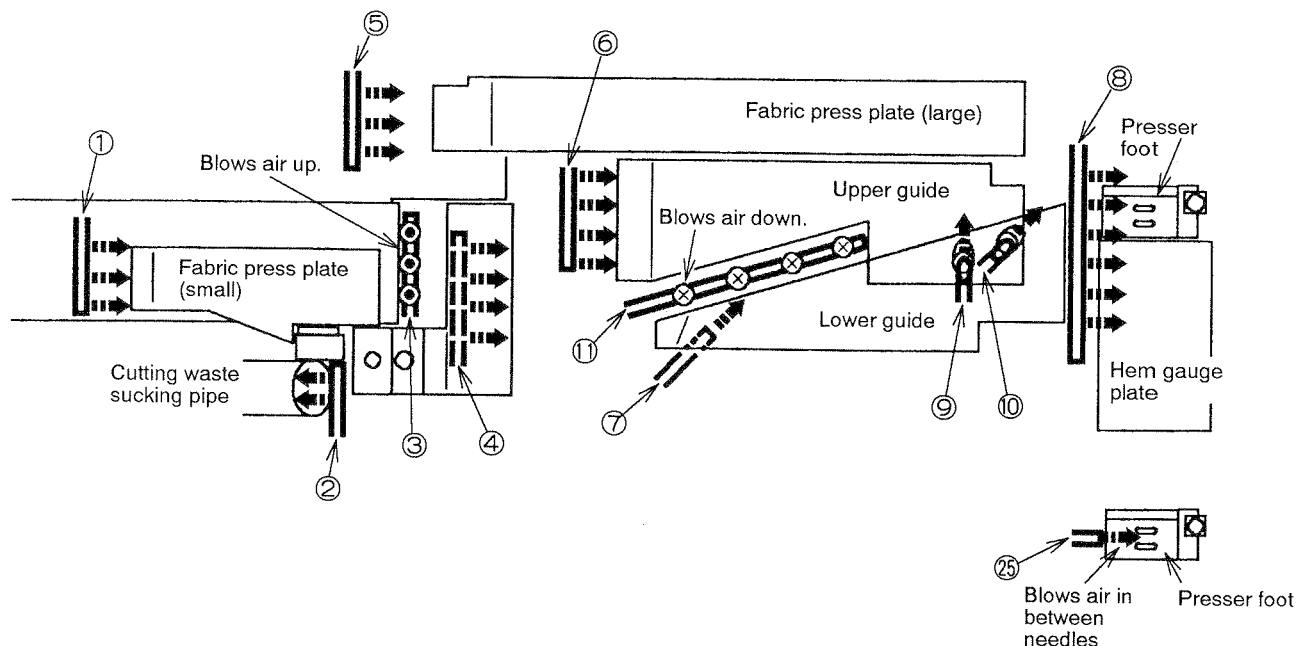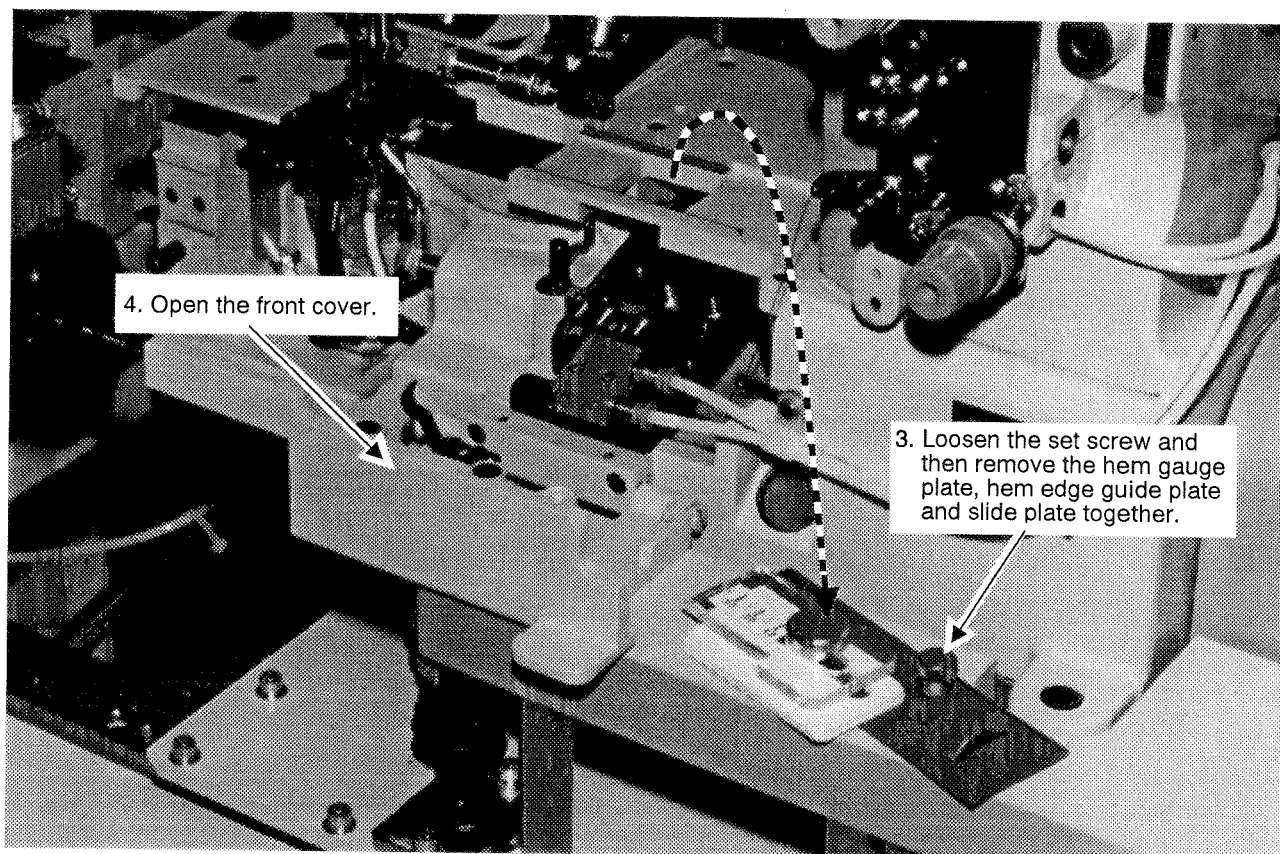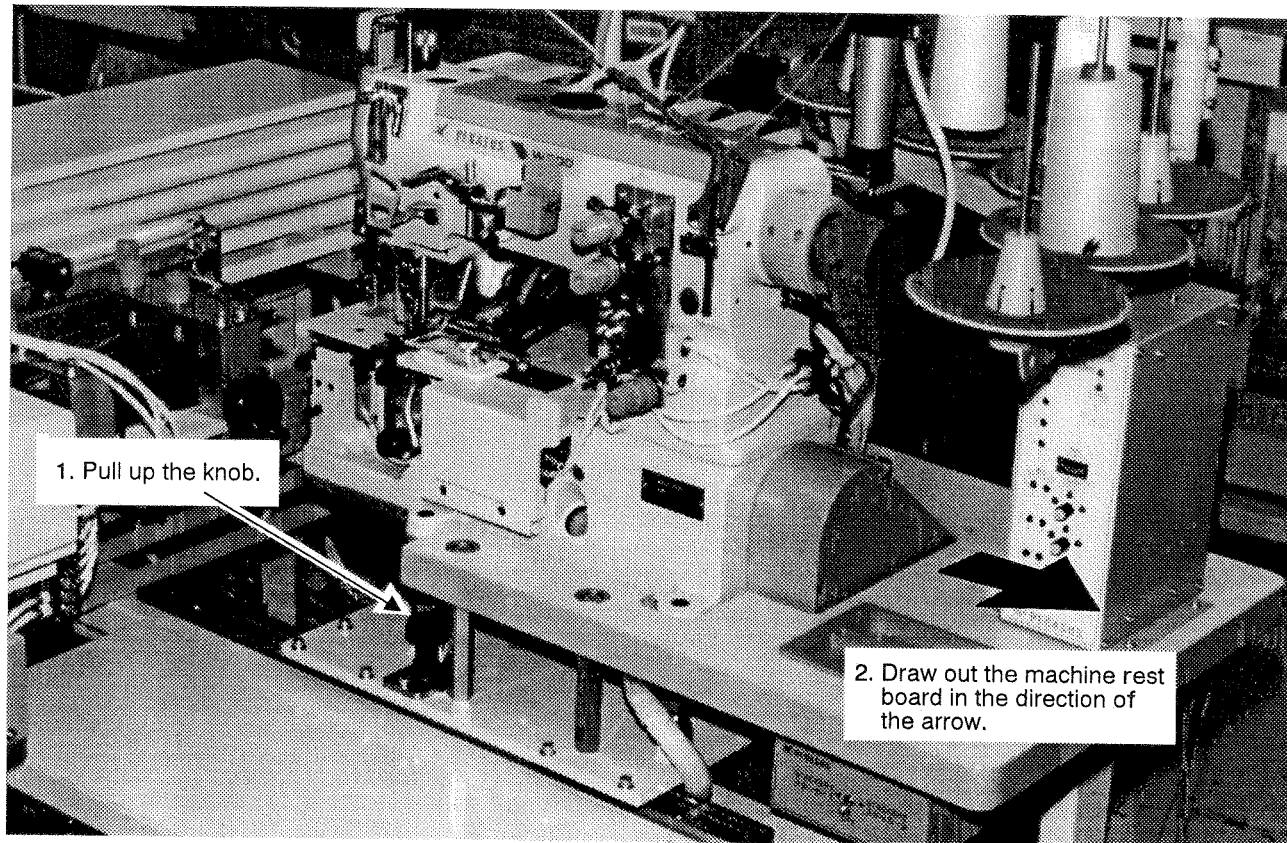To adjust the air blowing pressure, turn the knob which has the same number as on the air blower to be adjusted (the numbered label is attached on each speed controller). See page 11. * Speed controller ⑬ is on the rear side of the machine.

NO.	Function of air blower	Blowing pressure is too heavy.	Blowing pressure is too light.
① ⑤ ⑥	Prevents the fabric from curling so that the fabric can go through each guide smoothly.	The rear end of the fabric is tuned up, so the fabric cannot go through each guide easily.	The fabric is curled, so it cannot go through each guide.
②	Sucks up cutting wastes.	The fabric edge is not evenly trimmed.	Sucks up no cutting wastes.
③	Prevents the fabric from being caught in the belt.	The fabric is fluttered, so it cannot be fed accurately.	The fabric is caught in the belt.
④	Prevents the end of the fabric from being rolled down when the fabric is going under the guide.	The fabric is fluttered, so it cannot be fed accurately.	The end of the fabric is rolled down.
⑦	Prevents the fabric from curling. Feeds the fabric.	The fabric is fluttered, so the hem is not evenly formed.	The fabric is curled.
⑧	Makes the fabric go through the presser foot and the hem gauge plate easily.	The hem is not accurately formed at the start of sewing.	The fabric does not go through the presser foot and the hem gauge plate smoothly.
⑨	Makes the folded fabric tightly touch the middle guide plate in order to form the hem accurately.	The lower fabric is not sewn to the upper fabric correctly at the start of sewing.	The fabric is not folded correctly at the start of sewing, so the hem is not formed accurately.
⑩	Feeds the upper and lower plys correctly.	The lower fabric is not sewn to the upper fabric neatly at the start of sewing.	The fabric is not folded correctly at the start of sewing, so the hem is not formed accurately.
⑪	Folds the fabric neatly.	The fabric is fluttered, so the hem is not formed accurately.	The fabric rides up on the lower guide plate.
㉕	Forms the needle thread loop correctly when the thread chain is produced.	The needle thread loop is fluttered, so the thread chain is not produced neatly.	The needle thread loop is not formed correctly, so the thread chain is not produced neatly.

⚠️Always turn off the power first and then thread the machine correctly.

1. Pull up the knob.

2. Draw out the machine rest board in the direction of the arrow.

4. Open the front cover.

3. Loosen the set screw and then remove the hem gauge plate, hem edge guide plate and slide plate together.

14

Thread the machine correctly as shown below.
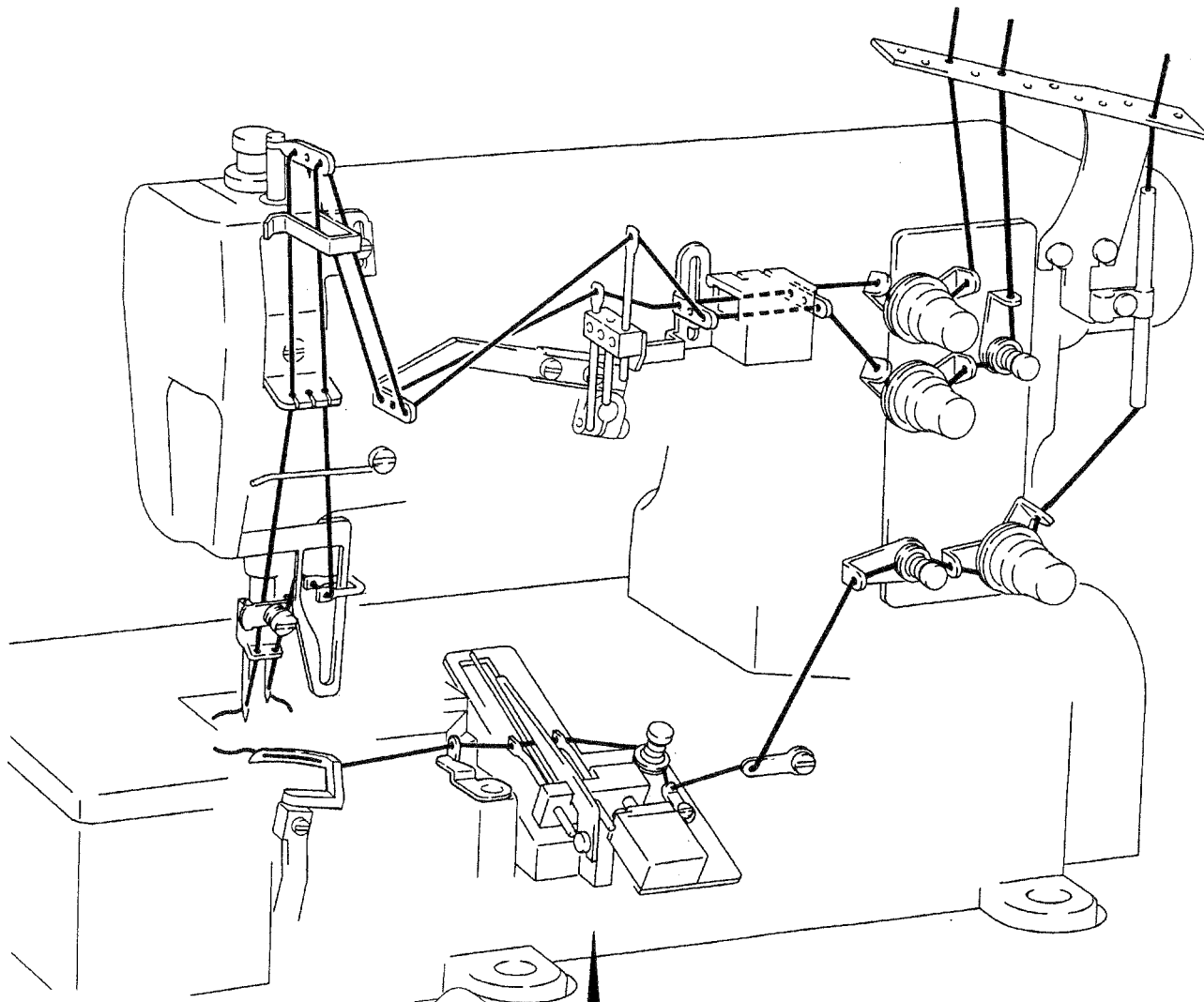
When threading the machine
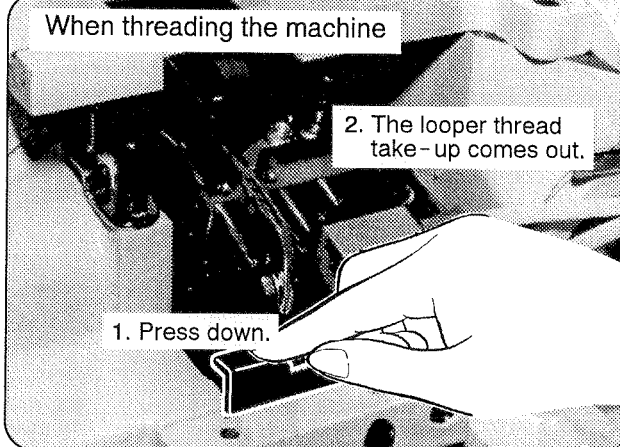
2. The looper thread take-up comes out.

1. Press down.

After threading the machine, replace the looper thread take-up.
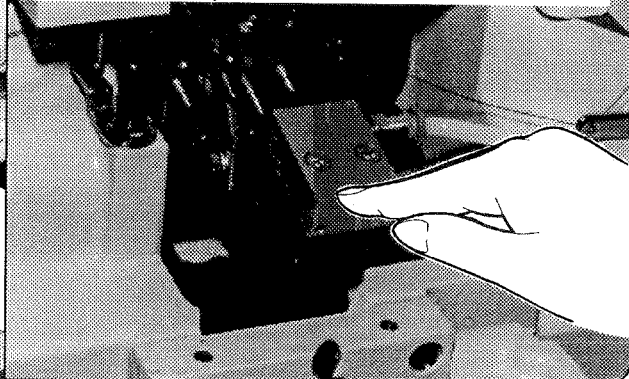
1)Connect the air line to the filter regulator.

2)Pull the pressure adjusting knob up until it clicks and then set the filter regulator at 5kgf/c m² (0.5MPa) by turning the knob clockwise or counterclockwise as required.

● To increase the air pressure, turn the pressure adjusting knob clockwise.
● To decrease the air pressure, turn the pressure adjusting knob counterclockwise.

Set at 5kgf/cm² (0.5MPa) by pulling the knob up.

Baffle

Press the button to drain the filter regulator until the drainage level reaches the baffle.

16

SOH

-300 Series
Integrated sewing unit for hemming
flat sleeves and/or bottoms
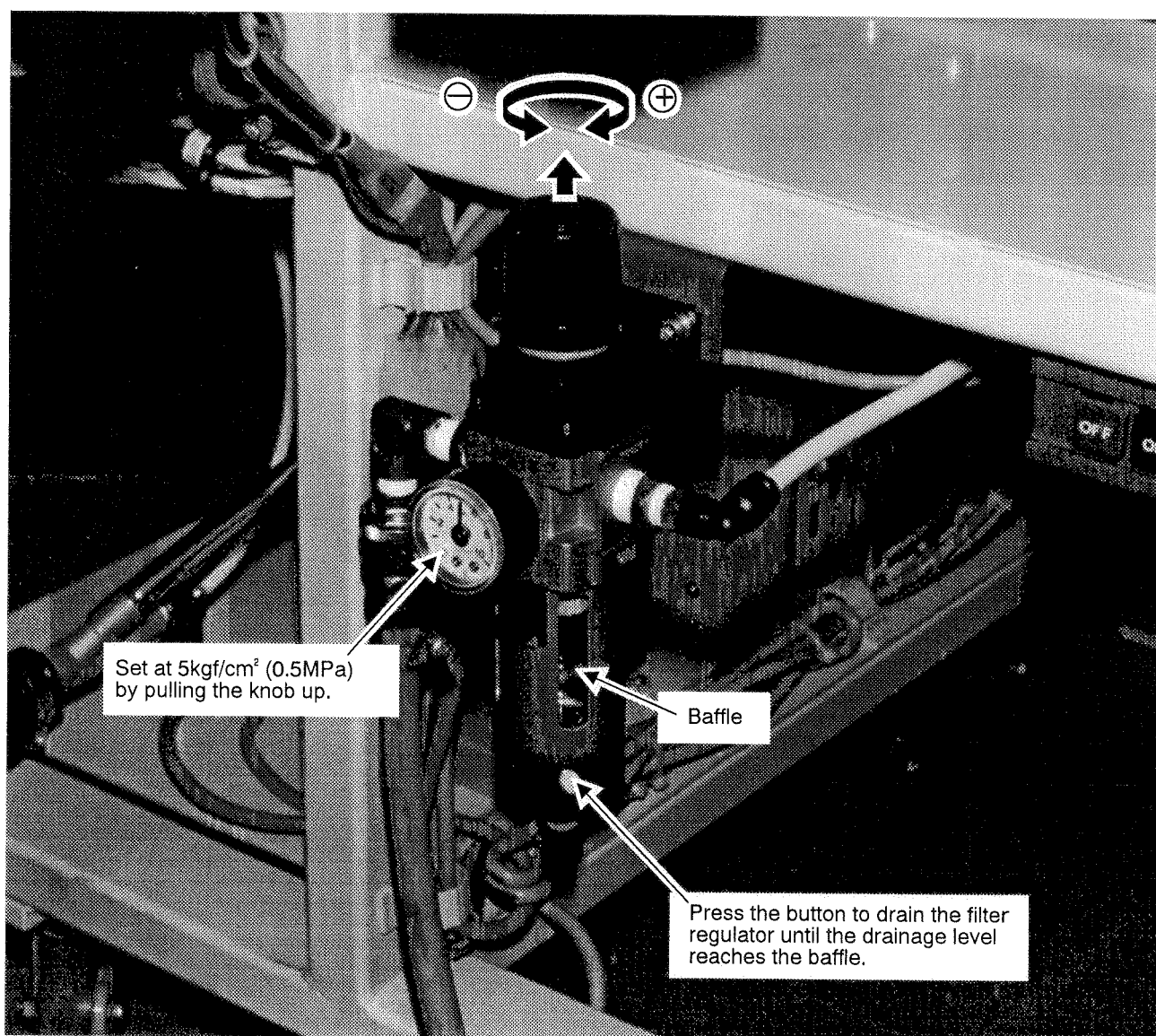
Basic adjustment

Adjusting the sensitivity of the fabric sensors

1. Turn on the power.
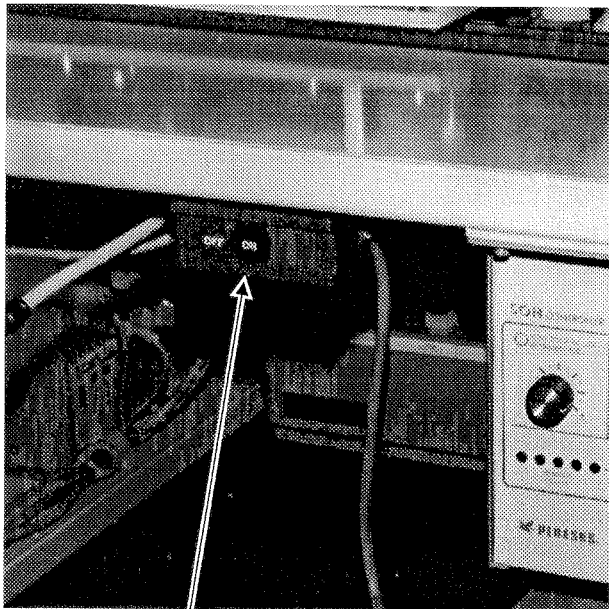
SOH power switch
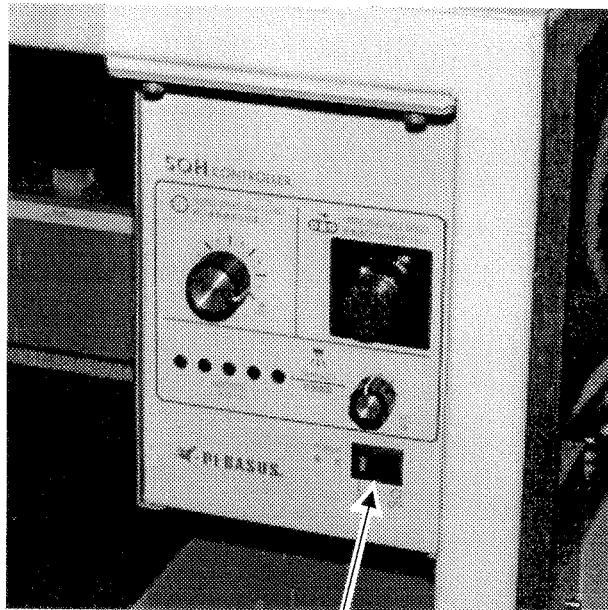
Power switch for the SOH power box

2. To adjust the sensitivity of the machine start sensor
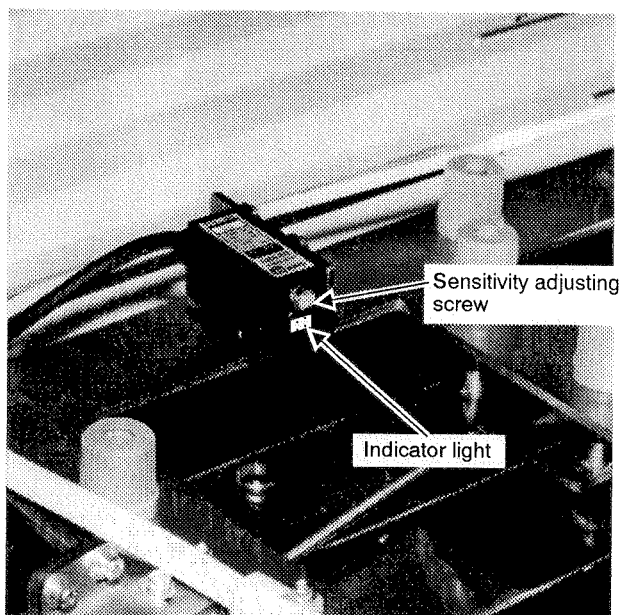
Sensitivity adjusting screw

Indicator light

1) Turn the sensitivity adjusting screw counterclockwise with no fabric under the sensor until the indicator light (red) is turned on. Note the position as (A).

2) Turn the sensitivity adjusting screw clockwise with the fabric under the sensor until the indicator light (green) is turned on.
   Note the position as (B).

3) Set the sensitivity adjusting screw in the middle of point (A) and point (B).

4) When the fabric is removed from the sensor, the indicator light (green) is turned on.
   When the fabric is positioned under the sensor, the indicator light (red) is turned on.
   Confirm the above.

If the indicator light (red) is turned on with no fabric under the sensor, the sensor is too sensitive. Decrease the sensitivity by turning the sensitivity adjusting screw counterclockwise.

※ To obtain the proper sensitivity, make a fine adjustment repeatedly with the sensitivity adjusting screw.
   •To increase the sensitivity, turn clockwise.
   •To decrease the sensitivity, turn counterclockwise.

18

3.To adjust the sensitivity of the AT/SC sensor

AT/SC sensor

Sensitivity adjusting dial

Indicator lights

1)Turn the sensitivity adjusting dial on the control box counterclockwise all the way to the end with no fabric under the sensor.
2)Turn the sensitivity adjusting dial clockwise slowly until five indicator lights are turned on.
3)Make sure five indicator lights are turned on with no fabric under the sensor and all five indicator lights are turned off with the fabric under the sensor.

However, if a light weight fabric is used, all the indicator lights may not be turned off with the fabric under the sensor.
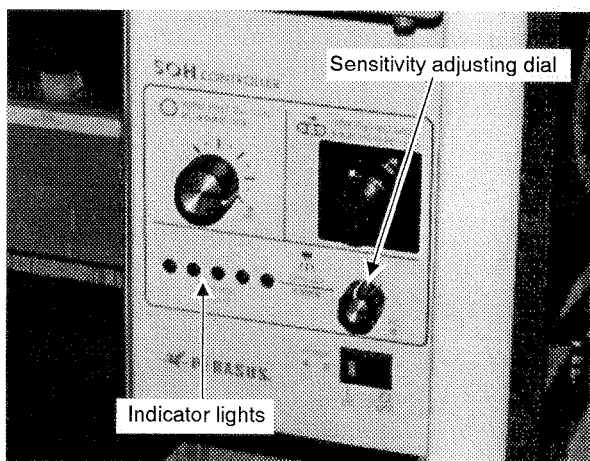
4.To adjust the sensitivity of the body stacker sensor
5.To adjust the sensitivity of the sleeve stacker sensor
(optional)
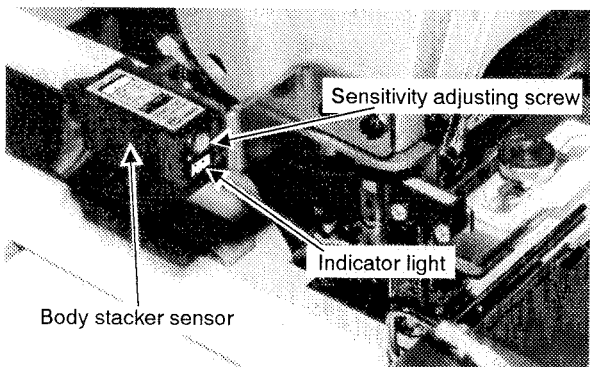
Sensitivity adjusting screw

Indicator light

Body stacker sensor

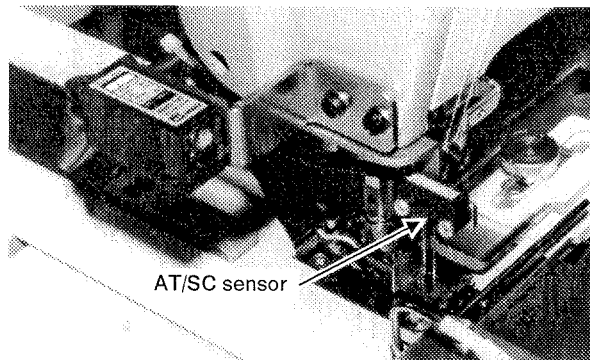Sensitivity adjusting screw

Sleeve stacker sensor

Indicator light

1)Turn the sensitivity adjusting screw counterclockwise with no fabric under the sensor until the indicator light (red) is turned on. Note the position as (A).
2)Turn the sensitivity adjusting screw clockwise with the fabric under the sensor until the indicator light (green) is turned on. Note the point as (B).
3)Set the sensitivity adjusting screw in the middle of point (A) and point (B).
4)When the fabric is removed from the sensor, the indicator light (green) is turned on.
   When the fabric is positioned under the sensor, the indicator light (red) is turned on.
Confirm the above.
If the indicator light (red) is turned on with no fabric under the sensor, the sensor is too sensitive. Decrease the sensitivity by turning the sensitivity adjusting screw counterclockwise.

※ To obtain the proper sensitivity, make a fine adjustment repeatedly with the sensitivity adjusting screw.
•To increase the sensitivity, turn clockwise.
•To decrease the sensitivity, turn counterclockwise.

Test sewing

```
Manual          HIGH
Ordering Sewing
```
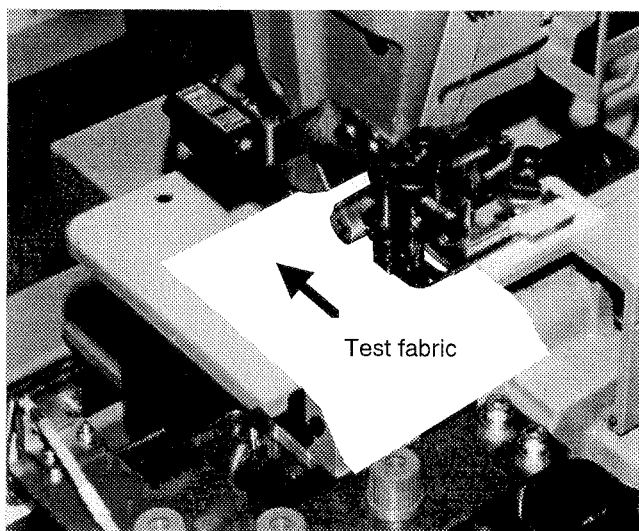
1. Call up "Manual Ordering sewing" on the display. Refer to page 91.

Pressing INC. ▲ button runs the machine at high speed.
Pressing DEC. ▼ button runs the machine at low speed.

2. Press the foot switch (black) to lift the presser foot and position the test fabric under the presser foot.

Test fabric

Foot switch (black)
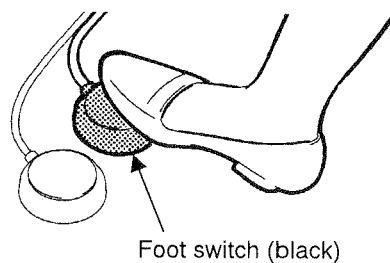
3. Press the foot switch (green) to perform a test sewing operation.

Foot switch (green)
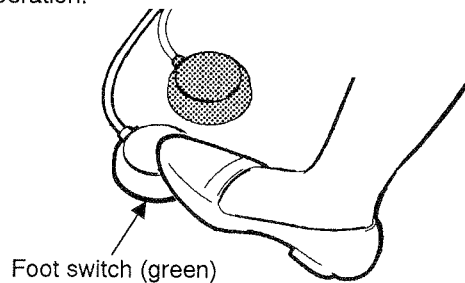
4. Press CURSOR/CUTTER → /≈ button to activate the AT device (thread chain cutter).

5. Check the stitch formation on the fabric.

6. Press PROGRAMMING ◇ button to return to the initial sewing mode display.
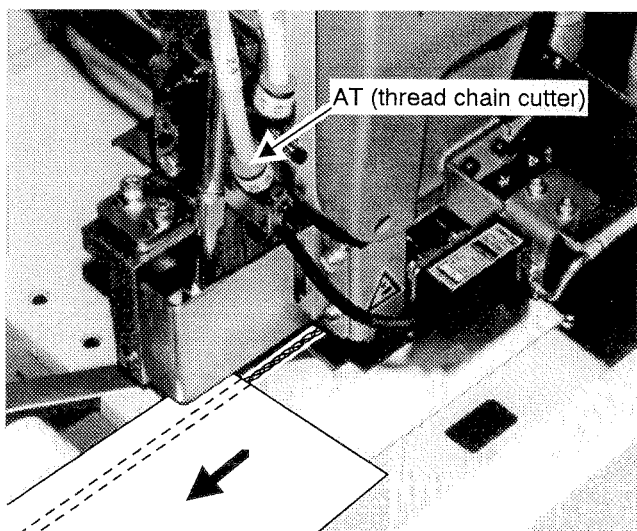
AT (thread chain cutter)

1. To adjust the height of the cuttter

1)Loosen adjusting screw ① and attach (the cutter) at an intermediate position of the mounting slit.

Adjusting screws ①

Intermediate position
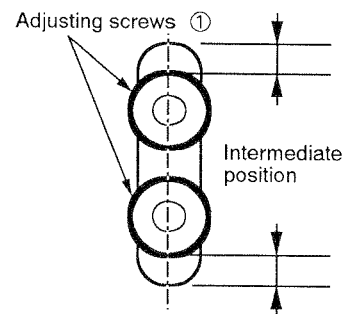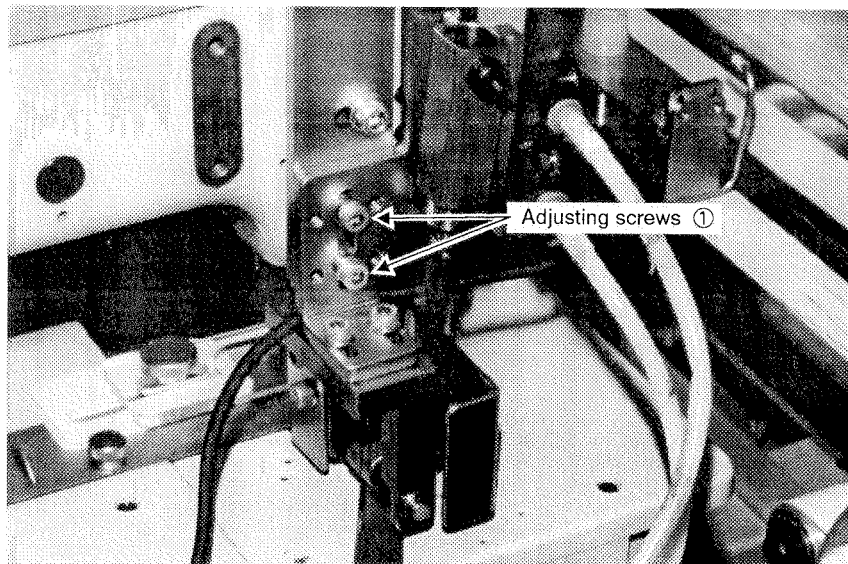
2. To adjust upper knife

1)Put the upper knife and the lower knife parallel to each other and adjust by loosening adjusting screw ② in such a way that a clearance of about 1 mm may be produced at the part A in the state where the upper knife is meshed with the lower knife. (Loosen screws ④, ⑥ in advance when making this adjustment.)

2)When only the guide of the upper knife is in contact with the lower knife (state in which the upper knife is slightly raised), adjust the position of collar ③ by loosening adjusting screw ④ in a way not to produce any gap in the part B.

3)When the cylinder is at the lowest position, adjust by loosening adjusting screw ⑥ of collar ⑤ and moving the upper knife in such a way that the meshing depth of the upper and lower knives comes to 1 mm. At that time, make bracket ⑦ come to a position symmetricaly opposite against coller ⑤.

3. Adjustment of upper knife pressure

1)Adjust the position of collar ⑧ by loosening adjusting screw ⑨ so that the pressure becomes weakest in the range where thread chain are cut smoothly.

Adjusting screw ② (2 points)

Symmetrical

Bracket ⑦

Adjusting screw ④ (2 points)

Collar ③

Upper knife

Collar ⑧

Collar ⑤

Adjusting screw ⑨ (2 points)

Adjusting screw ⑥ (2 points)

Part A : Approx. 1 mm

Part B : Do not produce any gap.

Lower knife

Upper knife

Parallelism of upper knife and lower knife

Upper knife

Meshing depth 1 mm

Upper knife guide

Lower knife

Adjusting the fabric trimmer

1. To adjust the lower knife up and down

Adjust the lower knife up and down so that the cutting edge of the lower knife is flush with the top surface of the fabric feed belt.

Line of feed ➡ — Fabric feed belt

Adjusting screw

Lower knife

2. To adjust the upper knife up and down

When the upper knife is at the bottom of its stroke, the overlap of the upper and lower knives should be 0mm.

Line of feed ➡

0mm — Upper knife

Adjusting screw
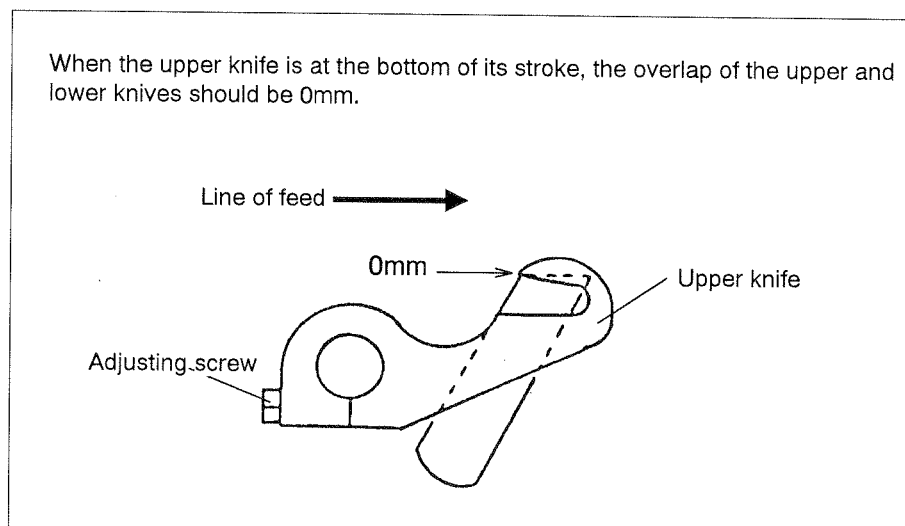
3. To adjust the pressure of the upper knife

Adjust the position of the pressure adjusting collar so that it presses the upper knife properly.

Line of feed ➡ — Upper knife

Shaft

Pressure adjusting collar

Adjusting screw

Pressure spring
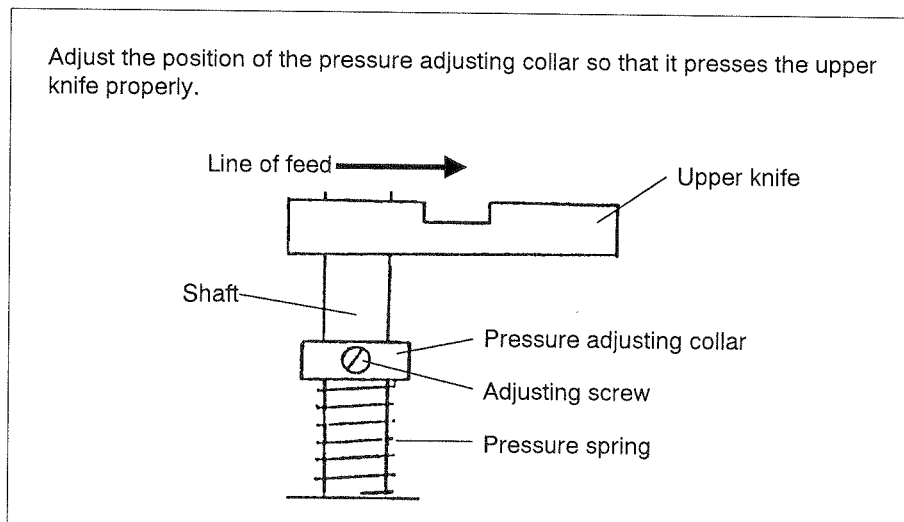
Basic adjustment   Adjusting the fabric press plate (small)
Adjusting the fabric press plate guide
Adjusting the fabric edge guide plate

1.To adjust the fabric press plate (small)

Adjust the clearance between the fabric press plate (small) and the upper knife of the fabric trimmer (FT device). See below.

Line of feed ➡

Fabric press plate (small) height adjusting screws   Support plate

Fabric press plate (small)

1mm —   0.5mm

Upper knife   Fabric press plate guide

Adjusting screws

2.To adjust the fabric press plate guide

After the fabric press plate (small) is positioned, adjust the position of the fabric press plate guide so that it is aligned with the fabric press plate (small) as shown below.

Line of feed ➡

Adjusting screw
Fabric press plate guide

3.To adjust the fabric edge guide plate
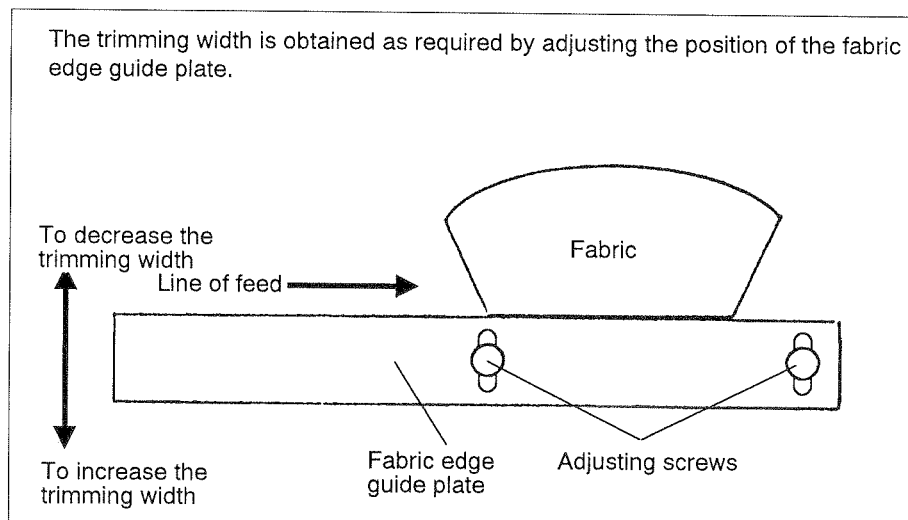
The trimming width is obtained as required by adjusting the position of the fabric edge guide plate.

To decrease the trimming width

Line of feed ➡

Fabric

To increase the trimming width

Fabric edge guide plate   Adjusting screws

1.To adjust the fabric press plate (large)

1) Adjust the height of the fabric press plate (large) so that the fabric can go through the fabric press plate (large) smoothly.

Fabric press plate (large)
height adjusting screw

Fabric press plate (large) height adjusting screw
•To move up the plate, turn the adjusting
 screw clockwise.
•To move down the plate, turn the adjusting
 screw counterclockwise.

Fabric press plate (large)

Clearance which is approximately
1/2 thickness of the fabric

Fabric feed belt

Clearance which is approximately
equal to a piece of the fabric
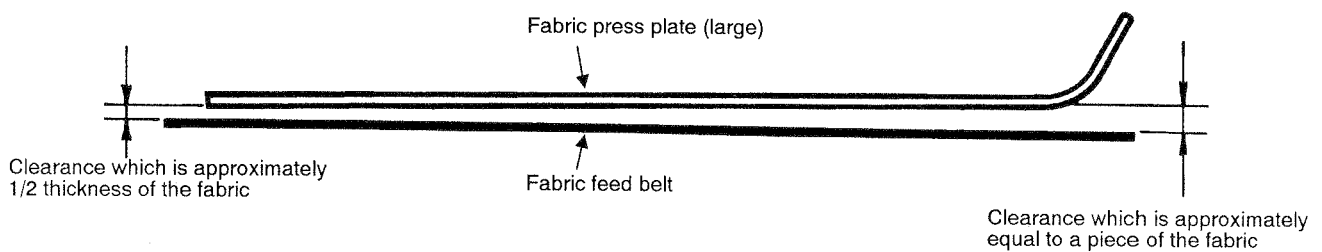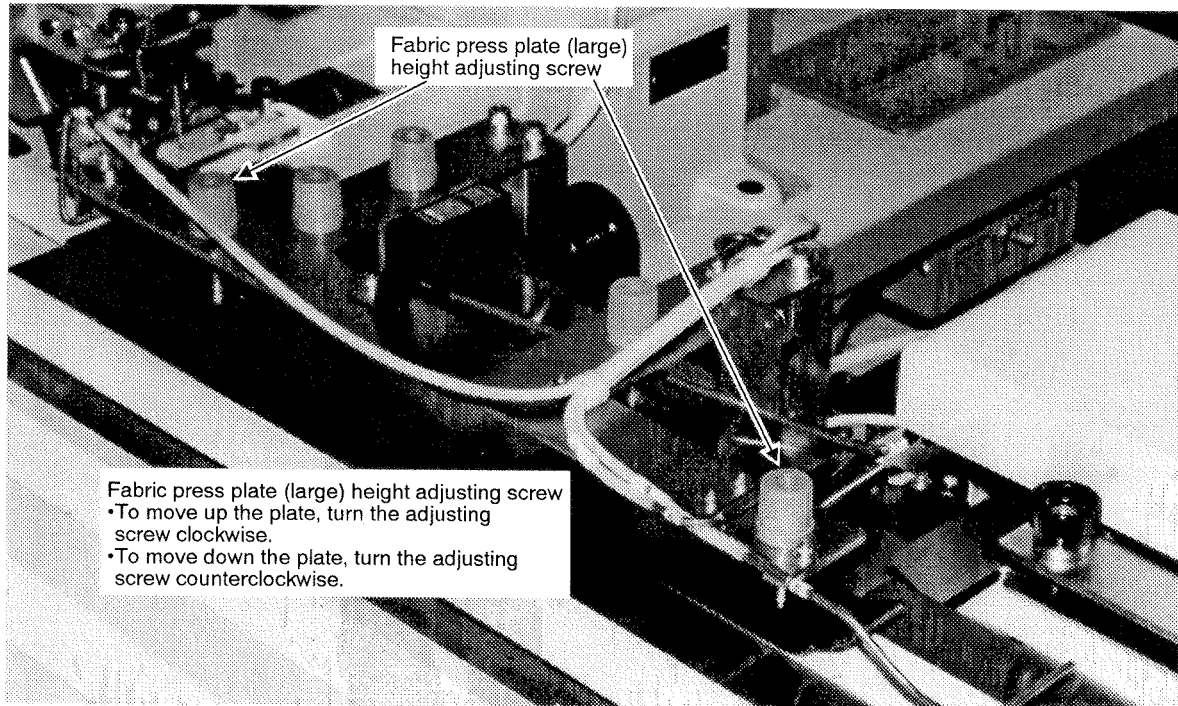
Before adjustment

1.Call up "Belt run manual" on the display. Refer to "Programming sewing data" on page 34.

Belt run manual

To run the fabric feed belt in the operating direction, press the foot switch (green).

To run the fabric feed belt in the reverse direction, press the foot switch (black).

Align the edge of the fabric with that of the second fabric feed belt.

Test fabric

2)Feed the fabric under the fabric press plate (large) by pressing the foot switch (green).

5)The fabric should go under the fabric press plate (large) smoothly with no wrinkle.

Test fabric

6)Make sure the fabric cannot be removed easily by pulling here slightly.

7)Make sure the fabric can be removed effortlessly by pulling here slightly.
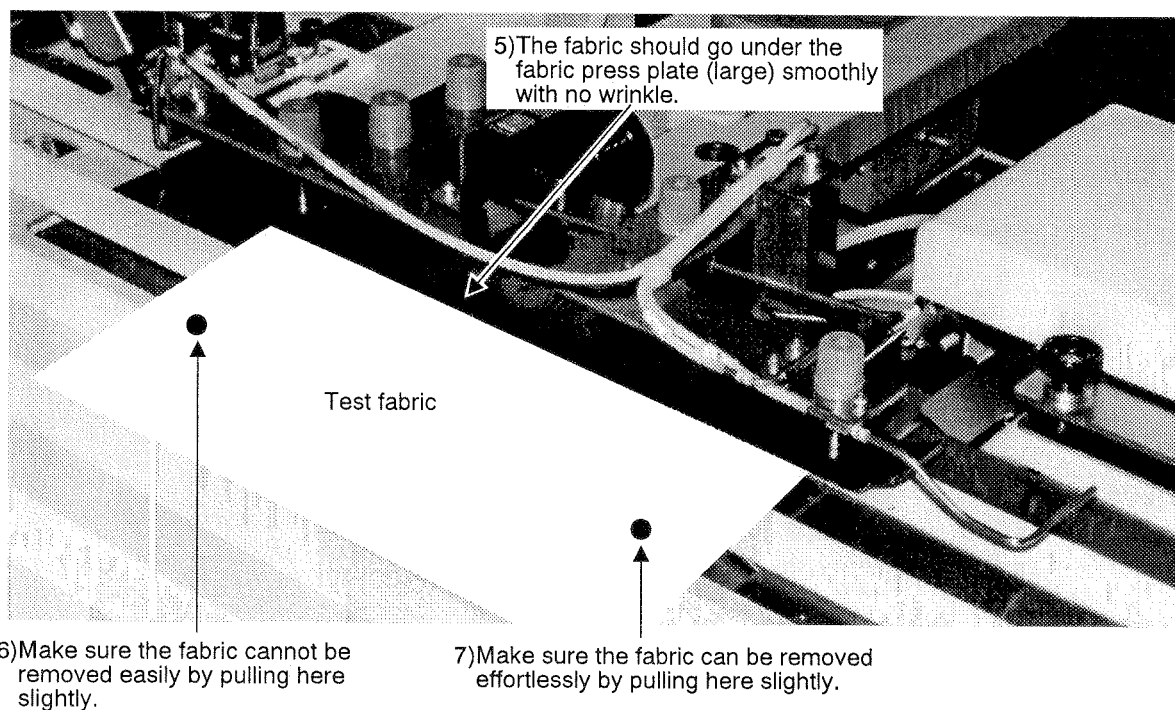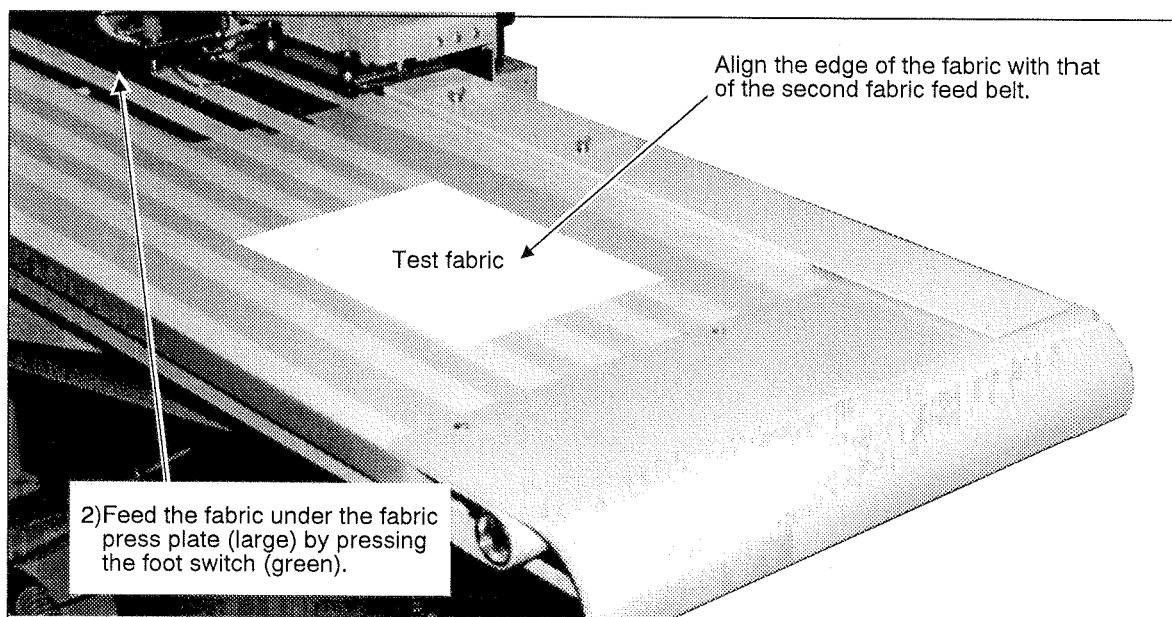
2.To adjust the height of the upper and lower guide plates

1)Position the fabric so that the fabric edge is aligned with the fabric edge guide plate.

Test fabric

2) Feed the fabric under the fabric folder guide by pressing the foot switch (green).

Upper guide plate height adjusting screws
•To move the guide up, turn clockwise.
•To move the guide down, turn counterclockwise.

Upper guide plate height adjusting screws

Lower guide plate space adjusting screws

Portion B

Portion A

Lower guide plate height adjusting screws

Cross section of portion A

Fabric press plate (large)

Upper guide plate

Fabric feed belts   Middle guide plate   Lower guide plate

Clearance should be a little larger than the thickness of the fabric to be used.
Then the unit can start folding the fabric smoothly.

Cross section of portion B

Upper guide plate

Fabric feed belts   Middle guide plate   Lower guide plate

Adjust the fabric folder guides (upper/middle/lower) so that they can form a hem smoothly and accurately. (Clearance should be as large as the thickness of the fabric to be used.)

3.To adjust the height of the machine

Machine height
adjusting screws

Adjust the height of the machine so that the needle plate is 0.5 – 1mm below the top surface of the lower guide plate.

Lower guide plate

0.5~1 mm

0.5~1mm

Needle plate
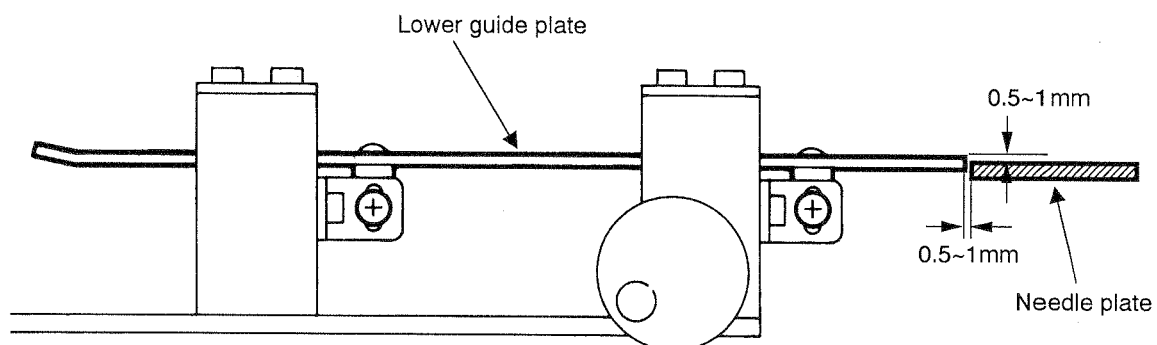
1.To position the fabric trimmer
(to adjust the width of the fabric edge to be cut)
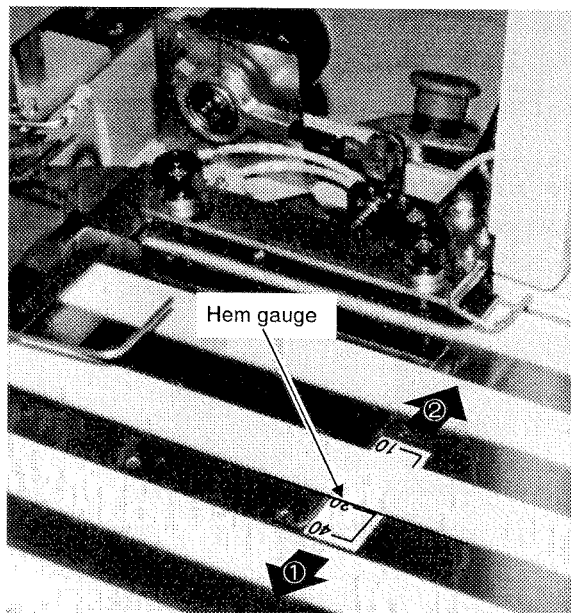
1)Loosen the lock screw.
2)Adjust the width as required with the position adjusting screw while referring to the hem gauge.
(An exact width may not be obtained by the hem gauge due to the change of fabric thickness. Therefore use the hem gauge just for reference.)

Hem gauge

②

①

Position adjusting screw

Lock screws
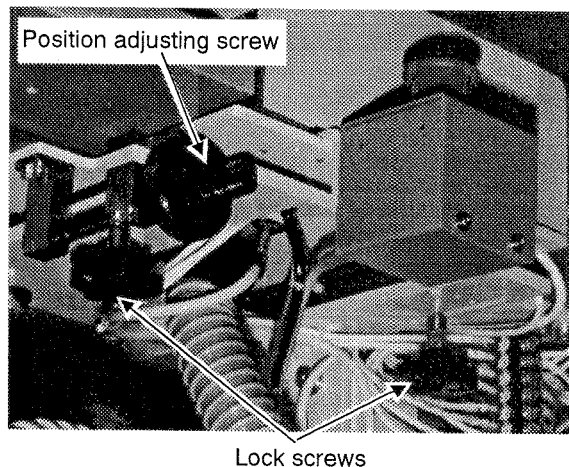
2.To adjust the hem edge guide plate
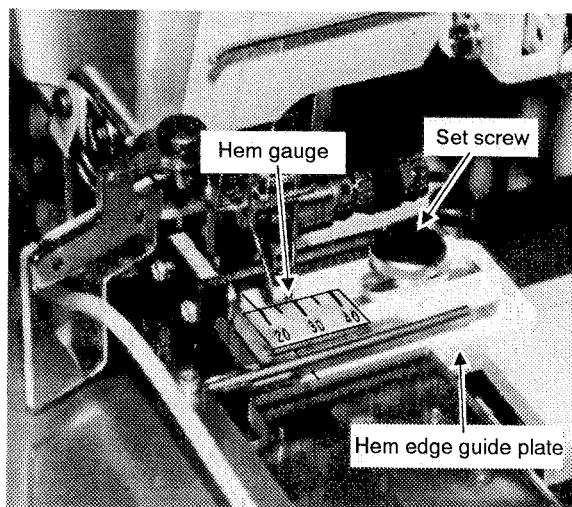
Loosen the set screw. Adjust the hem edge guide plate by moving it to the left or right while referring to the hem gauge. Three kinds of hem edge guide plates (1, 1.5 and 2mm) are available, so replace the guide plate according to the thickness of the fabric if necessary.
(An exact width may not be obtained by the hem gauge due to the change of fabric thickness. Therefore use the hem gauge just for reference.)

Hem gauge   Set screw

Hem edge guide plate

3. To position the middle guide plate

1)Loosen the clamp.

To move the middle guide plate to the right, turn the handle clockwise .
(to increase the hem width)
To move the middle guide plate to the left, turn the handle counterclockwise.
(to decrease the hem width)

Clamp
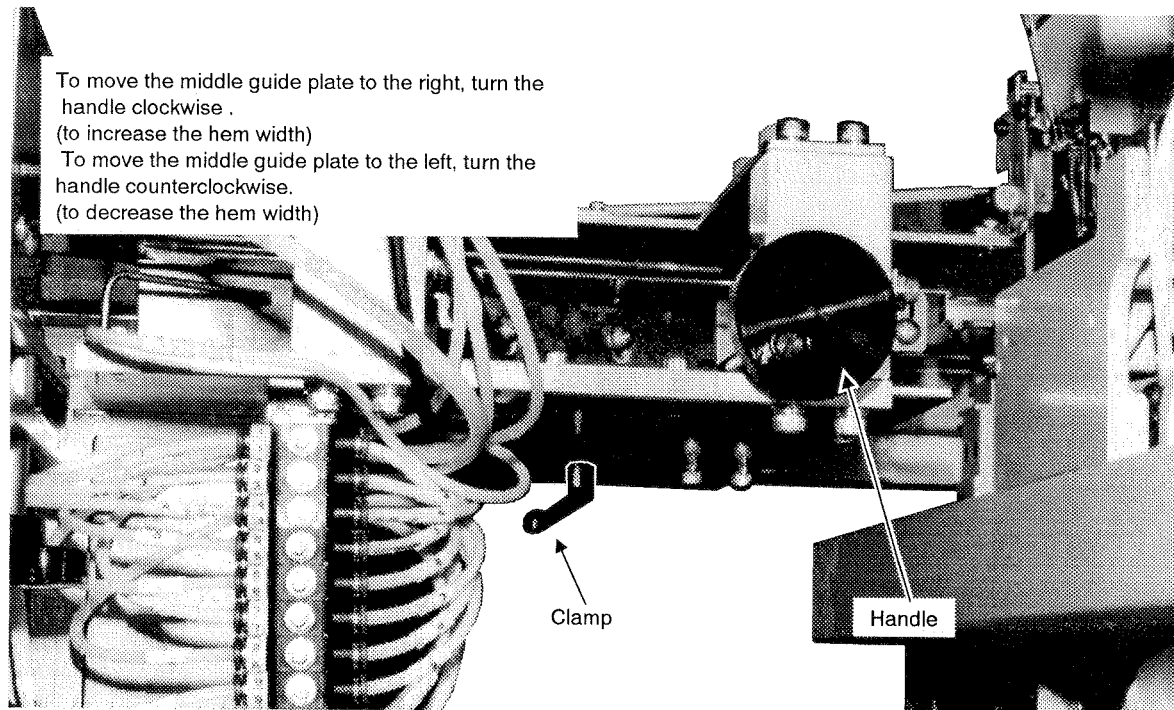
Handle

2)Turn the handle to align line B on the middle guide plate with line A on the hem edge guide plate which has been adjusted.

Line A

Line B

Hem edge guide plate

Middle guide plate
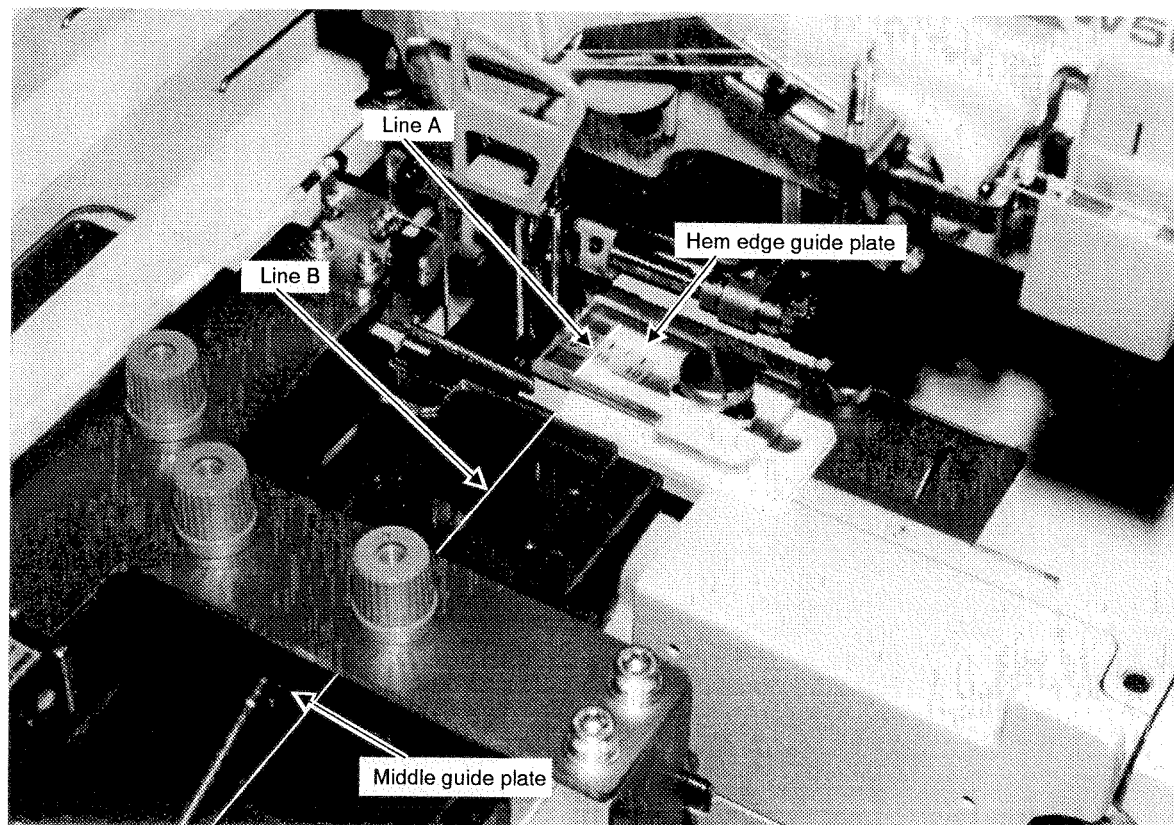
Adjusting the machine speed in low speed range and the fabric feed belt speed

1.To adjust the machine speed in low speed range

When the machine is running at the thread chain producing speed, increase the speed enough to produce the thread chain smoothly.

Machine speed (in low speed range) adjusting dial

Fabric feed belt speed adjusting dial
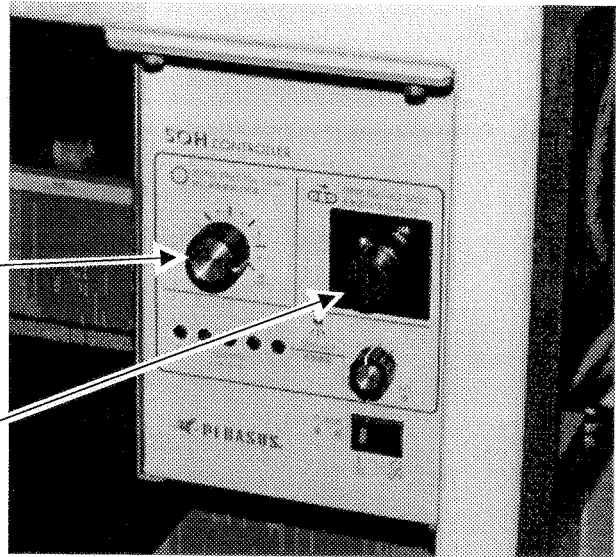
2.To adjust the fabric feed belt speed

When the machine is running at high speed, synchronize the fabric feed belt speed with the machine speed with the fabric feed belt speed adjusting dial.

If the fabric feed belt speed is too high

Plyshift

Wrinkles

Line of feed

If the fabric feed belt speed is too low

Plyshift

Wrinkles

Line of feed
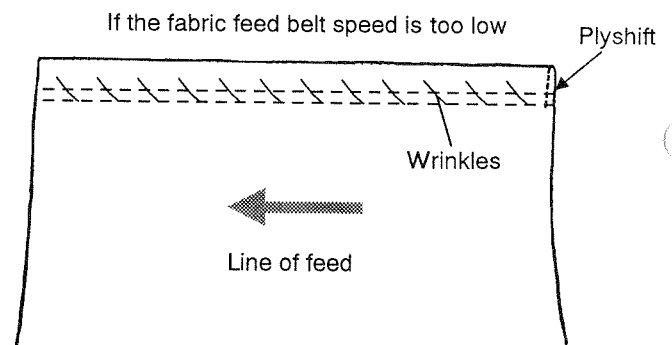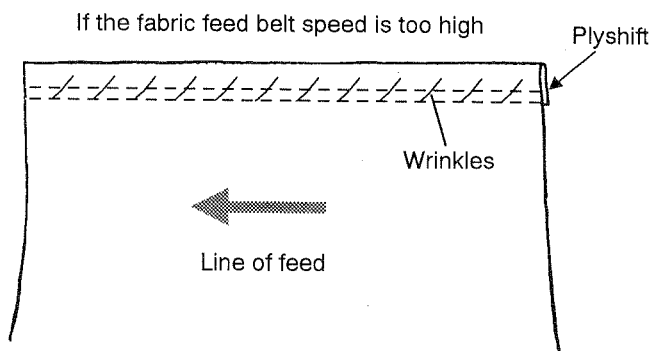
1. To select the sleeve/body stacker
※ Refer to the following instructions for the SOH-320 S1

Note: Pull out the switch first and then select the stacker.

● STACKER 1 = For bodies
OFF = The stackers are off.
STACKER 2 = For sleeves
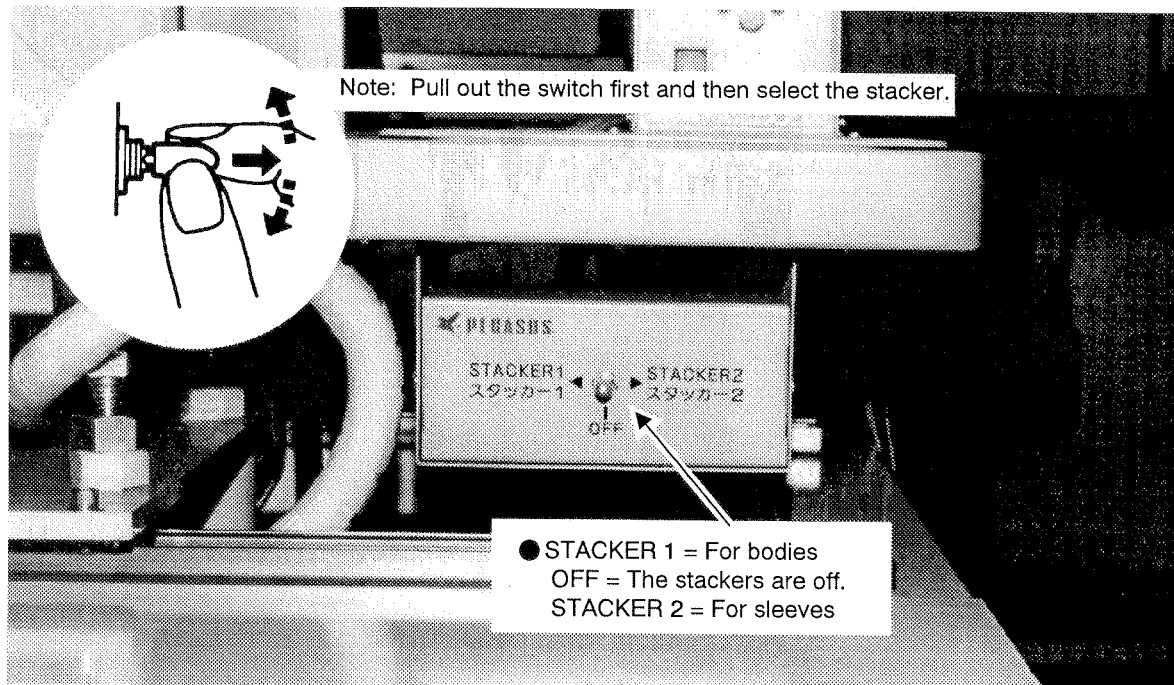
2. To return the stacker tables

1) Body stacker

After removing finished products, return the stacker table by turning the returning knob.
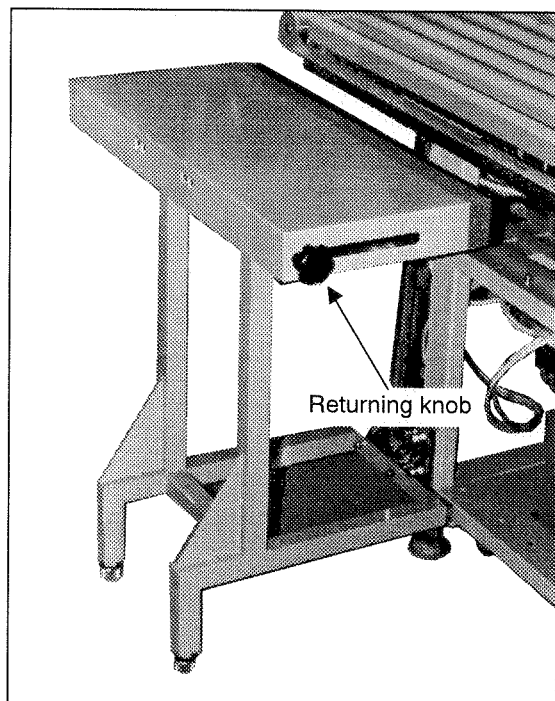
Returning knob

2) Sleeve stacker

After removing finished products, return the stacker table by flipping the returning switch up.
After the returning the stacker table, flip the returning switch down.

Returning switch

SOH
-300 Series
Integrated sewing unit for hemming
flat sleeves and/or bottoms
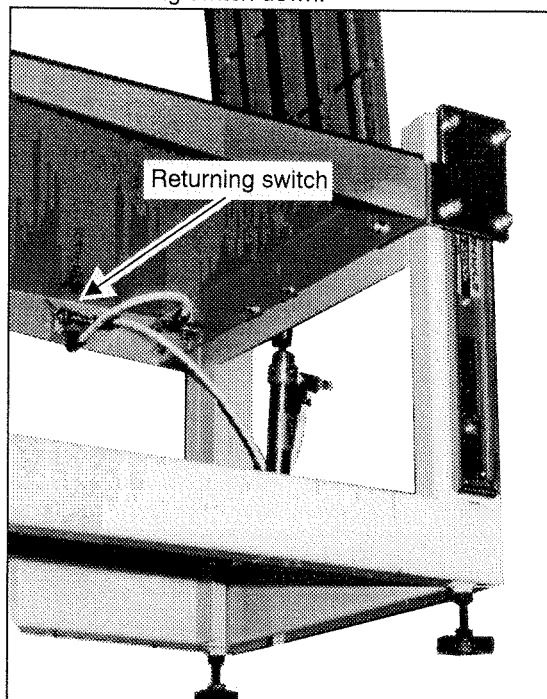
Programming sewing data

Descriptions and functions of the control panel
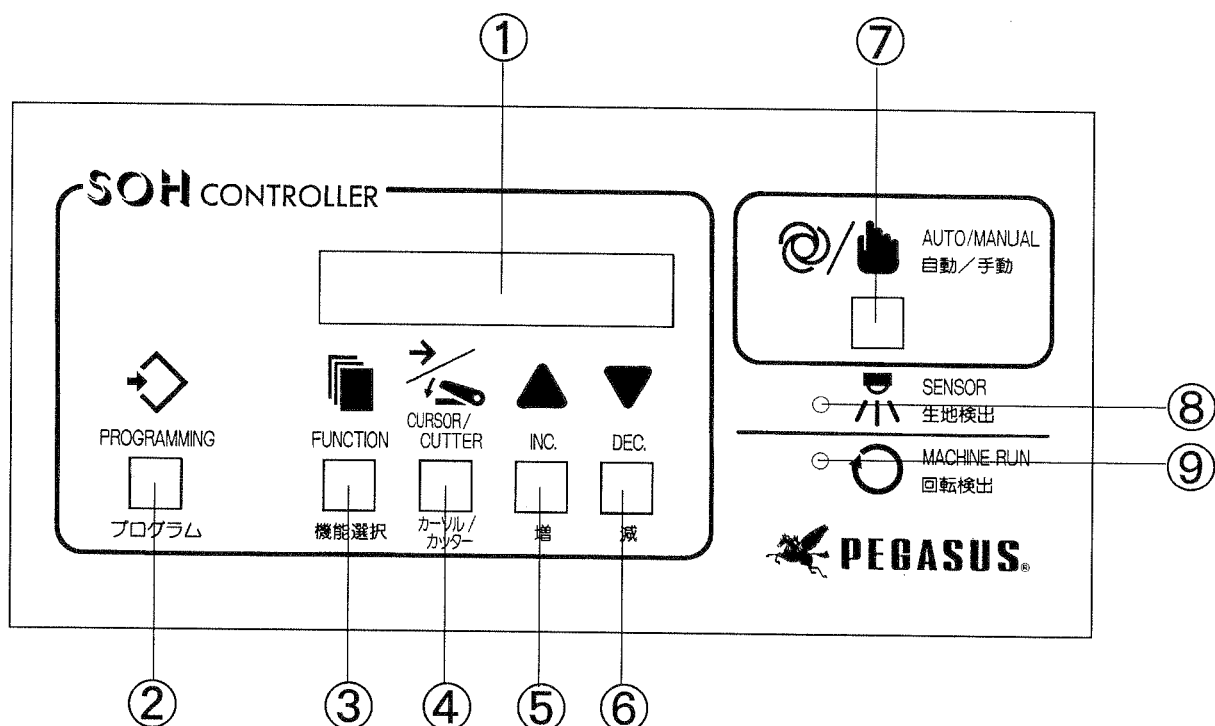
1.Display window
Displays various information.

2.PROGRAMMING button
•Operator stage (Operator Level)
 To select the display, "Manual Ordering Sewing" or "Memo"
•Service personnel stage (Mechanic Level)
 To call up various kinds of counters or timers to control
this sewing unit.

3.FUNCTION button
•Operator stage (Operator Level)
 To select the display, "Test Sewing", "Belt run manual" or
"Piece Count"
•Service personnel stage (Mechanic Level)
 To call up each function
 To change the display sequentially in the programming
mode

4.CURSOR/CUTTER button
 To move the cursor that indicates a particular position to
be entered in the programming mode
 To move a space on the display "Memo"
 To activate the AT device in order to cut the thread chain
in the test sewing mode.

5.INC. button
 To increase the number to be entered in the programming
mode

6.DEC. button
 To decrease the number to be entered in the
programming mode

7.AUTO/MANUAL button
 To select AUTO or MANUAL sewing (test sewing)

8.Fabric detector light
 When the light from the fabric sensor is interrupted by the
fabric, this light is turned on.
 (Detecting the fabric edge is a reference for setting each
counter and timer.)

9.Rotation detector light
 Turns on every time the machine has finished one
cycle.

1.How to turn on the power

Turn on the SOH power switch while pressing PROGRAMMING◇ button.
If the power of the SOH is on, turn it off and then perform the above procedure.

2.To select each function

<Initial display>

```
┌─────────────────────────────┐
│ No.  01                     │
│                             │
│                 Auto        │
└─────────────────────────────┘
```

Press ▓ button.

```
┌─────────────────────────────┐
│ Manual          HIGH        │
│ Ordering   Sewing           │
└─────────────────────────────┘
```

Press ▓ button.

```
┌─────────────────────────────┐
│ Belt   run   manual         │
│                             │
└─────────────────────────────┘
```

Press ▓ button.

Select ON or OFF.

```
┌─────────────────────────────┐
│ Piece  Count        ON      │
│ OOOOO           ▲▼RESET     │
└─────────────────────────────┘
```

A number is added
each time when a   Press ▓ button.
piece has been finished.

Continued on the following page.

To select a sewing pattern
To select AUTO or MANUAL
Select a pattern No. to be programmed by INC. ▲ or
DEC. ▼ button.
Select AUTO or MANUAL with AUTO/MANUAL ◎/🖐
button.
MANUAL .... Keep the foot switch (green) on to sew the
            fabric.
AUTO   .... Once you press the foot switch (green), the
            unit will sew the fabric automatically.

Stitch formation checking mode
Pressing INC. ▲ button runs the machine at high speed.
Pressing DEC. ▼ button runs the machine at low speed.
Pressing CURSOR/CUTTER ➔ /🖐button operates the
AT device for cutting the thread chain.
※ Refer to page 76 for more information.
CS shows on the display by pressing AUTO/MANUAL
◎/🖐 button.
The machine runs at the thread chain producing speed.
The sensors does not operate.

To adjust the fabric feed belt/fabric folder guide
To rotate the belt in the operating direction, press the foot
switch (green).
To rotate the belt in the reverse direction, press the foot
switch (black).

Output counter
If the output counter display is needed, select "ON."
If not, select "OFF."
Select ON or OFF by pressing AUTO/MANUAL ◎/🖐
button.
To reset the output counter, press INC. ▲ and DEC. ▼
buttons simultaneously.

Continued from the previous page.

```
Machine  Speed
   00000  spm   HIGH
```

Displays the machine speed. | Displays the selected speed range.

Press ▮ button.

Machine speed display
To confirm the machine speed while sewing
Press INC. ▲ button to display the machine speed in high speed range (plain seaming).
Press DEC. ▼ button to display the machine speed in low speed range (thread chain producing).

```
Japanese
ニホンゴヒョウジ
```

Displays the selected language.

Press ▮ button.

Selecting a language displayed on the window
Select Japanese or English by pressing INC. ▲ or DEC. ▼ button.

<Initial display>

```
No. 01

           Auto
```

Initial display
The display window returns to the initial stage.

1.How to turn the power on.

Turn on the push button while pressing PROGRAMMING◇ button.
If the power on, turn it off and the perform the above procedure.

2.Select a pattern number to be programmed.

<Initial display>

```
No. 01

              Auto
```
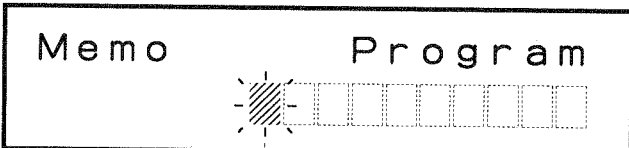
Select a pattern No. to be programmed by pressing INC. ▲
or DEC. ▼ button.

Press ◇ botton to call up the display "Memo Program".

3.To program the sewing pattern

```
Memo        Program

```

The cursor is blinking at the entry point.

Entry of memos
To enter up to 10 letters such as memos or the name of
sewing pattern. These letters are shown in the initial
display.

The following letters can be entered.
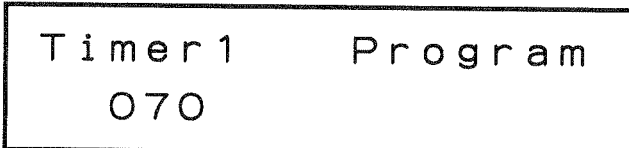
English

```
□ ! " #$%&'( )*+, − . / 0123456789 : ; < = > ?@
ABCDEFGHIJKLMNOPQRSTUVWXYZ [¥]
^ ~abcdefghijklmnopqrstuvwxyz {|}→ ←
```

Japanese

```
。「」、・ヲアイウエオカキクケコサシスセソ
タチツテトナニヌネノハヒフヘホマミムメモ
ヤユヨラリルレロワン゛゜
```

To enter memos
1) Place the cursor on the entry point as desired with
   CURSOR →/ button.
2) Select letters to be entered by pressing ▲ or ▼ button.
3) Move the cursor to the next entry point.
4) Perform the above procedures repeatedly.

Press button.

```
Timer1       Program
  070
```

×1/100sec.

Low speed operation timer
(factory - set time: 0.7 sec.)
Program the time from when the light from the machine
start sensor is interrupted by the fabric to when the
machine speed is changed from low speed to high speed.
Enter the time with ▲ or ▼ button.

Press button.

Continued from the previous page.

```
Timer2        Program
    070
```
X 1/100sec.

Press ▓ button.

Presser foot descending timer (factory–set time: 0.7 sec.)
Program the time from when the light from the machine
start sensor is interrupted by the fabric to when the presser
foot starts descending.
Normally select "OFF" on the display "PL Program" and
sew the fabric with the presser foot lowered.
Enter the time with ▲ or ▼ button.

```
Timer3        Program
    200
```
X 1/100sec.

Press ▓ button.

High speed operation timer (factory–set time: 2.0 sec.)
Program the time from when the fabric has gone through
the light from the machine start sensor to when the
machine speed is changed from high speed to low speed.
Enter the time with ▲ or ▼ button.

```
Timer4        Program
    040
```
X 1/100sec.

Press ▓ button.

Low speed operation timer (factory–set time: 0.4 sec.)
Program the time from when the machine starts to run at
low speed to when the fabric feed belt stops.
Enter the time with ▲ or ▼ button.

```
Timer5        Program
    030
```
X 1/100sec.

Press ▓ button.

Machine stop timer (factory–set time: 0.3 sec.)
Program the time from when the fabric feed belt stops to
when the machine stops.
Enter the time with ▲ or ▼ button.

```
Timer6        Program
    000
```
X 1/100sec.

Press ▓ button.

Fabric feed belt start timer (factory–set: 0 sec.)
Program the time from when the fabric feed belt stops to
when the fabric feed belt restarts in the automatic start
mode.
Enter the time with ▲ or ▼ button.

```
Timer7        Program
    030
```
X 1/100sec.

Press ▓ button.

Stacker operation timer (factory–set time: 0.3 sec.)
When the stacker operation mode is set for "IN", program
the time from when the light from the stacker sensor is
interrupted by the fabric to when the stacker gets actuated.
When the stacker operation mode is set for "OUT",
program the time from when the fabric has gone through
the light from the stacker sensor to when the stacker gets
actuated.
Enter the time with ▲ or ▼ button.

Continued on the following page.

37

Continued from the previous page.

```
Timer8      Program
  040
```
× 1/100sec.

Stacker air blower operation timer
(factory-set time: 0.4 sec.)
Program the time from when the stacker get actuated to
when the stacker air blower starts blowing air.
Enter the time with ▲ or ▼ button.

Press ▦ button.

```
Timer9      Program
  000
```
× 1/100sec.

Stacker stop timer (factory-set time: 0 sec.)
Program the time from when the stacker air blower starts
blowing air when the stacker returns home.
Enter the time with ▲ or ▼ button.

Press ▦ button.

```
Timer10     Program
  000
```

Timer 10 is vacant.

Press ▦ button.

```
ATstart     Program
  15
```

AT stitch counter for the first cutting of the thread chain
(factory-set: 15 stitches)
Program the stitch count from when the light from the AT
thread chain cutting sensor is interrupted by the fabric to
when the AT get actuated.
Enter the stitch count with ▲ or ▼ button.

Press ▦ button.

```
ATend       Program
  35
```

AT stitch counter for the second cutting of the thread chain
(factory-set: 35 stitches)
Program the stitch count from when the fabric has gone
through the light from the AT thread chain cutting sensor
to when the AT get actuated.
Enter the stitch count with ▲ or ▼ button.

Press ▦ button.

```
SCstart     Program
  10
```

SC stitch counter to change the SC device
(thread releaser) from the thread chain mode to the plain
seaming mode (factory-set: 10 stitches)
Program the stitch count from when the light from the SC
sensor is interrupted by the fabric to when the SC device is
changed from the thread chain mode to the plain seaming
mode.

Press ▦ button.

Continued on the following page.

Continued from the previous page.

```
┌─────────────────────────────┐
│  SCend      Program         │
│      OO                     │
└─────────────────────────────┘
```

Press ▓ button.

SC stitch counter to change the SC device
(thread releaser) from the plain seaming mode to the
thread chain mode (factory - set stitch count: 0)
Program the stitch count from when the fabric has gone
through the light from the SC sensor to when the SC
device is changed from the plain seaming mode to the
thread chain mode.
Enter the stitch count with ▲ or ▼ button.

```
┌─────────────────────────────┐
│  ATTimer    Program         │
│      10                     │
└─────────────────────────────┘
```
× 1/100sec.

Press ▓ button.

AT device operation timer (factory - set time: 0.1 sec.)
Program the time when the AT device is operating.
Enter the stitch count with ▲ or ▼ button.

```
┌─────────────────────────────┐
│  RPstart    Program         │
│      O                      │
└─────────────────────────────┘
```

Press ▓ button.

No function.

```
┌─────────────────────────────┐
│  RPend      Program         │
│      10                     │
└─────────────────────────────┘
```

Press ▓ button.

No function.

```
┌─────────────────────────────┐
│  Stacker    Program         │
│      OUT                    │
└─────────────────────────────┘
```

Press ▓ button.

To select when to start the stacker timer
If you select "IN", the timer starts counting when the light
from the stacker sensor is interrupted by the fabric.
If you select "OUT", the timer starts counting when the
fabric has gone through the light from the stacker sensor.
Select "IN" or "OUT" with ▲ or ▼ button.

```
┌─────────────────────────────┐
│  PL         Program         │
│      ON                     │
└─────────────────────────────┘
```

Press ▓ button.

To select the presser foot operation mode
Normally select "OFF."
Select "ON" or "OFF" with ▲ or ▼ button.

Continued from the previous page.

```
AT            Program
  S & E
```
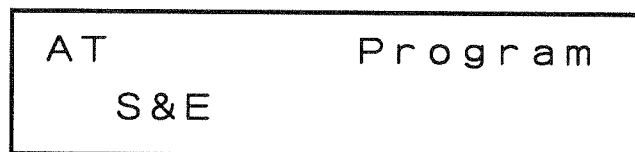
To select the AT device (thread chain cutter) operation mode
Select any one of four modes "OFF", "START, "END", "S & E."
Normally select "S & E."
Select any one of four modes with ▲ or ▼ button.

Press ▐ button.

```
SC            Program
      ON
```
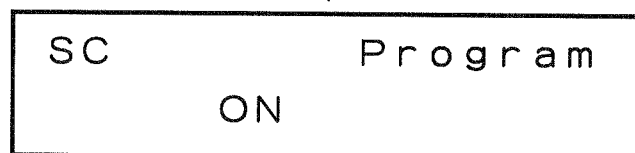
To select the SC device (thread releaser) operation mode
Select the SC device operation mode.
If you select "ON", the SC device automatically changes from the plain seaming mode to the thread chain mode.
If you select "OFF", the SC device does not operate.
The plain seaming mode is continued.
Normally select "ON."
Select "ON" or "OFF" with ▲ or ▼ button.

Press ▐ button.

The display returns to "MEMO."

SOH

-300 Series
Integrated sewing unit for hemming
flat sleeves and/or bottoms

Sewing procedures and safety switch

1. Turn on the SOH unit.

SOH power switch

Power switch on the SOH power box
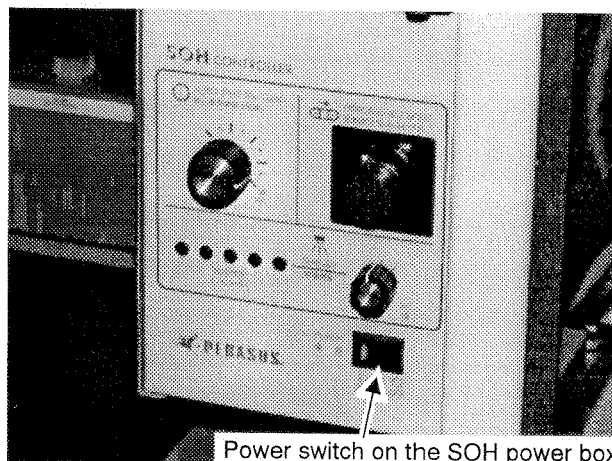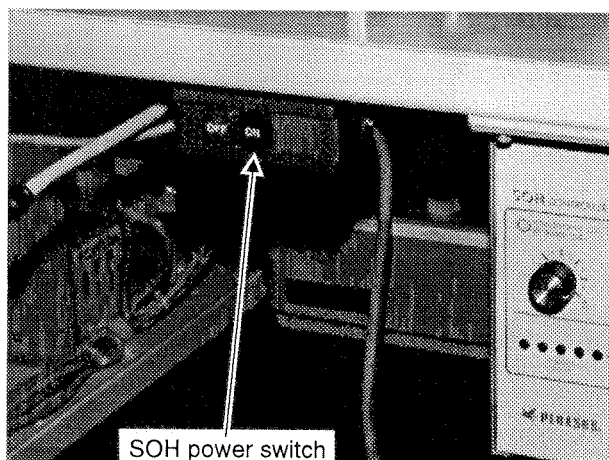
2. To select a sewing pattern, and AUTO or MANUAL

<Initial display>

```
No. 01

                    Auto
```

Select a sewing pattern, and AUTO or MANUAL.
Select a pattern No. to be programmed with ▲ or ▼ button.
Select AUTO or MANUAL with AUTO/MANUAL ⊚/🖱 button.
MANUAL... Keep the foot switch (green) on to sew the fabric.
AUTO ... Once you press the foot switch (green), the unit will sew the fabric automatically.

3. Foot switch (green)

To start running the fabric feed belt, press the foot switch (green).
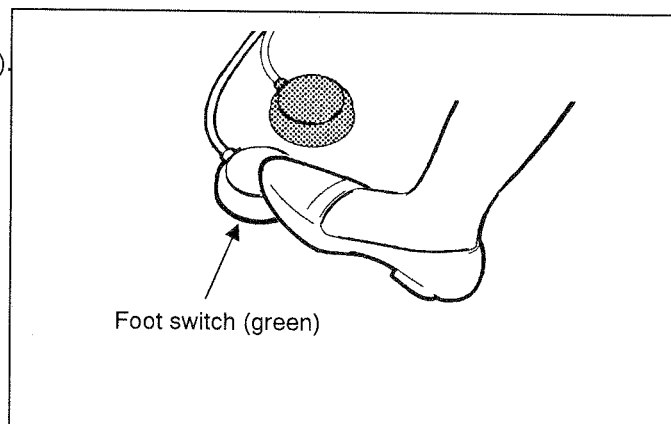
Foot switch (green)

4. Position the fabric on the fabric feed belt.
Align the edge of the fabric with the fabric edge guide plate.
Otherwise the fabric of required hem width may not be obtained.

5. If the foot switch (green) is pressed again, the whole unit will stop.
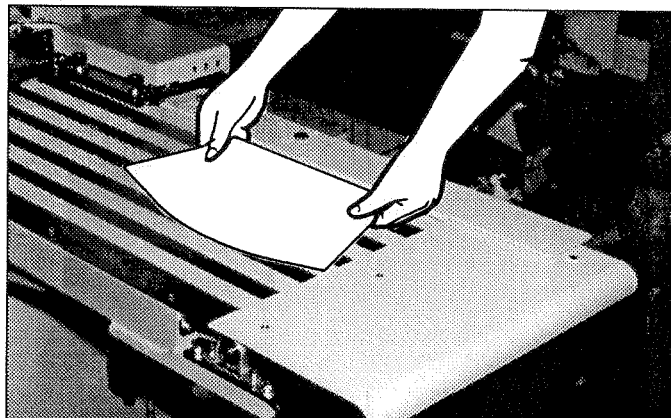
Emergency stop button

If any trouble occurs, press the emergency stop button to stop the whole unit urgently.

To release the emergency stop, turn off the SOH power switch. After settling the trouble, turn on the power.

Emergency stop button

SOH

-300 Series
Integrated sewing unit for hemming
flat sleeves and/or bottoms
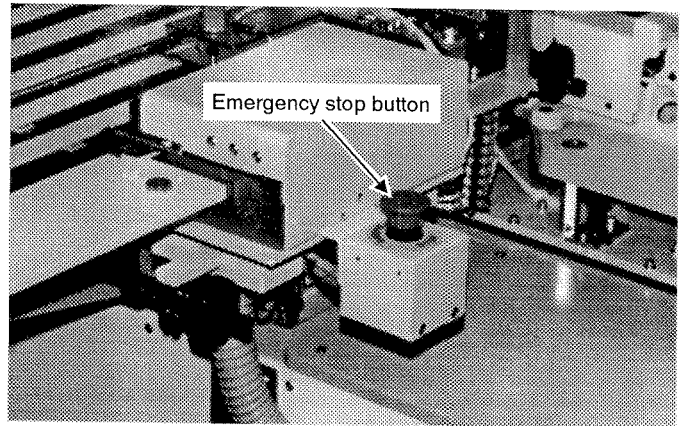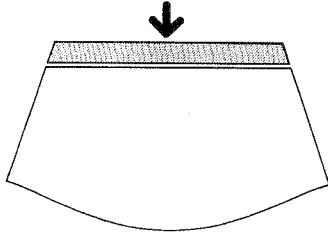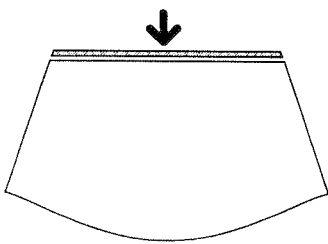
Troubleshooting

(sewing/mechanical trouble)
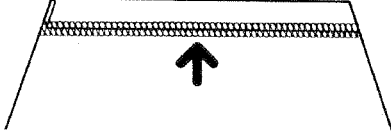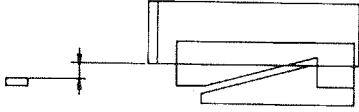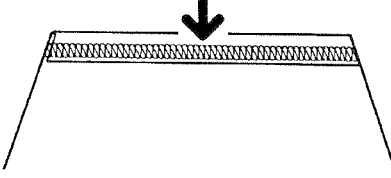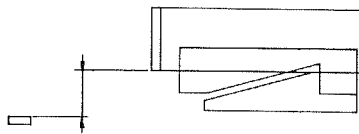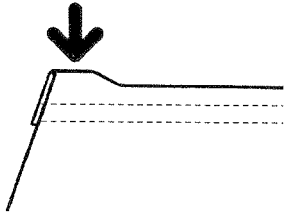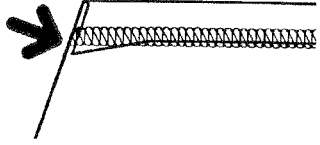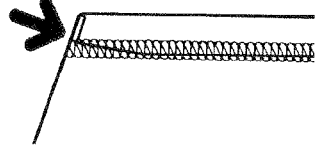
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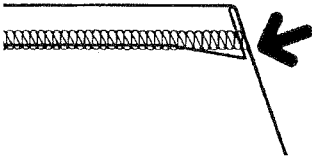
SOH-300 Troubleshooting (sewing/mechanical trouble)

NO.	Phenomenon	Cause	Remedy	Inst. page
1	Heavy trimmings by the fabric trimmer	a) The fabric edge guide plate is set far from the knife.	Set the fabric edge guide plate close to the knife so that trimmings will be reduced.	23-3
		b) The fabric is not positioned correctly (the edge of the fabric rides on the fabric edge guide plate).	Position the edge of the fabric along with the fabric edge guide plate.	42-4
2	Less trimmings or no trimmings by the fabric trimmer	a) The fabric edge guide plate is set too close to the knife.	Set the fabric edge guide plate away from the knife so that trimmings will be increased.	23-3
		b) The fabric is not positioned correctly (the edge of the fabric is positioned away from the fabric edge guide plate).	Position the edge of the fabric along with the fabric edge guide plate.	42-4
3	The cutting action of the fabric trimmer is not proper.	a) The lower knife becomes dull.	Sharpen or replace the lower knife.	
		b) The upper knife becomes dull.	Sharpen or replace the upper knife.	
		c) The upper knife pressure against the lower knife is too light.	Adjust the collar which presses against the upper knife pressure spring in order to increase the pressure.	22-3
		d) Overlap of the upper and lower knives is too little or much.	Adjust the position of the upper and lower knives.	22 -1, 2
		e) The fabric press plate (small) does not press the fabric down firmly, so the fabric comes off from the plate.	Adjust the height of the fabric press plate (small) so that it can press the fabric down firmly.	23-1
		f) The position of the fabric press plate (small) is not correct (the clearance between the plate and the upper knife is too large). Therefore the fabric comes off from the plate when the fabric is trimmed.	Install the fabric press plate (small) close to the upper knife. However, the plate should not touch the upper knife.	23-1

45

NO.	Phenomenon	Cause	Remedy	Inst. page
4	The fabric edge of the hem is sewn further into the seam.	a) The distance between the knife of the fabric trimmer and the middle guide plate is too short.	Move the knife of the fabric trimmer in order to increase the distance.	28-1
5	The fabric edge of the hem is sewn out of the seam.	a) The distance between the knife of the fabric trimmer and the middle guide plate is too long.	Move the knife of the fabric trimmer in order to decrease the distance.	28-1
6	The hem width at the start of sewing is wide.	a) The fabric press plate (large) does not press the fabric down firmly, so the fabric comes off from the guides.	Adjust the height of the fabric press plate (large) so that it can press the fabric down firmly.	24
		b) The clearances between the upper guide plate, middle guide plate and lower guide plate are too large, so they do not press the fabric down firmly.	Adjust each clearance so that it is equal to the thickness of a piece of the fabric.	24~26
		c) The hem edge guide plate to the right of the presser foot is not positioned on the extension line from the middle guide plate. Therefore the fabric comes off from the guides.	Position the hem edge guide plate to the right of the presser foot on the extension line from the middle guide plate.	29-2
		d) Air from the air blower under the lower guide plate is too little, so the fabric comes off from guides.	Increase the air from air blower ⑨ on the lower guide plate.	13
7	The hem edge at the end of sewing is sewn out of the seam.	a) Belt speed is lower than machine speed.	Increase the belt speed with the fabric feed belt speed adjusting knob on the control box so that it will be synchronized with the machine speed.	30-2
		b) Air from the air blower under the lower guide plate is too much, so the fabric is pushed away.	Decrease the air from air blower ⑨ on the lower guide plate.	13
8	The hem edge at the end of sewing is sewn further into the seam.	a) Belt speed is higher than machine speed.	Decrease the belt speed with the fabric feed belt speed adjusting knob on the control box so that it will be synchronized with the machine speed.	30-2
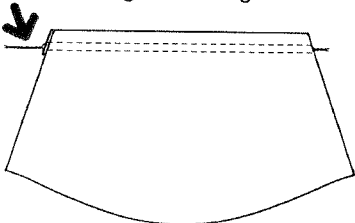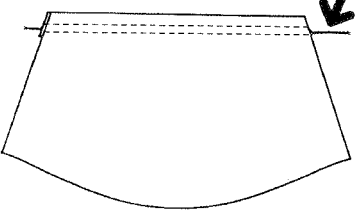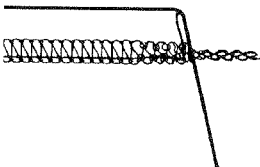
NO.	Phenomenon	Cause	Remedy	Inst. page
9	The lower ply of the hem at the start of sewing is not aligned with the upper ply.	a) The distance between the needle plate and the lower guide plate is too large. Therefore the fabric edge comes against the needle plate.	There should be 0.5 – 1mm between the needle plate and the lower guide plate.	26~27
		b) The lower guide plate is positioned lower than the needle plate, so the fabric edge comes against the needle plate.	Adjust so that the top surface of the lower guide plate is flush with that of the needle plate or the top surface of the lower guide plate is slightly higher than that of the needle plate.	26~27
		c) Air from the air blower under the lower guide plate is too little, so the fabric comes off.	Increase the air from air blower ⑩ on the lower guide plate.	13
		d) The fabric press plate (large) does not press the fabric down firmly, so the fabric comes off from the plate.	Adjust the height of the fabric press plate (large) so that it can press the fabric down firmly.	24~26
		e) The upper guide plate does not press the fabric down firmly, so the fabric comes off from the plate.	Adjust the height of the upper guide plate so that it can press the fabric down firmly.	26
10	The fabric edge does not go under the upper guide plate smoothly.	a) The fabric edge comes against the radius tip of the fabric press plate (large).	Adjust the height of the guide on the end of the fabric press plate (large) so that the fabric edge can go under the fabric press plate (large) smootly.	24
11	The fabric rides on the presser foot.	a) The position of the upper guide plate is too high (the plate cannot press the fabric down firmly).	Lower the upper guide plate so that the fabric can go under the presser foot smoothly.	24
		b) Air from the air blower in front of the presser foot is too little.	Increase the air from air blower ⑧ so that the fabric can go under the presser foot smoothly.	13
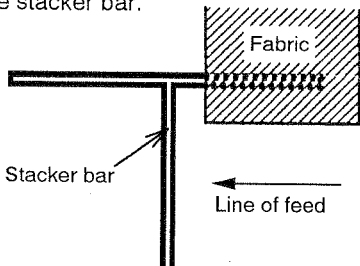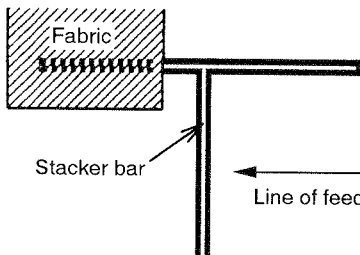
SOH-300 Troubleshooting (sewing/mechanical trouble)

NO.	Phenomenon	Cause	Remedy	Inst. page
12	The thread chain is not produced. The thread breaks occurs when the thread chain is being produced.	a) The needle is bent.	Replace the needle.	
		b) Wrong installation of the needle.	Make sure the needle is inserted into the needle holder correctly and the needle's eye is turned to the front.	
		c) Wrong threading.	Thread the machine correctly.	15
		d) Wrong looper setting.	Set the looper correctly.	
		e) Thread chaining is uneven because the tension spring pressure for the right needle thread or looper thread is too light.	To make the thread tension even, adjust the right needle thread tension or looper thread tension.	
		f) The SC (thread releaser) does not operate because SC PROGRAM is set for OFF.	Set SC PROGRAM for ON.	40
		g) The height of the main feed dog is too low.	Adjust the height of the main feed dog so that the thread chain is produced smoothly.	
		h) Presser foot pressure is too heavy.	Decrease the pressure by loosening the presser foot pressure adjusting screw, yet be sufficient to feed the fabric properly.	
		i) The SC device tightens the thread too early at the start of sewing (the thread is tightened when the thread chain is produced).	Increase the value of SC start to delay the timing at which the SC device loosen the thread at the start of sewing (1 – 2 stitches at the start of sewing should be loosened).	38
		j) The SC device loosens the thread too late at the end of sewing (the thread is tightened when the thread chain is produced).	Decrease the value of SC end to hasten the timing at which the SC device loosen the thread at the end of sewing (1 – 2 stitches at the end of sewing should be loosened).	39
		k) Needle thread take-up movement timing is too late against needle up-and-down movement timing, so the needle loop is too large and is collapsed, causing a needle loop skip.	•To hasten the timing, change the position of the needle thread take-up drive crank . •Remove the needle thread from the needle thread disc to make the needle loop small. •Increase the air from air blower ㉕.	15, 13

SOH-300 Troubleshooting (sewing/mechanical trouble)

NO.	Phenomenon	Cause	Remedy	Inst. page
13	The AT device (thread chain cutter) does not cut the thread chain neatly.	a) The lower knife becomes dull.	Sharpen or replace the lower knife.	
		b) The upper knife becomes dull.	Sharpen or replace the upper knife.	
		c) The upper knife is leaning against the lower knife or there is a clearance between the upper and the lower knives.	Adjust the installation angle of the upper knife to remove the clearance.	21
		d) The operating speed of the upper knife is too slow.	Loosen the speed control for the upper knife drive air cylinder to increase the operating speed of the upper knife.	21
		e) The value set in the AT timer is too small.	Increase the value. Initial value is 010.	39
14	The length of the thread chain at the start of sewing is too long.	a) The value set in AT start is too small.	Increase the value.	38
15	The length of the thread chain at the end of sewing is too long.	a) The value set in AT end is too large.	Decrease the value.	38
16	Seams (needle thread) at the start of sewing is loose.	a) The value set in SC start is too large.	Decrease the value.	38
17	Seams (needle thread) at the end of sewing is loose.	a) The value set in SC end is too small.	Increase the value.	39
18	Cutting wastes trimmed by the FT device (fabric trimmer) is not sucked up into the dust drum.	a) Air from air blower ② is too small.	Increase the air.	13
		b) Cutting wastes stops in the air line to the drum.	Remove the cutting wastes from the air line.	
		c) The dust drum is packed with cutting wastes, so the sucking force is decreased.	Empty the dust drum.	

49

SOH-300 Trouble shooting 【Body stacker】

NO.	Phenomenon	Cause	Remedy	Inst. page
1	The stacker is not activated.	a) The stacker is not switched from the sleeve stacker mode.	Select Stacker 1.	31
		b) The sensitivity of the sensor is not adjusted properly.	Adjust the sensor properly.	19-4
		c) Time at which the stacker bar gets activated is not set.	Increase the value in Timers 8 and 9.	38
		d) The speed control for the stacker bar drive air cylinder is tightened.	Loosen speed controls ⑯ and ⑰.	11
2	The fabric is blown away.	a) The stacker table is not returned in place and the stacker bar does not hold the fabric.	Return the stacker table home by turning the stacker table returning knob.	31-2
		b) Stacker bar operating time is too short, so the bar is not holding the fabric.	Increase the value in Timer 8.	38
		c) The speed control is tightened, so the stacker bar is not activated and is not holding the fabric.	Increase the operating speed of the stacker bar by loosening speed control ⑯.	11
3	The fabric is stacked to the right of the stacker bar.	a) Start Timing of the stacker bar is too early.	Increase the value set in Timer 7.	37
4	The fabric is stacked to the left of the stacker bar.	a) Start Timing of the stacker bar is too late.	Decrease the value set in Timer 7.	37
		b) The operating speed of the stacker bar is too slow.	Increase the speed by loosening speed control ⑯ for the stacker bar drive air cylinder.	11
5	The fabric is not blown away.	a) Air blowing time is too short.	Increase the value set in Timer 9.	38
		b) Wrong air blowing direction.	Correct the direction.	
		c) The finished products are stacked too much, so the air cannot blow out.	Remove the finished products.	
6	The stacker is not returned in place.	a) The stacker table returning knob is not adjusted.	Adjust the stacker table returning knob.	31-2

SOH-300 Trouble shooting 【Sleeve stacker】

NO.	Phenomenon	Cause	Remedy	Inst. page
1	The stacker is not activated.	a) The stacker is not switched from the body stacker mode.	Select Stacker 2.	31
		b) The sensitivity of the sensor is not adjusted properly.	Adjust the sensor properly.	19-5
		c) Time at which the stacker bar gets activated is not set.	Increase the value in Timer 8.	38
		d) The speed control for the stacker bar drive air cylinder is tightened.	Loosen the speed control.	12
2	The fabric is blown away.	a) The stacker board is moved before the fabric is put completely on it.	Increase the value set in Timer 7.	37
		b) The stacker board operating time is too short, so the fabric is not stacked neatly.	Increase the value in Timer 8.	38
3	The fabric drops.	a) Timing at which the stacker board starts moving is too late.	Decrease the value in Timer 7.	37
		b) The stacker board operating time is too short.	Increase the value in Timer 8.	38
		c) The operating speed of the stacker board is too slow.	To increase the speed, loosen the speed control for the stacker drive air cylinder.	12
4	The stacker table does not return home.	a) The stacker table returning switch is not changed.	Change the returning switch.	31-2

SOH-300 Series
Integrated sewing unit for hemming
flat sleeves and/or bottoms

Trouble shooting

(electrical trouble)

1)Sensitivity of the sensor

  Make sure the sensitivity of the sensor is adjusted properly by following the instructions in this manual.

2)Relay cord plug

  Make sure the relay cord plug is connected securely by referring to the wiring diagram.

3)Relay cord

  Make sure the relay cord is not broken by referring to the wiring diagram.

4)Solenoid valve

  If the solenoid valve is broken, replace the solenoid valve connector with a normal one and then check for the operation.

5)Air supply

  Make sure air is supplied to the air regulator uniformly.

6)Air lines

  Make sure the air lines are connected securely by referring to the air line connecting diagram.

7)Air valve, speed control

  Make sure the air valve or speed control is not tightened too much.

SOH-300 Troubleshooting (electrical trouble)

NO.	Phenomenon	Cause	Remedy	Inst. page
1	The power is not turned on.	a) The power cord is disconnected from the power source.	Connect the power plug to the power source firmly.	
		b) The power switch of the controller is OFF or is not completely ON.	If it is OFF, turn the power on, or if it is not completely ON, turn the power on again correctly.	42
		c) The fuse is broken.	Replace the fuse. Note) If the fuse is often broken, contact our sales office or representative.	
2	The machine does not run.	a) The machine start sensor is not adjusted correctly.	Adjust the machine start sensor is adjusted correctly.	18-2
		b) The relay cord plug is disconnected or the relay cord is broken.	Connect the relay cord firmly or confirm the relay cord is not broken.	8,9
		c) Machine motor trouble (The machine motor controller display shows an error code.)	Check for the motor by referring to the instructions for the error code in the machine motor instruction manual.	
3	The machine does not stop.	a) The machine start sensor is not adjusted properly.	Adjust the machine start sensor properly.	18-2
4	The machine does not stop (the machine keeps running at the positioning speed).	a) The machine belt tension is light.	Adjust the machine belt tension properly.	
		b) Malfunction of the position detector for the machine motor.	Check to see if the earth wire for the position detector is grounded.	
		c) Defective position detector for the machine motor.	Replace the position detector.	
5	The rotation detector LED on the controller is left on.	a) The relay cord for the rotation detector is not connected correctly.	Connect the relay cord for the rotation detector to another connector.	
6	The display on the controller shows error No.00 or 01.	a) The sleeve stacker has static.	Connect the sleeve stacker and unit with the earth wire.	
		b) The supply voltage is being decreased or dipped (intermittently decreased).	Check to see if the supply voltage is obtained correctly. Take the power from other power lines.	
		c) Noise gets into the controller from the power line.	Confirm that the power source is not connected to many lines or the lines are not connected to the power source in a row. If noise is not removed, insert a noise filter or a ferrite core obtainable into the power line.	
		d) The machine and unit have static.	•Confirm the machine and unit are grounded. •Confirm the earth wire of the power line is accurately grounded. •Ground the parts that tend to have static using another thick cord.	

SOH-300 Troubleshooting (electrical trouble)

NO.	Phenomenon	Cause	Remedy	Inst. page
7	The fabric feed belt does not start.	a) The initial display is called up on the controller display window.	Call up the initial display on the display window.	34
8	The fabric trimmer motor does not start.	a) The safety cover is not closed.	Close the safety cover securely.	
		b) The plug for the cover safety switch relay cord is disconnected. The cover safety switch relay cord is broken.	Connect the relay cord securely. Confirm the relay cord is not broken.	
		c) The cover safety switch is broken.	Replace the cover safety switch.	
9	The AT device (thread chain cutter) is not activated.	a) The sensitivity of the AT/SC sensor is not adjusted properly.	Adjust the sensitivity properly.	
		b) OFF is selected on AT function display.	Make sure OFF is not selected on the AT function display (usually set at "S & E").	40
		c) The value set in the AT timer is too small.	Increase the value set in the AT timer.	39

SOH -300 Series
Integrated sewing unit for hemming flat sleeves and/or bottoms

Sewing specifications

Applications
SOH - 311 : Hemming flat sleeves for T-shirts, polo shirts, etc.
SOH - 321 : Hemming flat sleeves and/or bottoms for T-shirts, polo shirts, etc.

Fabric weight
Light, Medium

Fabric
Plain knit fabric, Honeycomb fabric, Rib knit fabric, Interlock fabric

Thread
Needle thread: Polyester spun   Looper thread: Polyester spun, wooly nylon

Hem width
Finished width of sleeve opening/bottom: 20- 35mm

Unit specifications

Model
SOH- 311
SOH- 321

Machine equipped
W562-85BC

Approximate dimensions
SOH- 311 :W 2700mm × D 1580mm × H 1580mm [with thread stands and stacker for sleeves]
SOH- 321 :W 2700mm × D 1580mm × H 1580mm [with thread stands and stacker for sleeves and bottoms]

Machine speed
4,000 s.p.m.

Number of needles
2

Number of threads
3

Stitch length
2.2- 3.2mm

Needle space
4.8, 5.6, 6.4

Overedge width
—

Differential feed ratio
0.5- 1.3mm

Air pressure
5kgf/cm² (0.5MPa)

Air consumption
250Nl/min

Power source
Single phase : 100, 220, 240V
3 phase   : 200, 220, 240V

Power consumption
700W/h

PEGASUS

MEMO

MEMO

The description in this INSTRUCTIONS is subject to change without notice.