



PEGASUS®

SOH Series

**MODELS: SOH-530 / W500-08J
SOH-540 / WT500-08J**

Thank you for purchasing Pegasus' automatic unit.

Study this manual very carefully before beginning any of the procedure and then use the device correctly and safely.

Keep this manual in a convenient place for quick reference when needed.

¹ Integrated sewing unit for hemming flat sleeves

INSTRUCTIONS

9A2793E

Applications and performance

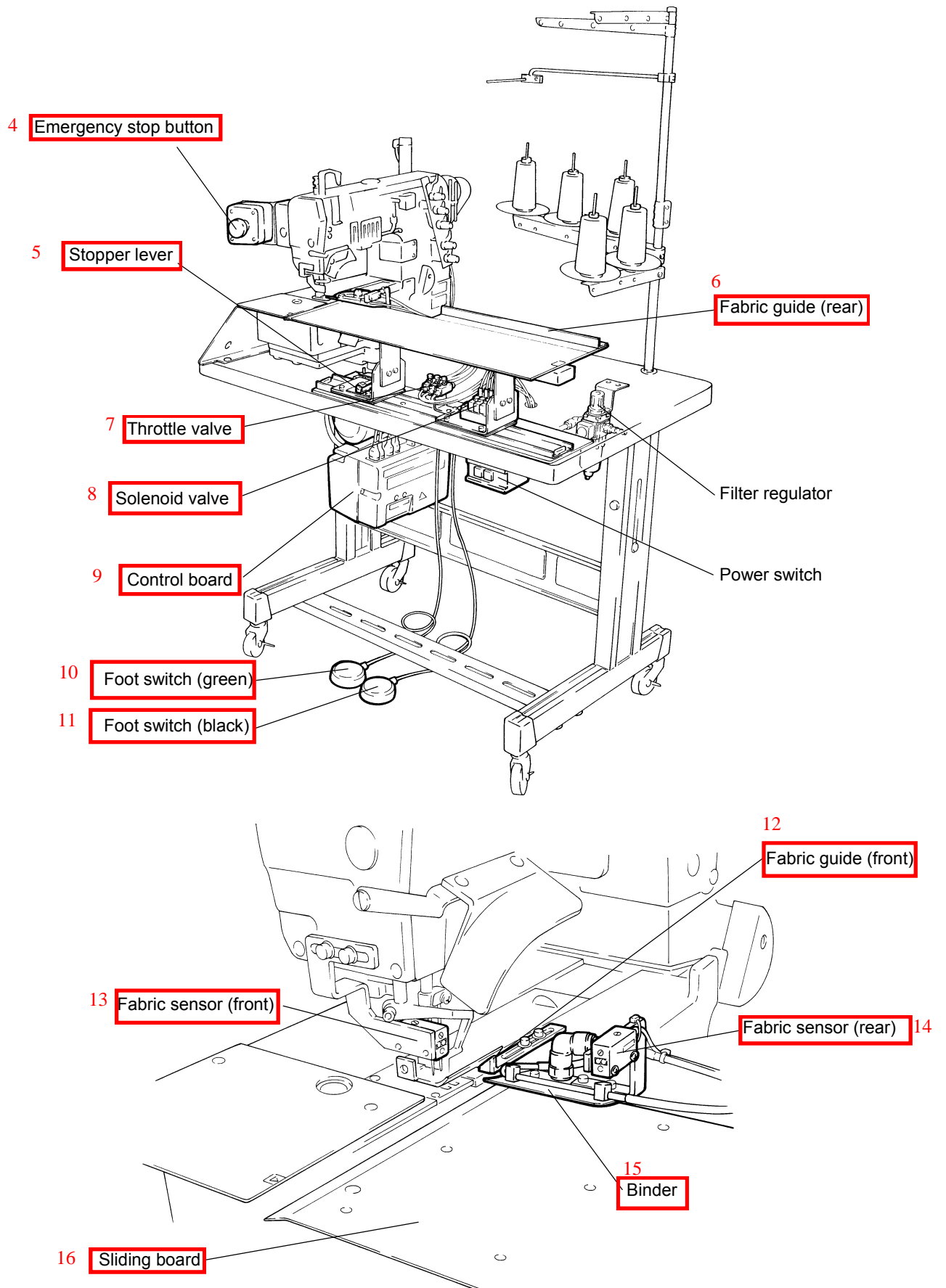
- 2 Features:
SOH-500 Series (Integrated sewing unit for hemming flat sleeves) automates and de-skills a difficult operation in hemming flat sleeves of T-shirts, polo shirts and similar garments, producing uniform products. The operator simply places the fabric on the guide. The unit completes sewing while forming a clean finished hem.

Installation

Installation

Mechanic level

Description of each part

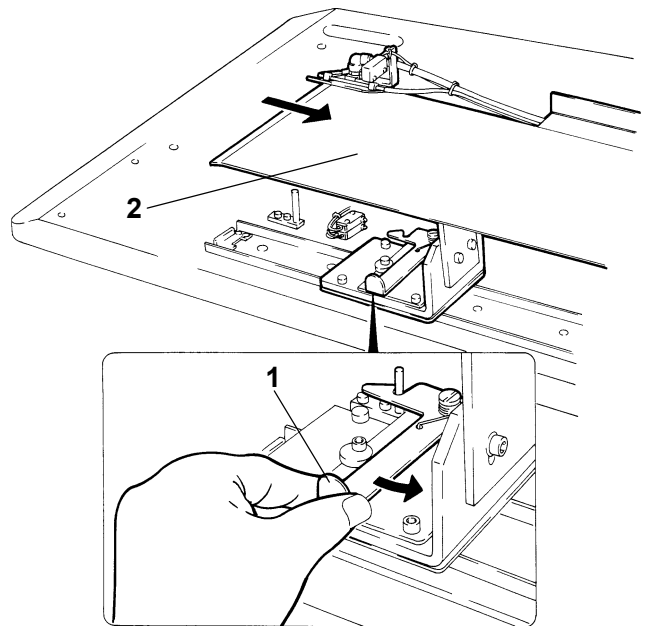


Installation

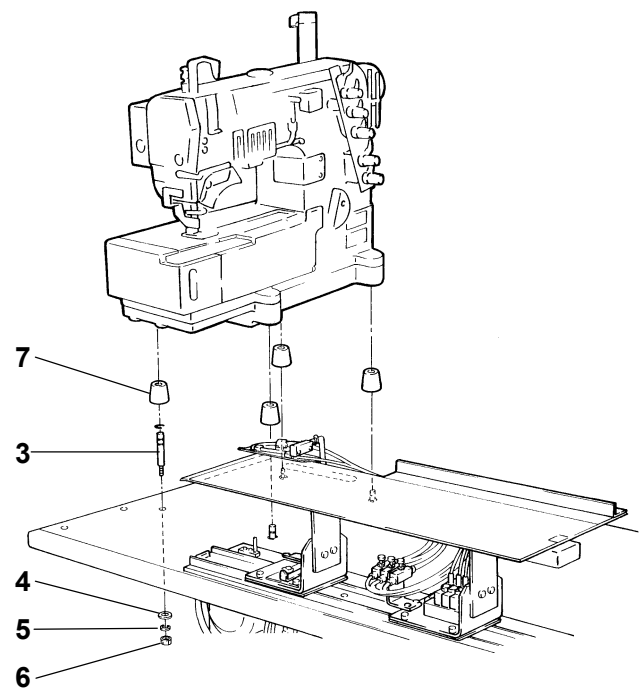
Mechanic level

Sewing machine installation

- 17 1. Slide sliding board **2** backward while moving stopper lever **1** in the direction of the arrow.



- 18 2. Secure step pin **3** to the table with washer **4**, spring washer **5** and nut **6** (four places). Fit rubber cushion **7** onto step pin **3**. Then mount the machine head. See the illustration on the right.



19 1. To install the belt cover

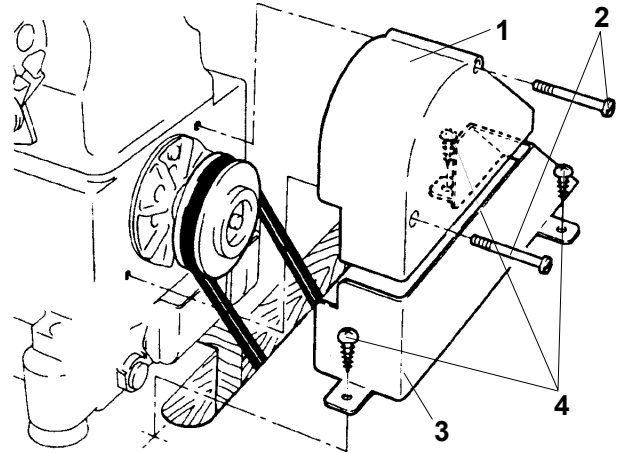


CAUTION



20

Always turn off the power, unplug the machine and then well-qualified technicians should install the belt cover.



- 21 Place the V belt on the machine pulley. Install upper belt cover 1 with screws 2. Secure lower belt cover 3 to the table with wood screws 4.

22 2. To install the position detector

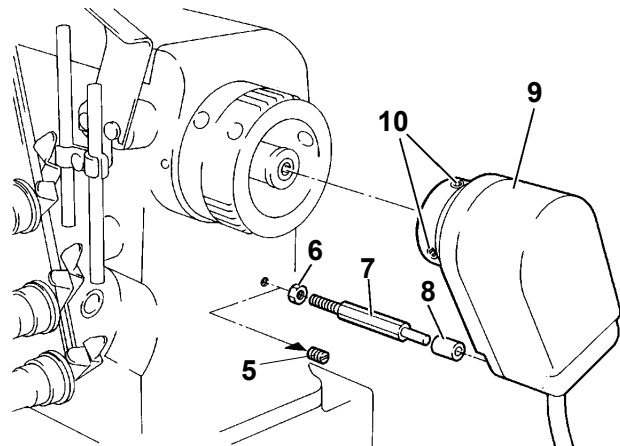


CAUTION



23

Always turn off the power, unplug the machine and then well-qualified technicians should install the position detector.



- 24 Remove screw 5. Secure screw 7 to the machine head with nut 6. Fit stopper 8 onto screw 7. Fit position detector 9 to the handwheel. Then tighten screws 10.

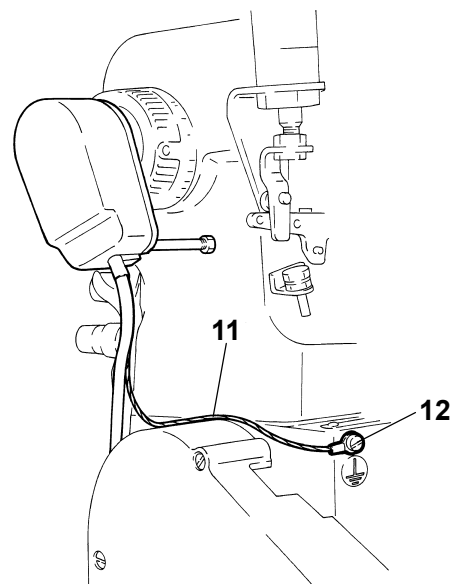
- 25 Connect GND wire 11 to the machine with screw 12 (see the illustration on the right).



WARNING



Be sure to connect the GND wire. Otherwise you may get an electric shock and/or the data programmed may break down.

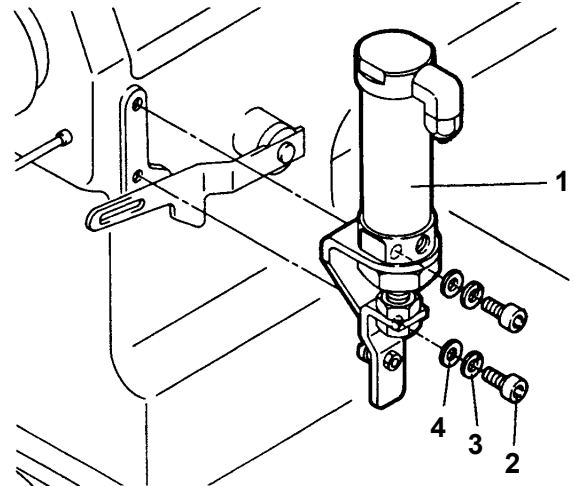


3. To install the presser foot lift air cylinder



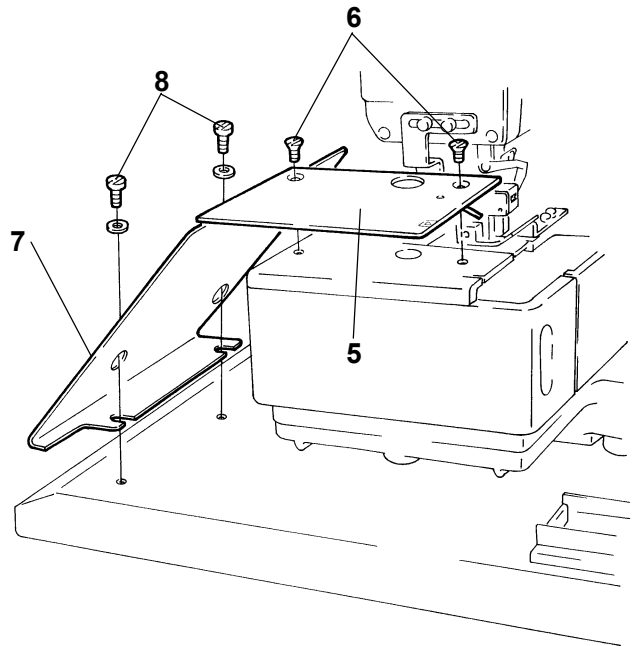
Always turn off the power and shut down the air compressor first and then well-qualified technicians should install the presser foot lift air cylinder.

Install presser foot lift air cylinder **1** on the machine with screws **2**, spring washers **3** and washer **4**.



26 4. To install the front and rear fabric guards

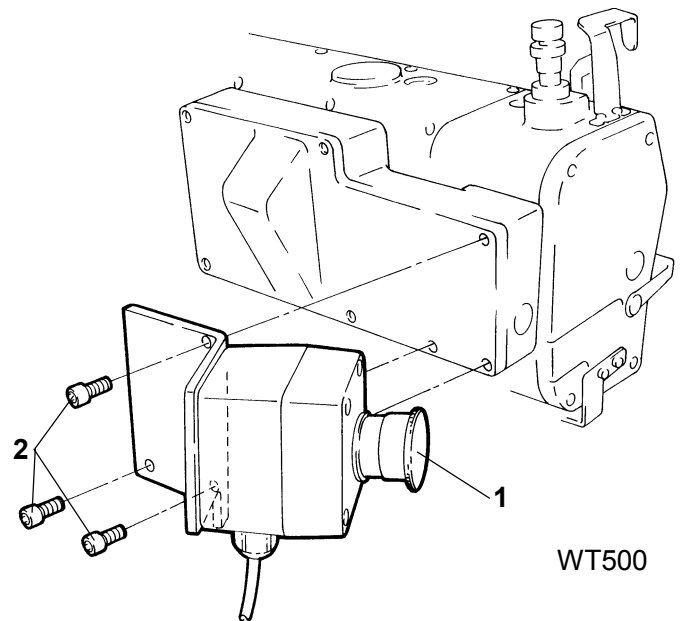
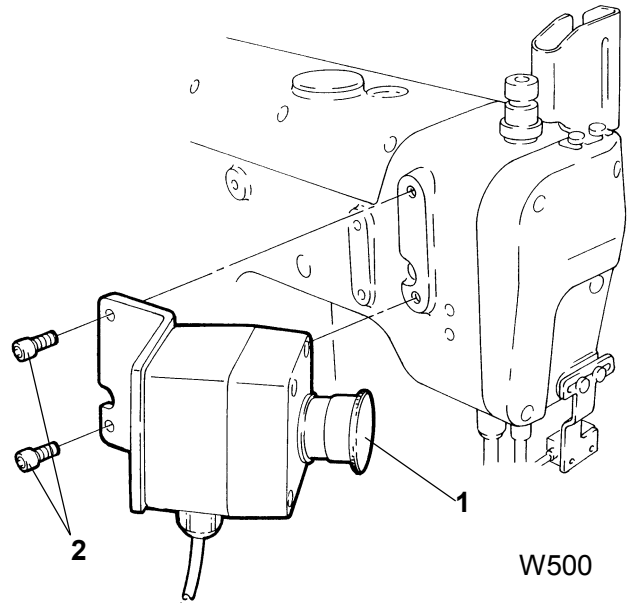
27 Install front fabric guard **5** on the machine with screws **6**.
Install rear fabric guard **7** on the table with screws **8**.
See the illustration on the right.



Installing the accessories

28 5. To install the emergency stop button

29 Install emergency stop button 1 on the machine with screws 2 (see the illustration on the right).



Installation

Mechanic level

Connecting the cords

CAUTION



Always turn off the power, unplug the machine and then well-qualified technicians should connect relay cords. Match the colors and shapes of the connectors when connecting the relay cords.

WARNING

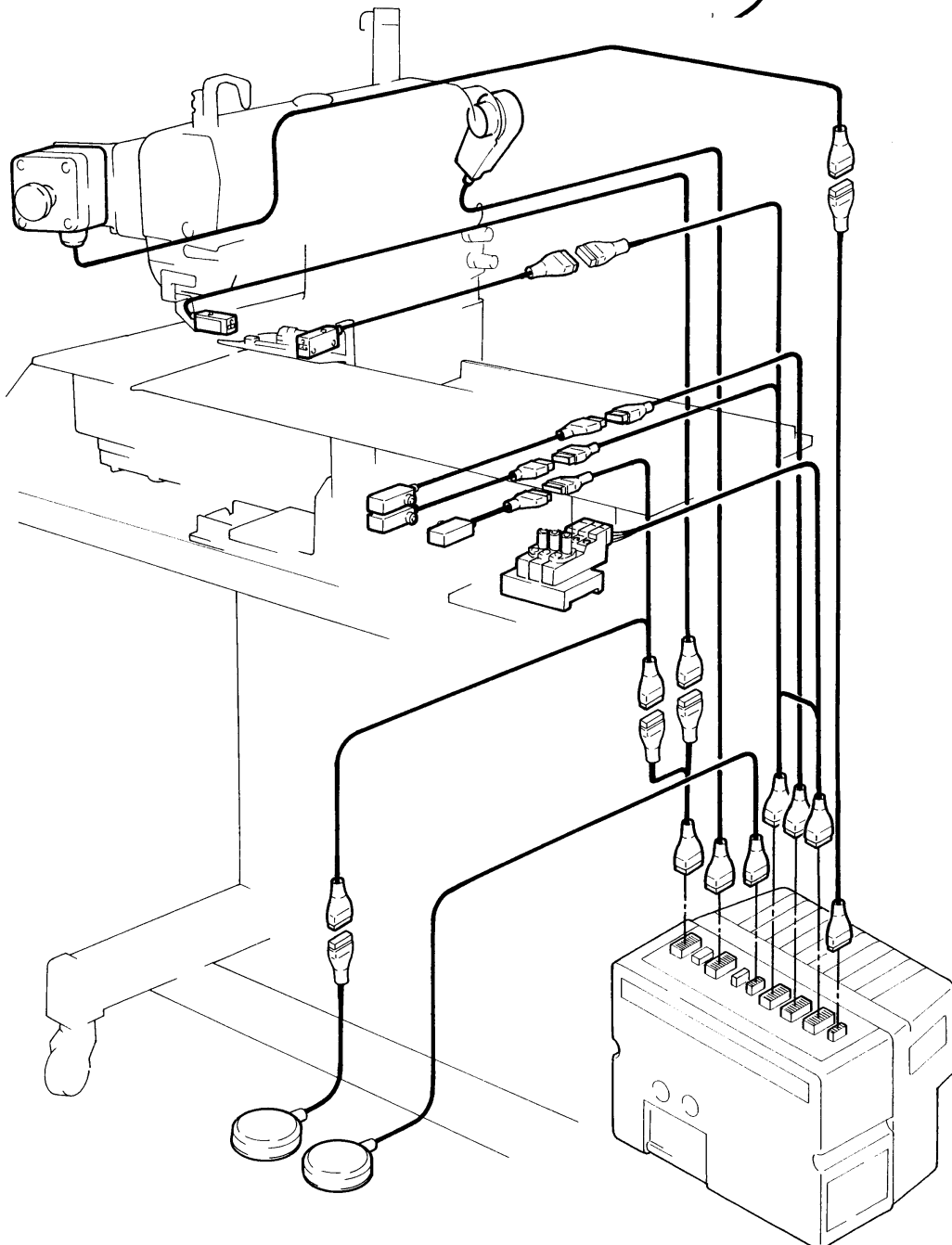
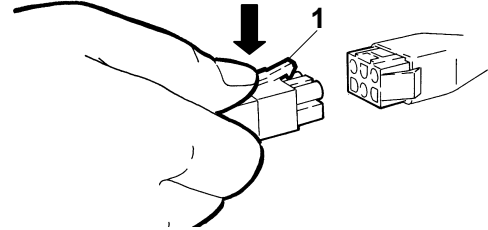


Faulty wiring of the relay cords may cause a malfunction. To prevent accidents and damage to the machine, check the relay cords for correct wiring.

To disconnect the locking connector, pull the connector while pressing locking mechanism 1 with your thumb.

30

Connect the cords by referring to the illustration below





Installation

Mechanic level


Connecting the air lines

CAUTION

 Always turn off the power and shut down the air compressor first and well-qualified technicians should connect the air line.

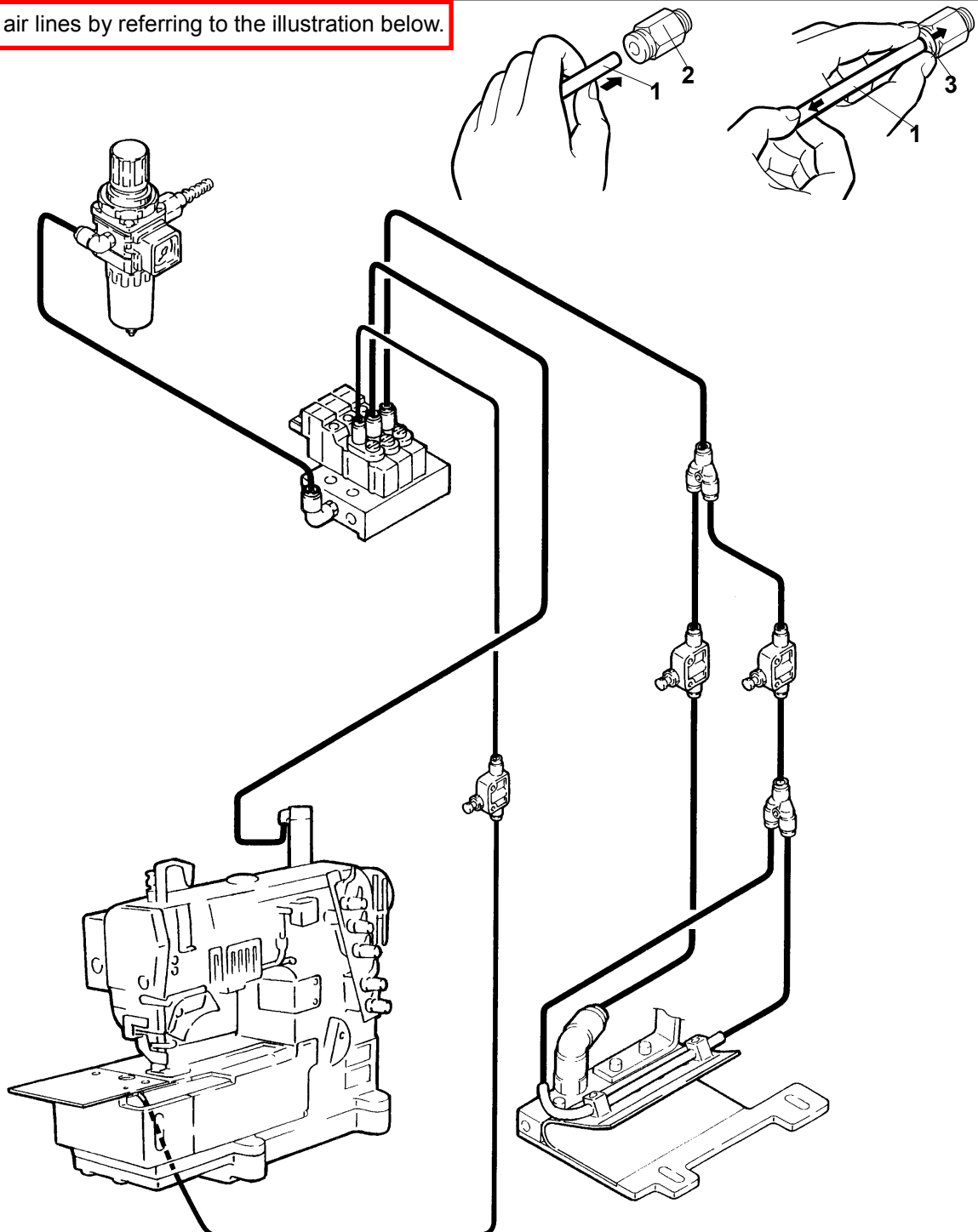
 Before connecting to the air compressor (air source), all the air lines should be connected completely.

WARNING

 Improper piping of the air lines may cause a malfunction. To prevent accidents and damage to the machine, check all the air lines for correct piping.

Insert the tube 1 completely to the depth of the joint 2. And check if the air tube can not be removed by pulling it by hand. To remove the air tube 1 from the joint 2, push the release ring 3 toward the joint 2 and pull out the air tube 1.

31 Connect the air lines by referring to the illustration below.



CAUTION

To adjust the filter regulator, turn off the power and finish air piping and then turn on the air compressor.



Be sure to drain periodically before drainage level reaches the baffle. Otherwise the drainage will flow into the solenoid valve or air cylinder and may cause trouble. Note that drainage spouts downward with air.

1. Adjusting air pressure

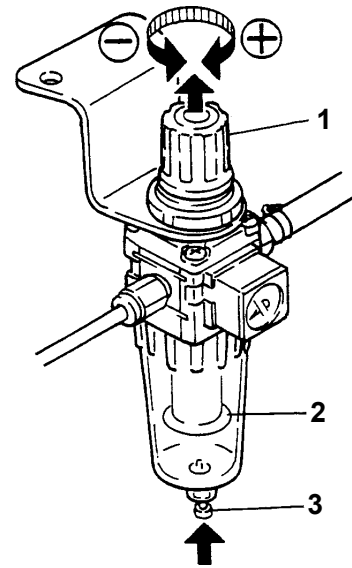
Pull up knob **1** on filter regulator until it clicks. Then set the air pressure at 0.5Mpa. (5kgf/cm²).

To increase the air pressure, turn knob **1** clockwise.

To decrease the air pressure, turn knob **1** counterclockwise.


2. Draining the filter regulator

Drain the filter regulator by pressing button **3** before drainage level reaches baffle **2**.

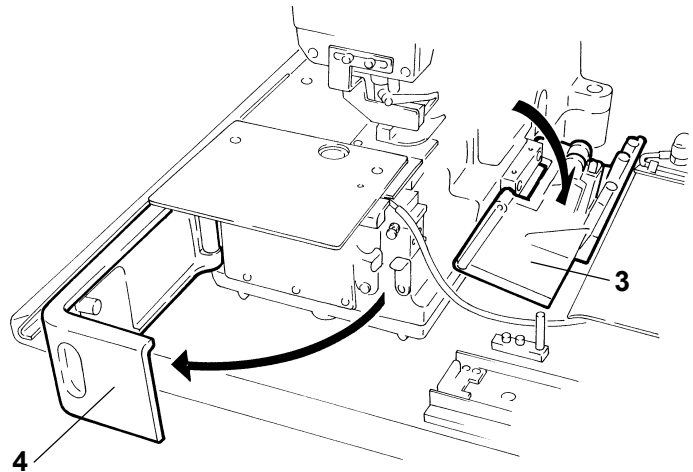
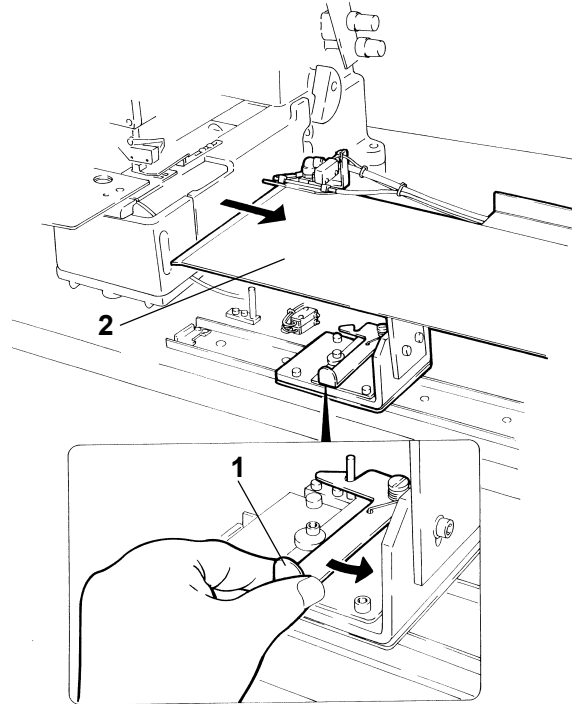


Threading the machine

 **CAUTION**

 Always turn off the power, unplug the machine and then well-qualified technicians should thread the machine.

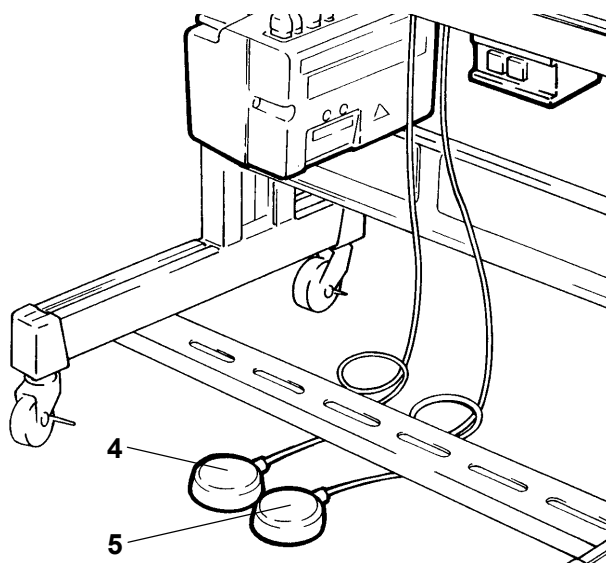
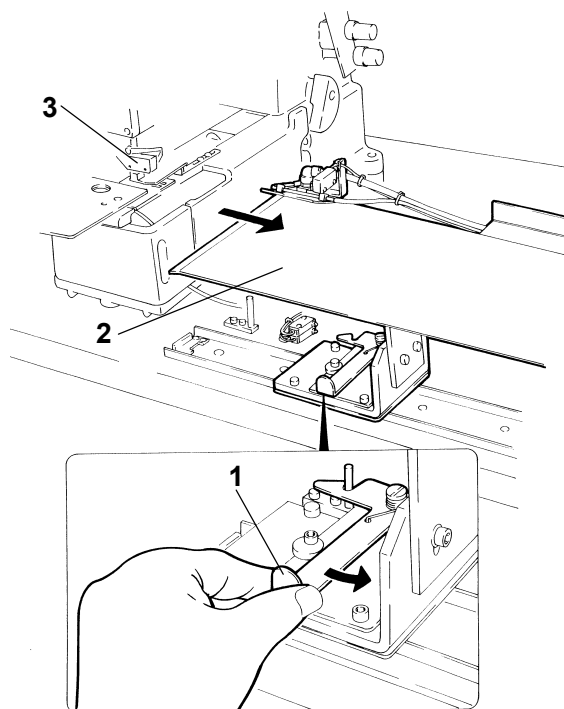
- 32 1. Slide sliding board **2** backward while moving stopper lever **1** in the direction of the arrow.
- 33 2. Open front cover **3** and side cover **4**.
- 34 3. Thread the machine by referring to the threading diagram in the instruction manual of the machine.
- 35 4. After threading the machine, close front cover **3** and side cover **4**. Then slide sliding board **2** back into place.



Basic Adjustment

Before adjusting the threads' tension

- 37 1. Slide sliding board **2** backward while moving stopper lever **1** in the direction of the arrow.
- 38 2. The presser foot is in its up position while foot switch (black) **5** is pressed. Raise the presser foot by pressing foot switch (black) **5**. Then position the fabric.
- 39 3. The machine runs while foot switch (green) **4** is pressed. Start the machine by pressing foot switch (green) **4**. Then adjust the threads' tension while sewing the fabric.
The machine stops when the fabric has gone through fabric edge sensor **3**.
- 40 4. Slide sliding board **2** back into place after this adjustment is made.



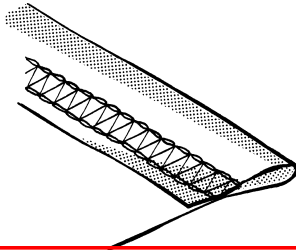
Adjusting the fabric edge

 **CAUTION**

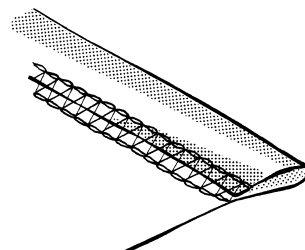

Always turn off the power, unplug the machine and then well-qualified technicians should adjust the fabric edge.

42

- 43 The following adjustments should be made if the fabric edge protrudes from or retracts into the seams produced by the left needle.

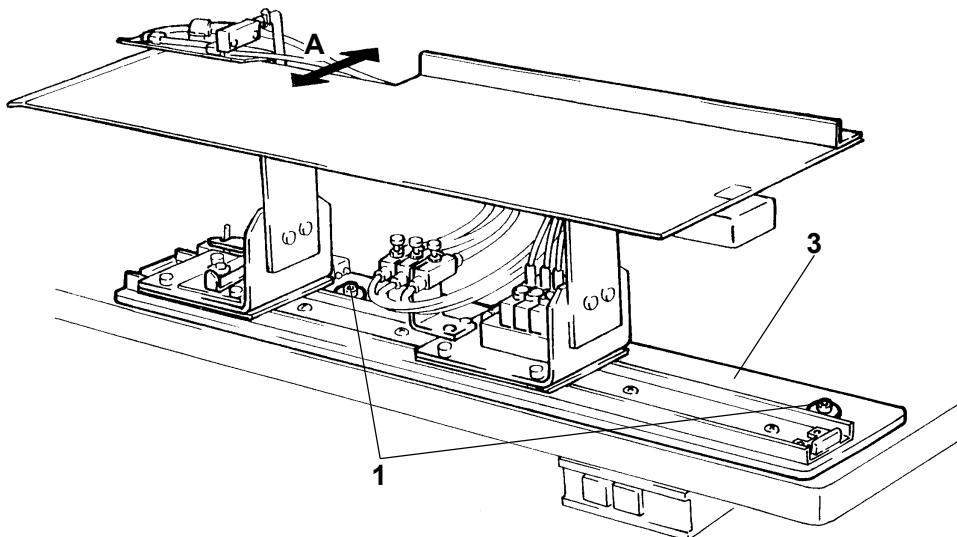


- 44 The fabric edge protrudes from the seams.

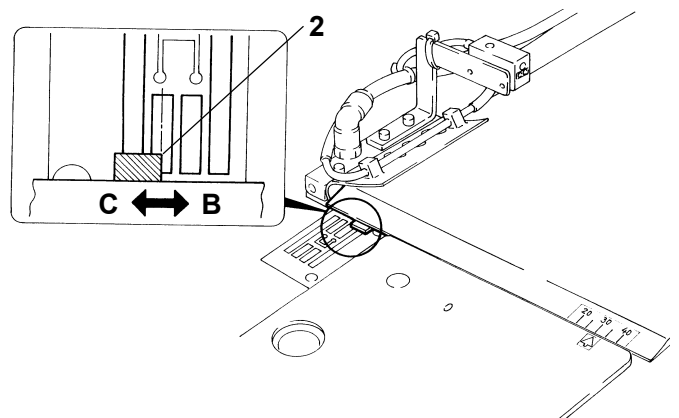


- 45 The fabric edge retracts into the seams.

- 46 1. Loosen screws 1.



- 47 2. To make a standard adjustment, move table board 3 as required in the direction of arrow A and then align end 2 of the guide with the center of the slot on the needle plate (see the illustration).



- 48 3. If the fabric edge protrudes from the seams produced by the left needle, move the end of the guide slightly in the direction of arrow B. If the fabric edge retracts into the seams produced by the left needle, move the end of the guide slightly in the direction of arrow C.


CAUTION


50 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the binder.

51 Adjust the binder if it is difficult to position the fabric under the binder or the hem is not uniformly formed.

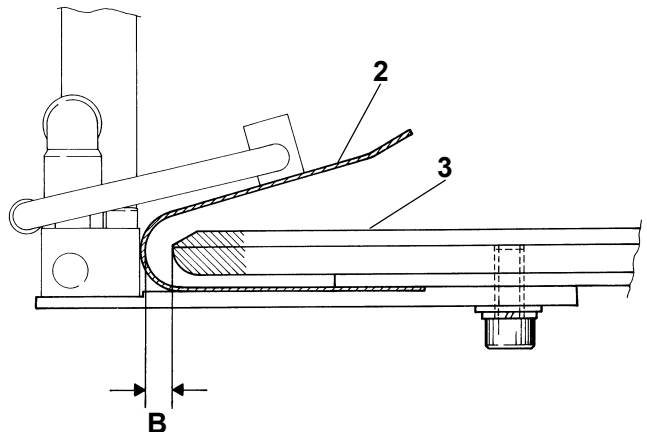
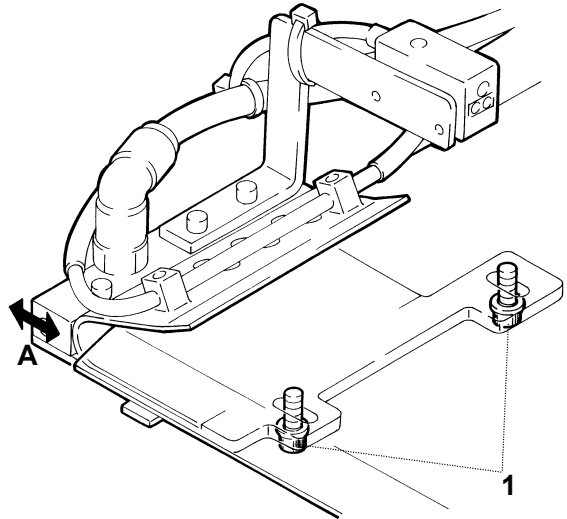
52 1. Loosen screws 1.

53 2. Move binder 2 in the direction of arrow A. Adjust clearance B between middle plate 3 and binder 2 according to the fabric (3mm is standard).

If B is too small for the fabric, it is difficult to position the fabric under the binder.

If B is too large for the fabric, the hem is not uniformly formed.

54 3. Tighten screws 1 after this adjustment is made.




CAUTION


56 Always turn off the power, shut down the air compressor first and well-qualified technicians should adjust hem width.

57 To adjust the hem width

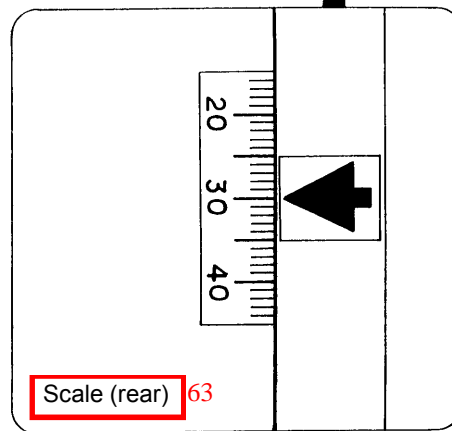
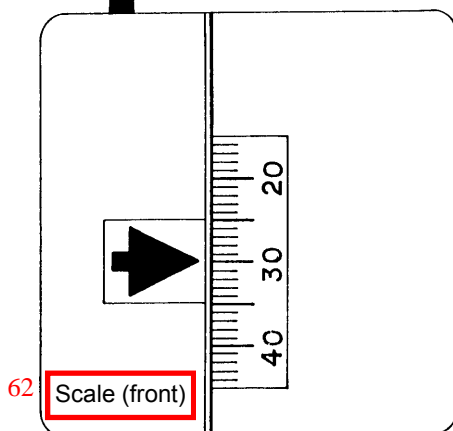
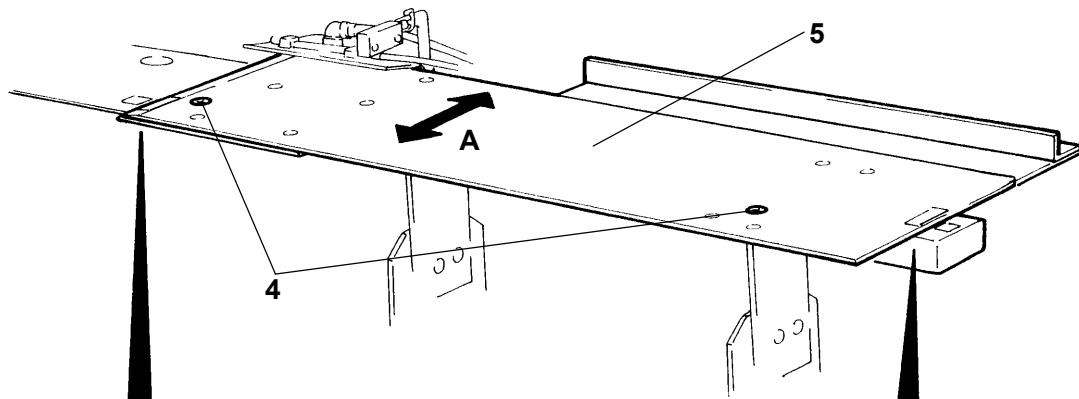
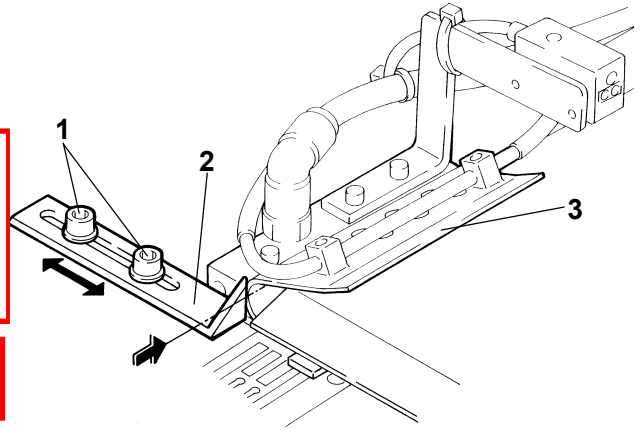
58 1. Loosen screws 1 and 4.

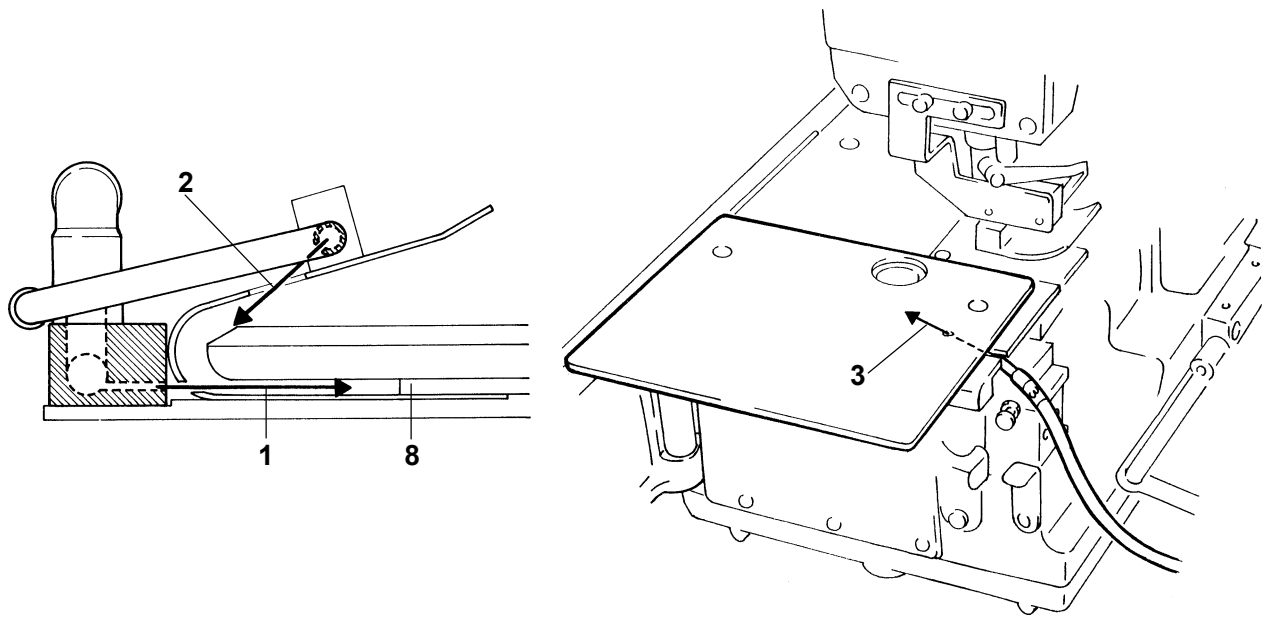
59 2. Slide sliding board 5 in the direction of arrow A. Adjust the hem width while referring to the scale at the front or back end of sliding board 5. Tighten screws 4 after this adjustment is made.

3. Align the end of fabric guide 2 with that of binder 3. Tighten screws 1.

60 The scale should be used as the reference. To form the hem properly, check the finished hem and then

61 make a fine adjustment.



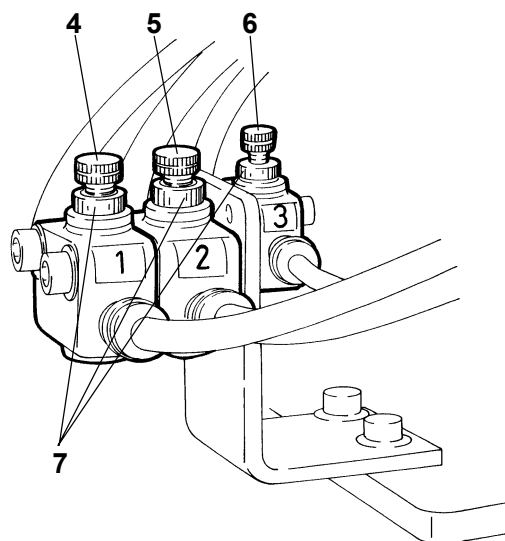
64 **Adjusting the air blows**

65 **Air blow 1** To position the fabric along guide **8**. If the air blow is too strong, jamming of the fabric tends to occur. If the air blow is too weak, the hem is not uniformly formed. Adjustment is made by turning knob **4**.

66 **Air blow 2** To position the fabric correctly under the binder. If the air blow is too strong or too weak, the fabric is not positioned properly under the binder. Adjustment is made by turning knob **5**.

67 **Air blow 3** To remove the fabric when sewing is completed. Adjustment is made by turning knob **6**.

68 To adjust each air blow, loosen nuts **7** first and then turn each knob. To increase the amount of air blow, turn each knob counterclockwise. To decrease the amount of air blow, turn each knob clockwise. Tighten nuts **7** after the adjustment is made.



Changing the thickness of the fabric

CAUTION



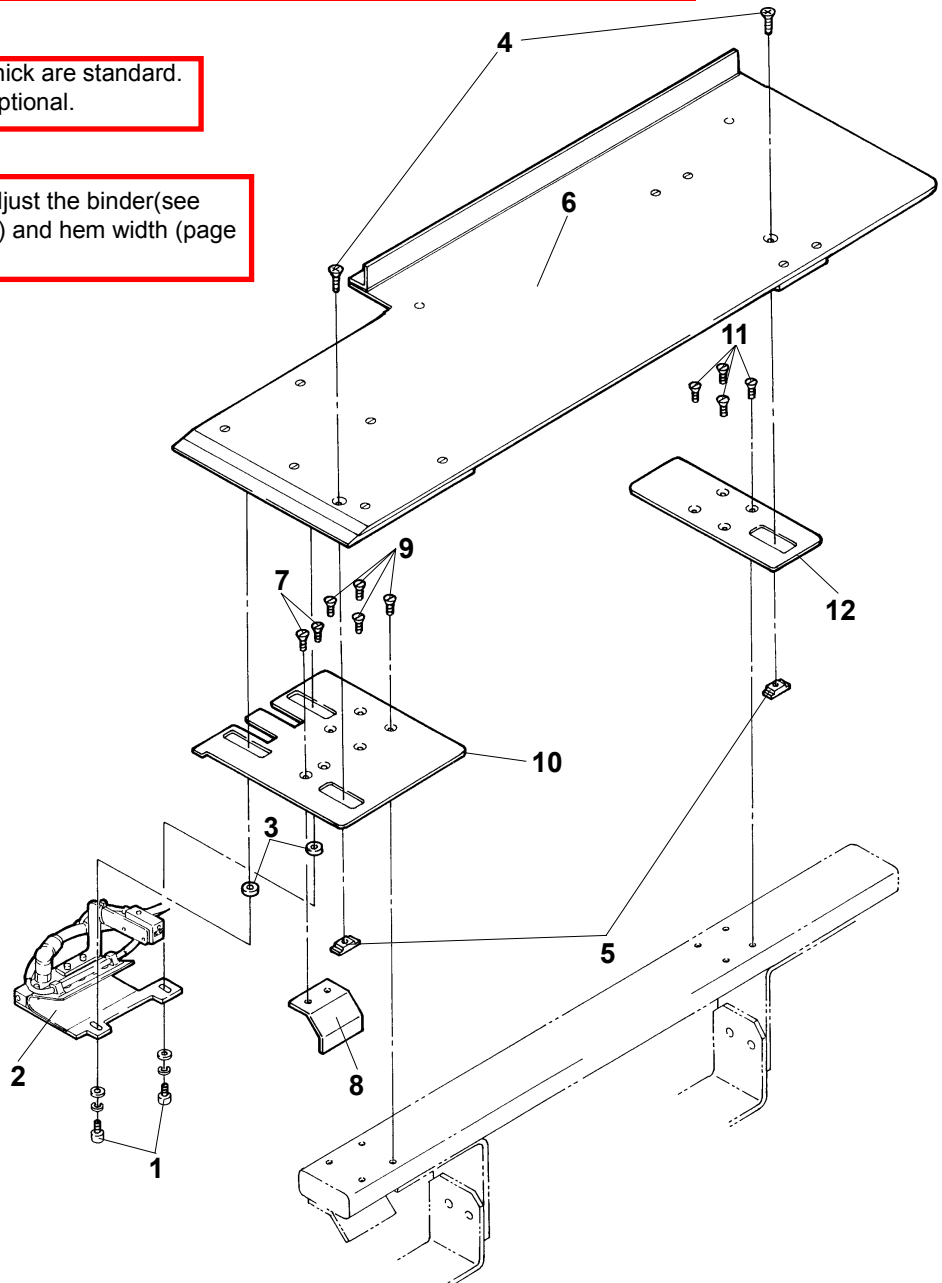
Always turn off the power, unplug the machine and then well-qualified technicians should change the guides.

70

- 71 1. Remove screws 1, binder 2 and spacers 3.
- 72 2. Remove screws 4, guide plates 5 and sliding board 6.
- 73 3. Remove screws 7 and bracket 8.
- 74 4. Remove screws 9 and guide (front) 10.
- 75 5. Remove screws 11 and guide (rear) 12.
- 76 6. Change spacers 3, guide (front) 10 and guide (rear) 12 according to the fabric.
- 77 7. Install the replacement parts by following a reverse of the procedure mentioned above.

- 78 Front and rear guides 1.6mm thick are standard. 2mm, 2.5mm and 3.2mm are optional.

- 79 After changing the guides, readjust the binder (see page 19), fabric edge (page 18) and hem width (page 20).



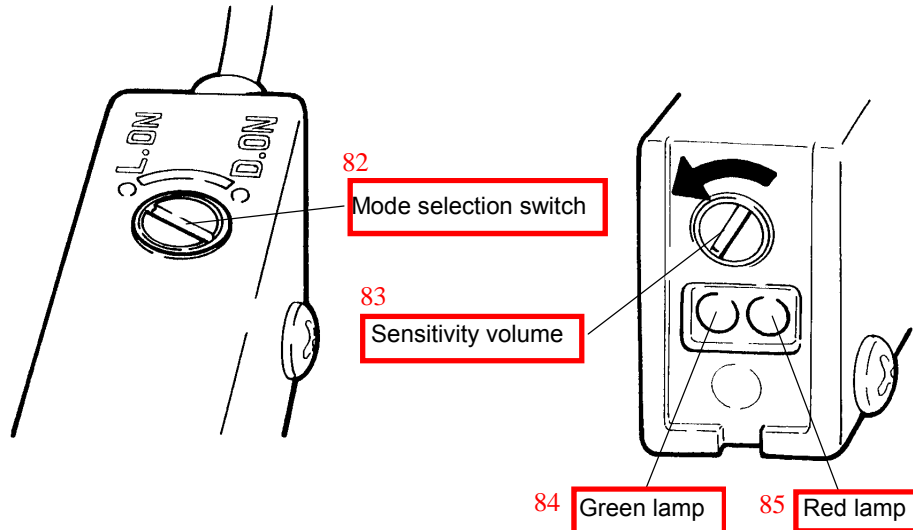
Adjusting the fabric edge sensor

CAUTION



Adjustments to the fabric edge sensor should be made with the power on. To prevent accidents due to the unexpected start of the machine, be extremely careful when performing the procedures.

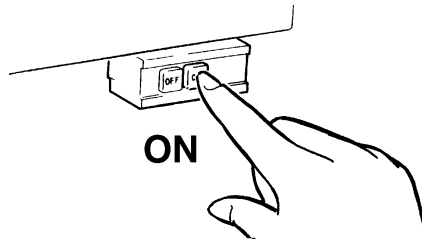
81



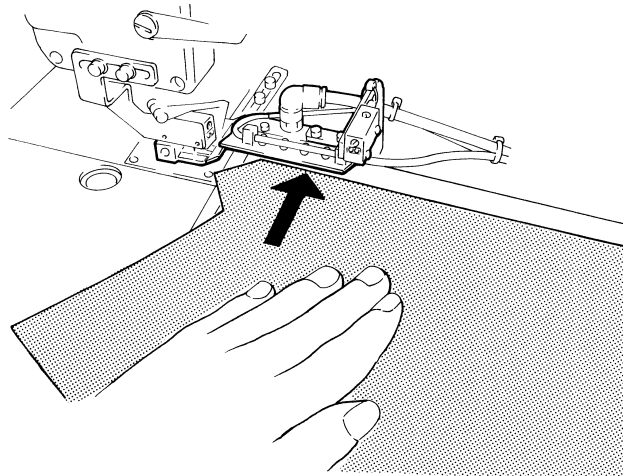
- 86 1. Check to make sure the mode selection switch is turned to L. ON. If it is not, turn it to L.ON.
- 87 2. Turn the sensitive volume counterclockwise to a minimum.
- 88 3. Turn the sensitive volume clockwise slowly until both the red and green lamps go on.
- 89 4. Check to make sure the red lamp goes off while the green lamp goes on with the fabric positioned under the fabric edge sensor.
If the red lamp does not go off with the fabric under the fabric edge sensor, turn the sensitive volume counterclockwise until the red lamp goes off.

Sewing

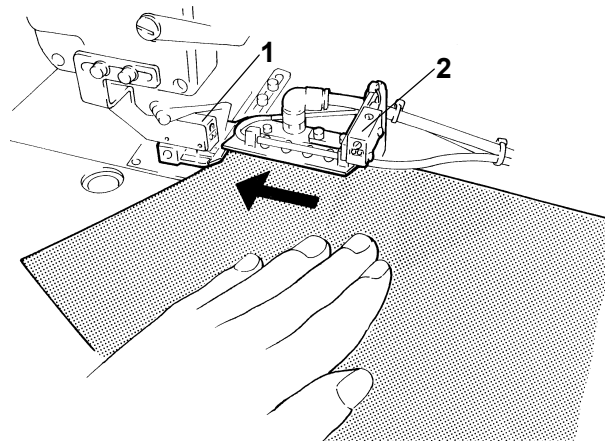
- 90 1. Turn on the power.



- 91 2. Position the fabric under the binder.



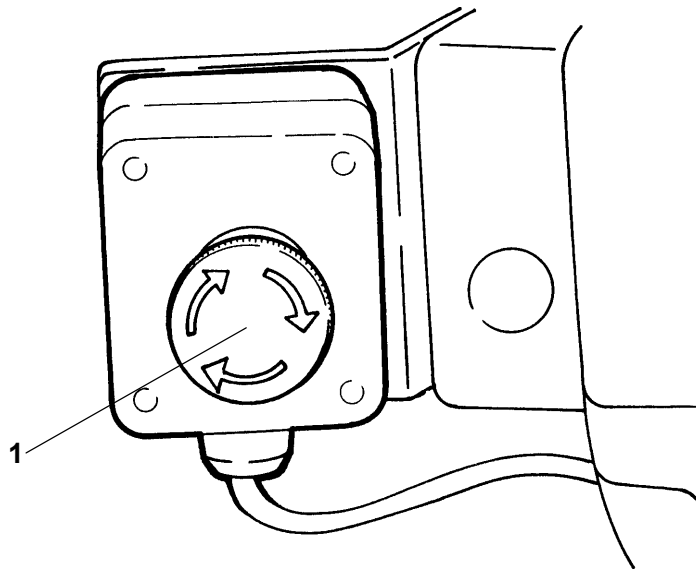
- 92 3. Slide the fabric under the presser foot.



- 93 4. If you select Auto start, the presser foot automatically descends as soon as fabric edge sensor (front) 1 detects the fabric and then the machine automatically starts sewing. If you select Manual start, pressing the foot switch (green) lowers the presser foot and then the machine automatically starts sewing.
To select Auto or Manual start, see [Selecting Auto/Manual start](#) on page 35.

- 94 5. If you press the foot switch (green) during sewing, the machine temporarily stops. To restart the machine, press the foot switch (green) again.
If you press the foot switch (green) after the fabric has gone through fabric edge sensor (rear) 2, the machine does not stop.

- 95 6. When sewing is completed, the machine stops and the presser foot ascends automatically.



96 If you press emergency stop button 1 during sewing, the machine instantly stops.

97 To release the emergency stop

98 1. Turn off the power.

99 2. Turn emergency stop button 1 in the direction of the arrow.


100 3. Turn on the power.

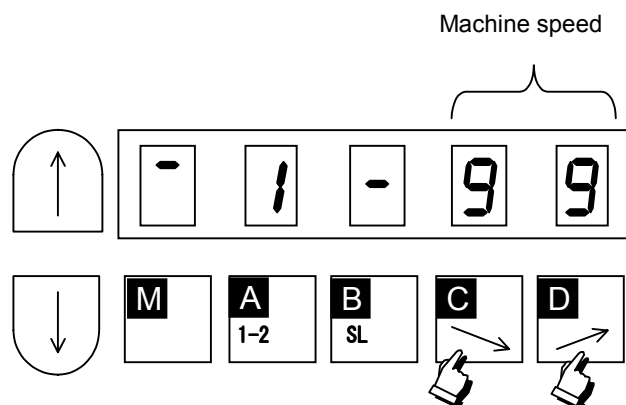
101 4. Remove the fabric being sewn by referring to “Before adjusting the threads’ tension” on page 17.

Entering sewing data


Adjusting the machine speed


CAUTION

 The power is on while the data is entered. Therefore, the machine could start unexpectedly. Great care should be taken in entering the data.



The machine speed can be adjusted with 99 steps in the range of the minimum to the maximum speeds.

To increase the machine speed by 1 step, press  key.

To decrease the machine speed by 1 step, press  key.



Adjustable in the range from 0 to 99.

Stopping the machine by stitch counting

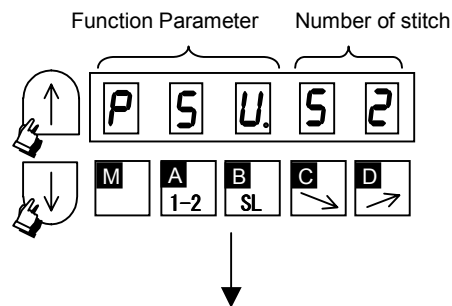
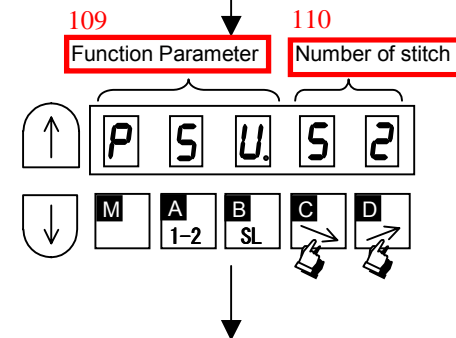
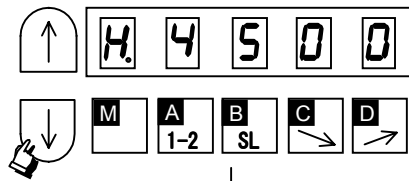
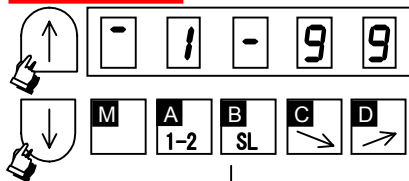
CAUTION

The power is on while the data is entered. Therefore, the machine could start unexpectedly. Great care should be taken in entering the data.

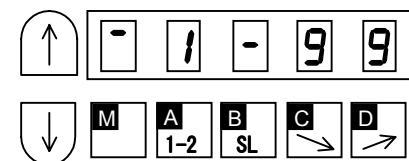
103 Enter the number of stitches from when the fabric has gone through the fabric edge sensor (rear) to when the machine stops.



How many times the keys ( , ) are pressed may depend on the version of the motor controller.

104 <Normal mode>





<Normal mode>









105 1. Turn on the power. Press  and  keys simultaneously for more than 2 seconds.

106 2. The display on the left appears.

107 Select function parameter **PSU.** by pressing  key 12 times.

108 If you press  key more than 12 times, press  key to call up the previous display.

3. The display on the left appears.
 Enter the number of stitches with  key and/or  key.
 Enter the first digit with  key.
 Enter the second digit with  key.
 Every time each key is pressed, the number changes with 0 to 9.
 Factory-set value: 52

4. Return to the normal mode by pressing  and  keys simultaneously.

Adjusting the machine speed at the start of sewing (Slow Start)

CAUTION

The power is on while the data is entered. Therefore, the machine could start unexpectedly. Great care should be taken in entering the data.

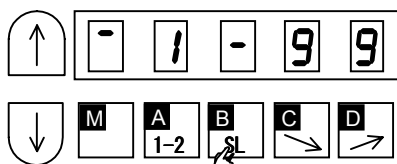
112 To run the machine at low speed at the start of sewing (Slow Start)

How many times the keys ( , ) are pressed may depend on the version of the motor controller.



113 1. To select Slow Start mode

Select "with slow start" or "without slow start."

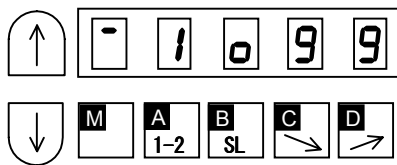
114 < without slow start >



Turn on the power.

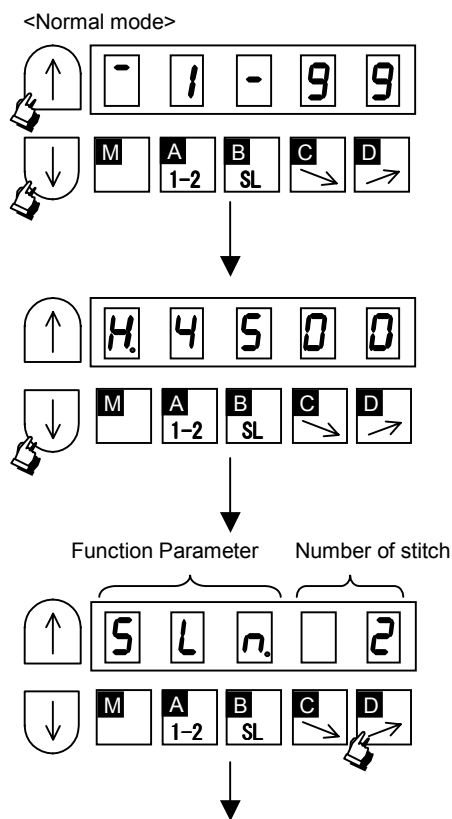
Pressing  key calls up the slow start mode. To release this mode, press  key again.

115 < with slow start >




116 2. To program the Slow Start stitch counter



Enter the number of stitches for Slow Start.




1. Turn on the power. Press  and  keys simultaneously for more than 2 seconds.

2. The display on the left appears.

Select function parameter **SLn.** by pressing  key 7 times.

If you press  key more than 7 times, press  key to call up the previous display.

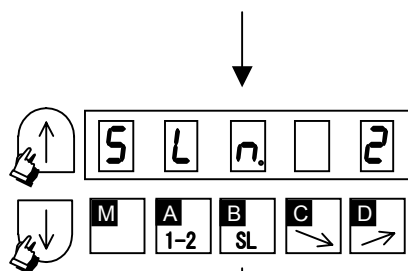
3. The display on the left appears.

Enter the number of stitches with  key.
Factory-set value: 2
Adjustable in the range of 1 to 5 stitches.

Continued on the following page.

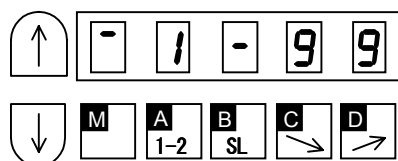
Adjusting the machine speed at the start of sewing (Slow Start)

Continued from the previous page.



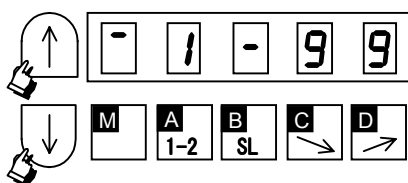
4. Return to the normal mode by pressing and keys simultaneously.

<Normal mode>



117 3. To program the Slow Start speed regulator Enter the number of revolutions for Slow Start.

<Normal mode>

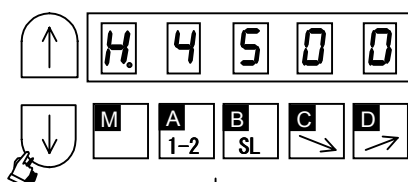


1. Turn on the power. Press and keys simultaneously for more than 2 seconds.

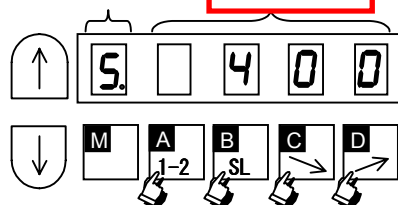
2. The display on the left appears.

Select function parameter **S.** by pressing key 6 times.

If you press key more than 6 times, press key to call up the previous display.



Function Parameter **Machine speed**



3. The display on the left appears.

Enter the machine speed with , , and keys.

Enter the fourth digit with key.

Enter the third digit with key.

Enter the second digit with key.

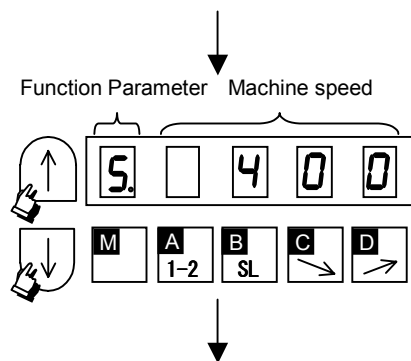
Enter the first digit with key.



Every time each key is pressed, the number changes with 0 to 9. Adjustable in the range of 0 to 2999 rpm.
Factory-set value: 400

Continued on the following page.

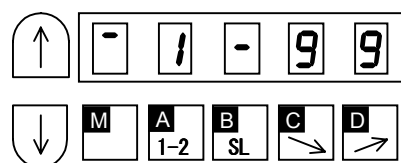
Adjusting the machine speed at the start of sewing (Slow Start)

Continued from the previous page.



4. Return to the normal mode by pressing  and  keys simultaneously.

<Normal mode>





Adjusting the machine speed at the end of sewing (Slow Down)

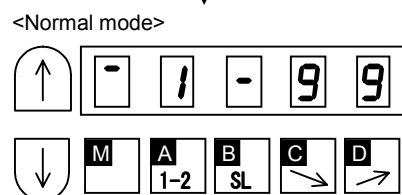
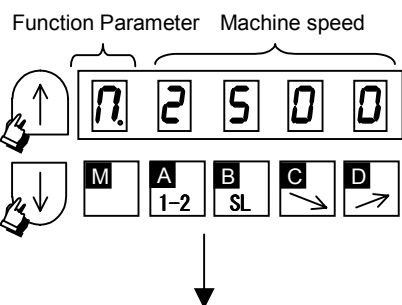
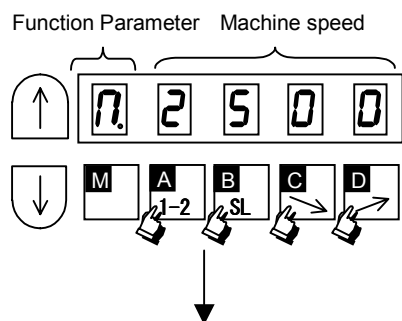
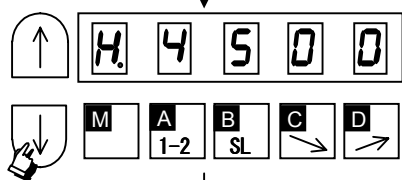
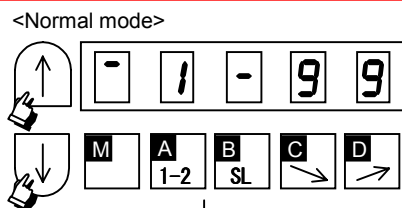
CAUTION

The power is on while the data is entered. Therefore, the machine could start unexpectedly. Great care should be taken in entering the data.

120 To run the machine at low speed at the end of sewing (Slow Dow)


How many times the keys ( , ) are pressed may depend on the version of the motor controller.



121 1. To program the Slow Down speed regulator







1. Turn on the power. Press  and  keys simultaneously for more than 2 seconds.


2. The display on the left appears.

Select function parameter **n.** by pressing  key 5 times.


If you press  key more than 5 times, press  key to call up the previous display.

3. The display on the left appears.

Enter the machine speed with  ,  ,  and  keys.



Enter the fourth digit with  key.

Enter the third digit with  key.

Enter the second digit with  key.

Enter the first digit with  key.

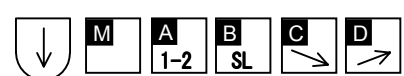
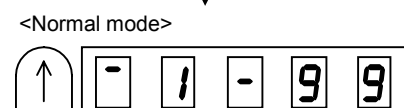
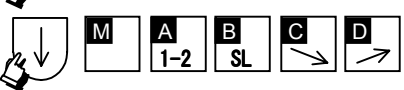
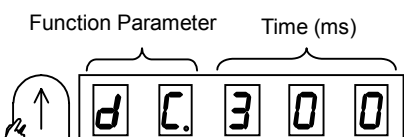
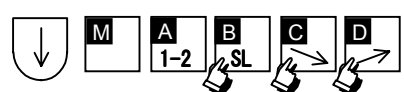
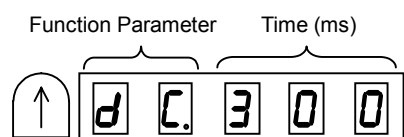
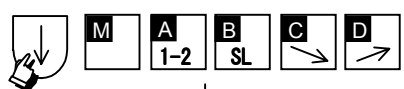
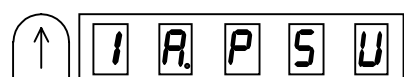
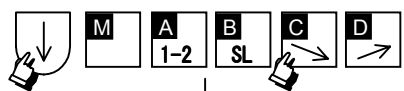
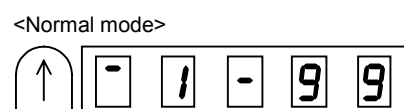
Every time each key is pressed, the number changes with 0 to 9. Adjustable in the range of 0 to 2999 rpm.
Factory-set value: 2500

4. Return to the normal mode by pressing  and  keys simultaneously.

Adjusting the machine speed at the end of sewing (Slow Down)

122 2. To program the Slow Down timing controller

Enter the time from when the fabric has gone through the fabric edge sensor (rear) to when the machine reduces speed.



1. Turn on the power. Press and keys simultaneously for more than 2 seconds.

2. The display on the left appears.

Select function parameter **dC** by pressing key 95 times.

If you press key more than 95 times, press key to call up the previous display.

3. The display on the left appears.

Enter the machine speed with , and keys.

Enter the third digit with key.

Enter the second digit with key.

Enter the first digit with key.

Every time each key is pressed, the number changes with 0 to

123 9. (key changes the number from 0 through 5.)
Adjustable from 0 through 510ms.



Factory-set value: 300

4. Return to the normal mode by pressing and keys simultaneously.

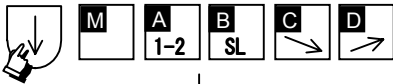
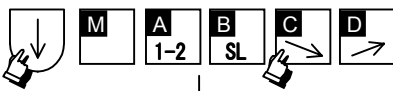
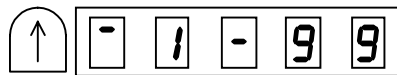
CAUTION

The power is on while the data is entered. Therefore, the machine could start unexpectedly. Great care should be taken in entering the data.

125 Select Auto or Manual start.

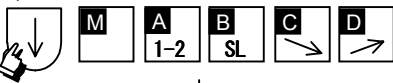
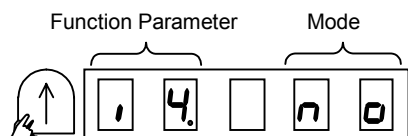
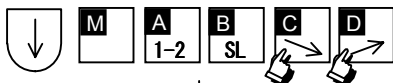
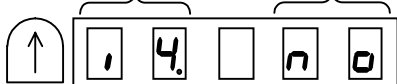
How many times the keys ( , ) are pressed may depend on the version of the motor controller.

<Normal mode>

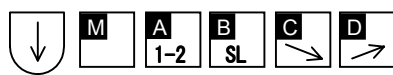
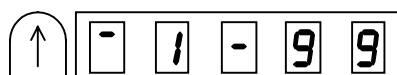




Function Parameter

Mode






<Normal mode>



1. Turn on the power. Press  and  keys simultaneously for more than 2 seconds.

2. The display on the left appears.


Select function parameter **14** by pressing  key 69 times.

If you press  key more than 69 times, press  key to call up the previous display.


126 3. The display on the left appears.

no displayed on the mode denotes Manual start.

Sl displayed on the mode denotes Automatic start.



To change Manual to Auto start, press  key twice.

no changes to **Sl**.

To change Auto to Manual start, press  key twice.

Sl changes to **no**.



The factory-set mode is Manual start.

4. Return to the normal mode by pressing  and  keys simultaneously.

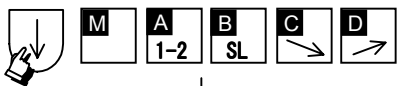
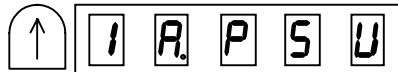
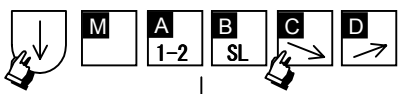
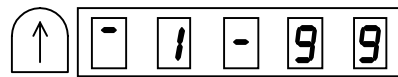
CAUTION

The power is on while the data is entered. Therefore, the machine could start unexpectedly. Great care should be taken in entering the data.

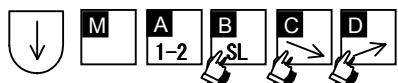
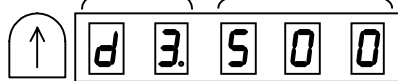
128 If you select Auto start, program the start timer. Enter the time from when the fabric edge sensor (front) has detected the fabric to when the presser foot descends.

How many times the keys ( , ) are pressed may depend on the version of the motor controller.

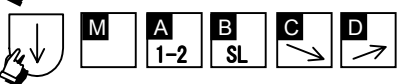
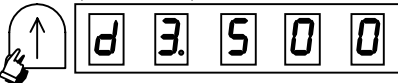
<Normal mode>



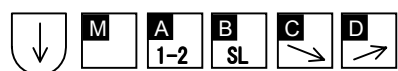
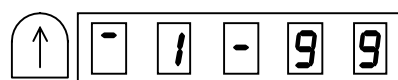
Function Parameter Time (ms)





Function Parameter Time (ms)






<Normal mode>



1. Turn on the power. Press  and  keys simultaneously for more than 2 seconds.

2. The display on the left appears.


Select function parameter **d3.** by pressing  key 121 times.

If you press  key more than 121 times, press  key to call up the previous display.

3. The display on the left appears.


Enter the machine speed with ,  and  keys.

Enter the third digit with  key.

Enter the second digit with  key.



Enter the first digit with  key.

Every time each key is pressed, the number changes with 0

to 9. ( key changes the number from 0 through 5.)

Adjustable from 0 through 510ms.



Factory-set value: 500

4. Return to the normal mode by pressing  and  keys simultaneously.

CAUTION

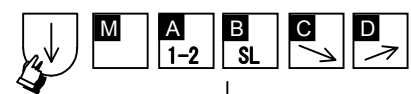
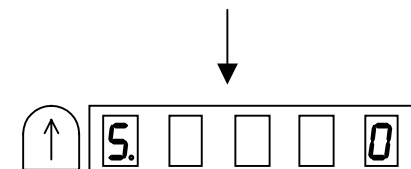
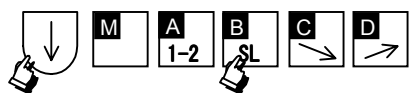
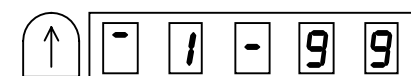
The power is on while the data is entered. Therefore, the machine could start unexpectedly. Great care should be taken in entering the data.

130 If you count the output, program the output counter.

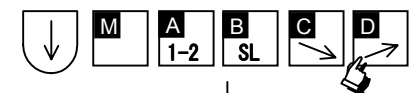
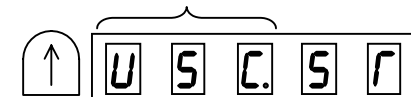
How many times the keys ( , ) are pressed may depend on the version of the motor controller.

131 **1. To program the output counter**
To enable the output counting function

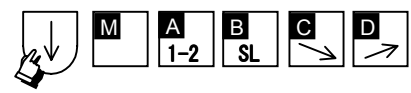
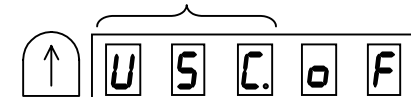
<Normal mode>



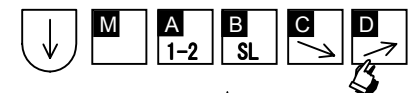
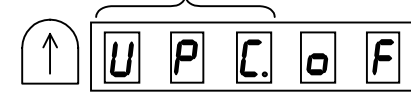
Function Parameter





Function Parameter




Function Parameter





Continued on the following page.


1. Turn on the power. Press  and  keys simultaneously for more than 2 seconds.

2. The display on the left appears.


Select function parameter **USC.** by pressing  key 6 times.



If you press  key more than 6 times, press  key to call up the previous display.

3. The display on the left appears.


Press  key.

4. The display on the left appears.

Select function parameter **UPC.** by pressing  key twice.

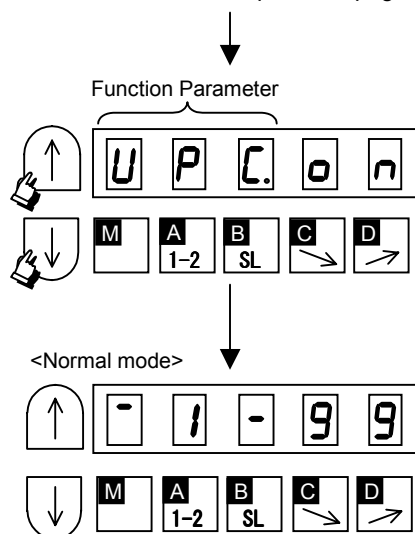
If you press  key more than 2 times, press  key to call up the previous display.

5. The display on the left appears.

Press  key.

Adjusting the output counter

Continued from the previous page.

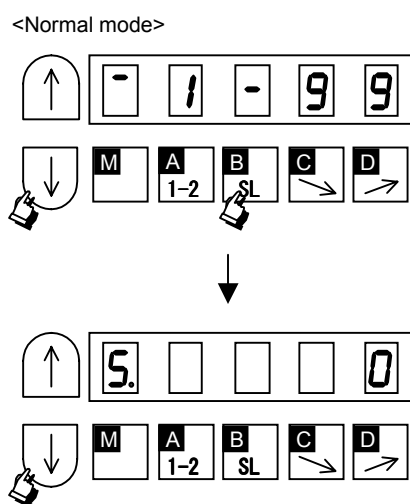


6. The display on the left appears.

Return to the normal mode by pressing and keys simultaneously.

132 2. To adjust the output counter

To check, reset and correct the number of counts



1. Turn on the power. Press and keys simultaneously for more than 2 seconds.

2. The display on the left appears.

Select function parameter **U.** by pressing key 4 times.

If you press key more than 4 times, press key to call up the previous display.

3. The display on the left appears. Then entering is completed.

To show "0" or to correct the number on the counter, press , , and/or key.

Enter the fourth digit with key.

Enter the third digit with key.

Enter the second digit with key.


Enter the first digit with key.

Every time each key is pressed, the number changes with 0 to 9.

134 4. Pressing and keys simultaneously calls up the normal mode display. (Sewing can be performed with the output count shown on the screen.)

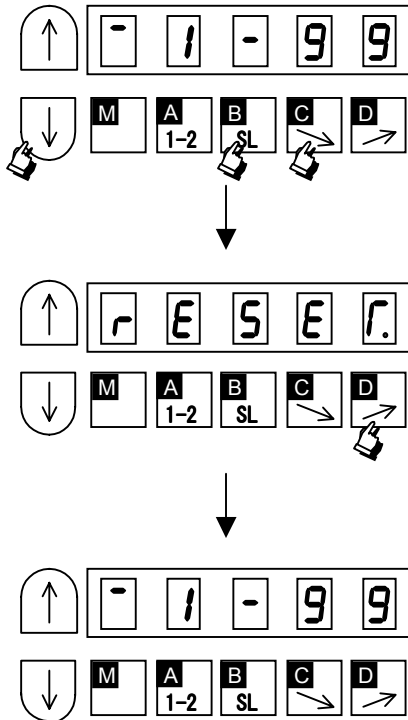
Resetting the machine




CAUTION

 The power is on while the data is entered. Therefore, the machine could start unexpectedly. Great care should be taken in entering the data.


135 To reset all the settings to the factory-set ones.

<Normal mode>

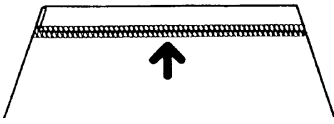
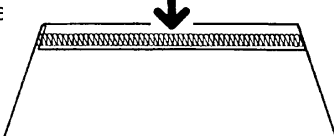


136 1. Press ,  and  keys simultaneously for more than 2 seconds.

2. The display on the left appears.

Press  for more than 2 seconds. The display automatically returns to the normal mode. Entering is completed.

Troubleshooting

No.	Phenomenon	Cause	Remedy	Inst. page
1	The machine does not get started with the power on. 137	Emergency stop is effective. 138	Release the emergency stop button. 139	26
2	The air blow does not come out with the fabric under the binder. 140	The sensitivity of the fabric edge sensor (rear) is not proper. 141	Adjust the sensitivity of the fabric edge sensor (rear). 142	23
3	The machine does not get started with Auto start selected. 143	A) The sensitivity of the fabric edge sensor (front) is not proper. 144	Adjust the sensitivity of the fabric edge sensor (front). 145	23
		B) The fabric edge sensor (front) is not detecting the fabric. 146	Adjust the position of the fabric edge sensor (front) so that it can detect the fabric placed under the presser foot. 147	—
4	Stitch skipping and/or thread breakage occurs. 148	The machine is running at idle because the number of stitches from when sewing is completed to when the machine stops is not proper. 149	Adjust the number of stitches so that the machine can stop as soon as sewing is completed. 150	29
5	<p>The fabric edge retracts excessively into the seams. 151</p>  <p>152</p> <p>The fabric edge protrudes</p> 	The position of the guide is not proper. 153	Adjust the position of the guide. 154	18
6	The fabric edge retracts excessively into the seams at the end of sewing. 155	Air blow 1 is too light. 158	Increase air blow 1. 157	21
		The presser foot pressure is too light. 156	Increase the presser foot pressure. 159	—

Sewing specifications

Applications	160 Hemming flat sleeves of T-shirts, polo shirts and similar garments
Fabrics	161 Plain knit fabric, Honeycomb fabric, Rib knit fabric, Interlock fabric, etc.
Threads	162 Spun, Polyester spun, Woolly nylon
163 Fabric size	Length of sleeve opening: 600mm (max.) Length of sleeve side: 300mm (max)
164 Hem width	20mm 30mm

Unit specifications

Model name	SOH - 530 , SOH - 540
Equipped with	W562-08JC X 356 (SOH-530) WT562-08JB X 248 , WT562-08JC X 356 (SOH-540)
Measurement	Width: 990mm Depth: 596mm Height: 1200mm 1440mm (except thread stand)
Number of needles	3
Number of threads	5
Stitch length	1.2 4.4mm
165 Needle space	4.8mm , 5.6mm
Differential feed ratio	1:0.5 1:1.3
Presser foot lift	5mm
Machine speed	4500rpm
Power source	AC 100V 120V , 200 240V
Air pressure	0.5MPa (5kgf / cm ²)
Air consumption	95l / min (ANR)
Power consumption	550.4w



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