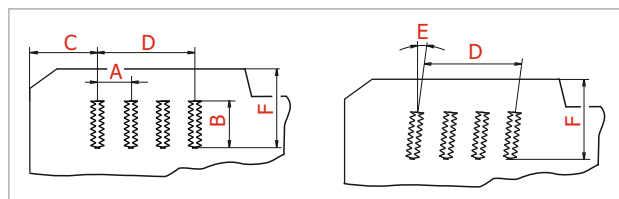


## Technical Specifications

	S-4002 ISBH STANDARD VERSION	S-4002 ISBH SILK-THREAD VERSION
Motor	DC Drive	
Sewing Speed	1,500 - 3,800 spm	
Stitch Type	Single Thread Chainstitch	
Stitch Length	0.3 - 5 mm	
Stitch Bite	1.7 mm - 2.3 mm	
Buttonhole Type	Imitation Sleeve Buttonhole	
Number of Buttonholes	1 - 8	
Distance between Buttonholes (A)	4 - 100 mm (Adjustable in Programme)	
Buttonhole Length (B)	5 - 25 mm	
Maximum Distance from Edge (C)	67 mm	
Maximum Distance First to Last Buttonhole (D)	100 mm	
Angle Adjustable (E)	0° - 30°	0° - 30°
Maximum Distance from Edge (F)	up to 78 mm	
Thread Trimming	Pneumatic	
Recommended Thread	Core Spun Polyester No. 80, 100, 120	Tex Size 30, 40, 50, 60 Core Spun Polyester No. 80, 100
Recommended Needle	AMF Reece Series 750 Size 90/14, 80/12, 70/10	
Clamp Height	12.7 mm	
Maximum Work Thickness	3 mm	
Clamping	Pneumatic	
Lubrication	Semi - Automatic	
Control System	PLC	
Table Types	Crosswise	
Electrical Requirements	230 V 50/60 HZ 1 phase (according to EN 60204-1)	
Air Requirements	5.5 bar (80 psi) 14l/m (.5 cfm)	
Dimensions Head and Table	1150 mm (L) x 700 mm (W) x 710 mm (H)	
Dimensions Packed Weight	1300 (L) x 770 (W) x 1150 (H) 200 kg Gross	

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

Indexer Angle (E)	Max. Length (D)	Depth (F)
0°	100 mm	78 mm
6°	100 mm	75 mm
10°	100 mm	72 mm
15°	99 mm	70 mm
20°	93 mm	67 mm
25°	87 mm	63 mm
30°	80 mm	60 mm



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



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new

S-4002



## Imitation Sleeve Buttonhole with Electronic Feeding

The S-4002 ISBH is a fully electronically controlled chainstitch straight buttonhole machine designed for sewing decorative non-functional buttonholes on jacket sleeves. The machine is based on the well known AMF Reece S-4000 concept.



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## Features

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

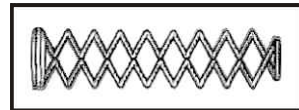
**High Sewing Speed** combined with low noise level is adjustable from 1,500 spm to 3,800 spm.

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

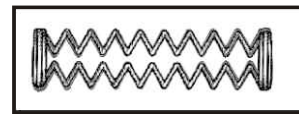
**Pneumatic System** is used for the thread trimming and clamping that reacts to different material thicknesses and types of fabric. Together with the **Single Pedal Electronic Start** it increases production and reduces operator's fatigue.

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

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



ISBH Buttonhole



Normal Buttonhole

## Electronic Feeding

Utilizing powerful three-phase stepper-motors ensures exact placement of individual stitches and brings more freedom in buttonhole design for user.

Electronic feeding further eliminates several mechanisms including clutches and gears thus reducing necessary maintenance and extending machine life-time.

## Applications

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

The **Silk-thread machine version** is designed primarily for decorative sewing of buttonholes using special threads such as silk.

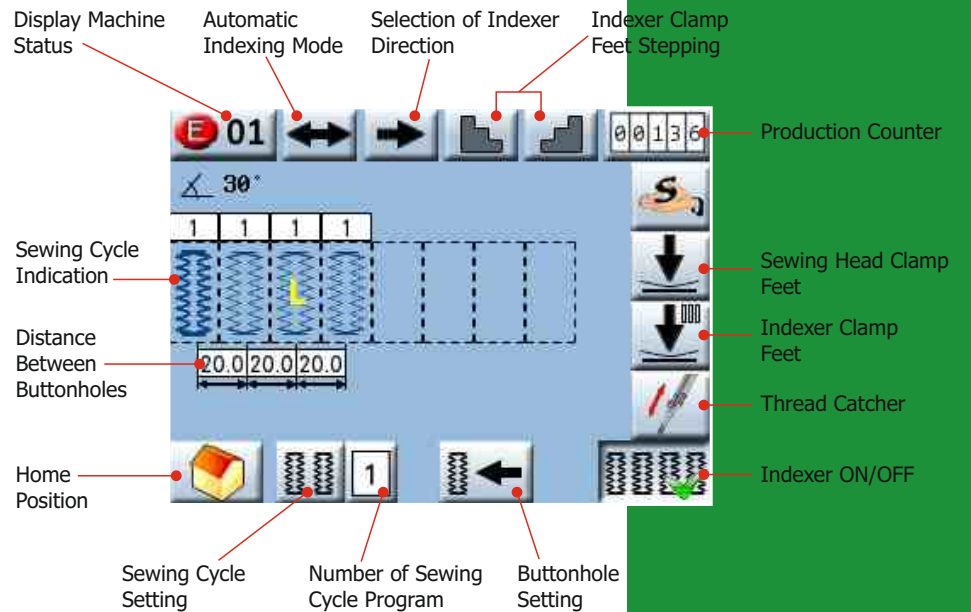
## Option

**Laser Light System** for S-4002 ISBH Indexer model that marks the position of the sleeve at the beginning of sewing cycle.

## S-4002 ISBH with Indexer

S-4002 ISBH with Indexer is programmable to sew imitation buttonholes at specific distances between each buttonhole. The number of buttonholes and the distance required between them are selected by the operator on the control panel.

Touch Screen Control Panel

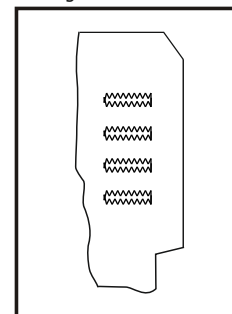


When using the S-4002 ISBH with Indexer, the operator simply places the sleeve cuff into the correct sewing position for the first buttonhole and during the sewing cycle prepares the next piece for sewing.

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

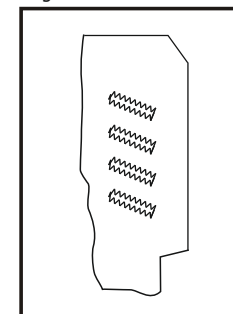
The machine clamps can be set to sew imitation buttonholes at an angle of 0 to 30 degrees from a sleeve cuff. This feature is usually required when sewing buttonholes on ladies' jackets while on menswear the buttonholes are normally sewn parallel to the cuff.

No Angle



Buttonholes placed parallel to sleeve cuff

Angle



Buttonholes sewn at an angle to sleeve cuff

For further explanation see the technical specifications.



Imitation Buttonholes on Fine Suits



Laser Light System