

S-311 Advanced Fully Programmable Eyelet Buttonhole Machine

The S-311 electronically controlled and fully programmable eyelet buttonhole machine uses the latest technology to provide the user with total flexibility and versatility with a wide variety of models. Machine is equipped with new, faster control system, including 20% reduced cycle time, and new touch screen display that is 25% larger than on the previous models.

New optional accessories, especially designed for jacket applications, provide higher cutting flexibility including the desired cutting position. These facilitate the production of buttonholes in one operation without any follow-up work which ensures maximum efficiency and productivity.

Features

Sewing Speed is adjustable from 1,000 spm to 2,000 spm on the touch screen display. Different sewing speed can be programmed at the start and stop position as well as around the eye to ensure excellent sewing quality even on difficult materials.

X-Y Electronic Control Motors reduce the number of mechanical parts, increase the machine flexibility and give a lower noise level which improves the operating environment. With fewer parts, the machine is quieter, more reliable and requires less service.

Submerged Sewing Head reduces the noise level significantly and allows the operator to handle the garment more ergonomically, which means less operator fatigue.

Cycle Sewing allows up to 21 different buttonhole combinations to be sewn in 47 different programs. The operator can set the machine to sew any of required buttonhole styles, i.e. to cover all buttonhole applications on a suit jacket. All settings can be done easily by the operator on the touch screen display.

Pneumatic System Controls are used for the clamping, spreading, cutting of the material as well as for the thread tension and the thread nipper. On the thread trimmer models, the shears are also activated by pneumatics.

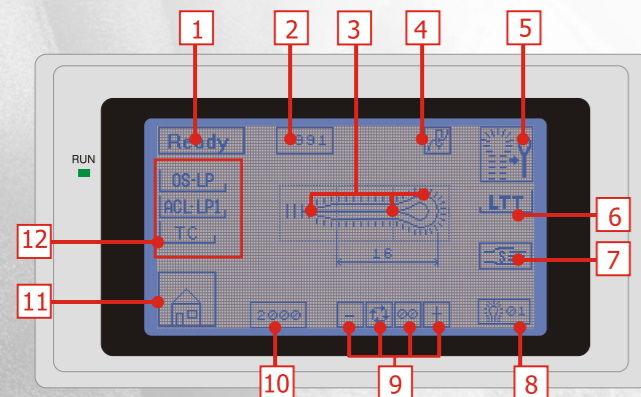
Electronically Adjustable Stitch Bite provides further programming of the two basic sewing widths. The operator can set the stitch bite for buttonhole and crossbar finish separately.

LED Sewing Lights as a part of the sewing head to illuminate the sewing area better.

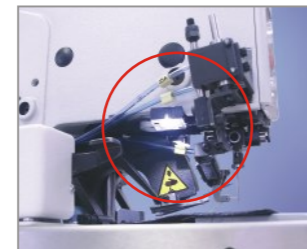
Waste Material Removal & Suction System help to keep the working environment cleaner by removal of the cut-off threads and cut-off eye material from the sewing area into a waste bag. This pneumatically controlled system prolongs the knife lifetime and provides our customers with better buttonhole cutting.

Improved Lubrication System ensures quicker oil distribution to the critical parts of the machine immediately after turning the machine on.

Touch Screen interface is fixed onto the machine table and can be adjusted for operator comfort. The use of easily understood symbols and graphics also reduces the operator training time normally required to set buttonhole types and programs.



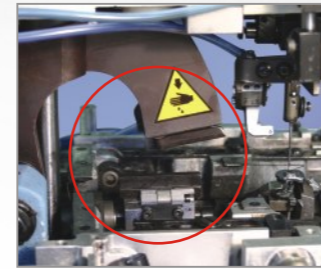
1. Display Machine Status
2. Production Counter
3. Buttonhole Adjustments
4. Button for easy Threading
5. Cutting Selection
6. Machine Model Modification
7. Service Mode
8. Memory
9. Cycle Mode
10. Sewing Speed
11. Home Position
12. Thread Catcher, Lapel System, Lapel Optical Sensor Indicators



LED Sewings Lights



Dust Bag



ACL System

Automatic Cutting Length (ACL) System allows the operator to sew different sizes of buttonholes without the need to change the knife or cutting block. This system can be combined with the S-311 AF and LTT models. The range of buttonhole length is between 13 to 38 mm depending on the model combination.

Ultra Flexibility on Men's Suit Applications

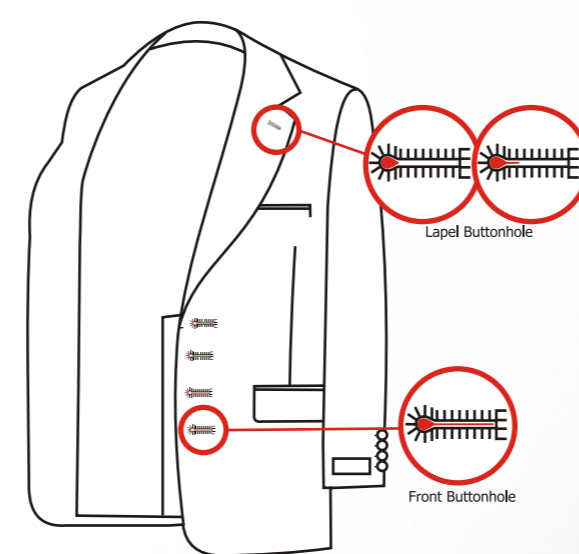
Thanks to our new Ultraflex model, the buttonhole applications on the men's suits are now very easy.

Lapel System is a special optional accessory for jacket applications where lapel buttonholes are cut fully or partially fully selectable by the user. The operator can easily program the cutting length and the cutting position of the lapel buttonhole from the touch screen display. This system can be combined only with machines that are equipped with the Automatic Cutting Length (ACL) System.

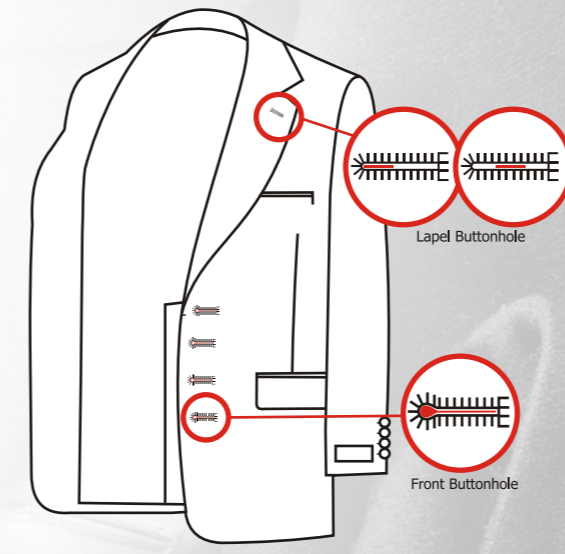
S-311 ACL Lapel Kits	ACL - LP1	ACL - LP2	ACL - LPE
Cutting Length (Eye Buttonhole)	13-26 mm	13-30 mm	6-30 mm
Cutting Length (Straight Buttonhole)	5- 21 mm	12-25 mm	N/A
Sewing Length	13-26 mm	13-30 mm	13-30 mm
Cutting Block	26 mm	30 mm	30 mm *
Cutting Knife	3,2 x 5,0 mm 26 mm	3,2 x 5,0 mm 30 mm	3,2 x 5,0 mm 38 mm

* ACL-LPE uses the standard S-311 ACL cutting block, that is turned 180°.

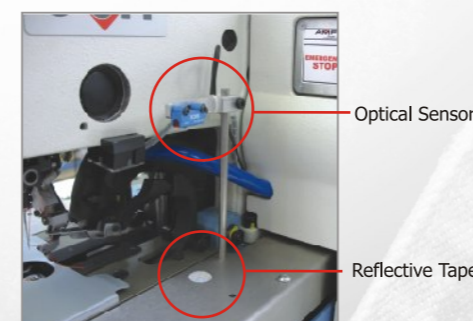
ACL - LPE



ACL - LP1 and ACL - LP2



Lapel Optical Sensor System is an optional accessory specially designed for jacket applications. Thanks to a specially designed sensor system the machine is able to recognize and activate the correct buttonhole program automatically. The system is used when sewing buttonholes on front and lapel sections of the jacket and substitutes the standard cycle mode. The lapel optical sensor system can be ordered with machines equipped with the lapel system.



Lapel Optical Sensor System



Reflective tape is uncovered - the lapel buttonhole is sewn



Reflective tape is covered - the front buttonholes are sewn

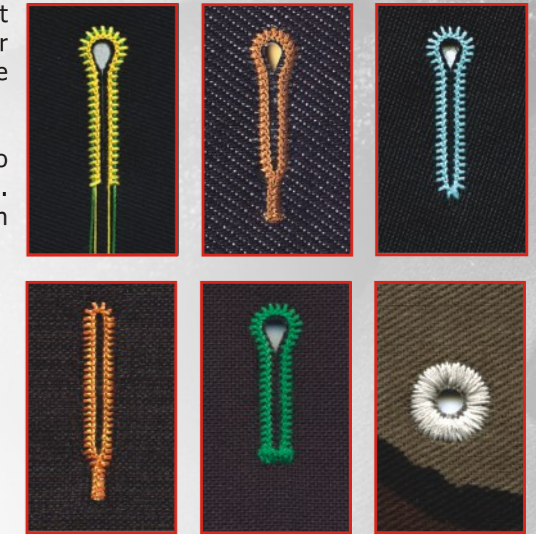
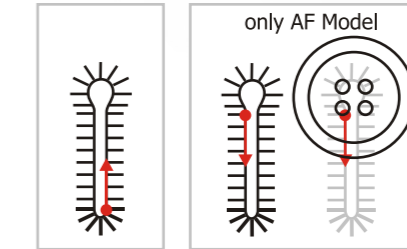
ACL System

Applications & Sewing Patterns

The S-311 machine can be used for a wide range of applications which are suited to all needs of the clothing manufacturer, both large and small. This machine can handle all types of garments ranging from light to heavy weigh materials including denim and leather. The application of the machine can be found on menswear, ladies' wear, jeans clothing, trousers and other outerwear.

The S-311 machine can sew variety of buttonhole shapes with or without gimp including the round eyelet. Depending on the manufacturer requirements, up to 99 different stitching shape patterns can be set in the memory of the machine.

When sewing the round end finish buttonhole, the operator can set two different start positions, which is either in the first row or below the eye. When the below eye start is selected, the finished buttonhole looks much cleaner since the trimmed thread ends are covered by the button.



Different Buttonhole Applications

Available Models

AF (Adjustable Flybar) Model recommended for all buttonholes applications that require only top thread trimming. The size range of buttonholes is adjustable from 10 to 50 mm, in increments of 1 mm.

CT (Cord Trim) Model for use on jeans, trousers or other applications where all threads need to be trimmed from the very end of the buttonhole. The range of buttonhole sizes from 16 to 32 mm can be sewn by use of four different clamp set.

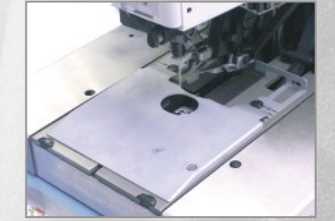
LTT (Long Tail Trimmer) Model used mostly on tailored clothing, when the end of the buttonhole is left open and the long tails of the threads are pulled through the buttonhole to be tacked in a separate operation. Buttonhole length can be set from 10 to 36 mm. All threads are trimmed with a 20-30 mm tail depending on the buttonhole size.



AF Clamp Set



CT Clamp Set



LTT Clamp Set

Optional Accessories

Thread Nipper Mechanism holds the top thread at the start of the sewing cycle to ensure that the first stitch is formed properly especially on difficult fabrics. The thread nipper is standard on LTT version and optional on AF and CT models.

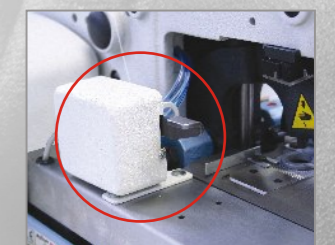
Hand Start Control is recommended for standing operators and is offered as an optional accessory. This mechanism is placed on the machine bed plate to start the machine operating.

Conversion Kits, that can be ordered optionally from AMF Reece, provide the manufacturer with maximum flexibility and versatility as far as the machine utilization. Please contact us for conversion charts.

Optional cutting knives, cutting steels, clamp feet, throat plates, work mats are available and can be ordered from our spare parts department if required. For further information please visit to our web site www.amfreece.com.



Thread Nipper



Hand Start Control

S-311 with Indexer

The S-311 Indexer machine is specially designed for sewing multiple buttonholes on jacket sleeves and jeans fly fronts at required distances between each buttonhole.

The indexer unit ensures that buttonholes are sewn automatically one after another at required lengths and distance that are set by the operator on the touch screen display.

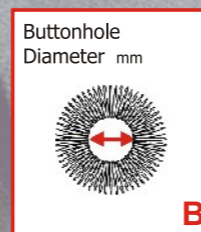
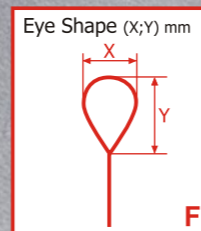
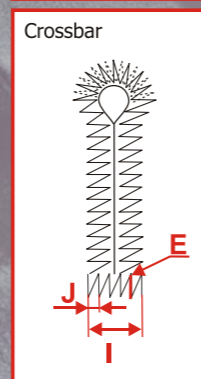
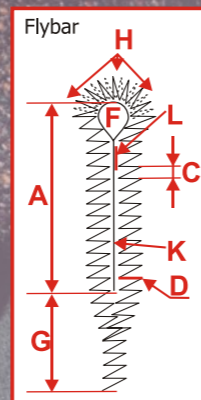
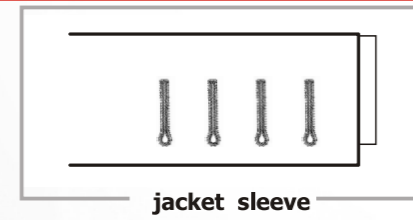
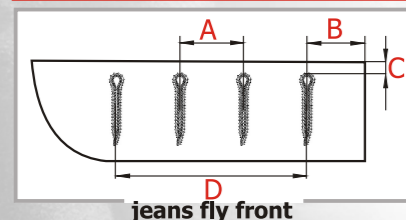


Available Models


AF (Adjustable Flybar) Model recommended for sewing of regular eyelet buttonholes with single thread ranging from 10 to 50 mm in length on jacket sleeves. Model is supplied with thread nipper that holds the top thread at the start of sewing to ensure that the first stitch is formed properly especially on difficult fabrics.

CT (Cord Trim) Model for use on **jacket sleeves** & **CT (Cord Trim) Model** for use on **jeans fly fronts**
Both models are used for applications with double thread with or without gimp where all threads are trimmed from the very end of the buttonhole. A buttonhole size range of 16-32 mm can be sewn by use of different clamp sets. The CT model for jacket sleeves applications is also equipped with the top thread nipper that helps to form the first stitch properly under difficult sewing conditions especially associated with crossbar buttonhole.

Machine Model	AF	CT	CT
Applications	jacket sleeve	jacket sleeve	jeans fly front
Stitch Type	single chainstitch	double chainstitch with or without gimp	
Thread Nipper	Yes	Yes	No
Number of Buttonholes		1-6 buttonholes	
Distance between Buttonholes	A	8 - 160 mm	
Distance from Fabric Edge (horizontal)	B	31 mm	
Distance from Fabric Edge (vertical)	C	9 - 19 mm	
Max. Horizontal Feed Amount	D	160 mm	

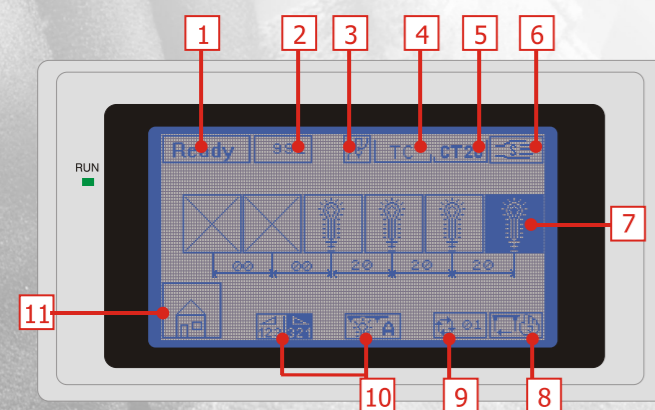


Technical Specifications S-311

Stitch Type	Single needle double chainstitch with or without gimp (401)	
Sewing Speed	1,000 to 2,000 spm adjustable	
Buttonhole Length	Adjustable in increments of 1 mm	A
AF Model	10 to 50 mm ($\frac{3}{8}$ " to $1\frac{1}{2}$ " ^{**}); 2 to 7 mm ($\frac{1}{16}$ " to $\frac{7}{32}$ " ^{**})	
LTT Model	10 to 36 mm ($\frac{3}{8}$ " to $1\frac{1}{2}$ " ^{**})	
CT Model	16 to 32 mm ($\frac{5}{8}$ " to $1\frac{1}{4}$ " ^{**}) with change of clamp kits: 16-20 mm; 20-24 mm; 24-28 mm; 28-32 mm	
RDE Model	2 to 7 mm ($\frac{1}{16}$ " to $\frac{7}{32}$ " ^{**}) - diameter	B
Buttonhole Types		
Automatic Cutting Length	Sliding block range: 13 - 38 mm Optional: Eye or No Eye (only AF, LTT)	
Stitch Density	0,5 - 2,0 mm adjustable in increments of 0,1 mm	C
Stitch Bite in Buttonhole	2,1+/- 0.3 mm (electronic adjustment); 2,7+/- 0.3 mm (electronic adjustment)	D
Stitch Bite in CRB	2,1+/- 0.5 mm (electronic adjustment); 2,7+/- 0.5 mm (electronic adjustment)	E
Eye Shape (X;Y) mm	No Eye / 2,2 x 3,0 / 2,8 x 4,2 / 3,0 x 4,6 / 3,2 x 5,0 / 3,4 x 4,2	F
Fly Bar Length	3,0 - 20,0 mm	G
Number of Eye Stitches	4 to 20	H
Number of Stitches in the round end	4 to 20	
Length of Crossbar	4 - 8 mm	I
Crossbar density	0,5 - 1,5 mm adjustable in increments of 0,1 mm	J
Clamp Foot Height	12 mm	
Sewing Thickness	8 mm	
Buttonhole Cutting	Cut Before, Cut After, No Cut	K
Cutting Space	- 0,5 to 1,2 mm	L
Thread Trimming	AF, RDE top thread only CT all threads LTT all threads	
Recommended Needle	AMF Reece Series 558; size Nm 90, 100, 110	
Recommended Thread	High Quality Core Spun Polyester; size 80, 100, 120; gimp size 30 and higher	
Air Requirement	0,45 MPa (4,5 bar) (65 psi)	
Electrical Supply	230V, 50/60 Hz 1 phase (according to EN 60947-2)	
Dimensions Head and Table Weight	1100 mm (w) x 700 mm (D) x 1140 mm (H); 43" (w) x 27 1/2" (D) x 45" (H) 175 kg (386 lbs.)	
Dimensions Packed Weight	1150 mm (w) x 790 mm (D) x 1300 mm (H); 45" (w) x 31" (D) x 51" (H) 240 kg (529 lbs.)	

Accuracy of illustration and description of equipment shown herein apply to products as manufactured at time of publication.
* Need to purchase a conversion kit to sew round eyelet buttonhole.
** Not possible with S-311 Indexer modification

Touch Screen Display



1. Display Machine Status
2. Production Counter
3. Button for easy Threading
4. Thread Catcher Indicator
5. Machine Model Modification
6. Service Mode
7. Buttonhole Adjustments
8. Button for Switching between Buttonholes
9. Cycle Mode Memory
10. Indexer Mode Selection (automatic, left, right)
11. Home Position



Website: www.amfreece.com

Distributor



World Headquarters

Phone: +420 582 309 275
Fax: +420 582 360 606
E-mail: marketing@amfreece.com

Europe, Africa & Americas

Phone: +420 582 309 275
Fax: +420 582 360 608
E-mail: amfreece@amfreece.cz

Southwest Asia & Middle East

Phone: +90 212 465 0707
Fax: +90 212 465 0711
E-mail: amfreeceturkey@superonline.com

Southeast Asia & Oceania

Phone: +852 2787 2273
Fax: +852 2787 5642
E-mail: amfreece@netvigator.com

Prostejov, Czech Republic

Phone: +420 582 309 275
Fax: +420 582 360 606
E-mail: marketing@amfreece.com

Prostejov, Czech Republic

Phone: +420 582 309 275
Fax: +420 582 360 608
E-mail: amfreece@amfreece.cz

Istanbul, Turkey

Phone: +90 212 465 0707
Fax: +90 212 465 0711
E-mail: amfreeceturkey@superonline.com

Kowloon, Hong Kong

Phone: +852 2787 2273
Fax: +852 2787 5642
E-mail: amfreece@netvigator.com

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World Sales Offices

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AMF Reece Electronic Programmable Eyelet Buttonhole Machine



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