

# B-1M Series

1-needle, Lockstitch Buttonholing Machine

## Features

- The direct drive system has been adopted.
- The control box is integrated with the machine head.



B-1M783

# B-1M Series

## SPECIFICATIONS

Model name	B-1M781S	B-1M783S
Application	Standard	
Max. sewing speed	3,600sti/min*	
Needle bar stroke	34.6mm	
Lift of the work clamp	12mm	
Thickness of material that can be used	4mm (with the work clamp lowered)	
Number of stitches	83~225 (by gear-change method)	
Length of buttonholes	22mm	40mm
Needle	DP×5 #11~#14	
Hook	DP type, automatic-lubricating full-rotary hook	
Lubrication	Automatic	
Lubrication oil	Sewing machin oil #10 (ISO VG10)	
Power supply	Single-phase 220V	
Weight	Machine head (include motor) 50kg	

\*sti/min is the abbreviation for "stitches per minute"

## WHEN YOU PLACE ORDERS

Please note when placing orders, that the model name should be written as follows:

### Machine head

Drive type	Code	Application	Code	Voltage	Code
Mechanical drive	M	Standard	S	Single-phase 220V	A

B 1 M 7 8    -

Buttonhole size	Code	Destination	Code
Standard (Max.22mm)	1	General export	A
Long hole type (Max.40mm)	3	India	F
		Turkey (for RoHS)	H

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\* Specifications and appearance are subject to change without prior notice for improvement.  
 \* Read the instruction manual before putting the machine into service to ensure safety.  
 \* This catalogue prints with environment-friendly soyink on recycle paper.  
 \* Paper from responsible sources FSC™ C001712

# B-1M Series

The B-1M Series buttonhole machines produce consistent quality seams and are widely adaptable to many different kinds of materials and seam specifications.



## The control box is integrated into the head

The control box is integrated with the head of the sewing machine, making it easy to set up and use.

The B-1M Series adopt the direct drive system. As a result, Quietness of the sewing machine during sewing is ensured by the direct-drive motor. The sewing machine starts up swiftly and promises increased stop accuracy, thereby demonstrating improved responsiveness.



## Comfortable working environment

The knife mechanism and stop-motion mechanism produce less noise when they actuate, thus contributing to a more comfortable working environment. Thanks to the simple design of the stop-motion mechanism and unique knife mechanism, the machine operates with low noise. The machine starts, decelerates and stops smoothly.

## Lift of the work clamp



The work clamp foot height can be increased up to 12 mm, enabling the machine to make high-quality buttonholes in heavy-weight materials. The lifting of the work clamp is driven by a motor, which reduces operator work. The operation can be easily done with one pedal.

## LED light

The LED light is located on the underside of the arm jaw. It is provided as standard for all models of the B-1M Series. It reduces operator fatigue and improves work efficiency. In addition, this needle drop point can be easily visually observed. This permits easy positioning of buttonholes.



## Sewing settings can be easily changed

This machine is capable of forming two different types of stitches, namely whip stitch and purl stitch.

### Purl stitch

When applying higher tension to the needle thread to permit it to pass straight through fabric, the purl stitch is formed by the bobbin thread which is pulled over from both sides to the center line.



### Whip stitch

The whip stitch is formed in zigzag showing the needle thread only top of fabric, and the bobbin thread on the bottom.



## Standard operation panel

The sewing machine has been integrated with the operation panel and the control box for ease of use. The operation panel has a simple design that allows the user to adjust the origin position of the feed cam and change the sewing speed.



## Changing the number of stitches

The gears are included in the standard accessories

### • Spur gears

By selecting the spur gears, you can control the number of stitches as shown in the table. Use a combination of gears which have the same alphabetical marks.

The numeral engraved on the gear installed in the rear position will represent the number of stitches provided by the then combination of spur gears.



### • List of the subclass machines according to their applications

Subclass models	Application	Stitch formation		Buttonholing size (mm)			
		A	B	A	B	C	
Standard type	Men's shirts, blouses, working wear, ladies' wear			A	6.4~19.0	A	6.4~31.7
				B	2.5~4.0	B	2.5~5.0
				C	Max. 22	C	Max. 40
				B-1M781		B-1M783	