brief instruction BASS 3050

A-S-S Automated-Sewing-Systems
Made in Germany

MADE IN GERMANY

picture 1

```
BASS 3050 REV.026 01/2010       CRC=4679
M/C: 3050XXX

    *******************************
    * - W A R T E   A U F   R E S E T - *
    *******************************

        ****************
        * BASS 3050/1 *
        ****************

info@assa9.de              www.assa9.de
```
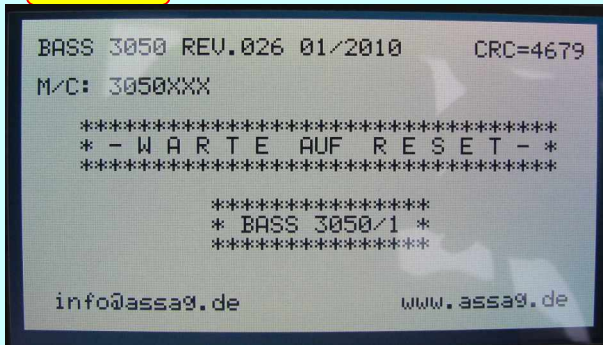
After you switch on the main switch picture 1 appears.

If you press the stop button the sewing machine will be initiated and ready for operation and then picture 2 appears.

STOP

picture 2

corner knife.correction seam beginn

seam length

docking point

corner knife correction seam end

```
M 04  30 31 32 33 34
   PANTS BACK LOOP
```
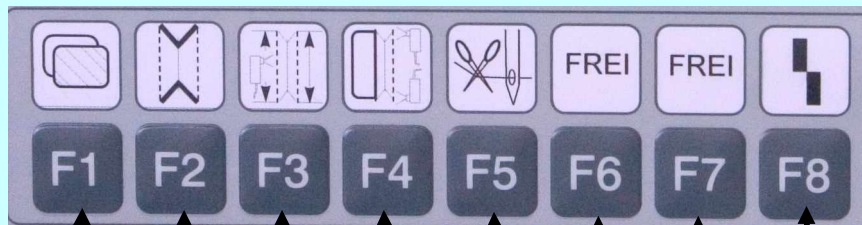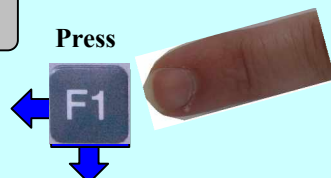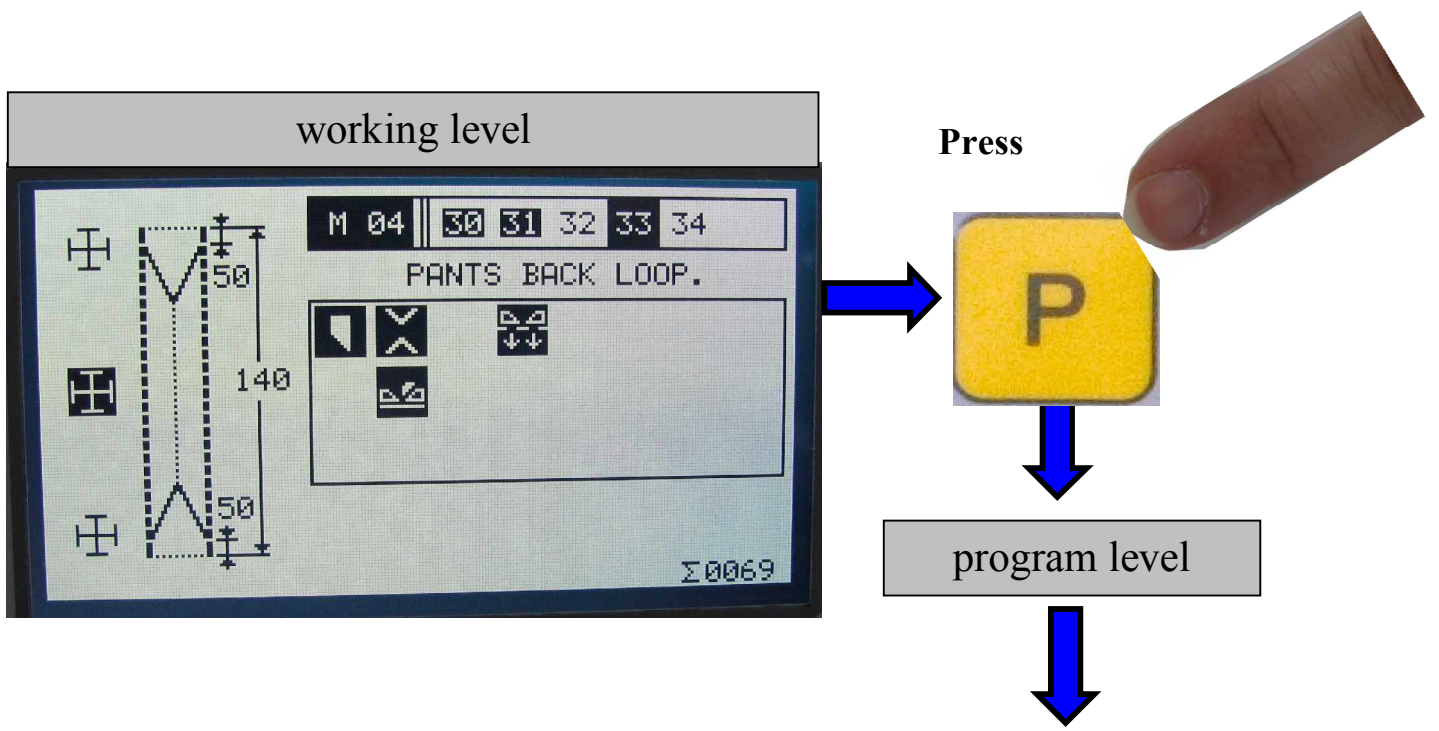50
140
50

sewing programm

active seam

seam - name

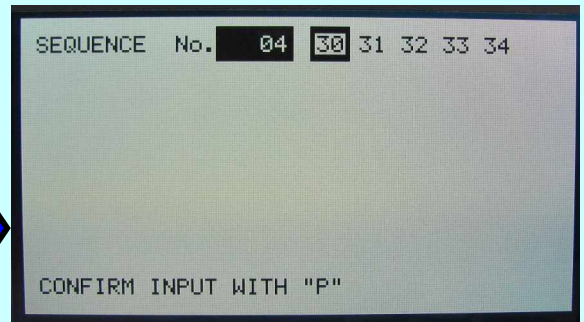active seam function

piece counter / per day
Σ0069

F1 | F2 | F3 | F4 | F5 | F6 FREI | F7 FREI | F8

- One step back
- Pick up function test
- without function
- upper thread-catcher / cutter
- photocell correction
- enter the seam length
- corner knife correction
- one level down

Press

F1

thread bobbin „full charge"

sewing motor ON / winding

piece counter per day into „ 0 "

docking mark ON / OFF

stacker/ Pick up ON / OFF

corner knife ON / OFF

center knife ON / OFF

one level back

Attention:
If the seam function in the program level is deactivated, they can't be activated in quick access.

working level

M 04 30 31 32 33 34
PANTS BACK LOOP.

50
140
50
Σ0069

Press

P

program level

level (1)	sewing sequence

```
(1) F1:  SEWING SEQUENCE
(1) F2:  SEWING FUNCTIONS
(1) F3:  SEWING PARAMETER
(1) F4:  BASIC PARAMETER
(1) F5:  INITIAL PARAMETER
(1) F6:  OTHERS
```

Press

F1

```
SEQUENCE  No.  04  30  31  32  33  34




CONFIRM INPUT WITH "P"
```

F1 sewing sequence: There you can put different seams together into one sewing program.
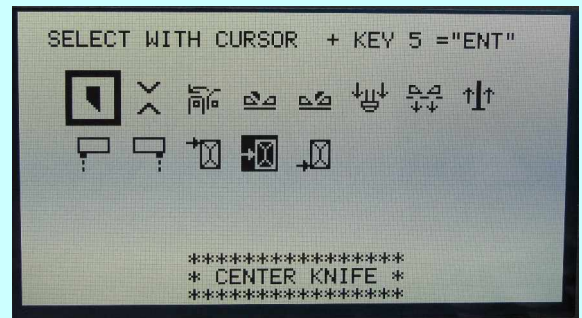
level (1)	sewing functions

```
(1) F1:  SEWING SEQUENCE
(1) F2:  SEWING FUNCTIONS
(1) F3:  SEWING PARAMETER
(1) F4:  BASIC PARAMETER
(1) F5:  INITIAL PARAMETER
(1) F6:  OTHERS
```

Press

F2

```
SELECT WITH CURSOR  + KEY 5 ="ENT"



          ******************
          * CENTER KNIFE *
          ******************
```
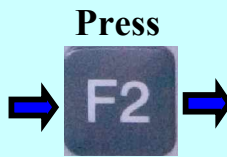
F2 sewing functions: There you can switch the different additional options from the current chosen seam on or off. The symbols which are deposed in black are in the current sewing in function.

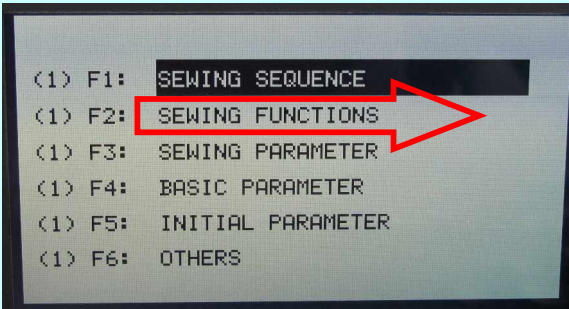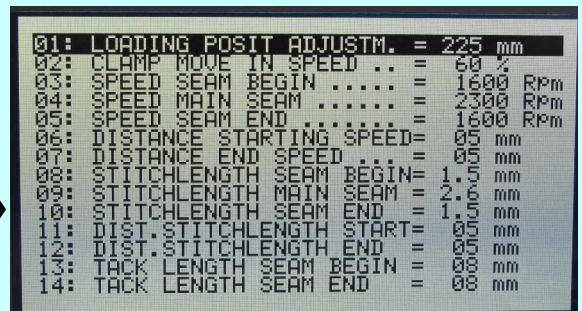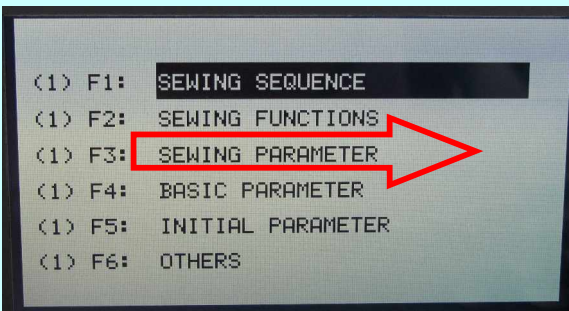| level (1)	sewing parameter

```
(1) F1:  SEWING SEQUENCE
(1) F2:  SEWING FUNCTIONS
(1) F3:  SEWING PARAMETER
(1) F4:  BASIC PARAMETER
(1) F5:  INITIAL PARAMETER
(1) F6:  OTHERS
```

Press

F3

```
01: LOADING POSIT ADJUSTM. = 225 mm
02: CLAMP MOVE IN SPEED .. =  60 %
03: SPEED SEAM BEGIN ..... = 1600 RPm
04: SPEED MAIN SEAM ...... = 2300 RPm
05: SPEED SEAM END ....... = 1600 RPm
06: DISTANCE STARTING SPEED=  05 mm
07: DISTANCE END SPEED ... =  05 mm
08: STITCHLENGTH SEAM BEGIN= 1.5 mm
09: STITCHLENGTH MAIN SEAM = 2.6 mm
10: STITCHLENGTH SEAM END  = 1.5 mm
11: DIST.STITCHLENGTH START=  05 mm
12: DIST.STITCHLENGTH END  =  05 mm
13: TACK LENGTH SEAM BEGIN =  08 mm
14: TACK LENGTH SEAM END   =  08 mm
```
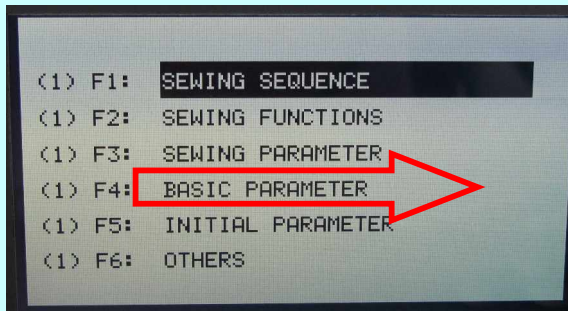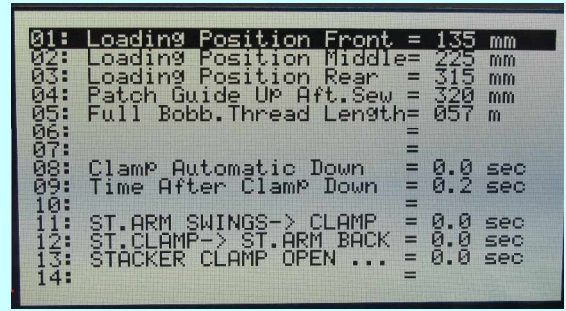
F3 sewing parameter: Sewing parameter give values which are effective in the current activated seam. If changes will be made, they have no effect on the other seams.
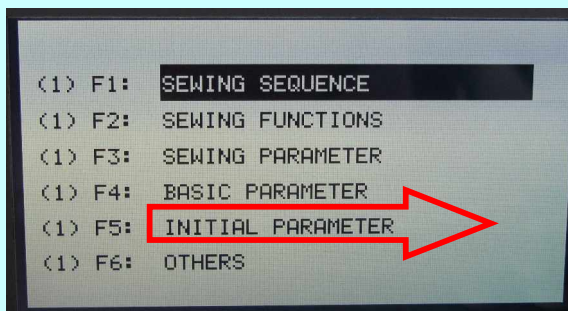
level (1)	basic parameter

```
(1) F1:  SEWING SEQUENCE          01: Loading Position Front = 135 mm
(1) F2:  SEWING FUNCTIONS         02: Loading Position Middle= 225 mm
(1) F3:  SEWING PARAMETER         03: Loading Position Rear  = 315 mm
(1) F4:  BASIC PARAMETER          04: Patch Guide Up Aft.Sew = 320 mm
(1) F5:  INITIAL PARAMETER        05: Full Bobb.Thread Length= 057 m
(1) F6:  OTHERS                   06:                        =
                                  07:                        =
                                  08: Clamp Automatic Down   = 0.0 sec
                                  09: Time After Clamp Down   = 0.2 sec
                                  10:                        =
                                  11: ST.ARM SWINGS-> CLAMP   = 0.0 sec
                                  12: ST.CLAMP-> ST.ARM BACK = 0.0 sec
                                  13: STACKER CLAMP OPEN ... = 0.0 sec
                                  14:                        =
```

Press **F4**

F4 basic parameter: Basic parameter give values which are effective in all seams. If changes will be made, they have effect on all the other seams.
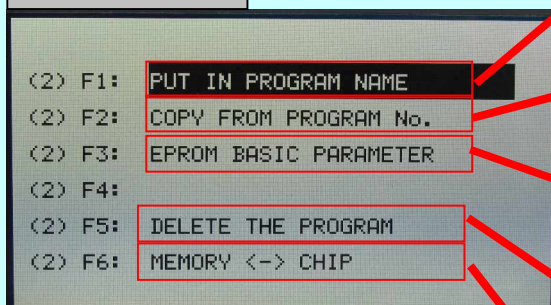
level (1)	init parameter

```
(1) F1:  SEWING SEQUENCE          (2) F1:  PUT IN PROGRAM NAME
(1) F2:  SEWING FUNCTIONS         (2) F2:  COPY FROM PROGRAM No.
(1) F3:  SEWING PARAMETER         (2) F3:  EPROM BASIC PARAMETER
(1) F4:  BASIC PARAMETER          (2) F4:
(1) F5:  INITIAL PARAMETER        (2) F5:  DELETE THE PROGRAM
(1) F6:  OTHERS                   (2) F6:  MEMORY <-> CHIP
```

Press **F5**

F5 init parameter: In the level init parameter different functions can be executed.

level (2)

```
(2) F1:  PUT IN PROGRAM NAME
(2) F2:  COPY FROM PROGRAM No.
(2) F3:  EPROM BASIC PARAMETER
(2) F4:
(2) F5:  DELETE THE PROGRAM
(2) F6:  MEMORY <-> CHIP
```

F1-put in program name,
There you can put in a name for the current chosen seam.

F2- copy from program no.,
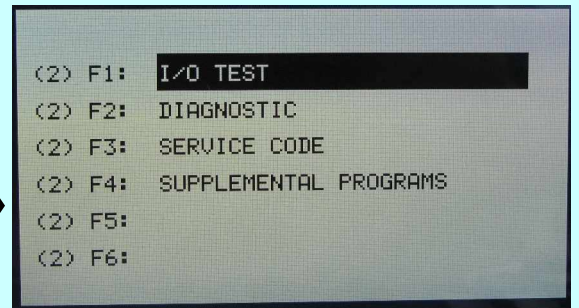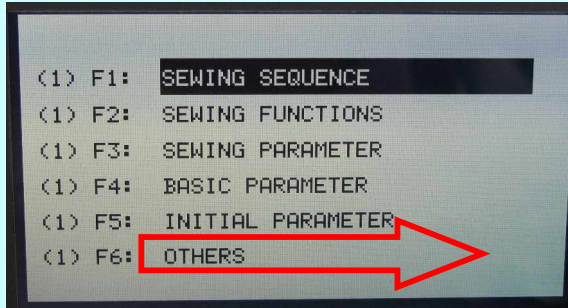There you can copy a copy of another program on the current chosen seam.

F3- e-prom basic parameter,
There you can use sample program from the sewing memory.

F5- delete the program,
They you can delete the current seam.

F6- memory - chip ,
There you can read in and read out sewing programs and format program dongle (external memory chip).
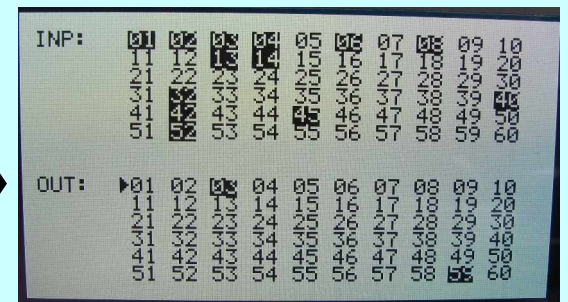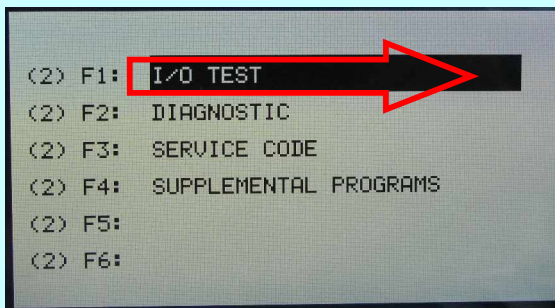
level (1)	other

```
(1) F1:  SEWING SEQUENCE
(1) F2:  SEWING FUNCTIONS
(1) F3:  SEWING PARAMETER
(1) F4:  BASIC PARAMETER
(1) F5:  INITIAL PARAMETER
(1) F6:  OTHERS
```

Press F6

```
(2) F1:  I/O TEST
(2) F2:  DIAGNOSTIC
(2) F3:  SERVICE CODE
(2) F4:  SUPPLEMENTAL PROGRAMS
(2) F5:
(2) F6:
```

F6 other: On button F6 there are more functions and tests deposed, which supports to localize the malfunctions.

level (2)	I / O test

```
(2) F1:  I/O TEST
(2) F2:  DIAGNOSTIC
(2) F3:  SERVICE CODE
(2) F4:  SUPPLEMENTAL PROGRAMS
(2) F5:
(2) F6:
```

Press F1

```
INP:  01 02 03 04 05 06 07 08 09 10
      11 12 13 14 15 16 17 18 19 20
      21 22 23 24 25 26 27 28 29 30
      31 32 33 34 35 36 37 38 39 40
      41 42 43 44 45 46 47 48 49 50
      51 52 53 54 55 56 57 58 59 60

OUT: ▶01 02 03 04 05 06 07 08 09 10
      11 12 13 14 15 16 17 18 19 20
      21 22 23 24 25 26 27 28 29 30
      31 32 33 34 35 36 37 38 39 40
      41 42 43 44 45 46 47 48 49 50
      51 52 53 54 55 56 57 58 59 60
```
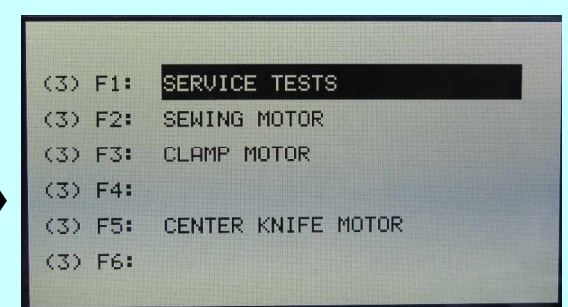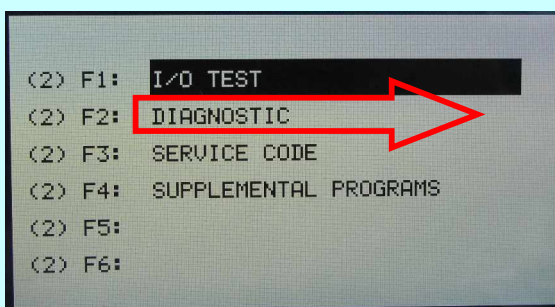
F1 I/O test: With the I/O test, you can check the inputs (switch and photocell) and also the outputs (valve).

level (2)	diagnostic

```
(2) F1:  I/O TEST
(2) F2:  DIAGNOSTIC
(2) F3:  SERVICE CODE
(2) F4:  SUPPLEMENTAL PROGRAMS
(2) F5:
(2) F6:
```

Press F2

```
(3) F1:  SERVICE TESTS
(3) F2:  SEWING MOTOR
(3) F3:  CLAMP MOTOR
(3) F4:
(3) F5:  CENTER KNIFE MOTOR
(3) F6:
```
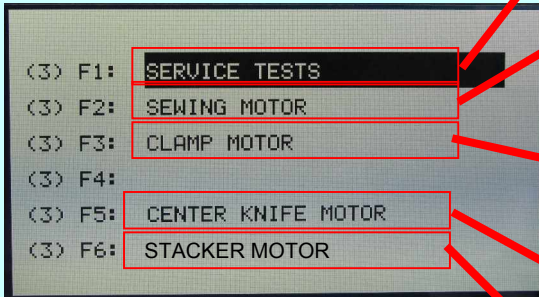
F2 diagnostic: Behind the level there are diagnostic programs which serve for localization of malfunctions.

level (3)

(3) F1: SERVICE TESTS
(3) F2: SEWING MOTOR
(3) F3: CLAMP MOTOR
(3) F4:
(3) F5: CENTER KNIFE MOTOR
(3) F6: STACKER MOTOR

F1-sevice test ,
These tests can only be made by producer with special auxiliary equipment.

F2- sewing motor. ,
There can be made a function test of sewing motor, thread cutter and internal transmitter of sewing motor.
Furthermore you can read in the parameter for sewing motor.

F3- clamp motor ,
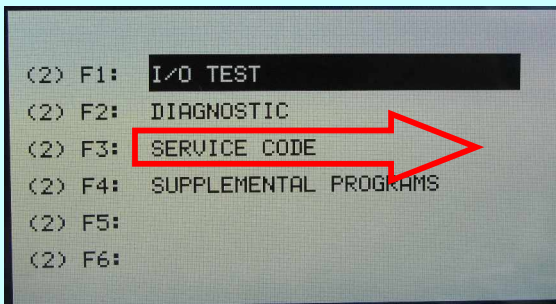There can be made a function test for clamp motor.

F4- centre knife motor ,
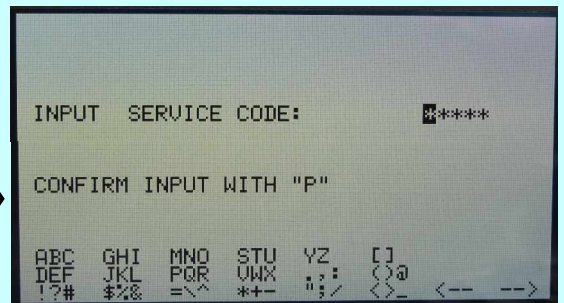There can be made a function test for centre knife motor.

F5- stacker motor ,
There can be made a function test for stacker motor.

level (2)   service code

(2) F1: I/O TEST
(2) F2: DIAGNOSTIC
(2) F3: SERVICE CODE
(2) F4: SUPPLEMENTAL PROGRAMS
(2) F5:
(2) F6:

Press

F3

INPUT   SERVICE CODE: █****

CONFIRM INPUT WITH "P"

ABC GHI MNO STU YZ_ []
DEF JKL PQR VWX ,;: {}@
!?# $%& =\^ *+- ";/ <>_   <-- -->

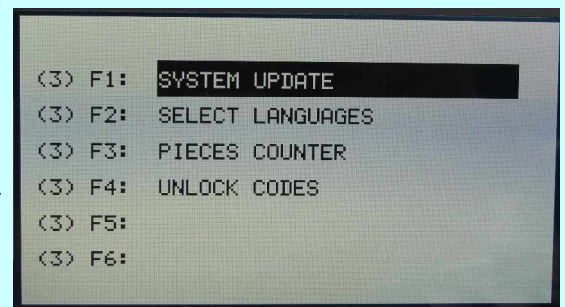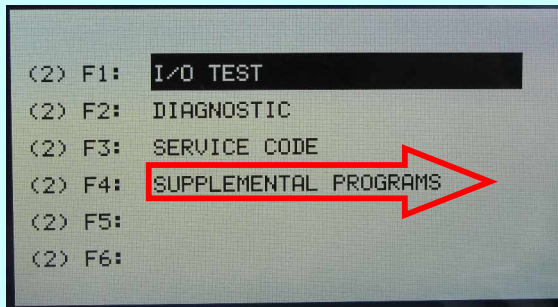**F3   service code**:   With the service code you can unlock or lock different user levels.
- without code you can't change the sewing programs.
- with code „99160" you can change the parameters and activate all test programs.
- with code „_____" you can make software updates and such tests which can be made **only by specialized staff.**
(in case of need please contact A-S-S and ask for this code!)

```
(2) F1:  I/O TEST
(2) F2:  DIAGNOSTIC
(2) F3:  SERVICE CODE
(2) F4:  SUPPLEMENTAL PROGRAMS
(2) F5:
(2) F6:
```

Press

F4

```
(3) F1:  SYSTEM UPDATE
(3) F2:  SELECT LANGUAGES
(3) F3:  PIECES COUNTER
(3) F4:  UNLOCK CODES
(3) F5:
(3) F6:
```

F4   supplemental programs: With supplemental programs you can make updates and quantity limitation, select languages and count pieces.

```
(3) F1:  SYSTEM UPDATE
(3) F2:  SELECT LANGUAGES
(3) F3:  PIECES COUNTER
(3) F4:  UNLOCK CODES
(3) F5:
(3) F6:
```

F1- system update. ,
Here you can read in a „newer" software
if A-S-S confirm that this is possible.
You can also read in a software from another
machine type to use the display on another
machine.
(**ONLY AFTER TALKING TO A-S-S!**)

F2- select languages,
Here you can select the language.
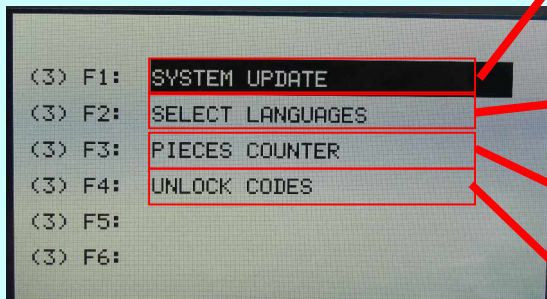You can choose the relevant language by pressing
the button F1- F6.

F3 pieces counter ,
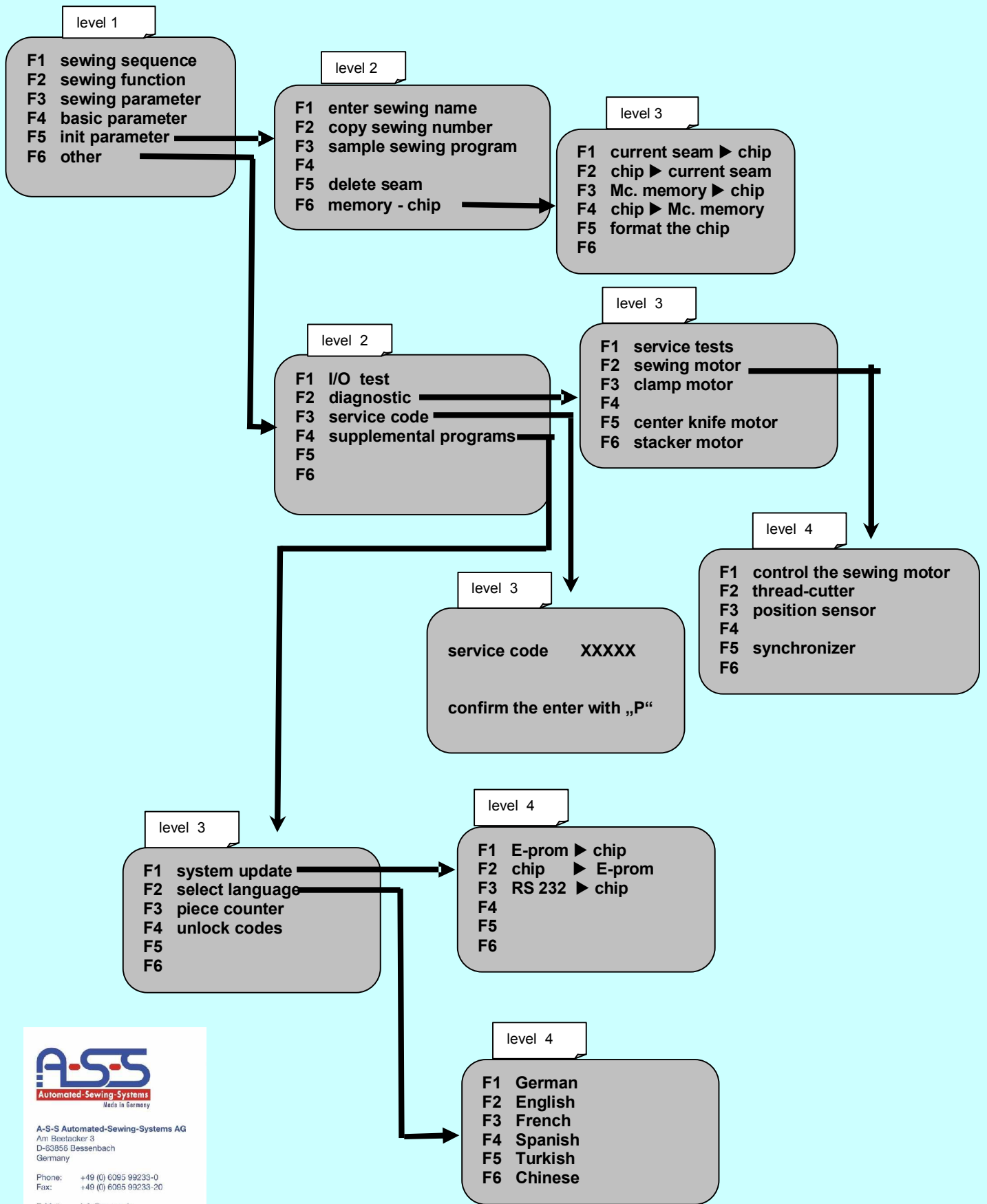Here you can see the number of pieces which you
have already sewed.

F4- unlock codes ,
Here can be made quantity limitation.
THIS CAN ONLY BE MADE BY A-S-S!

level 1

```
F1   sewing sequence
F2   sewing function
F3   sewing parameter
F4   basic parameter
F5   init parameter
F6   other
```

level 2

```
F1   enter sewing name
F2   copy sewing number
F3   sample sewing program
F4
F5   delete seam
F6   memory - chip
```

level 3

```
F1   current seam ▶ chip
F2   chip ▶ current seam
F3   Mc. memory ▶ chip
F4   chip ▶ Mc. memory
F5   format the chip
F6
```

level 2

```
F1   I/O  test
F2   diagnostic
F3   service code
F4   supplemental programs
F5
F6
```

level 3

```
F1   service tests
F2   sewing motor
F3   clamp motor
F4
F5   center knife motor
F6   stacker motor
```

level 4

```
F1   control the sewing motor
F2   thread-cutter
F3   position sensor
F4
F5   synchronizer
F6
```

level 3

```
service code     XXXXX


confirm the enter with „P"
```

level 3

```
F1   system update
F2   select language
F3   piece counter
F4   unlock codes
F5
F6
```

level 4

```
F1   E-prom ▶ chip
F2   chip    ▶ E-prom
F3   RS 232 ▶ chip
F4
F5
F6
```

level 4

```
F1   German
F2   English
F3   French
F4   Spanish
F5   Turkish
F6   Chinese
```

Different operating languages you may choose is departing on present installed Software.

Basic-Parameter list BASS 3050

```
01: Loading Position Front  = 135 mm
02: Loading Position Middle= 225 mm
03: Loading Position Rear   = 315 mm
04: Patch Guide Up Aft.Sew  = 320 mm
05: Full Bobb.Thread Length= 057 m
06:                         =
07:                         =
08: Clamp Automatic Down    = 0.0 sec
09: Time After Clamp Down   = 0.2 sec
10:                         =
11: ST.ARM SWINGS-> CLAMP   = 0.0 sec
12: ST.CLAMP-> ST.ARM BACK  = 0.0 sec
13: STACKER CLAMP OPEN ...  = 0.0 sec
14:
```

```
15:                             =
16: Carriage Return ......  = 0.2 sec
17:                             =
18: Thread Pickup Release   =0.15 sec
19: Thread Clamp Duration   =0.04 sec
20:                             =
21: Needle Thread Trim Pos =0.07 sec
22: Durat.Needle Trim Knife=0.14 sec
23: Carriage Tab Cut Dist. = 154 mm
24: Carriage Speed Tab Cut =  50 %
25: Tab Knife Start ......  = 118 mm
26: Tab Knife Cutting Time = 0.2 sec
27: Clamps up ...........  = 0.4 sec
28: Pick Up Work Piece ... = 0.5 sec
```

```
29:                             =
30:                             =
31: Carriage Speed .......  =  99 %
32: Sequence In Step .....  =  00
33: Bobb.Thrd.Photoc.On/Off=  01
34: Trimming Speed .......  = 300 Rpm
35: Trimming Posit.(00..59)=  00 min
36: Bobbin Trimm. Duration =0.12 sec
37:                             =
38:                             =
39:                             =
40: Second Photocell .....  =  00
```
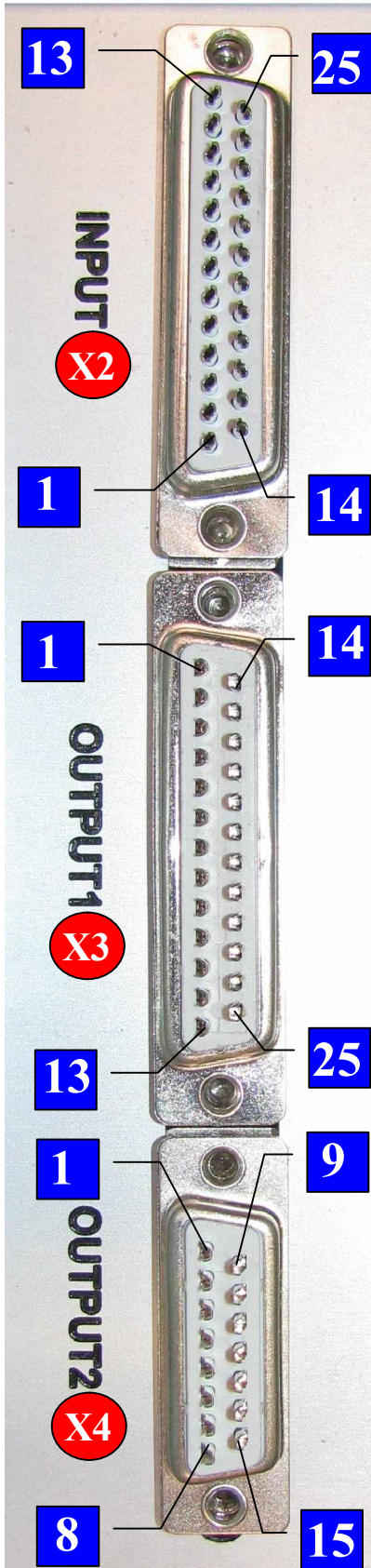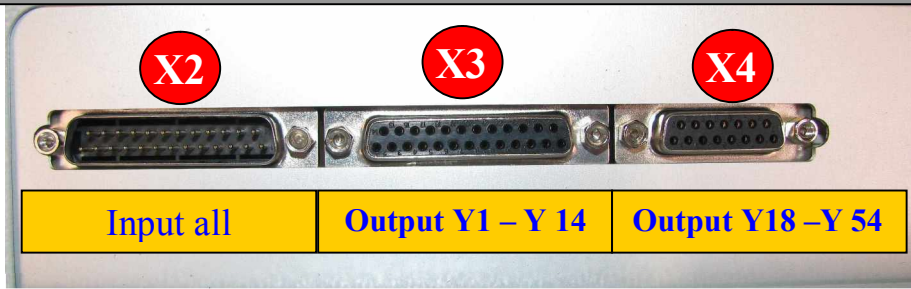
Seam-Parameter list BASS 3050

```
01: LOADING POSIT ADJUSTM. =  225 mm
02: CLAMP MOVE IN SPEED .. =   60 %
03: SPEED SEAM BEGIN ....: = 1600 Rpm
04: SPEED MAIN SEAM ......: = 2300 Rpm
05: SPEED SEAM END ......: = 1600 Rpm
06: DISTANCE STARTING SPEED=   05 mm
07: DISTANCE END SPEED ... =   05 mm
08: STITCHLENGTH SEAM BEGIN=  1.5 mm
09: STITCHLENGTH MAIN SEAM =  2.6 mm
10: STITCHLENGTH SEAM END  =  1.5 mm
11: DIST.STITCHLENGTH START=   05 mm
12: DIST.STITCHLENGTH END  =   05 mm
13: TACK LENGTH SEAM BEGIN =   08 mm
14: TACK LENGTH SEAM END   =   08 mm
```

```
15:                        =
16:                        =
17: CENTER KNIFE ENGAGE .. =   18 mm
18: CENTER KNIFE DISENGAGE =   00 mm
19: THREAD MONITOR ON AFTER=   30 mm
20: THREAD MONITOR FILTER  =   07 mm
21:                        =
22:                        =
23:                        =
24: INTERIM STOP SELECT+POS=   00 cm
25: PICK UP PART SELECT+POS=   00 cm
26: CENTER KNIFE MOT. SPEED=   75 %
27:                        =
28: STACKER POSITION ..... =   00 cm
```

```
29:                        =
30: FLAP CLAMPS MODE ..... =   04
31: FOLDING SLIDE MODE ... =   03
32: VACUUM MODE .........: =   03
33: MAIN CLAMP MODE ......: =   00
34:                        =
35: STACKER MODE ......... =   03
36:                        =
37:                        =
38:                        =
39:                        =
40:                        =
```

Input / Output BASS 3050

	X2	X3	X4
Input all	**Output Y1 – Y 14**	**Output Y18 –Y 54**

X2	Functional role	Signal/ black	+ 24 V / brown 21 - 25	GND blue 14 - 20
S2	clamp 0-position	Pin 02	Pin 21-25	Pin 14-20
S7	folder down	Pin 04	Pin 21-25	Pin 14-20
S15	photocell flap	Pin 11	Pin 21-25	Pin 14-20
S20	foot switch	Pin 06		Pin 14-20

X3	Functional role	Signal/ white	+ 24 V / brown 14 - 25
Y01	thread cutter	Pin 01	Pin 14-25
Y02	thread catcher	Pin 02	Pin 14-25
Y03	thread movable	Pin 03	Pin 14-25
Y04	center knife down	Pin 04	Pin 14-25
Y05	center knife lock to cut	Pin 05	Pin 14-25
Y06	folder down	Pin 06	Pin 14-25
Y07	folder up	Pin 07	Pin 14-25
Y08	dart stretcher	Pin 08	Pin 14-25
Y09	vacuum	Pin 09	Pin 14-25
Y11	stacker (pan bar)	Pin 10	Pin 14-25
Y13	corner knife (seam begin)	Pin 11	Pin 14-25
Y14	corner knife (seam end)	Pin 12	Pin 14-25

X4	Functional role	Signal/ white	+ 24 V / brown 09 - 15
Y18	flap clamp right	Pin 01	Pin 09-15
Y19	flap clamp left	Pin 02	Pin 09-15
Y20	folding slide left+right	Pin 03	Pin 09-15
Y22	mainclamp right	Pin 05	Pin 09-15
Y23	mainclamp left	Pin 06	Pin 09-15
Y24	mainclamp pressure supply	Pin 07	Pin 09-15
Y58	fabric clamp pick up	Pin 08	Pin 09-15