



PEGASUS®

Cat. No. 9538•Vol. 1
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PEGASUS TABLE

ETS SERIES

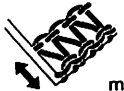
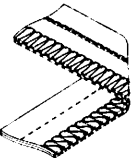
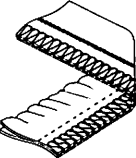
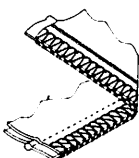
ETS32: VARIABLE TOP FEED SAFETY STITCH MACHINES

ETS52: VARIABLE TOP FEED OVEREDGERS

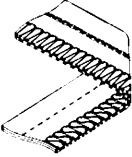
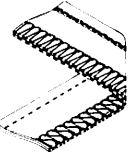
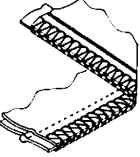
ETS32 ETS52 F : Front top feed type B : Rear top feed type A : General seaming B : Seaming heavy knits. C : Piping D : Gathering E : Blindhemming 2 : Operations heavier than "3" 3 : General operations	F A 2	
	P1	Fitted with a bracket for piping binder, without binder.
	P2	Fitted with both a bracket and a piping binder for 20mm tape width.
	S1	Without attachment for gathering and KL100.
	S2	Fitted with attachment for gathering or adding fullness and KL100.
	KL100	A mechanical knee press controller for intermittent shirring or adding fullness of top ply fabric.
	 Number of needles	 Number of threads
	 High lift: For light to medium fabrics.  Extra-high lift: For medium to heavy fabrics.	
	 Needle gauge	 Seam width
	 Maximum main feed stroke (Nominal maximum stitch length)	
	 Minimum to maximum top feed ratio	 Minimum to maximum diff. feed ratio
	 Presser foot lift	 Top feed lift
	 Type of the diff. feed dog, e.g., 2W=2-row Wide, 3N=3-row Narrow	
	 Type of top feed	 Maximum speed s.p.m.

ETS32 SERIES

■ VARIABLE FRONT TOP FEED SAFETY STITCH MACHINES

						
■ Seaming  	420FA3/516-413	2	5	Extra-high lift	3	3,4,5
	422FA3/516-313			High lift	3	3,4,5
	430FA2/516-433			Extra-high lift	3	3,4,5
	432FA2/516-453				5	5,6
	434FA2/516-333			High lift	3	3,4,5
					5	5,6
■ Gathering  	542FD3/516-453	2	5	Extra-high lift	3	3,4,5
	544FD3/516-353			High lift	3	3,4,5
■ Gathering/piping 	542FD4/P1/516-453	2	5	Extra-high lift	3	3,4,5
	542FD4/P2/516-453			Extra-high lift	3	3,4,5
■ Piping  	432FC2/P1/516-453	2	5	Extra-high lift	3	4,5
					5	5,6
	432FC2/P2/516-453			Extra-high lift	3	4,5
					5	5,6
	433FC2/P1/516-333			High lift	3	4,5
					5	5,6
	433FC2/P2/516-333			High lift	3	4,5
					5	5,6

■ VARIABLE REAR TOP FEED SAFETY STITCH MACHINES

■ Seaming  	430BA2/516-433	2	5	Extra-high lift	3	3,4,5
	432BA2/516-453				5	5,6
■ For jeans  	452BA2/516-433	2	5	Extra-high lift	3	5,6
	452BA4/516-433				5	5,6,7
■ Piping  	432BC2/P1/516-453	2	5	Extra-high lift	3	4,5
					5	5,6
	432BC2/P2/516-453			Extra-high lift	3	4,5
					5	5,6

● Standard machines are those of boldface.

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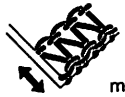
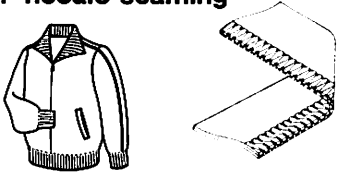
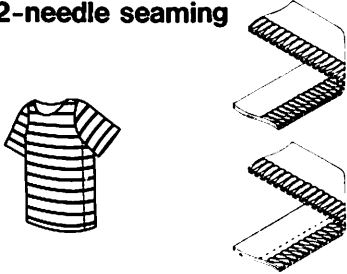
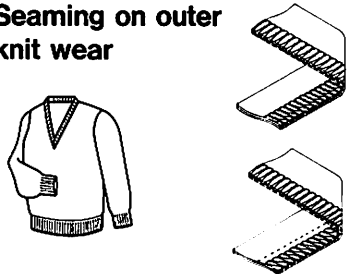
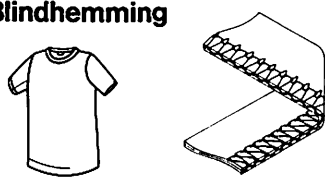
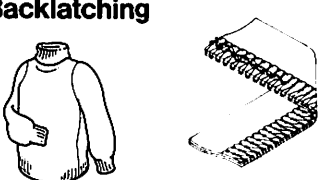
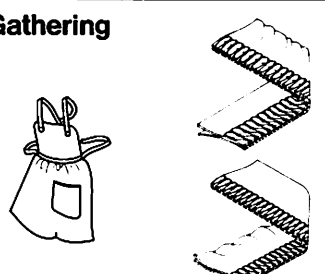
● 515 stitch type machine also available if so specified in ordering,
e.g. ETS32-420FA3/515-413.

● Specifications subject to change without notice.

 mm			 mm	 mm			 s.p.m.	
3.8	0.7-1.5	0.7-2	5.5	5.5	2N	2-row	6,000	Pants, pajamas
					2W	3-row		Dress shirts, blouses (P.P. fabrics, georgette)
					3N			Pants, pajamas
					2W			Dress shirts, blouses (P.P. fabrics, georgette)
3.8	0.7-2	0.7-2	5.5	5.5	3N	2-row	5,500	Knight gowns, heavy curtains
								Blouse (georgette, silk)
3.8	0.7-2	0.7-2	5.5	5.5	3N	2-row	5,500	Pillow cases, chair covers
3.8	0.7-1.5	0.7-2	5.5	5.5	3N	2-row	6,000	Sportswear
					2W			Light weight jeans, sports wear
3.8	0.7-1.5	0.7-2	6.0	6.0	2W	—	6,000	Working wear
					3N			Fashion pants
3.8	0.7-1.5	0.7-2	6.0	6.0	2W	—	5,500	Working wear, jeans
								Jeans ● Fitted with a tractor foot.
3.8	0.7-1.5	0.7-2	6.0	6.0	3N	—	6,000	Sportswear Jeans

ETS52 SERIES

■ VARIABLE FRONT TOP FEED OVEREDGERS

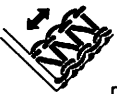
						
■ 1-needle seaming 	ETS52- <u>141FA3/504-463-W</u> 130FA3/504-363-N	1	3	Extra-high lift High lift	— —	3,4,5 3,4,5
■ 2-needle seaming 	ETS52- <u>142FA3/514-463-W</u> <u>142FA2/514-463-W</u> <u>133FA3/514-363-N</u> <u>133FA2/514-363-N</u>	2	4	Extra-high lift High lift	2 2 2 2	3,4,5 3,4,5 3,4,5 3,4,5
■ Seaming on outer knit wear 	ETS52- <u>253FB2/S1/514-493-W</u> <u>253FB2/S2/514-493-W</u> <u>/KL100</u> <u>142FB2/S1/514-463-W</u> <u>142FB2/S2/514-463-W</u> <u>/KL100</u>	2	4	Extra-high lift	2 2.5 3 2	3,4,5 2.5, 3.5, 4.5 4,5 3,4,5
■ Blindhemming 	ETS52-210FE3/505-323-N	1	3	High lift	—	4
■ Backlatching 	ETS52-184FB2/514-443-W /BT152	2	4	Extra-high lift	2	3,4
■ Gathering 	ETS52- <u>243FD3/514-463-W</u> <u>/KL100</u> <u>243FD2/514-463-W</u> <u>/KL100</u> <u>245FD3/514-363-W</u> <u>/KL100</u> <u>245FD2/514-363-W</u> <u>/KL100</u>	2	4	Extra-high lift High lift	2 2 2 2	3,4,5 3,4,5 3,4,5 3,4,5

● Standard machines are those of boldface.



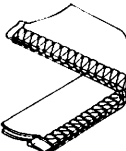
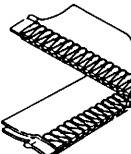
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- In place of 514 stitch type machine, 512 stitch type also available if so specified in ordering, e.g. ETS52-142FA3/512-463-W.
- Specifications subject to change without notice.

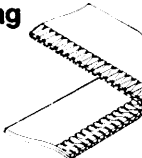
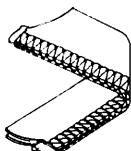
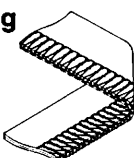
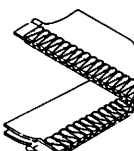
 mm	 mm	 mm	 mm	 mm			 s.p.m.	
3.8	0.7-1.5	0.7-2	5.5	5.5	3N	2-row	6,000	Sportswear Knit sport shirts
3.8	0.7-1.5	0.7-2	7.0 5.5	7.0 5.5	3N	2-row	6,000	Sportswear Childrens' wear Knit sport shirts
3.2 2.4	0.8-2.6 1.2-3.6	0.8-2.8 1.1-3.2	7.0	7.0	4row 3N	3-row	5,000	Sweaters Sportswear
3.8	0.7-1.5	0.7-2	5.5	5.5	2N	2-row	6,000	Underwear T-shirts
2.4	1.2-3.6	1.1-3.2	7.0	7.0	2-row	3-row	5,000	Sweaters
3.8	0.7-2	0.7-2	7.0 5.5	7.0 5.5	3N 3N	2-row	5,500	Pajamas Aprons Pillow cases

ETS52 SERIES

■ VARIABLE FRONT TOP FEED OVEREDGERS

						
■ 1-needle piping  	ETS52- 350FC2/P1/504-453-W 350FC2/P2/504-453-W	1	3	Extra-high lift	— —	5 5
■ 2-needle piping  	351FC2/P1/514-453-W ETS52- 351FC2/P2/514-453-W 352FC2/P1/514-353-W 352FC2/P2/514-353-W	2 2	4 4	Extra-high lift High lift	2 2 2 2	4 4 4 4
■ Gathering/piping 	243FD4/P1/514-463-W ETS52- /KL100 243FD4/P2/514-463-W /KL100	2	4	Extra-high lift	2 2	3,4,5 3,4,5

■ VARIABLE REAR TOP FEED OVEREDGERS

■ 1-needle seaming  	ETS52- 141BA2/504-463-W	1	3	Extra-high lift	—	4,5
■ 1-needle piping  	ETS52- 350BC2/P1/504-453-W 350BC2/P2/504-453-W	1	3	Extra-high lift	— —	5 5
■ 2-needle seaming  	ETS52- 142BA2/514-463-W	2	4	Extra-high lift	2	3,4,5
■ 2-needle piping  	ETS52- 351BC2/P1/514-453-W 351BC2/P2/514-453-W	2	4	Extra-high lift	2 2	4 4

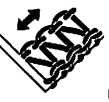
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- In place of 514 stitch type machine, 512 stitch type also available if so specified in ordering, e.g. ETS52-142BA2/512-463-W.
- Specifications subject to change without notice.

 mm			 mm	 mm			 s.p.m.	
3.8	0.7-1.5	0.7-2	6.0	6.0	3N	3-row	6,000	Sportswear Casual wear
 3.8	0.7-1.5	0.7-2	6.0	6.0	3N	3-row	6,000	Sportswear Casual wear
3.8	0.7-2	0.7-2	7.0	7.0	3N	3-row	5,500	Curtains, Childrens' wear
 3.8	0.7-1.5	0.7-2	6.0	6.0	3N	—	6,000	Jeans Fashion pants Working wear
3.8	0.7-1.5	0.7-2	5.0	6.0	3N	—	6,000	Jeans Fashion pants Working wear
3.8	0.7-1.5	0.7-2	6.0	6.0	3N	—	6,000	Jeans Fashion pants Working wear
3.8	0.7-1.5	0.7-2	5.0	6.0	3N	—	6,000	Sportswear Jeans

WORK AIDS

Machine	Flat type chain cutter	Tape cutter		Automatic tape cutter	
		Push button	Knee press	Vacuum continuous	Vacuum changeover
420FA2/516-413	KH211A	TK010	TK011	AT012	AT062
420FA3/516-413	"	"	"	"	"
422FA2/516-313	"	"	"	"	"
422FA3/516-313	"	"	"	"	"
430FA2/516-433	"	"	"	"	"
430FA3/516-433	"	"	"	"	"
432FA2/516-453	"	"	"	"	"
432FA3/516-453	"	"	"	"	"
432FC2/P1(P2)/516-453	—	"	"	"	"
ETS32-433FA2/516-353	KH211A	"	"	"	"
433FA3/516-353	"	"	"	"	"
433FC2/P1(P2)/516-333	—	"	"	"	"
434FA2/516-333	KH211A	"	"	"	"
434FA3/516-333	"	"	"	"	"
542FD2/516-453/KL100	"	"	"	"	"
542FD3/516-453/KL100	"	"	"	"	"
542FD4/P1(P2)/516-453/KL100	—	"	"	"	"
544FD2/516-353/KL100	"	"	"	"	"
544FD3/516-353/KL100	"	"	"	"	"
430BA2/516-433	KH211A	TK010	TK011	AT012	AT062
432BA2/516-453	"	"	"	"	"
432BC2/P1(P2)/516-453	—	"	"	"	"
ETS32-452BA2/516-433	KH211B	"	"	"	"
452BA4/516-433	"	"	"	"	"
453BA2/516-453	"	"	"	"	"
453BA4/516-453	"	"	"	"	"
130FA2/504-363-N	KH211C	TK010	TK011	AT012	AT062
130FA3/504-363-N	"	"	"	"	"
133FA2/514-363-N	"	"	"	"	"
133FA3/514-363-N	"	"	"	"	"
141FA2/504-463-W	KH211A	"	"	"	"
141FA3/504-463-W	"	"	"	"	"
142FA2/514-463-W	"	"	"	"	"
142FA3/514-463-W	"	"	"	"	"
142FB2/S1/514-463-W	"	"	"	"	"
142FB2/S2/514-463-W/KL100	"	"	"	"	"
184FB2/514-443-W/BT152	—	—	—	—	—
ETS52-210FE3/505-323-N	KH211A	—	—	—	—
243FD2/514-463-W/KL100	KH211C	TK010	TK011	AT012	AT062
243FD3/514-463-W/KL100	"	"	"	"	"
243FD4/P1(P2)/514-463-W/KL100	—	"	"	"	"
245FD2/514-363-W/KL100	"	"	"	"	"
245FD3/514-363-W/KL100	"	"	"	"	"
253FB2/S1/514-493-W	—	"	"	"	"
253FB2/S2/514-493-W/KL100	—	"	"	"	"
253FB2K/S1/514-493-W	—	"	"	"	"
253FB2K/S2/514-493-W/KL100	—	"	"	"	"
350FC2/P1(P2)/504-453-W	—	"	"	"	"
351FC2/P1(P2)/514-453-W	—	"	"	"	"
352FC2/P1(P2)/514-353-W	—	"	"	"	"
141BA2/504-463-W	KH211A	TK010	TK011	AT012	AT062
ETS52-142BA2/514-463-W	KH211C	"	"	"	"
350BC2/P1(P2)/504-453-W	—	"	"	"	"
351BC2/P1(P2)/514-453-W	—	"	"	"	"

MAXIMUM SPEED-FRONT TOP FEED ETS32

Table 3

EXTRA-HIGH LIFT		HIGH LIFT	
GENERAL SEAMING			
Machine type/spec.	Maximum speed (s.p.m.)	Machine type/spec.	Maximum speed (s.p.m.)
○ETS32-420FA2/ ⁵¹⁶ / ₍₅₁₅₎ -413	6,000	○ETS32-422FA2/ ⁵¹⁶ / ₍₅₁₅₎ -313	6,000
○ETS32-420FA5/ ⁵¹⁶ / ₍₅₁₅₎ -413		○ETS32-422FA5/ ⁵¹⁶ / ₍₅₁₅₎ -313	
○ETS32-430FA2/ ⁵¹⁶ / ₍₅₁₅₎ -433	"	○ETS32-434FA2/ ⁵¹⁶ / ₍₅₁₅₎ -333	"
○ETS32-430FA5/ ⁵¹⁶ / ₍₅₁₅₎ -433		○ETS32-434FA5/ ⁵¹⁶ / ₍₅₁₅₎ -333	
○ETS32-432FA2/ ⁵¹⁶ / ₍₅₁₅₎ -453	"	○ETS32-433FA2/ ⁵¹⁶ / ₍₅₁₅₎ -353	"
○ETS32-432FA5/ ⁵¹⁶ / ₍₅₁₅₎ -453		○ETS32-433FA5/ ⁵¹⁶ / ₍₅₁₅₎ -353	
●ETS32-420FA3/ ⁵¹⁶ / ₍₅₁₅₎ -413	"	●ETS32-422FA3/ ⁵¹⁶ / ₍₅₁₅₎ -313	"
●ETS32-430FA3/ ⁵¹⁶ / ₍₅₁₅₎ -433	"	●ETS32-434FA3/ ⁵¹⁶ / ₍₅₁₅₎ -333	"
●ETS32-432FA3/ ⁵¹⁶ / ₍₅₁₅₎ -453	"	●ETS32-433FA3/ ⁵¹⁶ / ₍₅₁₅₎ -353	"

GATHERING

Machine type/spec.	Maximum speed (s.p.m.)	Machine type/spec.	Maximum speed (s.p.m.)
○ETS32-542FD2/ ⁵¹⁶ / ₍₅₁₅₎ -453/KL100	5,500	○ETS32-544FD2/ ⁵¹⁶ / ₍₅₁₅₎ -353/KL100	5,500
○ETS32-542FD5/ ⁵¹⁶ / ₍₅₁₅₎ -453/KL100		○ETS32-544FD5/ ⁵¹⁶ / ₍₅₁₅₎ -353/KL100	
●ETS32-542FD3/ ⁵¹⁶ / ₍₅₁₅₎ -453/KL100	"	●ETS32-544FD3/ ⁵¹⁶ / ₍₅₁₅₎ -353/KL100	"

PIPING

Machine type/spec.	Maximum speed (s.p.m.)	Machine type/spec.	Maximum speed (s.p.m.)
○ETS32-432FC2/ ^{P1} / _{P2} ⁵¹⁶ / ₍₅₁₅₎ -453	6,000	○ETS32-433FC2/ ^{P1} / _{P2} ⁵¹⁶ / ₍₅₁₅₎ -333	6,000

MAXIMUM SPEED-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Maximum speed (s.p.m.)
○ETS32-430BA2/ ⁵¹⁶ / ₍₅₁₅₎ -433	6,000
○ETS32-432BA2/ ⁵¹⁶ / ₍₅₁₅₎ -453	"

SEAMING/HEAVY

Machine type/spec.	Maximum speed (s.p.m.)
○ETS32-452BA2/ ⁵¹⁶ / ₍₅₁₅₎ -433	5,500
■ETS32-452BA4/ ⁵¹⁶ / ₍₅₁₅₎ -433	"
○ETS32-453BA2/ ⁵¹⁶ / ₍₅₁₅₎ -453	"
■ETS32-453BA4/ ⁵¹⁶ / ₍₅₁₅₎ -453	"

PIPING

Machine type/spec.	Maximum speed (s.p.m.)
○ETS32-432BC2/ ^{P1} / _{P2} ⁵¹⁶ / ₍₅₁₅₎ -453	6,000

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

THREADING-FRONT TOP FEED ETS32

Table 4

EXTRA-HIGH LIFT

GENERAL SEAMING

Machine type/spec.	Stitch type			Machine type/spec.	Stitch type		
	516	515	401		516	515	401
○ETS32-420FA2/(⁵¹⁶ / ₅₁₅)-413	Fig.19	Fig.21	Fig.23	○ETS32-422FA2/(⁵¹⁶ / ₅₁₅)-313	Fig.20	Fig.22	Fig.23
○ETS32-420FA5/(⁵¹⁶ / ₅₁₅)-413				○ETS32-422FA5/(⁵¹⁶ / ₅₁₅)-313			
○ETS32-430FA2/(⁵¹⁶ / ₅₁₅)-433				○ETS32-434FA2/(⁵¹⁶ / ₅₁₅)-333			
○ETS32-430FA5/(⁵¹⁶ / ₅₁₅)-433	"	"	"	○ETS32-434FA5/(⁵¹⁶ / ₅₁₅)-333	"	"	"
○ETS32-432FA2/(⁵¹⁶ / ₅₁₅)-453	"	"	"	○ETS32-433FA2/(⁵¹⁶ / ₅₁₅)-353	"	"	"
○ETS32-432FA5/(⁵¹⁶ / ₅₁₅)-453				○ETS32-433FA5/(⁵¹⁶ / ₅₁₅)-353			
●ETS32-420FA3/(⁵¹⁶ / ₅₁₅)-413	"	"	"	●ETS32-422FA3/(⁵¹⁶ / ₅₁₅)-313	"	"	"
●ETS32-430FA3/(⁵¹⁶ / ₅₁₅)-433	"	"	"	●ETS32-434FA3/(⁵¹⁶ / ₅₁₅)-333	"	"	"
●ETS32-432FA3/(⁵¹⁶ / ₅₁₅)-453	"	"	"	●ETS32-433FA3/(⁵¹⁶ / ₅₁₅)-353	"	"	"

HIGH LIFT

GATHERING

Machine type/spec.	Stitch type			Machine type/spec.	Stitch type		
	516	515	401		516	515	401
○ETS32-542FD2/(⁵¹⁶ / ₅₁₅)-453/KL100	Fig.19	Fig.21	Fig.23	○ETS32-544FD2/(⁵¹⁶ / ₅₁₅)-353/KL100	Fig.20	Fig.22	Fig.23
○ETS32-542FD5/(⁵¹⁶ / ₅₁₅)-453/KL100				○ETS32-544FD5/(⁵¹⁶ / ₅₁₅)-353/KL100			
●ETS32-542FD3/(⁵¹⁶ / ₅₁₅)-453/KL100				●ETS32-544FD3/(⁵¹⁶ / ₅₁₅)-353/KL100			

PIPING

Machine type/spec.	Stitch type			Machine type/spec.	Stitch type		
	516	515	401		516	515	401
○ETS32-432FC2/(^{P1} / _{P2})(⁵¹⁶ / ₅₁₅)-453	Fig.19	Fig.21	Fig.23	○ETS32-433FC2/(^{P1} / _{P2})(⁵¹⁶ / ₅₁₅)-333	Fig.20	Fig.22	Fig.23

THREADING-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Stitch type		
	516	515	401
○ETS32-430BA2/(⁵¹⁶ / ₅₁₅)-433	Fig.19	Fig.21	Fig.23
○ETS32-432BA2/(⁵¹⁶ / ₅₁₅)-453			

SEAMING/HEAVY

Machine type/spec.	Stitch type		
	516	515	401
○ETS32-452BA2/(⁵¹⁶ / ₅₁₅)-433	Fig.19	Fig.21	Fig.23
■ETS32-452BA4/(⁵¹⁶ / ₅₁₅)-433			
○ETS32-453BA2/(⁵¹⁶ / ₅₁₅)-453	"	"	"
■ETS32-453BA4/(⁵¹⁶ / ₅₁₅)-453	"	"	"

PIPING

Machine type/spec.	Stitch type		
	516	515	401
○ETS32-432BC2/(^{P1} / _{P2})(⁵¹⁶ / ₅₁₅)-453	Fig.19	Fig.21	Fig.23

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

NEEDLE THREAD GUIDE SETTING POSITION-FRONT TOP FEED ETS32

Table 7

EXTRA-HIGH LIFT

GENERAL SEAMING

HIGH LIFT

Machine type/spec.	Stitch type 516			Stitch type 515			Machine type/spec.	Stitch type 516			Stitch type 515		
	①	②	③	①	②	③		①	②	③	①	②	③
○ETS32-420FA2/(516/515)-413	B	B	B	B	A	A	○ETS32-422FA2/(516/515)-313	B	C	C	B	C	C
○ETS32-420FA5/(516/515)-413							○ETS32-422FA5/(516/515)-313						
○ETS32-430FA2/(516/515)-433	"	"	"	"	"	"	○ETS32-434FA2/(516/515)-333	"	"	"	"	"	"
○ETS32-430FA5/(516/515)-433							○ETS32-434FA5/(516/515)-333						
○ETS32-432FA2/(516/515)-453	"	"	"	"	"	"	○ETS32-433FA2/(516/515)-353	"	"	"	"	"	"
○ETS32-432FA5/(516/515)-453							○ETS32-433FA5/(516/515)-353						
●ETS32-420FA3/(516/515)-413	"	"	"	"	"	"	●ETS32-422FA3/(516/515)-313	"	"	"	"	"	"
●ETS32-430FA3/(516/515)-433	"	"	"	"	"	"	●ETS32-434FA3/(516/515)-333	"	"	"	"	"	"
●ETS32-432FA3/(516/515)-453	"	"	"	"	"	"	●ETS32-433FA3/(516/515)-353	"	"	"	"	"	"

GATHERING

Machine type/spec.	Stitch type 516			Stitch type 515			Machine type/spec.	Stitch type 516			Stitch type 515		
	①	②	③	①	②	③		①	②	③	①	②	③
○ETS32-542FD2/ $\frac{516}{515}$ -453/KL100	B	B	B	B	A	A	○ETS32-544FD2/ $\frac{516}{515}$ -353/KL100	B	C	C	B	C	C
○ETS32-542FD5/ $\frac{516}{515}$ -453/KL100							○ETS32-544FD5/ $\frac{516}{515}$ -353/KL100						
●ETS32-542FD3/ $\frac{516}{515}$ -453/KL100	"	"	"	"	"	"	●ETS32-544FD3/ $\frac{516}{515}$ -353/KL100	"	"	"	"	"	"

PIPING

Machine type/spec.	Stitch type 516			Stitch type 515			Machine type/spec.	Stitch type 516			Stitch type 515		
	①	②	③	①	②	③		①	②	③	①	②	③
○ETS32-432FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	B	B	B	B	A	A	○ETS32-433FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -333	B	C	C	B	C	C

NEEDLE THREAD GUIDE SETTING POSITION-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Stitch type 516			Stitch type 515		
	①	②	③	①	②	③
○ETS32-430BA2/ $\frac{516}{515}$ -433	B	B	B	B	A	A
○ETS32-432BA2/ $\frac{516}{515}$ -453	"	"	"	"	"	"

SEAMING/HEAVY

Machine type/spec.	Stitch type 516			Stitch type 515		
	①	②	③	①	②	③
○ETS32-452BA2/ $\frac{516}{515}$ -433	C	C	C	C	A	A
■ETS32-452BA4/ $\frac{516}{515}$ -433	"	"	"	"	"	"
○ETS32-453BA2/ $\frac{516}{515}$ -453	"	"	"	"	"	"
■ETS32-453BA4/ $\frac{516}{515}$ -453	"	"	"	"	"	"

PIPING

Machine type/spec.	Stitch type 516			Stitch type 515		
	①	②	③	①	②	③
○ETS32-432BC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	B	B	B	B	A	A

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

BOTTOM FEED HEIGHT-FRONT TOP FEED ETS32

Table 8

EXTRA-HIGH LIFT	HIGH LIFT
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GENERAL SEAMING

Machine type/spec.	Bottom feed height	Machine type/spec.	Bottom feed height
○ETS32-420FA2/(⁵¹⁶ / ₅₁₅)-413	0.9~1.1	○ETS32-422FA2/(⁵¹⁶ / ₅₁₅)-313	0.8~1.0
○ETS32-420FA5/(⁵¹⁶ / ₅₁₅)-413		○ETS32-422FA5/(⁵¹⁶ / ₅₁₅)-313	
○ETS32-430FA2/(⁵¹⁶ / ₅₁₅)-433	"	○ETS32-434FA2/(⁵¹⁶ / ₅₁₅)-333	"
○ETS32-430FA5/(⁵¹⁶ / ₅₁₅)-433		○ETS32-434FA5/(⁵¹⁶ / ₅₁₅)-333	
○ETS32-432FA2/(⁵¹⁶ / ₅₁₅)-453	"	○ETS32-433FA2/(⁵¹⁶ / ₅₁₅)-353	"
○ETS32-432FA5/(⁵¹⁶ / ₅₁₅)-453		○ETS32-433FA5/(⁵¹⁶ / ₅₁₅)-353	
●ETS32-420FA3/(⁵¹⁶ / ₅₁₅)-413	"	●ETS32-422FA3/(⁵¹⁶ / ₅₁₅)-313	"
●ETS32-430FA3/(⁵¹⁶ / ₅₁₅)-433	"	●ETS32-434FA3/(⁵¹⁶ / ₅₁₅)-333	"
●ETS32-432FA3/(⁵¹⁶ / ₅₁₅)-453	"	●ETS32-433FA3/(⁵¹⁶ / ₅₁₅)-353	"

GATHERING

Machine type/spec.	Bottom feed height	Machine type/spec.	Bottom feed height
○ETS32-542FD2/(⁵¹⁶ / ₅₁₅)-453/KL100	0.9~1.1	○ETS32-544FD2/(⁵¹⁶ / ₅₁₅)-353/KL100	0.8~1.0
○ETS32-542FD5/(⁵¹⁶ / ₅₁₅)-453/KL100		○ETS32-544FD5/(⁵¹⁶ / ₅₁₅)-353/KL100	
●ETS32-542FD3/(⁵¹⁶ / ₅₁₅)-453/KL100	"	●ETS32-544FD3/(⁵¹⁶ / ₅₁₅)-353/KL100	"

PIPING

Machine type/spec.	Bottom feed height	Machine type/spec.	Bottom feed height
○ETS32-432FC2/ ^{P1} / _{P2} (⁵¹⁶ / ₅₁₅)-453	0.9~1.1	○ETS32-433FC2/ ^{P1} / _{P2} (⁵¹⁶ / ₅₁₅)-333	0.8~1.0

BOTTOM FEED HEIGHT-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Bottom feed height
○ETS32-430BA2/(⁵¹⁶ / ₅₁₅)-433	0.9~1.1
○ETS32-432BA2/(⁵¹⁶ / ₅₁₅)-453	"

SEAMING/HEAVY

Machine type/spec.	Bottom feed height
○ETS32-452BA2/(⁵¹⁶ / ₅₁₅)-433	0.9~1.1
■ETS32-452BA4/(⁵¹⁶ / ₅₁₅)-433	"
○ETS32-453BA2/(⁵¹⁶ / ₅₁₅)-453	"
■ETS32-453BA4/(⁵¹⁶ / ₅₁₅)-453	"

PIPING

Machine type/spec.	Bottom feed height
○ETS32-432BC2/ ^{P1} / _{P2} (⁵¹⁶ / ₅₁₅)-453	0.9~1.1

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

NEEDLE HEIGHT/LOWER LOOPER SETTING-FRONT TOP FEED ETS32

Table 9

EXTRA-HIGH LIFT			HIGH LIFT		
GENERAL SEAMING					
Machine type/spec.	Needle (a)	Lower looper (b)	Machine type/spec.	Needle (a)	Lower looper (b)
○ETS32-420FA2/(⁵¹⁶ / ₅₁₅)-413	11.7~11.9	3.6~3.9	○ETS32-422FA2/(⁵¹⁶ / ₅₁₅)-313	10.4~10.6	3.8~4.1
○ETS32-420FA5/(⁵¹⁶ / ₅₁₅)-413			○ETS32-422FA5/(⁵¹⁶ / ₅₁₅)-313		
○ETS32-430FA2/(⁵¹⁶ / ₅₁₅)-433	"	"	○ETS32-434FA2/(⁵¹⁶ / ₅₁₅)-333	"	"
○ETS32-430FA5/(⁵¹⁶ / ₅₁₅)-433			○ETS32-434FA5/(⁵¹⁶ / ₅₁₅)-333		
○ETS32-432FA2/(⁵¹⁶ / ₅₁₅)-453	"	"	○ETS32-433FA2/(⁵¹⁶ / ₅₁₅)-353	"	"
○ETS32-432FA5/(⁵¹⁶ / ₅₁₅)-453			○ETS32-433FA5/(⁵¹⁶ / ₅₁₅)-353		
●ETS32-420FA3/(⁵¹⁶ / ₅₁₅)-413	"	"	●ETS32-422FA3/(⁵¹⁶ / ₅₁₅)-313	"	"
●ETS32-430FA3/(⁵¹⁶ / ₅₁₅)-433			●ETS32-434FA3/(⁵¹⁶ / ₅₁₅)-333		
●ETS32-432FA3/(⁵¹⁶ / ₅₁₅)-453	"	"	●ETS32-433FA3/(⁵¹⁶ / ₅₁₅)-353	"	"

GATHERING

Machine type/spec.	Needle (a)	Lower looper (b)	Machine type/spec.	Needle (a)	Lower looper (b)
○ETS32-542FD2/ $\frac{516}{515}$ -453/KL100	11.7~11.9	3.6~3.9	○ETS32-544FD2/ $\frac{516}{515}$ -353/KL100	10.4~10.6	3.8~4.1
○ETS32-542FD5/ $\frac{516}{515}$ -453/KL100			○ETS32-544FD5/ $\frac{516}{515}$ -353/KL100		
●ETS32-542FD3/ $\frac{516}{515}$ -453/KL100	"	"	●ETS32-544FD3/ $\frac{516}{515}$ -353/KL100	"	"

PIPING

Machine type/spec.	Needle (a)	Lower looper (b)	Machine type/spec.	Needle (a)	Lower looper (b)
○ETS32-432FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	11.7~11.9	3.6~3.9	○ETS32-433FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -333	10.4~10.6	3.8~4.1

NEEDLE HEIGHT/LOWER LOOPER SETTING-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Needle (a)	Lower looper (b)
○ETS32-430BA2/ $\frac{516}{515}$ -433	11.7~11.9	3.6~3.9
○ETS32-432BA2/ $\frac{516}{515}$ -453		

SEAMING/HEAVY

Machine type/spec.	Needle (a)	Lower looper (b)
○ETS32-452BA2/ $\frac{516}{515}$ -433	11.7~11.9	3.6~3.9
■ETS32-452BA4/ $\frac{516}{515}$ -433		
○ETS32-453BA2/ $\frac{516}{515}$ -453	"	"
■ETS32-453BA4/ $\frac{516}{515}$ -453		

PIPING

Machine type/spec.	Needle (a)	Lower looper (b)
○ETS32-432BC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	11.7~11.9	3.6~3.9

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

UPPER LOOPER SETTING-FRONT TOP FEED TYPE ETS32

Table 10

EXTRA-HIGH LIFT			HIGH LIFT		
GENERAL SEAMING					
Machine type/spec.	Position	Distance (a)	Machine type/spec.	Position	Distance (a)
○ETS32-420FA2/(⁵¹⁶ / ₅₁₅)-413	A	4.5~5.0	○ETS32-422FA2/(⁵¹⁶ / ₅₁₅)-313	B	4.5~5.0
○ETS32-420FA5/(⁵¹⁶ / ₅₁₅)-413			○ETS32-422FA5/(⁵¹⁶ / ₅₁₅)-313		
○ETS32-430FA2/(⁵¹⁶ / ₅₁₅)-433	"	"	○ETS32-434FA2/(⁵¹⁶ / ₅₁₅)-333	"	"
○ETS32-430FA5/(⁵¹⁶ / ₅₁₅)-433			○ETS32-434FA5/(⁵¹⁶ / ₅₁₅)-333		
○ETS32-432FA2/(⁵¹⁶ / ₅₁₅)-453	"	"	○ETS32-433FA2/(⁵¹⁶ / ₅₁₅)-353	"	"
○ETS32-432FA5/(⁵¹⁶ / ₅₁₅)-453			○ETS32-433FA5/(⁵¹⁶ / ₅₁₅)-353		
●ETS32-420FA3/(⁵¹⁶ / ₅₁₅)-413	"	"	●ETS32-422FA3/(⁵¹⁶ / ₅₁₅)-313	"	"
●ETS32-430FA3/(⁵¹⁶ / ₅₁₅)-433			●ETS32-434FA3/(⁵¹⁶ / ₅₁₅)-333		
●ETS32-432FA3/(⁵¹⁶ / ₅₁₅)-453	"	"	●ETS32-433FA3/(⁵¹⁶ / ₅₁₅)-353	"	"

GATHERING

Machine type/spec.	Position	Distance (a)	Machine type/spec.	Position	Distance (a)
○ETS32-542FD2/ $\left(\frac{516}{515}\right)$ -453/KL100	A	4.5~5.0	○ETS32-544FD2/ $\left(\frac{516}{515}\right)$ -353/KL100	B	4.5~5.0
○ETS32-542FD5/ $\left(\frac{516}{515}\right)$ -453/KL100			○ETS32-544FD5/ $\left(\frac{516}{515}\right)$ -353/KL100		
●ETS32-542FD3/ $\left(\frac{516}{515}\right)$ -453/KL100	"	"	●ETS32-544FD3/ $\left(\frac{516}{515}\right)$ -353/KL100	"	"

PIPING

Machine type/spec.	Position	Distance (a)	Machine type/spec.	Position	Distance (a)
○ETS32-432FC2/ $\frac{P1}{P2}$ / $\left(\frac{516}{515}\right)$ -453	A	4.5~5.0	○ETS32-433FC2/ $\frac{P1}{P2}$ / $\left(\frac{516}{515}\right)$ -333	B	4.5~5.0

UPPER LOOPER SETTING-REAR TOP FEED TYPE ETS32

GENERAL SEAMING

Machine type/spec.	Position	Distance (a)
○ETS32-430BA2/ $\left(\frac{516}{515}\right)$ -433	A	4.5~5.0
○ETS32-432BA2/ $\left(\frac{516}{515}\right)$ -453	"	"

SEAMING/HEAVY

Machine type/spec.	Position	Distance (a)
○ETS32-452BA2/ $\left(\frac{516}{515}\right)$ -433	A	4.5~5.0
■ETS32-452BA4/ $\left(\frac{516}{515}\right)$ -433	"	"
○ETS32-453BA2/ $\left(\frac{516}{515}\right)$ -453	"	"
■ETS32-453BA4/ $\left(\frac{516}{515}\right)$ -453	"	"

PIPING

Machine type/spec.	Position	Distance (a)
○ETS32-432BC2/ $\frac{P1}{P2}$ / $\left(\frac{516}{515}\right)$ -453	A	4.5~5.0

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

TOP FEED VERTICAL STROKE AND SET POSITION- FRONT TOP FEED ETS32

Table 12

EXTRA-HIGH LIFT	HIGH LIFT
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GENERAL SEAMING

Machine type/spec.	Stroke	Gap (a)	Position	Machine type/spec.	Stroke	Gap (a)	Position
○ETS32-420FA2/ $\frac{516}{515}$ -413	4.5	1.5	A	○ETS32-422FA2/ $\frac{516}{515}$ -313	4.5	1.5	A
○ETS32-420FA5/ $\frac{516}{515}$ -413				○ETS32-422FA5/ $\frac{516}{515}$ -313			
○ETS32-430FA2/ $\frac{516}{515}$ -433	"	"	"	○ETS32-434FA2/ $\frac{516}{515}$ -333	"	"	"
○ETS32-430FA5/ $\frac{516}{515}$ -433				○ETS32-434FA5/ $\frac{516}{515}$ -333			
○ETS32-432FA2/ $\frac{516}{515}$ -453	"	"	"	○ETS32-433FA2/ $\frac{516}{515}$ -353	"	"	"
○ETS32-432FA5/ $\frac{516}{515}$ -453				○ETS32-433FA5/ $\frac{516}{515}$ -353			
●ETS32-420FA3/ $\frac{516}{515}$ -413	"	"	"	●ETS32-422FA3/ $\frac{516}{515}$ -313	"	"	"
●ETS32-430FA3/ $\frac{516}{515}$ -433	"	"	"	●ETS32-434FA3/ $\frac{516}{515}$ -333	"	"	"
●ETS32-432FA3/ $\frac{516}{515}$ -453	"	"	"	●ETS32-433FA3/ $\frac{516}{515}$ -353	"	"	"

GATHERING

Machine type/spec.	Stroke	Gap (a)	Position	Machine type/spec.	Stroke	Gap (a)	Position
○ETS32-542FD2/ $\frac{516}{515}$ -453/KL100	4.5	1.5	B	○ETS32-544FD2/ $\frac{516}{515}$ -353/KL100	4.5	1.5	B
○ETS32-542FD5/ $\frac{516}{515}$ -453/KL100				○ETS32-544FD5/ $\frac{516}{515}$ -353/KL100			
●ETS32-542FD3/ $\frac{516}{515}$ -453/KL100	"	"	"	●ETS32-544FD3/ $\frac{516}{515}$ -353/KL100	"	"	"

PIPING

Machine type/spec.	Stroke	Gap (a)	Position	Machine type/spec.	Stroke	Gap (a)	Position
○ETS32-432FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	4.5	1.5	A	○ETS32-433FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -333	4.5	1.5	A

TOP FEED VERTICAL STROKE AND SET POSITION- REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Stroke	Gap (a)	Position
○ETS32-430BA2/ $\frac{516}{515}$ -433	4.5	4.0	C
○ETS32-432BA2/ $\frac{516}{515}$ -453	"	"	"

SEAMING/HEAVY

Machine type/spec.	Stroke	Gap (a)	Position
○ETS32-452BA2/ $\frac{516}{515}$ -433	7.0	8.0	C
■ETS32-452BA4/ $\frac{516}{515}$ -433	"	"	"
○ETS32-453BA2/ $\frac{516}{515}$ -453	"	"	"
■ETS32-453BA4/ $\frac{516}{515}$ -453	"	"	"

PIPING

Machine type/spec.	Stroke	Gap (a)	Position
○ETS32-432BC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	4.5	4.0	C

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

TOP FEED STROKE AND TOP FEED RATIO-FRONT TOP FEED ETS32

Table 13

EXTRA-HIGH LIFT				HIGH LIFT			
GENERAL SEAMING							
Machine type/spec.	Stroke	Feed ratio	Setting	Machine type/spec.	Stroke	Feed ratio	Setting
○ETS32-420FA2/($\frac{516}{515}$)-413	2.8~5.8	1:0.75 ~1:1.5	1~6	○ETS32-422FA2/($\frac{516}{515}$)-313	2.8~5.8	1:0.75 ~1:1.5	1~6
○ETS32-420FA5/($\frac{516}{515}$)-413				○ETS32-422FA5/($\frac{516}{515}$)-313			
○ETS32-430FA2/($\frac{516}{515}$)-433	"	"	"	○ETS32-434FA2/($\frac{516}{515}$)-333	"	"	"
○ETS32-430FA5/($\frac{516}{515}$)-433				○ETS32-434FA5/($\frac{516}{515}$)-333			
○ETS32-432FA2/($\frac{516}{515}$)-453	"	"	"	○ETS32-433FA2/($\frac{516}{515}$)-353	"	"	"
○ETS32-432FA5/($\frac{516}{515}$)-453				○ETS32-433FA5/($\frac{516}{515}$)-353			
●ETS32-420FA3/($\frac{516}{515}$)-413	"	"	"	●ETS32-422FA3/($\frac{516}{515}$)-313	"	"	"
●ETS32-430FA3/($\frac{516}{515}$)-433				●ETS32-434FA3/($\frac{516}{515}$)-333			
●ETS32-432FA3/($\frac{516}{515}$)-453	"	"	"	●ETS32-433FA3/($\frac{516}{515}$)-353	"	"	"

GATHERING

Machine type/spec.	Stroke	Feed ratio	Setting	Machine type/spec.	Stroke	Feed ratio	Setting
○ETS32-542FD2/ $\frac{516}{515}$ -453/KL100	2.8~7.4	1:0.75 ~1:1.95	1~9	○ETS32-544FD2/ $\frac{516}{515}$ -353/KL100	2.8~7.4	1:0.75 ~1:1.95	1~9
○ETS32-542FD5/ $\frac{516}{515}$ -453/KL100				○ETS32-544FD5/ $\frac{516}{515}$ -353/KL100			
●ETS32-542FD3/ $\frac{516}{515}$ -453/KL100	"	"	"	●ETS32-544FD3/ $\frac{516}{515}$ -353/KL100	"	"	"

PIPING

Machine type/spec.	Stroke	Feed ratio	Setting	Machine type/spec.	Stroke	Feed ratio	Setting
○ETS32-432FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	2.8~5.8	1:0.75 ~1:1.5	1~6	○ETS32-433FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -333	2.8~5.8	1:0.75 ~1:1.5	1~6

TOP FEED STROKE AND TOP FEED RATIO-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Stroke	Feed ratio	Setting
○ETS32-430BA2/ $\frac{516}{515}$ -433	2.8~5.8	1:0.75 ~1:1.95	1~6
○ETS32-432BA2/ $\frac{516}{515}$ -453			

SEAMING/HEAVY

Machine type/spec.	Stroke	Feed ratio	Setting
○ETS32-452BA2/ $\frac{516}{515}$ -433	2.8~5.8	1:0.75 ~1:1.95	1~6
■ETS32-452BA4/ $\frac{516}{515}$ -433			
○ETS32-453BA2/ $\frac{516}{515}$ -453	"	"	"
■ETS32-453BA4/ $\frac{516}{515}$ -453			

PIPING

Machine type/spec.	Stroke	Feed ratio	Setting
○ETS32-432BC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	2.8~5.8	1:0.75 ~1:1.95	1~6

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

HORIZONTAL TOP FEED POSITION-FRONT TOP FEED ETS32

Table 14

EXTRA-HIGH LIFT	HIGH LIFT
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GENERAL SEAMING

Machine type/spec.	Back and forth position (a)	Right to left position	Machine type/spec.	Back and forth position (a)	Right to left position
○ETS32-420FA2/ ⁵¹⁶ / ₍₅₁₅₎ -413	11.0	-0.6	○ETS32-422FA2/ ⁵¹⁶ / ₍₅₁₅₎ -313	11.0	-0.6
○ETS32-420FA5/ ⁵¹⁶ / ₍₅₁₅₎ -413			○ETS32-422FA5/ ⁵¹⁶ / ₍₅₁₅₎ -313		
○ETS32-430FA2/ ⁵¹⁶ / ₍₅₁₅₎ -433			○ETS32-434FA2/ ⁵¹⁶ / ₍₅₁₅₎ -333		
○ETS32-430FA5/ ⁵¹⁶ / ₍₅₁₅₎ -433	"	+1.6	○ETS32-434FA5/ ⁵¹⁶ / ₍₅₁₅₎ -333	"	+1.6
○ETS32-432FA2/ ⁵¹⁶ / ₍₅₁₅₎ -453			○ETS32-433FA2/ ⁵¹⁶ / ₍₅₁₅₎ -353		
○ETS32-432FA5/ ⁵¹⁶ / ₍₅₁₅₎ -453			○ETS32-433FA5/ ⁵¹⁶ / ₍₅₁₅₎ -353		
●ETS32-420FA3/ ⁵¹⁶ / ₍₅₁₅₎ -413	12.5	+2.05	●ETS32-422FA3/ ⁵¹⁶ / ₍₅₁₅₎ -313	12.5	+2.05
●ETS32-430FA3/ ⁵¹⁶ / ₍₅₁₅₎ -433	"	+4.25	●ETS32-434FA3/ ⁵¹⁶ / ₍₅₁₅₎ -333	"	+4.25
●ETS32-432FA3/ ⁵¹⁶ / ₍₅₁₅₎ -453			●ETS32-433FA3/ ⁵¹⁶ / ₍₅₁₅₎ -353		

GATHERING

Machine type/spec.	Back and forth position (a)	Right to left position	Machine type/spec.	Back and forth position (a)	Right to left position
○ETS32-542FD2/ ⁵¹⁶ / ₍₅₁₅₎ -453/KL100	10.0	+1.6	○ETS32-544FD2/ ⁵¹⁶ / ₍₅₁₅₎ -353/KL100	10.0	+1.6
○ETS32-542FD5/ ⁵¹⁶ / ₍₅₁₅₎ -453/KL100			○ETS32-544FD5/ ⁵¹⁶ / ₍₅₁₅₎ -353/KL100		
●ETS32-542FD3/ ⁵¹⁶ / ₍₅₁₅₎ -453/KL100	11.5	+4.25	●ETS32-544FD3/ ⁵¹⁶ / ₍₅₁₅₎ -353/KL100	11.5	+4.25

PIPING

Machine type/spec.	Back and forth position (a)	Right to left position	Machine type/spec.	Back and forth position (a)	Right to left position
○ETS32-432FC2/ ^{P1} / _{P2} / ⁵¹⁶ / ₍₅₁₅₎ -453	11.0	+1.6	○ETS32-433FC2/ ^{P1} / _{P2} / ⁵¹⁶ / ₍₅₁₅₎ -333	11.0	+1.6

HORIZONTAL TOP FEED POSITION-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Back and forth position (a)	Right to left position
○ETS32-430BA2/ ⁵¹⁶ / ₍₅₁₅₎ -433	43.5	-0.3
○ETS32-432BA2/ ⁵¹⁶ / ₍₅₁₅₎ -453	"	"

SEAMING/HEAVY

Machine type/spec.	Back and forth position (a)	Right to left position
○ETS32-452BA2/ ⁵¹⁶ / ₍₅₁₅₎ -433	43.5	-0.3
■ETS32-452BA4/ ⁵¹⁶ / ₍₅₁₅₎ -433	47.0	+3.8
○ETS32-453BA2/ ⁵¹⁶ / ₍₅₁₅₎ -453	43.5	-0.3
■ETS32-453BA4/ ⁵¹⁶ / ₍₅₁₅₎ -453	47.0	+3.8

PIPING

Machine type/spec.	Back and forth position (a)	Right to left position
○ETS32-432BC2/ ^{P1} / _{P2} / ⁵¹⁶ / ₍₅₁₅₎ -453	43.5	-0.3

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

VERTICAL TOP FEED POSITION-FRONT TOP FEED ETS32

Table 15

EXTRA-HIGH LIFT	HIGH LIFT
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GENERAL SEAMING

Machine type/spec.	Height (b)	Checking dead point	Machine type/spec.	Height (b)	Checking dead point
○ETS32-420FA2/ $\frac{516}{515}$ -413	0.2	Bottom	○ETS32-422FA2/ $\frac{516}{515}$ -313	0.2	Bottom
○ETS32-420FA5/ $\frac{516}{515}$ -413			○ETS32-422FA5/ $\frac{516}{515}$ -313		
○ETS32-430FA2/ $\frac{516}{515}$ -433	"	"	○ETS32-434FA2/ $\frac{516}{515}$ -333	"	"
○ETS32-430FA5/ $\frac{516}{515}$ -433			○ETS32-434FA5/ $\frac{516}{515}$ -333		
○ETS32-432FA2/ $\frac{516}{515}$ -453	"	"	○ETS32-433FA2/ $\frac{516}{515}$ -353	"	"
○ETS32-432FA5/ $\frac{516}{515}$ -453			○ETS32-433FA5/ $\frac{516}{515}$ -353		
●ETS32-420FA3/ $\frac{516}{515}$ -413	"	"	●ETS32-422FA3/ $\frac{516}{515}$ -313	"	"
●ETS32-430FA3/ $\frac{516}{515}$ -433	"	"	●ETS32-434FA3/ $\frac{516}{515}$ -333	"	"
●ETS32-432FA3/ $\frac{516}{515}$ -453	"	"	●ETS32-433FA3/ $\frac{516}{515}$ -353	"	"

GATHERING

Machine type/spec.	Height (b)	Checking dead point	Machine type/spec.	Height (b)	Checking dead point
○ETS32-542FD2/ $\frac{516}{515}$ -453/KL100	3.5	Top	○ETS32-544FD2/ $\frac{516}{515}$ -353/KL100	3.5	Top
○ETS32-542FD5/ $\frac{516}{515}$ -453/KL100			○ETS32-544FD5/ $\frac{516}{515}$ -353/KL100		
●ETS32-542FD3/ $\frac{516}{515}$ -453/KL100	"	"	●ETS32-544FD3/ $\frac{516}{515}$ -353/KL100	"	"

PIPING

Machine type/spec.	Height (b)	Checking dead point	Machine type/spec.	Height (b)	Checking dead point
○ETS32-432FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	0.2	Bottom	○ETS32-433FC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -333	0.2	Bottom

VERTICAL TOP FEED POSITION-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Height (b)	Checking dead point
○ETS32-430BA2/ $\frac{516}{515}$ -433	0.2	Bottom
○ETS32-432BA2/ $\frac{516}{515}$ -453	"	"

SEAMING/HEAVY

Machine type/spec.	Height (b)	Checking dead point
○ETS32-452BA2/ $\frac{516}{515}$ -433	7.0	Top
■ETS32-452BA4/ $\frac{516}{515}$ -433	"	"
○ETS32-453BA2/ $\frac{516}{515}$ -453	"	"
■ETS32-453BA4/ $\frac{516}{515}$ -453	"	"

PIPING

Machine type/spec.	Height (b)	Checking dead point
○ETS32-432BC2/ $\frac{P1}{P2}$ / $\frac{516}{515}$ -453	0.2	Bottom

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

PRESSER FOOT AND TOP FEED HEIGHTS-FRONT TOP FEED ETS32

Table 16

EXTRA-HIGH LIFT					HIGH LIFT				
GENERAL SEAMING									
Machine type/spec.	Foot lift(e)	Feed lift	Gap (a)	Gap (b)	Machine type/spec.	Foot lift(e)	Feed lift	Gap (a)	Gap (b)
○ETS32-420FA2/(⁵¹⁶ / ₅₁₅)-413	5.5	5.5	2.0	3.0	○ETS32-422FA2/(⁵¹⁶ / ₅₁₅)-313	5.5	5.5	2.0	3.0
○ETS32-420FA5/(⁵¹⁶ / ₅₁₅)-413	3.0				○ETS32-422FA5/(⁵¹⁶ / ₅₁₅)-313	3.0			
○ETS32-430FA2/(⁵¹⁶ / ₅₁₅)-433	5.5	"	"	"	○ETS32-434FA2/(⁵¹⁶ / ₅₁₅)-333	5.5	"	"	"
○ETS32-430FA5/(⁵¹⁶ / ₅₁₅)-433	3.0				○ETS32-434FA5/(⁵¹⁶ / ₅₁₅)-333	3.0			
○ETS32-432FA2/(⁵¹⁶ / ₅₁₅)-453	5.5	"	"	"	○ETS32-433FA2/(⁵¹⁶ / ₅₁₅)-353	5.5	"	"	"
○ETS32-432FA5/(⁵¹⁶ / ₅₁₅)-453	3.0				○ETS32-433FA5/(⁵¹⁶ / ₅₁₅)-353	3.0			
●ETS32-420FA3/(⁵¹⁶ / ₅₁₅)-413	5.5	"	"	"	●ETS32-422FA3/(⁵¹⁶ / ₅₁₅)-313	5.5	"	"	"
●ETS32-430FA3/(⁵¹⁶ / ₅₁₅)-433	"	"	"	"	●ETS32-434FA3/(⁵¹⁶ / ₅₁₅)-333	"	"	"	"
●ETS32-432FA3/(⁵¹⁶ / ₅₁₅)-453	"	"	"	"	●ETS32-433FA3/(⁵¹⁶ / ₅₁₅)-353	"	"	"	"

GATHERING

Machine type/spec.	Foot lift(e)	Feed lift	Gap (a)	Gap (b)	Machine type/spec.	Foot lift(e)	Feed lift	Gap (a)	Gap (b)
○ETS32-542FD2/ ⁵¹⁶ / ₍₅₁₅₎ -453/KL100	5.5	5.5	2.0	1.0	○ETS32-544FD2/ ⁵¹⁶ / ₍₅₁₅₎ -353/KL100	5.5	5.5	2.0	1.0
○ETS32-542FD5/ ⁵¹⁶ / ₍₅₁₅₎ -453/KL100	3.0				○ETS32-544FD5/ ⁵¹⁶ / ₍₅₁₅₎ -353/KL100	3.0			
●ETS32-542FD3/ ⁵¹⁶ / ₍₅₁₅₎ -453/KL100	5.5	"	"	"	●ETS32-544FD3/ ⁵¹⁶ / ₍₅₁₅₎ -353/KL100	5.5	"	"	"

PIPING

Machine type/spec.	Foot lift(e)	Feed lift	Gap (a)	Gap (b)	Machine type/spec.	Foot lift(e)	Feed lift	Gap (a)	Gap (b)
○ETS32-432FC2/ ^{P1} / _{P2} / ⁵¹⁶ / ₍₅₁₅₎ -453	5.5	5.5	2.0	3.0	ETS32-433FC2/ ^{P1} / _{P2} / ⁵¹⁶ / ₍₅₁₅₎ -333	5.5	5.5	2.0	3.0

PRESSER FOOT AND TOP FEED HEIGHTS-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Foot lift(e)	Feed lift	Gap (a)	Gap (b)
○ETS32-430BA2/ ⁵¹⁶ / ₍₅₁₅₎ -433	6.0	6.0	2.0	1.0
○ETS32-432BA2/ ⁵¹⁶ / ₍₅₁₅₎ -453	"	"	"	"

SEAMING/HEAVY

Machine type/spec.	Foot lift(e)	Feed lift	Gap (a)	Gap (b)
○ETS32-452BA2/ ⁵¹⁶ / ₍₅₁₅₎ -433	6.0	6.0	2.5	0.5
■ETS32-452BA4/ ⁵¹⁶ / ₍₅₁₅₎ -433	7.0	"	2.0	1.0
○ETS32-453BA2/ ⁵¹⁶ / ₍₅₁₅₎ -453	6.0	"	2.5	0.5
■ETS32-453BA4/ ⁵¹⁶ / ₍₅₁₅₎ -453	7.0	"	2.0	1.0

PIPING

Machine type/spec.	Foot lift(e)	Feed lift	Gap (a)	Gap (b)
○ETS32-432BC2/ ^{P1} / _{P2} / ⁵¹⁶ / ₍₅₁₅₎ -453	6.0	6.0	2.0	1.0

- = Normal presser foot
- = Narrow presser foot
- = Tractor foot

HEIGHT OF UPPER KNIFE HOLDER-FRONT TOP FEED ETS32

Table 17

EXTRA-HIGH LIFT		HIGH LIFT	
GENERAL SEAMING			
Machine type/spec.	Height (b)	Machine type/spec.	Height (b)
○ETS32-420FA2/ $\frac{516}{515}$ -413	20.0	○ETS32-422FA2/ $\frac{516}{515}$ -313	19.5
○ETS32-420FA5/ $\frac{516}{515}$ -413		○ETS32-422FA5/ $\frac{516}{515}$ -313	
○ETS32-430FA2/ $\frac{516}{515}$ -433	"	○ETS32-434FA2/ $\frac{516}{515}$ -333	"
○ETS32-430FA5/ $\frac{516}{515}$ -433		○ETS32-434FA5/ $\frac{516}{515}$ -333	
○ETS32-432FA2/ $\frac{516}{515}$ -453	"	○ETS32-433FA2/ $\frac{516}{515}$ -353	"
○ETS32-432FA5/ $\frac{516}{515}$ -453		○ETS32-433FA5/ $\frac{516}{515}$ -353	
●ETS32-420FA3/ $\frac{516}{515}$ -413	"	●ETS32-422FA3/ $\frac{516}{515}$ -313	"
●ETS32-430FA3/ $\frac{516}{515}$ -433	"	●ETS32-434FA3/ $\frac{516}{515}$ -333	"
●ETS32-432FA3/ $\frac{516}{515}$ -453	"	●ETS32-433FA3/ $\frac{516}{515}$ -353	"

GATHERING

Machine type/spec.	Height (b)	Machine type/spec.	Height (b)
○ETS32-542FD2/ $\frac{516}{515}$ -453/KL100	20.0	○ETS32-544FD2/ $\frac{516}{515}$ -353/KL100	19.5
○ETS32-542FD5/ $\frac{516}{515}$ -453/KL100		○ETS32-544FD5/ $\frac{516}{515}$ -353/KL100	
●ETS32-542FD3/ $\frac{516}{515}$ -453/KL100	"	●ETS32-544FD3/ $\frac{516}{515}$ -353/KL100	"

PIPING

Machine type/spec.	Height (b)	Machine type/spec.	Height (b)
○ETS32-432FC2/ $\frac{P1}{P2} \frac{516}{515}$ -453	20.0	○ETS32-433FC2/ $\frac{P1}{P2} \frac{516}{515}$ -333	19.5

HEIGHT OF UPPER KNIFE HOLDER-REAR TOP FEED ETS32

GENERAL SEAMING

Machine type/spec.	Height (b)
○ETS32-430BA2/ $\frac{516}{515}$ -433	20.0
○ETS32-432BA2/ $\frac{516}{515}$ -453	"

SEAMING/HEAVY

Machine type/spec.	Height (b)
○ETS32-452BA2/ $\frac{516}{515}$ -433	20.0
■ETS32-452BA4/ $\frac{516}{515}$ -433	"
○ETS32-453BA2/ $\frac{516}{515}$ -453	"
■ETS32-453BA4/ $\frac{516}{515}$ -453	"

PIPING

Machine type/spec.	Height (b)
○ETS32-432BC2/ $\frac{P1}{P2} \frac{516}{515}$ -453	20.0

○ = Normal presser foot
 ● = Narrow presser foot
 ■ = Tractor foot