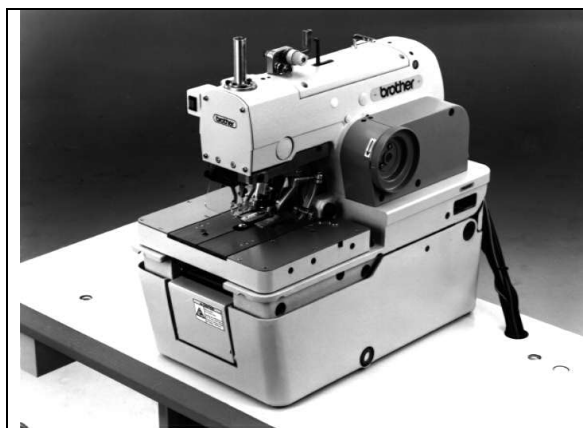


# RH-9800

## Electronic Eyelet Button Holer



### Specifications

Specifications	-00	-01	-02
Main use	Men's clothes and ladies' clothes		Jeans and work clothes
Sewing speed	1,000–2,000 rpm (100-rpm steps)		
Buttonhole length	10 – 50mm	10 – 38 mm	L1: 14 – 18 mm L5: 28 – 32 mm L2: 18 – 22 mm L6: 32 – 36 mm L3: 22 – 26 mm L7: 36 – 40 mm L4: 26 – 30 mm
Stitch length	0.5 – 2.0 mm (0.1 mm steps)		
Stitch width	1.5 – 3.2 mm		
Tacking length	0 mm, 3 – 43 mm (1 mm steps)		
Cloth presser height	12 mm		16 mm
Stitch shape changing	Selected by a program		
Cut timing selection	Selected by a switch		
Starting method	Dual switch (cloth presser switch and start switch) or single switch		
Feed method	Intermittent feed by three pulse motors (X, Y, θ)		
Needle	DO × 558 #80 – #120 (Schmetz)		
Safety equipment	Built-in emergency stop function and automatic stopping device which stops the machine when the safety circuit is activated.		
Air pressure	Main regulator: 0.49 Mpa Knife pressure regulator: 0.3 Mpa		
Air consumption	43.2 l / min (8 cycle / min)		
Noise level	81 dB at max. speed of 2,000 rpm, measured according to ISO 10821		
Dimensions	1,200 mm (W) × 590 mm (D) × 1,120 mm (H)		
Work table legs	T-shaped height-adjustable type		
Power supply	Single-phase 110, 200, 220, 230, 240 V Three phase 220, 380, 415 V Max. electric power consumption: 1kVA		
Weight	175 kg		

## Device for each sub-class

RH-9800-

		Upper thread trimmer	Lower thread trimmer		Upper thread nipper*2	Fly indexer	Upper gimp guide	Circular stitching buttonhole set	Round bar tacking set	Special lapel cutting device
			Long	Short						
00	Standard bar tacking / eyelet buttonhole with taper bar	○	—	—	Option*2	—	Option*2	Option	Option	Option *3
01		○	○	—	Option*2	—	Option*2	Option	Option	Option *3
02		○	—	○*1	Option	Option	—	—	—	—
03		○	—	—	○	—	—	—	—	—
04		○	○	—	○	—	—	—	—	—
05		○	—	○*1	○	Option	—	—	—	—
12	Straight bar tacking	○	—	○*1	Option	—	—	—	—	—
15		○	—	○*1	○	—	—	—	—	—
52	Eyelet button hole with taper bar	○	—	○*1	Option	○	—	—	—	—
55	Eyelet button hole (with fly indexer)	○	—	○*1	○	○	—	—	—	—

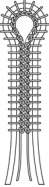
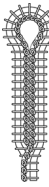
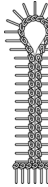
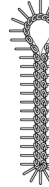
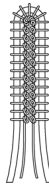
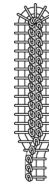
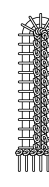
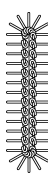
\*1 If using the lower thread trimmer (short type), please specify the buttonhole length when ordering.

There is 10 mm of difference in the knife installation positions between L1 – L4 and L5 – L7.

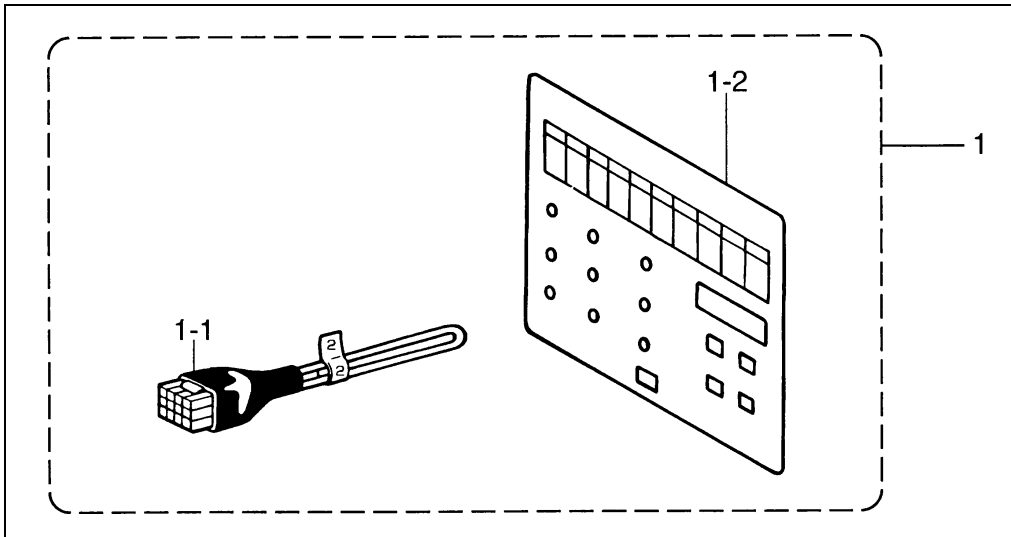
\*2 The upper thread nipper cannot be used in conjunction with the upper gimp guide.

\*3 The special lapel cutting device can be used only when the feed bracket is set to the front position.

## Sewing shape

Eyelet buttonhole				Straight buttonhole			
Eyelet buttonhole	Eyelet Buttonhole with taper	With straight bar tack	With round bar tack	Straight buttonhole	Straight buttonhole with taper	With straight bar tack	With round bar tack
							


## Round bar tacker set



Ref. No.	Part name	Part code		
1	Round bar tacker set	S45195-000		
1-1	Harness	S44954-000		
1-2	Panel sheet	S44953-000		
	Pressers	Buttonhole length	Pressers	Buttonhole length
	L1	16 – 19 mm	L5	30 – 33 mm
	L2	20 – 23 mm	L6	34 – 37 mm
	L3	24 – 27 mm	L7	38 – 41 mm
	L4	28 – 31 mm		

\*When a short thread trimmer is attached, each presser is designated as L1–L4 according to the stitch length. Use the appropriate presser as per the table above.

## Circular stitching set

Sewing shape	Outer diameter of circular stitching	Presser harness
	-10 mm	-
	-12 mm	Presser harness D13 S41506-000

## Exchange parts set

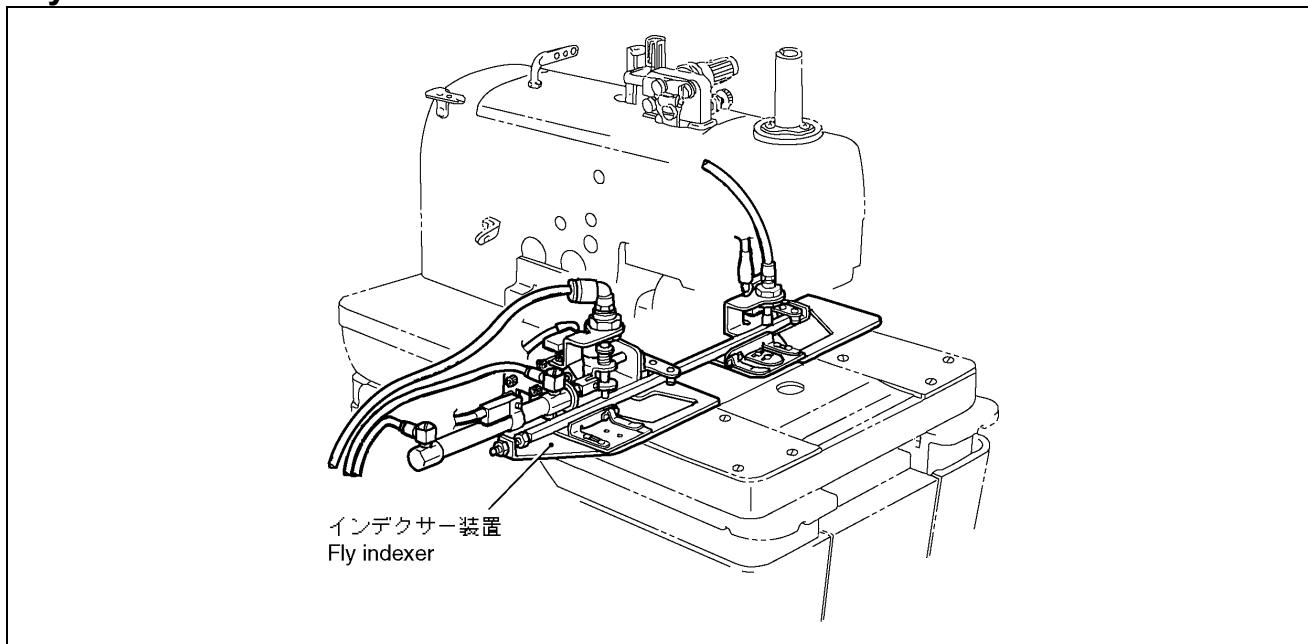
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Stitching diameter (mm)	Parts set	Contents
2	Exchange parts set D2 (-00) S42174-001	Cloth presser set D11 (-00) S43934-001
		Knife (D2) S41346-001
		Hammer (D3) S41344-001
3	Exchange parts set D3 (-00) S41998-001	Cloth presser set D11 (-00) S43934-001
		Knife (D3) S41347-001
		Hammer (D3) S41344-001
4	Exchange parts set D4 (-00) S42175-001	Cloth presser set D13 (-00) S43935-001
		Knife (D4) S41348-001
		Hammer (D5) S41345-001
5	Exchange parts set D5 (-00) S41999-001	Cloth presser set D13 (-00) S43935-001
		Knife (D5) S41349-001
		Hammer (D5) S41345-001

## For - 01

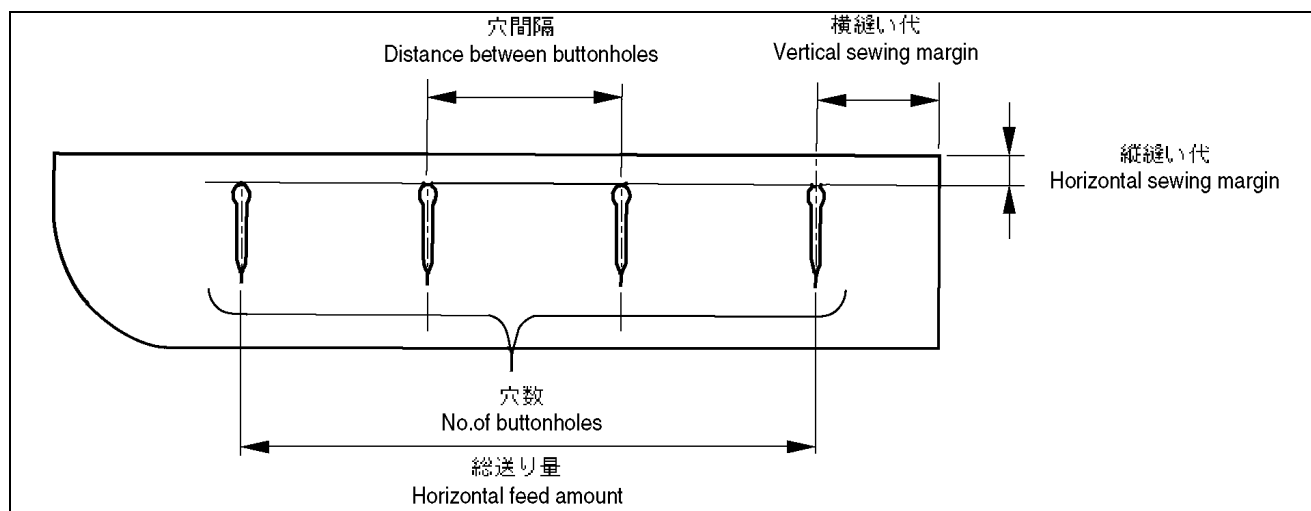
Stitching diameter (mm)	Parts set	Contents
2	Exchange parts set D2 (-01) S42176-001	Cloth presser set D11 (-01) S43936-001
		Knife (D2) S41346-001
		Hammer (D3) S41344-001
3	Exchange parts set D3 (-01) S42000-001	Cloth presser set D11 (-01) S43936-001
		Knife (D3) S41347-001
		Hammer (D3) S41344-001
4	Exchange parts set D4 (-01) S42177-001	Cloth presser set D13 (-01) S43937-001
		Knife (D4) S41348-001
		Hammer (D5) S41345-001
5	Exchange parts set D5 (-01) S42001-001	Cloth presser set D13 (-01) S43937-001
		Knife (D5) S41349-001
		Hammer (D5) S41345-001

## Option parts Fly indexer



### Specifications

	Standard size	Large size
Applicable specifications	L1 (Buttonhole length : 14 - 18 mm), L2 (Buttonhole length : 18 - 22 mm), L3 (Buttonhole length : 22 - 26 mm), L4 (Buttonhole length : 26 - 30 mm)	L5 (Buttonhole length : 28 - 32 mm), L6 (Buttonhole length : 32 - 36 mm), L7 (Buttonhole length : 36 - 40 mm)
Distance between button holes	38.1 mm, 50.8 mm, 44.45 mm	38.1 mm, 50.8 mm, 44.45 mm, 57.15 mm
No. of buttonholes	1 - 4 holes	1 - 6 holes
Horizontal sewing margin	(L1 - L4) 9 - 21 mm, (L5 - L7) 9 - 11 mm	
Vertical sewing margin	30 - 40 mm	
Max. horizontal feed amount	152.4 mm	285.75 mm



### Parts for the standard-sized fly indexer (Conventional parts)

Part name	Part code	Applicable specifications	Remarks
Fly indexer assy	S42168-101	For L1, L2, L5	Without upper thread nipper
	S42169-101		With upper thread nipper
	S42110-101	For L3, L4, L6, L7	Without upper thread nipper
	S42170-101		With upper thread nipper

\*If the standard-sized fly indexer is used for sewing with a non-standard distance between buttonholes and a non-standard number of buttonholes (up to 9), you need to make additional holes in the cloth feed bar (F) assy (optional part). For this processing, refer to the instruction manual supplied with this optional part.

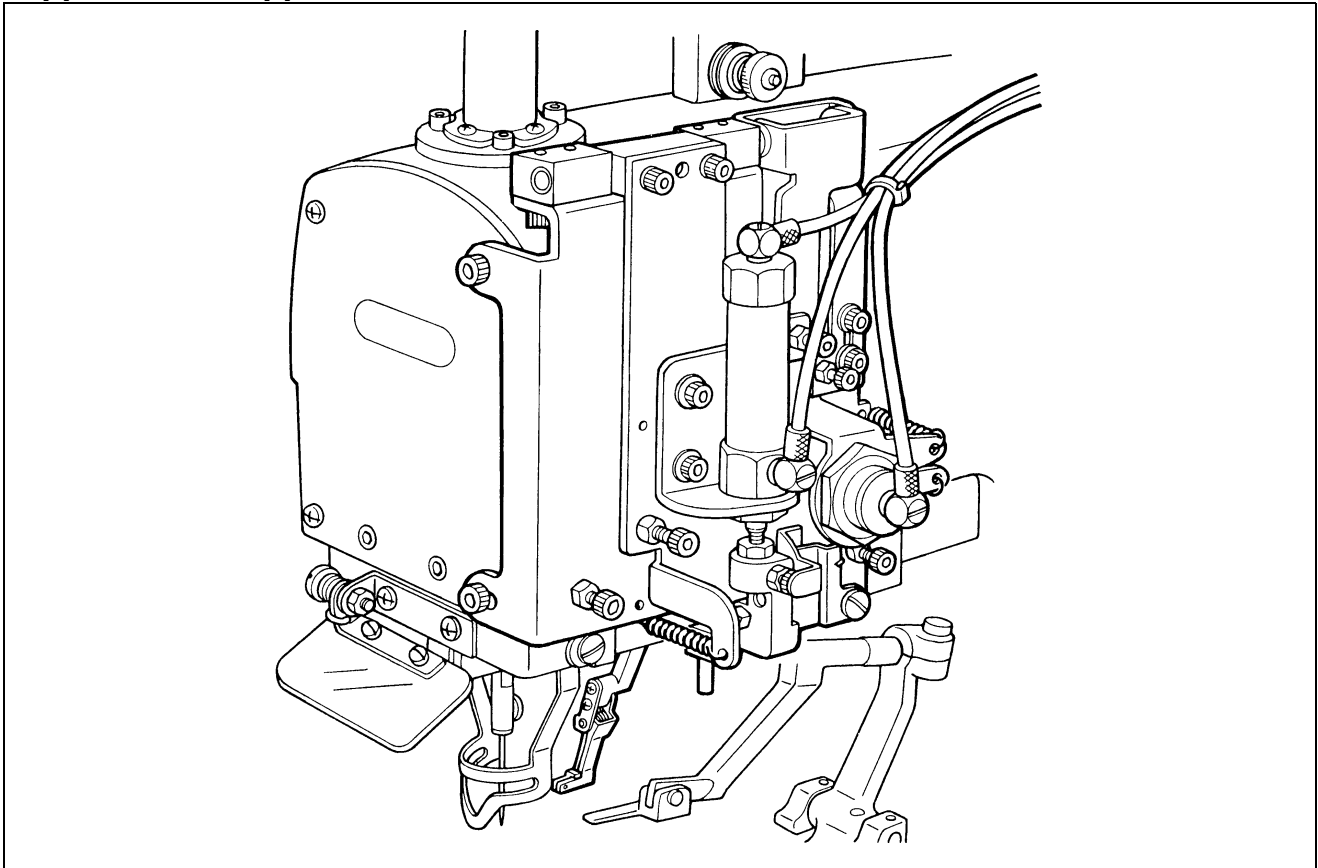
Part name	Part code	Applicable specifications
Cloth feed bar (F) assy (L1, L2)	S45193-101	L1, L2, L5
Cloth feed bar (F) assy (L3, L4)	S45194-101	L3, L4, L6, L7

### Parts for the large-sized fly indexer

Part name	Part code	Applicable specifications	Remarks
Fly indexer (LS) assy	S48329-101	L1, L2, L5	Without upper thread nipper
Fly indexer (LL) assy	S48334-101	L3, L4, L6, L7	

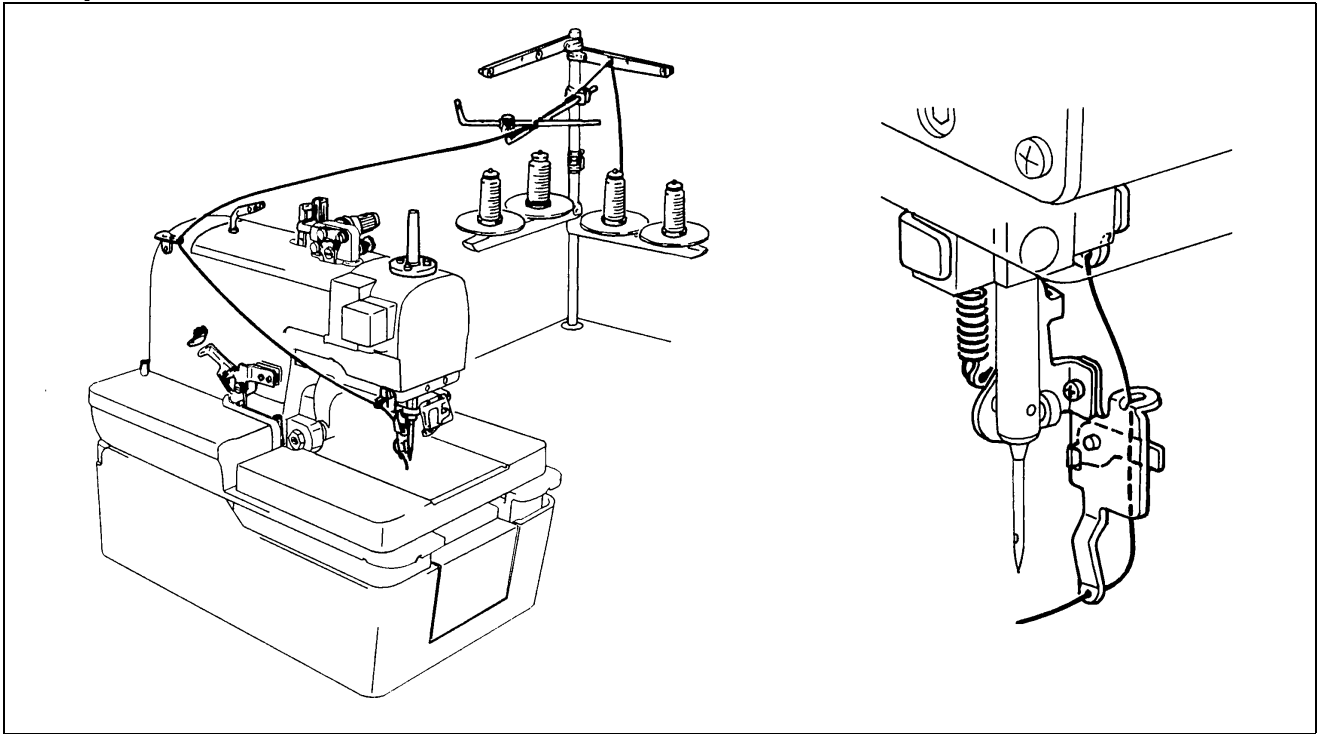
\*There are only four types of the distances between buttonholes for large-sized fly indexer.

**Option parts**  
**Upper thread nipper**



Part name	Part code	Q'ty
Thread nipper device set	S43406-301	1

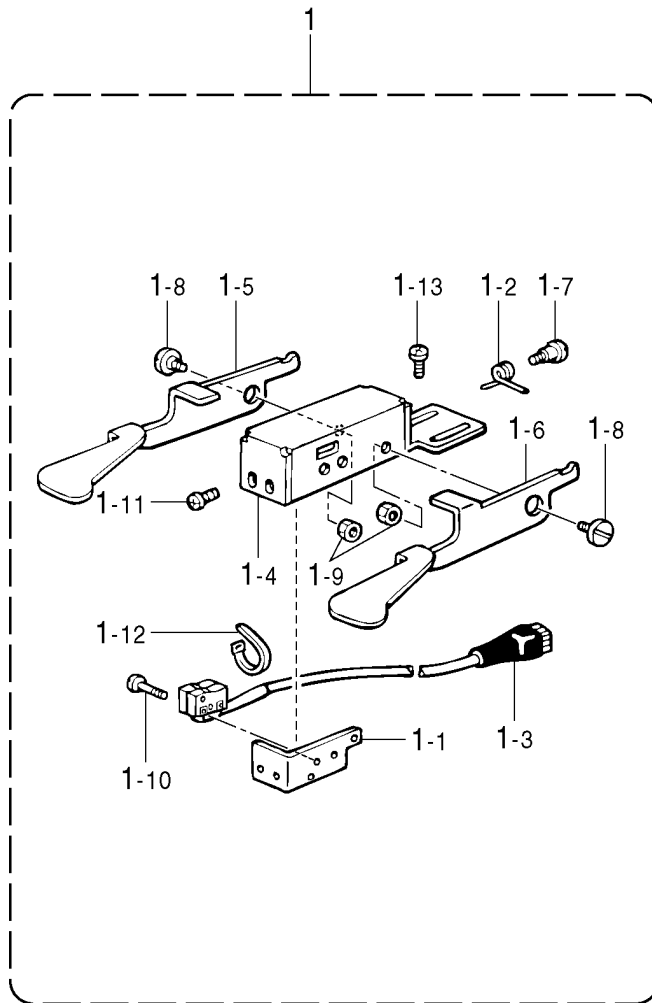
**Option parts  
Gimp device**



Parts set	Contents
Upper gimp guide set S42656-001	Upper gimp guide set S44503-001
	Cotton stand assy, 4DTHF S29854-109



**Option parts**  
**Hand start switch**



Ref. No.	Part name	Part code	Q'ty
1	Hand start switch assy	S39909-001	1
1-1	Switch set plate	S39913-001	1
1-2	Switch lever spring	S39914-001	1
1-3	Hand switch	S39915-000	1
1-4	Switch cover	S39910-001	1
1-5	Switch lever (L)	S39911-001	1
1-6	Switch lever (R)	S39912-001	1
1-7	Stud screw, M4	S34922-101	1
1-8	Stud screw, M4	S34966-001	2
1-9	Nut, 2M4	012400-202	3
1-10	Screw, M2.38	146124-001	2
1-11	Screw, bind M3 × 6	060300-616	2
1-12	Band PLTIM	S04557-000	1
1-13	Screw, bind M4 × 8	060400-816	2

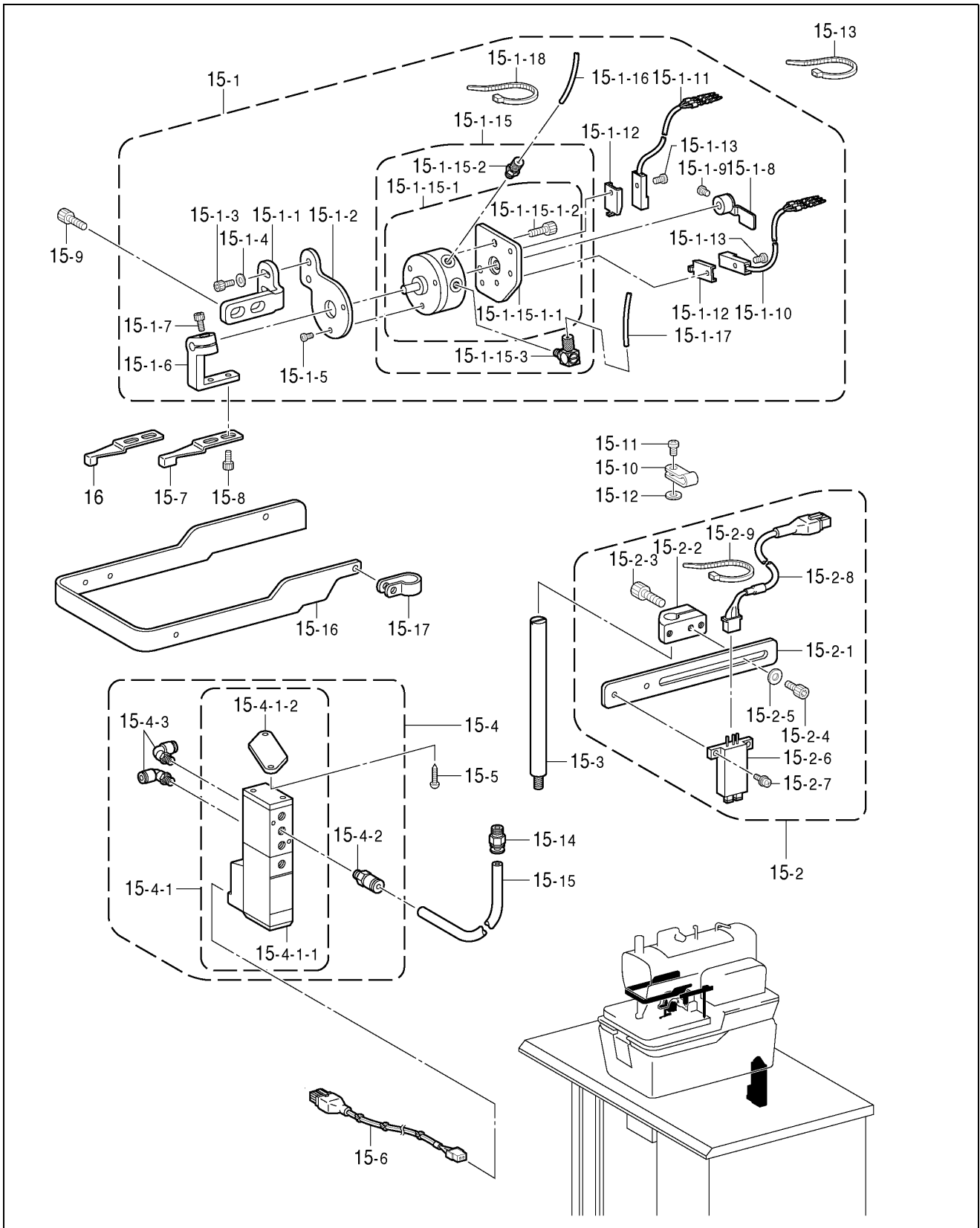
## Special lapel cutting device

\*When sewing straight buttonholes, needle rotates 6 mm in front of the tip of the eyelet buttonhole knife, so that the seam length for straight buttonholes will be as shown in the table.

\*The standard hammers are 5 mm and 7 mm.

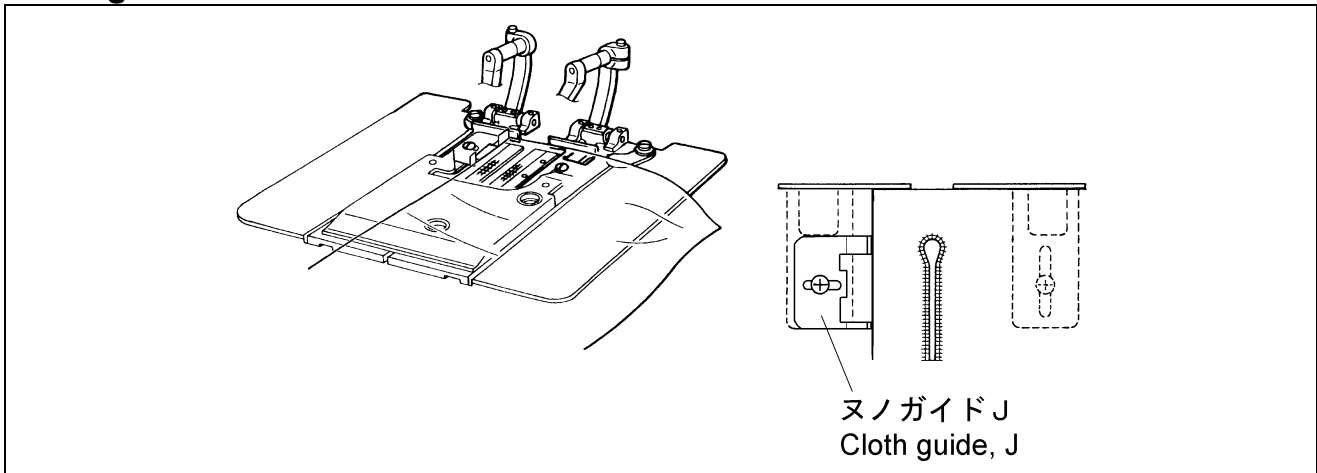
\*The special lapel cutting device can be used only when the feed bracket is set to the front position.

Specifications	Eyelet buttonhole	Straight buttonhole
RH-9800-00	10 – 50 mm	10 – 44 mm
RH-9800-01	10 – 38 mm	10 – 32 mm
RH-981A-00	5 – 50 mm	5 – 44 mm
RH-981A-01	5 – 38 mm	5 – 32 mm



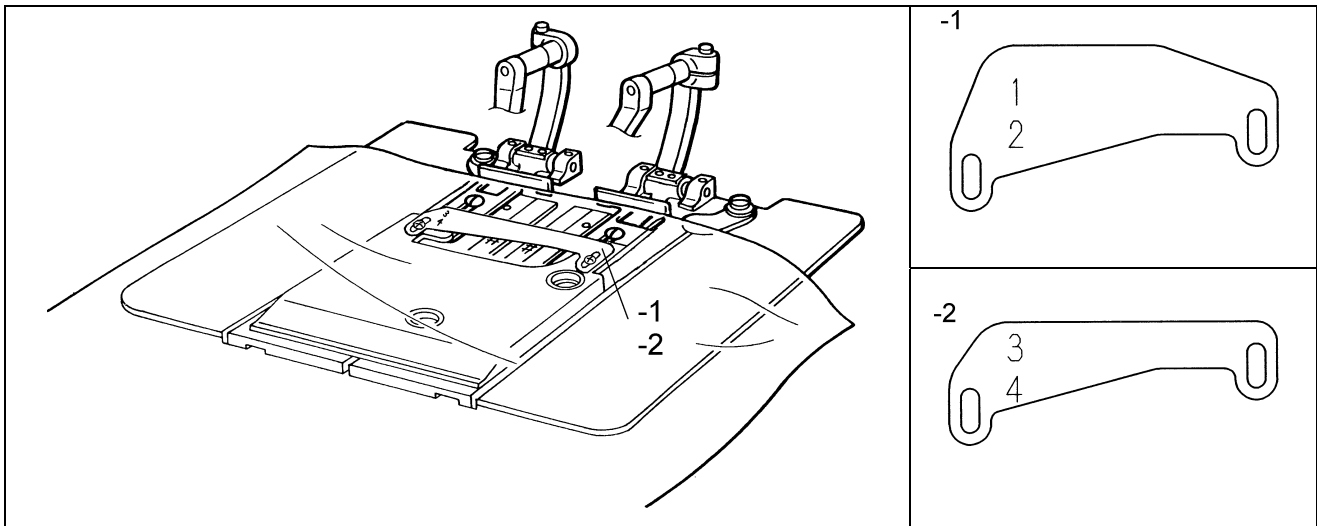
Ref. No.	Part name	Part code	Q'ty
15	Special lapel cutting device	S53906-101	1
15-1	Selector assy, hammer	S53907-001	1
15-1-1	Support plate, cylinder	S53908-001	1
15-1-2	Setting plate, cylinder	S53909-001	1
15-1-3	Bolt, socket SM3.57x8	154965-001	2
15-1-4	Washer, plain	105161-004	2
15-1-5	Screw, pan M3x6	062300-605	2
15-1-6	Setting lever, hammer	S53910-001	1
15-1-7	Bolt, socket SM3.57x8	154965-001	1
15-1-8	Partition plate, sensor	S53914-001	1
15-1-9	Set screw, SM3.57-40x4.5	144458-001	1
15-1-10	Sensor, hammer home position	S53915-000	1
15-1-11	Sensor, hammer position	S53916-000	1
15-1-12	Sensor bracket, MS-GL8	S53917-000	2
15-1-13	Screw, pan M3x8	062300-805	2
15-1-15	Rotary cylinder assy	S53918-001	1
15-1-1	Rotary cylinder plate assy	S54026-001	1
15-1-15-1-1	Setting plate, sensor	S53913-001	1
15-1-15-1-2	Bolt, socket M3x16	018301-636	2
15-1-15-2	Throttle tube joint	S19900-000	1
15-1-16	Tube elbow, w/valve	S16603-000	1
15-1-17	Air tube, 4x2.5-60	S53920-000	1
15-1-18	Air tube, 4x2.5-61	S53921-000	1
15-2	Band, PLT1M	S04557-000	1
15-2-	Sensor plate assy, B-hole	S53923-001	1
15-2-1	Setting plate, cloth sensor	S53924-001	1
15-2-2	Y-driving shaft holder	S31568-000	1
15-2-3	Bolt, socket M5x16	018501-622	1
15-2-4	Bolt, socket SM4.37x8	018680-822	2
15-2-5	Washer	100645-003	2
15-2-6	Photo sensor	S53925-000	1
15-2-7	Screw, pan (S/P washer) M3x8	0A4300-805	2
15-2-8	Harness, B-hole sensor	S53926-000	1
15-2-9	Band, PLT1M	S04557-000	1
15-3	Setting shaft, sensor	S53922-001	1
15-4	Valve assy	S53927-000	1
15-4-1	Valve, VZ3120-F	S53928-001	1
15-4-1-1	Valve, VZ3120	S13578-000	1
15-4-1-2	Bracket	S53929-000	1
15-4-2	Half union	S04905-000	1
15-4-3	Elbow union, 4M5	S11426-000	2
15-5	Wood screw, round M3.5x16	032361-602	2
15-6	Valve harness	S53930-000	1
15-7	Hammer plate, 7	S53911-001	1
15-8	Bolt, socket M3x5	018300-536	2
15-9	Bolt, socket M4x8	018400-832	2
15-10	Cord holder, 6N	146202-000	1
15-11	Screw, pan M4x16	062401-616	1
15-12	Washer, plain M6	025060-236	1
15-13	Band, PLT1M	S04557-000	3
15-14	Half union, ;KQH04-01S	S04910-000	1
15-15	Air tube, 4x2.5-62	S53939-000	1
15-16	Cover, H ;N-rotation	S53937-001	1
15-17	Cord holder, 10N	552907-000	1
16	Hammer plate, 5	S53912-001	1

**Option parts**  
**Cloth guide**



Part name	Part code	Q'ty
Cloth guide, J	S37870-000	1

**Movable knife cover**



Ref. No.	Part name	Part code	Q'ty
	<L1, L2, L5, L6>		
1	Movable knife cover, L1-2	S37698-000	1
	<L3, L4, L7>		
2	Movable knife cover, L3-4	S37699-000	1

**For changing to -02 from -01**

Replace with the parts shown in the table below.

L1: 14 - 18 mm	L2: 18 - 22 mm	L3: 22 - 26 mm	L4: 26 - 30 mm
S38572-001	S38573-001	S38574-001	S38575-001
Exchange parts set, L1	Exchange parts set, L2	Exchange parts set, L3	Exchange parts set, L4
S38584-001			
Exchange parts set, -2			

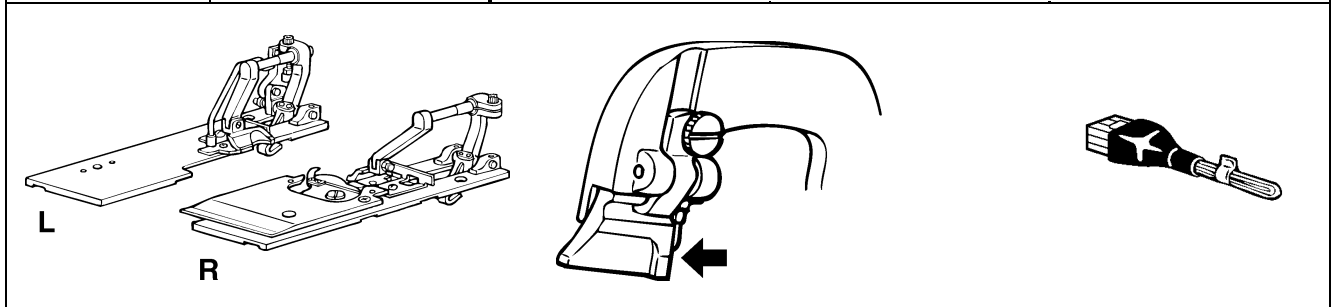
L2: 28 - 32 mm	L3: 32 - 36 mm	L4: 36 - 40 mm
S41467-00	S41468-001	S41469-001
Exchange parts set, L5	Exchange parts set, L6	Exchange parts set, L7
S38584-001		
Exchange parts set, -2		

## Replacement parts list for specification changes

The sewing machine can be changed to any one of L1 to L7 for -02 and -52 specifications by replacing the specified parts with the appropriate parts given below.

### -02 specifications

Specifications (buttonhole length)	Replacement parts set	Plate R assembly Plate L assembly	Hammer	Specification harness
L1 (14 - 18mm)	S38572-001	S38576-301 S38577-201	S37702-001 (S12) S37704-001 (S16)	S37869-100
L2 (18 - 22mm)	S38573-001	S38578-301 S38579-201	S37704-001 (S16) S37706-001 (S20)	S37871-000
L3 (22 - 26mm)	S38574-001	S38580-301 S38581-201	S37706-001 (S20) S37708-001 (S24)	S37872-100
L4 (26 - 30mm)	S38575-001	S38582-301 S38583-201	S37708-001 (S24) S42053-001 (S28)	S37873-000
L5 (28 - 32mm)	S41467-001	S41470-101 S41471-101	S37197-001 (26) S37199-001 (30)	S41476-000
L6 (32 - 36mm)	S41468-001	S41472-101 S41473-101	S37199-001 (30) S37201-001 (34)	S41477-000
L7 (36 - 40mm)	S41469-001	S41474-101 S41475-101	S37201-001 (34) S35093-001 (38)	S41478-000



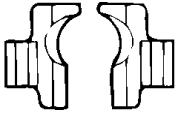
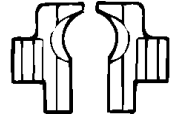
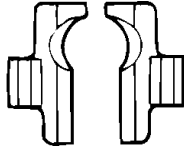
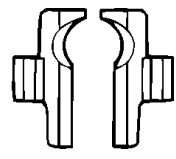
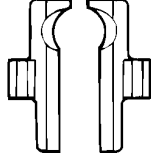
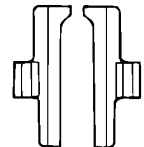
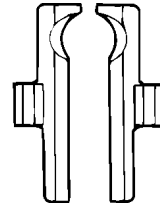
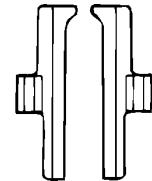
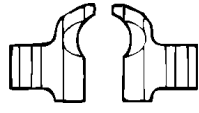
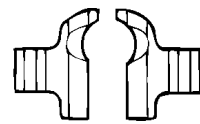
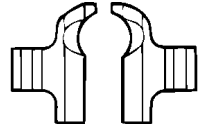
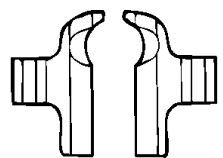
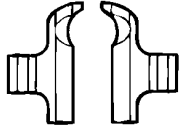
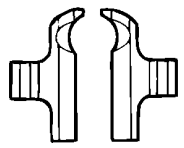
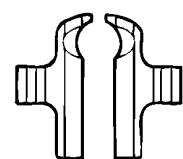
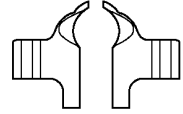
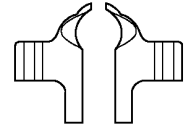
**Note:** There is 10 mm of difference in the knife cutting position between L1 – L4 and L5 – L7 specifications.

### -52 specifications

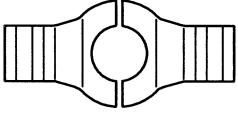
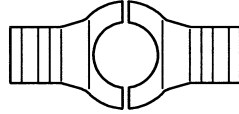
Specifications (buttonhole length)	Plate R assembly Plate L assembly	Hammer	Cloth feed plate R
L1 (14 - 18mm)	S38576-301 S38577-201	S37702-001 (S12) S37704-001 (S16)	S43809-001
L2 (18 - 22mm)	S38578-301 S38579-201	S37704-001 (S16) S37706-001 (S20)	S43809-001
L3 (22 - 26mm)	S38580-301 S38581-201	S37706-001 (S20) S37708-001 (S24)	S42139-101
L4 (26 - 30mm)	S38582-301 S38583-201	S37708-001 (S24) S42053-001 (S28)	S42139-101
L5 (28 - 32mm)	S41470-101 S41471-101	S37197-001 (26) S37199-001 (30)	S43809-001
L6 (32 - 36mm)	S41472-101 S41473-101	S37199-001 (30) S37201-001 (34)	S42139-101
L7 (36 - 40mm)	S41474-101 S41475-101	S37201-001 (34) S35093-001 (38)	S42139-101

**Note:** There is 10 mm of difference in the knife cutting position between L1 – L4 and L5 – L7 specifications.

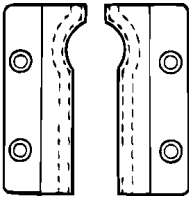
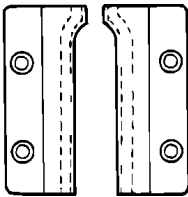
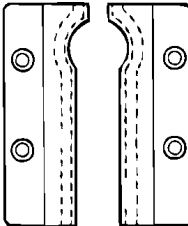
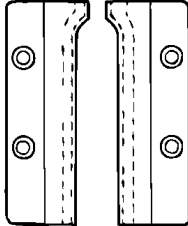
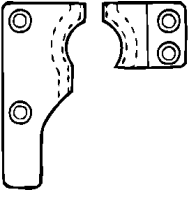
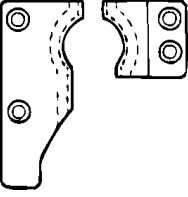
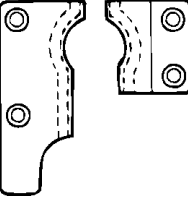
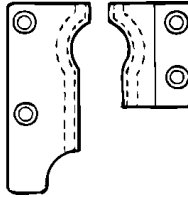
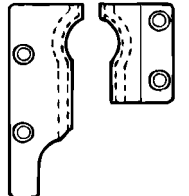
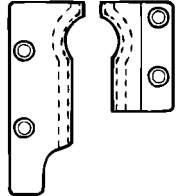
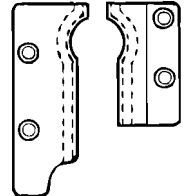
**Gauge parts list**  
**(For -00, -01, -02) Work clamp**

L	S35455-001	S39929-001	S35197-001	S39931-001	
R	S35454-001	S39930-001	S35198-001	S39932-001	
-00 & -01	<10 – 18 mm>	<18 – 22 mm>	<22 – 26 mm>	<26 – 30 mm>	
					
	S35453-001	S35200-101	S37679-001	S37677-101	
	S35452-001	S35199-101	S37680-001	S37678-101	
	<26 – 38 mm>	<38 mm>	<50 mm>	<50 mm>	
					
L	S37755-001	S37689-001	S37691-001	S37759-001	
R	S37754-001	S37690-001	S37692-001	S37758-001	
-02	L1 <14 – 18 mm>	L2 <18 – 22 mm>	L3 <22 – 26 mm>	L4 <26 – 30 mm>	
					
	S41848-001	S41486-101	S41488-001	S43408-001	S43410-001
	S41483-001	S41485-101	S41487-001	S43409-001	S43411-001
	L5 <28 – 32 mm>	L6 <32 – 36 mm>	L7 <36 – 40 mm>	L3W <22 – 26 mm>	L4W <26 – 30 mm>
					
<For waist belt presser>					

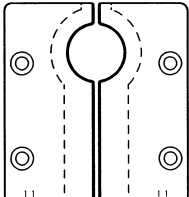
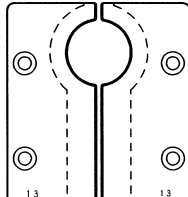
**For circular stitching work clamp**

R & L	S41336-001	S41337-001
	D11 < – 10 mm>	D13 < – 12 mm>
-00 & -01		

**Gauge parts list**  
**Needle plate**

L	S35308-101 (L)	S35307-101 (SL)	S37683-101 (L-50)	S37681-101 (SL-50)
R	S35309-101 (R)	S35306-101 (SR)	S37684-101 (R-50)	S37682-101 (SR-50)
-00 & -01	<38 mm> 	<38 mm> 	<50 mm> 	<50 mm> 
	L S37643-101 (L1L)	S37645-101 (L2L)	S37647-101 (L3L)	S37649-101 (L4L)
R	S37644-101 (L1R)	S37646-101 (L2R)	S37648-101 (L3R)	S37650-101 (L4R)
-02	L1 <14 - 18 mm> 	L2 <18 - 22 mm> 	L3 <22 - 26 mm> 	L4 <26 - 30mm> 
	S40823-001 (L5L)	S41480-001 (L6L)	S41482-001 (L7L)	
	S40822-001 (L5R)	S41479-001 (L6R)	S41481-001 (L7R)	
	L5 <28 - 32 mm> 	L6 <32 - 36 mm> 	L7 <36 - 40 mm> 	

**For circular stitching needle plate**

L	S41339-001	S41341-001
R	S41338-001	S41340-000
-00 & -01	D11 <- 10 mm> 	D13 <- 12 mm> 

## Gauge parts list

### Knife

S35439-101 <38 mm>	S35437-101 <38 mm>	S35480-101 <38 mm>	S35482-101 <38 mm>	S35408-101 (S) <38 mm>
S35438-101 <50 mm>	S35436-101 <50 mm>	S35481-101 <50 mm>	S35483-101 <50 mm>	S35409-101 (S) <50 mm>

### For circular stitching knife

S41346-001 <D2>	S41347-001 <D3>	S41348-001 <D4>	S41349-001 <D5>

### Hammer

-00 & -01	Size (mm)	10	12	14	16
	Part code	S37211-001	S37210-001	S37209-001	S37208-001
	Size (mm)	18	20	22	24
	Part code	S37194-001	S35092-001	S37195-001	S37196-001
	Size (mm)	26	28	30	32
	Part code	S37197-001	S37198-001	S37199-001	S37200-001
-02	Size (mm)	S10	S12	S14	S16
	Part code	S37701-001	S37702-001	S37703-001	S37704-001
	Size (mm)	S18	S20	S22	S24
	Part code	S37705-001	S37706-001	S37707-001	S37708-001
	Size (mm)	S26	S28		
	Part code	S37709-001	S42053-001		

### For circular stitching hammer

-00 & -01	Size (mm)	φ5 (D2, D3)	φ7 (D4, D5)
	Part code	S41344-001	S41345-001





### Harness

-02	Specification	L1	L2	L3	L4
	Part code	S37869-100	S37871-000	S37872-100	S37873-000
	Specification	L5	L6	L7	
	Part code	S41476-000	S41477-000	S41478-000	


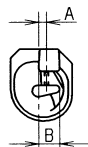


## Gauge parts list

### Double chain stitch looper mechanism

	Eye Looper	Looper, R	Spreader, L	Spreader, R
Use				
Standard	S35411-001	S35410-001	S35413-101	S35412-101
For heavy	S35471-001		S35472-101	
For single chain stitch	S49078-001		S49079-001	

## Throat plate

	Throat plate
Use	 
For -00 and -01	A = 1.8 mm B = 4.6 mm S47033-001
For -00 and -01 (For small hole)	A = 1.8 mm B = 4.6 mm S47034-001
For -02	A = 1.8 mm B = 4.6 mm S37752-001
For straight bar tack	A = — B = 4.6 mm S39923-101