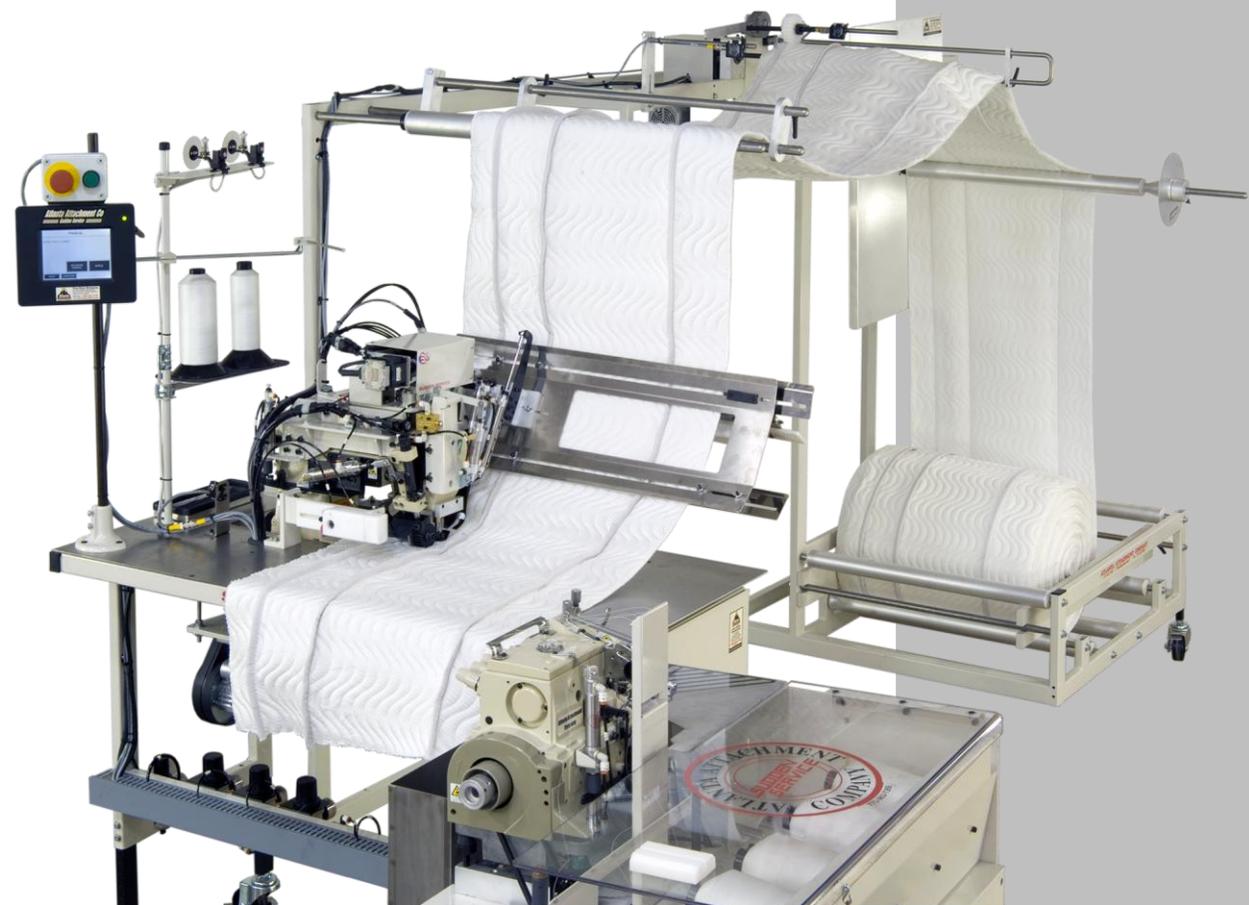




Model **1335MGB**

Revision 4 Updated Aug 22, 2012

Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

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IMPORTANT

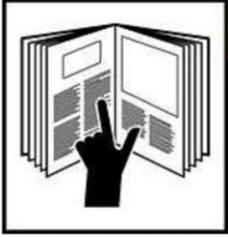
It is important to read and understand the information contained within this manual before attempting to operate the machine. Atlanta Attachment Co., Inc. shall not be held liable for damage resulting from misuse of the information presented within, and reserves the right to change the information contained within, without prior notification.

Contents

Important Safety Instruction	1
Liability	2
Safety Equipment on the Machines	3
Protective Eyewear	4
Important Notices.....	5
Maintenance	7
Repair	8
A Word to the End User.....	9
Safety Precautions.....	9
General Machine Data	10
Electrical & Pneumatic Specifications.....	10
Installation & Setup	10
Operating Instructions.....	11
Touch Screen Operation	11
Machine Operation.....	21
Stepper Control Box	22
Efka Control Box	22
Basic Machine Operation.....	22
Loading the Gusset Roll and Unwinder.....	22
Loading and Adjusting the Folder	23
Adjusting the Edge Guide	23
Loading the Panel and Border/Gusset.....	23
Sewing the Panel with Rounded Corners.....	23
Sewing the Panel with Straight Corners	23
Adjusting the Corner Ruffles	24
Adjusting the Corner Stop Count.....	24
Finishing the Panel.....	24
Sewing in Border Mode	24
Efka Control Box Settings	24
Initial Set-Up of Border Mode:.....	25
General Machine Adjustments.....	25
Air Pressure.....	25
Sewing Head	25
Ruffler Drive.....	25
Unwinder Assembly.....	26
General Machine Maintenance	26

Daily.....	26
Weekly	26
Electric Eye Sensor Adjustment	26
Reflective Tape Maintenance	26
Parameter Settings for Efka Controller.....	27
1335M Folder Spacer Reference Chart.....	28
Assembly Drawings & Parts Lists	30
11335MGBA-UW Border Frame Ruffler.....	32
Page 3200PMD Marking Module Assembly.....	32
1335145 Unwinder Assembly.....	34
1335575 Roll Holder Assembly.....	36
1335764 Base Console Assembly.....	38
1335500 Stand & Motor Assembly	40
1335505 Stripper Blade Assembly	42
1335697 Ruffler Assembly.....	44
1335298 Ruffler Mount Assembly	46
1335690 Ruffler Cylinder Lift Assembly	48
1335M-2300B Pivot Assembly.....	50
1335762 Sewing Head Assembly	52
1335370 Control Box Assembly.....	54
1335271 Foot Pressure Assembly.....	55
3200PMD Marking Module Assembly.....	56
1335426 Puller Lift Assembly	58
1335750 Puller Assembly	60
1335659 Guide Roller Assembly.....	62
1335674 Encoder Assembly	64
A-2216W56 Folder Assembly	66
3200PME Marking Module Assembly	68
33008708 Ball Bearing Disc Assembly	69
1335MFB-PD Pneumatic Diagram.....	70
1335MFB18-PD Pneumatic Diagram.....	71
1335MFB-WD Wiring Diagram.....	72
1335MFB18-WD Wiring Diagram.....	73

Important Safety Instruction



This part of the Instruction Material is provided for the safe use of your equipment. It contains important information to help work safely with the unit and describes the dangers inherent in machinery. Some of these dangers are obvious, while others are less evident.

Mandatory Information

All persons operating and/or working on the 1335MGB Border Frame Ruffler should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

- The Instruction Material comprises:
- Safety information
- Operator Instructions
- Electrical and Pneumatic diagrams

And may also include;

- A list of recommended spare parts
- Instruction Manual(s) for components made by other manufacturers
- The layout and installation diagram containing information for installation

Intended Use

Our machines are designed and built in line with the state of the art and the accepted safety rules. However, all machines may endanger the life and limb of their users and/or third parties and be damaged or cause damage to other property, particularly if they are operated incorrectly or used for purposes other than those specified in the Instruction Manual.

Exclusion of Misuse



Non-conforming uses include, for example, using the equipment for something other than it was designed for, as well as operation without duly installed safety equipment. The risk rests exclusively with the end user.

Conforming use of the machine includes compliance with the technical data, information and regulations in all parts of the complete Instruction Material, as well as compliance with the maintenance regulations. All local safety and accident prevention regulations must also be observed.

Liability

The machine should only be operated when in perfect working order, with due regard for safety and the potential dangers, as well as in accordance with the Instruction Material. Faults and malfunctions capable of impairing safety should be remedied immediately. We cannot accept any liability for personal injury or property damage due to operator errors or non-compliance with the safety instructions contained in this booklet. The risk rests exclusively with the end user.

The Instruction Material should always be kept near the machine so that it is accessible to all concerned.

The local, general, statutory and other binding regulations on accident prevention and environmental protection must also be observed in addition to the Instruction Material. The operating staff must be instructed accordingly. This obligation also includes the handling of dangerous substances and provision/use of personal protective equipment.

The Instruction Material should be supplemented by instructions, including supervisory and notification duties with due regard for special operational features, such as the organization of work, work sequences, the personnel deployed, etc.

The personnel's awareness of the dangers and compliance with the safety regulations should be checked at irregular intervals.

Choice and Qualification of Personnel

Ensure that work on the machine is only carried out by reliable persons who have been appropriately trained for such work - either within the company, by our field staff or at our office - and who have not only been duly appointed and authorized, but are also fully familiar with the local regulations. Work on the machine should only be carried out by skilled personnel, under the management and supervision of a duly qualified engineer.

This not only applies when the machine is used for production, but also for special work associated with its operation (start-up and maintenance), especially when it concerns work on the hydraulic or electrical systems, as well as on the software/serial bus system.

Training

Everyone working on or with the machine should be duly trained and informed with regard to correct use of the safety equipment, the foreseeable dangers which may arise during operation of the machine and the safety precautions to be taken. In addition, the personnel should be instructed to check all safety mechanisms at regular intervals.

Responsibilities

Clearly define exactly who is responsible for operating, setting-up, servicing and repairing the machine. Define the responsibilities of the machine operator and authorize him to refuse any instructions by third parties if they run contrary to the machine's safety. This applies in particular for the operators of machines linked to other equipment. Persons receiving training of any kind may only work on or with the machine under the constant supervision of an experienced operator. Note the minimum age limits permitted by law.

A Word to the Operator

The greatest danger inherent in our machines: is that of fingers, hands or loose clothing being drawn into a machine by live, coasting or rotating tools or assemblies or of being cut by sharp tools or burned by hot elements.

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines



All machines are delivered with safety equipment, which shall not be removed or bypassed during operation.

The correct functioning of safety equipment on machines and systems should be checked every day and before every new shift starts, after maintenance and repair work, when starting up for the first time and when restarting (e.g. after prolonged shutdowns).

If safety equipment has to be dismantled for setting-up, maintenance or repair work, such safety equipment shall be replaced and checked immediately upon completing the maintenance or repair work. All protective mechanisms shall be fitted and fully operational whenever the machine is at a standstill or if it has been shut down for a longer period of time.

Damage

If any changes capable of impairing safety are observed in the machine or its mode of operation, such as malfunctions, faults or changes in the machine or tools, appropriate steps must be taken immediately, the machine switched off and a proper lockout tagout procedure followed. The machine should be examined for obvious damage and defects at least once per shift. Damage found shall be immediately remedied by a duly authorized person before resuming operation of machine.

The machine should only be operated when in perfect working order and when all protective mechanisms and safety equipment, such as detachable protective mechanisms, emergency STOP systems, etc. are in place and operational.

Faults or Errors

The machine must be switched off and all moving or rotating parts allowed to come to a standstill and secured against accidental restart before starting to remedy any faults or errors.

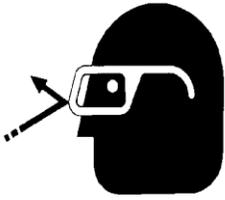
Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.

Clothing, Jewelry, Protective Equipment

Long loose hair, loose-fitting clothes, gloves and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

Protective Eyewear



Protective eyewear that has been tested by the local authorities should be worn whenever there is a possibility of loose or flying objects or particles such as when cleaning the machine with compressed air.

Tools

Always count the number of tools in your possession before starting work on the machine. This will allow you to check that no tools have been left behind inside the machine. Never leave a tool in the machine while working.

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

Smoking and open flame (e.g. welding work) should be prohibited in the production area due to the risk of fire and explosions.

Workplace

A clear working area without any obstructions whatsoever is essential for safe operation of the machine. The floor should be level and clean, without any waste.

The workplace should be well lit, either by the general lighting or by local lights.

Emergency STOP

The emergency STOP buttons bring all machine movements to a standstill. Make sure you know exactly where they are located and how they work. Try them out. Always ensure easy access to the nearest emergency STOP button while working on the machine.

First Aid

1. Keep calm even when injured.
2. Clear the operator from the danger zone. The decision of what to do and whether to seek additional assistance rests entirely with you, particularly if someone has been trapped.
3. Give First Aid. Special courses are offered by such organizations as the employers' liability insurance association. Your colleagues should be able to rely on you and vice versa.
4. Call an ambulance. Do you know the telephone numbers for the ambulance service, police and fire service?

Important Notices

Reporting and Fighting Fires

Read the instructions posted in the factory with regard to reporting fires and the emergency exits. Make sure you know exactly where the fire extinguishers and sprinkler systems are located and how they are operated. Pass on the corresponding information to the firemen when they arrive. Ensure there are enough signs to avoid fire hazards.

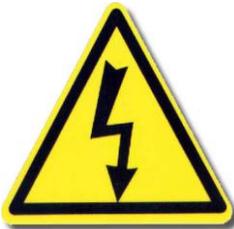
The following fire extinguishers may be used:

- Dry powder extinguishers, ABC fire-extinguishing powder.
- Carbon dioxide fire extinguishers to DIN 14461 for electronic components. Great care must be exercised when using carbon dioxide fire extinguishers in confined, badly ventilated rooms (see DIN 14406 and 14270).

Isolate the machine from the power supply if a fire breaks out. Do not use water on burning electrical parts until it is absolutely certain that they have been completely disconnected from the power supply. Burning oils, lubricants, plastics and coatings on the machine can give off gases and vapors that may be harmful to your health.

A qualified person should be consulted to repair the damage after a fire.

Electrical Power Supply



Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.

In practice, this may mean that the technician, electrician and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.

Energy sources (electrical/pneumatic/hydraulic, etc.) for the equipment shall be turned off or disconnected and the switches locked or labeled with a warning tag. It is the responsibility of the employer to establish control procedures. Follow lockout/tagout procedures before, setup and/or any service or maintenance work is performed, including lubrication, cleaning or clearance of jams.

Caution: The machine is still not completely de-energized even when the master switch is off.

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.
- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

- Kinetic energy - Note that some motors or spindles, for example, may continue to run or coast run on after being switched off.
- Potential energy - Individual assemblies may need to be secured if necessary for repair work.

Delivery of the Machine/Packaging

Note any markings on the packaging, such as weights, lifting points and special information. Avoid temperature fluctuations. Condensation may damage the machine.

Transport Damage

The packaging and machine must immediately be examined for signs of damage in transit. Such damage must be reported to the shipper/transporter within the applicable time limits. Contact Atlanta Attachment Company and/or your transport insurer immediately, if signs of damage are visible. Never operate a damaged machine.

Interim Storage

If the machine has to be stored temporarily, it must be oiled or greased and stored in a dry place where it is protected from the weather in order to avoid damage. A corrosion-inhibiting coating should be applied if the machine has to be stored for a longer period of time and additional precautions taken to avoid corrosion.

Transporting the Machine

Disconnect the machine from all external connections and secure any loose assemblies or parts. Never step under a suspended load. When transporting the machine or assemblies in a crate, ensure that the ropes or arms of a forklift truck are positioned as close to the edge of the crate as possible. The center of gravity is not necessarily in the middle of the crate. Note the accident prevention regulations, safety instructions and local regulations governing transport of the machine and its assemblies.

Only use suitable transport vehicles, hoisting gear and load suspension devices that are in perfect working order and of adequate carrying capacity. Transport should only be entrusted to duly qualified personnel.

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.

All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.

Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.

Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.

Protect against unauthorized access.

Ensure that the machine and accessories are set up in a stable position.

Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Local Regulations

Particular attention must be paid to local and statutory regulations, etc. when installing machines and the plant (e.g. with regard to the specified escape routes). Note the safety zones in relation to adjacent machines.

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.

Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.

Retighten all screw connections that have to be loosened for the maintenance and repair work. Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

The activities and intervals specified in the Instruction Manual for carrying out adjustments, maintenance and inspections must be observed and parts replaced as specified.

All hydraulic and pneumatic lines should be examined for leaks, loose connections, rubbing and damage whenever the machine is serviced. Any defects found must be remedied immediately.

Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard. Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control.

When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

Repair

Replacement Parts

We cannot accept any liability whatsoever for damage due to the use of parts made by other manufacturers or due to unqualified repair or modification of the machine.

Repair, Electrical

The power supply must be switched off (master switch off) and secured so that it cannot be switched on again inadvertently before starting any work on live parts.

Those parts of the machine and plant on which inspection, maintenance or repair work is to be carried out must be isolated from the power supply, if specified. The isolated parts must first be checked to determine that they are truly de-energized before being grounded and short-circuited. Adjacent live parts must also be isolated.

The protective measures implemented (e.g. grounding resistance) must be tested before restarting the machine after all assembly or repair work on electric parts.

Signal generators (limit switches) and other electrical parts on the safety mechanisms must not be removed or bypassed. Only use original fuses or circuit overloads with the specified current rating. The machine must be switched off immediately if a fault develops in the electrical power supply.

The electrical equipment of our machines must be checked at regular intervals and any defects found must be remedied immediately.

If it is necessary to carry out work on live parts, a second person should be on hand to operate the emergency OFF switch or master switch with voltage release in the event of an emergency. The working area should be cordoned off and marked by a warning sign. Only use electrically insulated tools.

Ventilation/Hazardous Gases

It is the end users responsibility to ensure adequate ventilation is provided to exhaust any and all noxious or hazardous gases that may be present in the working environment.

Hydraulic and Pneumatic Systems

Work on hydraulic or pneumatic equipment shall only be carried out by persons with training, knowledge and experience of hydraulic systems. Pressure lines shall be depressurized before starting any repair work.

General Liability

Liability for machine damage and personal injury is extinguished completely if any unauthorized conversions or modifications are undertaken. The machine must not be modified, enlarged or converted in any way capable of affecting safety without the manufacturer's prior approval.

Starting Machine Movements

Read the Instruction Manual carefully to establish which keys and functions start machine movements.

A Word to the End User

The end user has sole responsibility to enforce the use of safety procedures and guards on the machine. Any other safety devices or procedures due to local regulations should be should be retrofitted in accordance to these regulations and/or the EC Directive on the safety of machines.

Operator's position must always be readily accessible. Escape routes must always be kept clear and safety areas should be identified.

Safety Precautions

Safety should be a constant concern for everyone. Always be careful when working with this equipment. While normal safety precautions were taken in the design and manufacture of this equipment, there are some potential safety hazards.

Everyone involved with the operation and maintenance of this equipment should read and follow the instructions in this manual.

Operate the equipment only as stated in this manual. Incorrect use could cause damage to the equipment or personal injury.

It is the owner's responsibility to make certain that the operator reads and understands this manual before operating this equipment. It is also the owner's responsibility to make certain that the operator is a qualified and physically able individual, properly trained in the operation of this equipment.

Specific safety warning decals are located on the equipment near the immediate areas of potential hazards. These decals should not be removed or obliterated. Replace them if they become non-readable.

- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS operate equipment in daylight or with adequate working lights.
- Follow daily and weekly checklists, making sure hoses are tightly secured and bolts are tightened.
- ALWAYS watch and avoid holes or deep depressions.
- ALWAYS wear adequate eye protection when servicing the hydraulic system and battery.
- NEVER operate a poorly maintained machine.
- NEVER allow persons to operate this machine without proper instruction.
- NEVER put hands or feet under any part of the machine while it is running.
- NEVER attempt to make any adjustments or repairs to the machine while running. Repairs or maintenance should be performed by trained personnel only.
- NEVER work under the machine unless it is safely supported with stands, blocks or a hoist and blocks.
- NEVER touch hot parts of machine.

General Machine Data

Electrical & Pneumatic Specifications

Electrical: 220 VAC, 5amp, 50/60 Hz Single Phase
Pneumatic: 70-80 PSI, 2 SCFM avg.

Sewing Head: Yamato VM1804P
Sewing Speed: 3500 RPM
Needle (Standard): SN62X5721
Stitch Density: 6 SPI

Installation & Setup

Provide a 220VAC, single phase, 5 Amp electrical drop and 1/4" air supply line (80 PSI).
Remove any shipping straps from machine.
Mount and adjust the Guide Roller Assembly.
Check the oil level in the oil pan.

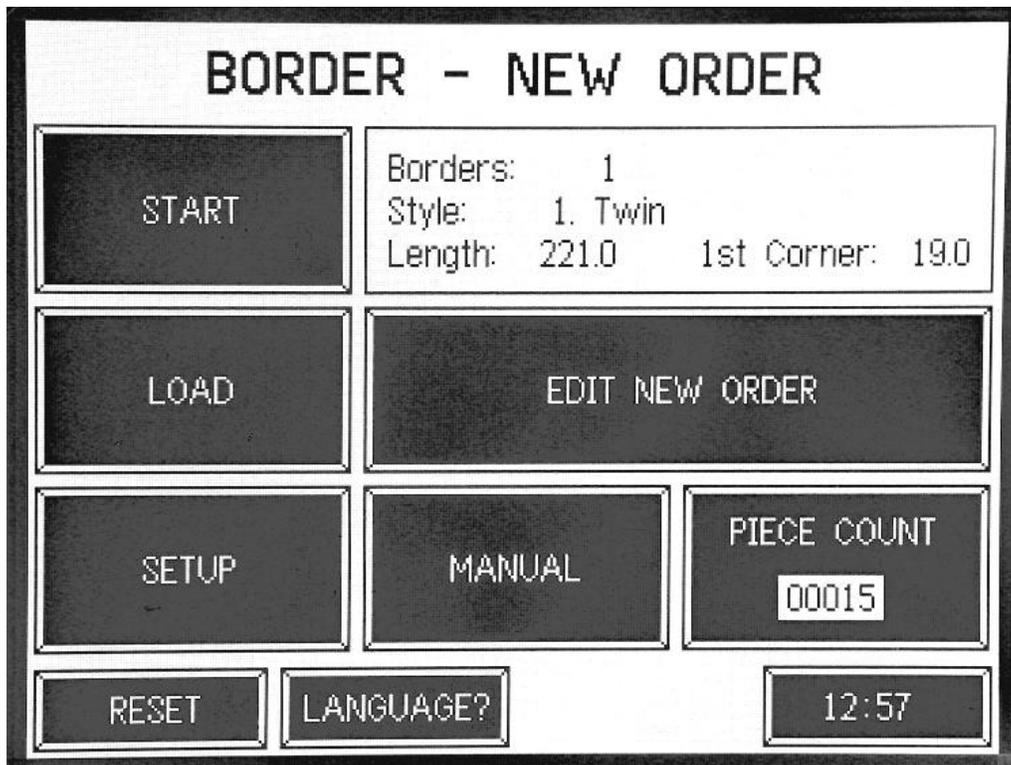
Operating Instructions

Touch Screen Operation

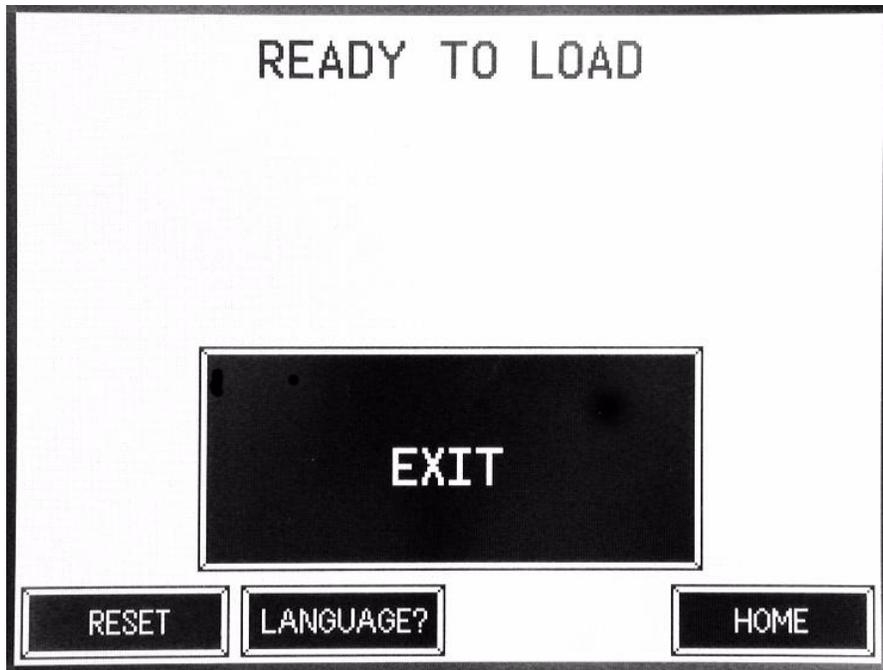
The graphics images presented on the touch screen show "3-dimensional" buttons, which may be pressed to access other screens, change counters and timers, or actuate hardware. Areas lacking the "3-dimensional" border contain information only. Counters are identified with the "+" and "-" buttons in the corners. These counters may be adjusted by pressing the "+" and "-" boxes. Pressing RESET from any screen clears all machine functions and returns to the main page. Normal operation of the machine is controlled from the main BORDER - NEW ORDER menu. From here you can start the automatic cycle and access all machine functions. Pressing the lower right button (clock) allows access to a screen for setting the correct time and date.

There are also ADVANCED settings and functions available. These functions are only accessible by a password, and include: timers that control machine hardware, input and output test screens, and machine statistics. To get to the advanced functions the appropriate password must be entered at the security screen. Security access is reset whenever the main power is turned off, or the RESET button on the main page is pressed. The factory default access code is "33333". The following is a summary of the different screens and their functions:

Main menu:

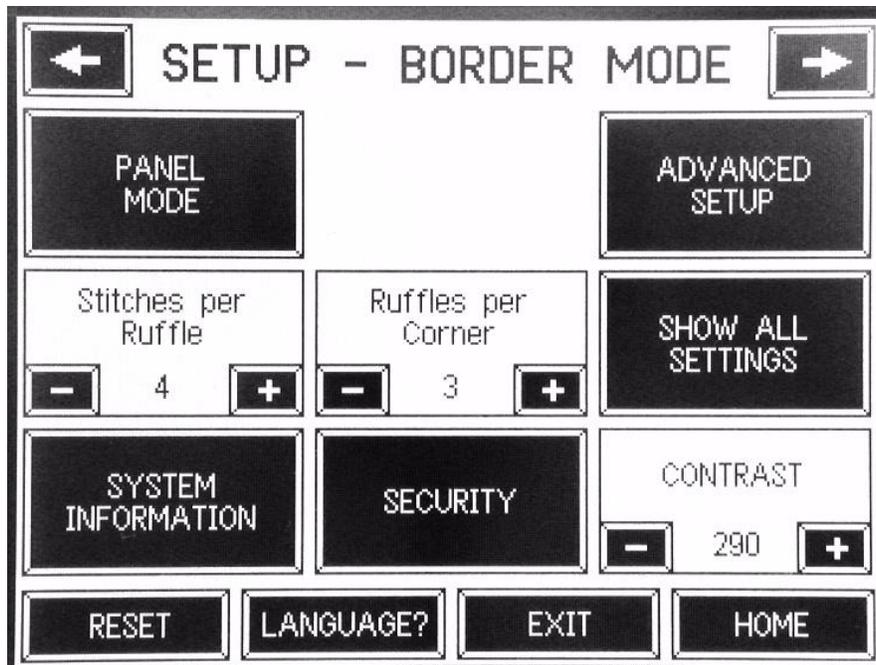


This is the main screen. Pressing START will run the machine in automatic. The top right display box shows how many borders will be made continuously after the START button is pressed. The LOAD button raises the foot, puller, and measuring wheel for loading. Pressing the LOAD button brings up another screen:



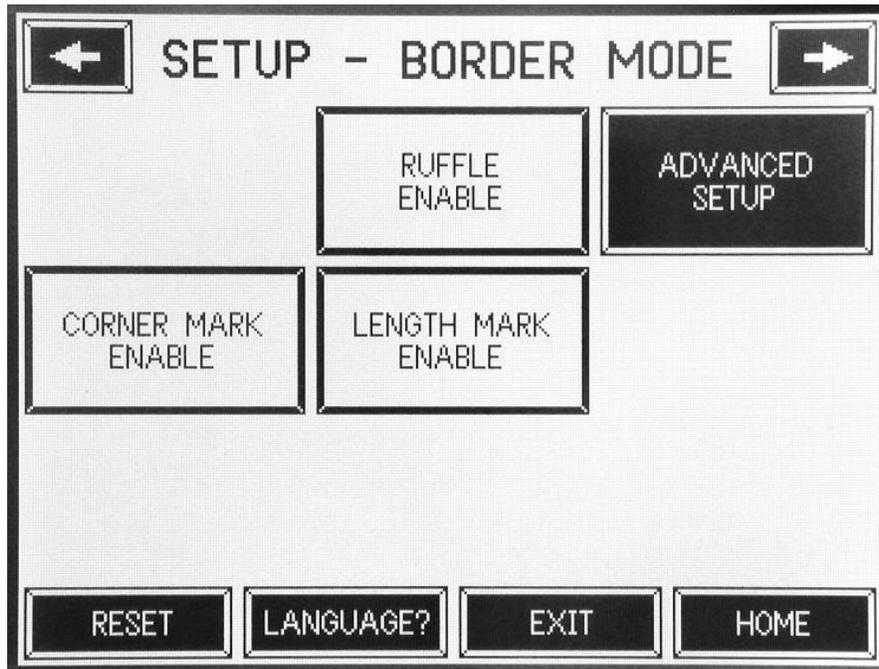
Press EXIT to lower the foot, etc., and return to the main screen. The HOME button takes you to the main screen without resetting the machine.

Back on the main screen press the SETUP button to access the setup screen:



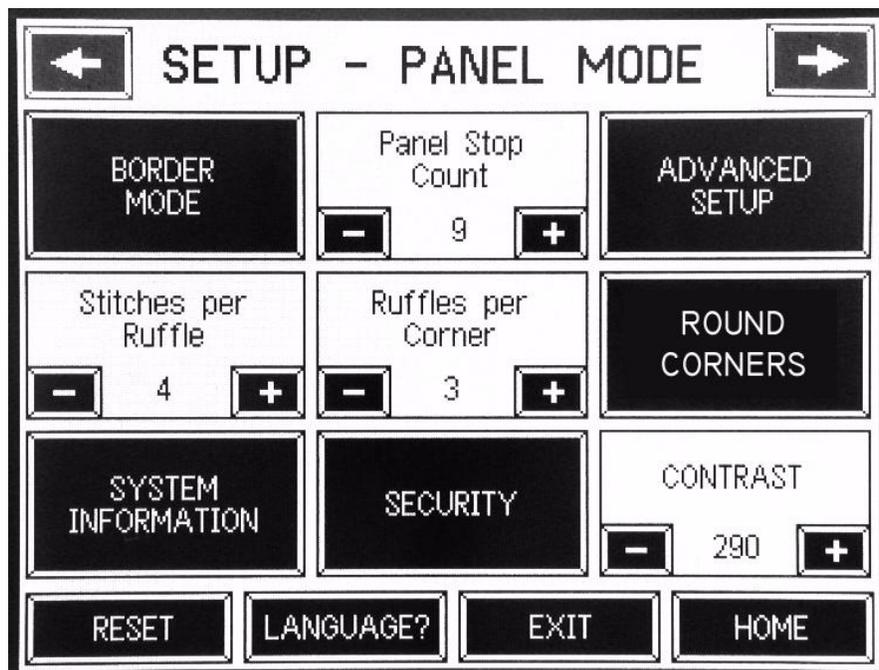
This allows setup of the ruffle quantity and stitches, access to SECURITY, SYSTEM INFORMATION, ADVANCED SETUP, and the SHOW ALL SETTINGS matrix screen. The CONTRAST button changes the screen contrast. The "+" and "-" buttons change the counters.

Press the top arrow buttons to access the second SETUP screen in BORDER mode for enabling or disabling the ruffler and markers and accessing the ADVANCED SETUP screens.



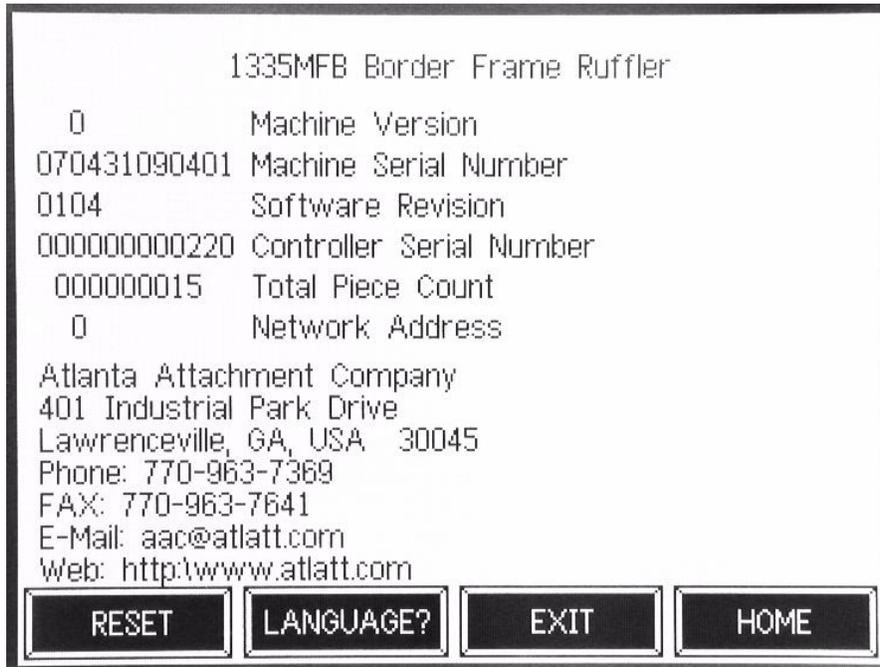
Note: when a button has a white background the function is on or enabled. A dark background indicates off or disabled. Press the top arrows to return to the first SETUP screen.

Press the PANEL MODE button to change the machine to the Panel Sewing mode. In this mode panel edge detection and corner stitch counting are enabled. The length and corner markers are disabled.



This screen has an additional button for adjusting the PANEL STOP COUNT that controls where the panel stops for turning the corners and a ROUND CORNER button for selecting the corner mode. When the ROUND CORNER button has a WHITE background the machine is in the ROUND CORNER mode. When the background is DARK the machine is in the STRAIGHT CORNER mode.

The SYSTEM INFORMATION screens displays serial numbers, lifetime counter, and company info:



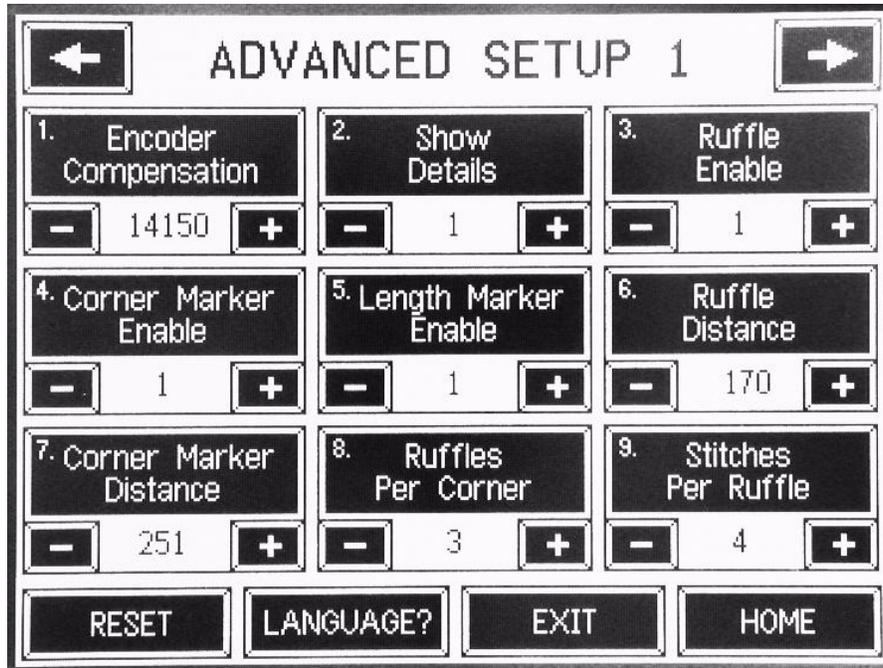
Press EXIT to return to SETUP screen.

The SECURITY screen allows you to change the access code for the ADVANCED functions.



Press EXIT to return to SETUP screen.

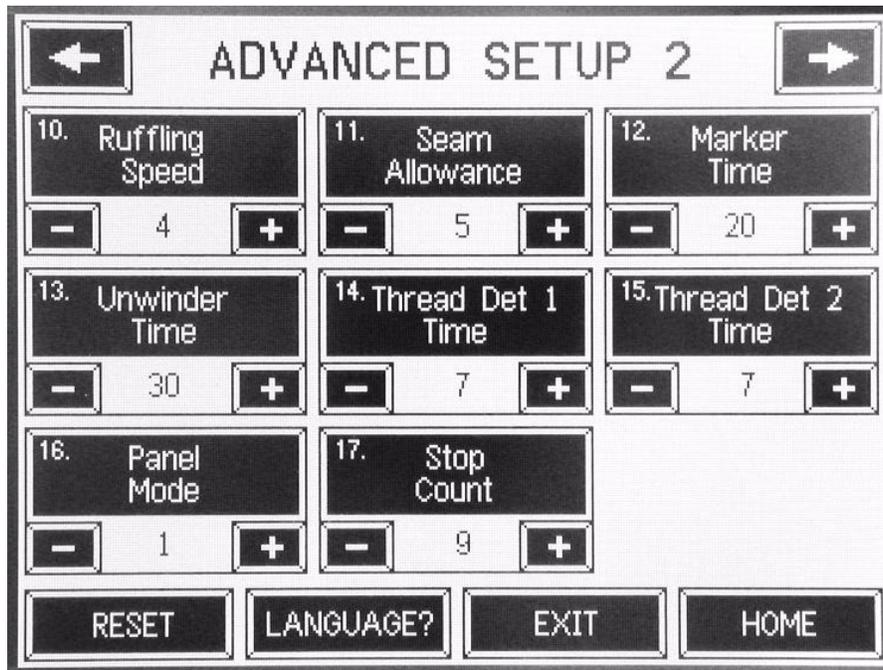
The ADVANCED SETUP button accesses the advanced machine settings and functions not normally accessible by the operator. After power on or a master reset, a pass code must be entered to access these screens.



This screen displays the internal machine settings that control all functions. The number in the upper left corner of each button represents the counter/setting number and is used on the SHOW ALL SETTINGS page matrix. Notice that the RUFFLE ENABLE setting is the same setting as the RUFFLE ENABLE button on SETUP BORDER MODE page 2 mentioned earlier. The same is true for many of the other settings shown.

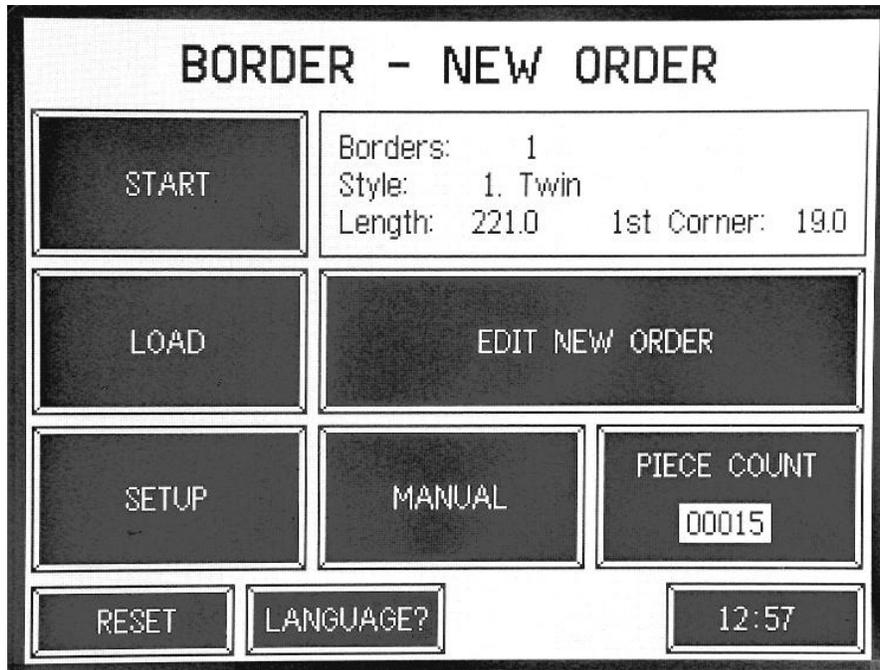
The Encoder Compensation setting is used to calibrate the measuring wheel for proper length measurement and is already calibrated. Do not alter this setting. The Corner Marker Distance setting has been set to place the corner marks in their proper position relative to the hardware on the machine and can be used to make adjustments in the corner mark locations. Likewise for the Ruffle Distance, Pressing the buttons in the dark area under the text will bring up a help screen that explains the button function and proper use. Pressing the "+" and "-" buttons will change the settings.

Pressing the top arrows will display the Advanced Setup 2 page.



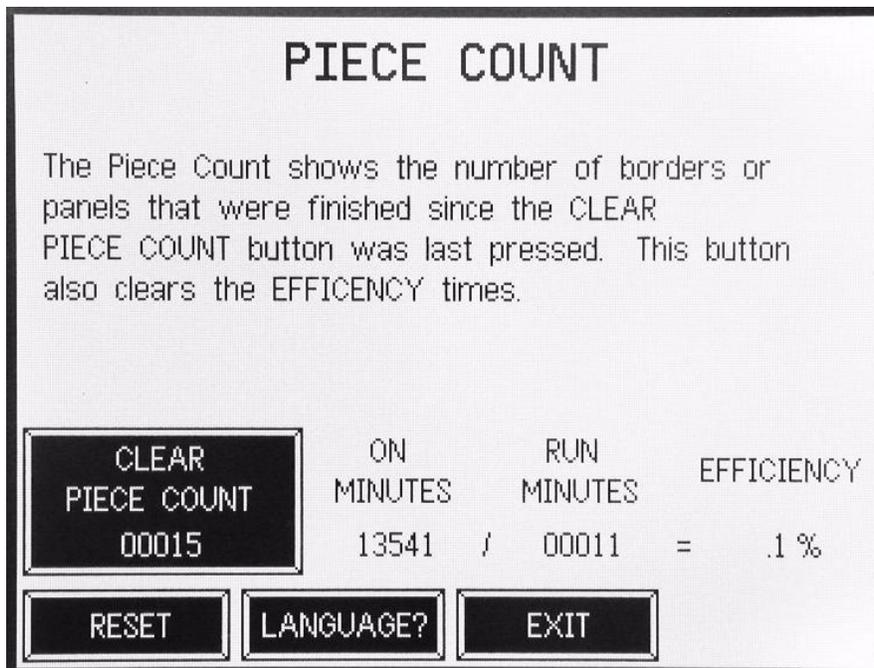
Ruffling Speed is the sewing speed while ruffling. Seam Allowance is the stitch margin for closing the border. Marker time is the on time of the markers. Unwinder Time is the minimum run time of the unwinder motor after the loop eye activates the motor. Thread Det Time is a delay of the thread break detectors to allow the sewing head to come to full speed before the detectors look at the thread. The Panel Mode / Border Mode button switches the machine mode and the STOP COUNT button adjust the CORNER STOP COUNT the same as the buttons in the SETUP screens above. Press the top arrows to return to Setup 1.

Press EXIT to back up to the main page.

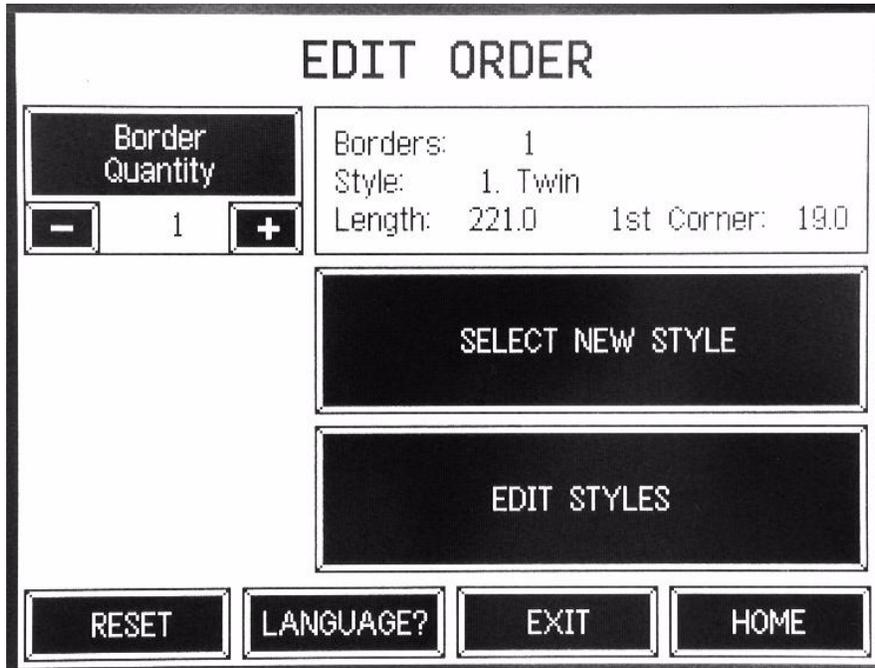


Press **MANUAL** to access the manual run page and enable the foot switches for manual sewing and foot lift functions. You can turn on the ruffle cycle for testing and access the advanced manual pages for testing inputs and outputs.

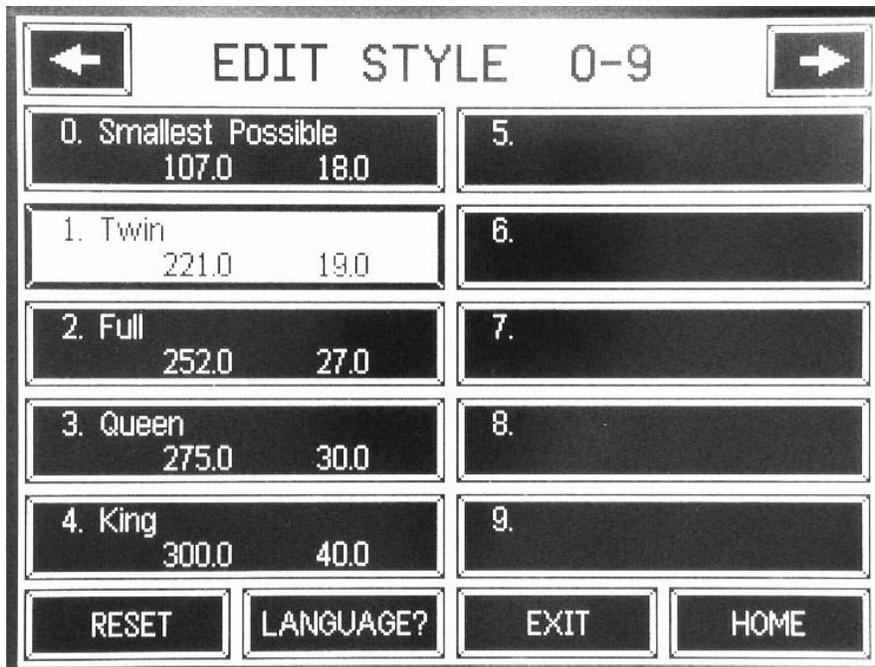
Press the **PIECE COUNT** button to access a screen for resetting the daily piece counter.



Press the EDIT NEW ORDER button to change to a different size border and edit the size settings.

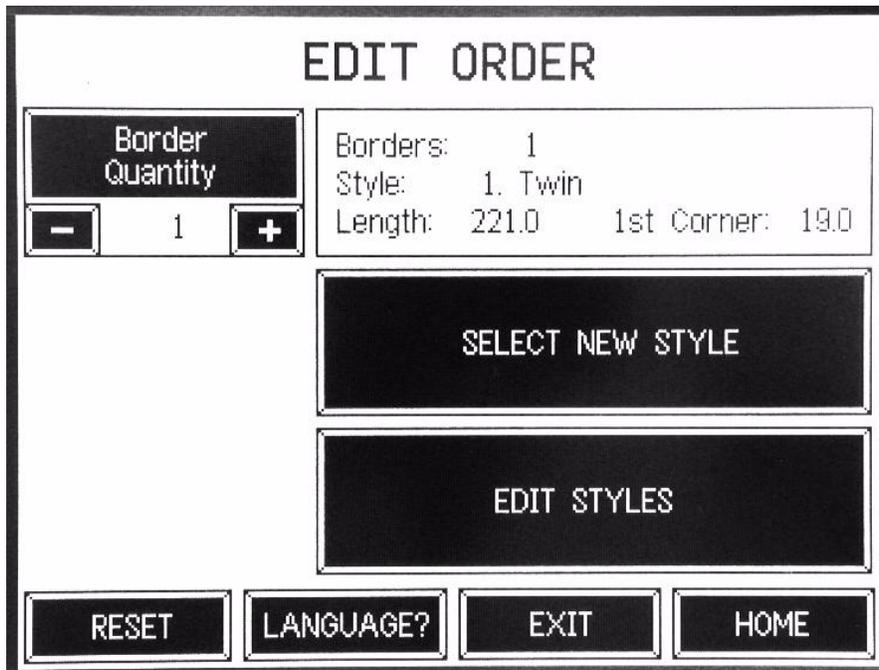


Use the Border Quantity button to set the number of borders to be run consecutively without stopping. Press SELECT NEW STYLE to change sizes.

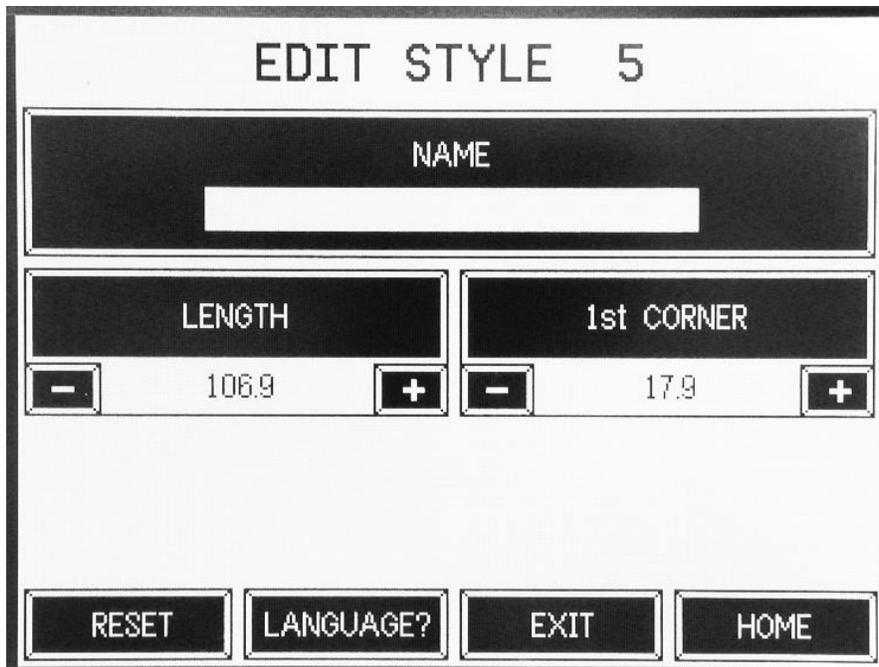


Select the desired style and the machine will return to the EDIT ORDER screen.

Press EDIT STYLES to input or change the styles menu.



The top arrows take you to additional screens. Select the button for the style you wish to edit or create. Example: select style "5":



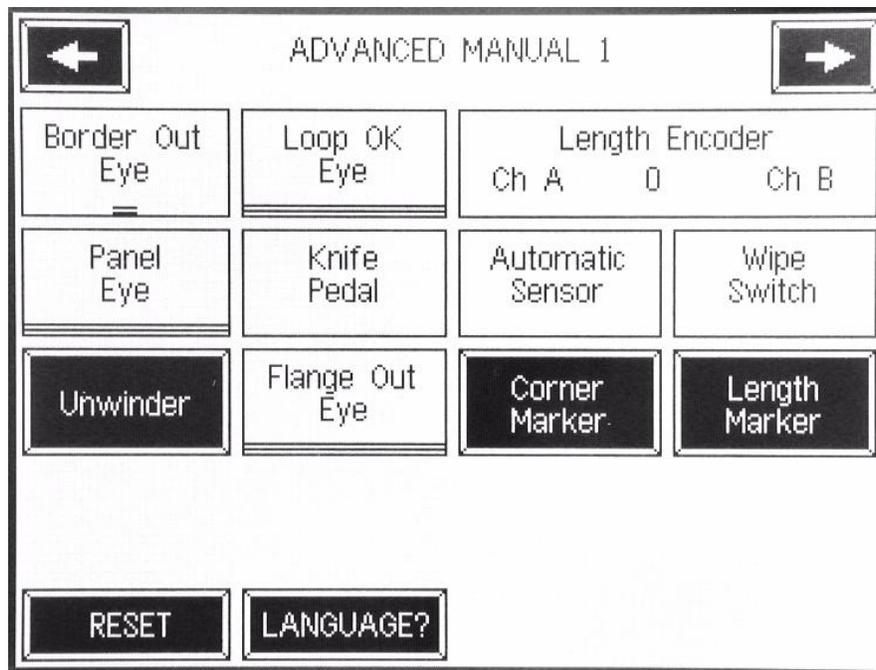
The EDIT STYLE 5 page is displayed. To change or create names press the NAME button. The NAME entry screen appears:

The left and right arrows move the cursor one character. The arrows with the vertical bar Move to the start or end of the text. Bck backs up and erases the character. Clr clears all the text. Spc is the blank space. Cap is caps lock ABORT leaves the screen without saving the changes and returns to the previous page. EXIT leaves and saves the changes. RESET aborts without saving and returns to the main page.

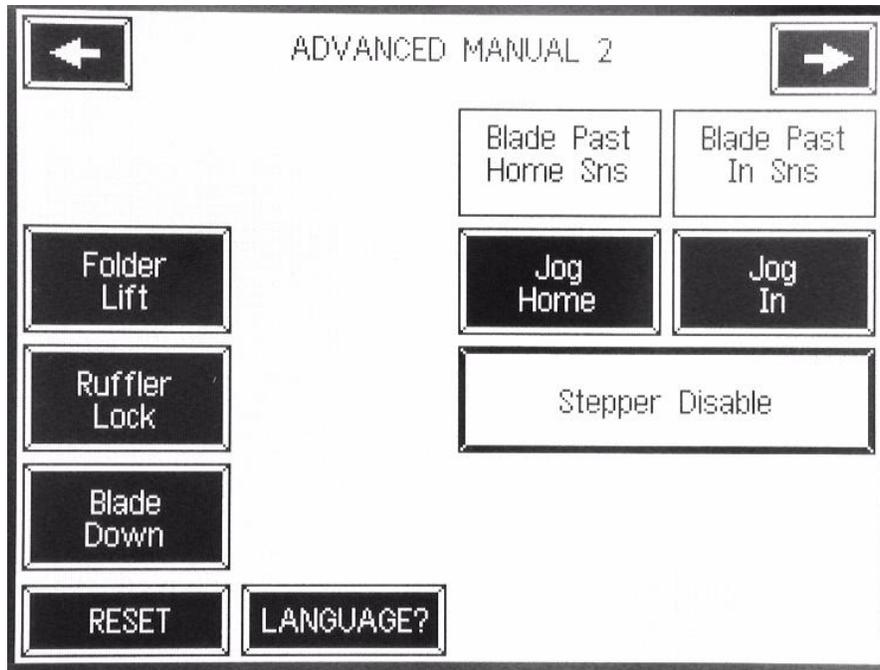
In the EDIT STYLE page the LENGTH button "+" and "-" buttons change the value of the border length in tenths of an inch. Pressing the dark area under the button text brings up a keyboard for quickly entering a starting value. The border length equals the bed length times 2 plus the bed width times 2 plus the seam allowance times 2. Example: For a bed that is 78" long and 36" wide and has a seam allowance of 1/2", the border length is $78" + 78" + 36" + 36" + 1/2" + 1/2" = 229"$. The numbers can be adjusted as needed to get the best fit on the bed.

The 1st CORNER distance is set the same way and is equal to one half of the bed width plus one seam allowance. Example: If the bed is 36" wide, the setting is $36/2 + 1/2"$ or 18.5".

The ADVANCED MANUAL pages allow testing and operation of all inputs and outputs.



The inputs are represented by plain boxes with small "hash marks" or "bars" at the bottom. The bars and marks indicate whether the input is on or off. The "3 dimensional" looking rectangles are buttons and represent outputs. A dark background indicates the output is off. Pressing the button will turn the output on or off. Some outputs toggle on/off, others must be held down to stay on. There are 3 screens that show all of the machines inputs and outputs.

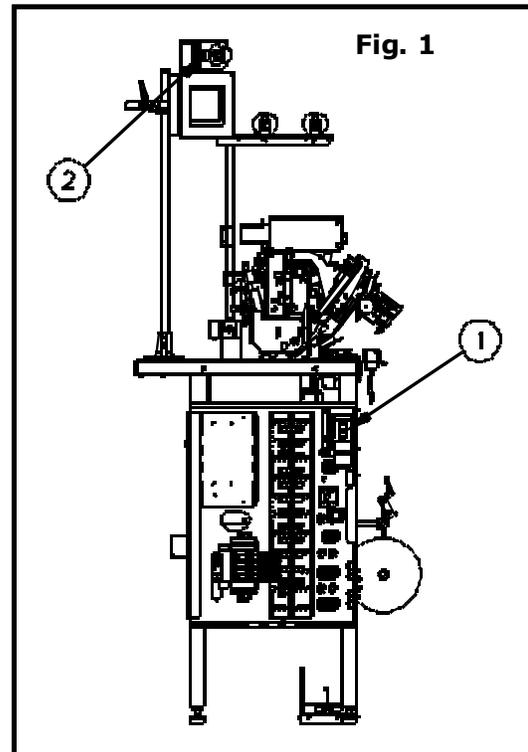


Other screens display whenever there is a machine error or other condition that prohibits the operation of the machine. Simply follow the instruction on the screens to resolve the problem.

Machine Operation

Turn on the main power circuit breaker (item 1) (with lockout) located inside the control cabinet.

Turn on the machine by pressing the green on button (item 2) located above the touch screen panel. Be sure the red emergency stop button is released. After a moment the main screen will appear and the green status LED will be blinking. Refer to these instructions for detailed touch screen operation.



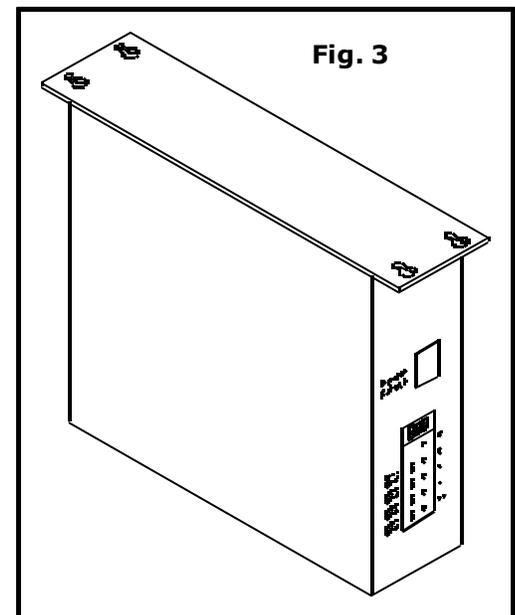
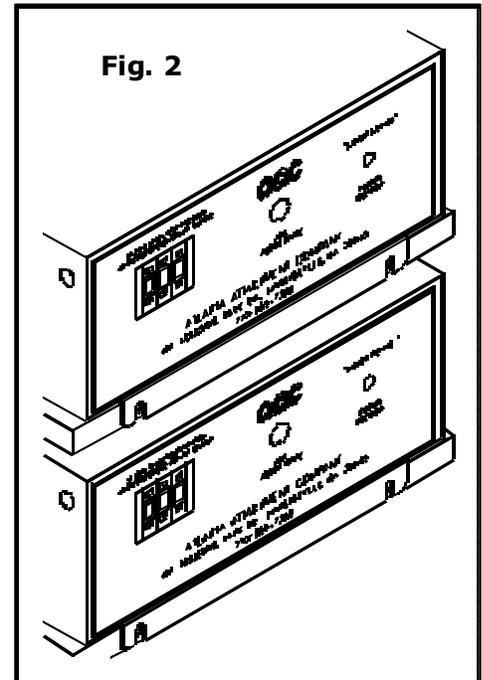
Stepper Control Box

There is a stepping motor box located under the table. The Ruffler box has three thumbwheels on the front which are set to synchronize the Ruffler to the sewing head. The number is proportional to the stitch length and is not affected by sewing speed. The 10-turn potentiometer is used to set the speed of the Ruffler during the feed in to pleat and feed out to make the next ruffle. It is set to maximum and is locked in place by a small locking lever. Unlock to adjust.

Note: The on/off switch only switches one line and does not make the box safe to work on. Always disconnect the main power cord before servicing the control box.

Efka Control Box

The sewing machine is powered by the Efka motor controller located under the table. It has its own on/off switch which should be left on at all times. It also has some small buttons and LED's on the front to indicate the enabled functions. The only LED that should be on is the second to last from the bottom which sets the control to stop the machine needle down at neutral treadle and needle up after full heal back. The functions can be changed upon power up or after a full heal back. The control box has been preprogrammed to operate with the Ruffler. If the box were replaced, the new box would need to be programmed according to the included parameter list in order to function properly. Notice that the sewing head does not stop at normal needle up (lockstitch heads) position after full heal back, but stops at needle top dead center to allow more room for loading thicker material (the head actually turns in reverse for a moment).



From the library of: Diamond Needle Corp

Basic Machine Operation

Loading the Gusset Roll and Unwinder

Remove the small disc from the roll holding rod. Load the border roll onto the rod so the good side is up for making one piece borders or down for making foundation caps. The border must pass through the guide rod, between the feed rollers, under the Loop Eye, and over the guide roller above the ruffler. Replace the small disc onto the spindle with just enough pressure on the roll to hold it in place but allow it to rotate. Heal back on the treadle to activate the Unwinder and create a loop of gusset as you continue to load the machine. Feed the border down to the folder with the good side toward the sewing head (for one piece borders). When making continental foundations, the good side will face the operator.

Loading and Adjusting the Folder

Activate the folder up switch to raise the folder. Feed the border through the top portion of the folder; heal the treadle to raise the measuring wheel, feed the border through the bottom of the folder and under the presser foot and puller. The border material must extend past the length marker. Adjust the folder seam guides to make a snug fit to the tape seams. Adjust the folder left or right as necessary to set the desired stitch margin. The folder spacers should be sized as required to fit the thickness of the border. The seam guides must be at least as thick as the seams are high when the seams are standing straight up. Extra spacers can be ordered to fit any thickness from 1/16" to 1/2". Activate the folder up switch to lower the folder. The machine will not ruffle or detect the corners with the folder up, however it will sew (for manual operation).

Adjusting the Edge Guide

The edge guide located on the front of the table should be set so its left edge aligns with the right edge of the gusset. This is the guide for the right edge of the panel.

Loading the Panel and Border/Gusset

Heal back the treadle or step on the foot lift pedal to raise the presser foot. Swing in the stripper blade and the folder/ruffler assembly. Be sure the sensor at the back of the swing-out bracket is lit indicating that the bracket is all the way in to the detent. Pull the border through the folder, under the presser foot and under the puller. Load the panel under the border, stripper blade, and presser foot with the center of the short side even with the needle and the edge of the panel against the edge guide. Lower the presser foot. Be sure the machine is in PANEL MODE and the folder is down.

Sewing the Panel with Rounded Corners

Go to the SETUP - PANEL MODE screen and set the ROUND CORNER button so it has a WHITE background indicating ROUND CORNER mode. Set the Ruffles per Corner, Stitches per Ruffle, and Stop Count as desired. Return to the Main screen.

Sew the panel all the way to corner being sure not to get your hands in the way of the electric eye mounted under the table that must "see" the edge of the panel as it nears the presser foot. The machine will stop automatically at the corner. Go to neutral treadle as you position your hands for turning. Place your right hand on the panel near the presser foot and your left hand about 1 foot to the left on the panel. Treadle forward and allow the machine to make the first ruffle sewing straight. Begin to rotate the panel as the rest of the ruffles are formed. Try to turn an equal amount with each ruffle so that when the ruffles are complete the panel has turned 90 degrees and the right edge of the panel is resting against the left edge of the edge guide. The ruffles can be made one at a time by going to neutral treadle between each ruffle. Complete all four corners.

Sewing the Panel with Straight Corners

Go to the SETUP - PANEL MODE screen and set the ROUND CORNER button so it has a DARK background indicating STRAIGHT CORNER mode. Set the Ruffles per Corner and Stitches per Ruffle as desired. When the RUFFLES per CORNER is set to an even number (2, 4, etc.) the machine will make half of the ruffles on each side of the corner. When the Ruffles per Corner is set to an odd number (1, 3, 5, etc) the machine will make the odd ruffle on the second side. Example: If Ruffles per Corner is set to 3, the machine will make 1 ruffle on the first side of the corner and 2 ruffles on the second side of the corner. Set the Ruffles per Corner, Stitches per Ruffle, and Stop Count as desired. Return to the Main screen.

Sew the panel to the corner being sure not to get your hands in the way of the electric eye mounted under the table, which must "see" the edge of the panel as it nears the presser foot. The machine will pause momentarily as the ruffler engages and then

continue to sew straight as it makes the ruffles. After the last ruffle is finished on the first side of the corner the machine will stop with the presser foot lifted. Turn the panel 90 degrees. Release and depress the treadle. The foot will drop and the machine will begin making the ruffles on the second side of the corner. When the ruffles are complete the machine will resume sewing at treadle speed. Adjust the stop count as necessary to achieve the desired corner finish.

Adjusting the Corner Ruffles

The ruffles should be set so the sew line in the corners lays flat. A typical ruffled gusset will have ruffles that butt against each other without overlapping or gaps between them. Adjust the number of ruffles, the number of stitches in each ruffle, and the size of the ruffles to achieve the desired finish. The total number of stitches sewn (no. of ruffles times the no. of stitches/ruffle) while ruffling must be adequate to complete the corner turn. Foundation borders typically have 3 or 4 small ruffles with extra stitches between them.

Adjusting the Corner Stop Count

After the panel has turned 90 degrees the right edge of the panel should align with the left edge of the edge guide. If the panel edge is too far to the right of the edge guide, it means the panel stopped too late prior to turning the corner and the Stop Count should be decreased. If the panel overlaps the edge guide after turning, panel stopped too soon and the Stop Count should be increased.

Finishing the Panel

After the last corner, sew the panel until the trailing edge of the border overlaps the starting point. Stop, raise the folder, cut the border, and swing out the folder and stripper blade. Remove the panel from the machine. Mark and close the border so it fits the panel. Place the border and panel back under the presser foot and join the unsewn portion of the panel to the closed portion of the border.

Sewing in Border Mode

Sew in Border Mode when making borders without panels attached. These borders usually have flanging sewn in. Mount the flange roll onto the roll holder located under the front of the sewing table. Run the flange through the guides, in front of the material detector, up and over the edge of the table and under the presser foot and stripper blade. Adjust the edge guides for desired stitch margin. Select the desired border size (Style) and quantity from the menu. Press the LOAD button to raise the foot, puller, and measuring wheel. Load the border so it extends past the LENGTH MARKER. Exit the LOAD screen and press START. The border will be sewn with the ruffles and corner miter positions marked. The machine will also mark the end of each border for cutting apart. On a separate machine, close the border and miter the corners. Adjust the length and corner settings as necessary to achieve the desired fit on the bed.

Efka Control Box Settings

The Efka control has been preprogrammed to operate the sewing head in conjunction with the ruffler. The maximum sewing speed has been preset to 4000 RPM. The maximum sewing speed can be temporarily reduced by holding in the "-" button on front of the control box while sewing. To restore back to the maximum speed use the "+" button and make sure the needle down LED is the only LED lit on front of the control box. The LED's can be changed only immediately after power on or a full heal back. Refer to the appendix for complete Efka programming parameters.

Initial Set-Up of Border Mode:

Initial set-up of border mode settings should be done in the following order:

1. Using a Twin border style, set the border length and corner position.
2. Compensate the machine so it is measuring correctly.
3. Make a twin border with corner marks only.
4. Adjust the CORNER MARKER DISTANCE until the corner marks are symmetrical (first and last marks are equal distance from ends). Note: Increasing the counter will move the first corner mark CLOSER to the starting end of the border.
5. Make a border with ruffles and corners.
6. Adjust the RUFFLE DISTANCE until the ruffles align with the corner marks. Note: Increasing the counter will move the first Ruffle CLOSER to the end of the border.

Note: The CORNER MARKER DISTANCE and RUFFLE DISTANCE settings are only used to make the border symmetrical. The length of the border and the corner locations are controlled by the settings in STYLES.

General Machine Adjustments

Air Pressure

Set all air supply pressure regulators (Right to left):

Main Pressure:	70 PSI
Puller Pressure:	30 PSI
Ruffle Blade Pressure:	10 PSI
Foot Sew Pressure:	15 PSI

Sewing Head

See the manufacturer's manuals for normal adjustments and parts. The presser foot spring pressure should be set very light so that the ruffling blade can feed under the foot while ruffling. The Efka motor should be set for stopping needle down at neutral treadle to help hold the ruffle in place while turning the corners. The auxiliary foot pressure cylinder should be set to provide added foot pressure while sewing straight.

Ruffler Drive

Set the Ruffler blade position left to right. The slot in the Ruffler blade should align with the sewing needle. Loosen the 4 clamp screws and adjust ruffler blade left or right as needed.

Set the Ruffler blade IN position so that the front edge of the blade is even with the needle when the ruffler drive is positioned at the IN sensor. To position the drive at the sensor, press the manual ruffle button once and quickly tap the treadle or sew pedal. The Ruffler should position itself at the IN sensor. Adjust the sensor position in its slot, press the manual ruffle button to reset the ruffler and repeat the cycle to test the setting.

Set the Ruffler blade OUT position by turning the adjusting knob on the front cover of the ruffler drive. This controls how big each ruffle will be. After making an adjustment, always reset the ruffler by pressing the manual ruffle button twice.

The swing-out stripper blade protects the panel from the ruffler blade while ruffling so that the panel does not get pleated by the blade. It should be positioned as close to the presser foot as possible. The ruffling air pressure should be set as high as practical without it pressing the stripper blade down and pinching the panel while turning.

Unwinder Assembly

The Unwinder is belt driven from a right angle gear motor. The motor and bearings are permanently lubricated and require no regular maintenance. Check the belt tension periodically and adjust if necessary. Check the gear pulley and bearing set screws for tightness. The electric eye mounted on the guide rod should be set to "see" the border material before the loop is entirely used up.

General Machine Maintenance

Daily

- Clean machine at the end of every shift
- Clean lint etc. from the Loper/bobbin area on the sewing head
- Remove any threads wrapped around moving parts of the handwheel, puller, and ruffler.
- Wipe all photo eye lenses with clean, nonabrasive, dry cloth
- Use blow-off hose to get rid of excess lint, thread and other clippings
- Follow manufactures recommendations and guidelines for daily maintenance and lubricating of the sewing head.

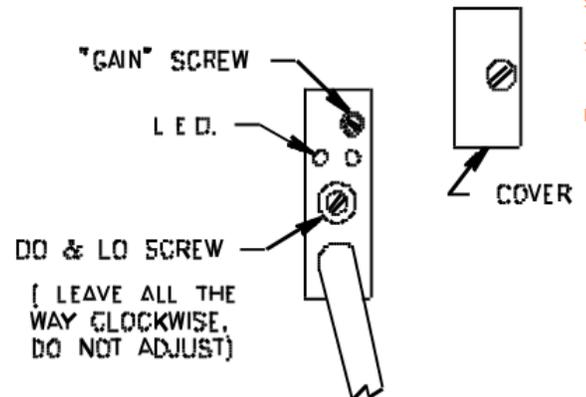
Weekly

- Check all belts for tightness and condition. Adjust or replace as necessary.
- Check oil level in oil pan.
- Put one drop of machine oil on all moving Ruffler parts.

Electric Eye Sensor Adjustment

To adjust the sensor, first remove the clear plastic cover from the end of the sensor. There are two adjusting screws under the cover. One is labeled "GAIN" and is used to set the sensitivity of the sensor. The other screw is labeled "DO & LO" and should always be fully clockwise.

With the end of the sensor pointing at the center of the reflective tape, turn the "GAIN" screw counter-clockwise until the red LED indicator is off. Then turn the "GAIN" screw clockwise until the LED indicator comes on. Then turn the "GAIN" screw one full turn clockwise. The LED indicator should be blinking slowly. Cover the eye so that the sensor cannot see the reflective tape and the LED should go off.



Reflective Tape Maintenance

Use a soft cloth for cleaning.
 Do not use chemicals or abrasives to clean it.
 Avoid any contact with oils and liquids.
 Do not touch the tape with bare fingers.
 If tape is dirty or opaque, the eye may not function correctly.

Parameter Settings for Efka Controller

1335M EFKA Motor Parameter List

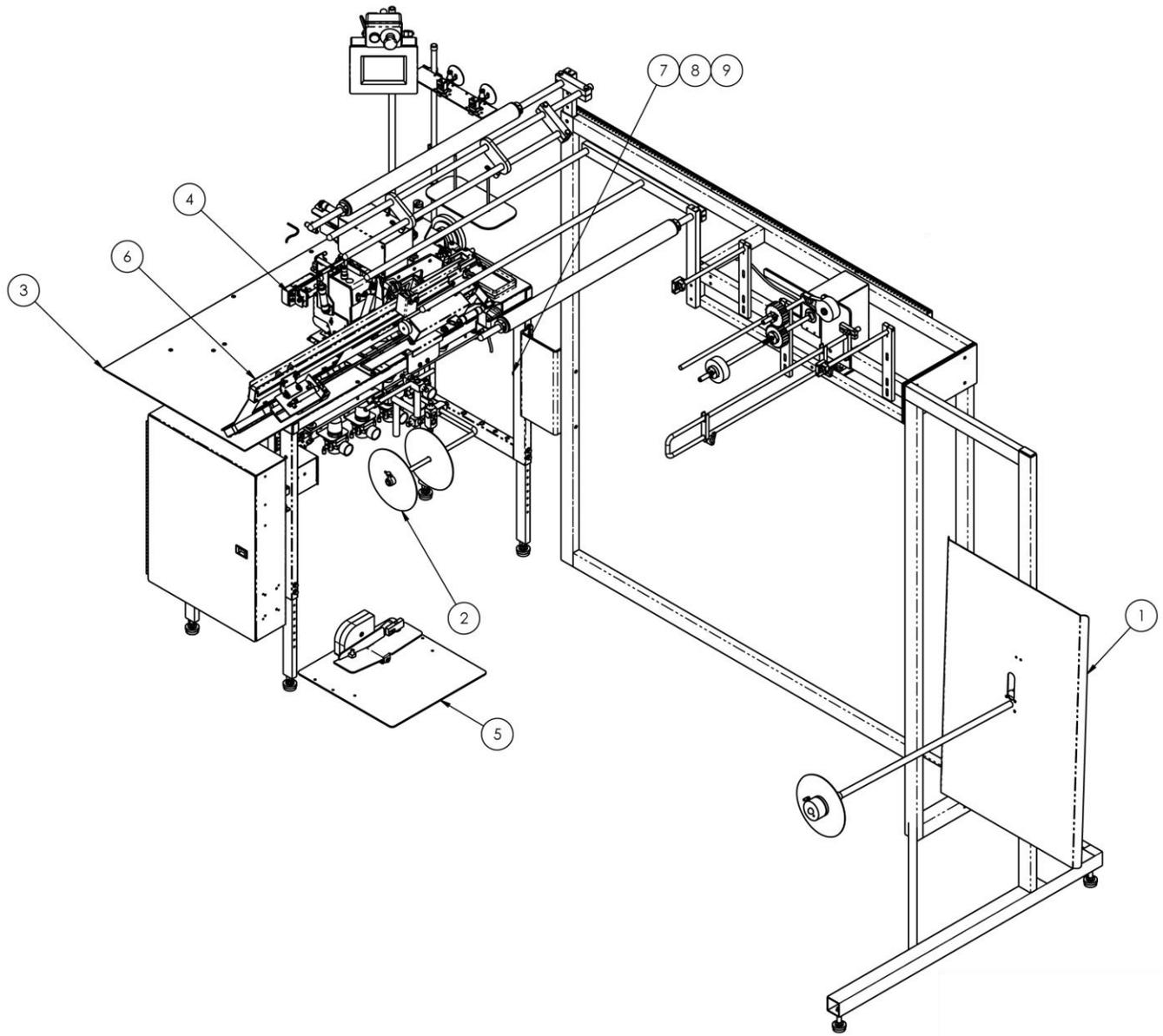
PARAMETER	RANGE	mitsubishi LOCHSTITC H	JUKI CHAINSTITCH	YAM 1804 CHAINSTITCH	YAM 2002 CHAINSTITCH	SING 300UX5 WALKING FOOT	1335M PARAMETER DESCRIPTION
Do this first	*****	****	****				Perform a master reset before programming, see below Mode (Lockstitch) of operation. MUST SET THIS PARAMETER FIRST!
290		0	5	5	5	5	
111	200-9900 rpm	400	400	350	320	250	Maximum speed when "129" is 0, 1, or 2.
153	0-50	--	--	--	--	35	Braking power at machine stand still
161	0-1	1	1	0	1	1	Motor rotation, 1=CCW
180	0-360 (175)	60	--	--	--	--	Degrees reverse run goes to get to needle up
181	0-999 (10)	01	--	--	--	--	Delay till reverse run starts after trim
182	0-1 (0)	1	0	0	0	0	Enable reverse run after trim to get to "true" needle up
202	0-500	50	50	500	500	500	Sew delay after foot lift off
219	1-55	35	--	--	35	35	Breaking power at stop
250	0-359	150	--	--	--	--	Thread trimmer activation angle
270	0-5	1	1	1	1	1	External handwheel sensor configuration. (Position 2)
271	0-255	180	180	165	165	165	Ref angle for Position 1 (Trim) from Position 2
272	020-255	100	100	100	100	100	Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111. (For Yamato and Pegasus, setting should be 100; for Fimoldi, setting should be 124)
Front panel LED's:							
LED 1:	Off						Programming Instructions:
LED 2:	Off						1. Power on holding down the "P" button till "COD" is displayed.
LED 3:	Off						2. Press ">>" once and enter the number "311"
LED 4:	Off						3. Press "E" once and "2.0.0." is displayed this is a parameter
LED 5:	Off						4. Proceed to the parameter to be changed and press "E".
LED 6:	Off.						5. The value now shows in the screen, adjust to desired value.
LED 7:	ON, Stop at needle down.						6. Press "E" to enter value and continue with parameter setting.
LED 8:	OFF, Stop at needle up.						7. Repeat for other parameters, press "P" once when complete.
							8. Run sewing head to save parameters before powering down
							To Perform Master Reset of Parameters:
							1. Power on holding down the "P" button till "COD" is displayed.
							2. Press ">>" once and enter the number "591"
							3. Press "E" twice and "093" is displayed.
							4. Press "+," once, "094" is displayed.
							5. Press "P" to exit programming mode with all default values.

Assembly Drawings & Parts Lists

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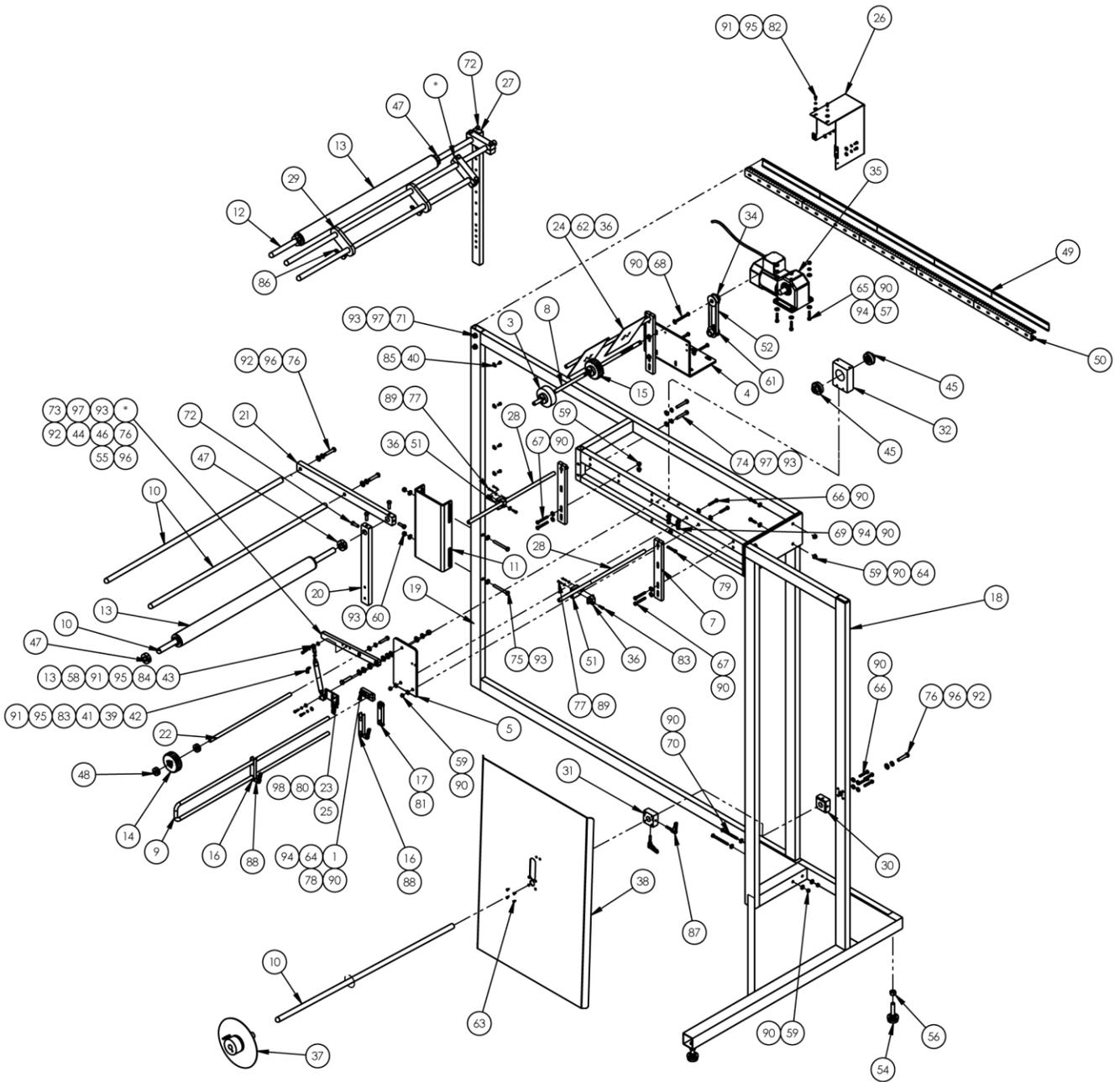


From the library of: Diamond Needle Corp

11335MGBA-UW Border Frame Ruffler

AAC Drawing Number 9000270 Rev1

NO.	QTY	PART #	DESCRIPTION	
1	1	1335145	UNWINDER ASSY, HEAVY DUTY	Page 34
2	1	1335575	ROLL HOLDER ASBLY	Page 36
3	1	1335764	BASE CONSOLE, SBUS	Page 38
4	1	3200PMD	MARKING MODULE,EXT MOUNT	Page 56
5	1	4059-FP301D	FOOT PEDAL ASSY,EFKA	
6	1	A-2216W56	FOLDER, CONT W/GUSSET	Page 66
7	2	NNK5/16-18	KEP NUT, 5/16-18	
8	2	SSHC10176	5/16-18 X 2-3/4 HEX HEAD	
9	4	WWFS5/16	WASHER, FLAT, 5/16	



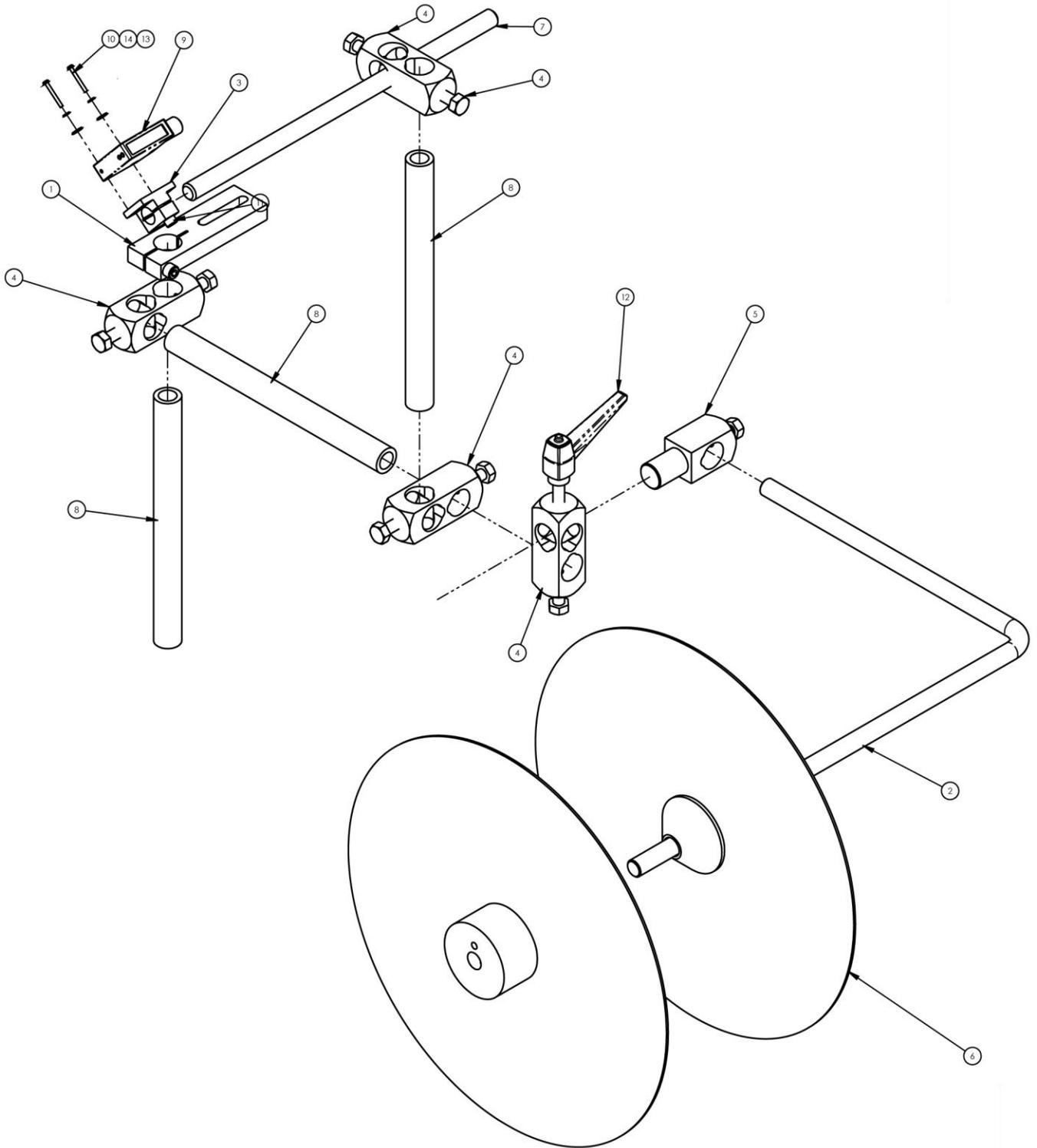
From the library of: Diamond Needle Corp

1335145 Unwinder Assembly

AAC Drawing Number 1335145 Rev12

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1325-346	HOLDER,ROD,1/2 D,SLOT MNT	50	5	EEDF1X1	DUCT,WIRE,1X1
2	1	1334383	ROD, SS 1/2 OD X 18.0 LG	51	2	FFQM42VN6A	EYE,ELECTRIC,10-30VDC
3	1	1335108	DRIVE ROLLER ASSEMBLY	52	1	GG157L050	BELT,GEAR,3/8P,1/2W
4	1	1335112	MOUNT,MOTOR	53	1	MM132-1496	PLUG 1 X 2
5	1	1335115	MOUNT, PINCH ROLLER	54	2	MMFB4444	FOOT, RUBBER
6	1	1335189	LINK, IDLER ROLLER	55	1	NNE3/8-16	NUT, ELASTIC 3/8-16
7	3	1335386	MOUNT, HINGE ROD	56	2	NNH1/2-13	1/2-13 HEX NUT
8	1	1335390	SHAFT, DRIVE ROLLER	57	4	NNH1/4-20	1/4-20 HEX NUT
9	1	1335457	ROD,1/2 DIA, 180 DEG	58	1	NNJ10-32	NUT,JAM,THIN #10-32
10	5	1335458	ROD,SS,3/4 X 37.0L	59	15	NNK1/4-20	KEP NUT, 1/4-20
11	1	1335466	BRACKET, UNWUNDER MOUNT	60	2	NNK5/16-18	KEP NUT, 5/16-18
12	2	1335473	ROD,SS,3/4 X 44.0L	61	1	PP12LF050-3/4	PULLEY,GEAR,3/8P,.50B,12T
13	2	1335485	ROLL, 28"L, 2"OD, 3/4 ROD	62	8	SSFC70016	4-40 X 1/4 FLAT SOC CAP
14	1	1335497	ROLLER, FLUTTED, IDLER,	63	4	SSFC80024	#6-32 X 3/8 FLAT ALLEN
15	1	1335498	DRIVE ROLLER, FLUTTED	64	6	SSHC01064	1/4-20 X 1 HEX HEAD
16	2	1335499	ARM, 1/2" ROD CLAMP	65	4	SSHC01080	1/4-20 X 1-1/4 HEX HEAD
17	1	1335501	ARM, 1/2" ROD CLAMP	66	7	SSHC01096	1/4-20 X 1-1/2 HEX HEAD
18	1	1335726	FRAME, REAR, UNWINDER	67	4	SSHC01128	1/4-20 X 2 HEX HEAD
19	1	1335727	FRAME, FRONT, UNWINDER	68	2	SSHC01144	1/4-20 X 2-1/4 HEX HEAD
20	1	1335730	SUPPORT, TENSIONER	69	2	SSHC01160	1/4-20 X 2-1/2 HEX HEAD
21	1	1335731	SUPPORT, BORDER RODS	70	2	SSHC01192	1/4-20 X 3 HEX HEAD
22	1	1335829	DRIVE ROD, ROLLER	71	2	SSHC10048	5/16-18 X 3/4 HEX HEAD
23	1	1335864	BRACKET, CYLINDER	72	6	SSHC10064	5/16-18 X 1" HEX HEAD
24	2	1335908	PLATE, BORDER DEFLECTOR	73	1	SSHC10096	5/16-18 X 1-1/2 HEX HEAD
25	1	1335M-2046	PLATE,NUT,8-32@.43 CTC	74	2	SSHC10128	5/16-18 X 2 HEX HEAD
26	1	1335M-4007	COVER, BELT	75	2	SSHC10176	5/16-18 X 2-3/4 HEX HEAD
27	1	1347097	SUPPORT, TENSIONER	76	4	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
28	2	1349381	ROD, STRAIGHT, CRS	77	4	SSPS70048	#4-40 X 3/4 PAN HD SLOT
29	2	1961-211	PLATE, EDGE GUIDE	78	1	SSSC01048	1/4-20 X 3/4 SOC CAP
30	1	1961-251C	HUB, UNWIND SHAFT	79	3	SSSC01096	1/4-20 X 1-1/2 SOC CAP
31	1	1961-253A	HUB, UNWIND STAND	80	2	SSSC90024	#8-32 X 3/8 SOC CAP SC
32	1	1961-365	YOKE, BEARING	81	2	SSSC95048	#10-24 X 3/4 SOC CAP
33	2	1962-3201	CLAMP,3/4ROD,3"CTC	82	5	SSSC98024	#10-32 X 3/8 SOC CAP
34	1	211-057	PULLEY, 3/8P, 12T,1/2B	83	4	SSSC98040	10-32 X 5/8 SOC CAP
35	1	23218DM	MOTOR ASSY,GEAR	84	1	SSSC98048	10-32 X 3/4 SOC CAP
36	4	265155A	HOLDER, EYE, 1/2 BORE	85	4	SSZS93032	SCREW, SHT.METAL 10 ZIP
37	1	33008708	BALL BEARING DISC ASSY	86	2	TTH32415	HANDLE, THREADED,1/4-20X7/
38	1	784B-2436	PLATE, ALU, 23.75 X 31.75	87	2	TTH32416	HANDLE, THRD,1/4-20X1-1/8
39	1	AAC8DP-3	CYLINDER,AIR,DA	88	2	TTH34311	HANDLE, THREADED,10-24X3/4
40	4	AAF1/8	1/8" PLASTIC CLAMP	89	4	WWF4	WASHER, FLAT #4
41	1	AAFBP-8C	BRKT,PIVOT,5/32 BORE	90	46	WWFS1/4	WASHER FLAT, 1/4
42	1	AAQME-5-10	ELBOW, MALE,5/32X10-32	91	9	WWFS10	WASHER, FLAT, #10, SAE
43	1	BBAW-3Z	BRG,ROD END,F, 10-32	92	4	WWFS3/8	WASHER, FLAT, 3/8
44	2	BBNTA613	BEARING,THRUST,375BORE	93	9	WWFS5/16	WASHER, FLAT, 5/16
45	2	BBS8701-88	BEARING,BALL,.50IDX1.75OD	94	12	WWL1/4	1/4 LW
46	4	BBTRA613	WASHER,THRUST,STL, .375B	95	8	WWL10	WASHER,LOCK,#10,S/S
47	4	CCCL12F	CLAMP COLLAR- 3/4	96	4	WWL3/8	3/8 LW
48	2	CCCL8F	CLAMP COLLAR- 1/2	97	5	WWL5/16	5/16 LW
49	5	EEDC1LG	DUCT,WIRE COVER,1"	98	2	WWL8	WASHER,LOCK,#8

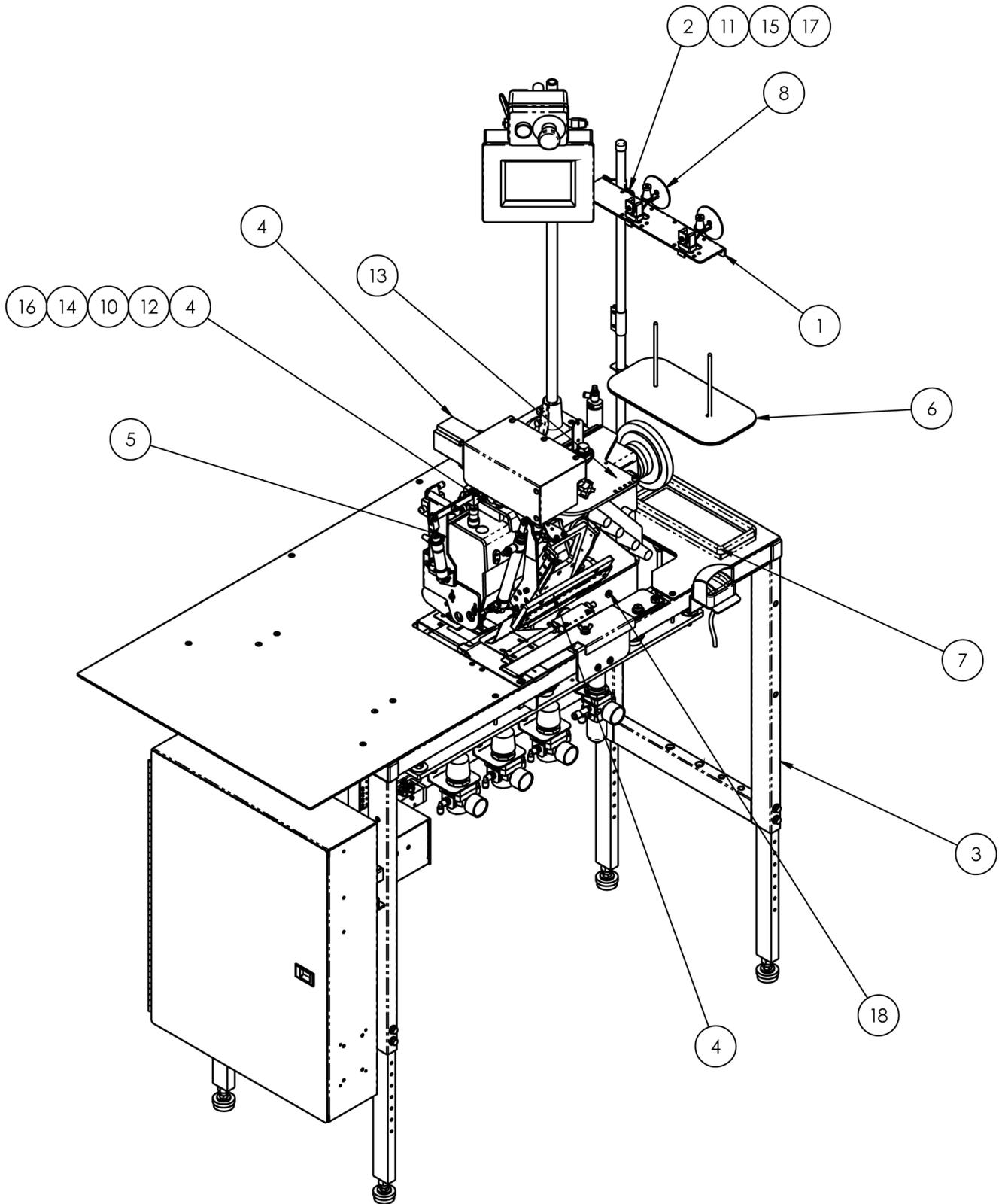
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1335575 Roll Holder Assembly

AAC Drawing Number 1335575 Rev3

NO.	QTY	PART #	DESCRIPTION
1	1	1325-346A	HOLDER, ROD, 3/4", SLOT
2	1	1335598	ROD, SS BENT, 90 DEG
3	1	265155A	HOLDER, EYE, 1/2 BORE
4	4	28201	BLOCK,CROSS,(LARGE)
5	1	28201B	LARGE PIVOT BLOCK
6	2	786B12-2.2	DISC & CONE BEARING ASSY
7	1	8732-0736	ROD, ST, CRS, 1/2 X 11.5
8	3	8748-0512	ROD,STRA,CRS,3/4X8
9	1	FFQM42VN6A	EYE,ELECTRIC,10-30VDC
10	2	SSPS50048	#2-56 X 3/4 PAN HD SLOT
11	1	SSSC98040	#10-32 X 5/8 SOC CAP
12	1	TTH32426	HANDLE,THRD,5/16-18X1-1/4
13	2	WWF4	WASHER, FLAT #4
14	2	WWL4	#4 LW



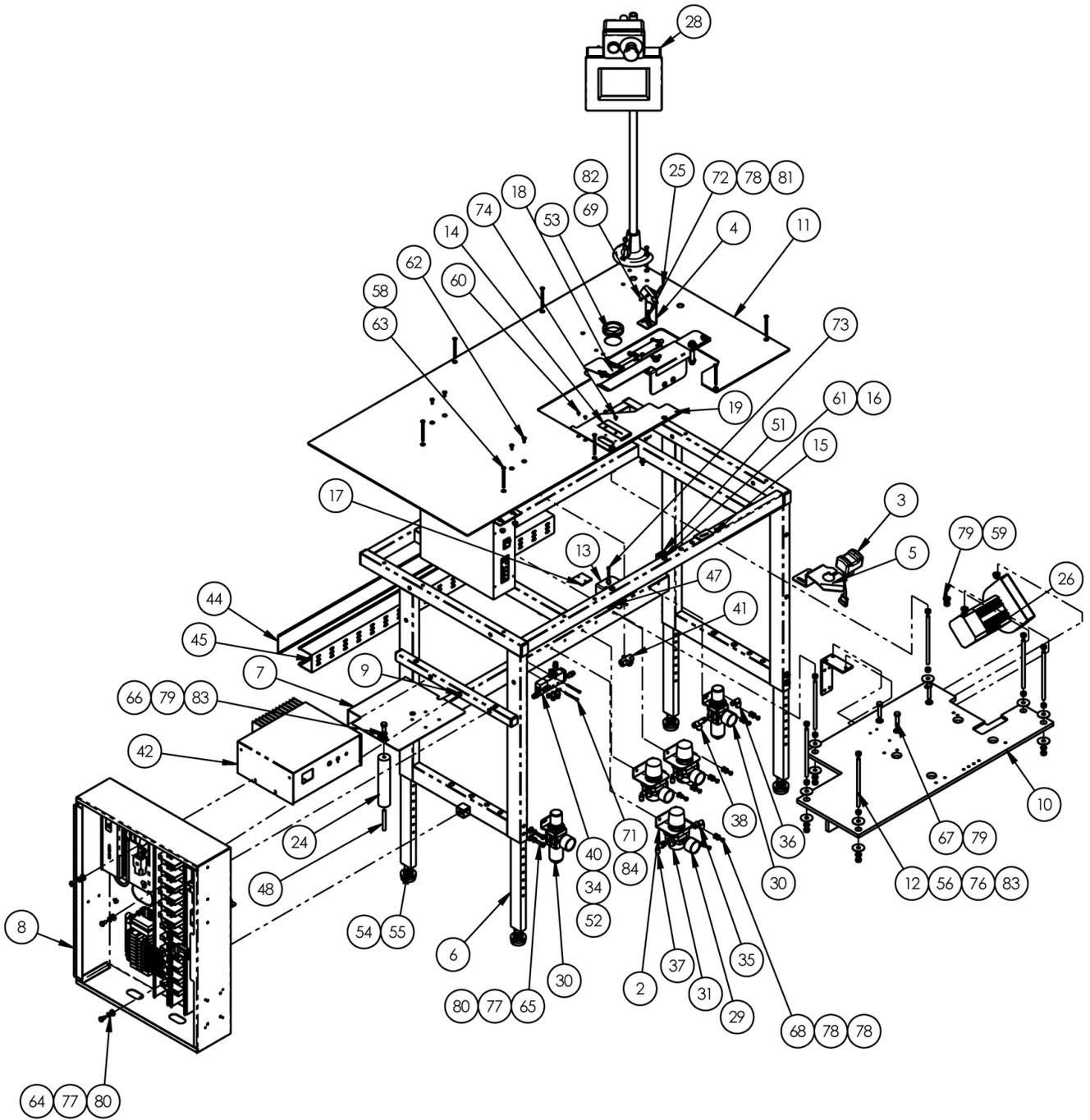
1335764 Base Console Assembly

AAC Drawing Number 1335764 Rev0

NO.	QTY	PART #	DESCRIPTION
1	1	0411-069D	BRKT, THREAD BRK DETECTIO
2	1	0411-070	CLAMP, SENSOR BRACKET
3	1	1335500	DO NOT USE SEE 1335698
4	1	1335697	RUFFLER ASSEMBLY
5	1	1335762	SEW HEAD ASSY,1335MG,HD
6	1	1959-112	2 POS THREAD PLATE ASSY
7	1	26151	TOOL TRAY, 1X3.5X9
8	2	4003-IS3WT2	SENSOR,THREAD BREAK
9	1	97-2250A	SPACER, THREAD STAND
10	2	SSSC05040	1/4-28 X 5/8 SOC CAP
11	2	SSSC98032	#10-32 X 1/2 SOC CAP
12	1	SSSCM6X20	M6-1.0 X 20 SOC CAP
13	1	WWF5/8	WASHER, FLAT, 5/8
14	3	WWFS1/4	WASHER FLAT, 1/4
15	2	WWFS10	WASHER, FLAT #10
16	3	WWL1/4	1/4 LW
17	2	WWL10	#10 LW
18	1	ZX3833	V-BELT,3/8 X 33

Page 44

Page 52



1335500 Stand & Motor Assembly

AAC Drawing Number 1335500 Rev7

Page 54

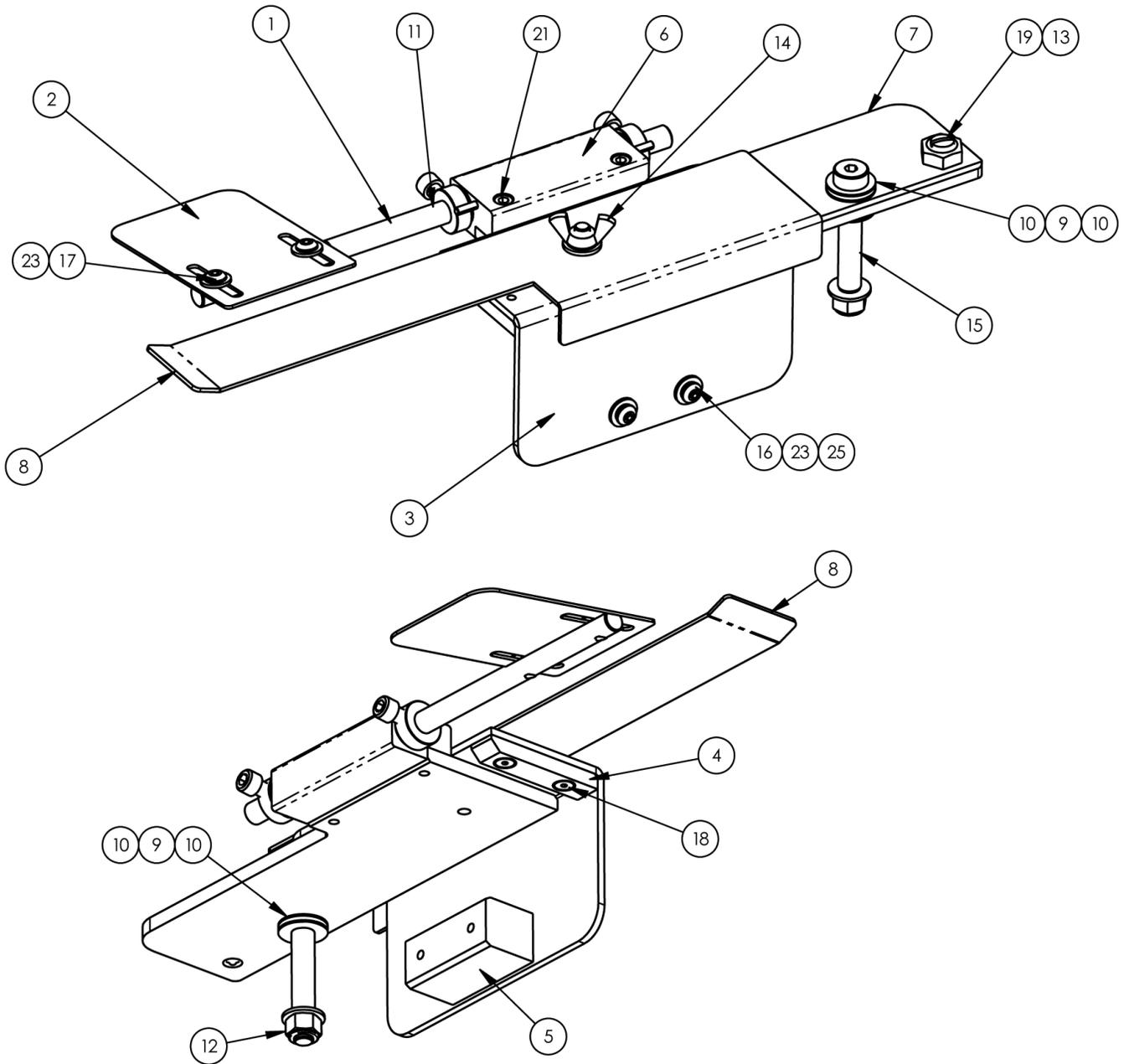
Page 42

Page 70

Page 72

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
NS	1	0211-702A	CABLE, POS SENSOR	43	1	CCCL12F	CLAMP COLLAR- 3/4
2	3	0411-071	BRKT,REGULATOR	44	3*	EEDC2X2	COVER, WIRE DUCT
3	1	1278-6602	TOUCH SWITCH ASSEMBLY	45	3*	EEDF2X2	DUCT, WIRE, 2X2, MOD
4	1	1278-6689B	BRACKET, EYE MOUNT	NS	1	FFHBL4579C	RECEPTACLE, 3 POLE, 3W
5	1	1278-6718A	BRKT,OPTO TOUCH SWITCH	47	2	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
6	4	132556-273	LEG, 3/4 X 1-1/2 X 15 LG	48	1	K-102-21	ROD,TH,5/16-18,2-1/2L
7	1	1335234	MTG. BRKT. STEP BOX	49	2	MM132-1202	END CAP,SQUARE,BLACK
8	1	1335370	CONTROL BOX, SBUS	50	4	MM132-1420	PLUG 1 X 1 1/2
9	1	1335432	FRAME WELDT, 1335M GENERI	51	1	MM1676A12	MAGNETIC CATCH
10	1	1335443	SEWHEAD SUPPORT PLT WELDT	52	2	MM4554K11	PLUG, 1/8" PIPE
11	1	1335454	MAIN TABLE TOP 2002P	53	1	MM9307K75	GROMMET,1.5ID,2.125OD,.13GV
12	6	1335464	ROD THRD,5/16-18	54	4	MMFB4444	FOOT, RUBBER
13	1	1335465	PINCH CYL/ EYE MOUNT	55	4	NNH1/2-13	NUT,HEX,1/2-13
14	1	1335470	PANEL TENSION FINGER-SS T	56	18	NNH5/16-18	5/16-18 HEX NUT
15	1	1335479	PIVOT STOP, DETENT	57	1	NNHM4X0.7	NUT,HEX,M4-0.7
16	2	1335490	LOCATING DISK, TABLE INS	58	12	NNK10-32	KEP NUT, 10-32
17	1	1335502	LOCK TAB, TABLE INSERT-18	59	3	NNK5/16-18	KEP NUT, 5/16-18
18	1	1335505	STRIPPER BLADE ASSY	60	2	SSFC80016	6-32 X 1/4 FLAT SOC CAP
19	1	1335509	TABLE INSERT - MG2002	61	2	SSFC98024	#10-32 X .375 FLAT CAP
NS	AR	1335M-LAB	LABELS	62	4	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
NS	AR	1335MFB-PD	DIAGRAM, PNEUMATIC	63	8	SSFC98240	#10-32 X 2.5 FLAT CAP
NS	AR	1335MFB-WD	DIAGRAM, WIRING	64	4	SSHC01032	1/4-20 X 1/2 HHCS
NS	1	1335MGBCAB	CABLE PACKAGE	65	8	SSHC01048	1/4-20 X 3/4 HEX CAP
24	1	1338-018	SPACER, HEAD	66	1	SSHC10048	5/16-18 X 3/4 HHCS
25	2	1975-412A	PLATE,NUT,4-40,.95CTC	67	3	SSHC10096	5/16-18 X 1-1/2 HHCS
26	1	4059-DC1500	MOTOR & CONTROLLER	68	10	SSPP98024	10-32 X 3/8 PAN HD PHILIP
NS	1	4080-4508B	CABLE, MOTOR	69	4	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
28	1	97-1700A	TOUCH SCREEN ASSEMBLY	70	2	SSSC70080	4-40 X 1-1/4 SOCKET CAP
29	3	AA198-503	0-30PSI AIR GAGE 1/8NPT	71	2	SSSC80112	6-32 X 1-3/4 SOC CAP SC
30	2	AA198-5102	REGULATOR W/GAUGE & NUT	72	6	SSSC98032	10-32X1/2, SOC CAP
31	3	AA198-RP3	REGULATOR,PRECISION AIR	73	1	SSSCM4X40	SCREW,SOC CAP,M4-0.7X40
32	2	AA198RA510	FLOW CONTROL,5/32X10-32	74	2	SSTP80016	6-32 X 1/4 TRUSS PH.
33	1	AACNCQ2B16-10D	COMPACT, 16MM BORE, 10MM	75	2	TTH32425	HANDLE,THRDED,5/16-18X3/4
34	6	AAQMC-5-8	QU. MALE CONN 5/32X1/8	76	12	WWFE020	WASHER,FENDER,5/16
35	3	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT	77	12	WWFS1/4	WASHER,FLAT,SAE,1/4
36	1	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8	78	34	WWFS10	WASHER, FLAT, #10, SAE
37	3	AAQME-5-4	ELBOW, MALE 5/32X1/4NPT	79	7	WWFS5/16	WASHER,FLAT,SAE,5/16
38	1	AAQMT-4-8	MALE RUN T 1/4 X 1/8 NPT	80	12	WWL1/4	WASHER,LOCK,1/4
NS	2	AAQUY-4-4	QUICK UNION Y, 1/4"	81	10	WWL10	WASHER,LOCK,#10,S/S
40	1	AAV125B	PILOT VALVE	82	6	WWL4	WASHER,LOCK,#4
41	1	AAVS125	SHUTTLE VALVE,1/8"PORT	83	7	WWL5/16	WASHER, LOCK, 5/16
42	1	AP-28-800Y1	BOX,STEPPER,H.S. (X5)	84	2	WWL6	WASHER,LOCK,#6

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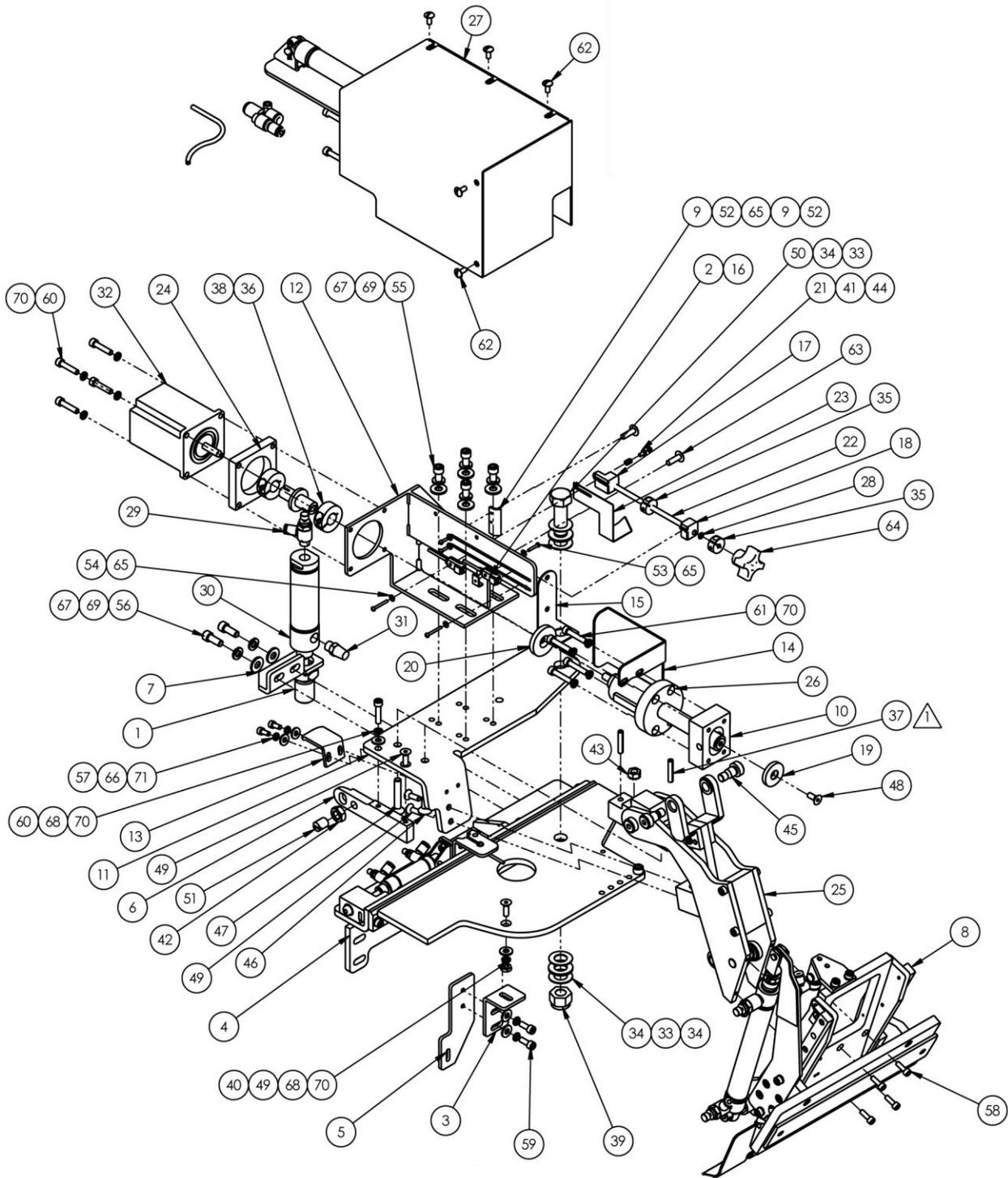


1335505 Stripper Blade Assembly

AAC Drawing Number 1335505 Rev3

NO.	QTY	PART #	DESCRIPTION
1	1	1335474	PIVOT ROD, STRIP BLADE
2	1	1335475	STRIPPER BLADE-1804P
3	1	1335476	EDGE GUIDE, STRIP BLADE
4	1	1335489	PIVOT WEARPLATE
5	1	1335493	BLOCK, SWINGOUT PLATE
6	1	1335506	PIVOT BLOCK, STRIPPER BLA
7	1	1335508	PIVOT PLATE WELD'T
8	1	1335732	BRACKET, PANEL EYE TAPE
9	2	BBNTA613	BEARING, THRUST, 375BORE
10	4	BBTRA613	WASHER, THRUST, STL, .375B
11	2	CCSC6F3_8	COLLAR, SET 3/8
12	1	NNE5/16-18	NUT, ELASTIC LOCK, 5/16-18
13	1	NNJ3/8-16	3/8-16 JAM NUT
14	1	NNW1/4-20	NUT, WING, 1/4-20
15	1	SSAS024128	SHULDER BOLT 3/8 X 2.0L
16	2	SSBC95040	10-24 X 5/8 BUTTON CAP SC
17	2	SSBC98024	10-32 X 3/8 BUTTON CAP SC
18	2	SSFC90024	8-32 X 3/8 FL ALN CAP
19	1	SSMB58N	PLUNGER, BALL, 3/8-16X5/8L
20	2	SSSC01024	1/4-20 X 3/8 SOC CAP SC
21	2	SSSC98032	10-32X1/2, SOC CAP
22	1	WWFS1/4	WASHER, FLAT, SAE, 1/4
23	4	WWFS10	WASHER, FLAT, #10, SAE
24	1	WWFS5/16	WASHER, FLAT, SAE, 5/16
25	2	WWL10	WASHER, LOCK, #10, S/S

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1335697 Ruffler Assembly

AAC Drawing Number 1335697 Rev2

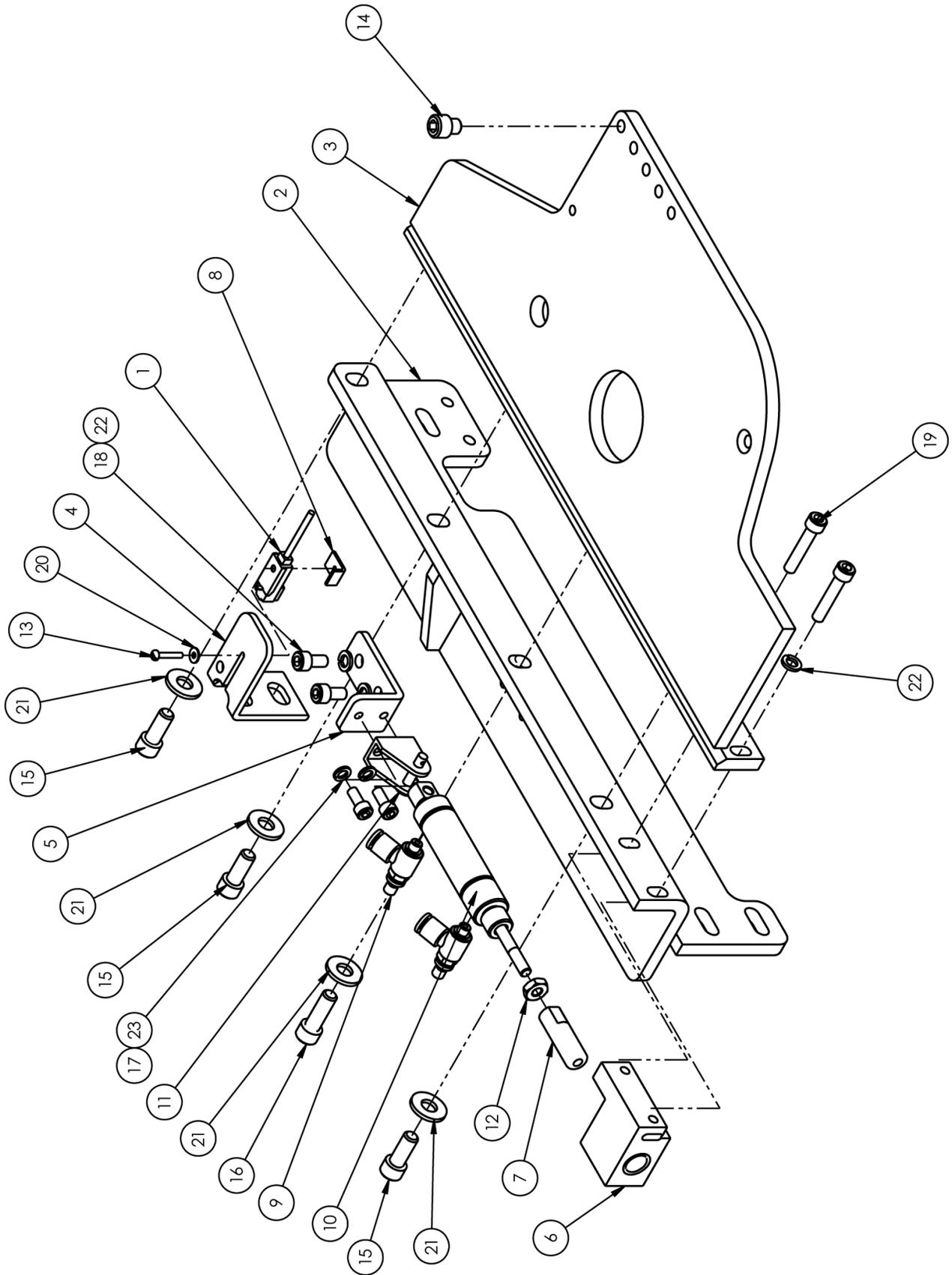
Page 46

Page 48

Page 50

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	11200A	BUMPER 5/16-24	37	2	IIS012X064	SPRING PIN 3/16 DIA
2	2	1278-7055D	PROX SWITCH W/PLUG,12"	38	1	MM8FM	JOINT,UNIVERSAL,MOD
3	1	1335218	ADJ ANGLE-RUFFLER SUPP	39	1	NNE1/2-13	NUT, ELASTIC 1/2-13
4	1	1335298	RUFFLER MNT ASSY,MG2002P	40	1	NNH10-32	#10-32 HEX NUT
5	1	1335323	SUPPORT BRKT-RUFFLER	41	1	NNH2-56	#2-56 HEX NUT
6	1	1335324	LOCKING LEVER	42	1	NNJ3/8-16	3/8-16 HEX JAM NUT
7	1	1335328	FOOT LIFT BRKT	43	1	NNK1/4-20	KEP NUT, 1/4-20
8	1	1335690	RUFFLER CYL LIFT ASSY	44	1	RRLC026B1	SPRING,COMP .026X.18X.25
9	1	1335M-001	BRACKET, STOP, PRX SWITCH	45	2	SSAS024024M	3/8 X 3/4 X 5/16-18
10	1	1335M-2006	BLOCK, NUT TRUNION	46	1	SSFC01040	1/4-20 X 5/8 FLAT ALLEN
11	1	1335M-2008	PIVOT PLATE	47	1	SSFC01096	1/4-20 X 1-1/2 FLAT ALLEN
12	1	1335M-2016	MTG BRKT WELDT	48	1	SSFC98032	#10-32 X 1/2 FLAT ALLEN
13	1	1335M-2020	HLD DWN BRKT	49	4	SSFC98040	#10-32 X 5/8 FLAT ALLEN
14	1	1335M-2021	VANE, SWITCH ACTUATING	50	1	SSHC45096	1/2-13 X 1 1/2 L HHCS
15	1	1335M-2031	PIVOT BRKT AIR LINE	51	1	SSMB58N	PLUNGER,BALL,3/8-16X5/8L
16	1	1335M-2034	PLATE, NUT #2-56	52	2	SSPS50020	#2-56 X 5/16 PAN HD SLOT
17	1	1335M-2035	ADJUSTMENT NUT, 10-32	53	1	SSPS50032	#2-56 X 1/2 PAN HD SLOT
18	1	1335M-2036	SUPPORT BLOCK	54	2	SSPS50048	#2-56 X 3/4 PAN HD SLOT
19	1	1335M-2037	WASHER, STOP	55	4	SSSC01032	1/4-20 X 1/2 SOC CAP
20	1	1335M-2038	STOP WASHER	56	2	SSSC01040	1/4-20 X 5/8 SOC CAP
21	1	1335M-2039	NUT,SPRING RETAINER	57	2	SSSC90024	#8-32 X 3/8 SOC CAP
22	1	1335M-2040	SCREW, ADJUSTMENT	58	4	SSSC90032	#8-32 X 1/2 SOC CAP
23	1	1335M-2047	POINTER, RUFFLE SIZE	59	2	SSSC98032	#10-32 X 1/2 SOC CAP
24	1	1335M-2049	SPACER, MOTOR, 3/8	60	5	SSSC98056	#10-32 X 7/8 SOC CAP
25	1	1335M-2300B	PIVOT ASSY	61	4	SSSC98064	#10-32 X 1 SOC CAP
26	1	1335M-2400	BALL SCREW AND NUT	62	5	SSTS90024	#8-32 X 3/8 TRUSS HD
27	1	1335M-KIT114	UPDATE,FOLDER SUPP CYL.	63	2	SSTS98040	#10-32 X 5/8 TRUSS HD
28	1	AA198-7006	O RING, 1/8 ID, 1/4 OD	64	1	TTCL1APPK1	PLASTIC KNOB, #10-32
29	1	AA198RR508	FLOW CONTROL,5/32 X 1/8"	65	5	WWF2	WASHER, FLAT #2
30	1	AAC6D-1.5	CYL, AIR, DA 1-1/16 B,1.5 S	66	2	WWF8	WASHER, FLAT #8
31	1	AAFP18	MUFFLER,1/8 NPT, BRONZ	67	6	WWFS1/4	WASHER FLAT, 1/4
32	1	AP-22E-103	STEP MOTOR,MODIFIED	68	4	WWFS10	WASHER, FLAT #10
33	2	BBNTA815	BEARING,THRUST,1/2BORE	69	6	WWL1/4	1/4 LW
34	4	BBTRA815	WASHER,THRUST,STEEL 1/2	70	12	WWL10	#10 LW
35	2	CCCL10T	CLAMP COLLAR TRD, 10-32	71	2	WWL8	#8 LW
36	2	CCCL8F	CLAMP COLLAR- 1/2				

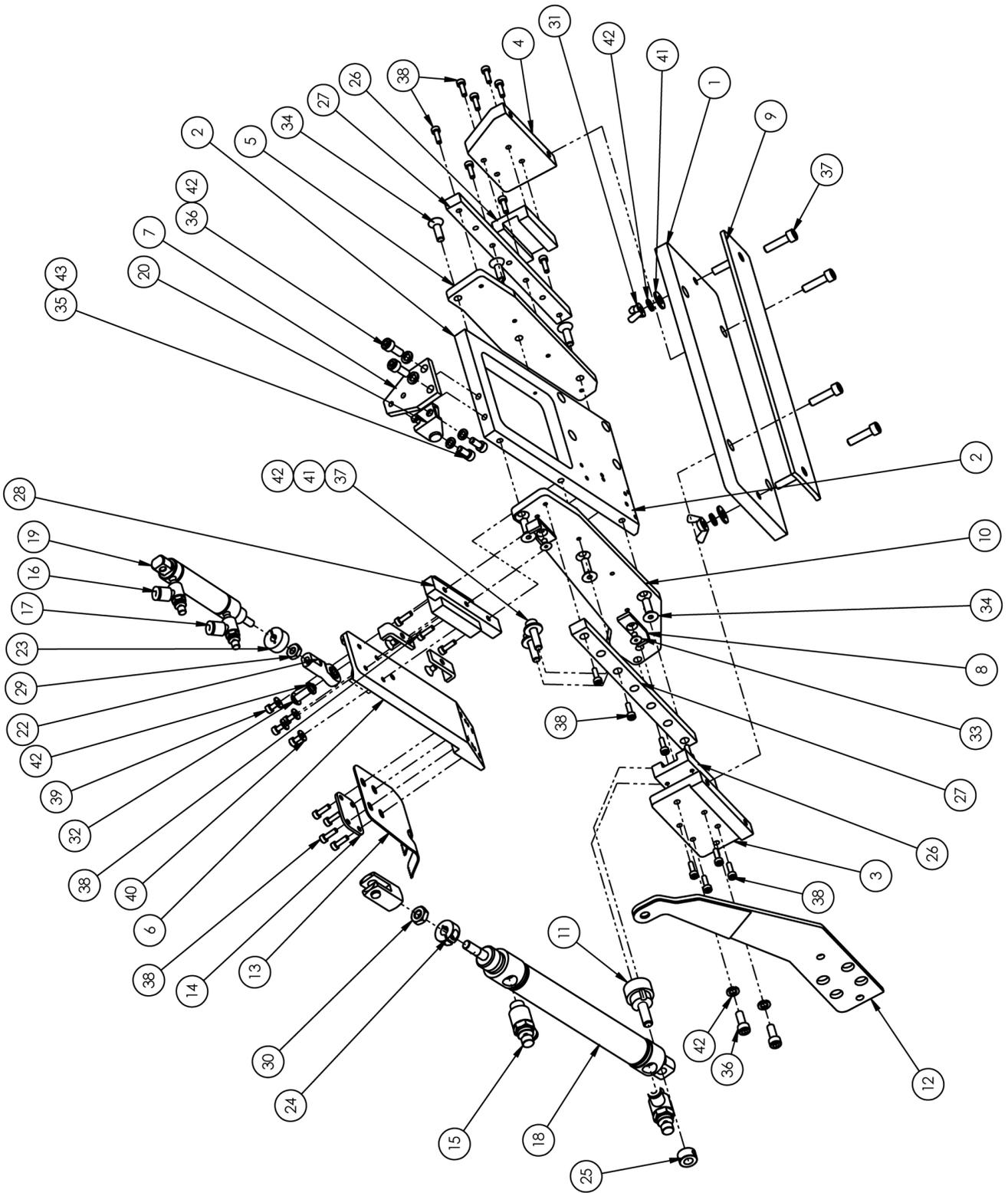
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1335298 Ruffler Mount Assembly

AAC Drawing Number 1335298 Rev3

NO.	QTY	PART #	DESCRIPTION
1	1	1278-7055D	PROX SWITCH W/PLUG,12"
2	1	1335314	RUFFLER MTG BRKT WELDT
3	1	1335315	BASE PLATE, RUFFLER MTG
4	1	1335325	MTG. BRKT. SENSOR
5	1	1335330	MTG. BRKT. LOCK PIN CYL.
6	1	1335334	CYL. MOUNT
7	1	1335M-2017	ROD, END
8	1	1335M-2034	PLATE, NUT #2-56
9	2	AA198RA510	FLOW CONTROL,5/32X10-32
10	1	AAC8DP-.5	CYL,AIR,DA,9/16 B,1/2S
11	1	AAFBP-8C	BRKT,PIVOT,5/32 BORE
12	1	NNH10-32	#10-32 HEX NUT
13	1	SSPS50032	#2-56 X 1/2 PAN HD SLOT
14	1	SSSC01016S	1/4-20 X 1/4 SOC CAP SC
15	3	SSSC01040	1/4-20 X 5/8 SOC CAP
16	1	SSSC01048	1/4-20 X 3/4 SOC CAP
17	2	SSSC90024	#8-32 X 3/8 SOC CAP SC
18	2	SSSC98024	#10-32 X 3/8 SOC CAP
19	2	SSSC98064	#10-32 X 1 SOC CAP
20	1	WWF2	WASHER, FLAT #2
21	4	WWFS1/4	WASHER FLAT, 1/4
22	4	WWL10	#10 LW
23	2	WWL8	#8 LW

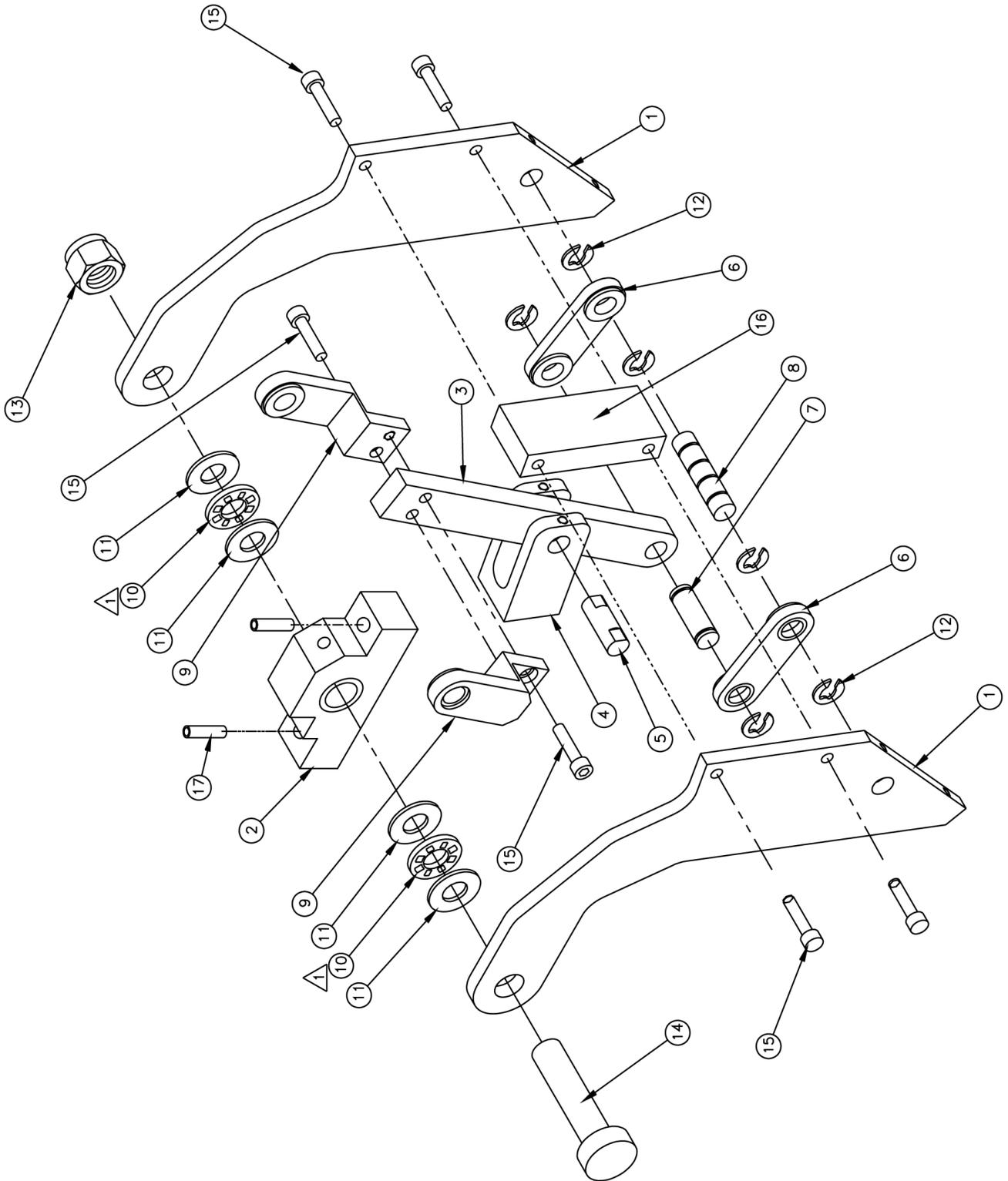


1335690 Ruffler Cylinder Lift Assembly

AAC Drawing Number 1335690 Rev2

NO.	QTY	PART #	DESCRIPTION
1	1	1335223	BASE MTG PLT, FOLDER
2	1	1335224	BASE MTG PLATE
3	1	1335227	SUPPORT-SLIDE, LH SIDE
4	1	1335228	SUPPORT, RH
5	1	1335229	MTG PLT RH- RAIL
6	1	1335335	MTG PLT- HEAVY DUTY
7	1	1335336	CYL. MOUNTING PLATE
8	4	1335338	BRG STOP
9	1	1335691	STUD PLATE
10	1	1335692	PLATE,MNT,LH RAIL
11	1	1335705	STUD, CYLINDER MNT
12	1	1335713	LIFT ARM WELDMENT
13	1	1335M-2002D	BLADE,RUFFLER,10TPI
14	1	1335M-5004	PLATE, WASHER, 136DIA@4PL
15	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"
16	1	AA198RA510	FLOW CONTROL,5/32X10-32
17	1	AA198RR510	REV FL CONT,5/32X10-32
18	1	AAC7DP-4	CYLINDER,AIR,DA
19	1	AAC8DP-1	CYL, AIR, DA, 9/16B, 1S
20	1	AAFBP-8C	BRKT,PIVOT,5/32 BORE
21	1	AAFCT-7	CLEVIS,AIR CYL, 1/4-28
22	1	BBAW-3Z	BRG,ROD END,F, 10-32
23	1	CCCL3F	CLAMP COLLAR- 3/16
24	1	CCCL4F	COLLAR,1/4,CLAMP
25	1	CCSC41/4	COLLAR,SET 1/4"
26	3	MMGN12HZ0HN	MGN12H BEARING BLOCK
27	2	MMGNR12R0165HN	165MM RAIL - MGN12H BLK
28	1	MMGNR12R76HN	76MM RAIL - MOD
29	1	NNH10-32	#10-32 HEX NUT
30	1	NNJ1/4-28	1/4-28 HEX JAM NUT
31	2	NNW10-32	#10-32 WING NUT
32	1	SSBC98040	#10-32 X 5/8 BUT HEAD
33	4	SSFC80016	#6-32 X 1/4 FLAT ALLEN
34	6	SSFC98040	#10-32 X 5/8 FLAT ALLEN
35	2	SSSC90024	#8-32 X 3/8 SOC CAP
36	4	SSSC98032	#10-32 X 1/2 SOC CAP
37	6	SSSC98048	#10-32 X 3/4 SOC CAP
38	23	SSSCM3X10	M3-0.5 X 10 SOC CAP
39	4	SSSCM3X6	M3-0.5 X 6 SOC CAP
40	4	WWF4	WASHER, FLAT #4
41	4	WWFS10	WASHER, FLAT #10
42	9	WWL10	#10 LW
43	2	WWL8	#8 LW

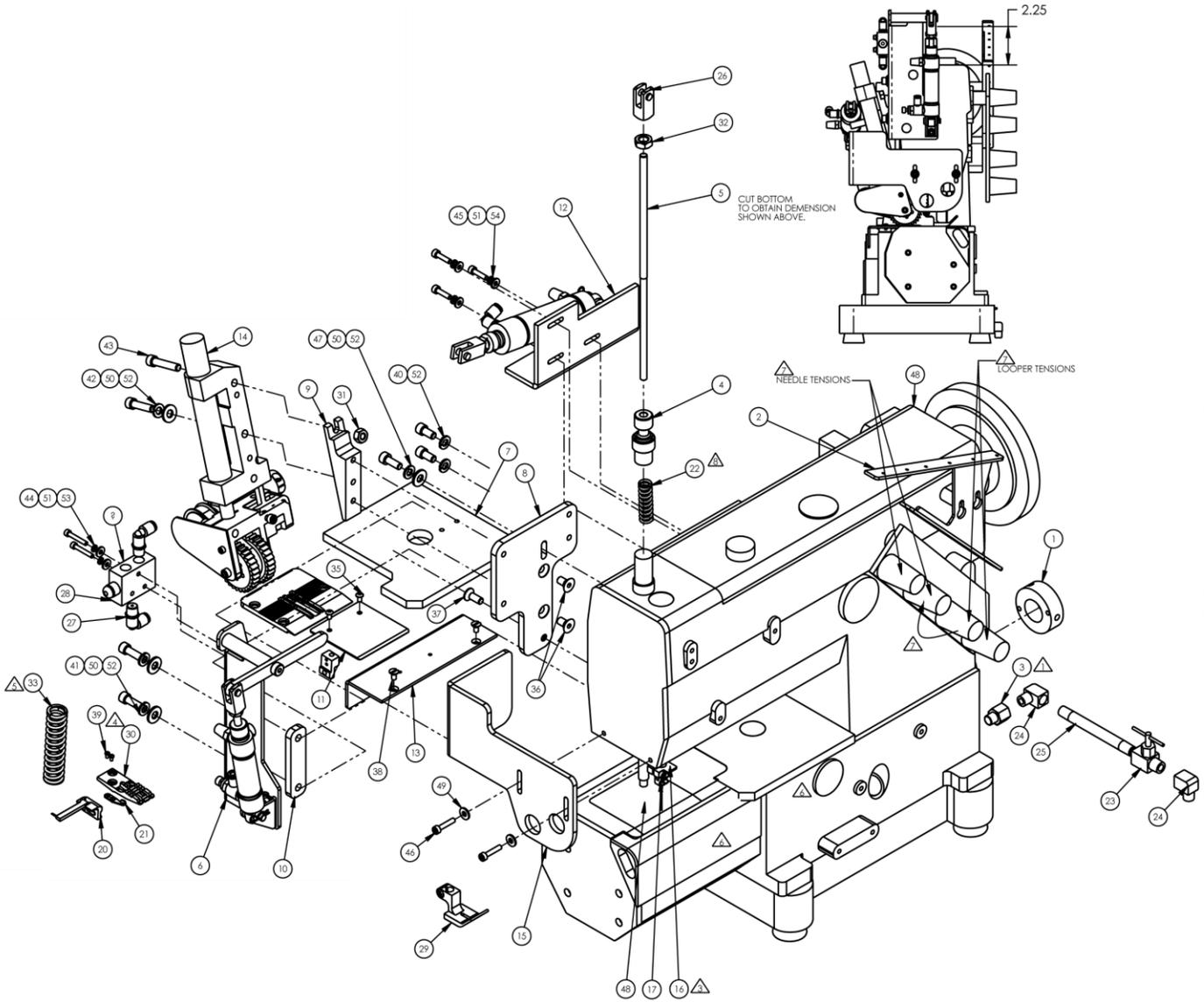
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1335M-2300B Pivot Assembly

AAC Drawing Number 192985C Rev3

NO.	QTY	PART #	DESCRIPTION
1	2	1335M-2004A	Pivot Arm
2	1	1335M-2007	Pivot Block
3	1	1335M-2009	Drive Link
4	1	1335M-2010	Pivot Block
5	1	1335M-2011	Pivot Shaft
6	2	1335M-2012	Side Link
7	1	1335M-2013	Link Shaft
8	1	1335M-2014	Link Shaft
9	2	1335M-2015	Link Yoke
10	2	BBNTA815	Thrust Bearing
11	4	BBTRA815	Thrust Washer
12	6	MM8407A134	E-Ring
13	1	NNE1/2-13	Elastic Lock Nut
14	1	SSHC45160	Screw, Hex Cap
15	6	SSSC98048	Screw, Socket Cap
16	1	1335373	Spacer
17	2	IIS012X064	Spring Pin



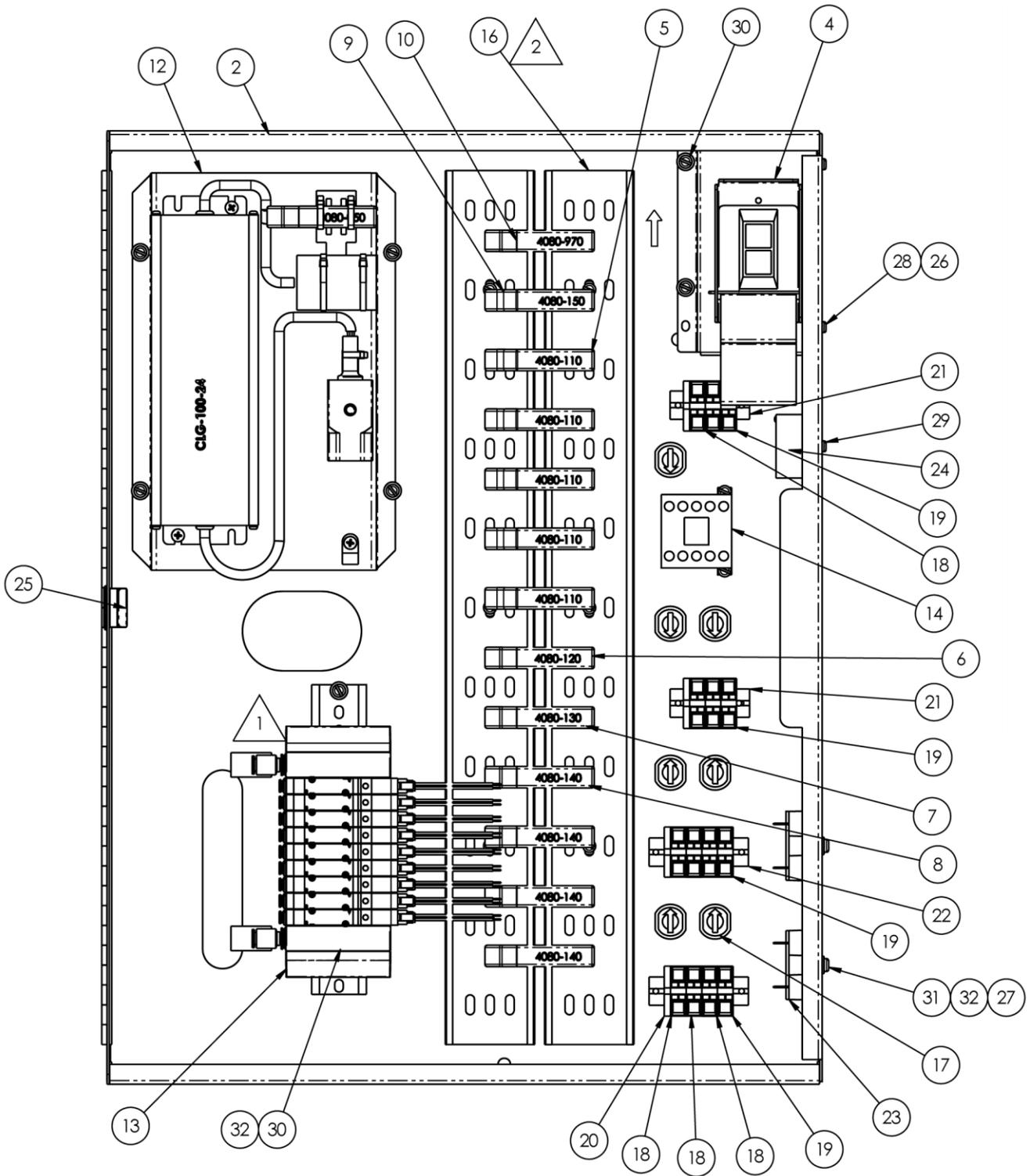
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1335762 Sewing Head Assembly

AAC Drawing Number 1335762 Rev3

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1278-6364	DISC, TAPE MOUNTING	28	1	AAV41-P	HUMPHREY VALVE,4 WAY
2	1	1325-013	THREAD GUIDE,MODIFIED	29	1	M1Y88-003	FOOT, SN, 1335MG
3	1	1335-109	ADAPTER,DRAIN PLUG	30	1	M2Y88-002	FEED DOG,1N,HEAVY DUTY
4	1	1335208	FOOT LIFT ADJ - MOD	31	1	NNH1/4-20	1/4-20 HEX NUT
5	1	1335209	FOOT LIFT PIN	32	1	NNJ3/8-16	3/8-16 HEX JAM NUT
Page 55	6	1335271	FOOT PRESSURE ASSY	33	1	RRLC105J10	SPRING,COMP .105X.75X3.0
7	1	1335308	SEWHEAD PLATE, MOD	NS	AR	SN62X5924	NEEDLE, SIZE 180/24
8	1	1335311	RUFFLER MTG BRKT-YA-1804	35	2	SSBC80016	#6-32 X 1/4 BUT HEAD
9	1	1335312	BRKT, PULLER MOUNT, YAM	36	2	SSFC01032	1/4-20 X 1/2 FLAT ALLEN
10	1	1335313	RUFFLER MTG BRKT-SPACER	37	1	SSFCM6X16	M6-1.0 X 16 FLAT ALLEN
11	1	1335418	PULLER WEAR PLATE	38	2	SSFSM4X8	M4-0.70 X 8 FLAT SLOT
Page 58	12	1335426	PULLER LIFT ASSY-1804P	39	2	SSM200172	SCREW,3/32-48X5/32
13	1	1335431	PLATE, SPACER, HD	40	2	SSSC01032	1/4-20 X 1/2 SOC CAP
Page 60	14	1335750	PULLER ASSY, INTERMIT.,HD	41	2	SSSC01048	1/4-20 X 3/4 SOC CAP
15	1	1335763	PULLER GUARD-HD	42	1	SSSC01064	1/4-20 X 1 SOC CAP
16	1	1825N10S01	THREAD GUIDE	43	1	SSSC01080	1/4-20 X 1-1/4 SOC CAP
17	1	1825N14S01	NEEDLE CHUCK,1N	44	2	SSSC80056	#6-32 X 7/8 SOC CAP
18	1	268602	LOOPER HOLDER, 1NDL	45	3	SSSCM4X16	M4-0.7 X 16 SOC CAP
19	1	268614M	PLATE,THROAT,1N	46	2	SSSCM4X20	M4-0.7 X 20 SOC CAP
20	1	281975	SPREADER BAR 1N	47	1	SSSCM6X16	M6-1.0 X 16 SOC CAP
21	1	4209200M	LOOP GUARD,MODIFIED	48	1	SYAM-MG2002P	SEWING HEAD,YAMATO,2N,NF
22	1	65372	SPRING,PRESSER BAR	49	2	WWF8	WASHER, FLAT #8
23	1	AAF2305-2	NEEDLE VALVE 1/8 NPT	50	4	WWFS1/4	WASHER FLAT, 1/4
24	2	AAF23400-2	"L",BRASS,1/8 FM - 1/8 M	51	5	WWFS6	WASHER, FLAT, #6
25	1	AAF4568K116	NIPPLE,1/4NPT X 3.5L	52	6	WWL1/4	1/4 LW
26	1	AAFCT-7	CLEVIS,AIR CYL, 1/4-28	53	2	WWL6	WASHER,LOCK,6
27	2	AAQME-5-8	QUICK MALE ELBOW	54	3	WWL8	#8 LW

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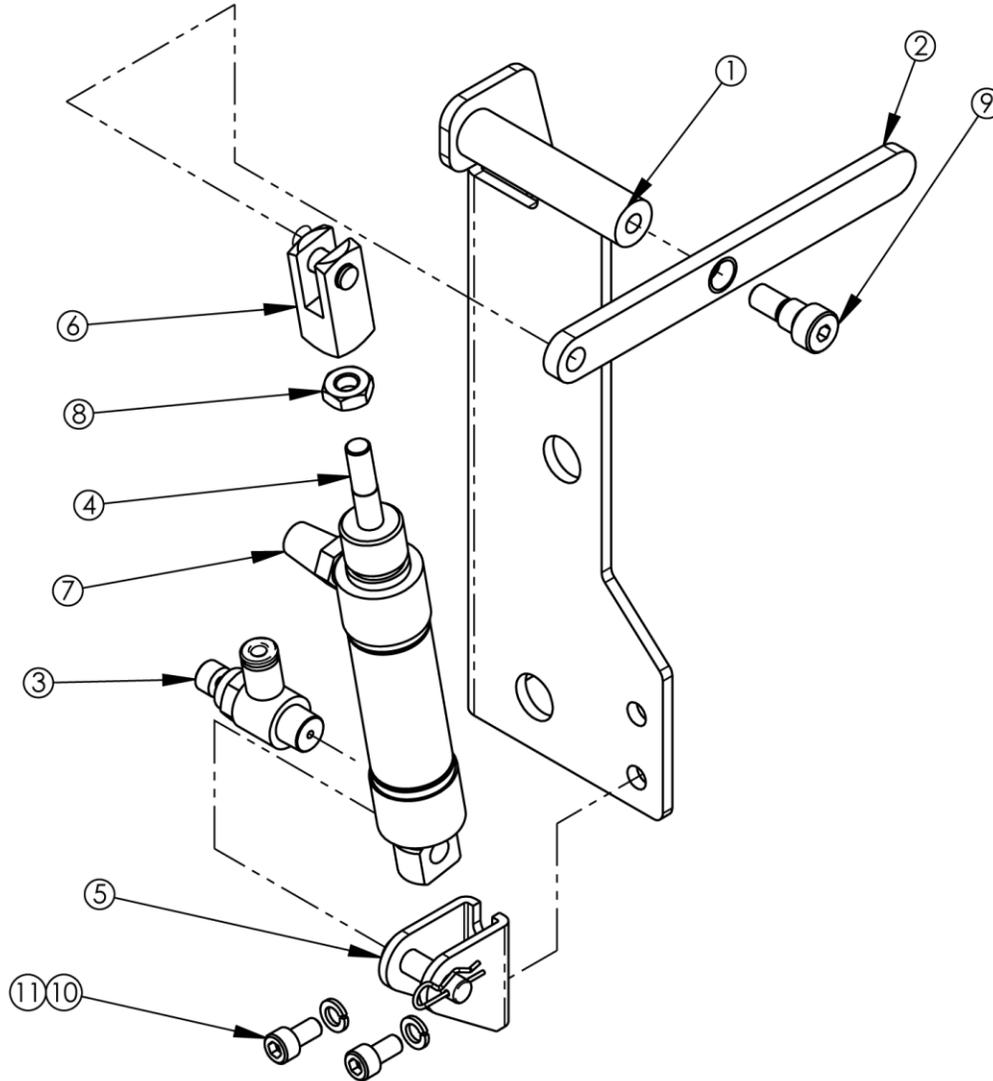
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1335370 Control Box Assembly

AAC Drawing Number 1335370 Rev8

NO.	QTY	PART #	DESCRIPTION
NS	1	1335370CAB	CABLE PACKAGE
2	1	1335372	CONTROL BOX, SBUS
NS	AR	1335MFB-WD	WIRING DIAGRAM
4	1	40-320	AC POWER DISCONNECT ASSY
5	5	4080-110	MODULE,QUAD INPUT
6	1	4080-120	MODULE,DUAL OPTO-ISO
7	1	4080-130	MODULE,QUAD OPTO-ISO
8	4	4080-140	MODULE,QUAD OUTPUT
9	1	4080-150	MODULE,PROGRAM
10	1	4080-970	MODULE,MEMORY
NS	1	4080-980	MODULE, S-BUS-CONT ADAPTER
12	1	4080-990R	POWER SUPPLY,SBUS,CLASS 2
13	1	AAE1335-9	SOLENOID ASSY,9 STATION
14	1	EECA491024	CONTACTOR, MINI, 240V
NS	4	EEDC2X2	COVER,WIRE DUCT
16	4 ft	EEDF2X2	DUCT,WIRE,2X2, MOD
17	8	FF1724	STRAIN RELIEF
18	10	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
19	4	FF264-347	TERMBLK,WAGO,TOP,DUAL,GRN
20	4	FF264-371	TERMBLK,WAGO,TOP,END
21	2	FF264-3BKT2	MOUNT, WAGO, 2" LONG
22	2	FF264-3BKT2.5	MOUNT, WAGO, 2" LONG
23	2	FFD2425F	RELAY,SSR,24VAC,25A
24	1	FFRAV781BW	MODULE, TVS, 240 VAC
25	1	MM40450010	FASTENER,SLIDE LOCK
26	3	NNK6-32	KEP NUT, 6-32
27	4	NNK8-32	KEP NUT, 8-32
28	2	SSPS80024	#6-32 X 3/8 PAN HD SLOT
29	9	SSPS80032	#6-32 X 1/2 PAN HD SLOT
30	16	SSPS90024	#8-32 X 3/8 PAN HD SLOT
31	4	SSPS90032	#8-32 X 1/2 PAN HD SLOT
32	18	WWF8	WASHER, FLAT #8

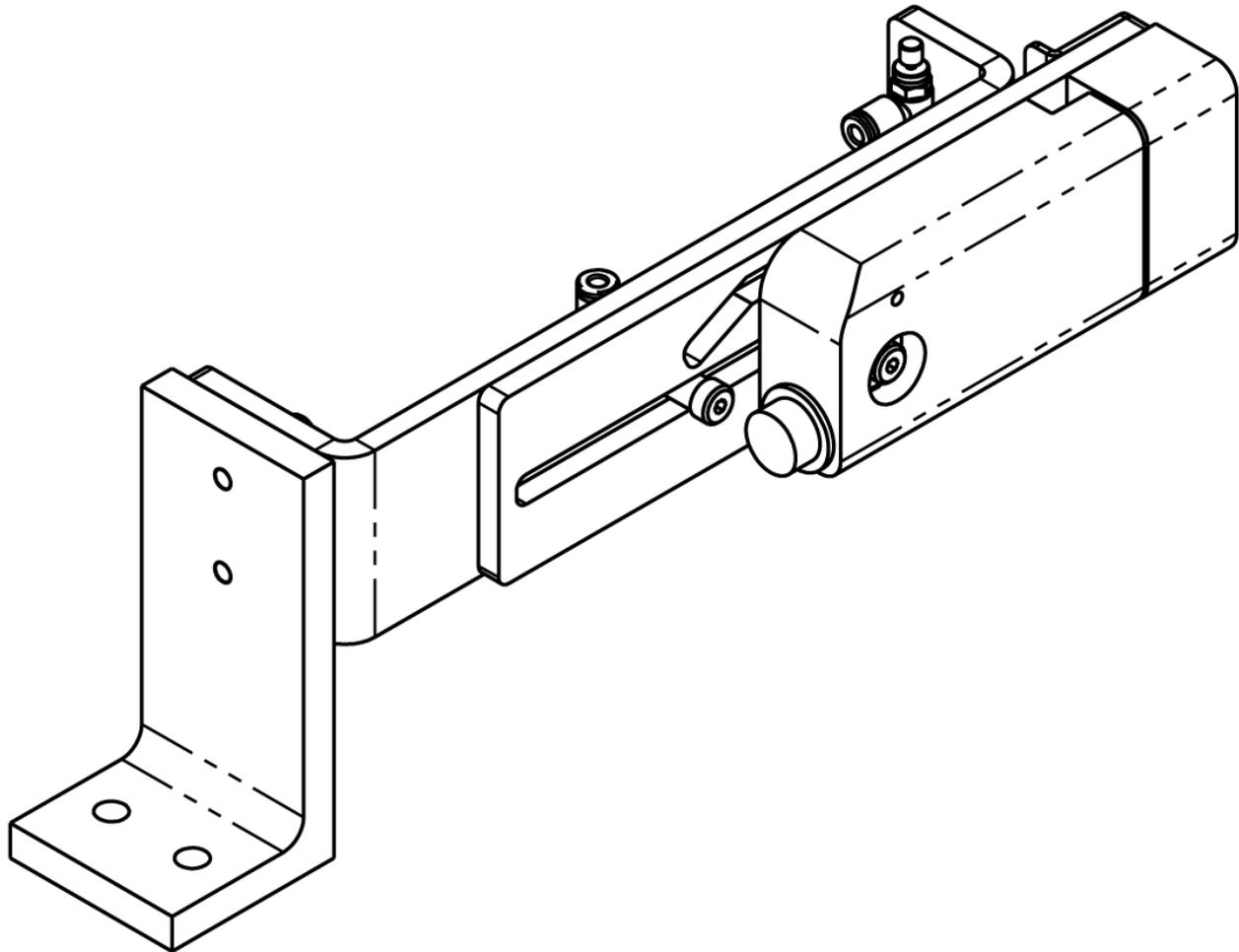
Page 72



1335271 Foot Pressure Assembly

AAC Drawing Number 1335271 Rev2

NO.	QTY	PART #	DESCRIPTION
1	1	1335207	MTG BRKT, FOOT LIFT
2	1	1335M-108	LEVER
3	1	AA198RR508	FLOW CONTROL, 5/32 X 1/8"
4	1	AAC7DP-.5	CYLINDER, AIR, DA
5	1	AAFBP-11C	BRKT, PIVOT, 1/4 BORE
6	1	AAFCT-7	CLEVIS, AIR CYL, 1/4-28
7	1	AAFP18	MUFFLER, 1/8 NPT, BRONZ
8	1	NNJ1/4-28	1/4-28 HEX JAM NUT
9	1	SSAS020016	SHOULDER BOLT 1/4 X 1/4L
10	2	SSSC98024	#10-32 X 3/8 Lg. SHCS
11	2	WWLM6	M6 LOCK WASHER



From the library of: Diamond Needle Corp

3200PMD Marking Module Assembly

AAC Drawing Number 9000107 Rev1

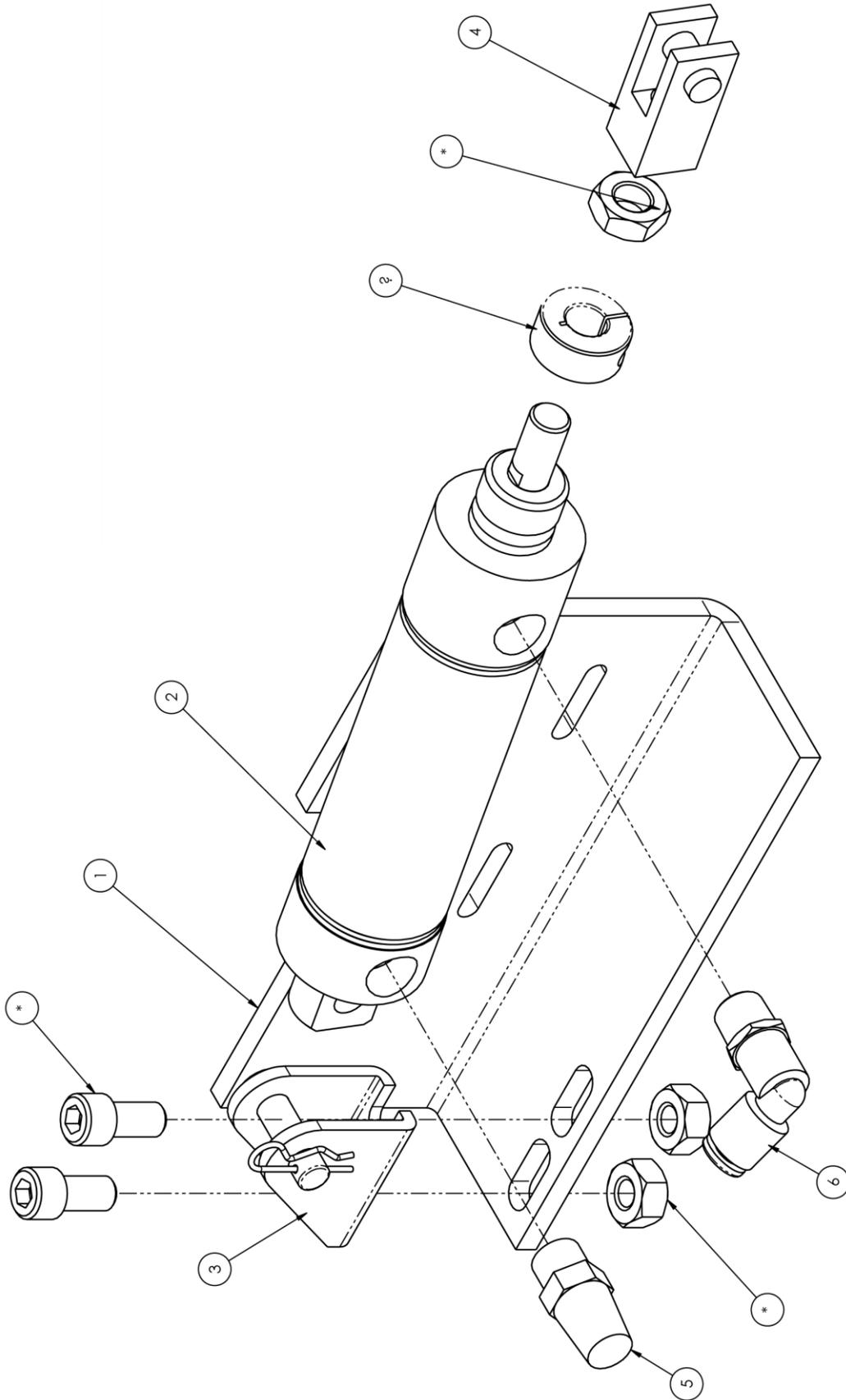
NO.	QTY	PART #	DESCRIPTION
1	1	1335530	BASE CONSOLE, SBUS
2	1	1335575	ROLL HOLDER ASBLY
NS	AR	1335MFB18-PD	PNEUMATIC DIAGRAM
NS	AR	1335MFB18-WD	WIRING DIAGRAM
5	1	3200PMD	MARKING MODULE, EXT MOUNT
6	1	4059-FP301D	FOOT PEDAL ASSY, EFKA
7	1	A-2216V5/8	FOLDER, CONT W/GUSSET

Page 36

Page 71

Page 73

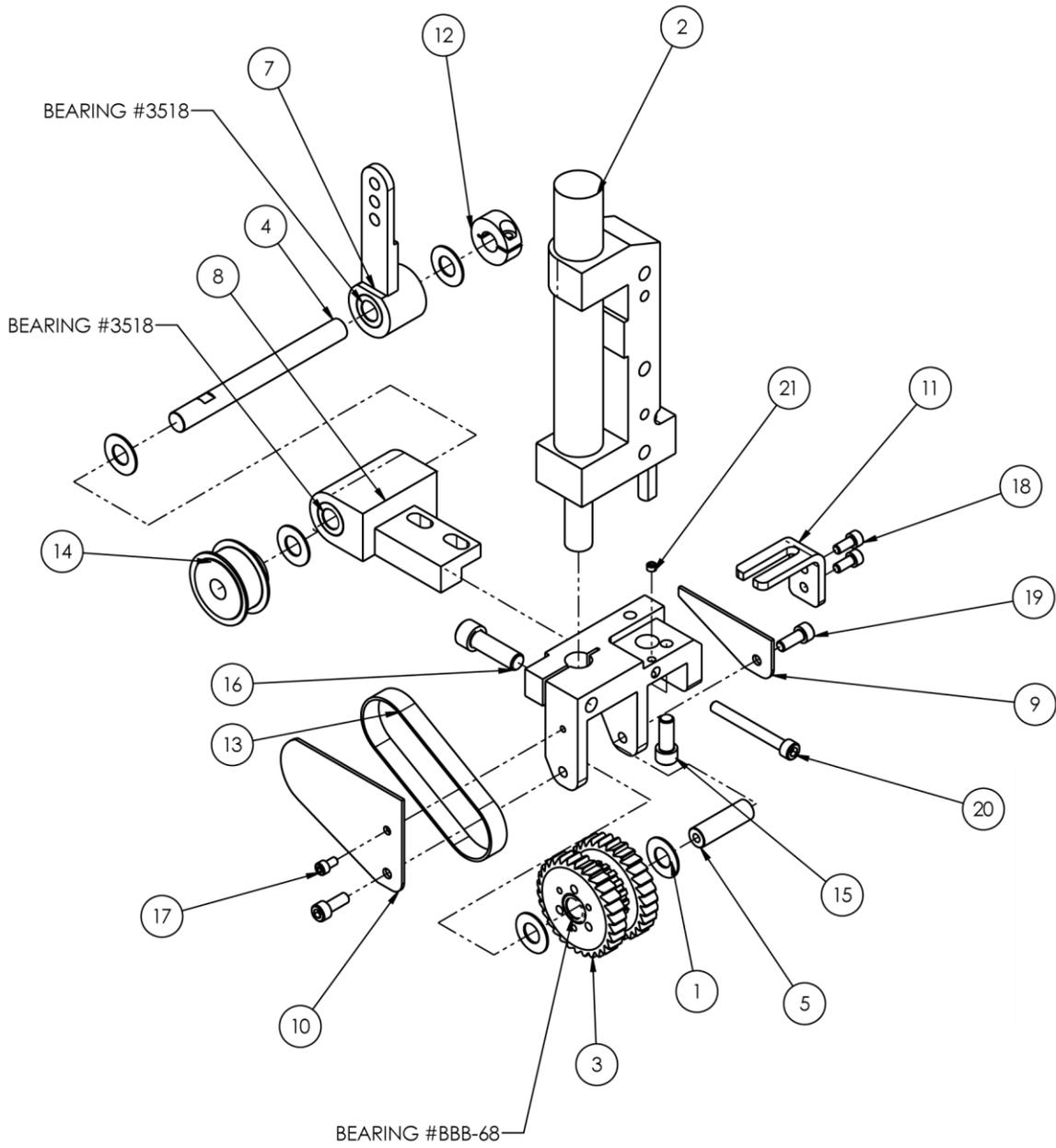
Page 56



1335426 Puller Lift Assembly

AAC Drawing Number 1335426 Rev1

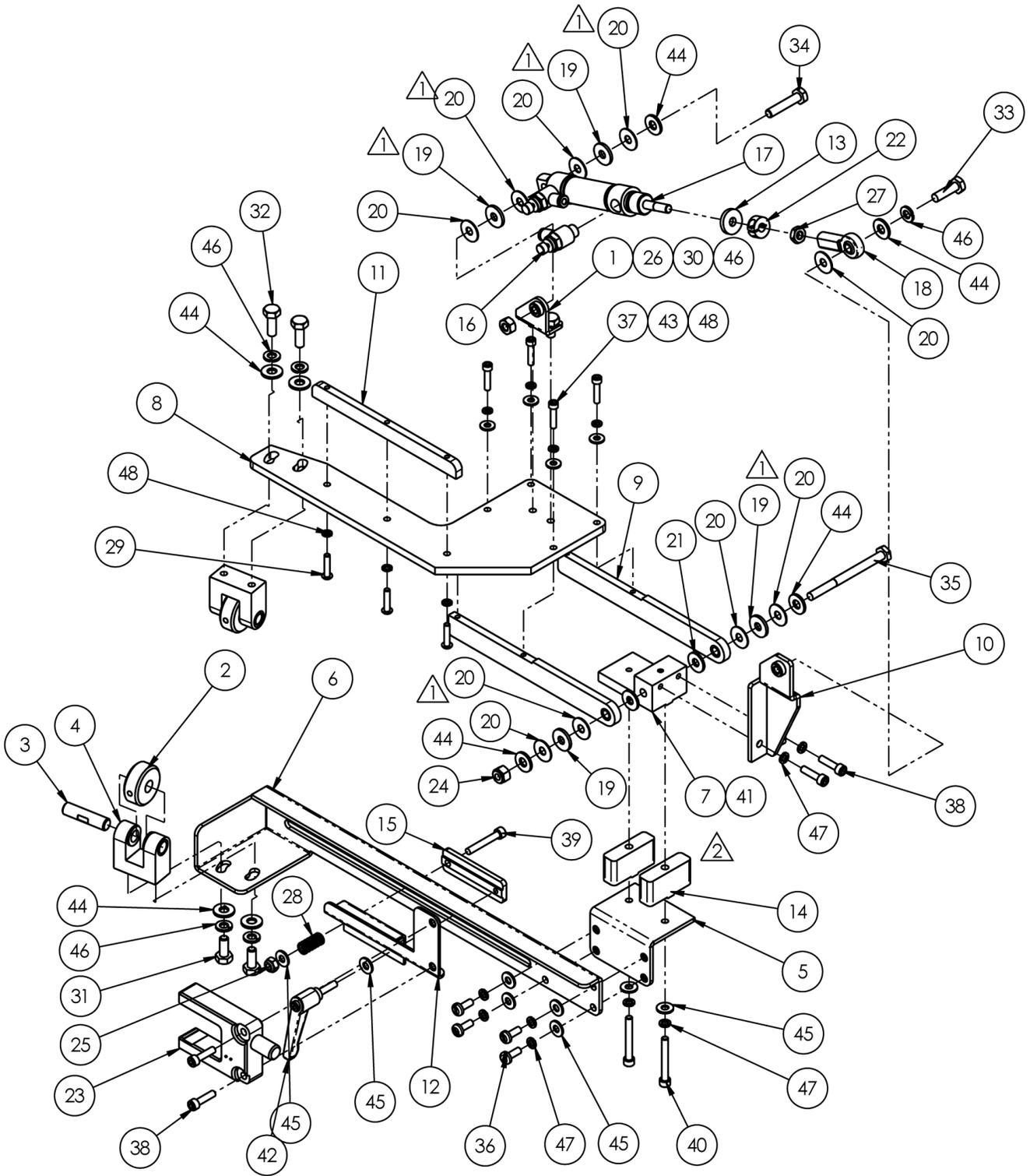
NO.	QTY	PART #	DESCRIPTION
1	1	132556-148D	BRACKET PULLER LIFT-HD
2	1	AAC6DX-1.5	CYLINDER,AIR,DA,PIVOT
3	1	AAFBP-11C	BRKT,PIVOT,1/4 BORE
4	1	AAFCT-11	CLEVIS, CYL, 5/16-24 ,1/4
5	1	AAFP18	MUFFLER,1/8 NPT, BRONZ
6	1	AAQME-5-8	QUICK MALE ELBOW
7	1	CCCL5F	CLAMP COLLAR,5/16" BORE
8	2	NNH1/4-20	1/4-20 HEX NUT
9	1	NNJ5/16-24	5/16-24 HEX JAM NUT
10	2	SSSC01032	1/4-20 X 1/2 SOC CAP



1335750 Puller Assembly

AAC Drawing Number 1335750 Rev3

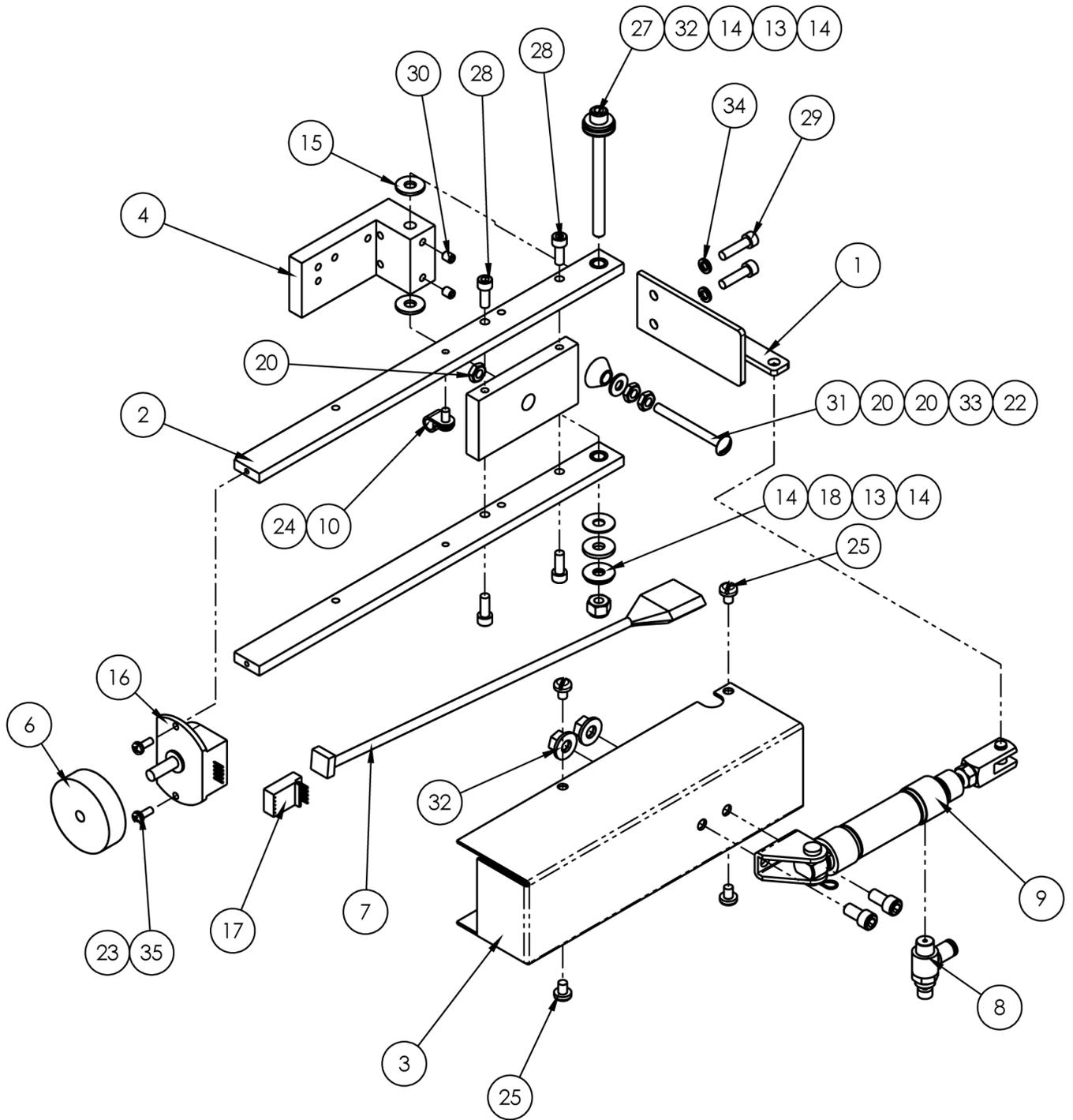
NO.	QTY	PART #	DESCRIPTION
1	5	3517	WASHER, THRUST, BRONZE
2	1	1335394	PULLER, MOD, MG2002/VM1804
3	1	1335743	PULLER ROLLER ASSEMBLY
4	1	1335747	SHAFT, PULLER, HD
5	1	1335748	SHAFT, PULLER, IDLER
6	1	1335749	YOKE, PULLER-HD
7	1	1335751	DRIVE ARM, PULLER, HD
8	1	1335754	CLUTCH HOUSING, PULLER
9	1	1335756	GUARD, RIGHT
10	1	1335757	GUARD, LEFT SIDE
11	1	3100612	UPPER FEED ROLLER YOKE GU
12	1	CCCL6F	CLAMP COLLAR- 3/8
13	1	GG80XL037U	BELT, GEAR, 1/5P, 3/8W, 8"L
14	1	PP18XL037M	PULLEY, GEAR, 1/5P, 18T, 3/8B
15	2	SSSC05040	1/4-28 X 5/8 SOC CAP
16	1	SSSC20064	5/16-24 X 1 SOC CAP
17	1	SSSC85016	#6-40 X 1/4 SOC CAP
18	2	SSSC90024	#8-32 X 3/8 SOC CAP
19	2	SSSC98032	#10-32 X 1/2 SOC CAP
20	1	SSSC98112	#10-32 X 1-3/4 SOC CAP
21	1	SSSS90008	#8-32 X 1/8 KNURL PT



1335659 Guide Roller Assembly

AAC Drawing Number 1335659 Rev2

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1278-6310	CYLINDER MOUNT	25	1	NNE10-32	NUT,ELASTIC LOCK
2	2	1335161	ROLLER KNURLT, .5W	26	1	NNH1/4-20	1/4-20 HEX NUT
3	2	1335164	SHAFT, FLATTED	27	1	NNJ1/4-28	1/4-28 HEX JAM NUT
4	2	1335167	YOKE, LOWER ROLLER	28	1	RRLC045F3	SPRING,COMP .042X.42X.75
5	1	1335654	MOUNT, GUIDE ROLLER	29	3	SSBC90048	#8-32 X 3/4 BUT HEAD
6	1	1335655	SUPPORT, LOWER	30	2	SSHC01032	1/4-20 X 1/2 HEX HEAD
7	1	1335656	BLOCK, PIVOT	31	2	SSHC01040	1/4-20 X 5/8 HEX HEAD
8	1	1335657	MOUNT, UPPER GUIDE ROLLER	32	2	SSHC01048	1/4-20 X 3/4 HEX HEAD
9	2	1335658	ARM, PIVOT	33	1	SSHC01056	1/4-20 X 7/8 HEX CAP
10	1	1335681	BRACKET, CYLINDER RODEND	34	1	SSHC01080	1/4-20 X 1-1/4 HHCS
11	1	1335683	BAR, STIFFENER	35	1	SSHC01192	HEX HEAD BOLTS, 1/4-20 X
12	1	1335684	MOUNT, SENSOR	36	4	SSPS98032	10-32X1/2 PAN HD SLOT
13	1	273-4-503	WASHER,LEATHER	37	4	SSSC90048	#8-32 X 3/4 SOC CAP
14	2	A-2216D65	GUIDE,LEFT FOLDER, 7/8"	38	4	SSSC98048	#10-32 X 3/4 SOC CAP
15	1	A-2216D66	T-NUT	39	1	SSSC98080	10-32 X 1-1/4 SOC CAP
16	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"	40	2	SSSC98096	#10-32 X 1-1/2 SOC CAP
17	1	AAC7DP-.5	CYLINDER,AIR,DA	41	1	SSSS98016	#10-32 X 1/4 KNURL PT
18	1	BBAW-4	BEARING,ROD END,FEMALE	42	1	TTH34311	HANDLE,THREADED,10-24X3/4
19	4	BBNTA411	BEARING,THRUST,.250B	43	4	WWF8	WASHER, FLAT #8
20	9	BBTRA411	WASHER,THRUST,STEEL	44	8	WWFS1/4	WASHER FLAT, 1/4
21	2	BBTT601	WASHER,THRUST,BRONZE	45	8	WWFS10	WASHER, FLAT #10
22	1	CCCL4F	COLLAR,1/4,CLAMP	46	7	WWL1/4	1/4 LW
23	1	FFSL30VB6VA	SLOT SENSOR W/4 PIN MOLEX	47	8	WWL10	#10 LW
24	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20	48	7	WWL8	#8 LW

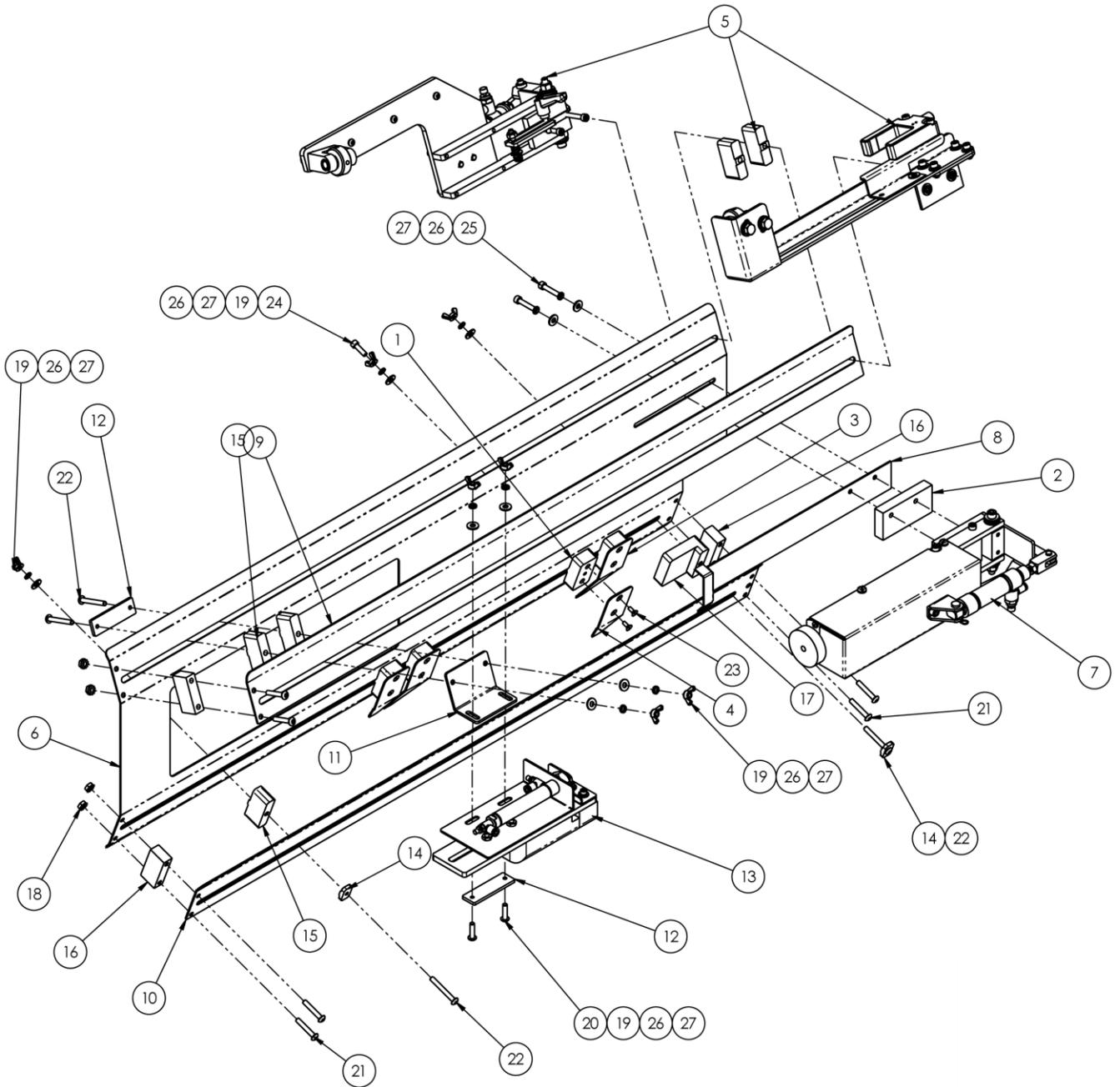


1335674 Encoder Assembly

AAC Drawing Number 1335674 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	1335637	MOUNT, CYL CLEVIS
2	2	1335675	BRACKET, SIDE, ENCODER
3	1	1335676	COVER, ENCODER, 8" CAP.
4	1	1335M-2502	MOUNT,BASE1335M-2500
5	1	1335M-2503	PLATE,TENSION
6	1	1981A-271	WHEEL,ENCODER
7	1	1981A-272	CABLE,PIGTAIL,OPTICAL
8	1	AA198RR508	FLOW CONTROL,5/32 X 1/8"
9	1	AAC7DP-.5	CYLINDER,AIR,DA
10	1	AAF1/8	CLAMP, BLACK PLASTIC
11	1	AAFBP-11C	BRKT,PIVOT,1/4 BORE
12	1	AAFCT-7	CLEVIS,AIR CYL, 1/4-28
13	2	BBNTA411	BEARING,THRUST,.250B
14	4	BBTRA411	WASHER,THRUST,STEEL
15	2	BBTT601	WASHER,THRUST,BRONZE
16	1	EEH1-096-HS	ENCODER,OPTICAL
17	1	EEPC3	MODULE,ENCODER
18	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
19	1	NNH1/4-20	NUT,HEX,1/4-20
20	3	NNH10-24	HEX-NUT 10-24 REG.
21	2	NNK1/4-20	KEP NUT, 1/4-20
22	1	RRBEEHIVEH	SPRING,HEAVY BEEHIVE
23	2	SSPP80024	#6-32X3/8 PAN PHILLIPS
24	1	SSPP90024	8-32X3/8 PAN PHLPS
25	4	SSPS98016	10-32 X 1/4 PAN HD SLOT
26	2	SSSC01032	1/4-20X1/2 SOC CAP
27	1	SSSC01192	1/4-20 X 3 SOC CAP
28	4	SSSC98032	10-32X1/2, SOC CAP
29	2	SSSC98048	10-32 X 3/4 SOC CAP
30	2	SSSS98016	SCREW,SKT SET,FLAT POINT
31	1	SSTS95128	SCREW,TRUSS HD SLOTTED,10-24X2
32	4	WWFS1/4	WASHER,FLAT,SAE,1/4
33	1	WWFS10	WASHER, FLAT, #10, SAE
34	2	WWL10	WASHER,LOCK,#10
35	2	WWL6	WASHER,LOCK,#6

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A-2216W56 Folder Assembly

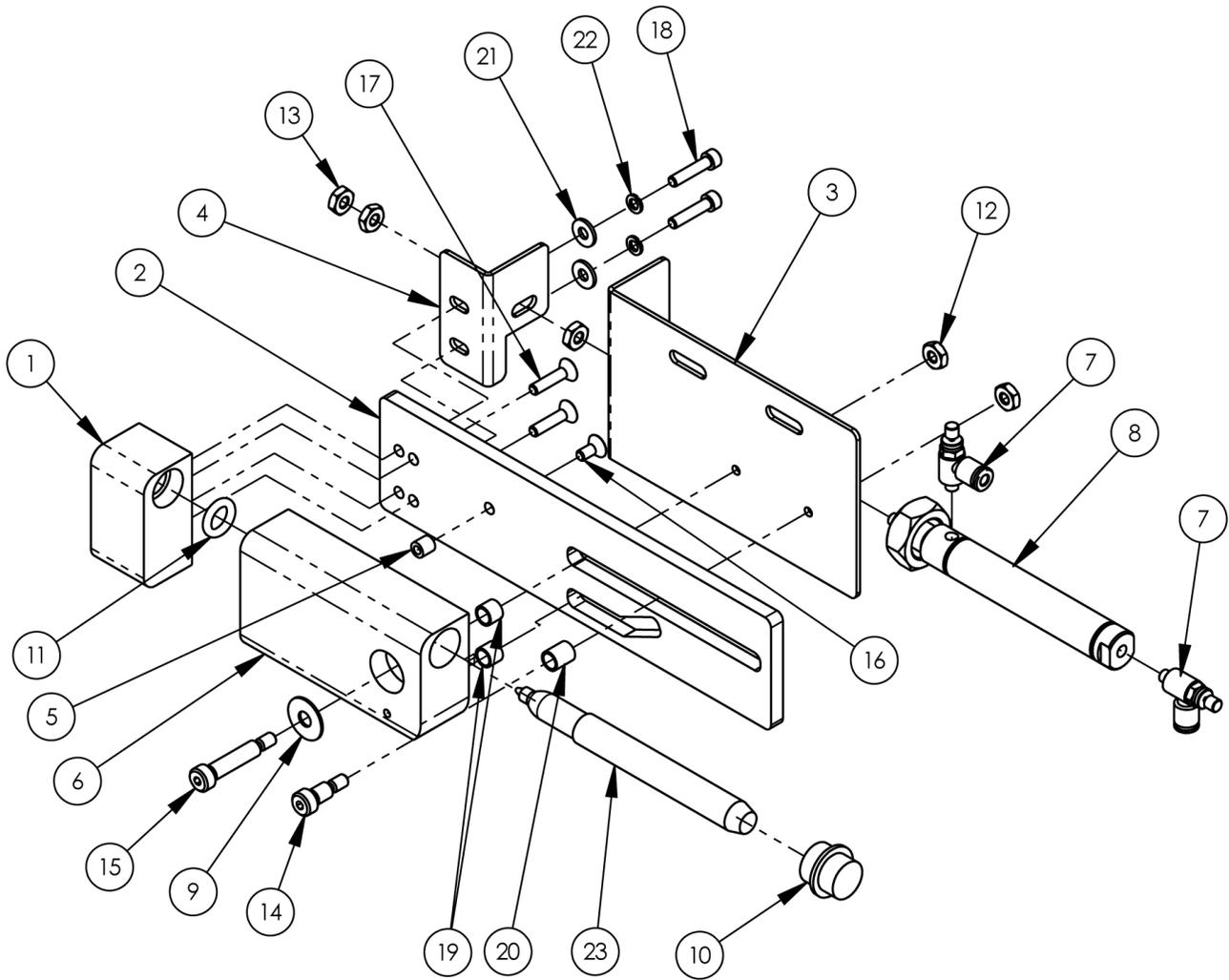
AAC Drawing Number 9000005 Rev1

NO.	QTY	PART #	DESCRIPTION
1	4	1335642	SEAM GUIDE, 9/16 X 1W
2	1	1335645	SPACER, ENCODER, 1/2"
3	2	1335652	GUIDE, SEAM, RIGHT
4	2	1335653	GUIDE, SEAM, LEFT
5	1	1335659	GUIDE ROLLER ASSEMBLY
6	1	1335672	PLATE, FOLDER, CONTIENTAL
7	1	1335674	ENCODER ASSEMBLY, 8" CAP.
8	1	1335677	SUPPORT, ENCODER WHEEL
9	1	1335678	FOLDER TOP, CONTINENTAL
10	1	1335685	FOLDER, LOWER TOP
11	1	3200306	BRACKET, MOUNTING, MARKER
12	2	3200307	PLATE, NUT, 10-32 X 2
13	1	3200PME	MARKING MODULE, MITER
14	2	A-2216D22	T-NUT
15	3	A-2216D65	GUIDE, LEFT FOLDER, 7/8"
16	3	A-2216G36	SPACER, FOLDER, 7/8"
17	1	A-2216G50	GUIDE, OFFSET, 7/8 X 3/8
18	6	NNK10-32	KEP NUT, 10-32
19	10	NNW10-32	#10-32 WING NUT
20	2	SSBC98048	#10-32 X 3/4 BUT HEAD
21	6	SSBC98072	#10-32 X 1-1/8 BUT HEAD
22	4	SSBC98096	#10-32 X 1-1/2 BUT HEAD
23	8	SSFC80024	#6-32 X 3/8 FLAT ALLEN
24	4	SSSC98040	#10-32 X 5/8 SOC CAP
25	2	SSSC98072	#10-32 X 1-1/8 SOC CAP
26	12	WWFS10	WASHER, FLAT #10
27	12	WWL10	#10 LW

Page 62

Page 64

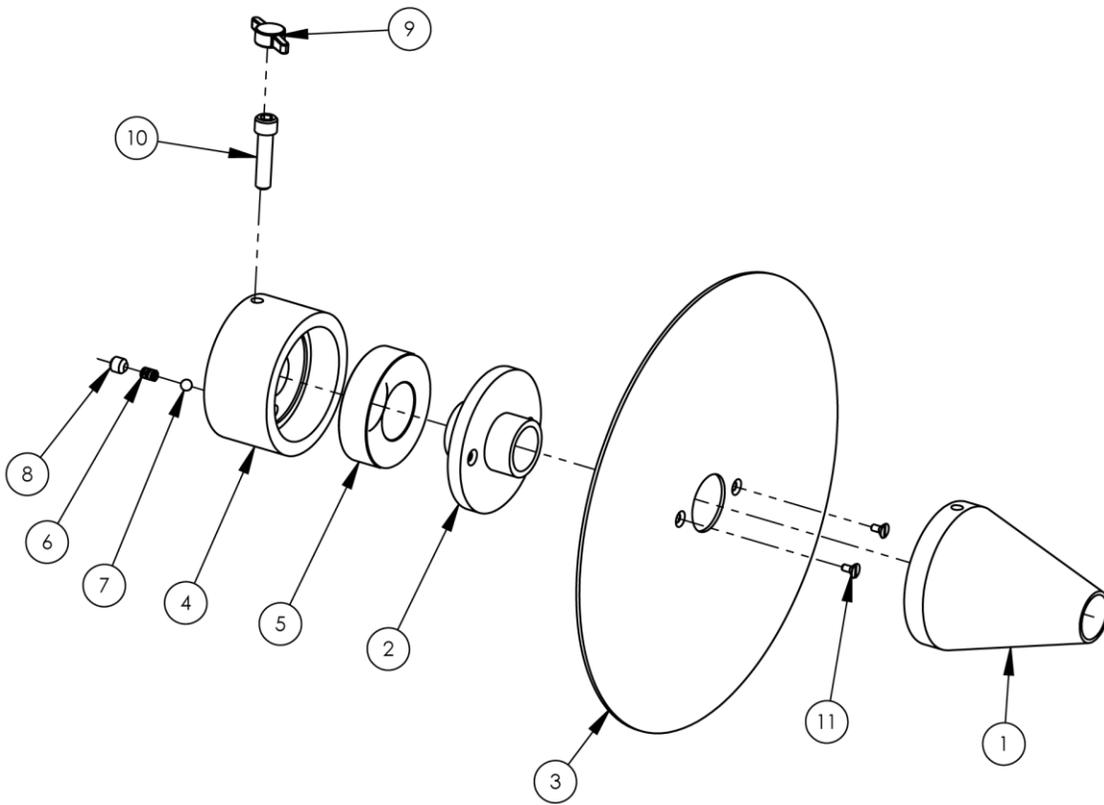
Page 68



3200PME Marking Module Assembly

AAC Drawing Number 9000645 Rev1

NO.	QTY	PART #	DESCRIPTION
1	1	3200302	PEN CAP
2	1	3200303	PLATE, CAM
3	1	3200304	MOUNTING BRKT.
4	1	3200305	BRACKET, CYL ROD MOUNT
5	1	3200312	GUIDE PIN, THREADED
6	1	3200PM-3001	HOLDER, PIN
7	2	AA198RA510	FLOW CONTROL,5/32X10-32
8	1	AAC8D-2	CYLINDER, AIR
9	1	BBTRA411	WASHER, THRUST, STEEL
10	1	MM6844K32	PLUG, 3/8 NPT
11	1	MM94115K204	O'RING, 1/8 X 3/8 X 5/8
12	2	NNH10-24	#10-24 HEX NUT
13	3	NNH10-32	#10-32 HEX NUT
14	1	SSAS016024	1/4 X 3/8 X 10-24 SHLD, BOLT
15	1	SSAS016064	1/4 X 1 X 10-24 SHLD, BOLT
16	1	SSFC90024	#8-32 x 3/8 FLAT ALLEN
17	2	SSFC90048	#8-32 X 3/4 FLAT ALLEN
18	2	SSSC90048	#8-32 X 3/4 SOC CAP
19	2	UUAA347-02	BEARING, BRONZE, .2515ID
20	1	UUAA347-03	BEARING, BRONZE, .2515ID
21	2	WWF8	WASHER, FLAT #8
22	2	WWL8	#8 LW
23	1	ZZZSR-200	SHARPIE MARKER, BLACK



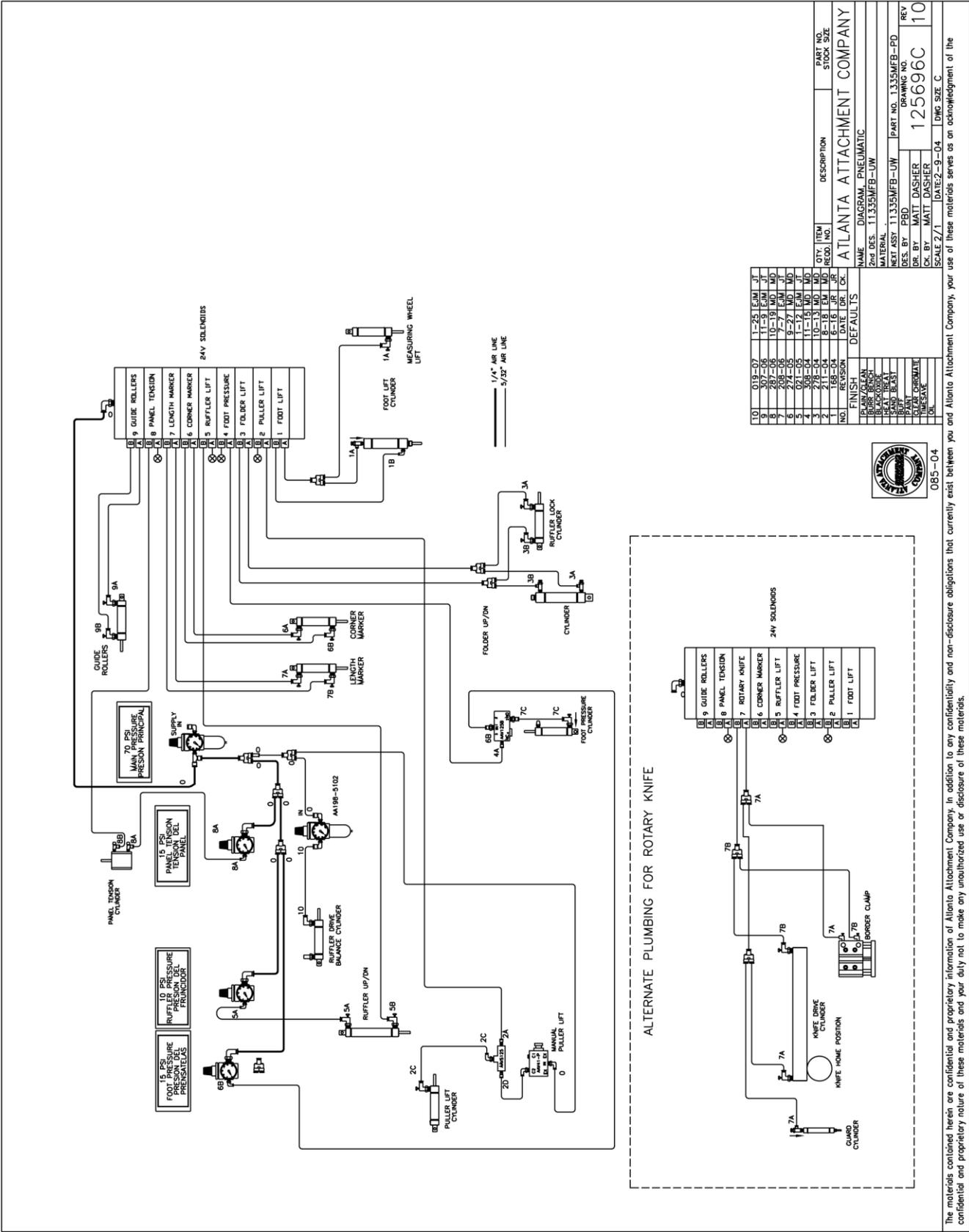
33008708 Ball Bearing Disc Assembly

AAC Drawing Number 9000904 Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1	33008604	CONE, SPOOL
2	1	33008602	HUB, FLANGE 3/4 BORE
3	1	SEE CHART	SEE CHART
4	1	33008601	HUB, CENTER, 3/4 SHAFT
5	1	BB23216-88	BEARING, BALL, 1.0B
6	1	RRLC026B1	SPRING, COMP .026X.18X.25
7	1	JJ012	3/16 DIA. BALL
8	1	SSSP01016	1/4-20 X 1/4 NYLOCK
9	1	SSW#1_4	WING SCREW KNOB
10	1	SSSC01064	1/4-20 X 1 SOC CAP
11	2	SSFS80016	6-32 X 1/4, FLAT SLOT

-	BALL BEARING	DISC ASSEMBLY	33008732
3	1	33008632	DISC 32" DIA
-	BALL BEARING	DISC ASSEMBLY	33008724
3	1	33008624	DISC 24" DIA
-	BALL BEARING	DISC ASSEMBLY	33008716
3	1	33008616	DISC 16" DIA
-	BALL BEARING	DISC ASSEMBLY	33008708

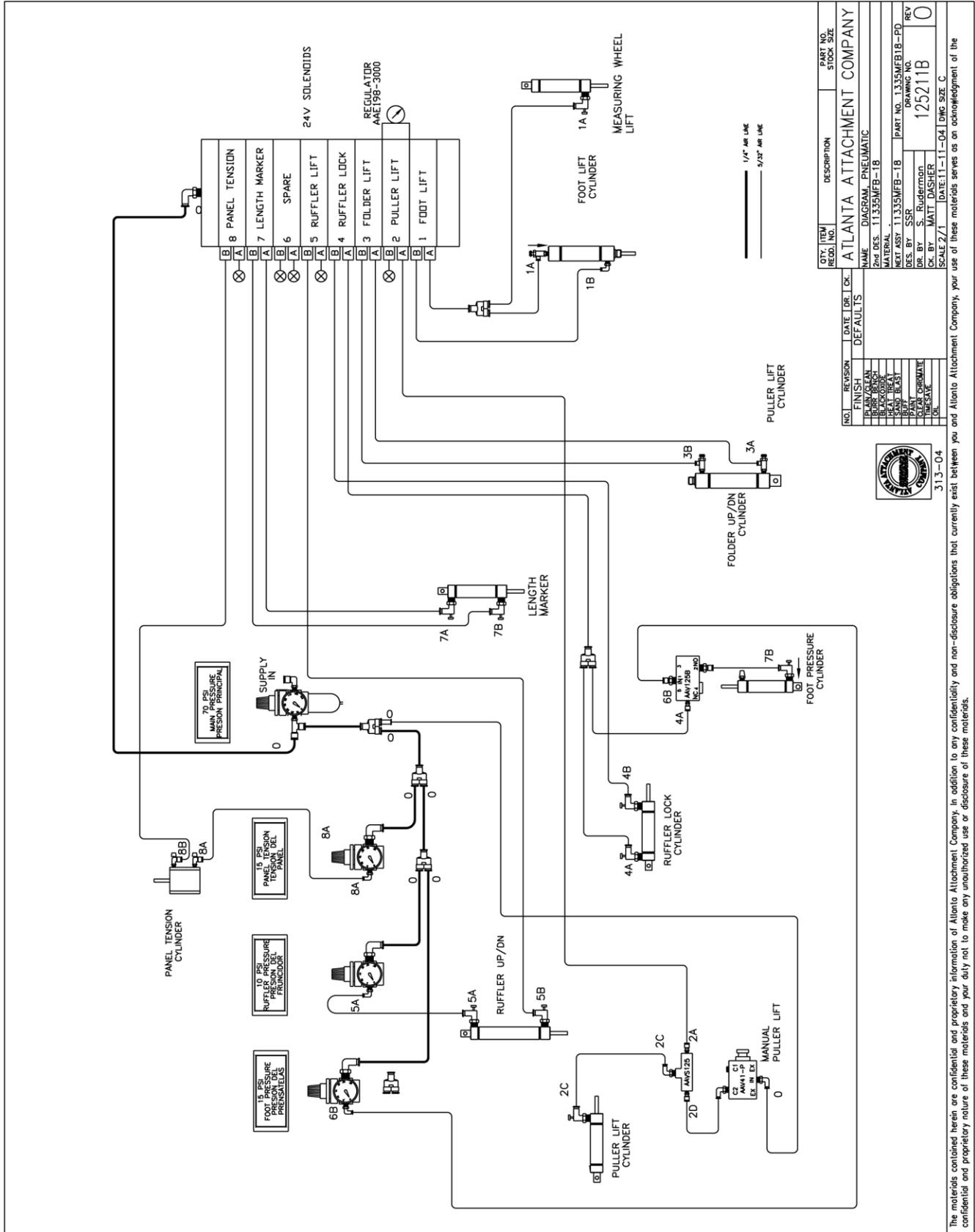
1335MFB-PD Pneumatic Diagram



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1335MFB18-PD Pneumatic Diagram



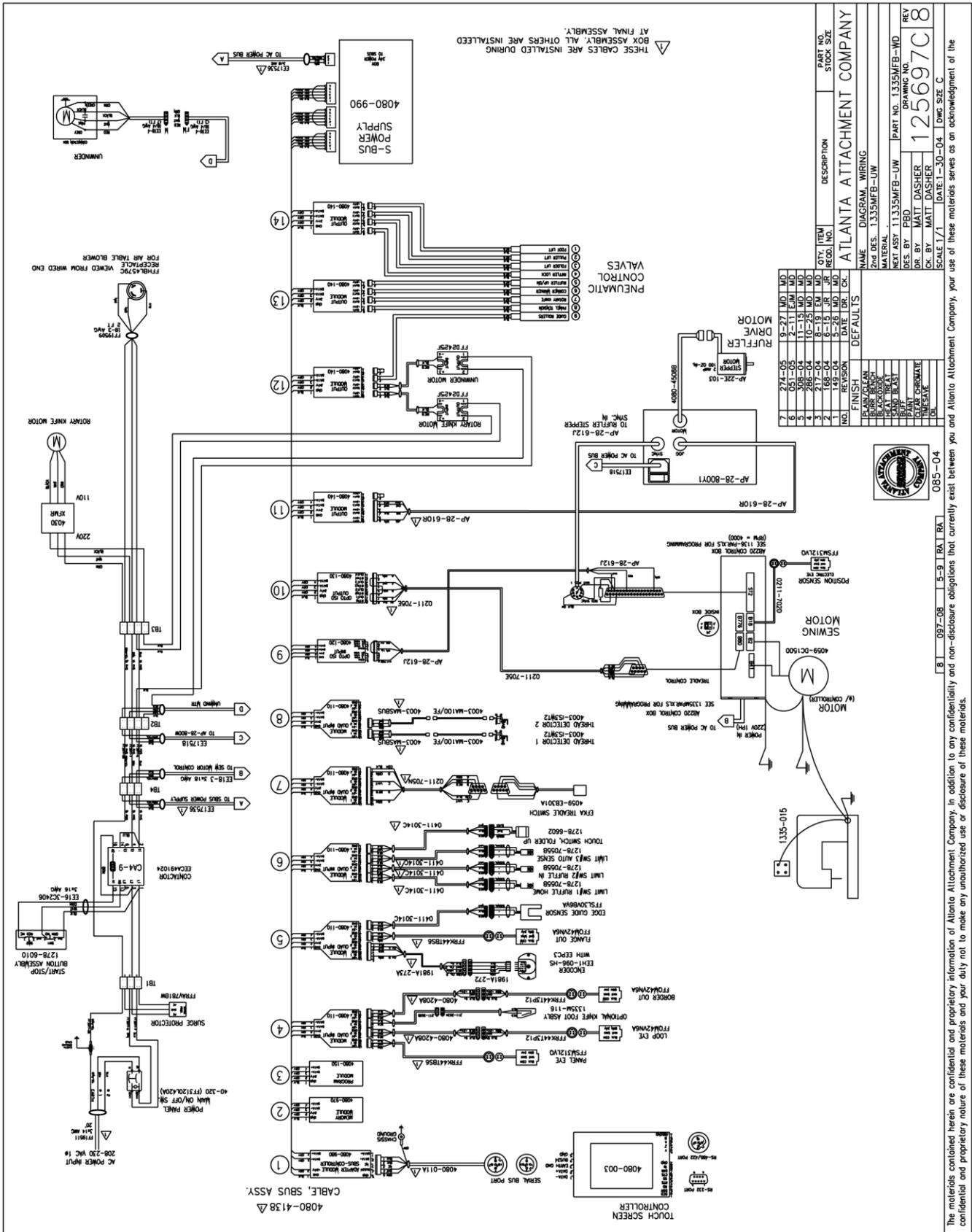
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			NAME: DIAGRAM - PNEUMATIC	
			2nd DES. 11335MFB-18	
			3rd DES. 11335MFB-18	
			4th DES. 11335MFB-18	
			5th DES. 11335MFB-18	
			6th DES. 11335MFB-18	
			7th DES. 11335MFB-18	
			8th DES. 11335MFB-18	
			9th DES. 11335MFB-18	
			10th DES. 11335MFB-18	
			11th DES. 11335MFB-18	
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			15th DES. 11335MFB-18	
			16th DES. 11335MFB-18	
			17th DES. 11335MFB-18	
			18th DES. 11335MFB-18	
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			20th DES. 11335MFB-18	
			21st DES. 11335MFB-18	
			22nd DES. 11335MFB-18	
			23rd DES. 11335MFB-18	
			24th DES. 11335MFB-18	
			25th DES. 11335MFB-18	
			26th DES. 11335MFB-18	
			27th DES. 11335MFB-18	
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			31st DES. 11335MFB-18	
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			33rd DES. 11335MFB-18	
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			39th DES. 11335MFB-18	
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			41st DES. 11335MFB-18	
			42nd DES. 11335MFB-18	
			43rd DES. 11335MFB-18	
			44th DES. 11335MFB-18	
			45th DES. 11335MFB-18	
			46th DES. 11335MFB-18	
			47th DES. 11335MFB-18	
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			49th DES. 11335MFB-18	
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			51st DES. 11335MFB-18	
			52nd DES. 11335MFB-18	
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			55th DES. 11335MFB-18	
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			61st DES. 11335MFB-18	
			62nd DES. 11335MFB-18	
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			64th DES. 11335MFB-18	
			65th DES. 11335MFB-18	
			66th DES. 11335MFB-18	
			67th DES. 11335MFB-18	
			68th DES. 11335MFB-18	
			69th DES. 11335MFB-18	
			70th DES. 11335MFB-18	
			71st DES. 11335MFB-18	
			72nd DES. 11335MFB-18	
			73rd DES. 11335MFB-18	
			74th DES. 11335MFB-18	
			75th DES. 11335MFB-18	
			76th DES. 11335MFB-18	
			77th DES. 11335MFB-18	
			78th DES. 11335MFB-18	
			79th DES. 11335MFB-18	
			80th DES. 11335MFB-18	
			81st DES. 11335MFB-18	
			82nd DES. 11335MFB-18	
			83rd DES. 11335MFB-18	
			84th DES. 11335MFB-18	
			85th DES. 11335MFB-18	
			86th DES. 11335MFB-18	
			87th DES. 11335MFB-18	
			88th DES. 11335MFB-18	
			89th DES. 11335MFB-18	
			90th DES. 11335MFB-18	
			91st DES. 11335MFB-18	
			92nd DES. 11335MFB-18	
			93rd DES. 11335MFB-18	
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			96th DES. 11335MFB-18	
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			98th DES. 11335MFB-18	
			99th DES. 11335MFB-18	
			100th DES. 11335MFB-18	



313-04

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1335MFB-WD Wiring Diagram



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Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

Atlanta Attachment Company warrants manufactured products to be free from defects in material and workmanship for a period of eight hundred (800) hours of operation or one hundred (100) days whichever comes first. Atlanta Attachment Company warrants all electrical components of the Serial Bus System to be free from defects in material or workmanship for a period of thirty six (36) months.

Terms and Conditions:

- AAC Limited Warranty becomes effective on the date of shipment.
- AAC Warranty claims may be made by telephone, letter, fax or e-mail. All verbal claims must be confirmed in writing.
- AAC reserves the right to require the return of all claimed defective parts with a completed warranty claim form.
- AAC will, at its option, repair or replace the defective machine and parts upon return to AAC.
- AAC reserves the right to make the final decision on all warranty coverage questions.
- AAC warranty periods as stated are for eight hundred (800) hours or one hundred (100) days whichever comes first.
- AAC guarantees satisfactory operation of the machines on the basis of generally accepted industry standards, contingent upon proper application, installation and maintenance.
- AAC Limited Warranty may not be changed or modified and is not subject to any other warranty expressed or implied by any other agent, dealer, or distributor unless approved in writing by AAC in advance of any claim being filed.

What Is Covered

- Electrical components that are not included within the Serial Bus System that fail due to defects in material or workmanship, which are manufactured by AAC are covered for a period of eight hundred (800) hours.
- Mechanical parts or components that fail due to defects in material or workmanship, which are manufactured by AAC.
- Purchased items (sewing heads, motors, etc.) will be covered by the manufacturers (OEM) warranty.
- AAC will assist in the procurement and handling of the manufacturers (OEM) claim.

What Is Not Covered

- Parts that fail due to improper usage, lack of proper maintenance, lubrication and/or modification.
- Damages caused by; improper freight handling, accidents, fire and issues resulting from unauthorized service and/or personnel, improper electrical, plumbing connections.
- Normal wear of machine and parts such as Conveyor belts, "O" rings, gauge parts, cutters, needles, etc.
- Machine adjustments related to sewing applications and/or general machine operation.
- Charges for field service.
- Loss of time, potential revenue, and/or profits.
- Personal injury and/or property damage resulting from the operation of this equipment.

Declaración de Garantía

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libres de defectos de material y de mano de obra durante un periodo de ochocientos (800) horas de operación o cien (100) días cual llegue primero. Atlanta Attachment Company garantiza que todos los componentes del Serial bus son libres de defectos de material y de mano de obra durante un periodo de treinta y seis (36) meses.

Términos y Condiciones:

- La Garantía Limitada de AAC entra en efecto el día de transporte.
- Reclamos de la Garantía de AAC pueden ser realizados por teléfono, carta, fax o correo electrónico. Todo reclamo verbal tiene que ser confirmado vía escrito.
- AAC reserva el derecho para exigir el retorno de cada pieza defectuosa con un formulario de reclamo de garantía.
- AAC va, según su criterio, reparar o reemplazar las máquinas o piezas defectuosas devueltas para AAC.
- AAC reserva el derecho para tomar la decisión final sobre toda cuestión de garantía.
- Las garantías de AAC tiene una validez de ochocientas (800) horas o cien (100) días cual llega primero.
- AAC garantiza la operación satisfactoria de sus máquinas en base de las normas aceptadas de la industria siempre y cuando se instale use y mantenga de forma apropiada.
- La garantía de AAC no puede ser cambiado o modificado y no está sujeto a cualquier otra garantía implicado por otro agente o distribuidor menos al menos que sea autorizado por AAC antes de cualquier reclamo.

Lo Que Está Garantizado

- Componentes eléctricos que no están incluidos dentro del sistema Serial Bus que fallen por defectos de materiales o de fabricación que han sido manufacturados por AAC son garantizados por un periodo de ochocientas (800) horas.
- Componentes mecánicos que fallen por defectos de materiales o de fabricación que han sido manufacturados por AAC son garantizados por un periodo de ochocientas (800) horas.
- Componentes comprados (Motores, Cabezales,) son protegidos debajo de la garantía del fabricante.
- AAC asistirá con el manejo de todo reclamo de garantía bajo la garantía del fabricante.

Lo Que No Está Garantizado

- Falla de repuestos al raíz de uso incorrecto, falta de mantenimiento, lubricación o modificación.
- Daños ocurridos a raíz de mal transporte, accidentes, incendios o cualquier daño como resultado de servicio por personas no autorizados o instalaciones incorrectas de conexiones eléctricas o neumáticas.
- Desgaste normal de piezas como correas, anillos de goma, cuchillas, agujas, etc.
- Ajustes de la máquina en relación a las aplicaciones de costura y/o la operación en general de la máquina.
- Gastos de Reparaciones fuera de las instalaciones de AAC
- Pérdida de tiempo, ingresos potenciales, y/o ganancias.
- Daños personales y/o daños a la propiedad como resultado de la operación de este equipo.



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