

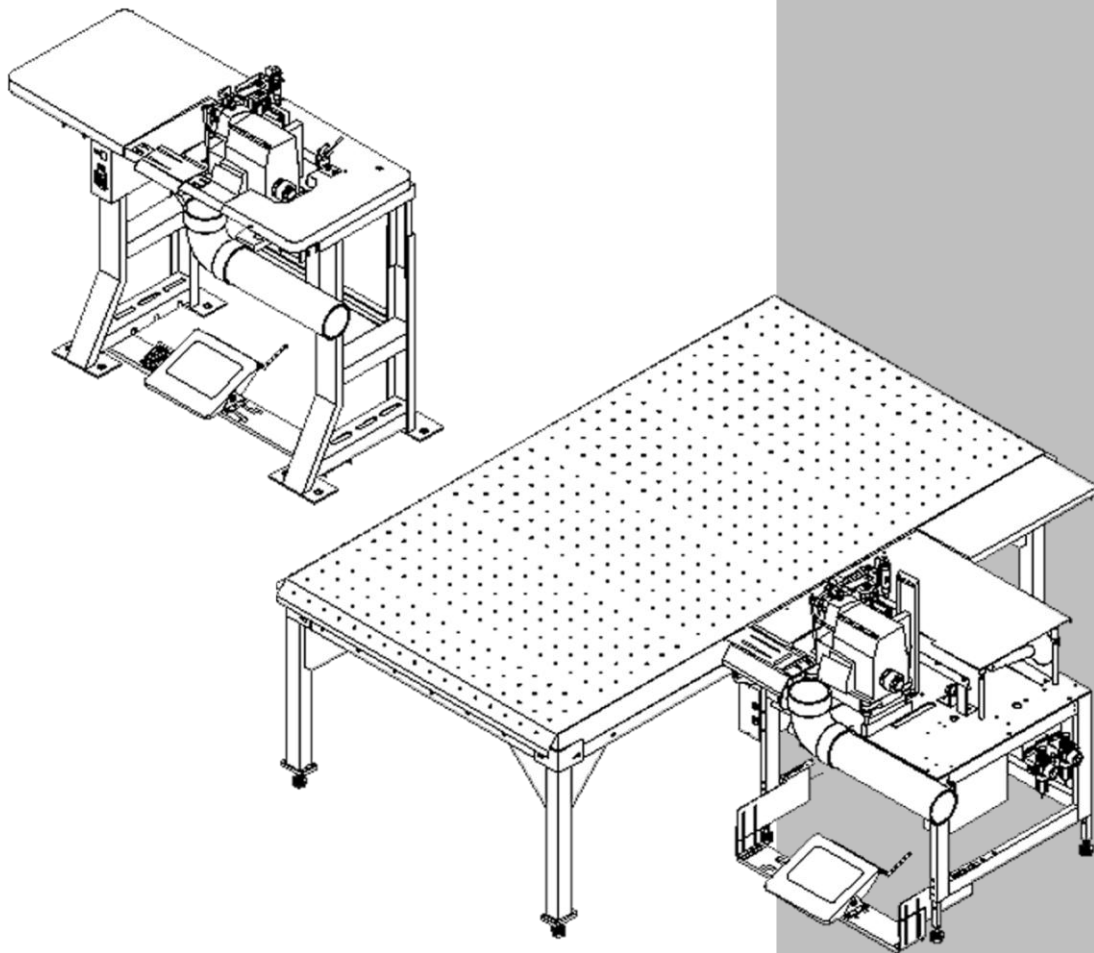


Model

1337

Revision 4.1 Updated Aug 24, 2012

Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

Atlanta Attachment Company

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ATLANTA ATTACHMENT COMPANY, INC.

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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.

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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 1337 Panel Flanging Workstation 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.

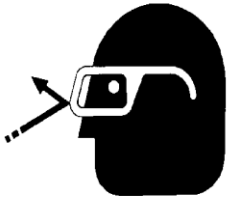
Signs on the Machine

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 PSI, 20 SCFM avg. (3/8" Airline).
Set the regulator to	70 PSI.
Pressure setting valves:	as required

Installation & Setup

- Remove all packing material (bubble wrap, foam padding, etc.).
- Assemble the air table to the Main Console Assembly. Refer to the assembly drawing on pages 25 and 27.
- Position the machine in a desired location on a sound and reasonably level floor. Adjust the leveling feet as required.
- Make sure that there is sufficient lighting over the machine.
- Clean the machine of any dust that may have accumulated during shipping.
- Make required electric and pneumatic connections using only appropriate connectors. Make sure the voltage has been set correctly.
- **Important!** - Before shipping, all **oil from the sewing head is drained**. Be sure to supply oil to the sewing head before using the machine.

Adjustments

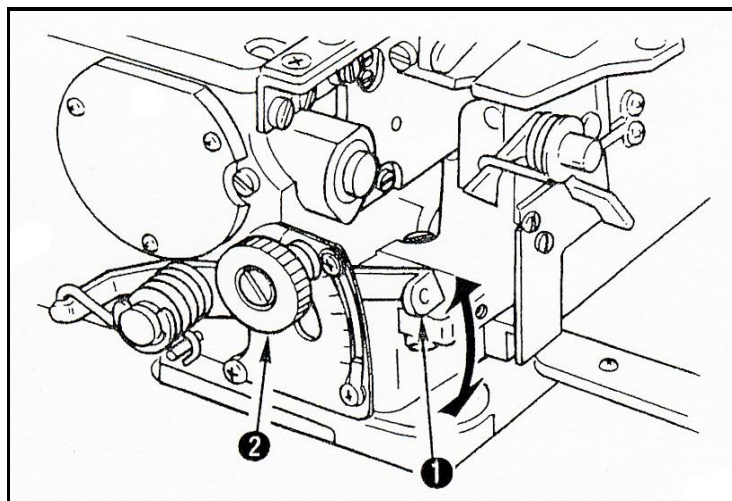
Adjusting the Differential Feed Mechanism

Loosen the differential feed lock nut (2). Move the lever (1) up for stretching stitch or down for gathering stitch.

When the differential feed adjusting lever is set to graduation S, the machine will perform stretching with a differential feed ratio of 1:0.6, or 1:0.7 only for MOG-3714.

For shirring, the maximum differential feed ratio is 1:1.75, or 1:2.0 only for MOG-3714.

Note that the differential feed ratio for shirring can be set to 1:3.8 by adjusting the internal mechanism of the sewing machine. Graduations are used only as a guide.

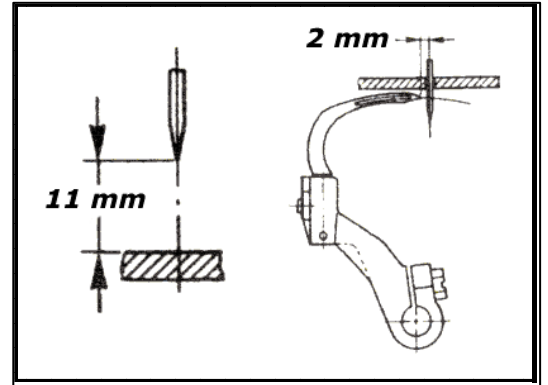


Adjusting the Timing of Loopers and Needle Guard

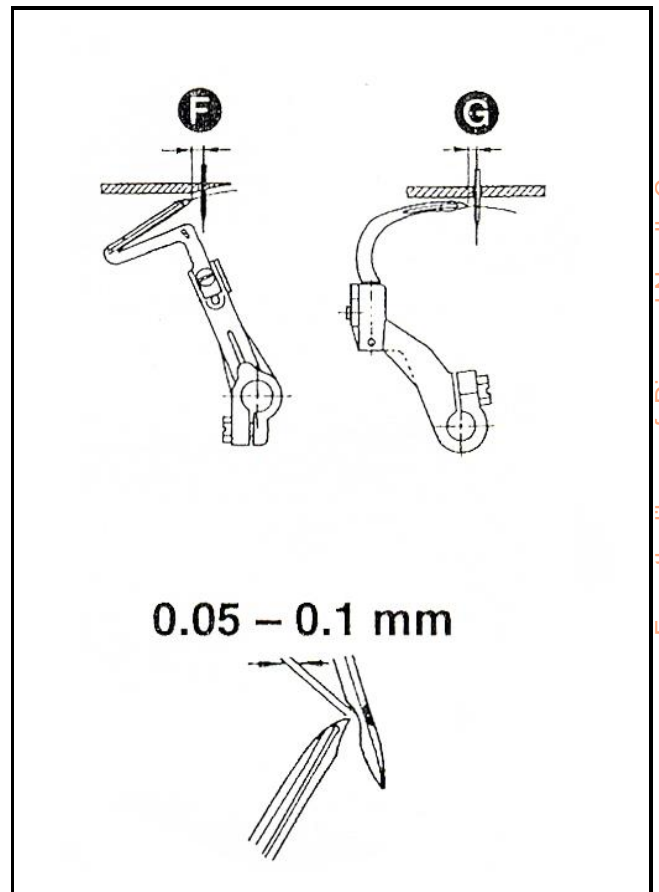
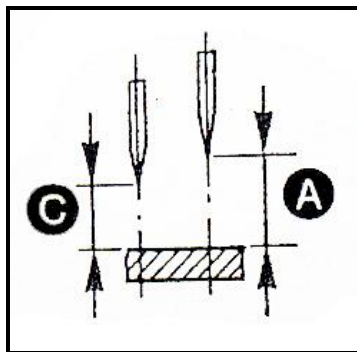
The looper and needle guard are set according to the dimensions in the illustrations on this page at the factory.

Adjustment will depend on the sewn products and thread being used.

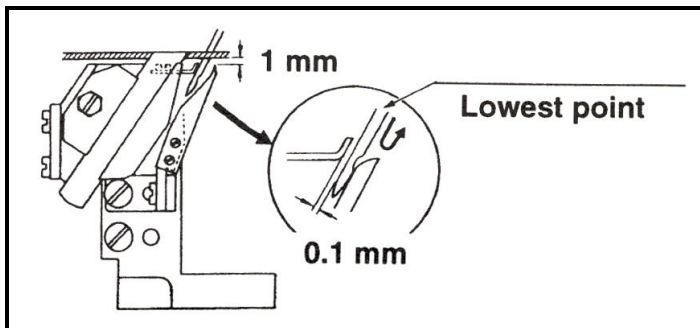
Warning: These adjustments should be made by a qualified technician. To avoid injury, disconnect the power source before making adjustments. Be sure that all screws are tightened and that none of the components come in contact with each other before restoring power to the machine.



A=1/2"
C=7/16"
F=9/64"
G=1/16"

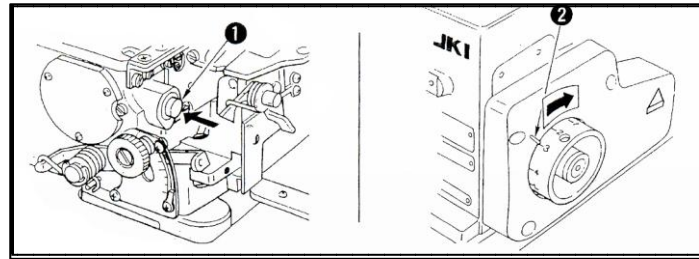


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Adjusting the Stitch Length

1. Slowly turn the handwheel as you keep depressing the pushbutton (1), and you will find a point at which the pushbutton goes farther.
2. With the above condition maintained, align the desired scale mark on the handwheel with mark (2) on the belt cover.
3. Reset the pushbutton after setting the dial.



Caution: Confirm that pushbutton (1) has returned to its original position before starting running the sew head since there is a danger that the machine parts may be damaged or the operator or other persons may be injured.

Parameter Settings for Efka Controller

Before Programming, Perform a Master Reset of Parameters (See Below)

PARAMETER	RANGE	VALUE	DESCRIPTION
290		5	Mode of operation. MUST SET THIS PARAMETER FIRST!
111	200-9900	400	Maximum speed
161	0-1	0 = CW	Motor rotation
270	0-5	1	External handwheel sensor configuration
272	020-255	100	Drive ration 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.

Front panel LED's:

- LED 1: Off
- LED 2: Off
- LED 3: Off
- LED 4: Off
- LED 5: Off
- LED 6: Off
- LED 7: On, Stop at needle down.
- LED 8: Off

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "311"
3. Press "E" once and "2.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E"
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
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.

11337SAJ96-PAR1 Parameter

PARAMETER	RANGE	VALUE	DESCRIPTION
Do this first	*****	****	Perform a master reset before programming, see below
290		5	Mode of operation. MUST SET THIS PARAMETER FIRST!
111	200-9900 rpm	400	Maximum speed.
161	0-1	0=CW	Motor rotation
270	0-5	1	External handwheel sensor configuration.
272	020-255	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

Front panel LED's:

- LED 1: Off
- LED 2: Off
- LED 3: Off
- LED 4: Off
- LED 5: Off
- LED 6: Off
- LED 7: On, Stop at needle down.
- LED 8: Off

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "311"
3. Press "E" once and "2.0.0." is displayed. This is a parameter.
4. Press "E" again and the value for parameter 200 is displayed.
5. With the value on the screen, adjust to desired setting.
6. Press "E" to enter value and continue with parameter setting.
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.

Efka Step motor / AB425S control box

1.- Sewing Head Parameter List for **1337HESEWPAR** on page 23

1.1. - Use SIR for Initial Settings

- Keeping [P] pressed and turn the machine “ON” until screen show “C: 0000”
- Type [3112]
- Press [E]
- Parameter “F-200” is showing, Type [500] Input Parameter
- Press [E]
- Press [>>] (Last key on the bottom right corner) machine shows F-467
- Press [E]
- Parameter “F-290” is showing. Type [5] Functional sequence
- Press [E]
- “F-161” is showing, Type [1] Direction of the motor
- Press [E]
- “F-272” is showing, Type [1000] Transmission Ration
- Press [E]
- “F-270” is showing, Type [0] Type of positioning sensor
- Press [E]
- “F-461” is showing, Do not change
- Press [E]
- “F-453” is showing, Do not change
- Press [E]
- “F-467” is showing, Do not change
- Press [E]
- Program returns to Parameter F-467
- Press [P]
- Press [P]
- End of SIR

1.2. - Set Needle Position Up

Set parameter F-171 to set 1 needle position “UP” and 2 Needle position “UP”.

- Press [P]
- Type [171] Setting the needle positions
- Press [E]
- Press [>>] (Last key on the bottom right corner) machine show 1E = Start, Turn handwheel in direction of sew until needle is up. Note parameter setting.
- Press [E]
- 2E = Start position, enter same number as 1E
- Press [E]
- 1A = End position. Set equal to 1E+60.
- Press [E]
- 2A = End position, Set equal to 2E+60.
- Press [E]
- Press [P]
- Press [P]

1.3. - Set Maximal Speed

After parameter, F-171 is set change F-111 to 4.000 Maximal Sewing Speed

- Press [P]
- Type [111] Type [4000] Maximal Sewing Speed
- Press [E]

- Press [P]
- Press [P]

2. - Step Motor Parameters

2.1. - Parameter List

Value	Function	Parameter
0	601	Puller coupling with presser foot lift ON/OFF (button 9 / V820)
1	602	Puller ON/OFF (button 0 / V820)
1	603	Direct choice of steps via button 1 -6 or sequence choice of steps via button F2 on V820
0	604	Stitch delay until puller down at seam begin ON/OFF (button 8 / V820)
0	605	Display puller function or normal sewing function ON/OFF (button F1 / V820)
1	606	Change of direction of stepper motor during back tack ON/OFF\par
0	607	Change display of puller 1 and puller 2 (button 7 / V820)
0	702	0 / Synchronous run of stepper motor, 1 / of stepper motor\par
0	703	Stitches until Puller down at seam begin
0	704	Automatic Puller lifting after trimming ON/OFF
100	705	Speed for manual run of stepper motor 1 and stepper motor 2
100	707	Holding current SM1 (100 = .1 A)
4000	708	Running current SM1 (4000 = 4.0A)
200	710	Ratio SM1 (Sets frequency of the pulses in intermitted run mode)
60	711	Start delay in degrees from position until stepper 1 starts for intermitted running
100	717	Holding current SM2
4000	718	Running current SM2
200	720	Ratio SM2 (Sets frequency of the pulses in intermitted run mode)
60	721	Start delay in degrees from position 2 until stepper 2 starts for intermitted running
1	734	Turning direction SM1
1	744	Turning direction SM2

2.2. - Feeding Steps Parameters

C A B

Function of push buttons on V820 :

Button 1 to 6 = Selection of stepper values 1 - 12

Button 7 = Display stepper values of puller 1 or puller 2

Button 8 = Puller delay at seam begin ON/OFF and input of stitches for puller delay

Button 9 = Puller coupling with presser foot lift ON/OFF

Button 0 = Puller function ON/OFF

Button F1 = Change display from puller to standard sewing

Button F2 = Go to next stepper value (1 -12) in sequenced mode

NOTE: 5/15V EYE POWER SELECTION IS VIA PAR 362, 0=5V, 1=15V

MOTOR SIZE SELECTION IS VIA PAR 467, 1=DC1500, 2=DC1550

2.2.1. - Panel Description

A = Belt Feeding Step

B = Belt Feeding Value

C = Belt Feed Step Selected

Pressing buttons 1 thru 6 to select a different Belt Feeding Step (You will have two Feeding Steps per button). Reference: Step 1 for Heavy materials, Step 12 for Light materials

+ = Increase Belt Feeding Value
 -- = Decrease Belt Feeding Value

2.2.2. - Parameters

Position	1	2	3	4	5	6	7	8	9	10	11	12
Step Value	246	240	234	228	222	216	210	204	198	192	186	180

2.2.3. - Storage Feeding Steps Parameters

Enter above settings with operator panel. Load settings into memory after loading.

Cycle power, press”P”. Enter 3112.

- Type 401 parameters
- Press [E]
- Set to [1]
- Press [E]
- Press [P]
- Press [P]

3. - Memory Stick Operation (Panel V820)

3.1.- Reading the installed software

In service Area

- In Service area type [F-179]
- Press [E] show Sr5
- Press [>>] (Last key on the bottom right corner) machine show program number
- Press [E] show data
- Press [E] show chk
- Press [E]
- Press [E]
- Press [P]
- Press [P]

If the original factory software is not the right one you will need to erase all memory data and reload new Software. After this procedure, you will require to load the Sewing head parameters and Step motor parameters again.

3.2. - Erase all memory

- Hold “P”, turn machine on
- Type code “5913”.
- Press [E]
- Set parameter F-459 to 3112
- Press [E]
- Press [P]. It will erase all memory sections.
- Turn Machine Off

3.3. - Loading Information from Memory Stick

Is recommended to erase all memory before loading the information from the memory stick (See Erase all Memory for instructions)

- With the machine in “OFF” position plug in the Memory stick
- Keeping “P” pressed, turn the machine “ON” until screen shows “C:0000”
- Type “3112”

- Press “E”
- Parameter “F-200” is showing
- Type “527”
- Press “E”
- Machine displays “F527 cdl (o)”
- Press [>>] (Last key on the bottom right corner) machine shows 5850 h_ 1 h86
- Press “E” twice quickly.
- Machine show “read data” for some time. Wait until display returns to normal and “prog” has gone from Efka box display. (Several minutes)
- Turn off power.
- Hold “P” and turn on power. Wait for “C:0000”
- Type “3112”.
- Press “E”
- Display shows F200
- Type “523”
- Press “E”.
- Press [>>] (Last key on the bottom right corner)
- Press “E” twice quickly.
- Machine show “read data”. Wait until display shows “F 523”.
- Type “511”
- Press “E”.
- Press [>>] (Last key on the bottom right corner)
- Press “E” twice quickly.
- Machine show “read data”. Wait until display shows “F 511”.
- Turn off the machine. Wait 10 seconds.
- Hold “P”, turn power back on. Wait for “C:0000”
- Enter “3112”, press “E”
- Enter “515”, Press “E”.
- Press [>>] (Last key on the bottom right corner)
- Press “E” twice quickly.
- Wait for normal screen.
- Turn power off.
- Remove memory stick.

Note: For initial operation after software updating or maintenance procedures, make sure to set parameter [467] for the specific motor to be used (DC1500, F-467 = 1 / DC1550, F-467 = 2)

3.4 - Data Transfer

Operation Parameter

Type of file

Parameters F-510

0100DATA.par

Parameters F-511

0100DATA.par

Compare parameters F-512

Array Data F-514

0300DATA.pay

Array Data F-515

0300DATA.pay

Compare Array Data F-516

Compiler.	F-523
Puller_V10.prg	
Control Software	F-526
0400DATA.hex	
Control Software	F-527
5850G_09012708.H86	5850X_09021312.H86
Compare Control	F-528

Machine Maintenance

Regularly scheduled maintenance of the model 1337 unit reduces possible problems and downtime. Proper care will also ensure a longer life and better performance of the machine.

Perform the following procedures to properly maintain the machine.

Clean the machine once or twice a day.

Wipe off both electric photo eyes with a clean, nonabrasive, dry cloth.

Use a blow-off hose to remove any excess lint, thread or other clippings.

Clean the lint from the edge guide drive belt and pulley.

Refer to the Juki sewing head manuals for the manufacturer's recommendations and guidelines for maintenance and lubrication of the sewing head.

Check the main air filter weekly. Change the filter element once every 6 months.

Change the oil in the sewing machine every 3 to 4 months.

If the pointer bar of the oil gauge falls below the lower marker line of the gauge, add oil.

Apply two or three drops of oil to the needle bar and upper looper guide and presser spring regulator before operating the machine for the first time and after a long period of disuse.

Cleaning the Filter and Pump Net

To use the sewing machine for an extended period of time, clean filter (1) and pump net (2) periodically twice or three times a year. If the filter and pump net are clogged with dust, etc., the machine components may be seized or worn out extraordinarily.

Carefully check the filter and pump net.

If the lubricating oil in the machine is stained, change the oil also at the time of cleaning.

Recommended Spare Parts List

Contact AAC's sales department to order replacement parts.

Phone: 770-963-7369
 Fax: 770-963-7641
 Email: sales@atlatt.com
 Website: www.atlatt.com

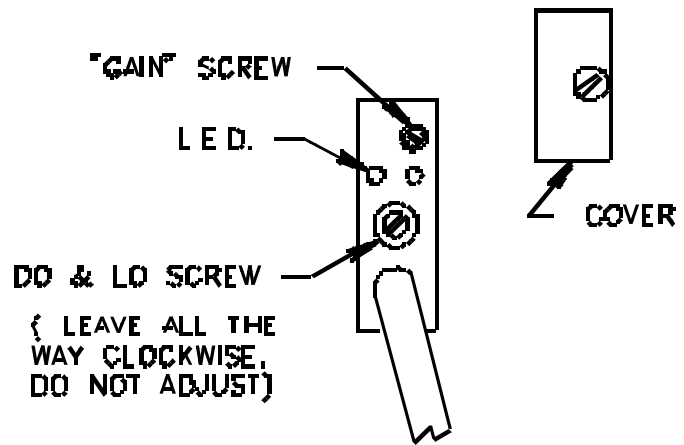
AAC Part # SP1337 Spare Parts Kit

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	115-65900	Upper Cutter	8	1	AAEVQZ2	Valve
2	2	115-66502	Lower Cutter	9	2'	EEFE-RR2	Reflective Tape
3	1	118-90001	Needle Guard	10	1	FFSM312L	Electric Eye
4	1	12015400	Needle Holder	11	1	GG140XL0	Gear Belt
5	1	123-83501	Upper Looper	12	2	GG356XL0	Gear Belt
6	1	123-84202	Lower Looper	13	1	RRE29C	Spring
7	1	123-84400	Chain Looper	14	1	SN135X72	Needle, Size 140/22

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

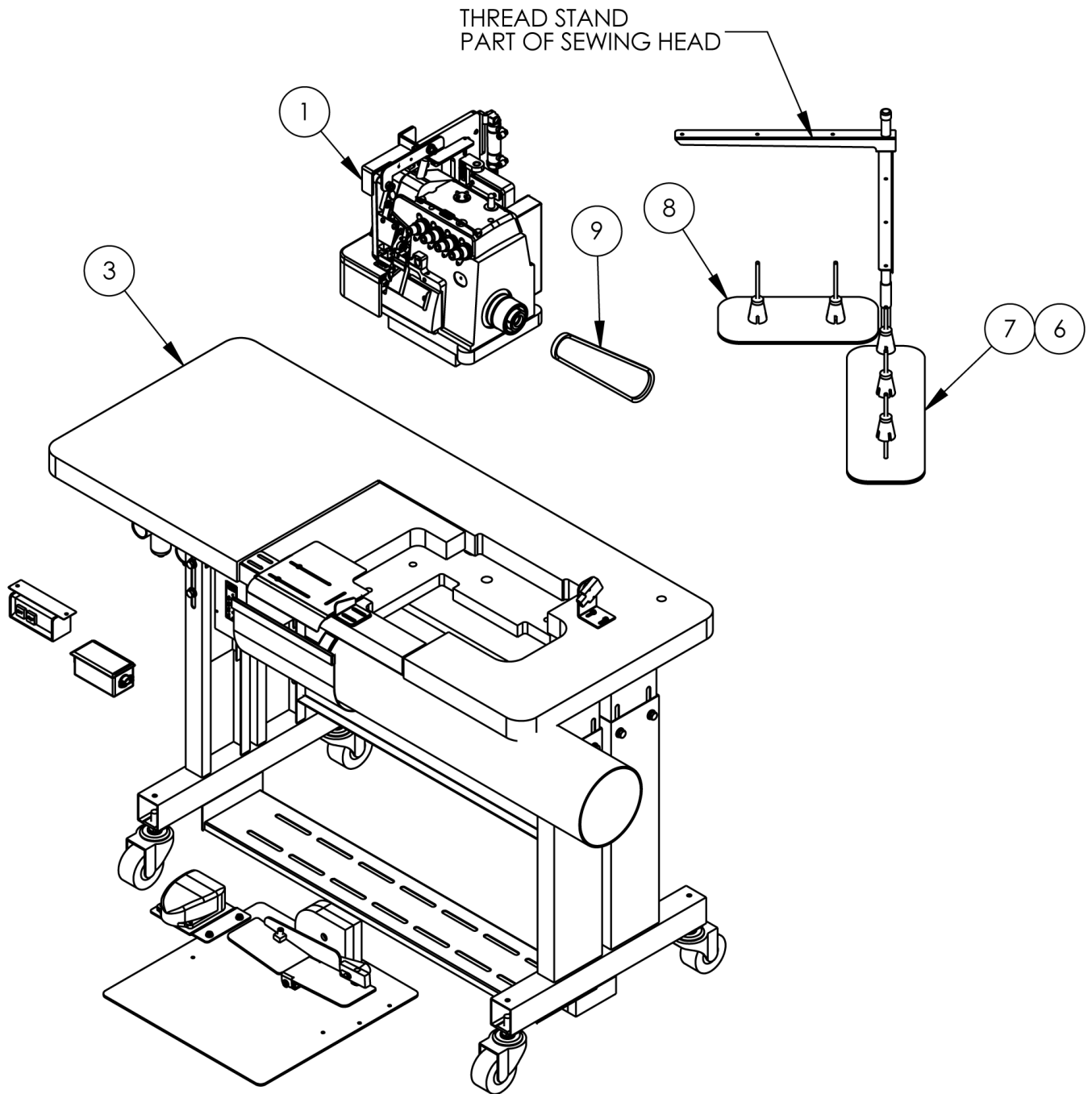
Use a soft cloth for cleaning.
 Do not use chemicals or abrasives to clean it.
 Avoid any contact with oils and liquids.
 Do not touch the tape with bare fingers.
 If tape is dirty or opaque, the eye may not function correctly.

Assembly Drawings & Parts Lists

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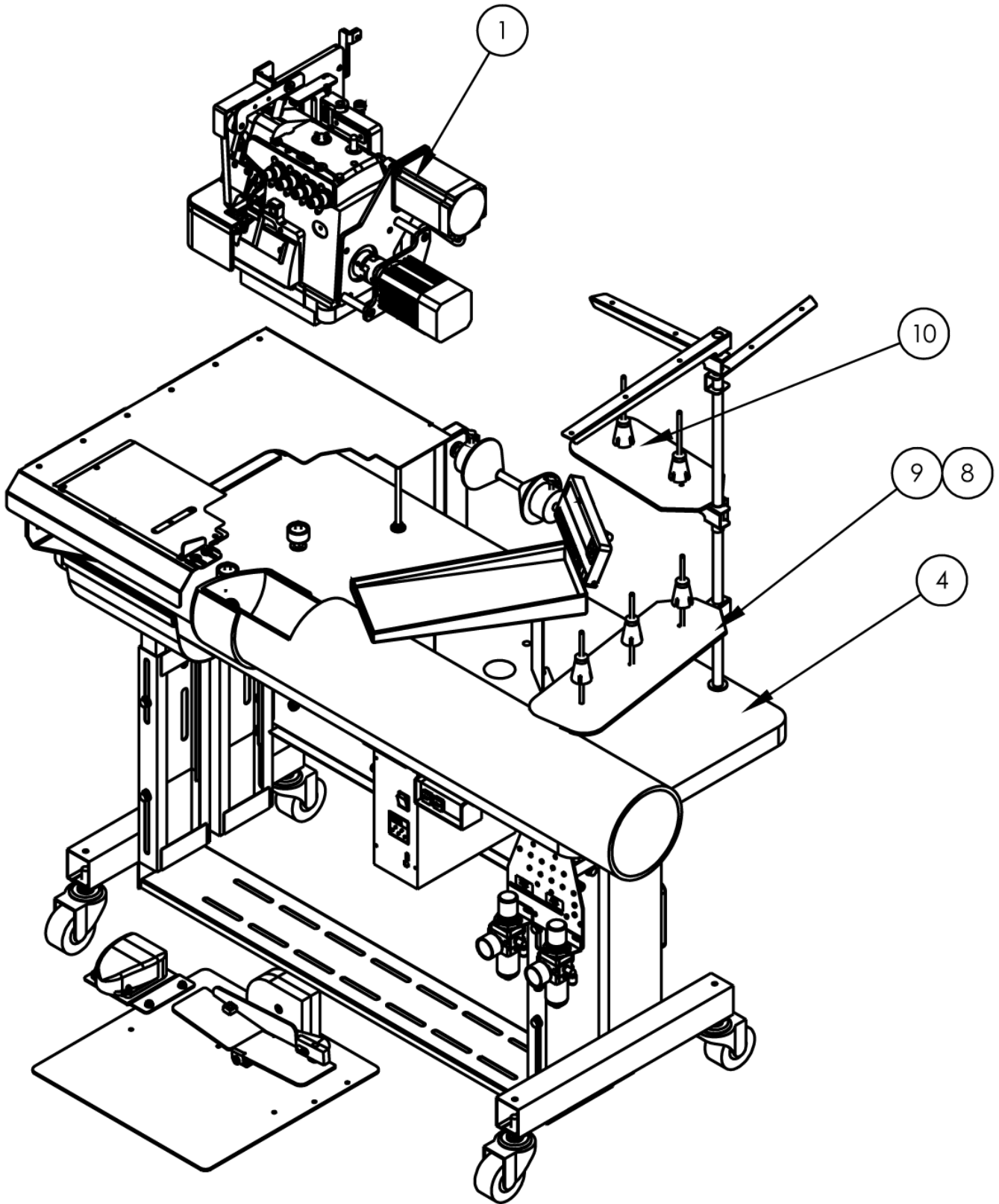
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11337HJ28A Sew Head and Console Assembly

AAC Drawing Number 9001878 Rev 6

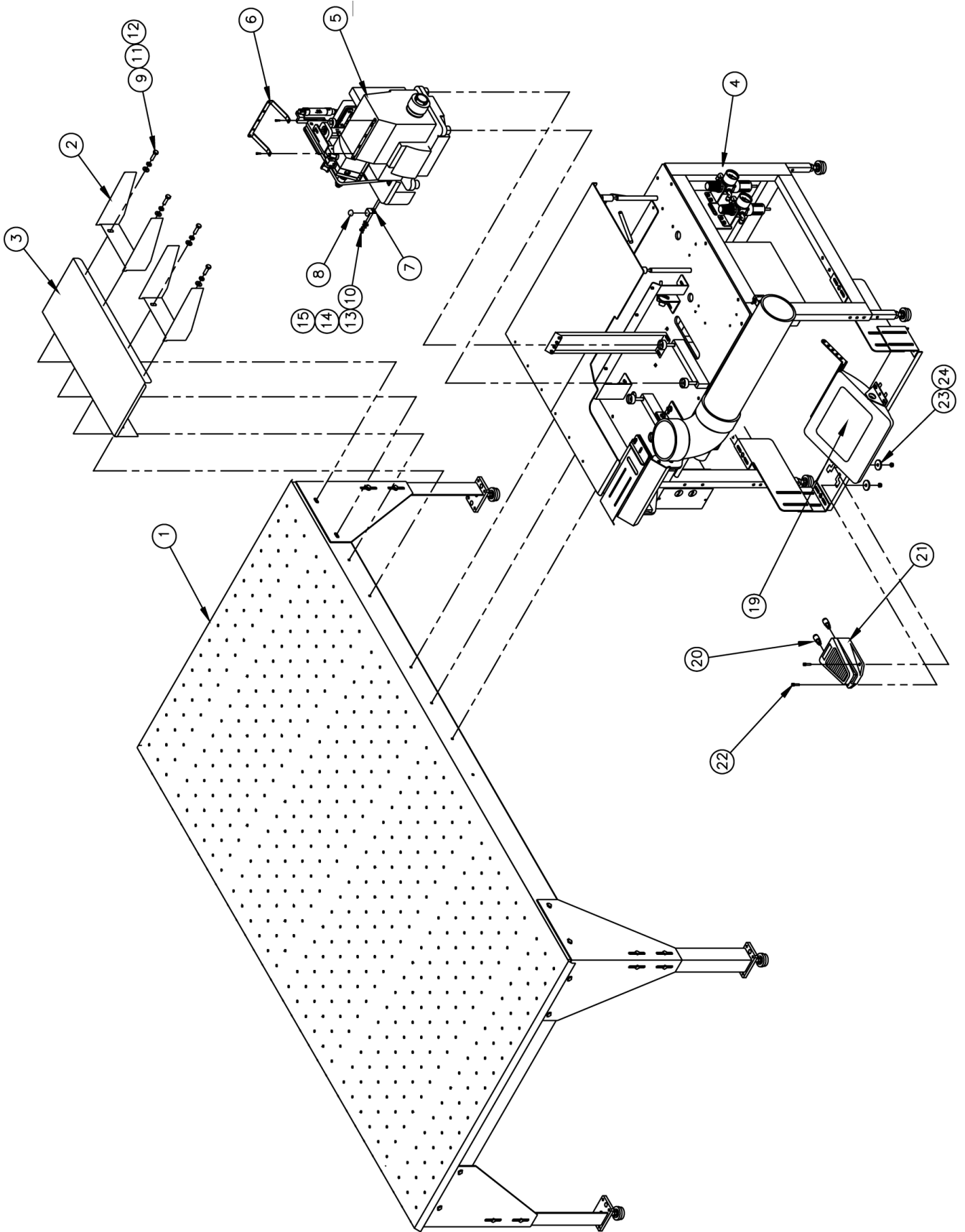
NO.	QTY	PART #	DESCRIPTION	
1	1	11337HSJ28A	SEW HEAD,FLANGER,BLT FEED	Page 30
2	1	1337-LAB2	LABELS	
3	1	1337H-1000	CONSOLE ASSY,SD,PANEL FLN	Page 32
4	1	1337SA-PD1	PNEUMATIC DIAGRAM	Page 68
5	1	1337SA-WD1	WIRING DIAGRAM	Page 70
6	1	1959-022	PLATE, THREAD, 3 POS	
7	1	1959-024	PAD, FOAM, 3 POS	
8	1	1959-112	2 POS THREAD PLATE ASSY	
9	1	ZX3829	V-BELT,3/8 X 27"	
10	*10	SN135X722	NEEDLE	



11337HEJ28A Console Assembly

AAC Drawing Number 9002687 Rev 0

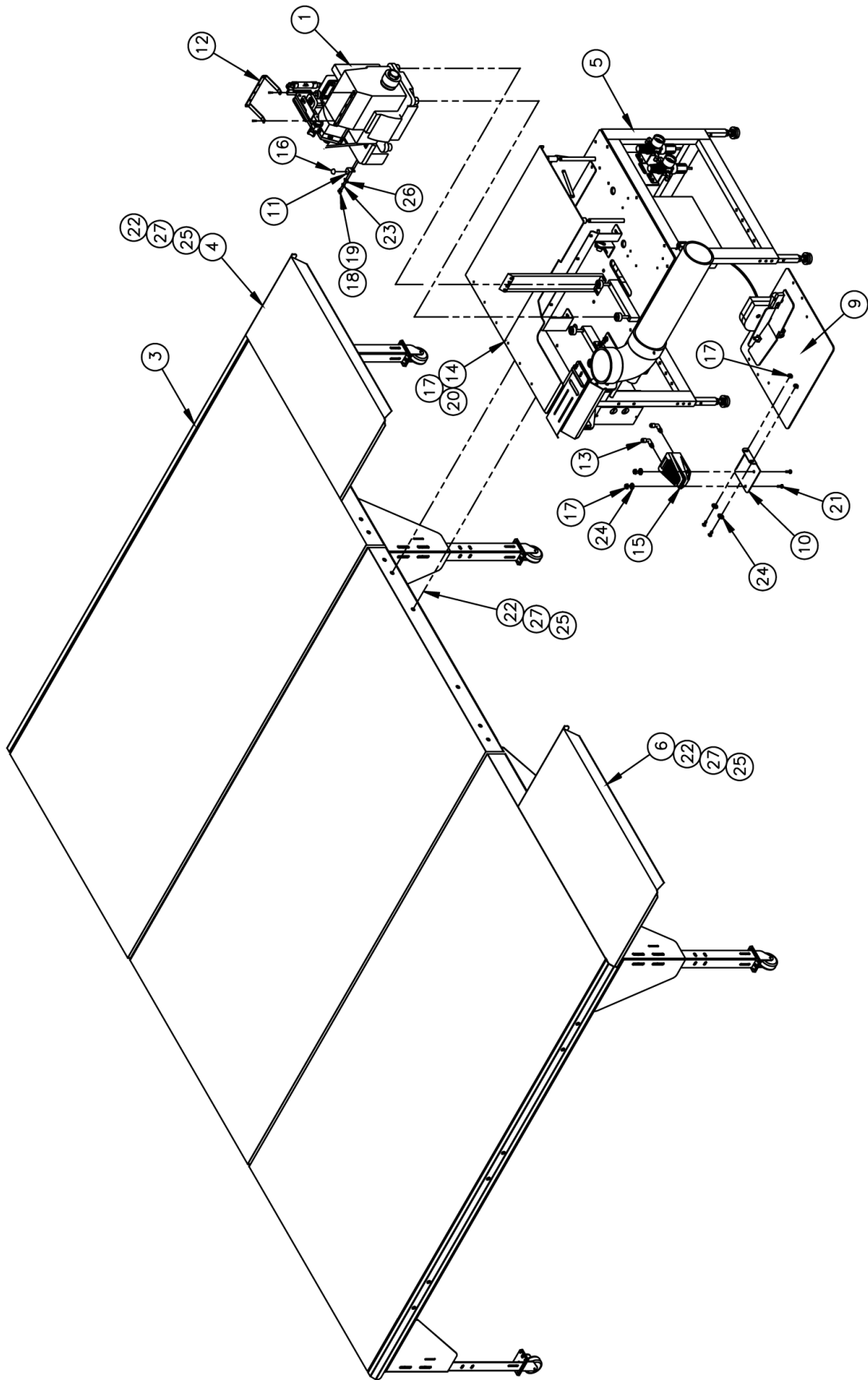
NO.	QTY	PART #	DESCRIPTION	
1	1	11337HSEJ28A	SEW HEAD,FLANGER,BLT FEED	Page 48
2	1	1337-LAB2	LABELS	
3	1	1337-LAB3	LABEL, V820 PANEL	
4	1	1337H-1001	CONSOLE ASSY,SD,PANEL FLN	Page 36
5	1	1337HESEWPAR	PARAMETER LIST	Page 14
6	1	1337H-PD	PNEUMATIC DIAGRAM	Page 67
7	1	1337H-WD	WIRING DIAGRAM	Page 69
8	1	1959-022	PLATE, THREAD, 3 POS	
9	1	1959-024	PAD, FOAM, 3 POS	
10	1	1959-112	2 POS THREAD PLATE ASSY	
11	1	4059-DC09	CABLE, STEPPER,6 FT	



11337SAJ28A Semi-Auto Panel Flange 3/4 Ga.

AAC Drawing Number 192051B Rev 2

NO.	QTY	PART #	DESCRIPTION	
1	1	1337A-160	Air Table Assembly	Page 62
2	2	1337A-0168	Retainer BRKT	
3	1	1337A-175	Shelf	
4	1	1337-1000	Console Assembly	Page 34
5	1	11337HSJ28A	Sew HD Assy	Page 30
6	1	49051	Thread Guide	
7	1	49034	Cloth Plate Supp	
8	1	MMSJ5017	Bumper	
9	4	SSHC10064	Hex cap Screw	
10	2	SSBC80024	Button Cap Screw	
11	4	WWFS5/16	Flat Washer	
12	4	WWL5/16	Lock Washer	
13	2	WWFS6	Flat Washer	
14	2	WWL6	Lock Washer	
15	2	NNK6-32	Kep Nut	
16	AR	1337SA-PD1	Pneumatic Diagram	Page 68
17	AR	1337SA-WD1	Wiring Diagram	Page 70
18	AR	11337SAJ96-PAR1	Parameter Settings	Page 13
19	1	1337-1005	Treadle Assy	Page 38
20	2	AAQMC-5-8	Quick Male Conn.	
21	1	K-3C30A2S	Air Foot Pedal	
22	2	SSSC98040	Socket Cap Screw	
23	2	WWFE012	Fender Washer	
24	2	NNK10-32	Kep Nut	
25	AR	1337-LAB2	Labels	



11337SBJ28A Semi-Auto Panel Flange 3/4 Ga.

AAC Drawing Number 192978C Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	11337HSJ28A	Sew Head Assy
2	AR	11337SAJ96-PAR1	Parameter Settings
3	1	1335001	Air table Assy
4	1	1335368	Table Ext.
5	1	1337-1000	Console Assy
6	1	1337-175A	Shelf
7	AR	1337SA-PD1	Pneumatic Diagram
8	AR	1337SA-WD1	Wiring Diagram
9	1	4059-FP301D	Foot Pedal
10	1	4059-FP1	Air Pedal
11	1	49034	Cloth Plate Supp
12	1	49051	Thread Guide
13	2	AQME-5-8	Quick Male Elbow
14	2'	K-3607T34	Cooper Sash Chain
15	1	K-3C30A2S	Blk Air Foot Pedal
16	1	MMSJ5017	Bumper
17	5	NNK10-32	Kep Nut
18	2	NNK6-32	Kep Nut
19	2	SSBC80024	Button Cap Screw
20	1	SSBC98032	Button Cap Screw
21	2	SSBC98040	Button Cap Screw
22	6	SSHC10064	Hex Cap Screw
23	2	WWL6	Lock Washer
24	4	WWFS10	Flat Washer SAE #10
25	6	WWFS5/16	Flat Washer SAE #5/16
26	2	WWFS6	Flat Washer
27	6	WWL5/16	Lock Washer

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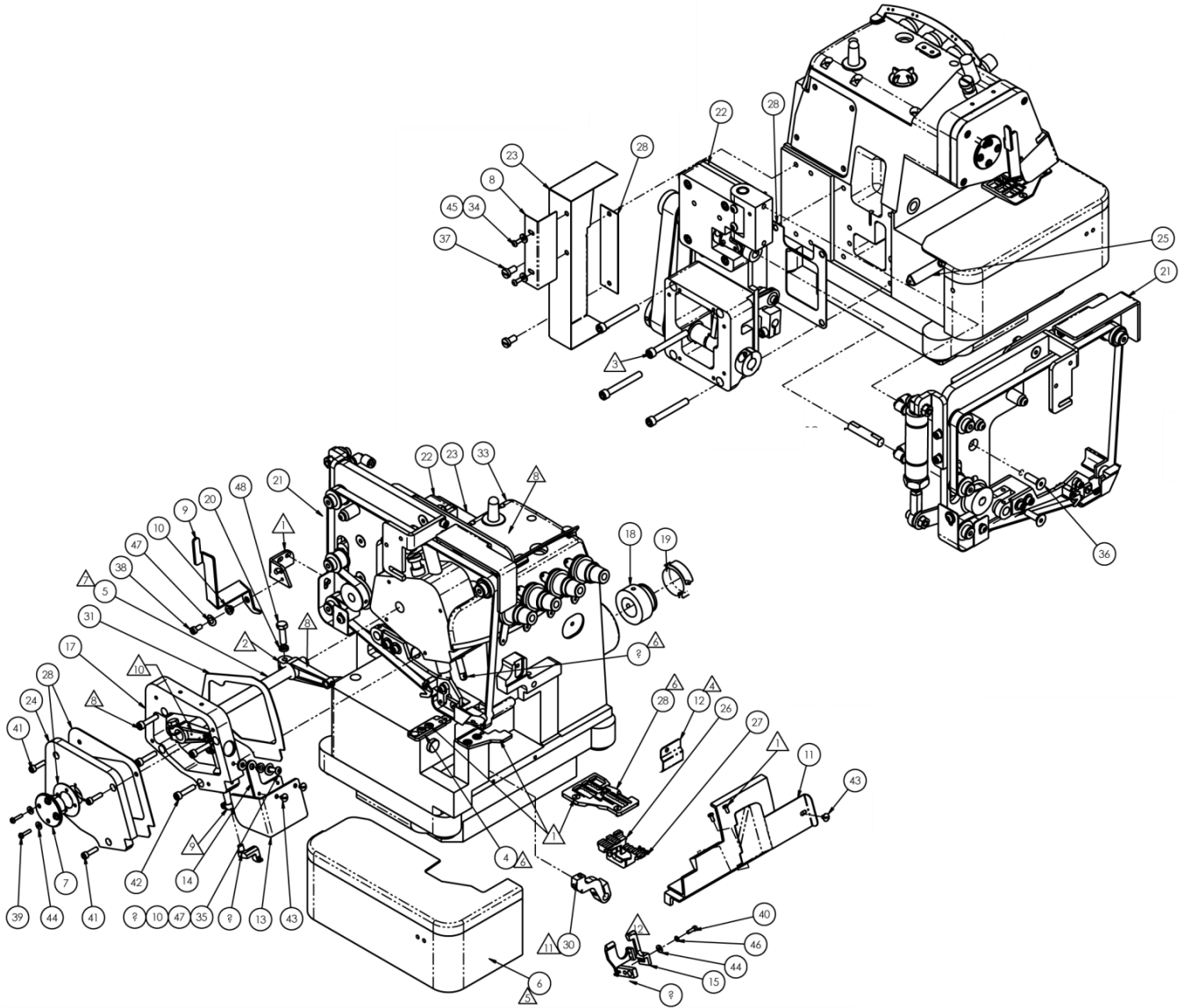
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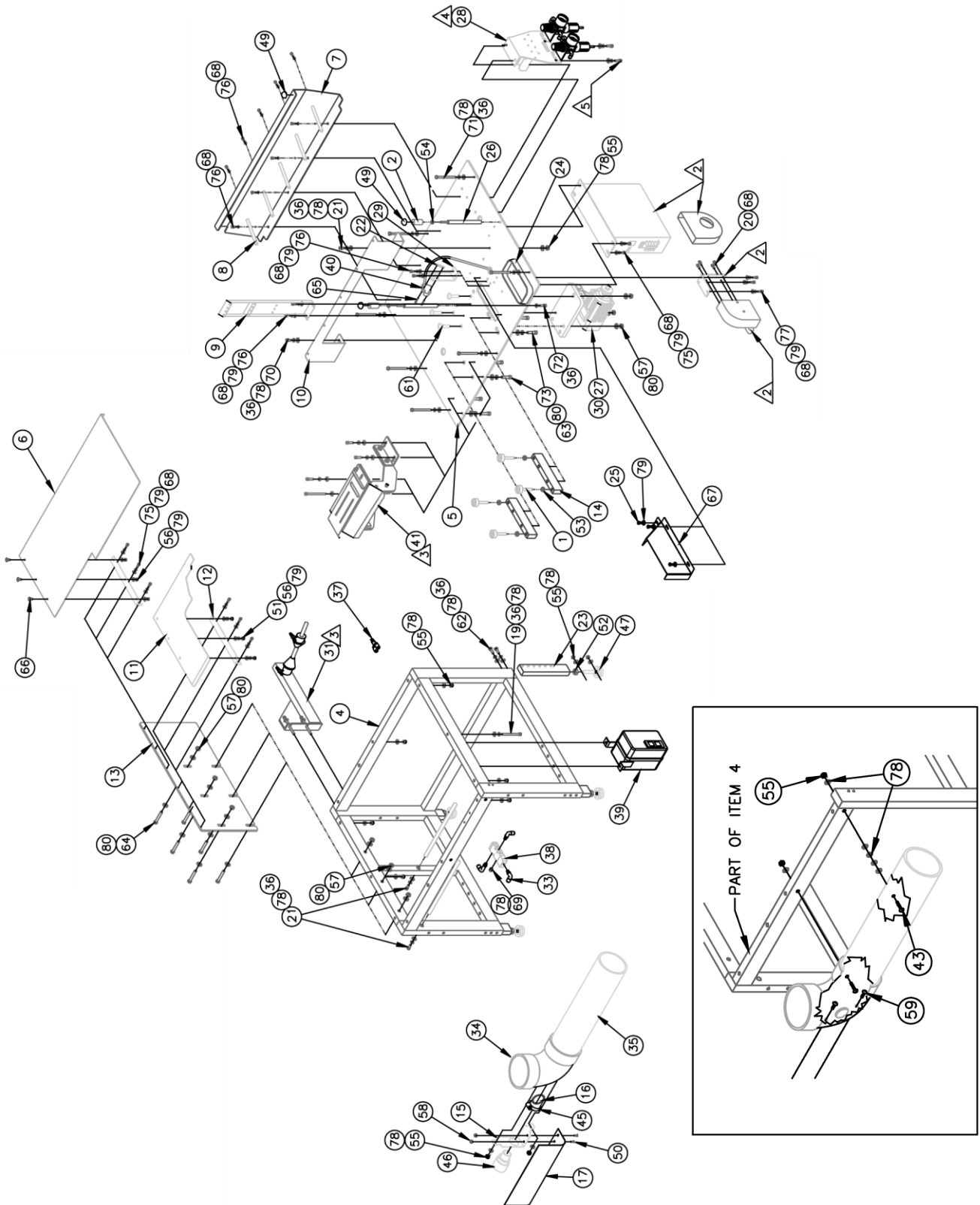
11337HSJ28A Sew Head, Flanger, BLT Feed

AAC Drawing Number 9000090 Rev 7

NO.	QTY	PART #	DESCRIPTION
1	1	MS14A4148	WICK
2	AR	SN135X722	NEEDLE,140
3	1	123-78808M1	NEEDLE CLAMP, M06919G JUK
4	1	49005	REAR THROAT PLATE MT.
5	1	49006	SHAFT,PLAIN,60C,12MMX7.0L
6	1	49021	PLATE,CLOTH MOD.
7	1	49026	BEARING CAP ASSY
8	1	49027	SHIELD,BELT
9	1	49047	PRESSER BAR LEVER
10	2	49063	LEVER SLEEVE
11	1	49065	CHIP DEFLECTOR
12	1	49066	TRIM DEFLECTOR
13	1	49067	GUARD, NEEDLE
14	1	49069	BRACKET, NEEDLE GUIDE
15	1	1337001	FRONT NEEDLE GUARD
16	1	1337002	REAR NEEDLE GUARD
17	1	1337020	LINKAGE ASSY,OUTSIDE NDL
18	1	311-128	HUB, HANDWHEEL, TAPE MOUN
19	1	311-129	SLEEVE TAPE MOUNT ADJUST
20	1	425-14179	STUD SPACER
21	1	49-1000B	BELT FEED ASSY,11337HSJ28
22	1	49-2000C	DRIVE ASSY,HEAVY DUTY
23	1	49024A	COVER,BELT
24	1	49025A	PLATE, SIDE COVER
25	1	B-2402-716-000	LOOPERTHREAD GUIDE TUBE
26	1	M2J96-002	MAIN FEED DOG
27	1	M2J96-003	DIFFERENTIAL FEED DOG
28	1	M3J96-003	PLATE, THROAT, 3/4 GA
29	1	M4J28-002	NEEDLE CHUCK,3/4 GA
30	1	M5J96-001	LOOPER HOLDER
31	AR	MM96165K31	CORK GASKET
32	1	MM98029A043	WASHER,.188ID,.438OD
33	1	SJUKI-6916GX	SEWING HEAD,JUKI,SS,4.8MM
34	2	SSBC80024	#6-32 X 3/8 BUT HEAD
35	1	SSBC90032	#8-32 X 1/2 BUT HEAD
36	2	SSFC01056	1/4-20 X 7/8 FLAT ALLEN
37	2	SSM7151210	SCREW, 15/64-28X7/16
38	1	SSM84-566	SCREW,11/64-40
39	4	SSPS70032	#4-40 X 1/2 PAN HD SLOT
40	1	SSSC70024	#4-40 X 3/8 SOC CAP
41	4	SSSC90040	#8-32 X 5/8 SOC CAP
42	4	SSSC98056	#10-32 X 7/8 SOC CAP
43	3	SSTS85012	#6-40 X 3/16 TRUSS HD
44	5	WWF4	WASHER, FLAT #4
45	2	WWFS6	WASHER, FLAT, #6
46	1	WWL4	#4 LW
47	2	WWS3502-27	SPRING WASHER
48	1	SSHCM6X20S	SCREW, HEX M6X20L SST

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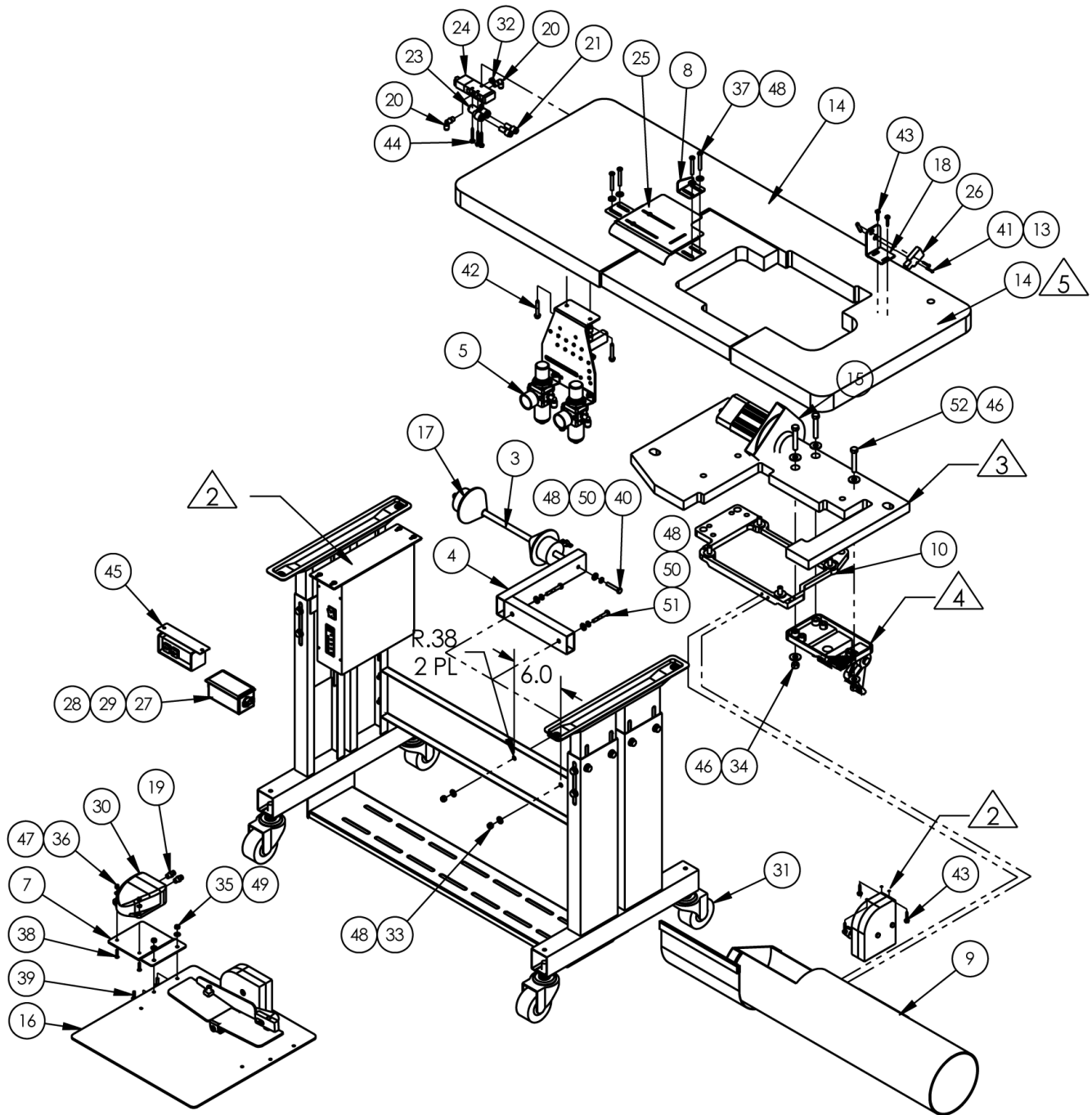
1337-1000 Console Assembly

AAC Drawing Number 192674C Rev 15

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	4	0411-128	Isolater Mnt Assy	43	2	SSBC01112	Button cap Screw
2	2	11200F	Bumper	44	AR	1337SA-PD5	Pneumatic Diagram
3	2	1335-803	Rod	45	1	MM5415K16	Hose Clamp
4	1	1337-4100B	Frame Weldment	46	1	MM6041	Air Amp
5	1	1337-4105B	Table top	47	4	MMFB4444	Rubber Foot
6	1	1337-4201B	Cloth Plate, R	48	1	AAQMF-144	Manifold
7	1	1337-4208A	Thrd Stnd Plate	49	3	MMSJ5017	Bumper
8	5	1337-4209	Thrd Holder Rod	50	2	SSBC090032	Button cap Screw
9	1	1337-4210B	Thread Guide	51	3	NNC10-32	Cap Nut
10	1	1337-4215A	Thread Guide	52	4	HHH1/2-13	Hex Nut
11	1	1337-4216C	Cloth Plate, L	53	4	NNH3/8-16	Hex Nut
12	2	1337-4217	Hinge	54	2	NNJ1/4-28	Jam Nut
13	1	1337-4220	Console, FR Tie	55	19	NNK1/4-20	Kep Nut
14	2	1337-4221	Iso MNT Bar	56	6	NNK10-32	Kep Nut
15	1	1337-4327A	Amp BRKT	57	9	NNK5/16-18	Kep Nut
16	1	1337-4328A	Amp Extension	58	2	NNK8/32	Kep Nut 8-32
17	1	1337-4101	Material Deflector	59	2	SSBC01048	Button cap Screw
18	AR	1337-LAB2	Labels	60	1	ZX3835	V Belt
19	1	SSSC05192	Socket Cap Screw	61	3	SSKB10096	Bolt Carriage
20	4	SSSCM5X14	Socket Cap Screw	62	8	SSHC01048	Hex Cap Screw
21	3	SSSC01048	Socket Cap Screw	63	4	WWL5/16	Lock Washer
22	1	1975-412A	Nut Plate	64	6	SSHC10112	Hex Cap Screw
23	4	132556-273	Leg	65	2	SSPS70048	Pan Slotted Screw
24	1	26151	Tool Tray	66	3	SSFC98032	Flat Allen Screw
25	3	SSPS98024	Pan Slotted Screw	67	1	1338120	Outside Guard
26	2	31101017	Support Rod	68	30	WWL10	Lock Washer
27	1	4059-DC1500	Motor	69	1	MM4554K11	Pipe Plug
28	1	1337-4000	Electrical Comp.	70	2	SSSC01032	Socket Cap Screw
29	1	127B6689B	Eye Mnt BRKT	71	7	SSSC01176	Socket Cap Screw
30	2	SSPSM4X10	Pan Slotted Screw	72	1	SSSC05048	Socket Cap Screw
31	1	1337-3000	Flange Support Comp.	73	4	SSSC10064	Socket Cap Screw
32	1	AAQME-4-4	Quick Male Elbow	74	6in.	ZZZSH-310	Double Sided Tape
33	3	AAQME-5-8	Quick Male Elbow	75	10	SSSC98024	Socket Cap Screw
34	1	1337-003A	Elbow	76	13	SSSC98032	Socket Cap Screw
35	1	1337-004A	Tube	77	3	SSSC98040	Socket Cap Screw
36	20	WWL1/4	Lock Washer	78	38	WWFS1/4	Flat Washer SAE
37	1	AAQUY-3-3	Quick Union	79	23	WWFS10	Flat Washer
38	1	AAV125B	Pilot Valve	80	19	WWFS5/16	Flat Washer SAE
39	1	K-CB600	Motor Starter	81	4	SSSC90080	Socket Cap Screw
40	1	FFSM312LVQ	Electric Eye	82	1	AAQPP-07	Quick Plug 1/4
41	1	1337-2000	Guide Assy	83	1	AAQPP-11	Quick Plug 3/8
42	AR	1337SA-WD1	Wiring Diagram				

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1337H-1000 Console Assembly

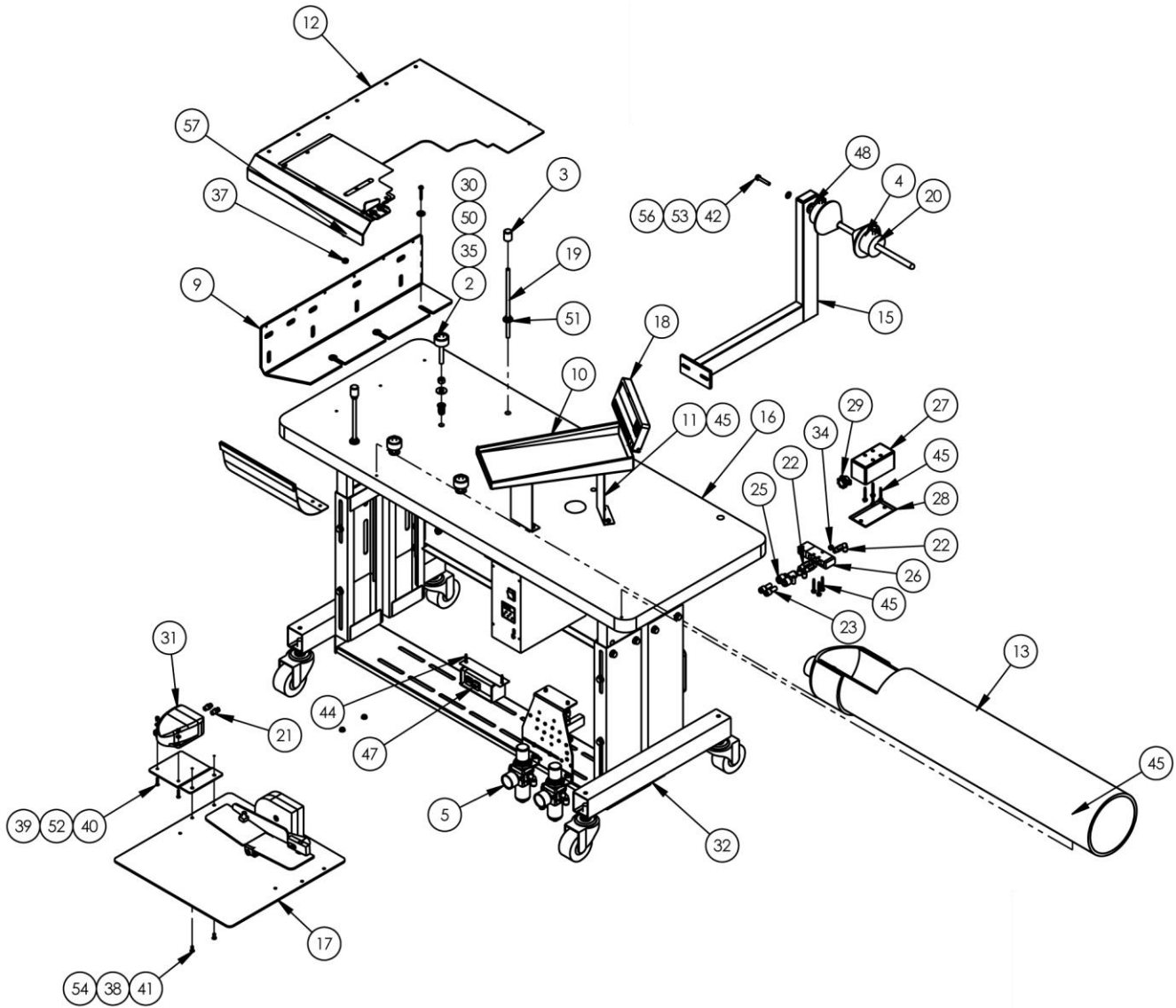
AAC Drawing Number 9001821 Rev 14

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NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	0211-701E	CABLE,I/O,11337SAJ96	28	1	K-231	COVER, 2X4
2	1	0211-702C	CABLE,POS.SENSOR,3',EFKA	29	2	K-235	CONNECTOR,ROMEX,1/2"
3	1	1335-816	ROD,SS, 1/2 X 15.0 L	30	1	K-3C30A2S	FOOT SWITCH ASSY W/O FITTINGS
4	1	1337-001	ROLL HOLDER	31	1	MM4554K11	PLUG, 1/8" PIPE
5	1	1337-1500	PNEUMATIC PANEL	32	2	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
6	*AR	1337-LAB2	LABELS	33	3	NNH3/8-16	NUT,HEX,3/8-16
7	1	1337111	BRKT,PEDAL	34	2	NNK10-32	KEP NUT, 10-32
8	1	1337138	GUIDE, EDGE, RIGHT	35	4	SSBC01112	1/4-20 X 1-3/4 BUT CAP SC
9	1	1337141	WASTE CHUTE TUBE	36	2	SSFC90048	8-32 X 3/4 FLAT AL CAP
10	1	1337149	MODIFICATION TO TRAY	37	2	SSFC98048	#10- 32 X .75 SHCSF
11	*AR	1337SA-PD1	PNEUMATIC DIAGRAM	38	1	SSH01096	1/4-20 X 1-1/2 HHCS
12	*AR	1337SA-WD1	WIRING DIAGRAM	39	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
13	1	1975-412A	PLATE,NUT,4-40,.95CTC	40	2	SSZH#01096	SCREW,HEX SHEET METAL
14	1	4048-3716AM	TABLE TOP, MODIFIED	41	9	SSZH#10064	SCREW,SHT.METAL HEX 10
15	1	4059-DC1500	MOTOR,DC WITH CONTROLLER	42	3	SSZH#10096	SCREW,SHT.METAL HEX 10, 1
16	1	4059-FP301D	FOOT PEDAL ASSY,EFKA	43	1	T75	ON/OFF 1PH SWITCH BOX, ONLY
17	2	787-4A-032	CONE BEARING ASSY.	44	6	WWF3/8	WASHER,FLAT,3/8 OR 10MM
18	1	98205010	BRKT,SENSOR,982A	45	9	WWFS1/4	WASHER,FLAT,SAE,1/4
19	2	AAQMC-5-8	QU. MALE CONN 5/32X1/8	46	2	WWFS10	WASHER, FLAT, #10, SAE
20	3	AAQME-5-8	QUICK MALE ELBOW	47	3	WWL1/4	WASHER,LOCK,1/4
21	2	AAQPR-3-4	QUICK REDUCER 3/8-1/4	48	2	SSH01112	HEX HEAD BOLT 1/4-20X1.75
22	1	AAQUT-4-4	QUICK UNION T 1/4X1/4	49	3	SSHC25144	3/8-16X2-1/4 HEX CAP SC
23	1	AAQUY-3-3	QUICK UNION Y 3/8 X 3/8	50	2	NNK8-32	NUT,KEP,8-32
24	1	AAV125B	PILOT VALVE	51	2	WWF8	WASHER, FLAT, #8
25	1	F661-A-1337E	GUIDE, FLG. 6.5"W X 4.0"D	52	1	K-4D	HD T LEG ADJ STAND
26	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	53	1	1337224	COVER,FOOT PEDAL,UPPER
27	1	K-230	BOX,METAL, 2X4X2	54	1	1337225	BRKT,PEDAL



1337H-1001 Console Assembly

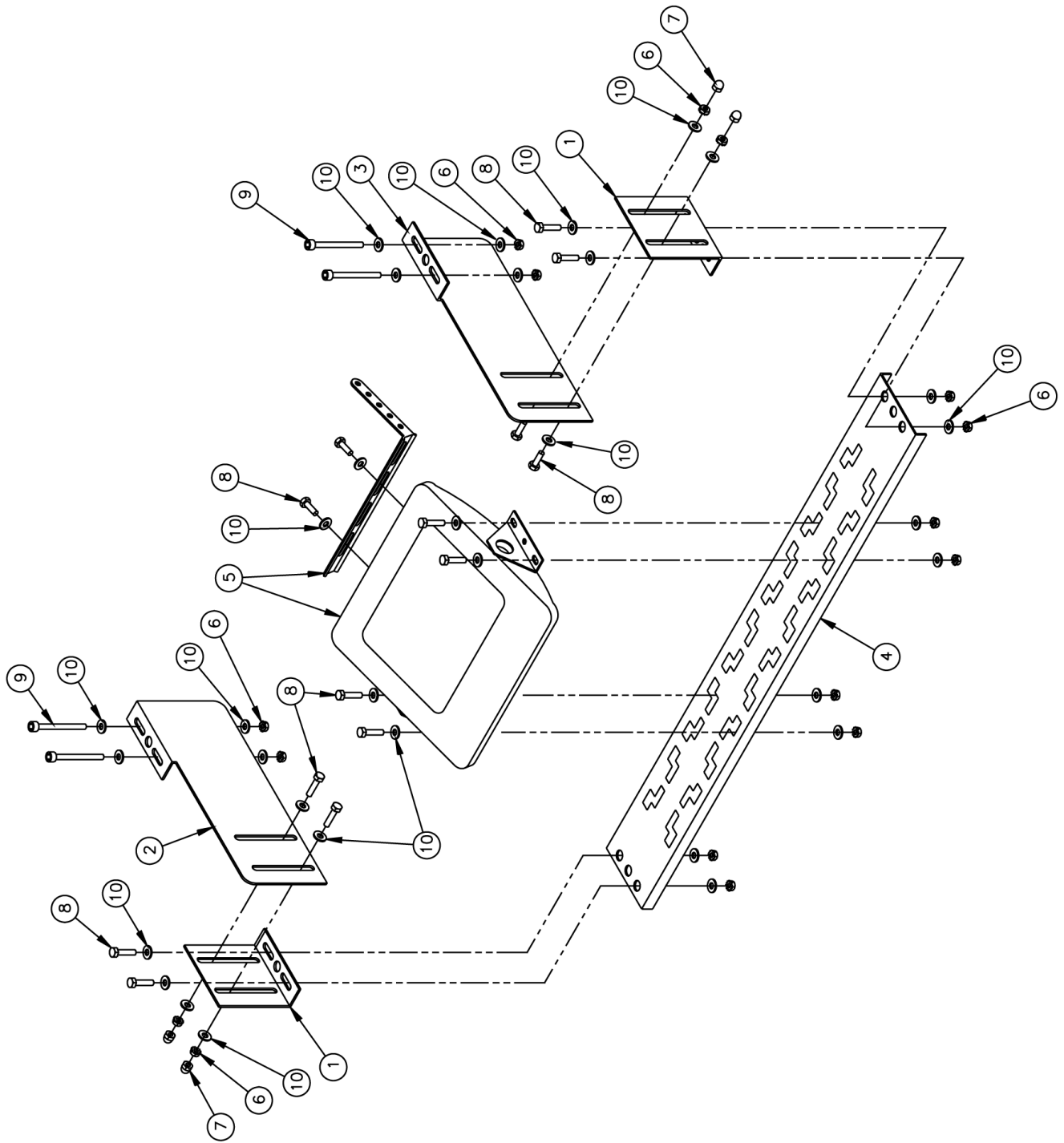
AAC Drawing Number 9002673 Rev 3

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NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	0211-701E	CABLE,I/O,11337SAJ96	30	4	K-340I-3/8	INSERT,LEG,1" LONG
2	4	0411-128B	ISOLATOR MOUNT ASSEMBLY	31	1	K-3C30A2S	FOOT AIR SWITCH PURCHASED
3	2	11200A	BUMPER 5/16-24	32	1	K-4D	HD T LEG ADJ STAND
4	1	1335-816	ROD,SS, 1/2 X 15.0 L	33	1	MM132-1496	PLUG 1 X 2
5	1	1337-1500	PNEUMATIC PANEL	34	1	MM4554K11	PLUG, 1/8" PIPE
6	*AR	1337-LAB2	LABELS	35	4	NNH3/8-16	NUT,HEX,3/8-16
7	1	1337111	BRKT,PEDAL	36	1	NNHM8X1.25	M8 X 1.25 HEX NUT
8	1	1337140	MATERIAL DEFLECTOR	37	6	NNJ5/16-24	NUT,JAM,5/16-24
9	1	1337177	PLATE, CONNECTING, CONSOL	38	2	NNK10-32	KEP NUT, 10-32
10	1	1337178	TOOL TRAY,1X6X14	39	2	NNK8-32	NUT,KEP,8-32
11	2	1337180	MOUNT, TOOL TRAY	40	2	SSFC90048	8-32 X 3/4 FLAT AL CAP
12	1	1337187	FLANGER GUIDE ASS	41	2	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
13	1	1337189	WASTE CHUTE TUBE	42	1	SSH01096	1/4-20 X 1-1/2 HHCS
14	*AR	1337SA-PD1	PNEUMATIC DIAGRAM	43	2	SSHCM8X20	SCREW,HEX CAP
15	1	1959335	ROLL HOLDER ARM	44	4	SSZH#10064	SCREW,SHT.METAL HEX 10
16	1	4048-11337HSE	TABLE TOP 20X48,6900 JUKI	45	19	SSZH#10096	SCREW,SHT.METAL HEX 10, 1
17	1	4059-FP301D	FOOT PEDAL ASSY,EFKA	46	1	SSZH#6096	SCREW,SHT.METAL HEX 6
18	1	4059-V820	EFKA V820 OP PANEL	47	1	T75	ON/OFF 1PH SWITCH BOX, ONLY
19	2	4400025	THREADED ROD, 5/16-24 X 8	48	1	UUFF707-05	BEARING,BRONZE,.502ID
20	2	787-4A-032	CONE BEARING ASSY.	49	3	WWF1/4	WASHER, FLAT, 1/4", COM
21	2	AAQMC-5-8	QU. MALE CONN 5/32X1/8	50	4	WWF3/8	WASHER,FLAT,3/8 OR 10MM
22	3	AAQMEL-5-8	QUICK MALE ELBOW,LONG	51	8	WWF5/16	WASHER,FLAT,5/16
23	2	AAQPR-3-4	QUICK REDUCER 3/8-1/4	52	2	WWF8	WASHER, FLAT, #8
24	1	AAQUT-4-4	QUICK UNION T 1/4X1/4	53	1	WWFS1/4	WASHER,FLAT,SAE,1/4
25	1	AAQUY-3-3	QUICK UNION Y,3/8X3/8	54	2	WWFS10	WASHER, FLAT, #10, SAE
26	1	AAV125B	PILOT VALVE	55	2	WWFS5/16	WASHER, FLAT, 5/16
27	1	K-230	BOX,METAL, 2X4X2	56	1	WWL1/4	WASHER,LOCK,1/4
28	1	K-231	COVER, 2X4	57	7	WWL5/16	WASHER, LOCK, 5/16
29	1	K-235	CONNECTOR,ROMEX,1/2"	58	1	WWLM8	M8 LOCK WASHER

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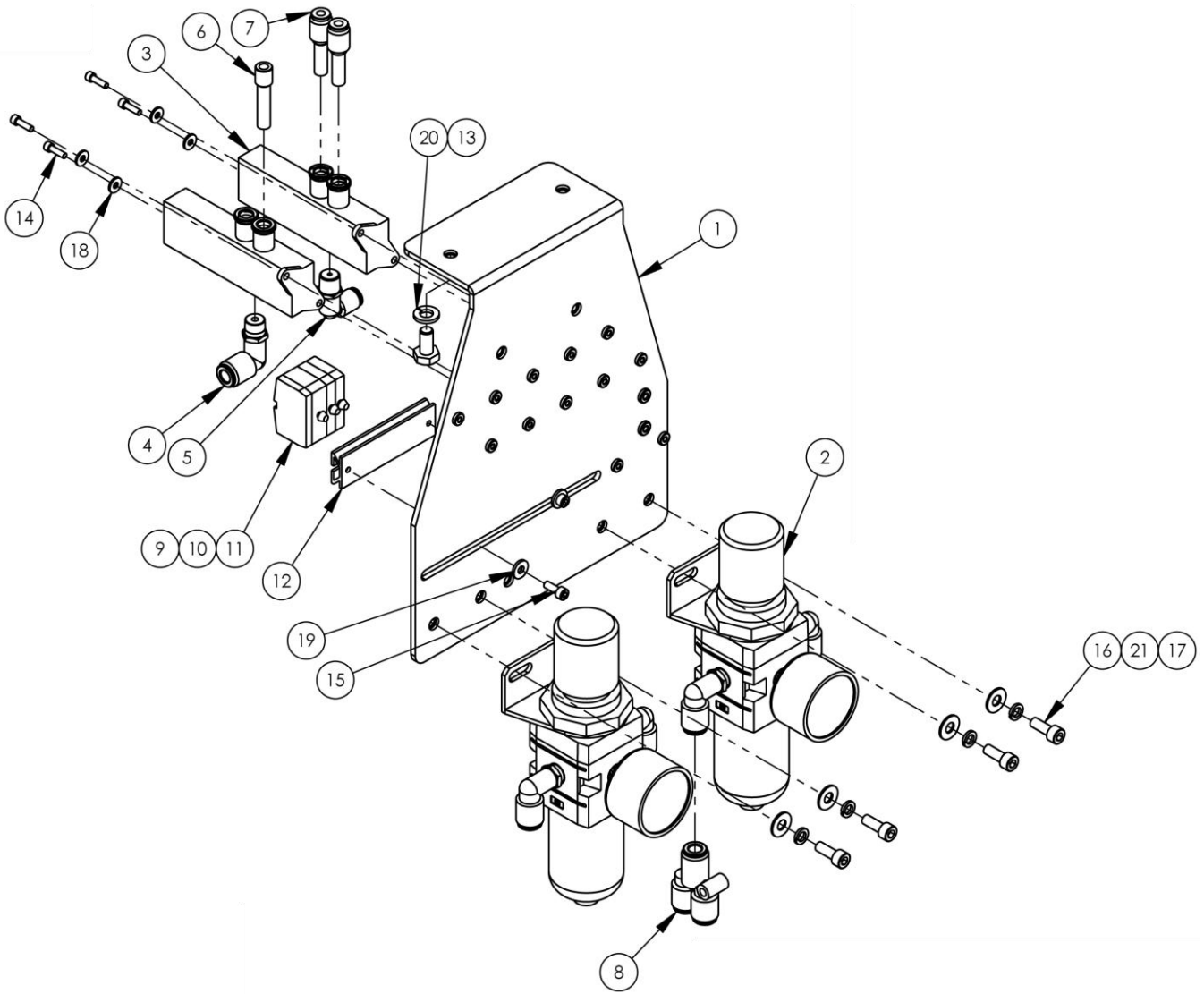


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1337-1005 Sit Down Treadle Assembly

AAC Drawing Number 192977C Rev 2

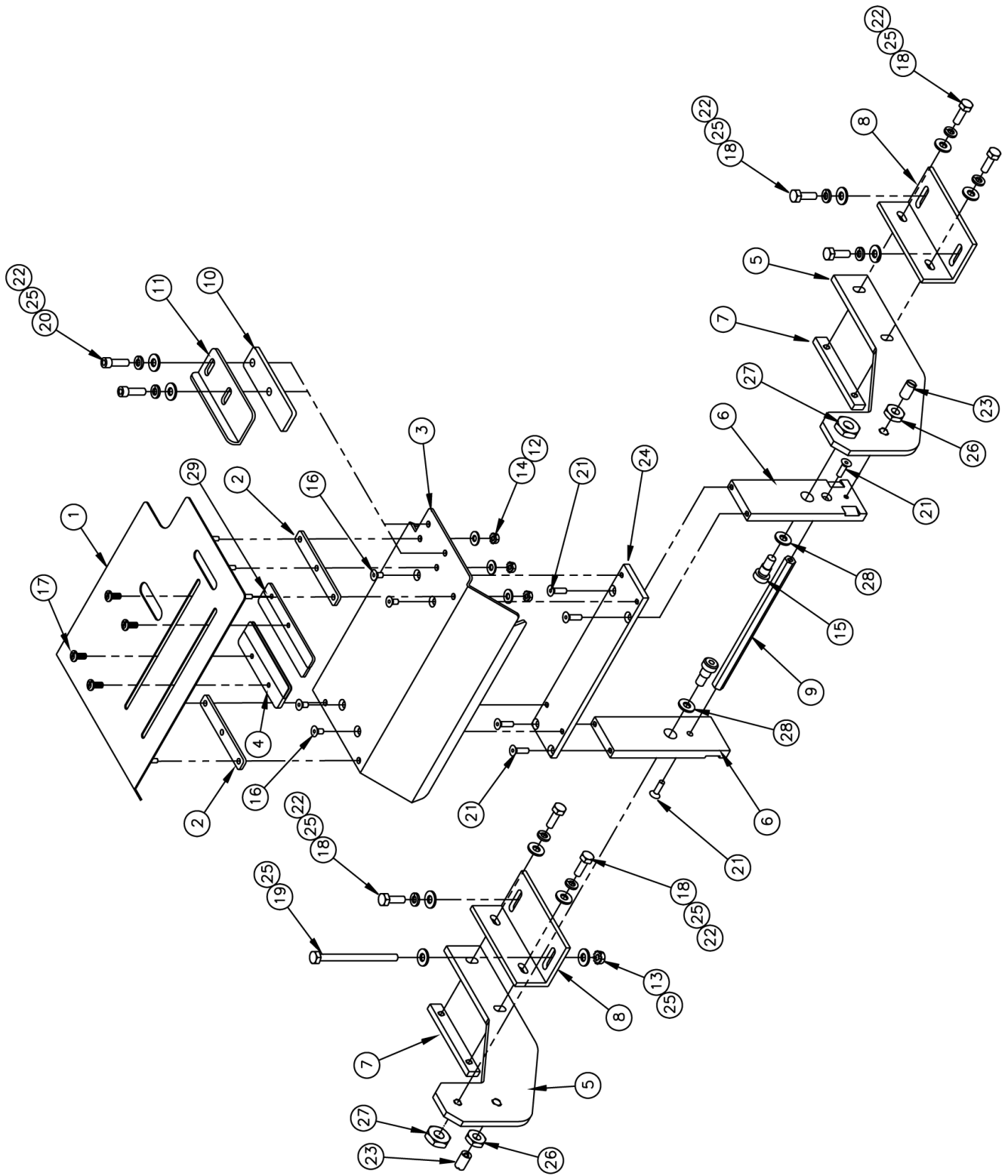
NO.	QTY	PART #	DESCRIPTION
1	2	160929A	Show Stand BRKT
2	1	160929B	Treadle BRKT, L
3	1	160929C	Treadle BRKT, R
4	1	K-100-30M	Treadle Brace
5	1	K-340	Treadle w/ BRKT
6	16	NNK1/4-20	Kep Nut
7	4	NNC1/4-20	Cap Nut
8	14	SSHC01048	Hex Cap Screw
9	4	SSSC01176	Socket Cap Screw
10	34	WWFS1/4	Flat Washer SAE



1337-1500 Pneumatic Panel

AAC Drawing Number 9001804 Rev 7

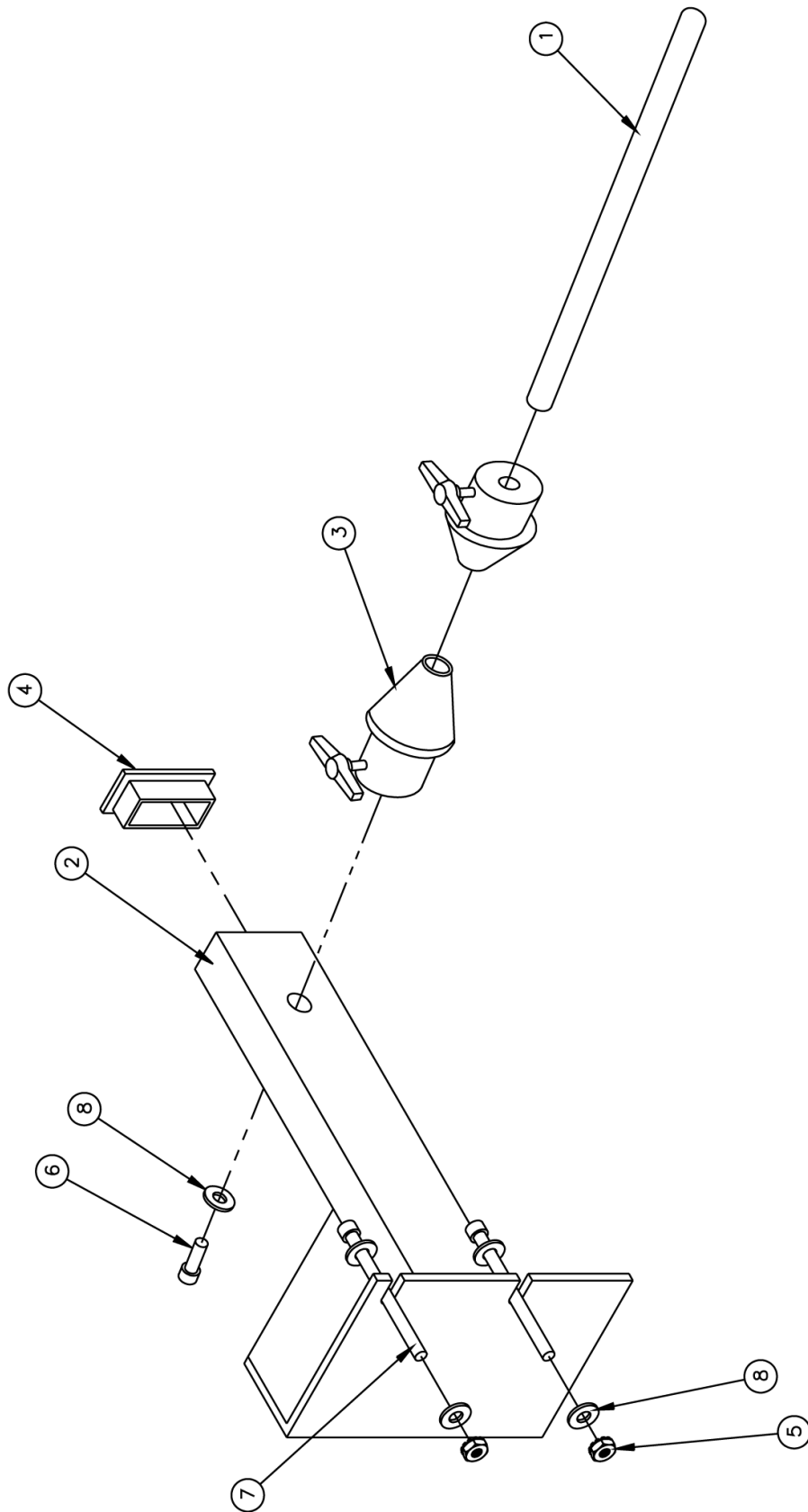
NO.	QTY	PART #	DESCRIPTION
1	1	1338-024	PANEL, PNEUMATIC
2	2	AA198-5102	REGULATOR W/GAUGE & NUT
3	2	AAEVQZ2121	VALVE, BODY PORTED
4	1	AAQME-4-8	ELBOW, QUICK MALE, 1/4X1/8
5	1	AAQME-5-8	QUICK MALE ELBOW
6	1	AAQPP-07	QUICK PLUG 1/4
7	2	AAQPR-5-4	QUICK PLUG-IN REDUCER
8	1	AAQUY-5-4	Y UNION, 5/32X1/4
9	2	FF264-311	TERMBLK, WAGO, TOP, SINGLE, GRY
10	1	FF264-341	TERMBLK, WAGO, TOP, DUAL, GRY
11	1	FF264-371	TERMBLK, WAGO, TOP, END
12	1	FF264-3BKT2.5	MOUNT, WAGO, 2" LONG
13	2	SSHC01032	1/4-20 X 1/2 HHCS
14	4	SSSC70024	4-40 X 3/8 SOCKET CAP
15	2	SSSC80024	6-32 X 3/8 SOC CAP SC
16	4	SSSC98032	10-32X1/2, SOC CAP
17	4	WWF10	WASHER, FLAT, #10, COM
18	4	WWF4	WASHER, FLAT, #4
19	2	WWF6	DO NOT USE - SEE WWFS6
20	2	WWL1/4	WASHER, LOCK, 1/4
21	4	WWL10	WASHER, LOCK, #10, S/S



1337-2000 Guide Assembly

AAC Drawing Number 192675C Rev 3

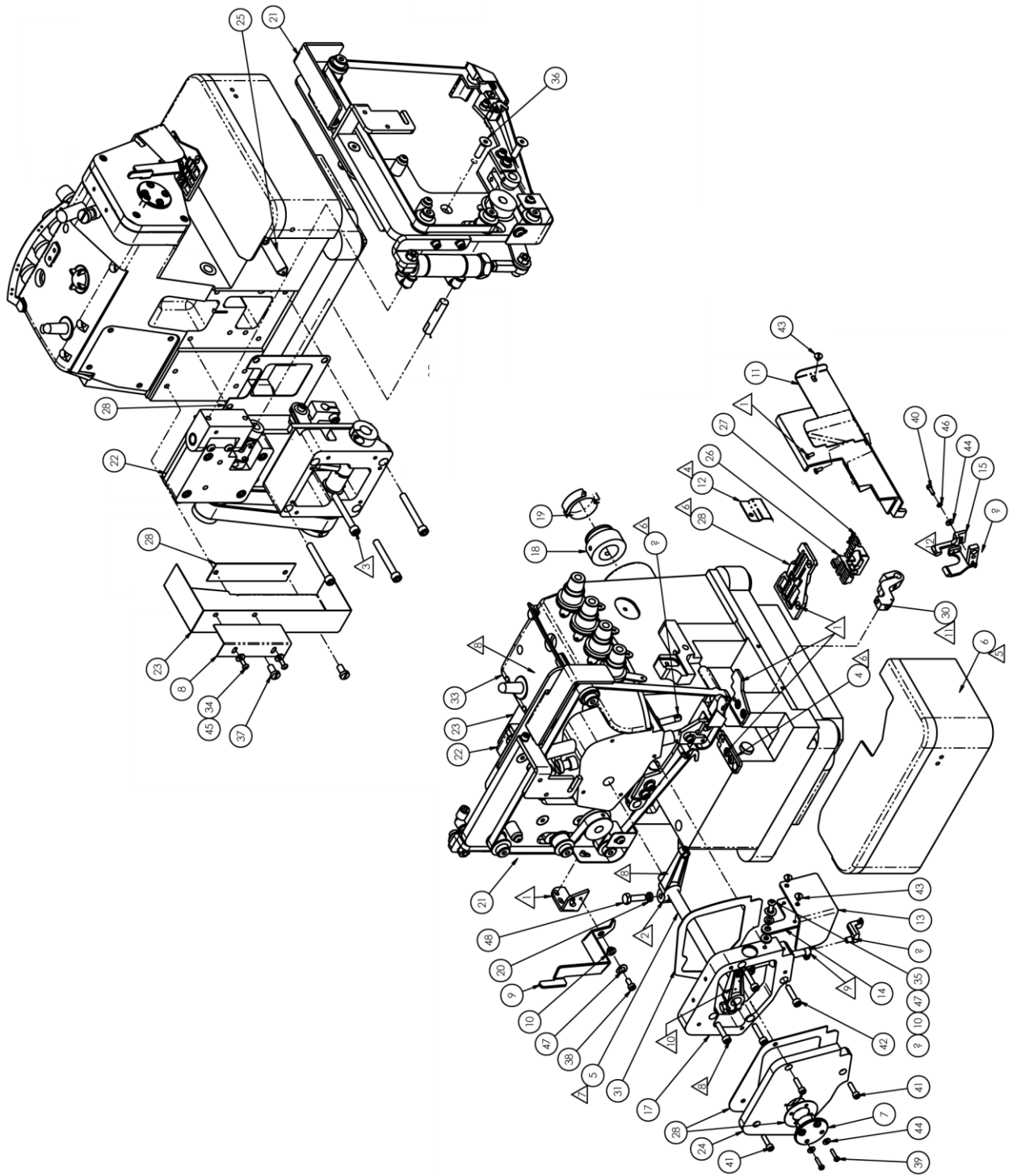
NO.	QTY	PART #	DESCRIPTION
1	1	1337-4301	Top Plate
2	2	1337-4302	Spacer
3	1	1337-4303B	Base Plate
4	1	1337-4304	Adj. Plate
5	2	1337-4306C	Guide Mount
6	2	1337-4333	Pivot Block
7	2	84-2006	Nut Plate
8	2	1337-4321	Mount Angle
9	1	1337-4331	Cross Brace
10	1	1337-4325	Guide Spacer
11	1	1337-4326	Edge Guide
12	5	WWFS10	Flat Washer
13	1	NNK1/4-20	Kep Nut
14	5	NNK10-32	Kep Nut
15	2	SSAS024032	Allen Shoulder Screw
16	4	SSFC98024	Flat Allen Screw
17	4	SSPS98012	Pan HD Slotted Screw
18	7	SSHC01064	Hex Cap Screw
19	1	SSHC01192	Hex Cap Screw
20	2	SSSC05048	Socket Cap Screw
21	6	SSFC98048	Flat Allen Screw
22	9	WWL1/4	Lock Washer
23	2	MM3126A92	Spring Plunger
24	1	1337-4332	Support Bar
25	11	WWFS1/4	Flat Washer
26	2	NNJ3/8-16	Jam Nut
27	2	NNJ5/16-18	Jam Nut
28	2	WWSB075028	Spring Washer
29	1	1337-4313	Flange Guide



1337-3000 Flange Support Components

AAC Drawing Number 192676C Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1	1335-816c	Rod
2	1	1337-4121	Arm Weldment
3	2	787-4A-032	Cone Bearing
4	1	MM132-1496	End Cap
5	2	NNK1/4-20	Kep Nut
6	1	SSSC01128	Socket Cap Screw
7	2	SSSC01176	Socket Cap Screw
8	5	WWFS1/4	Flat Washer



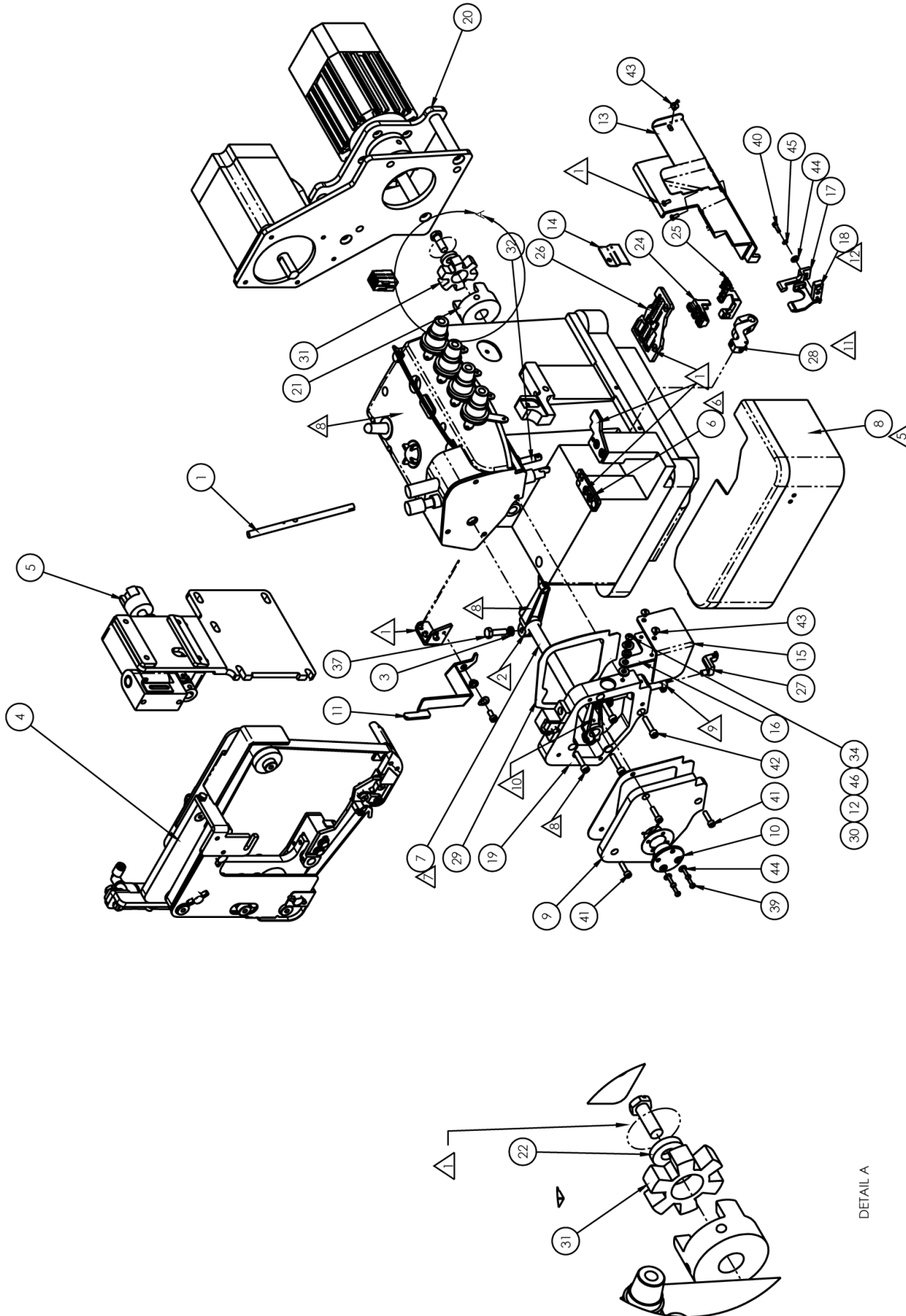
11337HSL28A Sew Head and Flanger

AAC Drawing Number 9000090 Rev 7

NO.	QTY	PART #	DESCRIPTION
1	1	MS14A4148	WICK
2	AR	SN135X722	NEEDLE,140
3	1	123-78808M1	NEEDLE CLAMP, M06919G JUK
4	1	49005	REAR THROAT PLATE MT.
5	1	49006	SHAFT,PLAIN,60C,12MMX7.0L
6	1	49021	PLATE,CLOTH MOD.
7	1	49026	BEARING CAP ASSY
8	1	49027	SHIELD,BELT
9	1	49047	PRESSER BAR LEVER
10	2	49063	LEVER SLEEVE
11	1	49065	CHIP DEFLECTOR
12	1	49066	TRIM DEFLECTOR
13	1	49067	GUARD, NEEDLE
14	1	49069	BRACKET, NEEDLE GUIDE
15	1	1337001	FRONT NEEDLE GUARD
16	1	1337002	REAR NEEDLE GUARD
17	1	1337020	LINKAGE ASSY,OUTSIDE NDL
18	1	311-128	HUB, HANDWHEEL, TAPE MOUN
19	1	311-129	SLEEVE TAPE MOUNT ADJUST
20	1	425-14179	STUD SPACER
21	1	49-1000B	BELT FEED ASSY,11337HSJ28
22	1	49-2000C	DRIVE ASSY,HEAVY DUTY
23	1	49024A	COVER,BELT
24	1	49025A	PLATE, SIDE COVER
25	1	B-2402-716-000	LOOPERTHREAD GUIDE TUBE
26	1	M2J96-002	MAIN FEED DOG
27	1	M2J96-003	DIFFERENTIAL FEED DOG
28	1	M3J96-003	PLATE, THROAT, 3/4 GA
29	1	M4J28-002	NEEDLE CHUCK,3/4 GA
30	1	M5J96-001	LOOPER HOLDER
31	AR	MM96165K31	CORK GASKET
32	1	MM98029A043	WASHER,.188ID,-.438OD
33	1	SJUKI-6916GX	SEWING HEAD,JUKI,SS,4.8MM
34	2	SSBC80024	#6-32 X 3/8 BUT HEAD
35	1	SSBC90032	#8-32 X 1/2 BUT HEAD
36	2	SSFC01056	1/4-20 X 7/8 FLAT ALLEN
37	2	SSM7151210	SCREW, 15/64-28X7/16
38	1	SSM84-566	SCREW,11/64-40
39	4	SSPS70032	#4-40 X 1/2 PAN HD SLOT
40	1	SSSC70024	#4-40 X 3/8 SOC CAP
41	4	SSSC90040	#8-32 X 5/8 SOC CAP
42	4	SSSC98056	#10-32 X 7/8 SOC CAP
43	3	SSTS85012	#6-40 X 3/16 TRUSS HD
44	5	WWF4	WASHER, FLAT #4
45	2	WWFS6	WASHER, FLAT, #6
46	1	WWL4	#4 LW
47	2	WWS3502-27	SPRING WASHER
48	1	SSHCM6X20S	SCREW, HEX M6X20L SST

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11337HSEJ28A Sew Head and Flanger

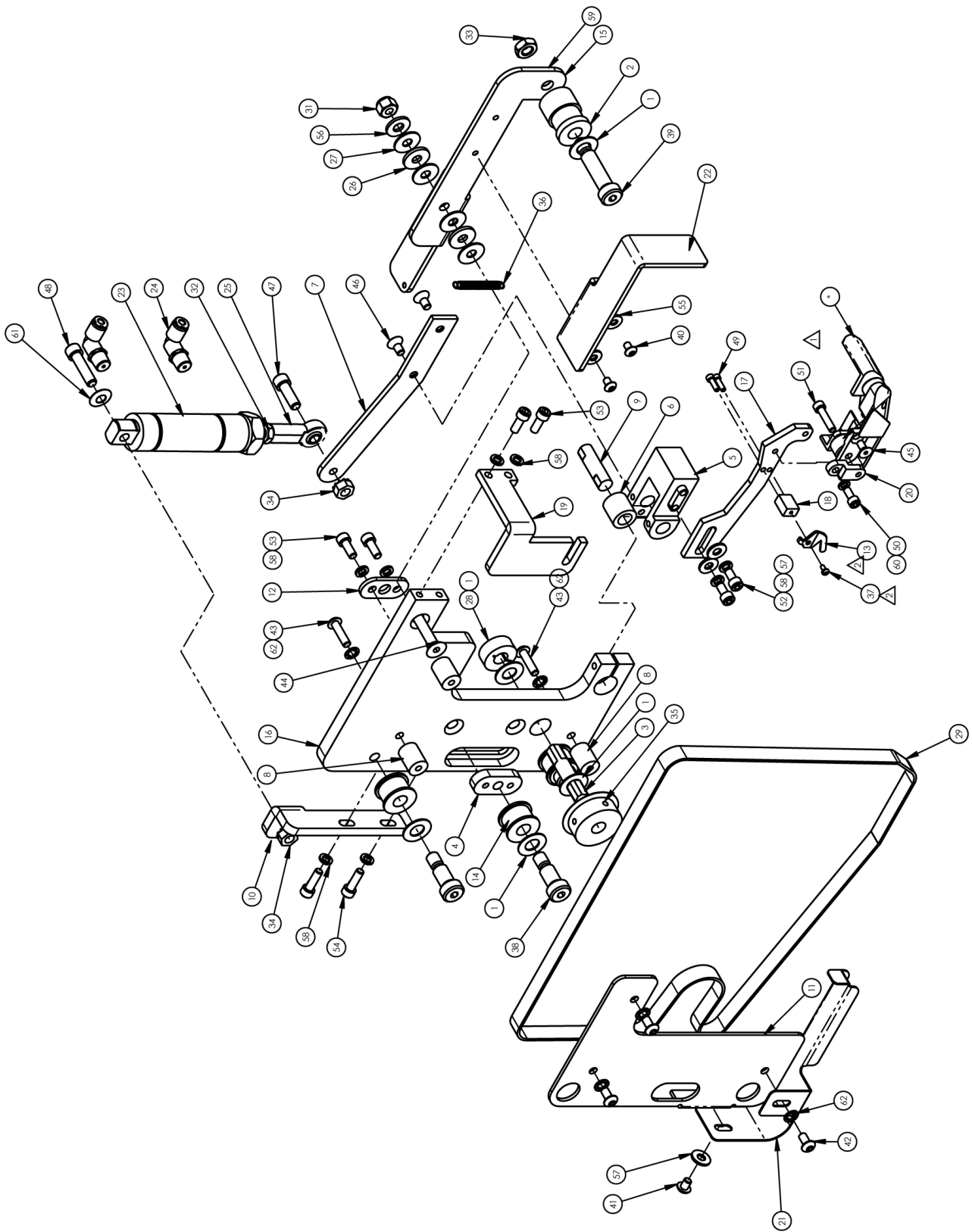
AAC Drawing Number 9002680 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	123-72157M	NEEDLE BAR,MODIFIED
2	1	123-78808M1	NEEDLE CLAMP, M06919G JUK
3	1	425-14179	STUD SPACER
4	1	49-1000C	BELT FEED ASSY,11337HSEJ2
5	1	49-2000E	DRIVE ASSY,HEAVY DUTY
6	1	49005	REAR THROAT PLATE MT.
7	1	49006	SHAFT,PLAIN,60C,12MMX7.0L
8	1	49021	PLATE,CLOTH MOD.
9	1	49025A	PLATE, SIDE COVER
10	1	49026	BEARING CAP ASSY
11	1	49047	PRESSER BAR LEVER
12	1	49063	LEVER SLEEVE
13	1	49065	CHIP DEFLECTOR
14	1	49066	TRIM DEFLECTOR
15	1	49067	GUARD, NEEDLE
16	1	49069	BRACKET, NEEDLE GUIDE
17	1	1337001	FRONT NEEDLE GUARD
18	1	1337002	REAR NEEDLE GUARD
19	1	1337020	LINKAGE ASSY,OUTSIDE NDL
20	1	1337169	MOTOR MOUNT ASSY
21	1	1337218	COUPLING,15MM BORE
22	1	9003365	MOD,JUKI PT WP-0764016-SP
23	1	B-2402-716-000	LOOPERTHREAD GUIDE TUBE
24	1	M2J96-002	MAIN FEED DOG
25	1	M2J96-003	DIFFERENTIAL FEED DOG
26	1	M3J96-003	PLATE, THROAT, 3/4 GA
27	1	M4J28-002	NEEDLE CHUCK,3/4 GA
28	1	M5J96-001	LOOPER HOLDER
29	AR	MM96165K31	CORK GASKET
30	1	MM98029A043	WASHER,.188ID,.438OD
31	1	MML075H	SPIDER,HITRL
32	1	SJUKI-6916G	SEWING HEAD,JUKI,SS,4.8MM
33	AR	SNTVX7X140GB	NEEDLE,SZ140/22,SCHMETZ
34	1	SSBC90032	8-32X1/2 BUTTON CAP
35	1	SSBC90040	8-32 X 3/4 BUTTON CAP
36	2	SSFC01056	1/4-20 X 7/8 FLAT CAP
37	1	SSHCM6X20S	SCREW, HEX M6X20L SST
38	1	SSPS70016	4-40 X 1/2 PAN HD SLOTTED
39	4	SSPS70032	4-40 X 1/2 PAN HD SLOTTED
40	1	SSSC70024	4-40 X 3/8 SOCKET CAP
41	4	SSSC90040	8-32 X 5/8 SOC CAP SC
42	4	SSSC98056	10-32 X 7/8 SOC CAP
43	3	SSTS85012	6-40 X 3/16 TRUSS HEAD
44	5	WWF4	WASHER, FLAT, #4
45	1	WWL4	WASHER,LOCK,#4
46	1	WWS3502-27	SPRING WASHER

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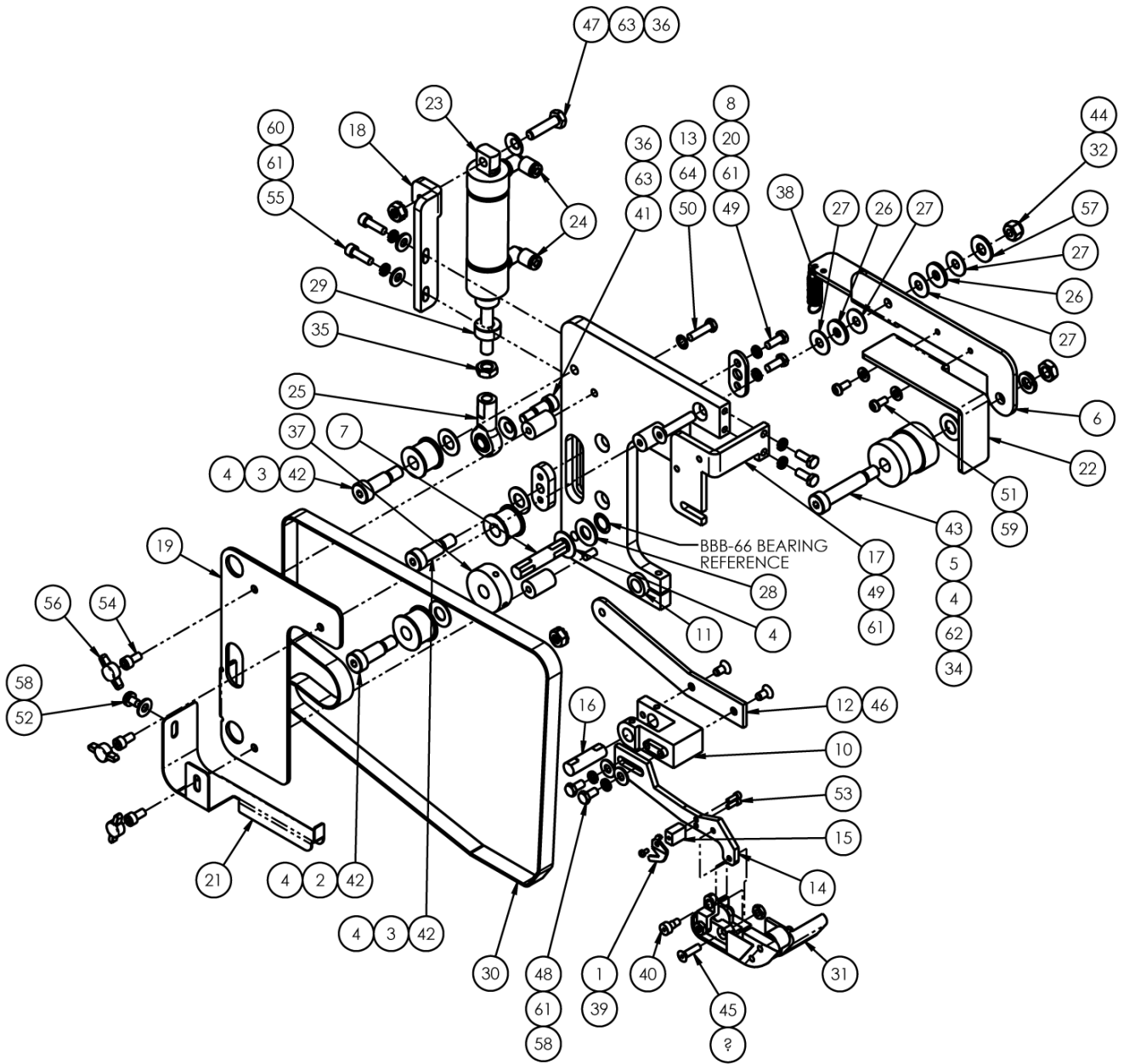
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49-1000B Belt Feed Assembly

AAC Drawing Number 9000057 Rev 4

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	6	3517	WASHER, THRUST, BRONZE	32	1	NNJ1/4-28	1/4-28 HEX JAM NUT
2	1	49023	ROLLER, FRONT	33	1	NNJ5/16-18	5/16-18 HEX JAM NUT
3	1	49030	SHAFT, DRIVE	34	2	NNK1/4-20	KEP NUT, 1/4-20
4	1	49031	SPACER, IDLER ROLLER	35	1	PP20XLB037M	PULLEY, MOD., 1/5P, 20T, 3/8B
5	1	49033	BLOCK, PRESSER ARM PIVOT	36	1	RRE29C	SPRING, EXT .020X.19X1.5
6	1	49035	BUSHING, PIVOT, PRESSER ARM	37	1	SS-7060510-SP	3/32-56 x 3/16 PAN HD
7	1	49036	ARM, FOOTLIFT	38	3	SSAS024040	3/8 X 5/8 X 5/16-18 SHLD, BOLT
8	3	49038	BELT COVER SPACER	39	1	SSAS024080	3/8X1-1/4, 5/16-18 SHLDBOLT
9	1	49040	PRESSER ARM PIVOT SHAFT	40	2	SSBC90016	#8-32 X 1/4 BUT HEAD
10	1	49045	MOUNT, FOOTLIFT CYL	41	1	SSBC98016	#10-32 X 1/4 BUT HD.
11	1	49048	BELT COVER	42	3	SSBC98024	#10-32 X 3/8 BUT HEAD
12	1	49049	PLATE, WASHER	43	3	SSBC98048	#10-32 X 3/4 BUT HEAD
13	1	13116702	THREAD TRIMMER	44	1	SSFC01080	1/4-20 X 1-1/4 FLAT ALLEN
14	3	1342Z-201	ROLLER, DELRIN, TOP BELT FD	45	1	SSFC90024	#8-32 x 3/8 FLAT ALLEN
15	1	49028A	ARM, BELT TENSION	46	2	SSFC98024	#10-32 X 3/8 FLAT ALLEN
16	1	49032A	MOUNT, MAIN	47	1	SSSC01048	1/4-20 X 3/4 SOC CAP
17	1	49039D	ARM, PRESSER, 11337HSJ28A	48	1	SSSC01064	1/4-20 X 1 SOC CAP
18	1	49039E	BRKT, THREAD CUTTER	49	2	SSSC70024	#4-40 X 3/8 SOC CAP
19	1	49041A	TOP SUPPORT BRKT	50	1	SSSC90024	#8-32 X 3/8 SOC CAP
20	1	49046A	PRESSER ARM LINK	51	1	SSSC90048	#8-32 X 3/4 SOC CAP
21	1	49050A	GUARD, BELT, EXTENDED	52	2	SSSC98024	#10-32 X 3/8 SOC CAP
22	1	49068A	GUARD, BELT	53	4	SSSC98032	#10-32 X 1/2 SOC CAP
23	1	AAC06.5DXP	CYLINDER, AIR, DA	54	2	SSSC98040	#10-32 X 5/8 SOC CAP
24	2	AAQME-5-8	QUICK MALE ELBOW	55	2	WWF8	WASHER, FLAT #8
25	1	BBAW-4	BEARING, ROD END, FEMALE	56	1	WWFS1/4	WASHER FLAT, 1/4
26	2	BBNTA411	BEARING, THRUST, .250B	57	3	WWFS10	WASHER, FLAT #10
27	4	BBTRA411	WASHER, THRUST, STEEL	58	8	WWL10	#10 LW
28	1	CCCL6F	CLAMP COLLAR- 3/8	59	1	WWL5/16	5/16 LW
29	1	GG356XL037U	BELT, GEAR, KEVLAR CORE, URE	60	1	WWL8	#8 LW
30	1	M1J28-001	FOOT, 3/4 GA, TBF, MO6916G	61	1	WWS307-1	WASHER, SPRING, BELVEL
31	1	NNE1/4-20	NUT, ELASTIC LOCK, 1/4-20	62	6	WWS110	WASHER, INTERNAL TOOTH, 10

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49-1000C Belt Feed Assembly

AAC Drawing Number 9002697 Rev 4

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	13116702	THREAD TRIMMER	33	1	NNH8-32	HEX-NUT 8-32 REG.
2	1	1342Z-201A	ROLLER,DELRIN, TOP BELT FD	34	1	NNJ5/16-18	NUT,JAM,5/16-18
3	2	1342Z-201B	ROLLER,DELRIN, TOP BELT FD	35	1	NNJ5/16-24	NUT,JAM,5/16-24
4	5	3517	WASHER, THRUST, BRONZE	36	2	NNK1/4-20	NUT, HEX, KEP, 1/4-20, W/LOCK
5	1	49023A	ROLLER, FRONT	37	1	PP20XLB037M4	PULLEY, MOD, 1/5P, 20T, 3/8B
6	1	49028A	ARM, BELT TENSION	38	1	RRE29C	SPRING, EXT .020X.19X1.5
7	1	49030	SHAFT, DRIVE	39	1	SS-7060510-SP	3/32-56 x 3/16 PAN HD
8	1	49031	SPACER, IDLER ROLLER	40	1	SSAS012012S	SCREW, ALLEN SHOULDER, S/S
9	1	49032A	MAIN MOUNTING PLATE	41	1	SSAS020032	SHOULDER BOLT 5/16 X 1/2L
10	1	49033	BLOCK, PRESSER ARM PIVOT	42	3	SSAS024048	SHULDER BOLT 3/8 X .75L
11	1	49035	BUSHING, PIVOT, PRESSER ARM	43	1	SSAS024096	SHULDER BOLT 3/8 X 1.50L
12	1	49036	ARM, FOOTLIFT	44	1	SSFC01080	1/4-20 X 1-1/4 FLAT CAP
13	3	49038A	BELT COVER SPACER	45	1	SSFC90040	8-32 x 2 FLAT ALLEN
14	1	49039D	ARM, PRESSER, 11337HSJ28A	46	2	SSFC98024	#10-32 X .375 FLAT CAP
15	1	49039E	BRKT, THREAD CUTTER	47	1	SSHCO1064	1/4-20 X 1 HHCS
16	1	49040	PRESSER ARM PIVOT SHAFT	48	2	SSHC98024	10-32 X 3/8 HEX CAP
17	1	49041A	TOP SUPPORT BRKT	49	4	SSHC98032	10-32X1/2 HEX HD
18	1	49045	MOUNT, FOOTLIFT CYL	50	3	SSHC98048	SCREW, HEX CAP #10-32X.75
19	1	49048	BELT COVER	51	2	SSPS90024	#8-32 X 3/8 LG PAN HD
20	1	49049	PLATE, WASHER	52	1	SSPS98016	10-32 X 1/4 PAN HD SLOT
21	1	49050B	GUARD, BELT, EXTENDED	53	2	SSSC70020	#4-40 X 5/16 SOCKET CAP
22	1	49068A	GUARD, BELT	54	3	SSSC98024	10-32 X 3/8 SOC CAP
23	1	AAC6DP-1	CYLINDER, AIR, DA	55	2	SSSC98040	10-32 X 5/8 SOC CAP
24	2	AAQME-5-8	QUICK MALE ELBOW	56	3	SSW#10	WING SCREW KNOB
25	1	BBAW-5Z	ROD END, SPHERICAL .5/16ID	57	1	WWF1/4	WASHER, FLAT, 1/4", COM
26	2	BBNTA411	BEARING, THRUST, .250B	58	3	WWF10	WASHER, FLAT, #10, COM
27	4	BBTRA411	WASHER, THRUST, STEEL	59	2	WWF8	WASHER, FLAT, #8
28	1	BBTT710-01	WASHER, THRUST, BRNZ.	60	2	WWFS10	WASHER, FLAT, #10, SAE
29	1	CCCL5F	CLAMP COLLAR, 5/16" BORE	61	8	WWL10	WASHER, LOCK, #10, S/S
30	1	GG356XL050U	BELT, GEAR, KEVLAR CORE, URE	62	1	WWL5/16	WASHER, LOCK, 5/16
31	1	M1J28-001A	FOOT, 3/4 GA, TBF, MO6916G	63	2	WWS5808	BELVILLE WASHER, .323I.D.X
32	1	NNE1/4-20	NUT, ELASTIC LOCK, 1/4-20	64	3	WWSI10	WASHER, INTERNAL TOOTH, 10

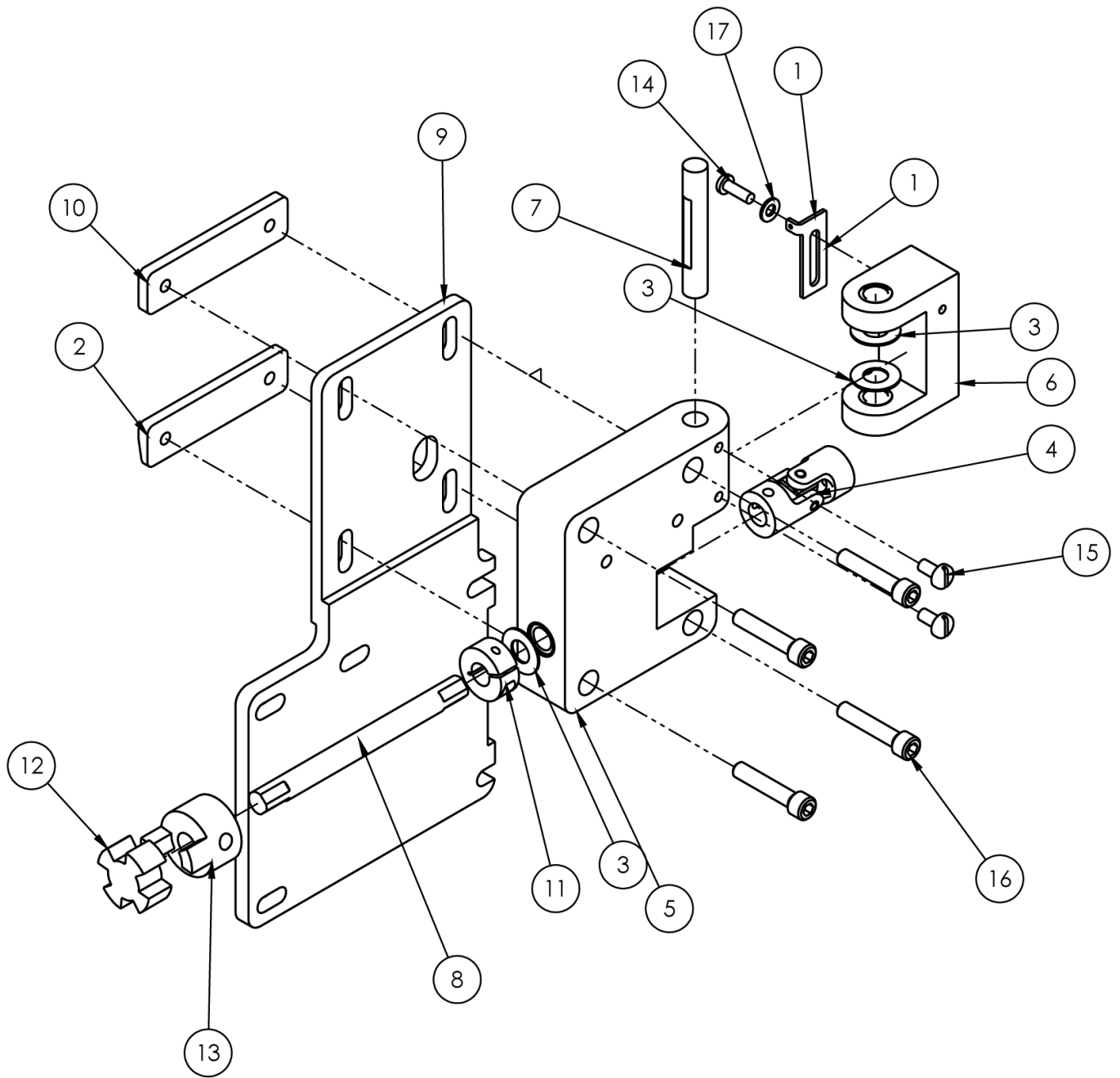
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49-2000C Drive Assembly, Heavy Duty

AAC Drawing Number 192940B Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	1337010	GEAR PULLEY
2	3	3517	THRUST WASHER
3	1	3524-02	U-JOINT
4	1	49007A	DRIVE ARM
5	1	49008J	CLUTCH DRIVE ASSY
6	1	49009	CONN. ARM
7	1	BBTT710-01	WASHER, THRUST,3/8
8	1	49011B	DRIVE SHAFT
9	1	49012	TRANSFER BLOCK
10	1	49013B	DRIVE HOUSING
11	1	49014	PIVOT BLOCK
12	1	49015	PIVOT SHAFT
13	1	49016A	TRANSFER SHAFT
14	1	49018	MOUNT PLATE, R
15	1	49019	DRIVE COVER
16	1	49022	NUT PLATE
17	2	BBTRA815	STEEL THRUST WASHER
18	1	CCCL6F	CLAMP COLLAR
19	1	GG140XL75U	GEAR BELT
20	1	MM95630A219	TEFLON WASHER
21	1	NNK 10-32	KEP NUT
22	8	SSBC90032	BUTTON CAP SCREW
23	2	SSBC98024	BUTTON CAP SCREW
24	1	CCCL8F	CLAMP COLLAR
25	4	SSSC01080	SOCKET CAP SCREW
26	4	SSSC05128	SOCKET CAP SCREW
27	1	SSSC98056	SOCKET CAP SCREW
28	8	WWSI8	INT. TOOTH WASHER
29	AR	MM96165K31	CORK GASKET
30	REF	BBKS3	BEARING
31	1	1337006	GEAR PULLEY
32	2	MM98029A043	HARD STL WASHER
33	1	NNL 10-32	FLEX LOCK NUT
34	1	SSSC98064	SOCKET CAP SCREW
35	1	1325-39C	MNT, SPRING CLIP
36	1	SSPS90032	PAN HD SLOTTED SCREW
37	1	WWF8	FLAT WASHER
38	2	BBTT1001	WASHER,THRUST,BRONZE
39	1	1337031	ANGLED PLATE NUT

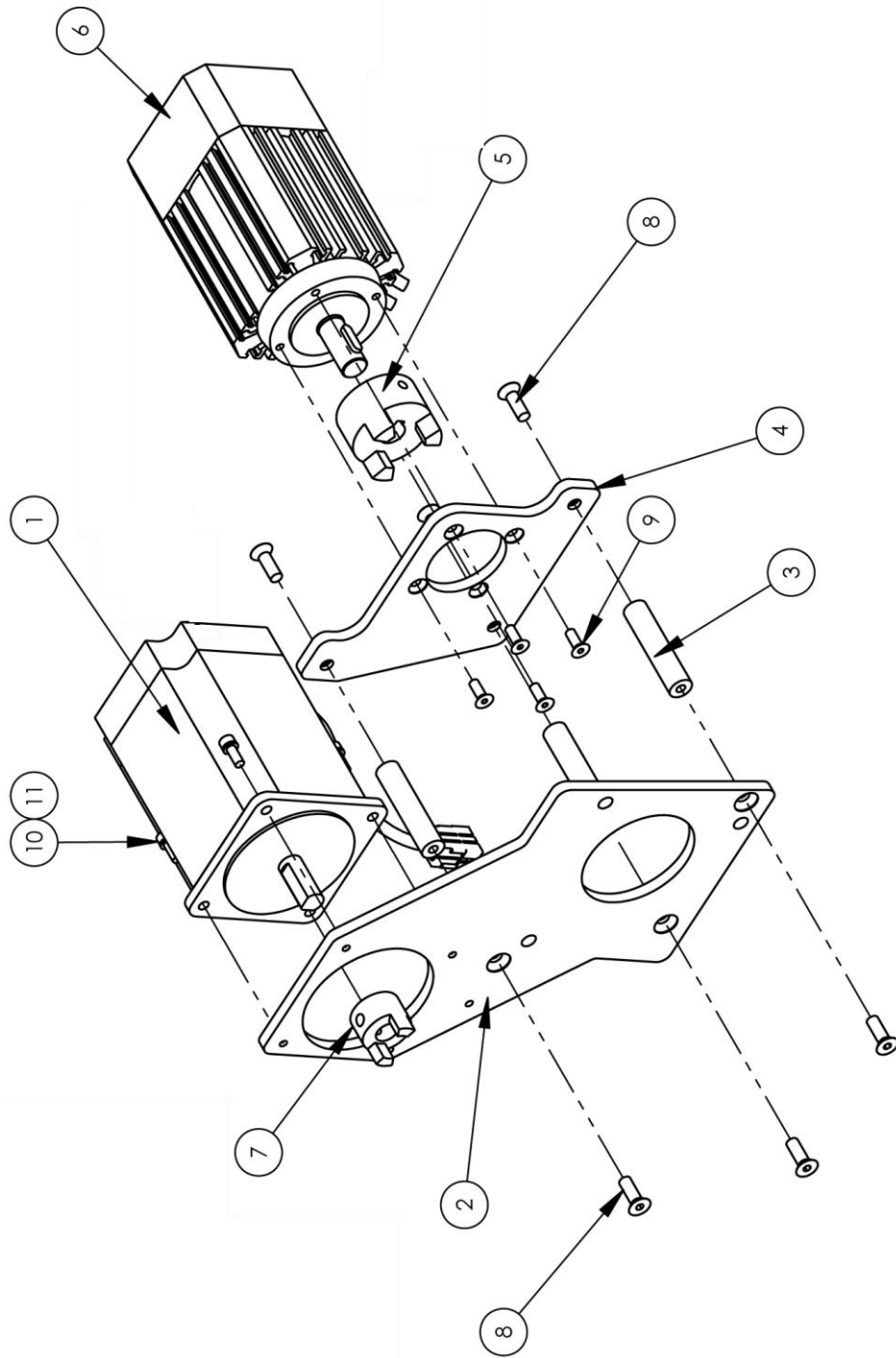
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49-2000E Heavy Duty Drive Assembly

AAC Drawing Number 9002699 Rev 2

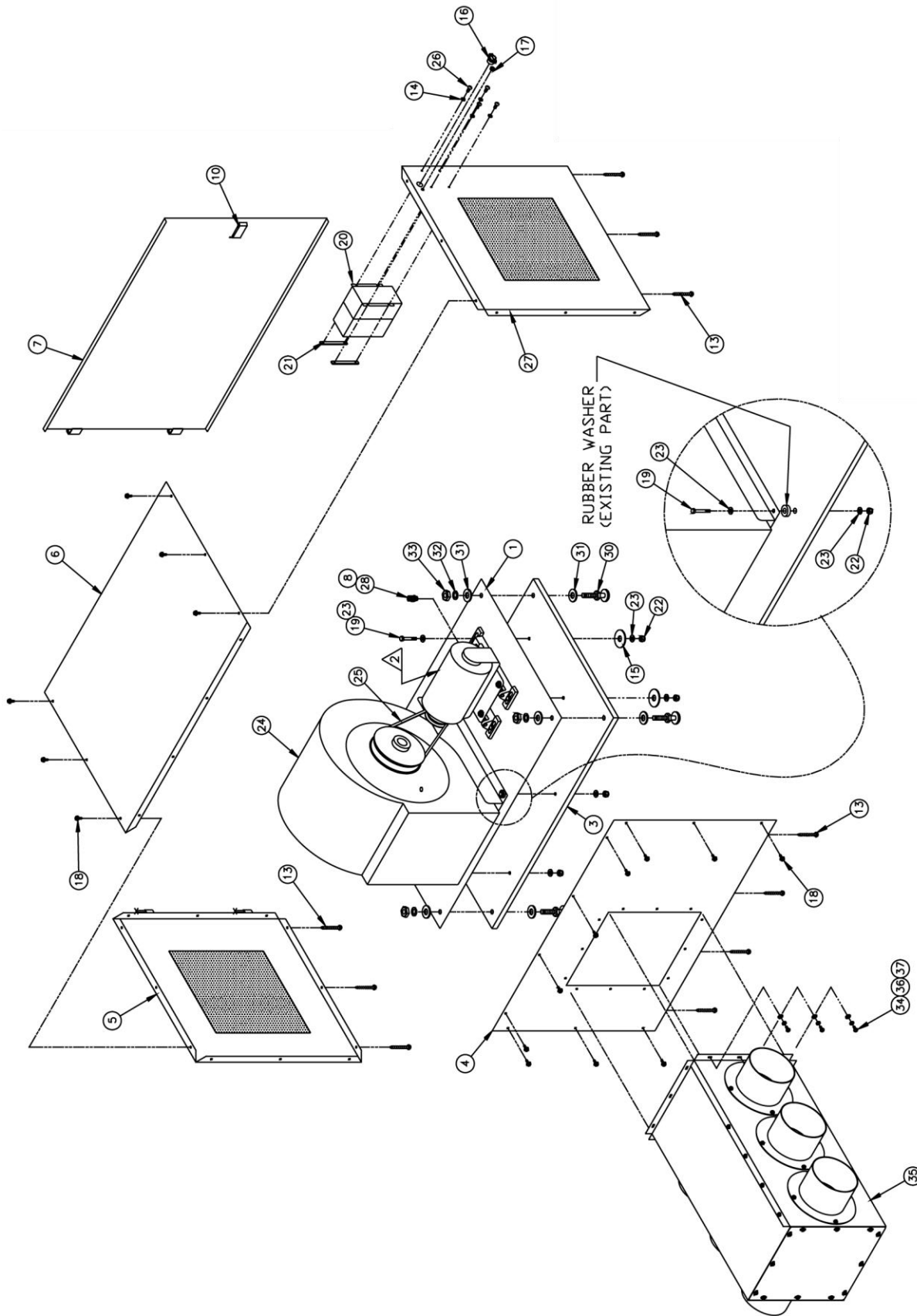
NO.	QTY	PART #	DESCRIPTION
1	1	1325-39C	SPRING CLIP
2	1	1337031	PLATE,NUT,1/4-20,ANGLED
3	3	3517	WASHER,THRUST,BRONZE
4	1	3524-02	3/8" U JOINT
5	1	49012	TRANSFER BLOCK
6	1	49014	PIVOT BLOCK
7	1	49015	PIVOT SHAFT
8	1	49016B	SHAFT, TRANSFER
9	1	49018A	PLATE,REAR MOUNT
10	1	49022	PLATE, NUT, 2 PL, 2.20 CT
11	1	CCCL6F	CLAMP COLLAR- 3/8
12	1	MML050	SPIDER, COUPLING
13	1	MML050-375	COUPLING,3/8 BORE
14	1	SSPS90032	#8-32 X 1/2 LG PAN HD
15	2	SSPS98024	10-32X3/8 PAN HD SLOT
16	4	SSSC01080	1/4-20X1-1/4, SOC CAP
17	1	WWF8	WASHER, FLAT, #8



1337169 Motor Mount Assembly

AAC Drawing Number 1337169 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	011-020C	MOTOR, STEPPER W/PLUG
2	1	1337166	PLATE,MNT,DUAL EFKA
3	3	1337167	SPACER,MOTOR MNT
4	1	1337168	BRKT,MOTOR MNT
5	1	1337191	COUPLING,14MM BORE,W/KEY
6	1	4059-AB425S	MOTOR & STEPPER CONTROL
7	1	MML050-500	COUPLING,1/2"BORE
8	6	SSFC01048	1/4-20 X 3/4 FLAT CAP
9	4	SSFCM5X14	M5-0.8X14, FLAT ALLEN
10	4	SSSC98032	10-32X1/2, SOC CAP
11	4	WWL10	WASHER,LOCK,#10,S/S

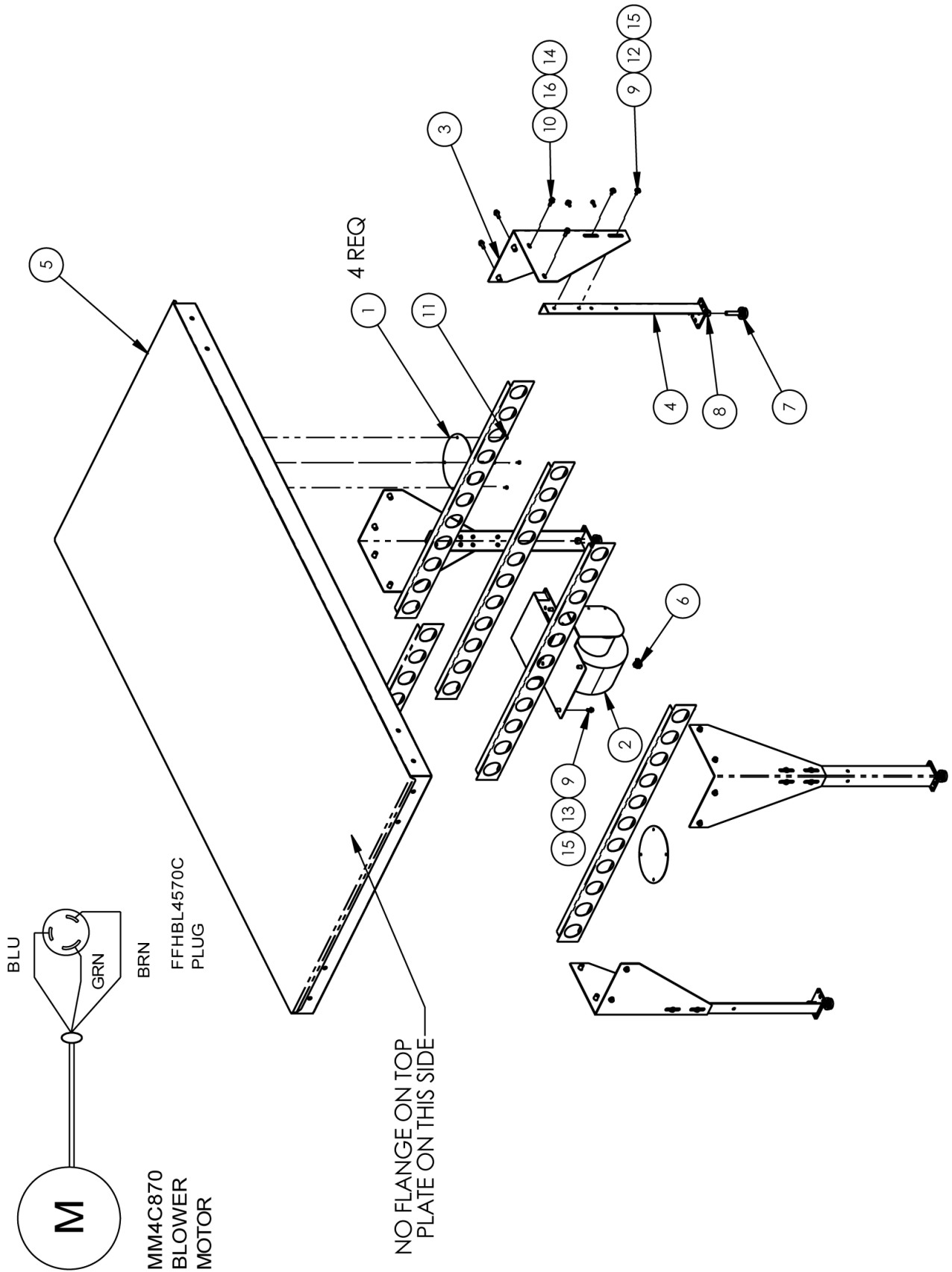


1335-0190 Blower Box Assembly

AAC Drawing Number 297096C Rev 11

NO.	QTY	PART #	DESCRIPTION
1	1	1335-0187	Base Plate
2	AR	1335-0190WD	Wiring Diagram
3	1	1335-0189	Box Base
4	1	1335-0191	Raer Panel
5	1	1335-0192	Rt. Side Panel
6	1	1335-0193	Top Panel
7	1	1335-0194	Door Panel
8	1	MM655445	Locknut, Conduit
9	1.3	EE16-4	Cable, 4 cond
10	1	MM40450010	Lock Slide
11	1	FF274-226	6 Pin Male Conn.
12	2.0	FF1216	Cable, 6 cond
13	10	SSZH#10048	Hex Sheet Metal Screw
14	4	WWSI10	Internal Tooth Washer
15	4	WWFE020	Fender Washer
16	1	K-235	Romax , Conn.
17	1	EESB-375-4	Heyco Bushing
18	16	SSZH#10032	Hex Sheet Metal Screw
19	8	SSHC10128	Hex Cap Screw
20	1	MMLZF092A	Drive, Var.
21	2	1335-903	Nut Plate
22	8	NNE5/16-18	Elastic Nut
23	16	WWFS5/16	Flat Washer SAE
24	1	MM7D634	Blower
25	1	ZX5036	V Belt
26	4	SSBC90032	Button Cap Screw
27	1	1335-0192A	Side Panel, LH
28	1	EEC403083	Connector
29	1	FF274-224	4 Pin Male Conn.
30	4	MMFB4444	Rubber Foot
31	4	WWL1/2	Lock Washer
32	8	WWL1/2	Flat Washer SAE
33	4	NNH1/2-13	Hex Nut
34	12	SSPS90024	Pan Phillips Screw
35	1	1335099	Duct Assy.
36	12	WWF8	Flat Washer
37	12	WWL8	Lock Washer
38	AR	K-CB600	Motor Starter

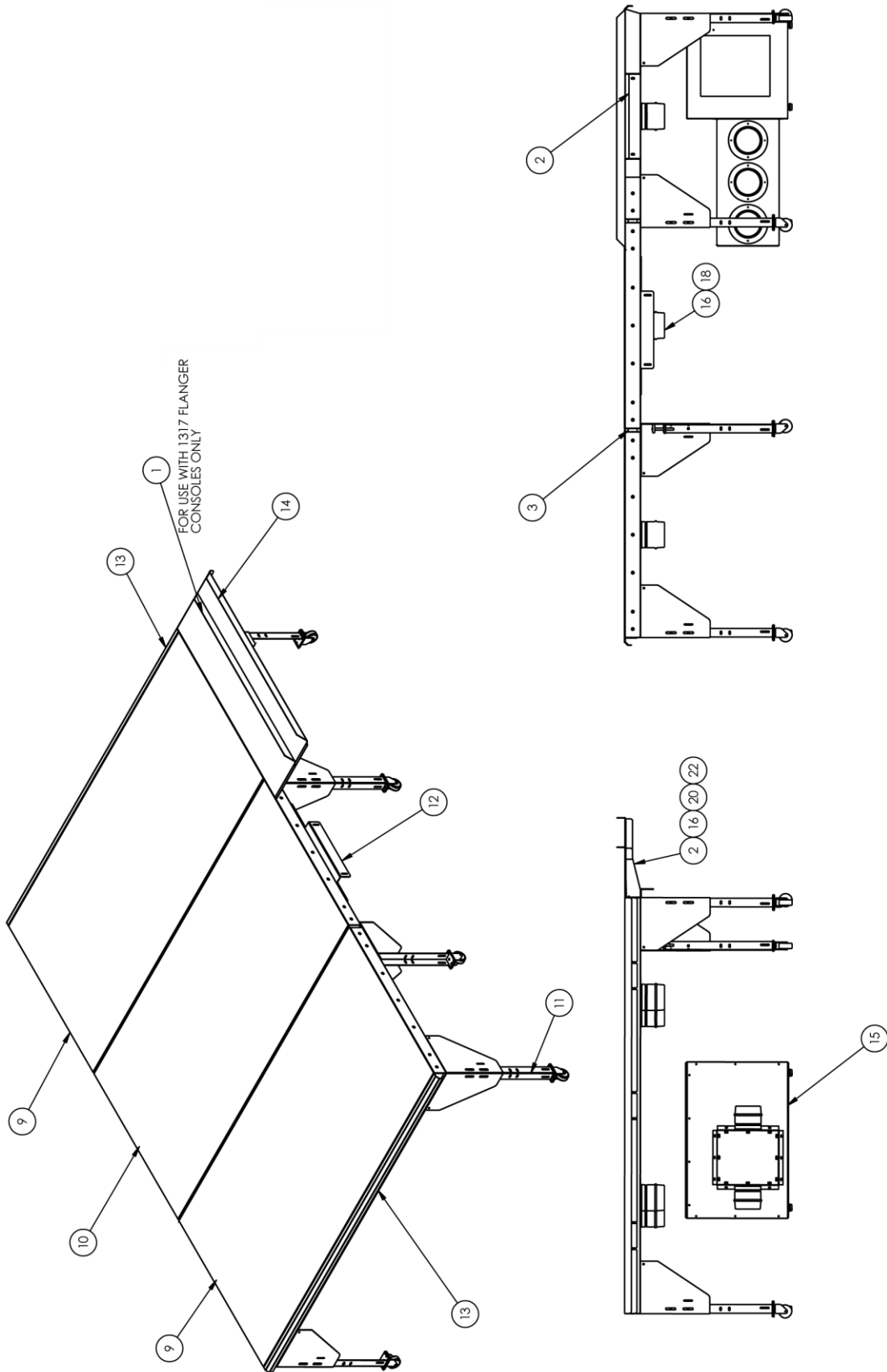
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1337A-160 Air Table Assembly, Single TBL

AAC Drawing Number 1337296 Rev 7

NO.	QTY	PART #	DESCRIPTION
1	4	1335-159	ACCESS COVER
2	1	1337135	BLOWER ASSY
3	4	1337A-0161	ANGLE, CORNER
4	4	1337A-0163	WELDMENT, LEG, TABLE
5	1	1337A-150	AIR TABLE ASSY
6	1	K-235	CONNECTOR, ROMEX, 1/2"
7	4	MMFB4444	FOOT, RUBBER
8	4	NNH1/2-13	NUT, HEX, 1/2-13
9	20	SSHC01048	1/4-20 X 3/4 HEX CAP
10	16	SSHC10064	5/16-18 X 1 HHCS
11	16	SSZH#10032	SCREW, SHT. METAL HEX 10
12	16	WWF1/4	WASHER, FLAT, 1/4", COM
13	4	WWFS1/4	WASHER, FLAT, SAE, 1/4
14	16	WWFS5/16	WASHER, FLAT, SAE, 5/16
15	20	WWL1/4	WASHER, LOCK, 1/4
16	16	WWL5/16	WASHER, LOCK, 5/16



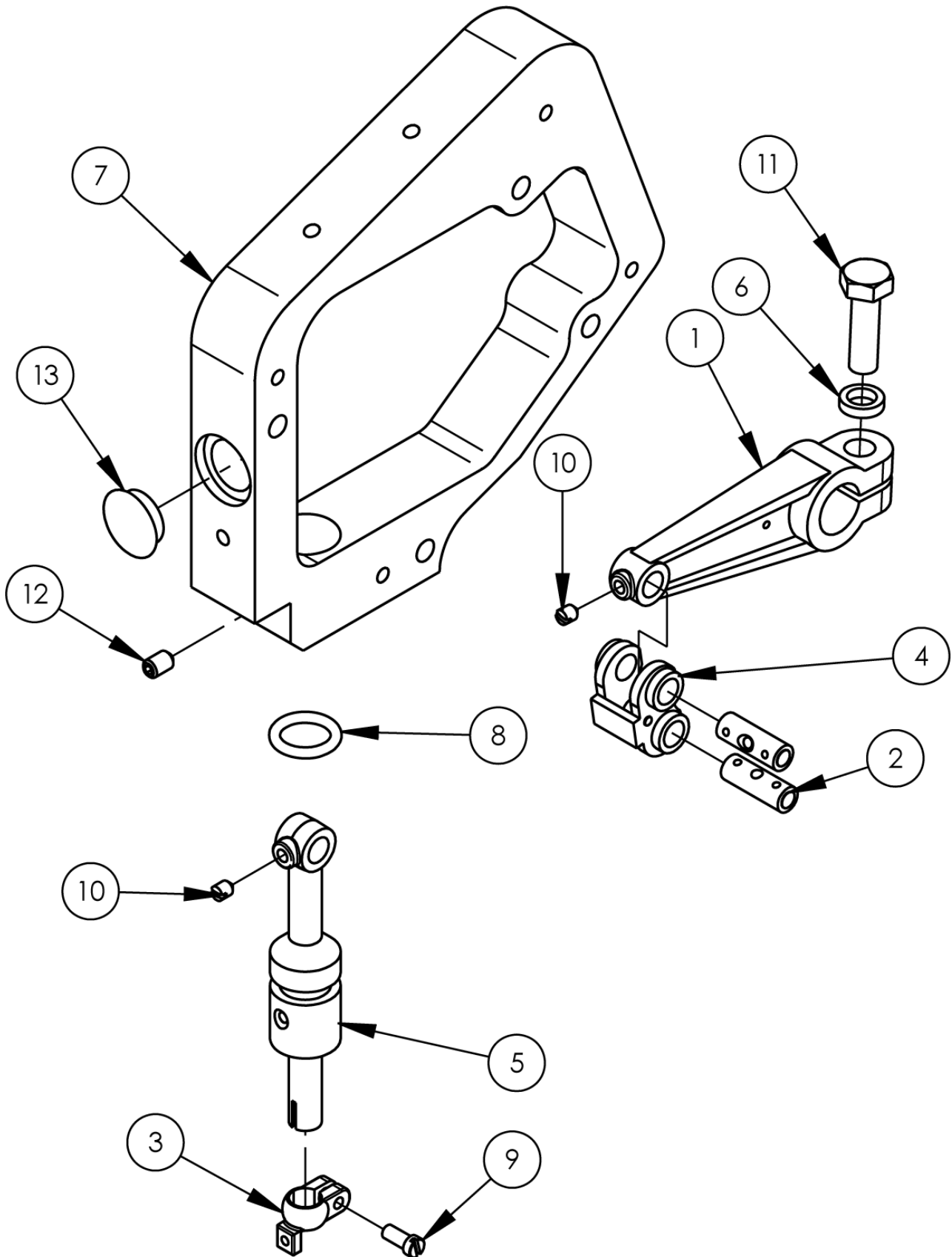
1335001 Air Table Assembly

AAC Drawing Number 1335001 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	AR*	1317281	EXTENSION, TABLE, 11.5"
2	1	1335-0168C	SHELF SUPPORT
3	4	1335-180	SPACER, AIR TABLE
4	AR*	1335001INS1	INSTRUCTIONAL SHEET
5	AR*	1335001INS2	INSTRUCTIONAL SHEET
6	AR*	1335001INS3	INSTRUCTIONAL SHEET
7	AR*	1335001INS4	INSTRUCTIONAL SHEET
8	1	1335002	HARDWARE PACKAGE
9	2	1335020	AIR TABLE, LEFT
10	1	1335033	AIR TABLE ASSY,CENTER
11	8	1335050	LEG ASSEMBLY
12	1	1335250	MOUNT, AIR TABLE
13	2	1335329	DEFLECTER,MATERIAL
14	1	1335331	EXTENSION, TABLE, 18"
15	1	1335S-0190	BLOWER BOX ASSY
16	6	MMATT06	TAKE OFF,6"

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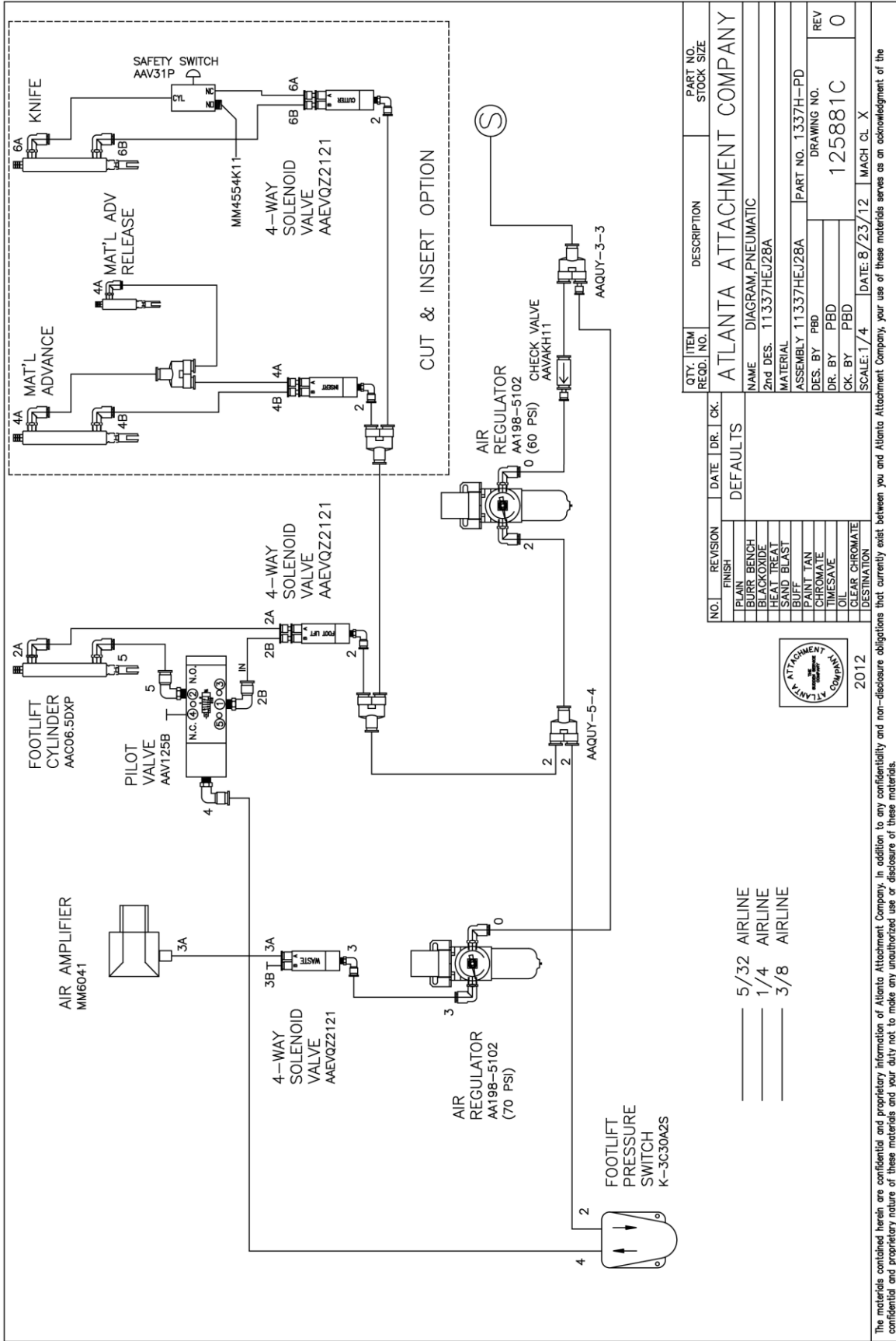


1337020 Linkage Assembly

AAC Drawing Number 1337020 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	121-09666	NDLE DRIVE ARM
2	2	121-09955	LINK PIN ASSY
3	1	122-80608	NEEDLE CLAMP
4	1	123-72009	NDLE DRIVE LINK
5	1	123-72157	NEEDLE BAR ASSY.
6	1	425-14179	STUD SPACER
7	1	49017A	SPACER,SIDE COVER
8	1	R0108240100	O-RING
9	1	SS6080720SP	SCREW, NEEDLE CLAMP MOG-3176
10	2	SS8090530TP	SCREW,SET SLOTTED 9/64-40 MOG-3176
11	1	SSHCM6X20S	SCREW, HEX M6X20L SST
12	1	SSSS90016	#8-32 X 1/4 KNURL PT
13	1	TA1250406R0	RUBBER PLUG

1337H-PD Pneumatic Diagram



- 5/32 AIRLINE
- 1/4 AIRLINE
- 3/8 AIRLINE

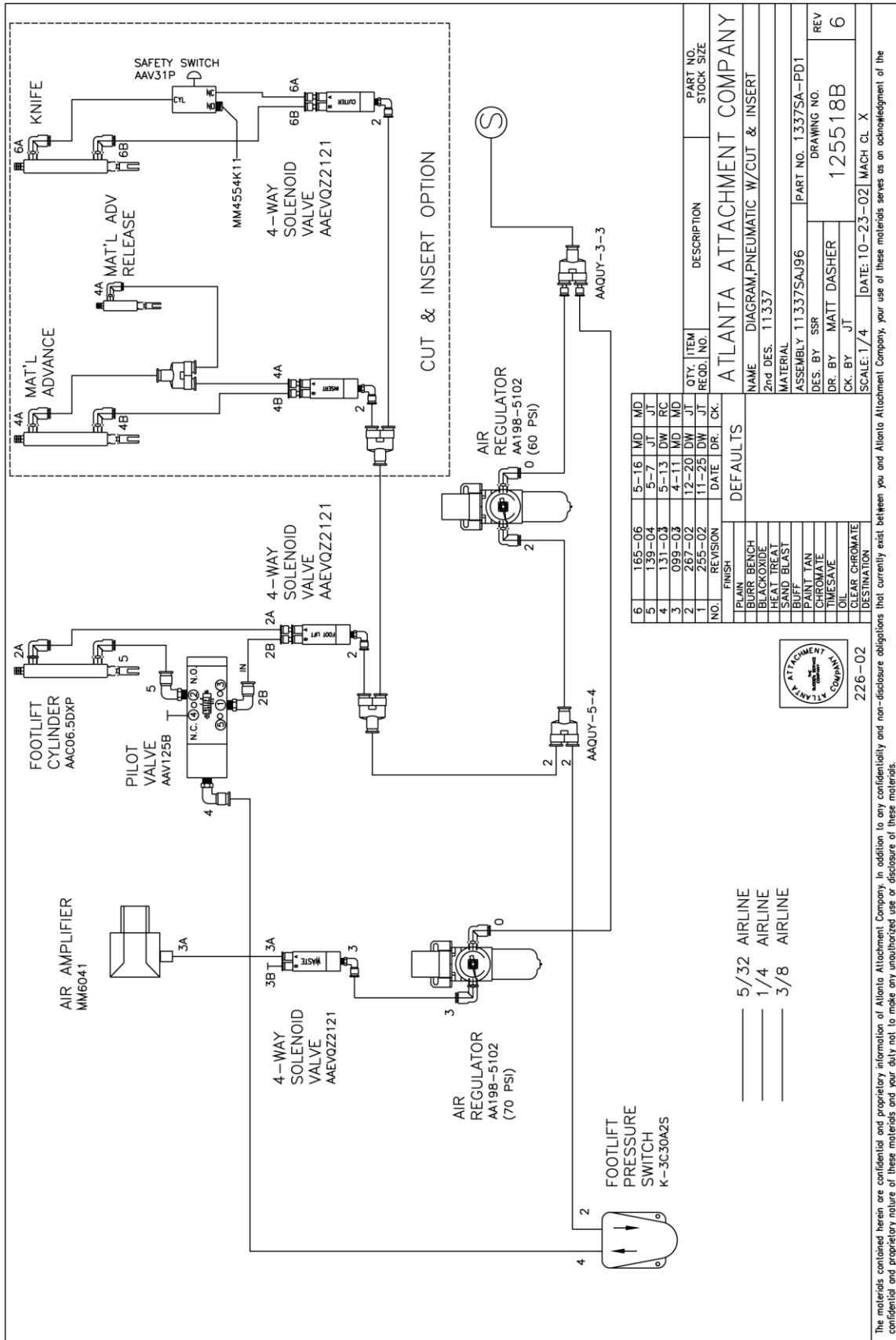
NO.	REVISION	DATE	DR.	CHK.	DESCRIPTION	PART NO.	STOCK SIZE
					ATLANTA ATTACHMENT COMPANY		
					NAME DIAGRAM,PNEUMATIC		
					2nd DES. 11337HEJ28A		
					MATERIAL		
					ASSEMBLY 11337HEJ28A	PART NO. 1337H-PD	
					DES. BY PBD	DRAWING NO.	REV
					CK. BY PBD	125881C	0
					SCALE: 1/4	DATE: 8/23/12	MACH CL X



2012

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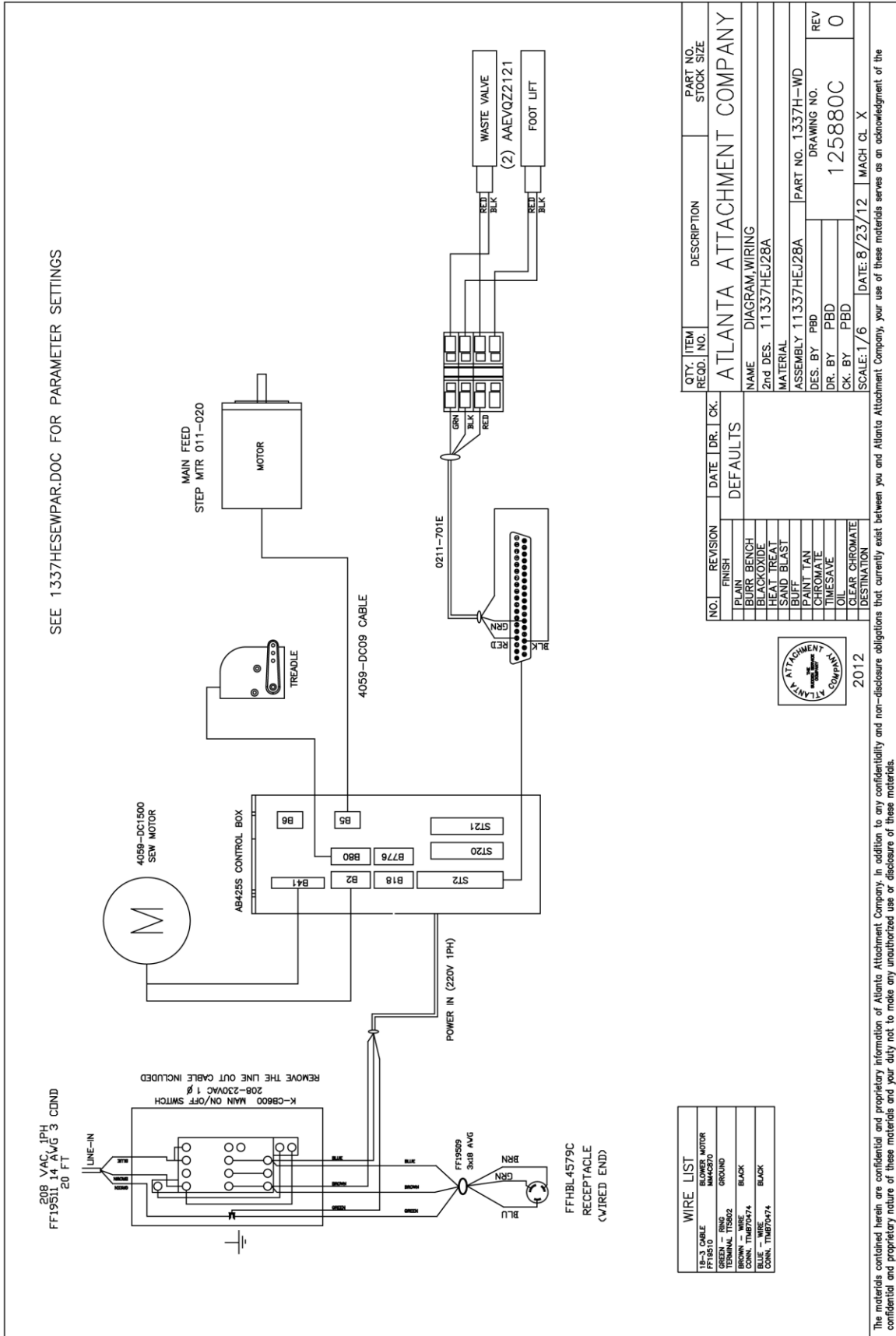
1337SA-PD1 Pneumatic Diagram / Cut & Insert



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1337H-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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