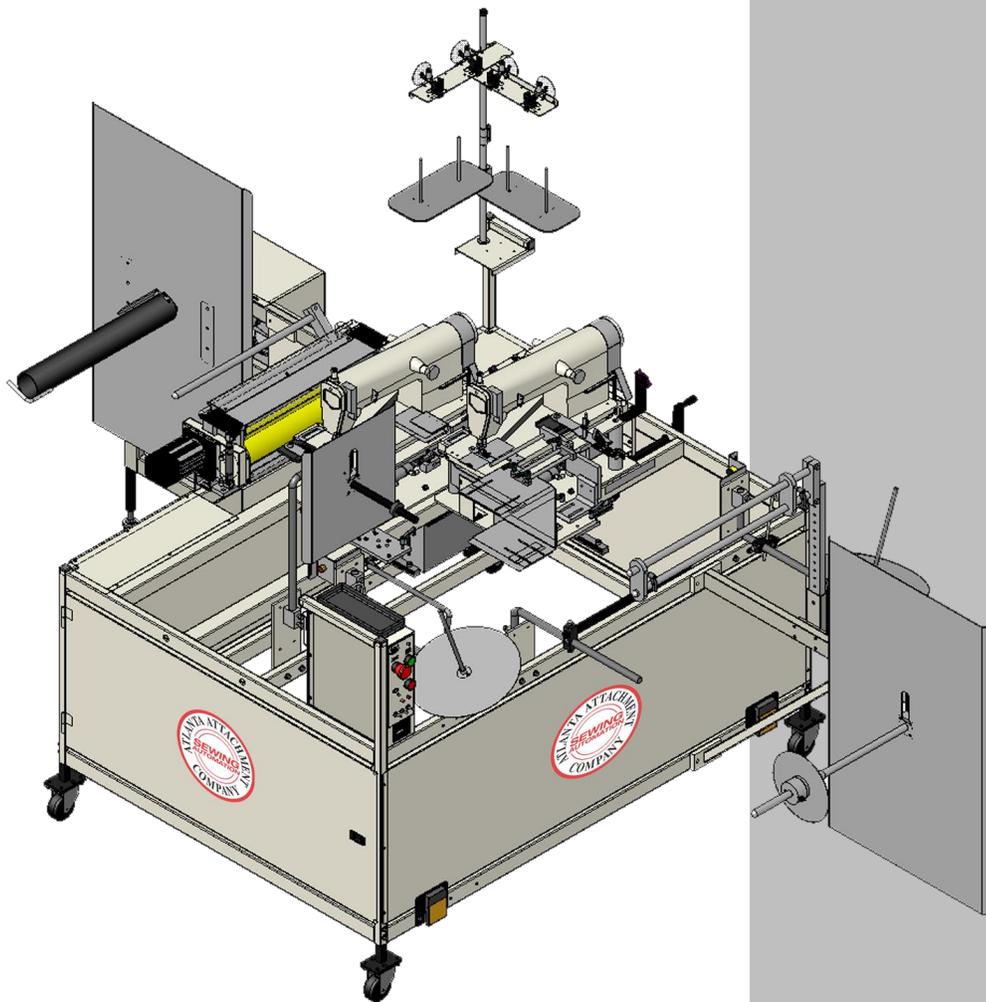




Model **1347D**

Revision 9.1 Updated Sept 6, 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

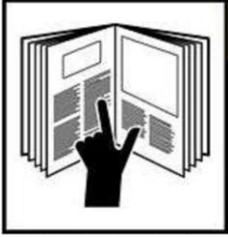
It is important to read and understand the information contained within this manual before attempting to operate the machine. Atlanta Attachment Co., Inc. shall not be held liable for damage resulting from misuse of the information presented within, and reserves the right to change the information contained 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 1347D 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.

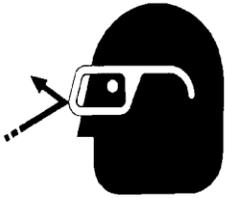
Signs on the Machine

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.

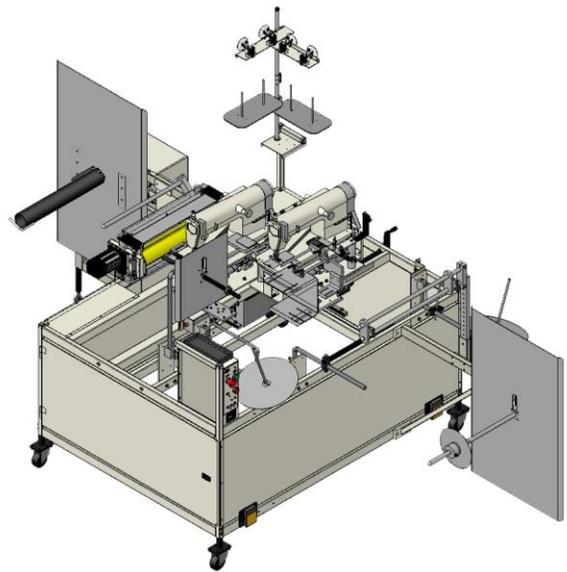
Specific safety warning decals are located on the equipment near the immediate areas of potential hazards. These decals should not be removed or obliterated. Replace them if they become non-readable.

- 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.

The 1347D is an automatic workstation for hemming and/or binding one or both sides of a mattress border or other flat goods. The material may be on rolls or festooned.

Features

- Dual adjustable single needle chain-stitch sewing heads
- Sewing heads can be turned off independently
- Swing out binders and retractable quick-change folders for ease of machine access
- Electronic positioning sewing motors
- Material out detectors
- Thread break detectors
- Variable speed heavy-duty electronic puller
- Variable speed reversible heavy-duty electronic rewinder
- Adjustable material tension
- Sew pedals for manual sewing
- Material capacity up to 18" wide
- Maximum distance between hem lines: 10"
- Minimum distance between hem lines: 2x the folder turn under.



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General Machine Data

| | |
|-------------|--|
| Electrical: | 220VAC, 10A, 50/60 Hz Single Phase Power |
| Pneumatic: | 70-80 PSI, 1 SCFM |
| Sew Heads: | Juki 481U Single Needle Chain-stitch |
| Needle: | TVX7 110/18 |
| Speed: | 3500 RPM |
| Weight: | Approx. 800 Lbs. |
| Dimensions: | 5-1/2' W, 11-1/2' L, 6' H |

Operating Procedure

1. Press the green button on the circuit breaker on the back of the control box. Leave this on except when locking out the power for maintenance.
2. Press the On/Start button momentarily to power up the machine. The amber Sensor light should light.

Note: Pressing the On/Start button a second time will run the machine at high speed.

3. Press the Stop button at any time to stop the machine.

Note: The Emergency Stop button will disconnect power to the machine

4. Turn on or off the Left and Right sewing heads as required.
5. Set the rewind direction as desired.
6. Load the required binding into the binders.
7. Load the material roll onto the front roll holder.
8. Adjust the sewing heads and folders for desired finish width. Most adjustments are made moving only the left head.
9. Adjust the front guide and roll holder to the folders.
10. Feed the material from the roll, between the front guide rods, and into the folders.
11. Raise the presser feet and puller roller by activating the switch on the front of the control panel.
12. Pull the material through the folders, past the binders, and through the puller roller with about 1 foot extending beyond the puller guard.
13. Close the puller roller and lower the presser feet.
14. Run the machine with the manual sew pedals until enough material is fed out of the puller to wrap around the rewriter spindle.
15. The material must go under the first guide rod (behind the puller) and over the second guide rod.
16. Adjust the rear guide rods and clutch air pressure for desired rewind roll tension.
17. Wrap the material around the rewriter spindle, being sure it is caught by the drive rod on the spindle.
18. Press the On/Start button to run the machine at full speed in automatic mode. You must hold the button on until the Sensor light goes out (approx. 2 seconds).
19. Use the Stop button to stop the machine.
20. Use the Emergency Stop button to turn off power at the end of the shift.
21. If the Sensor light does not go out, check for thread breaks and uncovered material/ binding sensors.
22. When the front material roll gets low a sensor will stop the machine for splicing on the next roll. Overlap the rolls about 2" with the new roll under the current roll and staple together.
Operate the machine with the manual sew pedals until the splice is past the puller. Cut the rolls apart and reload the rewriter.

Controls and Adjustments

Front of Control Box

1. Emergency Stop button- Pressing this button will turn off power to the machine. This button locks in and off when pressed. Twist to release; the machine will not start with this button in.

2. On/Start button- Pressing this button once at power off will turn on power to the control circuits. The amber Sensor light should light indicating the power is on. Pressing this button with the Sensor light on will start the automatic operation and run the machine at full speed. After the Sensor light goes out the machine will stay on until the Stop button is pressed, the material runs out, or there is a thread break.

3. Stop button-Pressing this button will stop the machine from sewing but does not disconnect power.

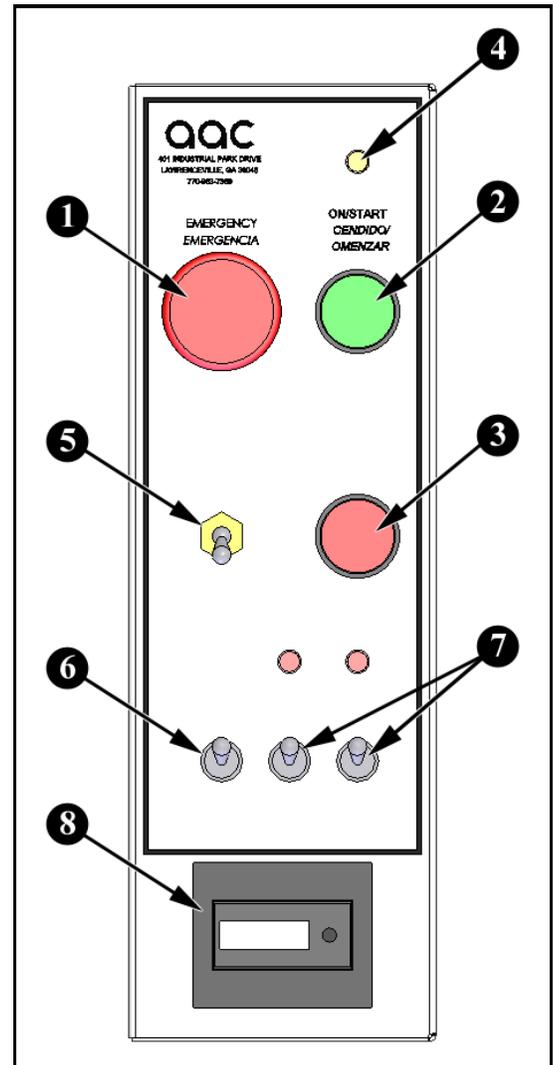
4. Sensor light- This light is on whenever the thread break sensors are idle and when one or more of the material sensors are uncovered.

5. Presser Feet and Feed Roller Up/Down Switch- Raises and lowers the Presser Feet of the sewing heads and the puller roller. Be sure this switch is down before running the machine.

6. Rewind Motor direction switch- Sets the winding direction of the rewind motor either CW or CCW.

7. Left and Right Heads switches- Independently turns off or on the sewing heads. Indicator lights show which head is off.

8. Hour Meter- Displays the total accumulated run time of the sewing heads in hours and Minutes.



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Rear of Control Box

Main power overload circuit breaker and lock-out/tag-out safety feature. This switch is usually left on all the time except when locking the machine power off for maintenance.

Manual Sew Pedals

Two manual sew pedals are located on the front of the frame. They operate both of the sewing heads at a slower speed than automatic speed. They are used for maintenance and for loading the machine.

Folder/Head Adjustment

The folders are mounted on the sewing head slides and move with the heads. There are two separate head adjustment cranks located on the right side of the machine. The front one adjusts the right head. The rear one adjusts the left head. The right head is adjusted to align the material with the rewriter disc and should not normally need adjusting unless the folders are changed to a different hem size. The left head is adjusted to desired stitch margin between the hems. There is a scale and pointer located on the back of the right head that indicates the distance between the two needles as a reference for adjusting the needle spacing.

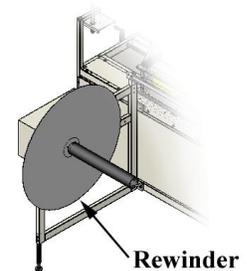
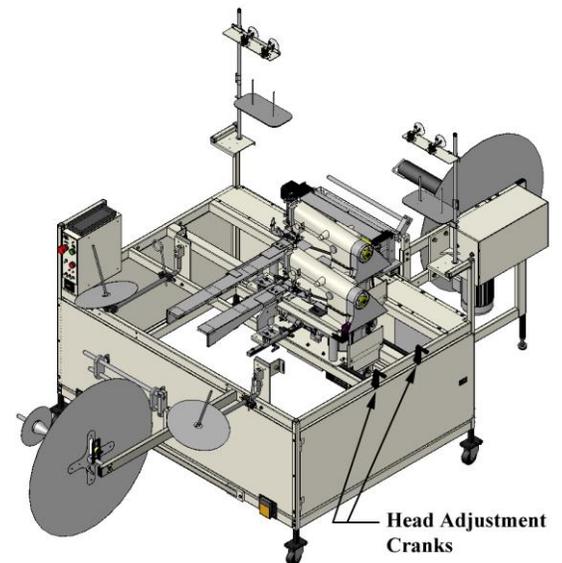
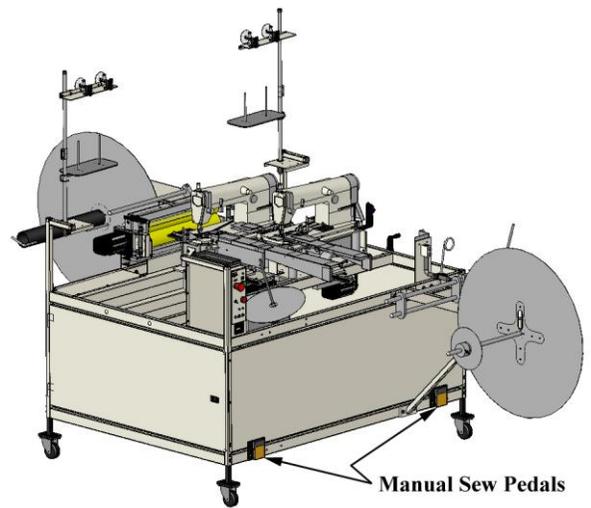
The hems consume approximately 1" of material each, so, for example, for a finished size of 8" you need to start with a 10" wide roll. The hems can be sewn with or without binding. Even if binding is not used, the binding material sensors must be covered to run the machine automatically.

Sewing stitch length is dependent on the speed of the puller. The head stitch length is adjusted to be consistent with the puller speed setting. The more stretchy the material the longer the stitch length, that can be sewn. Refer to the puller programming instructions (page 20) for adjustment of the puller speed drive ratio (parameter 272) in the Efka control box.

Rewriter

The rewriter motor runs whenever the sewing heads are running. The winding tension is controlled by a pneumatic clutch which has its own regulator located inside the left side door. There are tension rods located between the puller and the rewind spindle that can be adjusted to create more or less drag on the material, allowing more or less tension to be applied as the material is rolled up. The material coming out of the puller must go under the lower rod and over the upper rod.

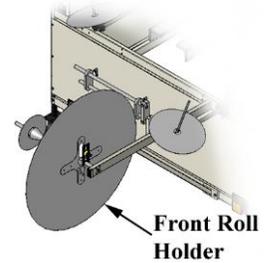
Caution: Too much tension will over-feed the sewing heads and may cause needle breaks.



From the library of: Diamond Needle Corp

Front Roll Holder

The front roll holder has a material out sensor mounted behind the disc. This sensor can be adjusted up or down to set the amount of material left on the rod when the machine stops. There should be enough material left to make a splice when the next roll is loaded. Splices can be made by overlapping the material about an inch or two and stapling together. Run the splice through the machine with the manual sew pedals at reduced speed.



Troubleshooting

Machine doesn't continue to run after the start button is pressed for the second time (Power on LED will not go out).

1. The thread break detectors are threaded wrong or damaged. (See page 15 for thread sensor instructions).
2. The fabric sensors are not properly aligned (not looking through the slot) or damaged.

Machine will not stop after fabric runs out

1. The fabric sensor is not properly aligned (not looking through the slot) or damaged.
2. Reflective tape on handwheel is worn or is not at least 1 inch long.

Sewing heads will not run

1. Check head on/off switches on control box.
2. Check that all plugs on motor are plugged in securely.
3. Check motor control boxes for error codes.

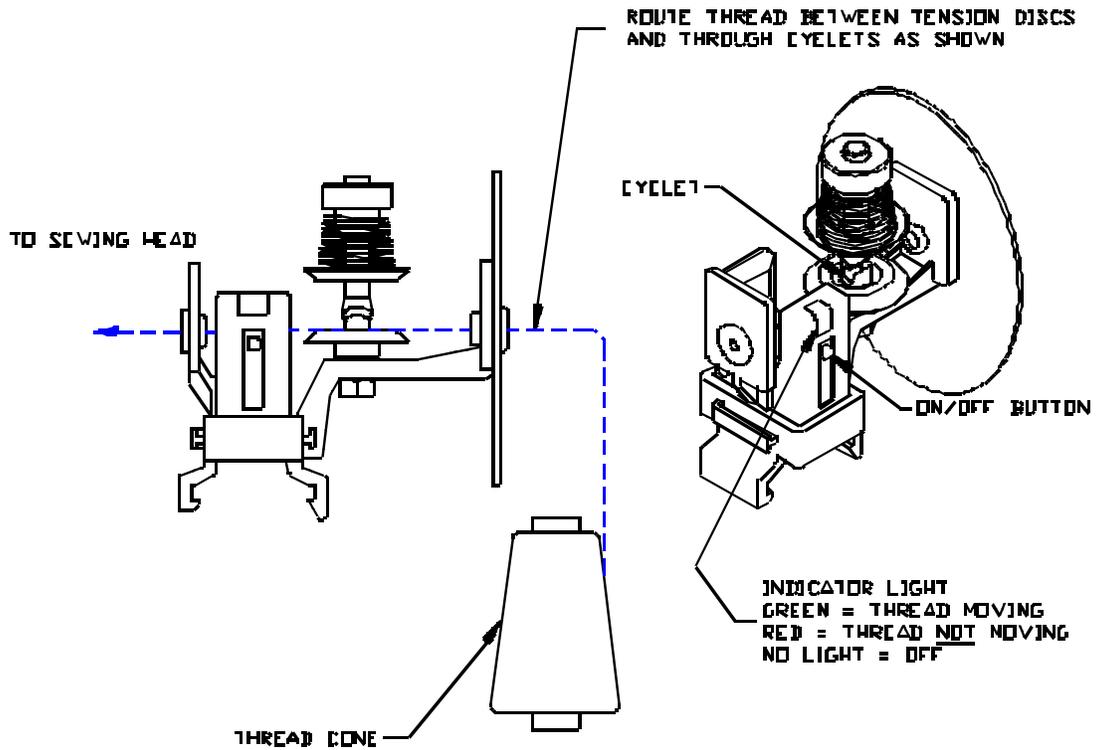
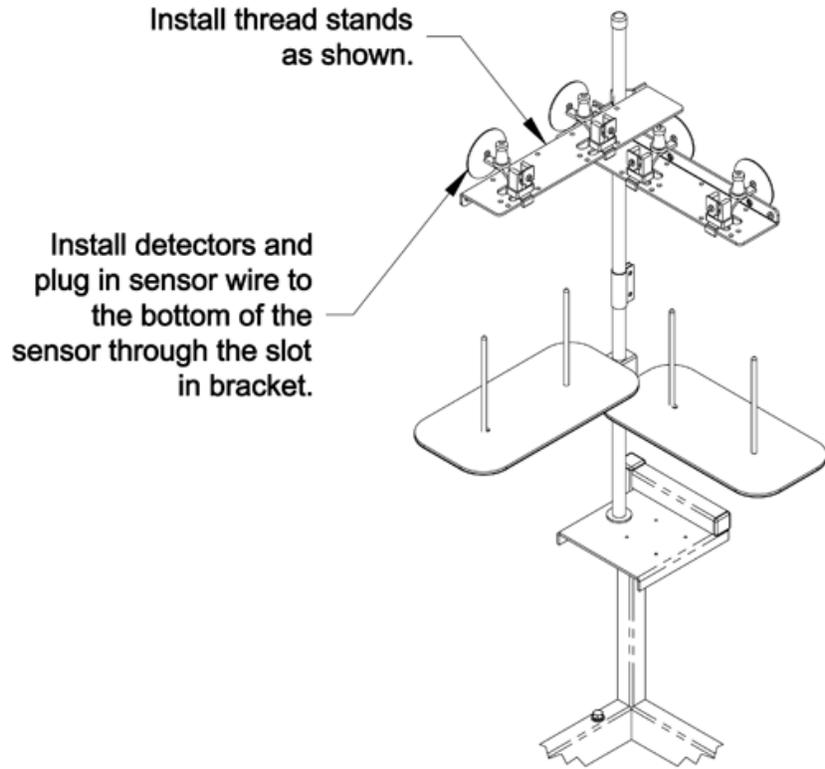
Heads sewing, but feed rollers not turning

1. Feed motor control box should be turned on (see power light on control box). Check box for error codes.
2. Check belt going from motor to feed roller.
3. Check pulleys on motor and feed roller (set screws should be tight).

Heads sewing, feed rollers turning, but cloth not being pulled through

1. Check air pressure, should be 30-40 psi. Higher pressures may cause feed rollers to stall.
2. Check that feed roller switch is set for feed roller down.
3. Check that threads on edge of cloth are not wrapped around roll rod.

Thread Sensor Instructions



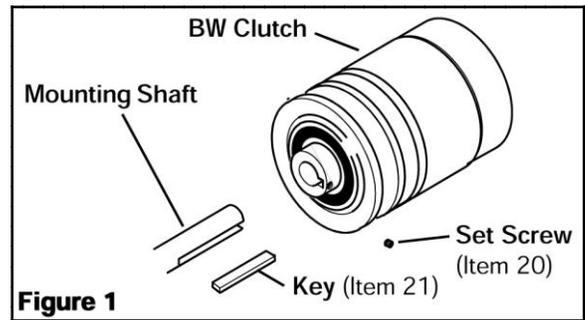
Clutch-Brake Installation & Maintenance



Installation

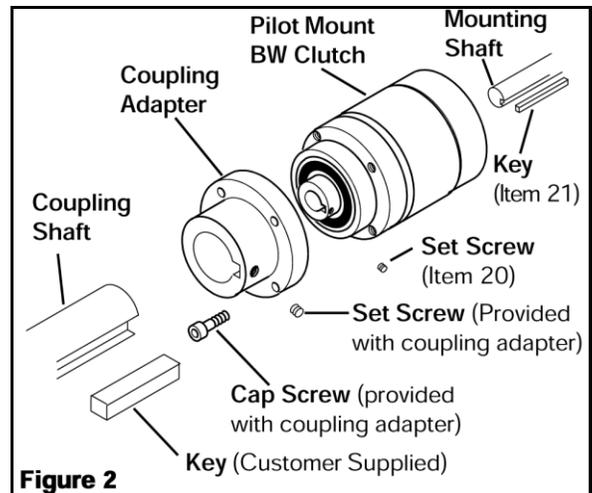
Sheave and Pilot Mounting (See Figure 1)

1. Insert the Key (Item 21) into the keyway of the mounting shaft.
2. Slide the BW Clutch onto the mounting shaft until the Key (Item 21) is seated in the BW Clutch.
3. Insert and tighten the two set screws (Item 20).



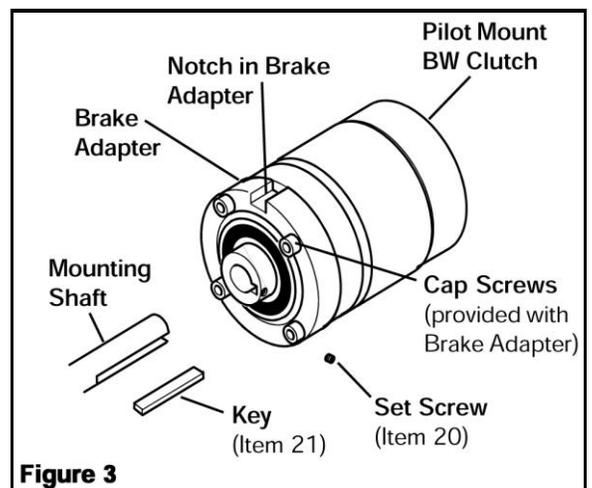
Coupling Mounting (See Figure 2)

1. Insert the Key (Item 21) into the keyway of the mounting shaft.
2. Slide the Pilot Mount BW Clutch onto the mounting shaft until the Key (Item 21) is seated in the Pilot Mount BW Clutch.
3. Insert and tighten the two set screws (Item 20).
4. Insert the customer supplied key into the coupling shaft.
5. Slide the Coupling Adapter onto the coupling shaft.
6. Using the cap screws provided with the Coupling Adapter, secure the Coupling Adapter to the Pilot Mount BW Clutch.
7. Insert and tighten the set screws provided with the Coupling Adapter.



Brake Mounting (See Figure 3)

1. Using the cap screws provided with the Brake Adapter, secure the Brake Adapter to the Pilot Mount BW Clutch.
2. Insert the Key (Item 21) into the keyway of the mounting shaft.
3. Slide the Pilot Mount BW Clutch with the Brake Adapter onto the mounting shaft and key.
4. Align the notch in the Brake Adapter with a torque pin or stop on the machine.
5. Insert and tighten the two set screws (Item 20).



Airline Connections

A 1/8 NPT female air inlet fitting is provided in the piston (Item 13) for the airline connection. The Air Hose Assembly (Item 19) must be used so that no side forces are introduced to the air chamber-piston assembly.

Bearing drag on the hose during operation may be relieved by securing the hose to a support.

Caution: The use of rigid pipe or tubing when connected directly to the BW Clutch will prevent proper actuation of the BW Clutch.

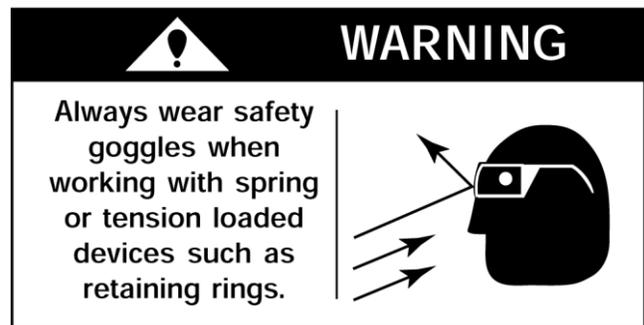
Lubrication

Nexen BW Clutches are factory lubricated and ready to install. The thrust bearings (Item 8) are packed with a lubricant specially selected for the BW Clutch. If it becomes necessary to lubricate the thrust bearings, use Nexen H-130 (Product No. 853900). Frequency of lubrication of the thrust bearings will depend on the speed of operation, temperature, and severity of application. The radial bearing (Item 3) is pre-lubricated, sealed, and requires no further lubrication. To disassemble the BW Clutch for lubrication, refer to Parts Replacement on page 17.

Parts Replacement

See Figure 4

1. Remove the Retaining Ring (Item 2)
2. Depending on which version of the BW Clutch is being used, remove the Pilot Mount Disc (Item 15) or the Sheave (Item 4).
3. Press the old Bearing (Item 3) out of the Sheave or Pilot Mount Disc.
4. Clean the bearing bore of the Sheave (Item 4) or Pilot Mount Disc (Item 15) with fresh solvent making sure all old Loctite® residue is removed.
5. Apply and adequate amount of Loctite® RC609 to evenly coat the outer race of the new Bearing (Item 3).
6. Carefully align the outer race of the new Bearing (Item 3) with the bore of the Sheave or Pilot Mount Disc and press the new Bearing (Item 3) into place.
7. Remove the first old Spring Retaining Washer (Item 23), old Return Spring (Item 5), and the second old Spring Retaining Washer (Item 23) from the Hub (Item 1).
8. Slide the old Friction Disc Assembly (Item 7) off of the Hub (Item 1).
9. Remove the old Disc Key (Item 6).
10. Slide the Hub (Item 1) out of the Air Chamber (Item 9) and Piston (Item 13).
11. Separate the Piston (Item 13) from the Air Chamber (Item 9).
12. Remove the old O-ring Seal (Item 11) form the Air Chamber (Item 9).
13. Press the old Thrust Bearing (Item 8) out of the Air Chamber (Item 9).
14. Carefully align the outer race of the new Thrust Bearing (Item 8) with the bore of the Air Chamber (Item 9) and press the new Thrust Bearing (Item 8) into place.
15. Remove the old O-ring Seal (Item 10) form the Piston (Item 13).
16. Press the old Thrust Bearing (Item 8) out of the Piston (Item 13).
17. Carefully align the outer race of the new Thrust Bearing (Item 8) with the bore of the Piston (Item 13) and press the new Thrust Bearing (Item 8) into place.
18. Clean the O-ring contact surfaces of the Air Chamber and Piston with fresh safety solvent.
19. Coat the O-ring contact surfaces of the Air Chamber and Piston with fresh O-ring lubricant and wipe off any excess lubricant.



20. Coat the new O-ring Seals (Items 10 and 11) with fresh O-ring Lubricant.
21. Install the new O-ring Seals (Items 10 and 11).
22. Slide the Piston (Item 13) into the Air Chamber (Item 9).
23. Slide the Air Chamber and Piston onto the Hub (Item 1).
24. Install the new Disc Key (Item 6) into the Hub.
25. Slide the new Friction Disc Assembly (Item 70) onto the Hub (Item 1) and Disc Key (Item 6).
26. **Note: The closed end of the Return Spring (Item 5) must face toward the Retaining Ring (Item 2).**
27. Install the new Return Spring (Item 5) and Spring Retaining Washers (Item 23).
28. Press the Pilot Mount Disc (Item 15) and Bearing (Item 3) or the Sheave (Item 4) and Bearing (Item 3) onto the Hub (Item 1).
29. Reinstall the Retaining Ring (Item 2).

Clutch Parts List

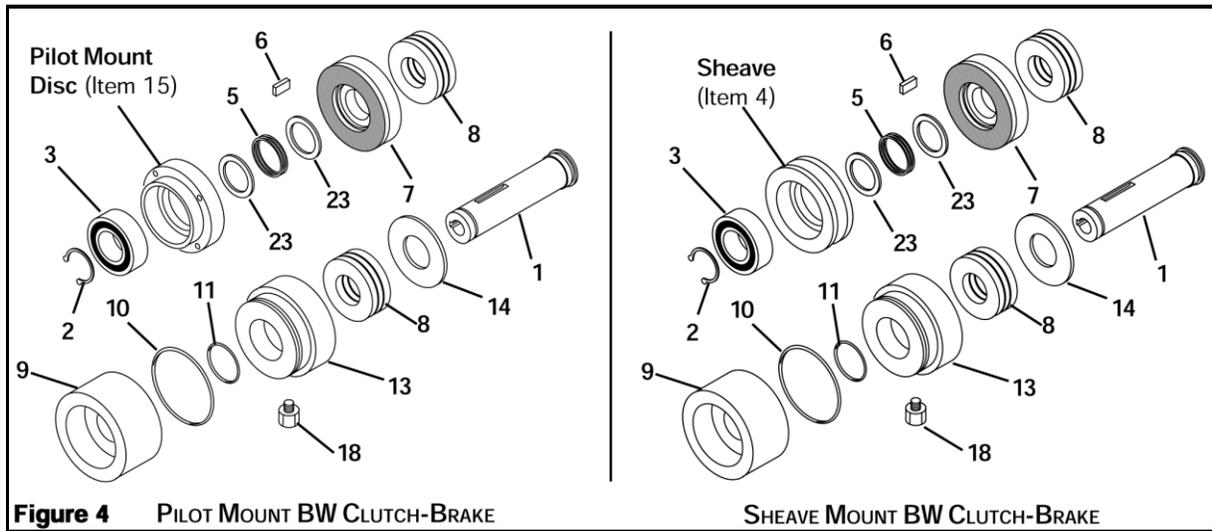


Figure 4 PILOT MOUNT BW CLUTCH-BRAKE

SHEAVE MOUNT BW CLUTCH-BRAKE

| ITEM | DESCRIPTION | QTY |
|-----------------|-------------------------------|-----|
| 1 | Hub | 1 |
| 2 | Retaining Ring (Ext.) | 1 |
| 3 | Bearing | 1 |
| 4 | Sheave | 1 |
| 5 ¹ | Return Spring | 1 |
| 6 ¹ | Disc Key | 1 |
| 7 ¹ | Friction Disc Assembly | 1 |
| 8 ¹ | Thrust Bearing | 2 |
| 9 | Air Chamber | 1 |
| 10 ¹ | O-Ring Seal (Large) | 1 |
| 11 ¹ | O-Ring Seal (Small) | 1 |
| 13 | Piston | 1 |
| 14 | Washer | 1 |
| 15 | Pilot Disc Mount | 1 |
| 18 | Air Inlet Fitting | 1 |
| 19 | Air Hose Assembly (Not Shown) | 1 |
| 20 | Set Screw (Not Shown) | 2 |
| 21 | Key (Not Shown) | 1 |
| 23 ¹ | Spring Retaining Washer | 2 |

1347D Puller Motor Parameter List

| PARAMETER | RANGE | SUGGESTED/ VALUE | SHIPPED/ VALUE | 11347D PARAMETER DESCRIPTION (PULLER MOTOR) |
|----------------------|--------------|---------------------|-------------------|---|
| Do this first | ***** | **** | | Perform a master reset before programming, see below |
| 290 | | 0 | | Mode (Lockstitch) of operation. MUST SET THIS PARAMETER FIRST! |
| 026 | 0-5 | 0 | | F-026=0 to disable the EB401 selection after power on. |
| 111 | 200-9900 rpm | 040 | | Maximum speed when "129" is 0, 1, or 2. |
| 119 | 1-3 | 1 | | Linear Acceleration |
| 153 | 0-50 | 35 | | Breaking power at standstill |
| 161 | 0-1 | 0=CW | | Motor Rotation |
| 220 | 1-55 | 5 | | Acceleration |
| 270 | 0-5 | 5 | | No Hand Wheel Sensor |
| 272 | 020-255 | *50 | | Drive ratio between motor pulley and driven pulley. The larger the number, the slower the motor RPM. (42 RPM) |
| 436 | | 0 | 0 | Use code "5913". This disables an input that was causing box to reset itself. |

Front panel LED's:

- LED 1: Off
- LED 2: Off
- LED 3: Off
- LED 4: Off
- LED 5: Off
- LED 6: Off.
- LED 7: OFF, 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.

* For Gearbox Driven Pullers

1347D Sewing Head Parameter List

| PARAMETER | RANGE | SUGGESTED/ VALUE | SHIPPED/ VALUE | 11347D PARAMETER DESCRIPTION (SEWING HEADS) |
|----------------------|--------------|---------------------|-------------------|--|
| Do this first | ***** | **** | | Perform a master reset before programming, see below |
| 290 | | 5 | | Mode (Chainstitch) of operation. MUST SET THIS PARAMETER FIRST! |
| 026 | 0-5 | 0 | | F-026=0 to disable the EB401 selection after power on. |
| 111 | 200-9900 rpm | 350 | | Maximum speed when "129" is 0, 1, or 2. |
| 119 | 1-3 | 1 | | Linear Acceleration |
| 161 | 0-1 | 1=CCW | | Motor Rotation |
| 240 | 0-31 | 6 | | Machine run blockage with open contact |
| 270 | 0-5 | 1 | | External Hand Wheel Sensor Configuration. |
| 272 | 020-255 | 90 | | 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 Rimoldi, setting should be 124) |
| 436 | | 0 | 0 | Use code "5913". This disables an input that was causing box to reset itself. |

Front panel LED's:

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

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

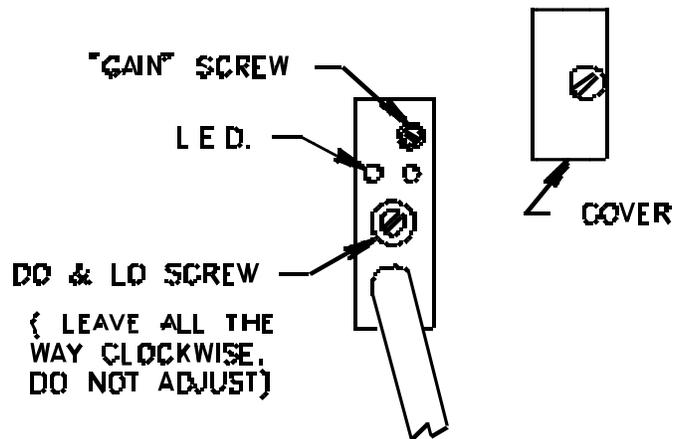
To Perform Master Reset of Parameters:

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.

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.

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 # SP1347D Spare Parts Kit

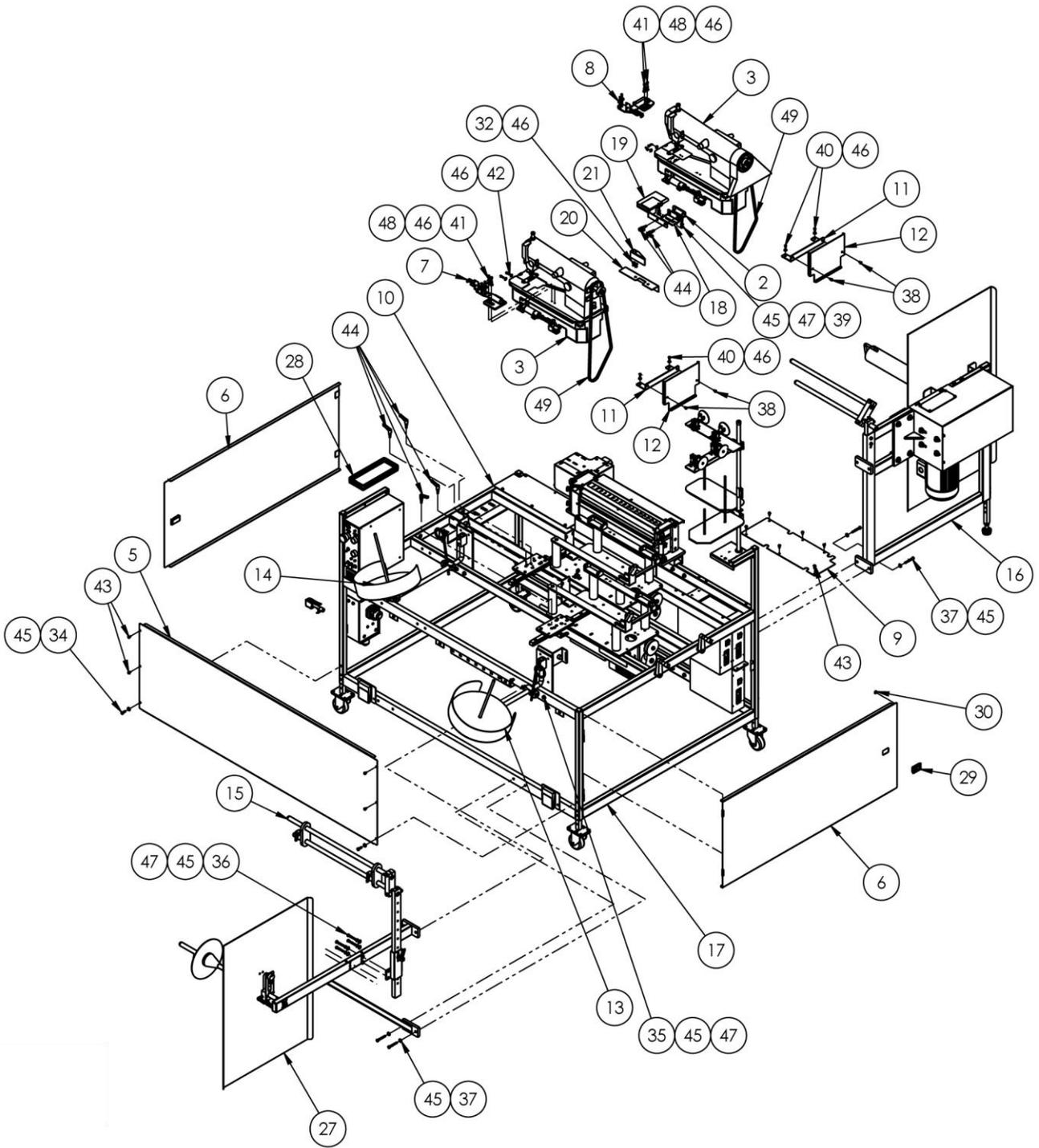
| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|-----|-----|-------------|---------------------|-----|------|------------|----------------|
| 1 | 1 | 4003-IS3WT2 | Thread Break Sensor | 6 | 100 | SNTVX7X110 | Needle, 110/18 |
| 2 | 3" | EEFE-RR2 | Reflective Tape | 7 | 3 bx | ZZZSR-202 | Staples |
| 3 | 1 | FFSM312LVQ | Electric Eye | 8 | 1 | ZZZSR20W | Scissors |
| 4 | 1 | FFT18FF100Q | Electric Eye | 9 | 1 | ZZZSR-220 | Stapler |
| 5 | 1 | FFT18FF25Q | Electric Eye | | | | |

Assembly Drawings & Parts Lists

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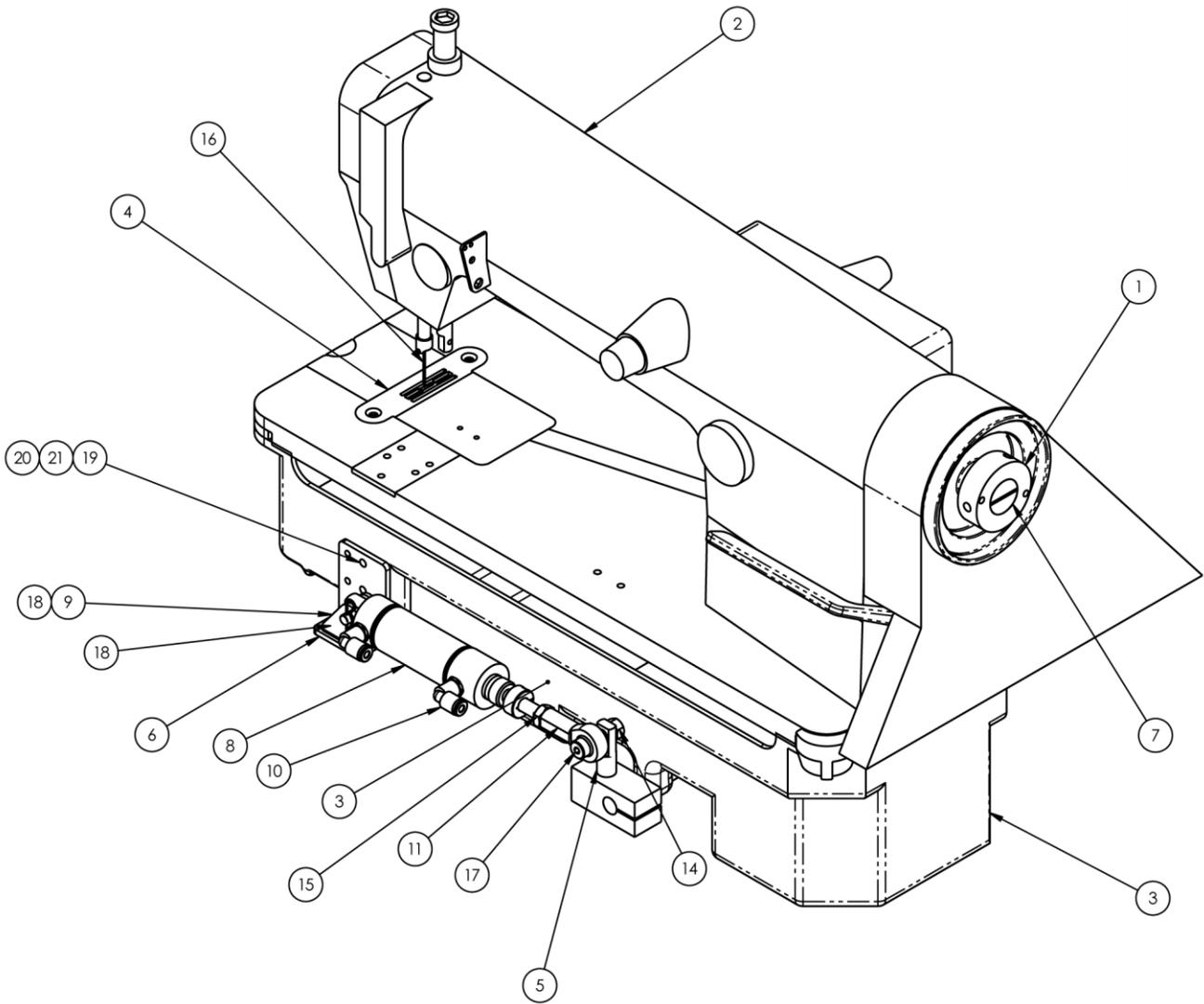


11347D Faux Pillowtop Border Workstation

AAC Drawing Number 1347000 Rev 4

| NO. | QTY | PART # | DESCRIPTION | |
|-----|-----|------------|---------------------------|---------|
| 1 | 2 | 0411-3907 | PLATE,NUT,10-32@1.50 CTC | |
| 2 | 1 | 1335M-131 | PLATE, NUT, 1/4-20 @ 2.0 | |
| 3 | 1 | 1347016 | PRESSER FOOT, MODIFIED | |
| 4 | 2 | 1347025 | COVER, FRONT | |
| 5 | 2 | 1347026 | DOOR | |
| 6 | 1 | 1347030 | SWING OUT BINDER ASSY | Page 28 |
| 7 | 1 | 1347040 | SWING OUT BINDER ASSY | Page 29 |
| 8 | 1 | 1347051 | COVER, RIGHT REAR | |
| 9 | 1 | 1347052 | COVER, LEFT REAR | |
| 10 | 2 | 1347053 | SUPPORT, BELT GUARD | |
| 11 | 2 | 1347054 | BELT GUARD | |
| 12 | 1 | 1347080 | BINDING ROLL SUPPORT | Page 36 |
| 13 | 1 | 1347090 | BINDING ROLL SUPPORT | Page 38 |
| 14 | 1 | 1347094 | TENSION ASSEMBLY | Page 40 |
| 15 | 1 | 1347098 | REWIND ASSY W/SLEEVE | Page 42 |
| 16 | 1 | 1347110 | MAIN FRAME ASSEMBLY | Page 44 |
| 17 | 1 | 1347123 | MOUNT, GUIDE | |
| 18 | 1 | 1347125 | GUIDE ASSEMBLY | |
| 19 | 1 | 1347128 | MOUNT, SCALE | |
| 20 | 1 | 1347129 | POINTER | |
| 21 | *AR | 1347D-HPAR | PARAMETER LIST,SEWING HD | Page 21 |
| 22 | *AR | 1347D-LAB | LABEL SHEET | |
| 23 | *AR | 1347D-PD | DIAGRAM,PNEUMATIC | Page 55 |
| 24 | *AR | 1347D-PPAR | PARAMETER LIST,PULLER MTR | Page 20 |
| 25 | *AR | 1347D-WD | DIAGRAM,WIRING,CONTROL | Page 56 |
| 26 | 1 | 1961-250F | PREFEED ASSEMBLY | Page 52 |
| 27 | 1 | 26151 | TOOL TRAY, 1X3.5X9 | |
| 28 | 2 | MM40450010 | FASTENER,SLIDE LOCK | |
| 29 | 4 | MMSLD-ECH | 1/2" DIA RUBBER BUMPER | |
| 30 | 2 | NNH1/4-20 | NUT,HEX,1/4-20 | |
| 31 | 2 | NNH10-32 | HEX-NUT 10-32 REG. | |
| 32 | 8 | NNK1/4-20 | NUT,HEX,KEP,1/4-20,W/LOCK | |
| 33 | 4 | SSHC01048 | 1/4-20 X 3/4 HEX CAP | |
| 34 | 4 | SSHC01096 | 1/4-20 X 1-1/2 HHCS | |
| 35 | 4 | SSHC01112 | HEX HEAD BOLT 1/4-20X1.75 | |
| 36 | 8 | SSHC01128 | 1/4-20 X 2 HEX CAP | |
| 37 | 4 | SSPS98024 | 10-32X3/8 PAN HD SLOT | |
| 38 | 2 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC | |
| 39 | 4 | SSSC98024 | 10-32 X 3/8 SOC CAP | |
| 40 | 4 | SSSC98032 | 10-32X1/2, SOC CAP | |
| 41 | 4 | SSSC98040 | 10-32 X 5/8 SOC CAP | |
| 42 | 20 | SSZS93032 | SCREW, SHT.METAL 10 ZIP | |
| 43 | 6 | TTH32415 | HANDLE,THREADED,1/4-20X7/ | |
| 44 | 32 | WWFS1/4 | WASHER,FLAT,SAE,1/4 | |
| 45 | 14 | WWFS10 | WASHER, FLAT, #10, SAE | |
| 46 | 12 | WWL1/4 | WASHER,LOCK,1/4 | |
| 47 | 4 | WWL10 | WASHER,LOCK,#10 | |
| 48 | 2 | ZX3848 | V BELT,3/8 X 48" | |
| 49 | 2 | 1347010 | HEAD ASSEMBLY | Page 27 |

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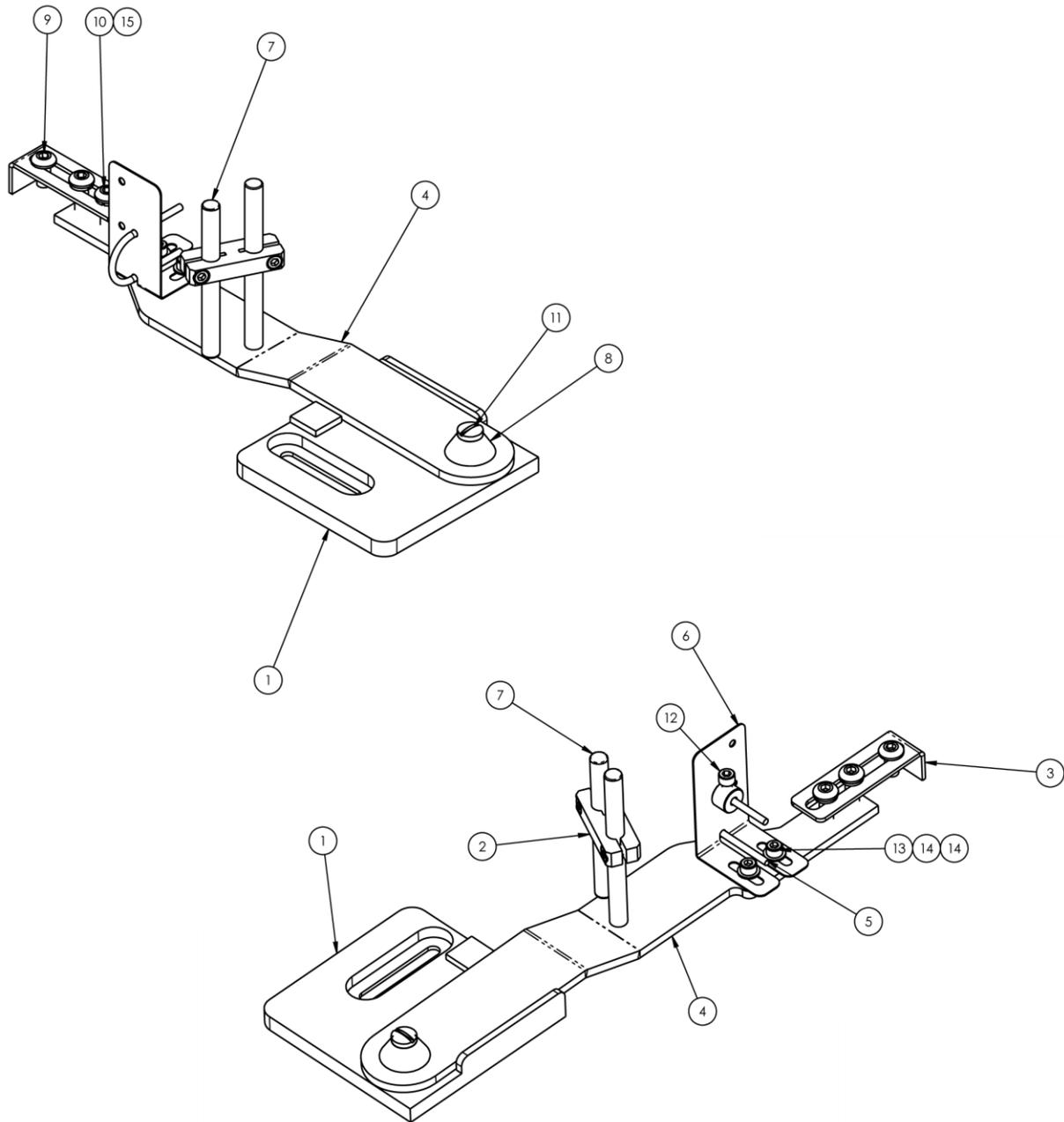


From the library of: Diamond Needle Corp

1347010 Sew Head Assembly

AAC Drawing Number 1347010 Rev 5

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|-----|-----|-----------|--------------------------|-----|-----|----------------|---------------------------|
| 1 | 1 | 1278-6364 | DISC, TAPE MOUNTING | 12 | 1 | CCCL5F | CLAMP COLLAR, 5/16" BORE |
| 2 | 1 | 1347001 | SEWING HEAD, MODIFIED | 13 | 2 | D8229555E00 | ISOLATOR, FRONT OIL PAN |
| 3 | 1 | 1347011 | OIL PAN, MODIFIED | 14 | 1 | NNH1/4-20 | NUT, HEX, 1/4-20 |
| 4 | 1 | 1347072 | THROAT PLATE, SJUKI-481U | 15 | 1 | NNJ5/16-24 | NUT, JAM, 5/16-24 |
| 5 | 1 | 1918-073 | FOOTLIFT LINK | 16 | 10 | SNTVX722-140GB | NEEDLE, SIZE 140/22 |
| 6 | 1 | 1961-737 | BRACKET, FOOT LIFT CYL. | 17 | 1 | ssas020040 | SHULDER BOLT 5/16 X 5/8L, |
| 7 | 1 | 22100-019 | ADAPTER, SYNCHRONIZER | 18 | 2 | SSPP98024 | 10-32 X 3/8 PAN HD PHILIP |
| 8 | 1 | AAC6DP-1 | CYLINDER, AIR, DA | 19 | 2 | SSSC98024 | 10-32 X 3/8 SOC CAP |
| 9 | 1 | AAFBP-11C | BRKT, PIVOT, 1/4 BORE | 20 | 2 | WWFS10 | WASHER, FLAT, #10, SAE |
| 10 | 2 | AAQME-5-8 | QUICK MALE ELBOW | 21 | 2 | WWL10 | WASHER, LOCK, #10 |
| 11 | 1 | BBAW-5Z | BEARING, ROD END, FEMALE | | | | |

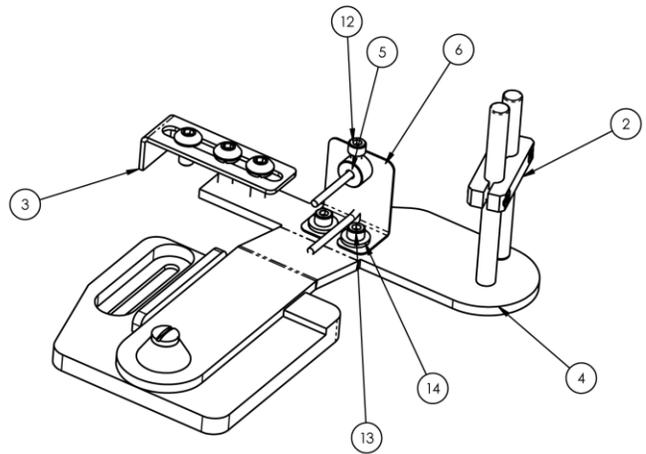
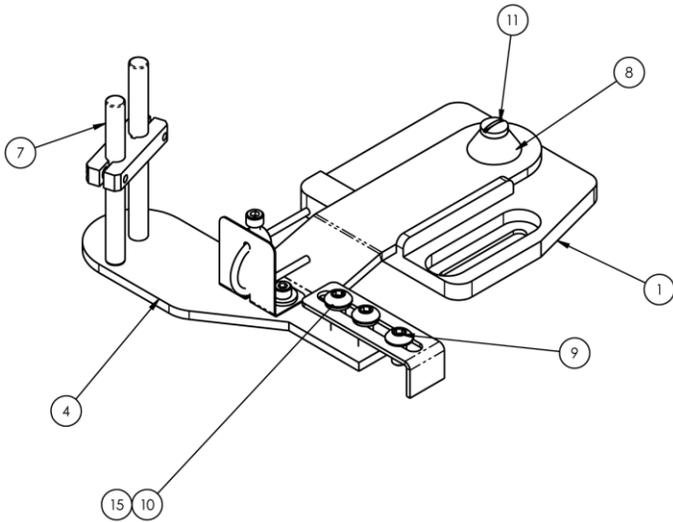


From the library of: Diamond Needle Corp

1347030 Swing Out Binder Assembly

AAC Drawing Number 1347030 Rev 3

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|-----|-----|------------|------------------------|-----|-----|-----------|---------------------------|
| 1 | 1 | 1335M-5001 | PLATE,MOUNTING | 9 | 1 | SSBC98024 | 10-32 X 3/8 BUTTON CAP SC |
| 2 | 1 | 1347022 | GUIDE CLAMP | 10 | 2 | SSBC98040 | 10-32 X 5/8 BUTTON CAP SC |
| 3 | 1 | 1347039 | EDGE GUIDE, BINDER | 11 | 1 | SSM200246 | SCREW,SHLDR,SLT.248X.437L |
| 4 | 1 | 1347060 | MOUNT, BLOCK BINDER | 12 | 1 | SSSC80016 | 6-32 X 3/16 SOC CAP SC |
| 5 | 1 | 1347459 | BINDER PREFOLD BAR | 13 | 2 | SSSC85016 | 6-40 X 1/4 SOC CAP SC |
| 6 | 1 | 1347460 | PREFOLD BINDER BRACKET | 14 | 2 | WWFS6 | WASHER, FLAT, #6 |
| 7 | 1 | IID016X160 | DOWEL PIN, 1/4 X 2-1/2 | 15 | 2 | WWL10 | WASHER,LOCK,#10 |
| 8 | 1 | RRBEEHIVEH | SPRING,HEAVY BEEHIVE | | | | |

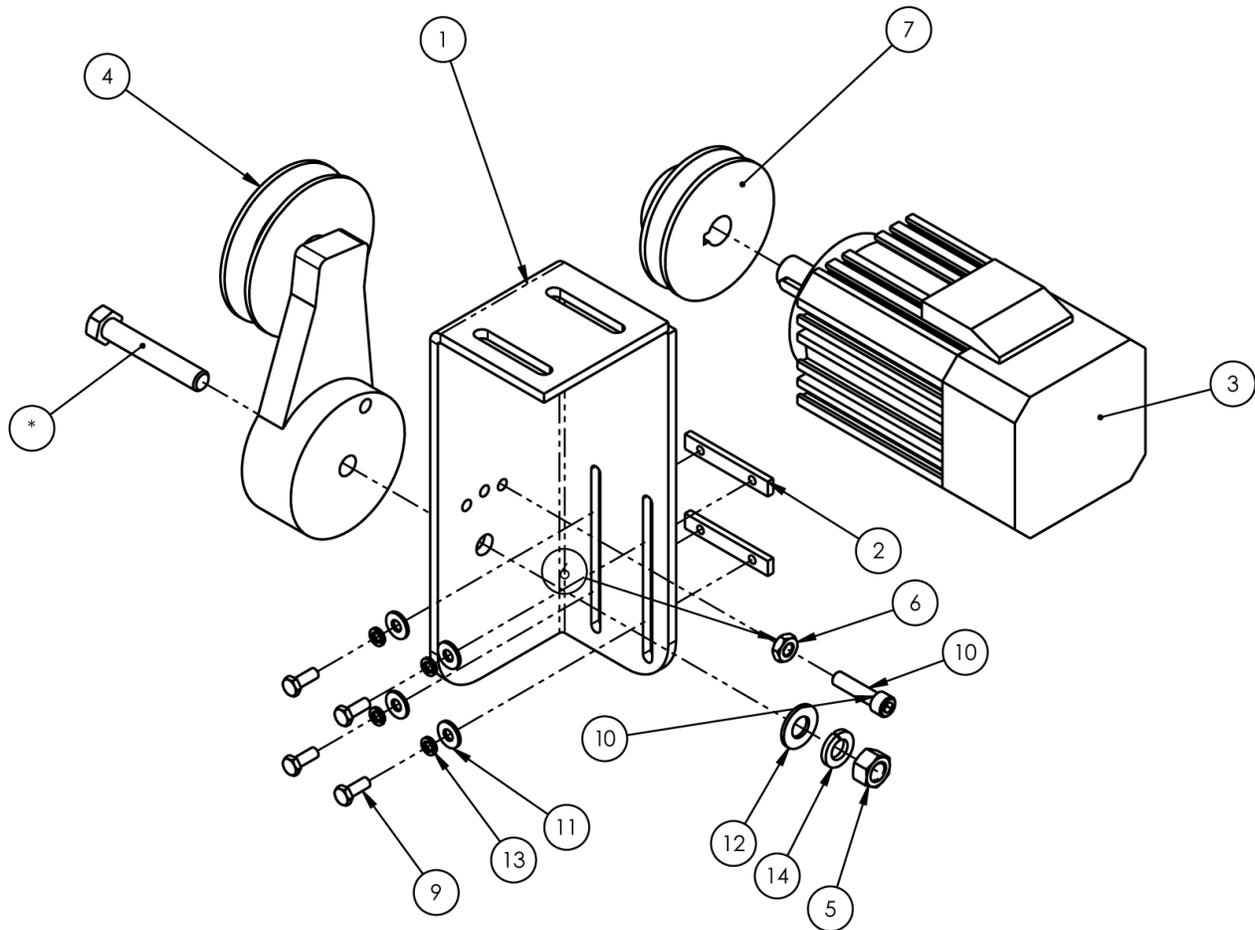


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1347040 Swing Out Binder Assembly

AAC Drawing Number 1347040 Rev 3

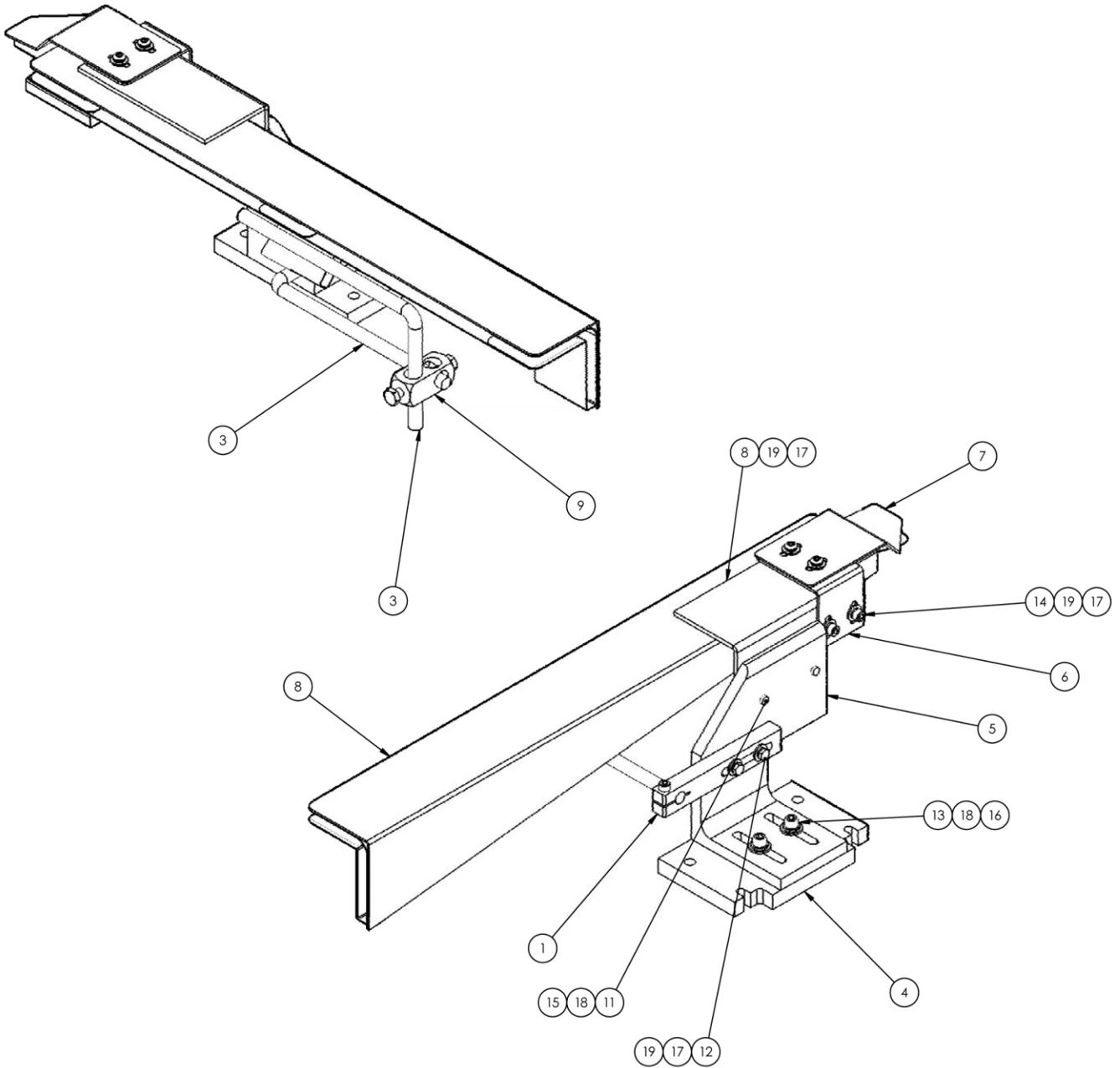
| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|-----|-----|------------|------------------------|-----|-----|-----------|---------------------------|
| 1 | 1 | 1347017 | PLATE, MOUNTING | 9 | 2 | WWF6 | DO NOT USE - SEE WWFS6 |
| 2 | 1 | 1347022 | GUIDE CLAMP | 10 | 2 | SSSC85016 | 6-40 X 1/4 SOC CAP SC |
| 3 | 1 | 1347039 | EDGE GUIDE, BINDER | 11 | 1 | SSM200246 | SCREW,SHLDR,SLT.248X.437L |
| 4 | 1 | 1347048 | MOUNT, BLOCK BINDER | 12 | 2 | SSBC98040 | 10-32 X 5/8 BUTTON CAP SC |
| 5 | 1 | 1347459 | BINDER PREFOLD BAR | 13 | 1 | SSSC90016 | #8-32 X 1/4 SOC CAP SC |
| 6 | 1 | 1347460 | PREFOLD BINDER BRACKET | 14 | 2 | WWL10 | WASHER,LOCK,#10 |
| 7 | 1 | IID016X160 | DOWEL PIN,1/4 X 2-1/2 | 15 | 1 | SSBC98024 | 10-32 X 3/8 BUTTON CAP SC |
| 8 | 1 | RRBEEHIVEH | SPRING,HEAVY BEEHIVE | | | | |



1347126 Motor / Tensioner Assembly

AAC Drawing Number 1347126 Rev 0

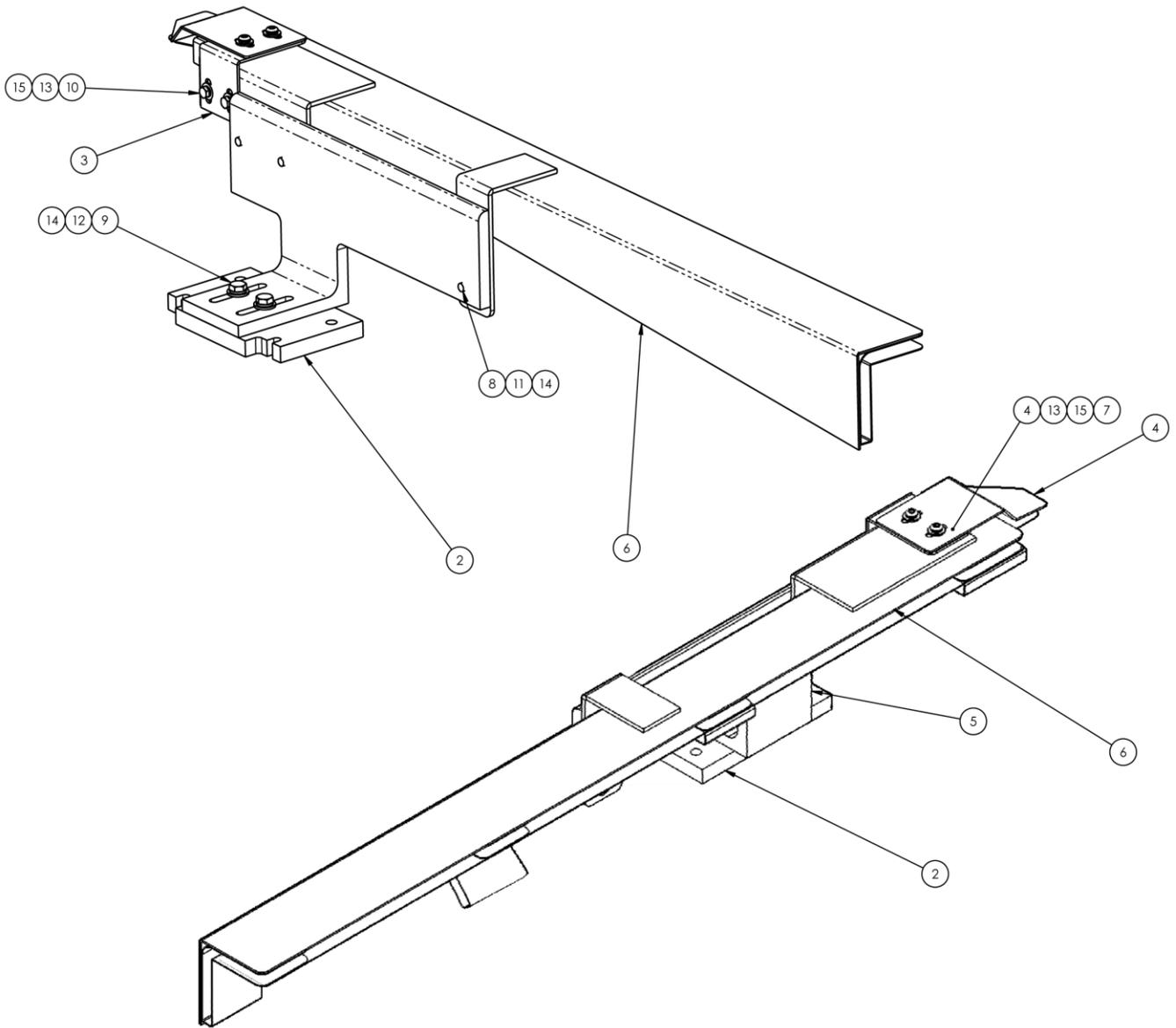
| NO. | QTY | PART # | DESCRIPTION |
|-----|-----|--------------|--------------------------|
| 1 | 1 | 1347008 | BRKT,MOTOR MOUNT |
| 2 | 2 | 1347046 | PLATE,NUT,10-32@1.25 CTC |
| 3 | 1 | 4059-DC1500A | MOTOR & CONTROLLER ONLY |
| 4 | 1 | MMFS0127 | TENSIONER,V-BELT |
| 5 | 1 | NNH3/8-16 | NUT,HEX,3/8-16 |
| 6 | 1 | NNJ1/4-28 | NUT, HEX, JAM, 1/4-28 |
| 7 | 1* | PP65X1-14 | PULLEY,V-BELT 65MM OD |
| 8 | 1 | SSHC25144 | 3/8-16 X 2-1/4 HEX HEAD |
| 9 | 4 | SSHC98032 | 10-32X1/2 HEX HD |
| 10 | 1 | SSSC05064 | 1/4-28 X 7/8 |
| 11 | 4 | WWFS10 | WASHER, FLAT, #10, SAE |
| 12 | 1 | WWFS3/8 | WASHER,FLAT,SAE,3/8 |
| 13 | 4 | WWL10 | WASHER,LOCK,#10 |
| 14 | 1 | WWL3/8 | WASHER, LOCK, 3/8 |



1347065 Right Side Folder Assembly

AAC Drawing Number 1347065 Rev 4

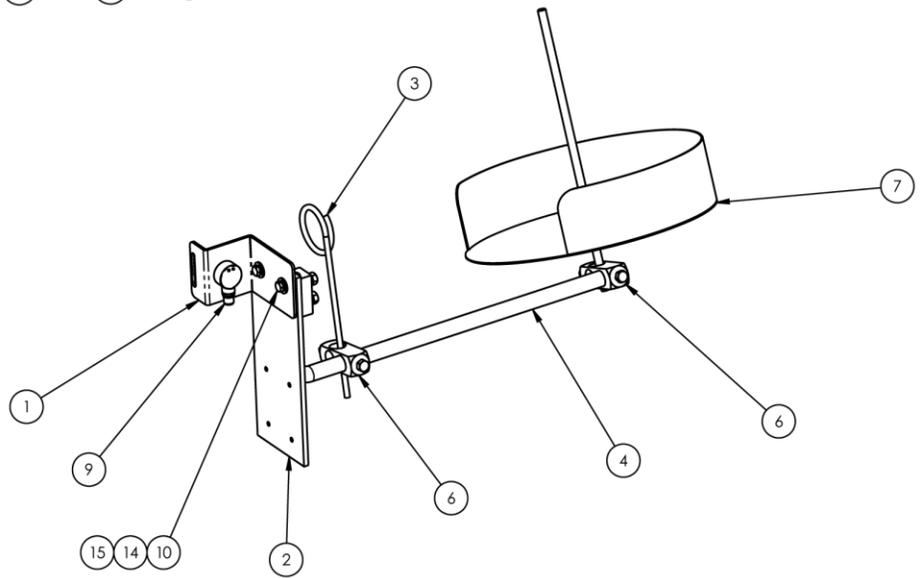
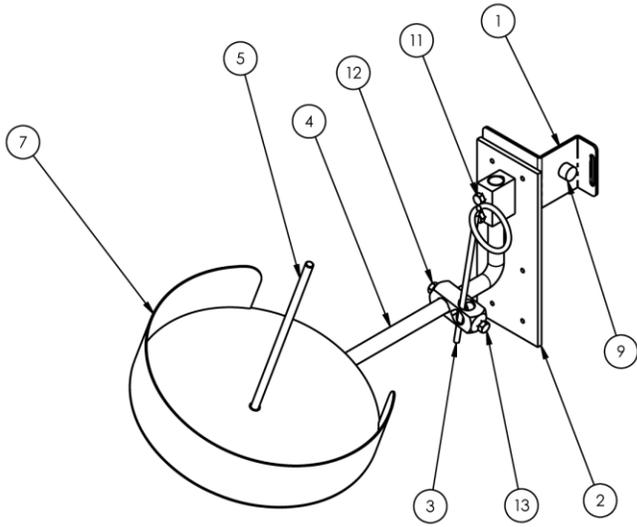
| NO. | QTY | PART # | DESCRIPTION |
|-----|-----|------------|---------------------------|
| 1 | 1 | 1136227 | HOLDER, ROD, 3/8" DIA., S |
| 2 | 1 | 1278-3140D | NUT PLATE, 10-32, 2 PL |
| 3 | 2 | 1335-316 | ROD, SS, "L", 3/8, 4.0 X |
| 4 | 1 | 1347062 | BASE, FOLDER MOUNT |
| 5 | 1 | 1347067 | MOUNT, FOLDER |
| 6 | 1 | 1347068 | SUPPORT, HOLD DOWN |
| 7 | 1 | 1347074 | CLOTH DOLD DOWN |
| 8 | 1 | 1347240 | FOLDER, 2-1/2 FOLD |
| 9 | 1 | A-U | ROD CROSS BLOCK |
| 10 | 2 | SSBC98024 | 10-32 X 3/8 BUTTON CAP SC |
| 11 | 2 | SSHC01048 | 1/4-20 X 3/4 HEX CAP |
| 12 | 2 | SSHC98080 | #10-32 X 1-1/4 HEX CAP |
| 13 | 2 | S SSC01080 | 1/4-20X1-1/4, SOC CAP |
| 14 | 2 | S SSC98024 | 10-32 X 3/8 SOC CAP |
| 15 | 2 | WWFE016 | WASHER,FENDER,LARGE,1/4 |
| 16 | 2 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 17 | 6 | WWFS10 | WASHER, FLAT, #10, SAE |
| 18 | 4 | WWL1/4 | WASHER,LOCK,1/4 |
| 19 | 6 | WWL10 | WASHER,LOCK,#10 |



1347079 Left Side Folder Assembly

AAC Drawing Number 1347079 Rev 6

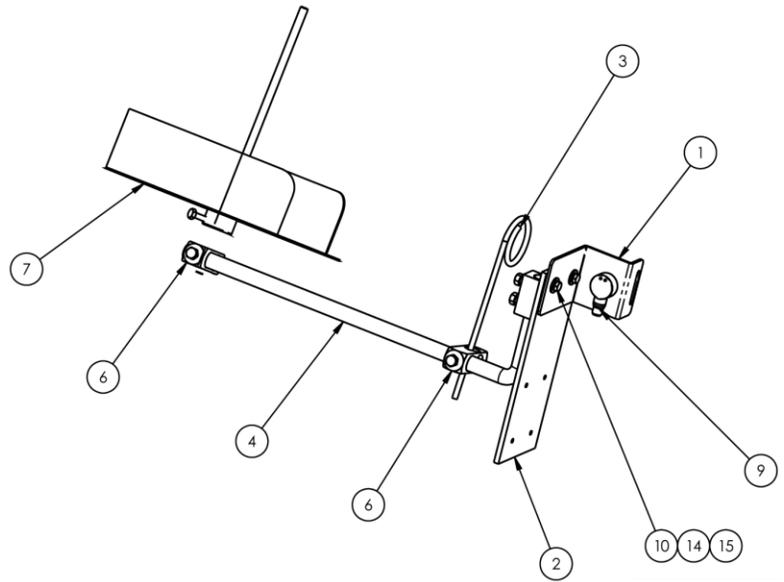
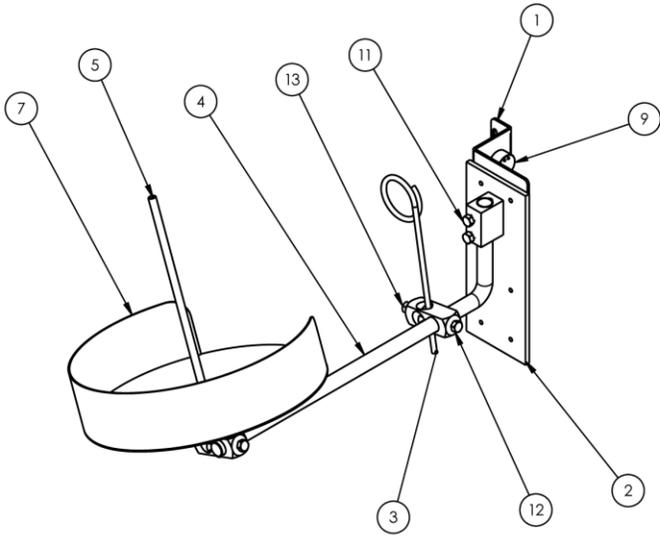
| NO. | QTY | PART # | DESCRIPTION |
|-----|-----|------------|----------------------------|
| 1 | 1 | 1278-3140D | NUT PLATE, 10-32, 2 PL |
| 2 | 1 | 1347062 | BASE, FOLDER MOUNT |
| 3 | 1 | 1347068 | SUPPORT, HOLD DOWN |
| 4 | 1 | 1347078 | CLOTH DOLD DOWN, LS |
| 5 | 1 | 1347179 | MOUNT, FOLDER, LEFT |
| 6 | 1 | 1347230 | FOLDER ASSEMBLY, LS |
| 7 | 2 | SSBC98024 | 10-32 X 3/8 BUTTON CAP SC |
| 8 | 3 | SSHC01048 | 1/4-20 X 3/4 HEX CAP |
| 9 | 2 | SSHC01080 | 1/4-20 X 1-1/4 HHCS |
| 10 | 2 | SSHC98024 | 10-32 X 3/8 HEX CAP |
| 11 | 3 | WWFE016 | WASHER, FENDER, LARGE, 1/4 |
| 12 | 2 | WWFS1/4 | WASHER, FLAT, SAE, 1/4 |
| 13 | 4 | WWFS10 | WASHER, FLAT, #10, SAE |
| 14 | 5 | WWL1/4 | WASHER, LOCK, 1/4 |
| 15 | 4 | WWL10 | WASHER, LOCK, #10 |



1347080 Binding Roll Support

AAC Drawing Number 1347080 Rev 1

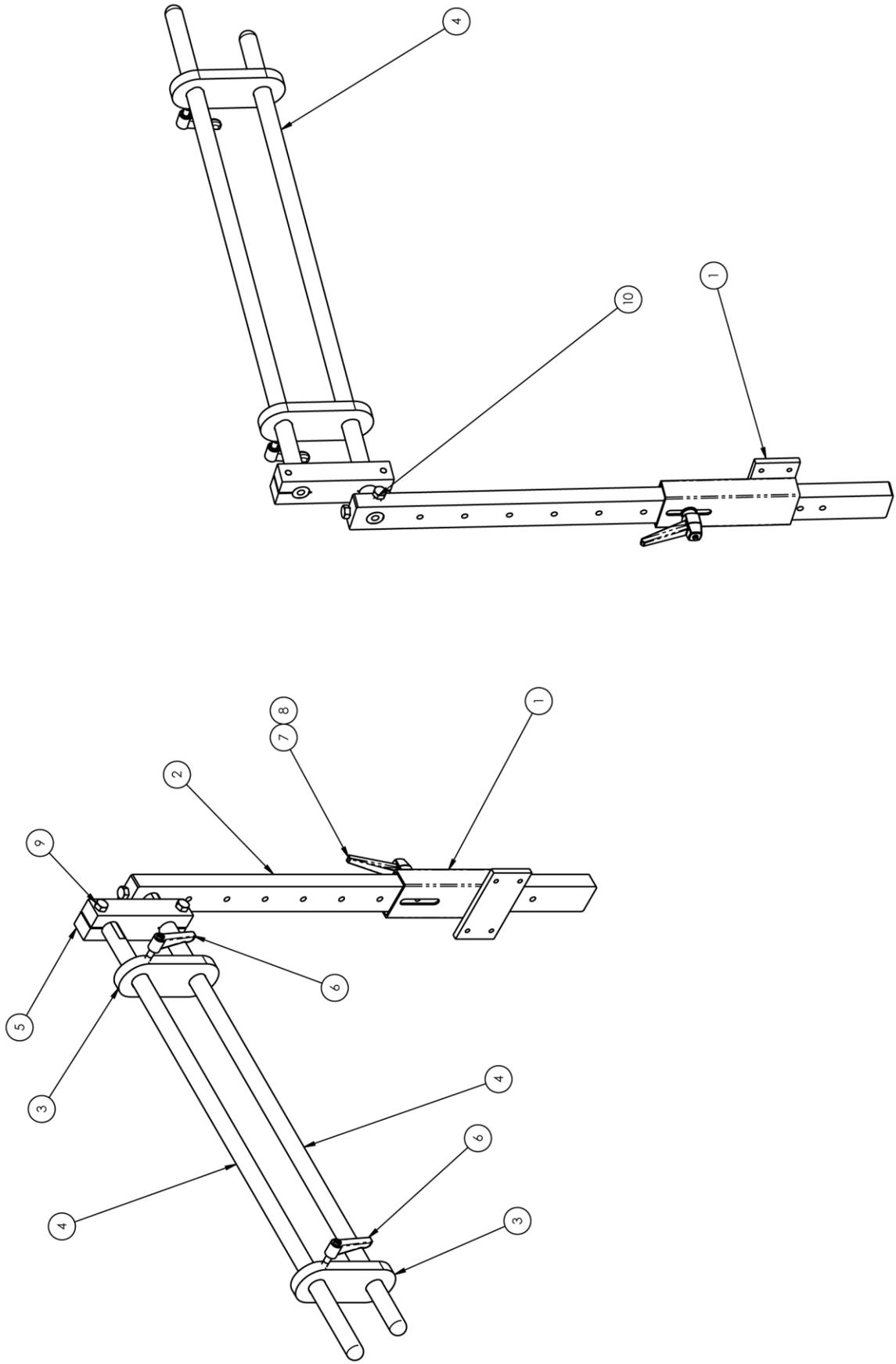
| NO. | QTY | PART # | DESCRIPTION |
|-----|-----|------------|--------------------------|
| 1 | 1 | 1347036 | SENSOR BRACKET |
| 2 | 1 | 1347050 | MOUNT, TAPE SPOOL |
| 3 | 1 | 1347116 | RING,TAPE GUIDE |
| 4 | 1 | 1347117 | ROD, BENT, 90 DEG |
| 5 | 1 | 1981-607 | ROD, STRAIGHT, CRS |
| 6 | 2 | 28201 | CROSS BLOCK, LARGE |
| 7 | 1 | 785-A9-12B | STATIONARY CRS DISC WITH |
| NS | - | FFRK44T-4 | CABLE |
| 9 | 1 | FFT18FF25Q | EYE, FIXED FIELD, 1IN |
| 10 | 2 | SSHC01032 | 1/4-20 X 1/2 HHCS |
| 11 | 2 | SSHC10032 | 5/16-18 X 1/2 HHCS |
| 12 | 2 | SSHC10040 | 5/16-18 X 5/8 HHCS |
| 13 | 2 | SSHC10080 | 5/16-18 X 1-1/4 HHCS |
| 14 | 2 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 15 | 2 | WWL1/4 | WASHER, LOCK, 1/4 |



1347090 Binding Roll Support

AAC Drawing Number 1347090 Rev 1

| NO. | QTY | PART # | DESCRIPTION |
|-----|-----|------------|--------------------------|
| 1 | 1 | 1347036 | SENSOR BRACKET |
| 2 | 1 | 1347050 | MOUNT, TAPE SPOOL |
| 3 | 1 | 1347116 | RING,TAPE GUIDE |
| 4 | 1 | 1347117 | ROD, BENT, 90 DEG |
| 5 | 1 | 1981-607 | ROD, STRAIGHT, CRS |
| 6 | 2 | 28201 | CROSS BLOCK, LARGE |
| 7 | 1 | 785-A9-12B | STATIONARY CRS DISC WITH |
| NS | - | FFRK44T-4 | CABLE |
| 9 | 1 | FFT18FF25Q | EYE, FIXED FIELD, 1IN |
| 10 | 2 | SSHC01032 | 1/4-20 X 1/2 HHCS |
| 11 | 2 | SSHC10032 | 5/16-18 X 1/2 HHCS |
| 12 | 2 | SSHC10040 | 5/16-18 X 5/8 HHCS |
| 13 | 2 | SSHC10080 | 5/16-18 X 1-1/4 HHCS |
| 14 | 2 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 15 | 2 | WWL1/4 | WASHER, LOCK, 1/4 |

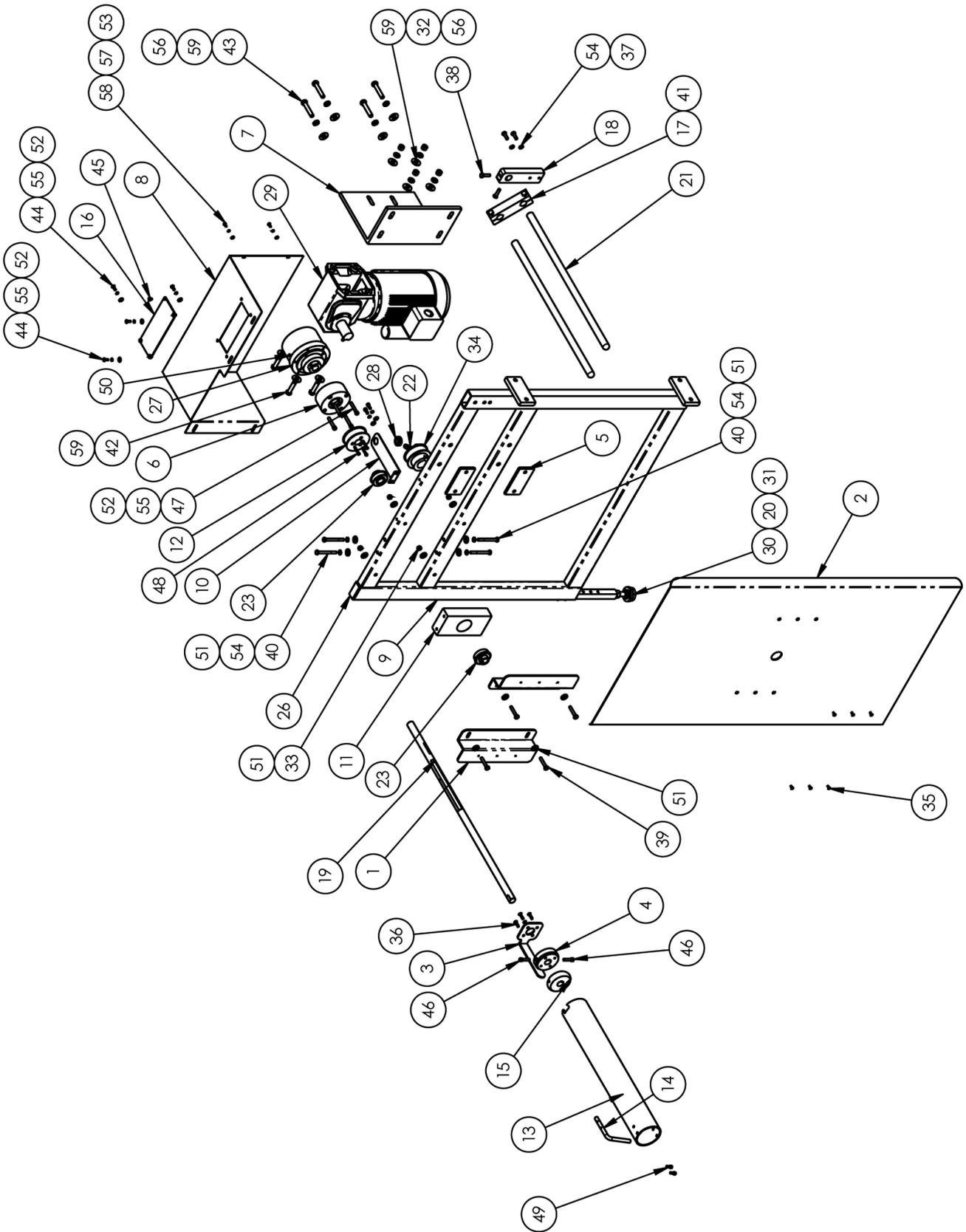


From the library of: Diamond Needle Corp

1347094 Upper Tension Assembly

AAC Drawing Number 1347094 Rev 1

| NO. | QTY | PART # | DESCRIPTION |
|-----|-----|-----------|-----------------------------|
| 1 | 1 | 1347093 | SUPPORT, TENSIONER |
| 2 | 1 | 1347097 | SUPPORT, TENSIONER |
| 3 | 2 | 1961-211 | PLATE, EDGE GUIDE |
| 4 | 2 | 1961-252D | ROD, ROLL, 27" L |
| 5 | 1 | 1962-3201 | CLAMP, 3/4 ROD, 3" CTC |
| 6 | 2 | TTH32416 | HANDLE, THRD, 1/4-20X1-1/8 |
| 7 | 1 | TTH32425 | HANDLE, THRDED, 5/16-18X3/4 |
| 8 | 1 | WWFS5/16 | WASHER, FLAT, SAE, 5/16 |
| 9 | 2 | SSHC10096 | 5/16-18 X 1-1/2 HHCS |
| 10 | 2 | SSHC10048 | 5/16-18 X 3/4 HHCS |

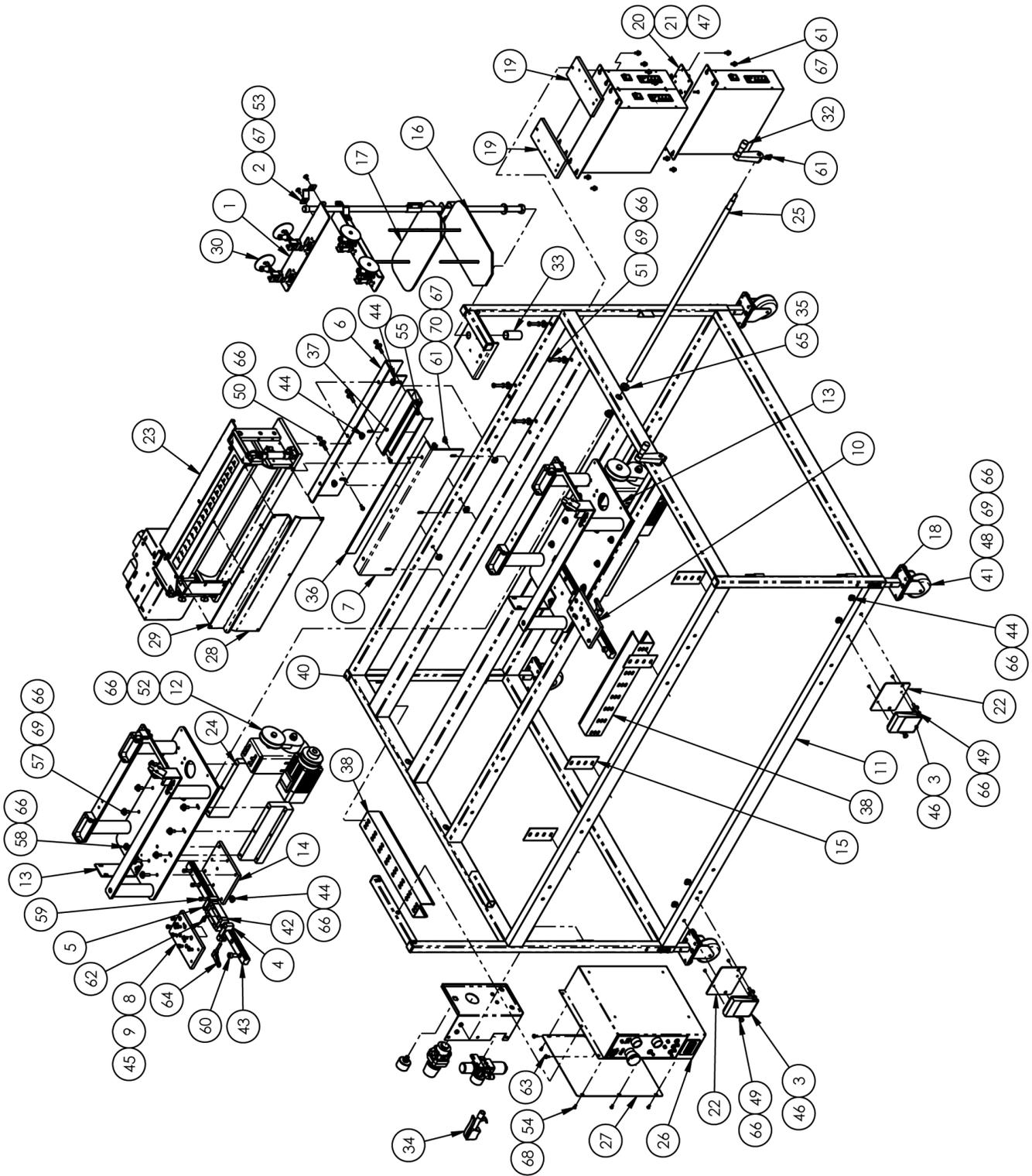


1347098 Rewind Assembly w/ Sleeve

AAC Drawing Number 1347098 Rev 1

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|-----|-----|------------|---------------------------|-----|-----|-----------------|--------------------------|
| 1 | 2 | 1334326 | MOUNT, FLANGE | 31 | 1 | NNH1/2-13 | NUT,HEX,1/2-13 |
| 2 | 1 | 1334376 | PLATE, REWIND,24 X 40 | 32 | 4 | NNH3/8-16 | NUT,HEX,3/8-16 |
| 3 | 1 | 1334387 | CATCH, MATL. TAKEUP REEL | 33 | 4 | NNK1/4-20 | KEP NUT, 1/4-20 |
| 4 | 1 | 1334388 | HUB, TAKEUP SPINDLE | 34 | 1 | PP22LB075-1-1/8 | PULLEY, GEAR, 3/8P, 22T |
| 5 | 2 | 1961-319 | PLATE,NUT,3/8-16@3.00 CTC | 35 | 6 | SSFC80024 | 6-32 X 3/8 FLAT CAP |
| 6 | 1 | 1961-321 | PLATE, ADAPTOR, AIR CLUTC | 36 | 4 | SSFC98048 | #10-32 X .75 SHCSF |
| 7 | 1 | 1961-331 | MOUNT, MOTOR | 37 | 4 | SSHC01048 | 1/4-20 X 3/4 HEX CAP |
| 8 | 1 | 1961-332 | COVER, MOTOR | 38 | 2 | SSHC01064 | 1/4-20 X 1 HHCS |
| 9 | 1 | 1961-335 | FRAME, PREFEED & REWIND A | 39 | 4 | SSHC01096 | 1/4-20 X 1-1/2 HHCS |
| 10 | 1 | 1961-354B | SUPPORT, AIR CLUTCH | 40 | 4 | SSHC01160 | 1/4-20 X 2-1/2 HHCS |
| 11 | 1 | 1961-365B | BLOCK, BEARING MOUNT | 41 | 2 | SSHC10096 | 5/16-18 X 1-1/2 HHCS |
| 12 | 1 | 1961-366A | PULLEY,CLUTCH,22 TH,3/8 P | 42 | 4 | SSHC25096 | 3/8-16 X 1 1/2 HEX HEAD |
| 13 | 1 | 1961-372 | SLEEVE, REWIND, 18" CAP | 43 | 4 | SSHC25128 | 3/8-16 X 2 HEX CAP |
| 14 | 1 | 1961-374A | HANDLE, SLEEVE | 44 | 4 | SSPP98032 | 10-32 X 1/2 PAN PHIL |
| 15 | 1 | 1961-379 | SUPPORT,REWIND SLEEVE | 45 | 4 | SSPS95016 | #10-24 X 1/4 PAN HD SLTD |
| 16 | 1 | 1961104 | COVER, INSPECTION | 46 | 2 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 17 | 1 | 1962-3201 | CLAMP, 3/4 ROD, 3" CTC | 47 | 4 | SSSC01096 | 1/4-20 X 1-1/2 SOC CAP |
| 18 | 1 | 1962-3202A | SUPPORT, TENSION PULLER | 48 | 3 | SSSC90064 | #8-32 X 1 SOC CAP SC |
| 19 | 1 | 1962-375 | SHAFT, AIR CLUTCH, MM8028 | 49 | 4 | SSSC98032 | 10-32X1/2, SOC CAP |
| 20 | 1 | 26127 | LEG FOR AP-26-02 | 50 | 2 | SSSS01016 | 1/4-20 X 1/4 KNURL PT |
| 21 | 2 | 33008202 | ROD,ROLL,SST,3/4X21 W/RAD | 51 | 14 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 22 | 1 | AAQMEL-5-8 | QUICK MALE ELBOW, LONG | 52 | 6 | WWF10 | WASHER, FLAT, #10, COM |
| 23 | 2 | BBS8703-88 | BEARING,BALL,.75IDX1.75OD | 53 | 2 | WWF8 | WASHER, FLAT, #8 |
| 24 | 1 | GG225L075 | GEAR BELT | 54 | 8 | WWL1/4 | WASHER,LOCK,1/4 |
| 25 | 1 | K-235A | ROMEX CONNECTOR | 55 | 6 | WWL10 | WASHER,LOCK,#10 |
| 26 | 1 | MM132-1496 | PLUG 1 X 2 | 56 | 8 | WWL3/8 | WASHER, LOCK, 3/8 |
| 27 | 1 | MM802860 | CLUTCH,AIR,3/4 BORE,4.5"D | 57 | 2 | WWL8 | WASHER,LOCK,#8 |
| 28 | 1 | MM9600K21 | GROMMET,RUBBER,9/16 ID | 58 | 2 | SSPP90024 | 8-32X3/8 PAN PHLPS |
| 29 | 1 | MMBH2LM22R | MOTOR,GEAR,R/A,220V | 59 | 12 | WWF3/8 | WASHER,FLAT,3/8 OR 10MM |
| 30 | 1 | MMFB4444 | FOOT, RUBBER | | | | |

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1347110 Main Frame Assembly

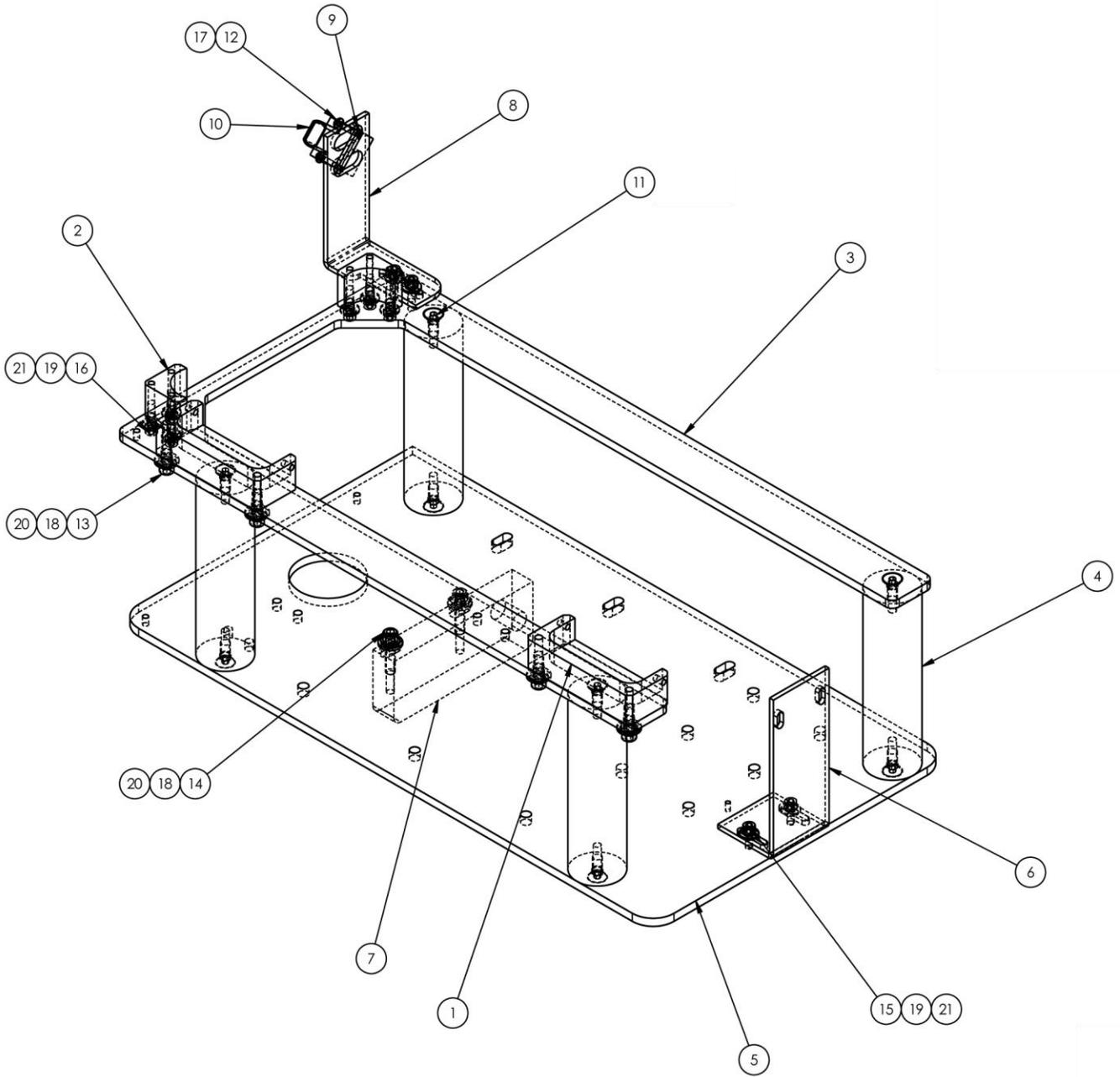
AAC Drawing Number 1347110 Rev 6

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|-----|-----|--------------|---------------------------|-----|-----|-------------|---------------------------|
| 1 | 2 | 0411-069B | BRKT, THREAD BREAK DETECT | 36 | 1 | EEDC1LG | DUCT,WIRE COVER,1" |
| 2 | 2 | 0411-070 | CLAMP, SENSOR BRACKET | 37 | 1 | EEDF1X2 | DUCT,WIRE,1X2 |
| 3 | 2 | 1278-6161 | FOOT SWITCH MODIFICATION | 38 | 2 | EEDF2X2 | DUCT,WIRE,2X2, MOD |
| 4 | 2 | 1334-1006 | MOUNT,LOCKING HANDLE | 39 | *1 | MM130-10A1 | TAPE, UHMW, 1" W X .01 TK |
| 5 | 2 | 1335-310 | BLOCK,STOP,FRONT | 40 | 6 | MM132-1202 | END CAP,SQUARE,BLACK |
| 6 | 1 | 1347043 | SUPPORT, PULLER | 41 | 4 | MM427-3RB | CASTER,SWIVEL,3"RUBBER |
| 7 | 1 | 1347044 | SUPPORT, PULLER | 42 | 2 | MMAGH25CAN | LINEAR BEARING |
| 8 | 1 | 1347059 | ADAPTOR, FOLDER, LEFT | 43 | 2 | MMAGR25414M | RAIL,MODIFIED |
| 9 | 4 | 1347088 | STUD, .312 OD, 1/4-20 | 44 | 22 | NNK1/4-20 | NUT,HEX,KEP,1/4-20,W/LOCK |
| 10 | 1 | 1347099 | ADAPTOR, FOLDER, RIGHT | 45 | 8 | SSCM6X10 | SCREW,CHEESE HEAD |
| 11 | 1 | 1347100 | FRAME WELDMENT | 46 | 4 | SSFC80016 | 6-32 X 1/4 FLAT SOC CAP |
| 12 | 2 | 1347126 | MOTOR/TENSIONER ASSEMBLY | 47 | 4 | SSFC80040 | SCREW, SOC HD, 6-32 X 5/8 |
| 13 | 2 | 1347127 | HEAD MOUNT ASSEMBLY | 48 | 24 | SSHC01048 | 1/4-20 X 3/4 HEX CAP |
| 14 | 1 | 1347180 | PLATE,RAIL ADAPTOR,LEFT | 49 | 4 | SSHC01096 | 1/4-20 X 1-1/2 HHCS |
| 15 | 4 | 1347338 | MOUNT, WIRE DUCT,2" | 50 | 3 | SSHC01112 | HEX HEAD BOLT 1/4-20X1.75 |
| 16 | 2 | 1959-021 | PLATE, THREAD, 2 POS | 51 | 4 | SSHC01160 | 1/4-20 X 2-1/2 HHCS |
| 17 | 2 | 1959-023 | PAD, FOAM, 2 POS | 52 | 8 | SSHC05048 | 1/4-28 X 3/4 HEX CAP |
| 18 | 4 | 1961-115 | LEG WELDMENT | 53 | 4 | SSPP98032 | 10-32 X 1/2 PAN PHIL |
| 19 | 2 | 1961-122 | MT, DUAL MOTOR CONTROL | 54 | 6 | SSPS80024 | #6-32 X 3/8 LG PAN HD |
| 20 | 1 | 1961-125 | BRKT,EFGA BOX HANG MOUNT | 55 | 3 | SSPS98032 | 10-32X1/2 PAN HD SLOT |
| 21 | 4 | 1961-126 | PLATE, NUT, 6-32, 1PL | 56 | 4 | SSSC01024 | 1/4-20 X 3/8 SOC CAP SC |
| 22 | 2 | 1961-159 | PLATE, MOUNT, FOOT PEDAL | 57 | 18 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 23 | 1 | 1961-300EB | PULLER ASSY,18",WORM GEAR | 58 | 6 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 24 | 4 | 1961-401 | RAIL,GUIDE | 59 | 3 | SSSC01080 | 1/4-20X1-1/4, SOC CAP |
| 25 | 2 | 1961-406A | ROD, HEAD LOCATION, ADJ. | 60 | 2 | SSSC25048 | 3/8-16X3/4 SOC CAP |
| 26 | 1 | 1961-900C | PANEL, CONTROL | 61 | 19 | SSSC98032 | 10-32X1/2, SOC CAP |
| 27 | 1 | 1961-903A | COVER, ELECTRICAL PANEL | 62 | 2 | SSSC98040 | 10-32 X 5/8 SOC CAP |
| 28 | 1 | 1961019 | GUARD | 63 | 5 | SSZS93032 | SCREW, SHT.METAL 10 ZIP |
| 29 | 1 | 1961020 | GUARD,PULLER | 64 | 2 | TTH32416 | HANDLE,THRD,1/4-20X1-1/8 |
| 30 | 4 | 4003-IS3WT2 | SENSOR,THREAD BREAK | 65 | 4 | UUFF723-05 | BEARING,BRONZE, .505ID |
| 31 | *2 | 4003-MA2A/FE | CABLE | 66 | 83 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 32 | 2 | 951A-0844 | CRANK HANDLE, MODIFIED | 67 | 19 | WWF10 | WASHER, FLAT, #10, COM |
| 33 | 1 | 97-2250A | SPACER, THREAD STAND | 68 | 6 | WWFS6 | WASHER, FLAT, #6 |
| 34 | 1 | AAVBG35C | BLOW GUN ASSY WITH HOSE | 69 | 48 | WWL1/4 | WASHER,LOCK,1/4 |
| 35 | 2 | BBTRA815 | WASHER,THRUST,STEEL 1/2 | 70 | 15 | WWL10 | WASHER,LOCK,#10 |

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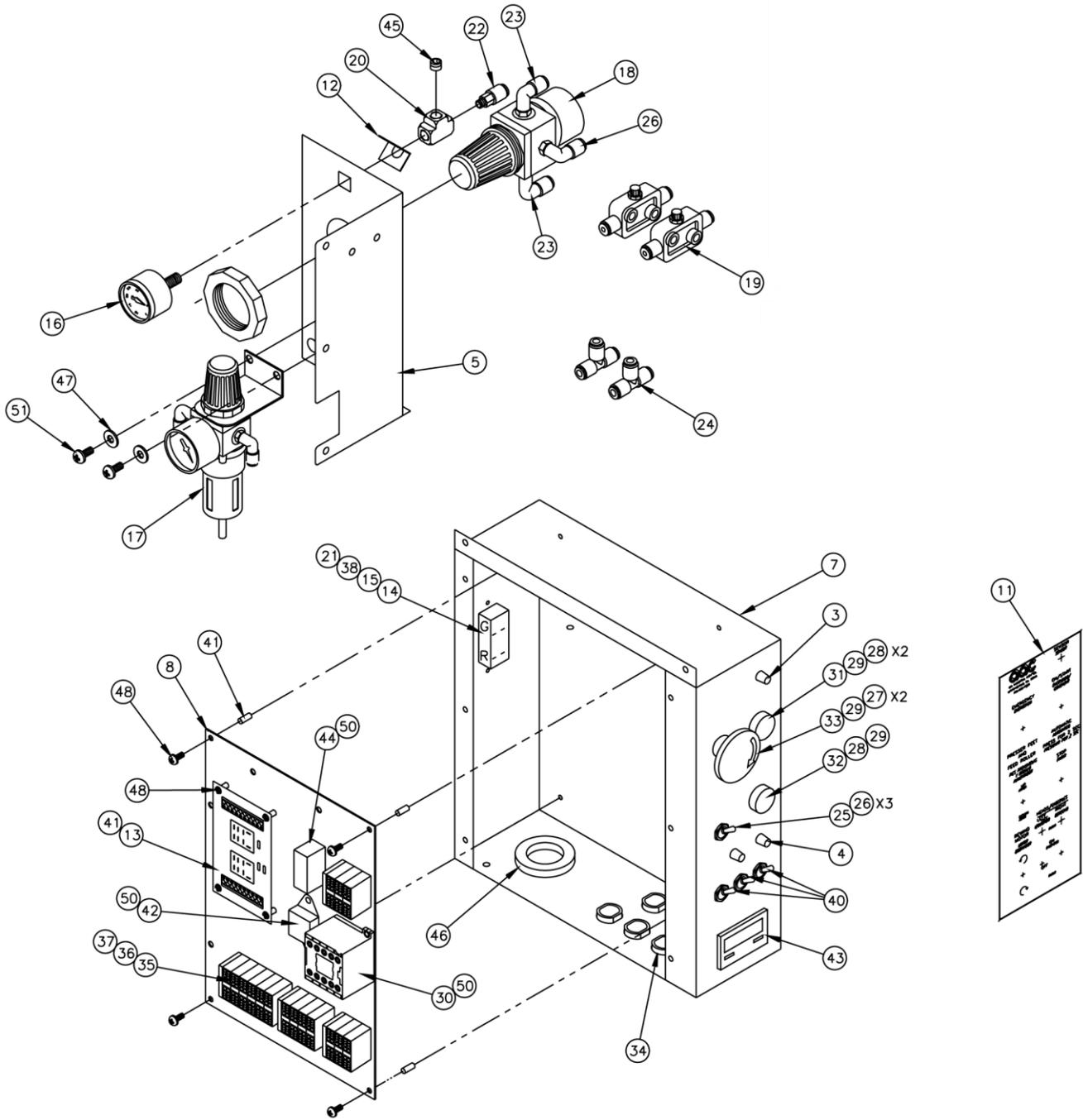
From the library of: Diamond Needle Corp



1347127 Head Mount Assembly

AAC Drawing Number 1347127 Rev 0

| NO. | QTY | PART # | DESCRIPTION |
|-----|-----|------------|---------------------------|
| 1 | 2 | 1347002 | MOUNT, HINGE |
| 2 | 2 | 1347003 | MOUNT, ISOLATOR |
| 3 | 1 | 1347005 | HEAD MOUNT TOP PLATE |
| 4 | 4 | 1347006 | STANDOFF, CLOTH PLATE |
| 5 | 1 | 1347007 | PLATE, HEAD MOUNT |
| 6 | 1 | 1347009 | SUPPORT, OILPAN |
| 7 | 1 | 1347045 | BLOCK, INDEX |
| 8 | 1 | 1347047 | BRACKET, EYE MOUNT |
| 9 | 1 | 1975-412A | PLATE,NUT,4-40,.95CTC |
| 10 | 1 | FFSM312LVQ | EYE,ELECTRIC,10-30VDC |
| 11 | 8 | SSFC01040 | 1/4-20 X 5/8 FLAT ALN CAP |
| 12 | 2 | SSPS70048 | 4-40 X 3/4 PAN HD SLOTTED |
| 13 | 4 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 14 | 2 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 15 | 2 | SSSC98032 | 10-32X1/2, SOC CAP |
| 16 | 8 | SSSC98048 | 10-32 X 3/4 SOC CAP |
| 17 | 2 | WWF4 | WASHER, FLAT, #4 |
| 18 | 6 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 19 | 10 | WWFS10 | WASHER, FLAT, #10, SAE |
| 20 | 6 | WWL1/4 | WASHER,LOCK,1/4 |
| 21 | 10 | WWL10 | WASHER,LOCK,#10 |

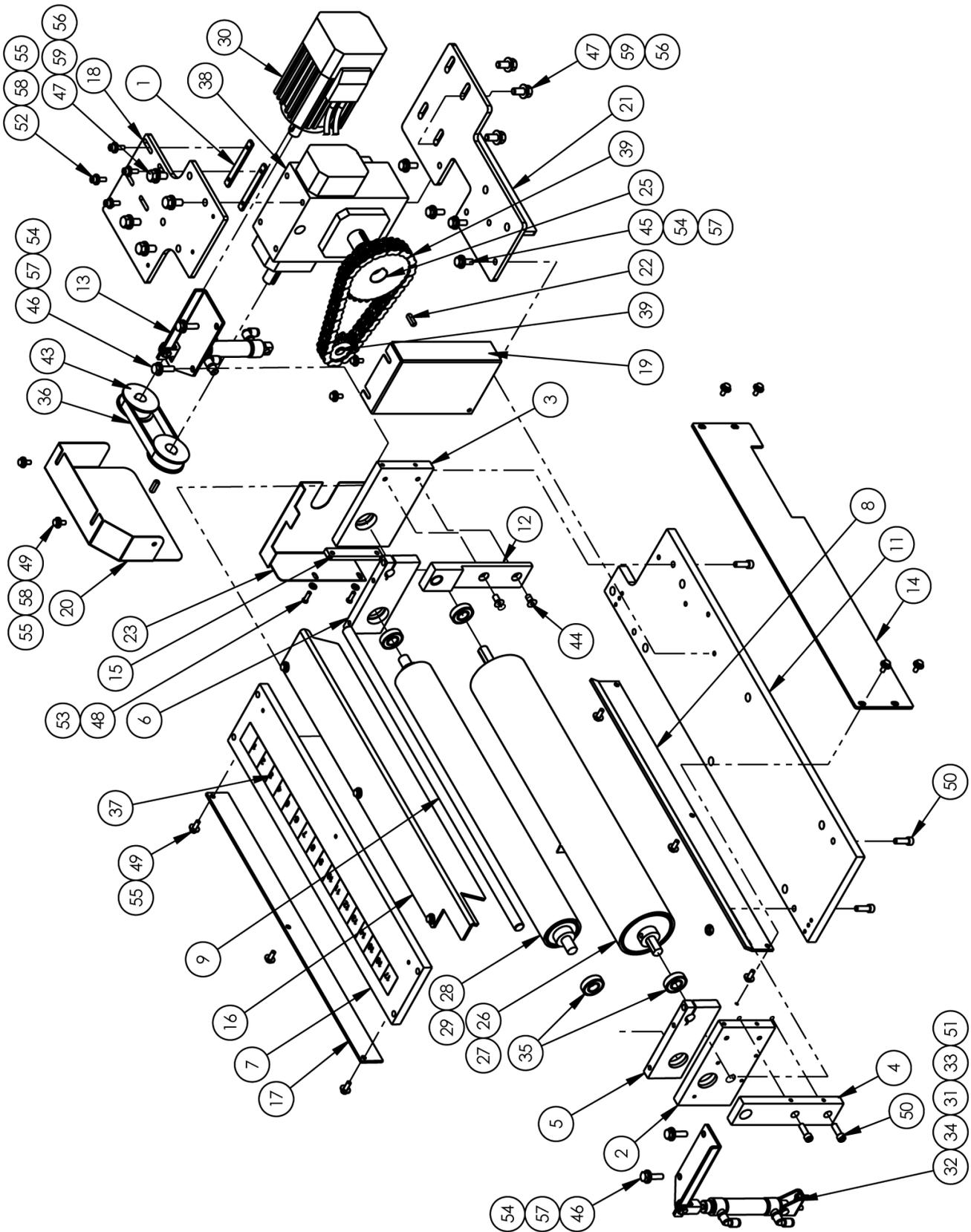


From the library of: Diamond Needle Corp

1961-900C Control Box Assembly

AAC Drawing Number 192937C Rev 4

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|-----|-----|------------|----------------|-----|-----|-------------|----------------------|
| 1 | 2 | 0211-703C | Cable | 33 | 1 | EEPMTS44 | E-Stop Button |
| 2 | 1 | 0211-705K | Treadle Cable | 34 | 7 | FF1724 | Strain Relief |
| 3 | 1 | 0411-1950C | Cable | 35 | 13 | FF264-341 | Dual Wago, Grey |
| 4 | 2 | 0411-1950D | Cable | 36 | 3 | FF264-347 | Dual Wago, Green |
| 5 | 1 | 1961-904A | Regulator Mnt | 37 | 4 | FF264-371 | Wago End |
| 6 | 3 | FFRK44T-4 | Cable | 38 | 1 | FF3120L420A | Circuit Breaker |
| 7 | 1 | 1961-912B | Control Panel | 39 | 1 | FF32958801 | AC/DC Adaptor |
| 8 | 1 | 1961-913A | Sub-Panel | 40 | 3 | FF34576Q | Toggle Switch |
| 9 | 1 | 1961-914A | Cable | 41 | 8 | FF67F4078 | Threaded Spacer |
| 10 | 4 | TT86085 | Quick Slide | 42 | 1 | FFD2425F | Relay |
| 11 | 1 | 1347D-LAB | Label | 43 | 1 | FF79998861 | Hour Meter |
| 12 | 1 | 31103701 | Gauge Brkt | 44 | 1 | FFRAV781BW | TVS Module |
| 13 | 1 | 4000D-02 | PC Board | 45 | 1 | MM4554K11 | Pipe Plug |
| 14 | 1 | 40-322 | Power Lockout | 46 | 1 | MM9280K33 | Grommet |
| 15 | 1 | 40-323 | Power Lockout | 47 | 2 | WWFS10 | Flat Washer |
| 16 | 1 | AA198-503 | Air Gauge | 48 | 16 | SSPP80016 | Screw, Pan Phillips |
| 17 | 1 | AA198-5102 | Regulator | 49 | 6 | TTC68302 | Quick Slide Terminal |
| 18 | 1 | AA198-RP3 | Regulator | 50 | 5 | SSPP90024 | Screw, Pan Phillips |
| 19 | 2 | AA2000F-03 | Flow Control | 51 | 2 | SSPP98024 | Screw, Pan Phillips |
| 20 | 1 | AAF10289 | Brass T | 52 | 7 | TT1825 | Quick Slide Terminal |
| 21 | 2 | MM4X641 | Rivet | 53 | 9 | TT1825-1 | Quick Slide Terminal |
| 22 | 1 | AAQMC-5-8 | Male Conn. | 54 | 1 | TT5811 | Terminal Ring |
| 23 | 2 | AAQME-4-8 | Male Elbow | 55 | 12' | EE18-4 | Cable |
| 24 | 2 | AAQUT-5-5 | Union "T" | 56 | 25' | FF19510 | Cable |
| 25 | 1 | AAV41V | Toggle Valve | 57 | 1 | 1961-909B | Cable |
| 26 | 4 | AAQME-5-8 | Male Elbow | 58 | 2 | 0211-702A | Cable |
| 27 | 2 | EE3X01 | Block, N.C. | 59 | 1 | 0211-705H | Cable |
| 28 | 3 | EE3X10 | Block, N.O. | 60 | 1 | 4059-EXT1 | Cable |
| 29 | 3 | EEA3L | Button Latch | 61 | 1 | 4059-EXT2 | Cable |
| 30 | 1 | EECA491024 | Mini Contactor | 62 | 1 | 1961-909A | Cable |
| 31 | 1 | EEPF3 | Green Button | 63 | AR | 1347D-WD | Wiring Diagram |
| 32 | 1 | EEPF4 | Red Button | | | | |



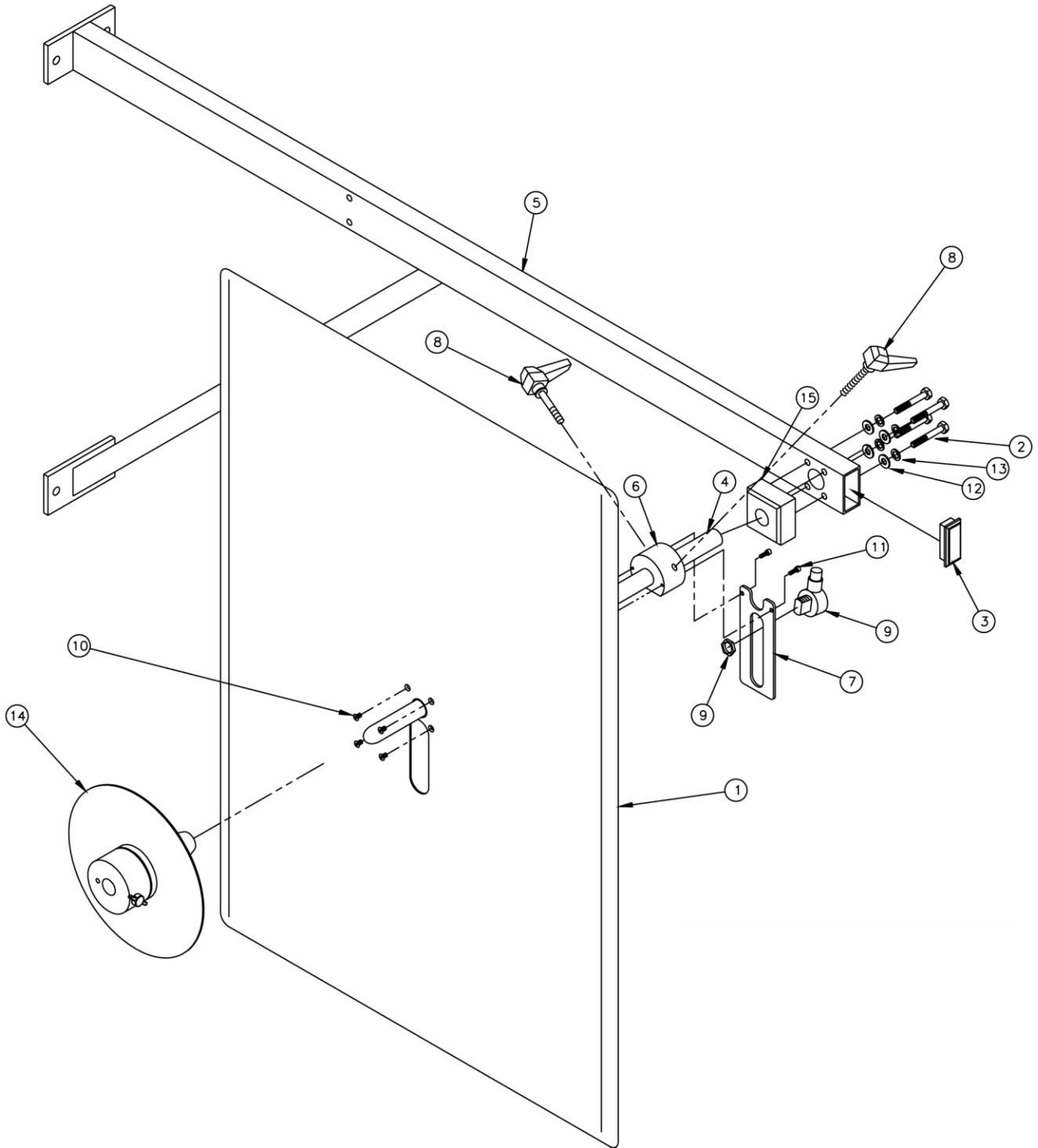
From the library of: Diamond Needle Corp

1961-300EB Worm Gear Puller Assembly, 18"

AAC Drawing Number 9000847 Rev 6

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|-----|-----|-------------|---------------------------|-----|-----|-------------------|----------------------------------|
| 1 | 2 | 0211-209 | PLATE,NUT,10-32@2.25 CTC | 31 | 2 | AAC7DP-1 | CYL.,AIR,DA 3/4 BORE,1STR |
| 2 | 1 | 1961-302 | LEFT SIDE PLATE | 32 | 2 | AAFBP-11C | BRKT,PIVOT,1/4 BORE |
| 3 | 1 | 1961-303 | PLATE,RIGHTSIDE,PULLER | 33 | 2 | AAFCT-7 | CLEVIS,AIR CYL, 1/4-28 |
| 4 | 1 | 1961-304 | HINGE PLATE,PULLER | 34 | 4 | AAQME-5-8 | QUICK MALE ELBOW |
| 5 | 1 | 1961-305 | TOP,LEFT SIDE,PULLER | 35 | 4 | BB1L005 | BEARING,BALL,,500D |
| 6 | 1 | 1961-306 | TOP,RIGHT SIDE,PULLER | 36 | 1 | GG124L050 | BELT, 3/8P,, 1/2W |
| 7 | 1 | 1961-307A | PLATE,TOP,PULLER | 37 | 1 | MM1910A22M | RULER,SILVER MYLAR 18" |
| 8 | 1 | 1961-309A | GUARD,ROLLER | 38 | 1 | MM20U1-30M1 | WORM, REDUCE,30:1,RH |
| 9 | 1 | 1961-311A | ROD,STRI AIGHT,CRS,1/2X21 | 39 | 1 | MMD35 (18.75" LG) | CHAIN,STEEL, DBL #35-2 X 32IN LG |
| 10 | 1 | 1961-312A | BRKT,LIFT,LEFT | 40 | 1 | MMD35CL | MASTER LINK,DBL,#35 CHAIN |
| 11 | 1 | 1961-313A | PLATE,BASE,PULLER | 41 | 2 | NNJ1/4-28 | NUT, HEX, JAM, 1/4-28 |
| 12 | 1 | 1961-314 | HINGE PLATE, WORM PULLER | 42 | 1 | PP14LF050M1 | PULLEY, 3/8P, 14T, 5/8B |
| 13 | 1 | 1961-315A | BRKT,LIFT | 43 | 1 | PP14LF050M2 | PULLEY, 3/8P, 14T, 14MM B |
| 14 | 1 | 1961-316A | GUARD,BOTTOM | 44 | 2 | SSFC01032 | 1/4-20 X 1/2 FLAT ALN CAP |
| 15 | 1 | 1961-323 | SPACER, ALUM, 1/4 | 45 | 4 | SSHC01048 | 1/4-20 X 3/4 HEX CAP |
| 16 | 1 | 1961-363A | GUARD, TOP | 46 | 4 | SSHC01064 | 1/4-20 X 1 HHCS |
| 17 | 1 | 1961-371A | GUARD,ROLLER | 47 | 8 | SSHC10048 | 5/16-18 X 3/4 HHCS |
| 18 | 1 | 1961022 | MTG. PLT, EFKA MOTOR | 48 | 2 | SSHC90032 | #8-32 X 1/2 HEX CAP |
| 19 | 1 | 1961024 | GUARD, WORM DRIVE | 49 | 17 | SSHC98032 | 10-32X1/2 HEX HD |
| 20 | 1 | 1961025 | GUARD, EFKA MOTOR | 50 | 6 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 21 | 1 | 1961027 | PLATE,MNT,WORM DRIVE | 51 | 4 | SSSC98032 | 10-32X1/2, SOC CAP |
| 22 | 2 | 1961028 | KEY, 3/16 SQ X 11/16 LG | 52 | 4 | SSSC98040 | 10-32 X 5/8 SOC CAP |
| 23 | 1 | 1961058 | COVER, ROLLER DRIVE BELT | 53 | 2 | WWF8 | WASHER, FLAT, #8 |
| 24 | 1 | 1961100 | SPROCKET, 12T, 35, DBL, M | 54 | 8 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 25 | 1 | 1961101 | SPROCKET, 30T, 35, DBL, | 55 | 21 | WWFS10 | WASHER, FLAT, #10, SAE |
| 26 | 1 | 33005603D4 | ROLLER,DRIVE,18" CAP | 56 | 8 | WWFS5/16 | WASHER,FLAT,SAE,5/16 |
| 27 | 1 | 33005603D5 | SHAFT,PREFEED DRIVE,18" | 57 | 8 | WWL1/4 | WASHER,LOCK,1/4 |
| 28 | 1 | 33005652D4 | ROLLER,IDLER,18" CAP | 58 | 15 | WWL10 | WASHER,LOCK,#10 |
| 29 | 1 | 33005652D5 | SHAFT,PREFEED IDLER,18" | 59 | 8 | WWL5/16 | WASHER, LOCK, 5/16 |
| 30 | 1 | 4059-DC1500 | MOTOR & CONTROLLER | | | | |

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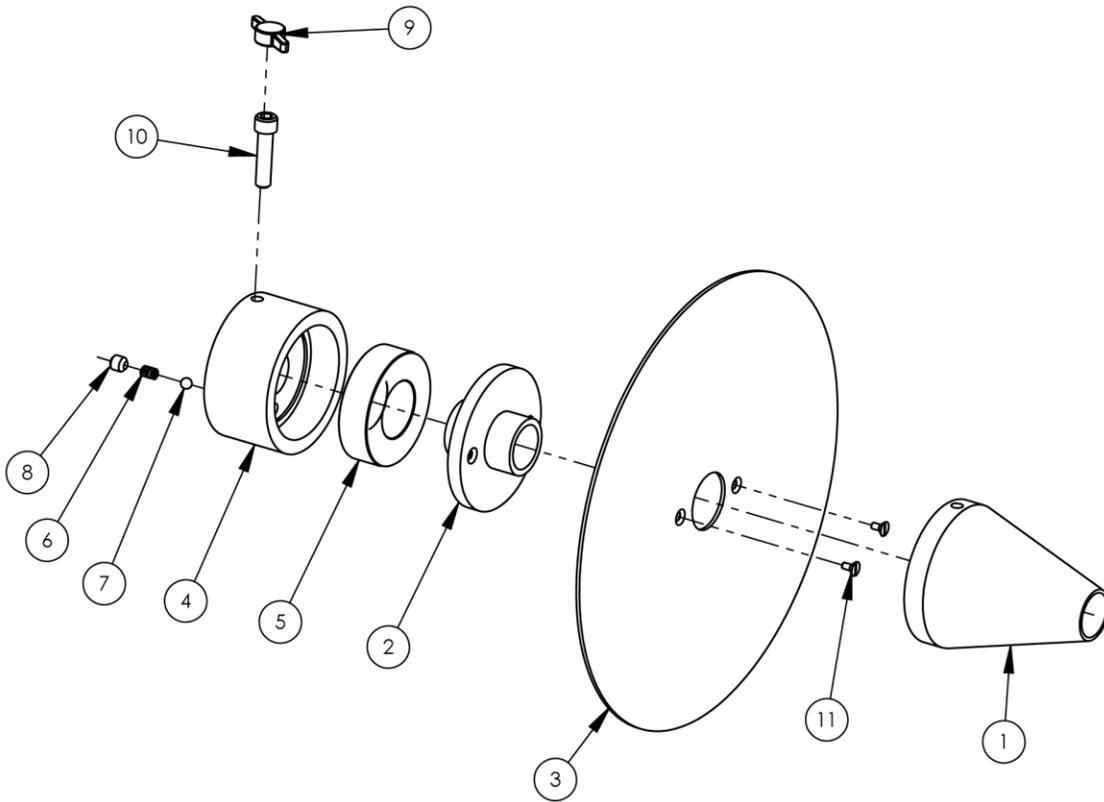


1961-250F Prefeed Assembly

AAC Drawing Number 192944C Rev 4

| NO. | QTY | PART # | DESCRIPTION |
|-----|-----|-------------|---------------------|
| 1 | 1 | 784B-2436 | Alum Plate, 24 x 34 |
| 2 | 1 | SSHC25064 | Screw, Hex Cap |
| 3 | 1 | MM132-1496 | End Cap |
| 4 | 1 | 1961-252D | Roll Rod |
| 5 | 1 | 1961-256 | Spin Holder Frame |
| 6 | 1 | 1961-253A | Hub |
| 7 | 1 | 1961-255 | Sensor Mount Brkt |
| 8 | 2 | TTH32416 | Threaded Handle |
| 9 | 1 | FFT18FF100Q | Electric Eye |
| 10 | 4 | SSFC80016 | Screw, Flat Allen |
| 11 | 2 | SSSC80016 | Screw, Socket Cap |
| 12 | 1 | WWFS3/8 | Flat Washer |
| 13 | 1 | WWL3/8 | Lock Washer |
| 14 | 1 | 33008708 | Disc Assy |
| 15 | 1 | 1961-251C | Unwind Shaft Hub |

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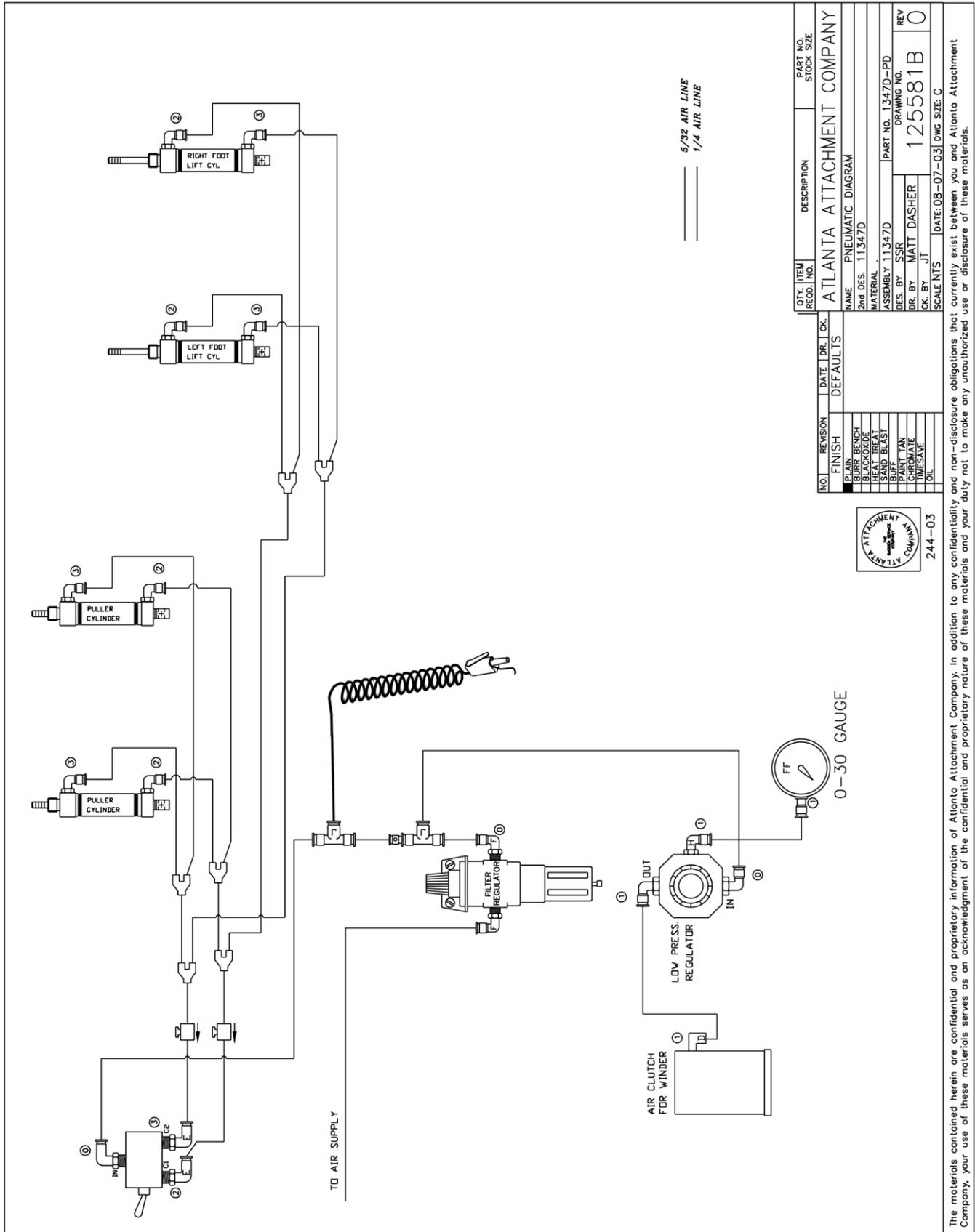
33008708 Ball Bearing Disc Assembly

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 |

1347D-PD Pneumatic Diagram



| QTY. | ITEM | RECD. NO. | DESCRIPTION | PART NO. | STOCK SIZE |
|------|------|-----------|----------------------------|----------|-----------------------------|
| | | | ATLANTA ATTACHMENT COMPANY | | |
| | | | NAME PNEUMATIC DIAGRAM | | |
| | | | 2nd DES. 11347D | | |
| | | | MATERIAL | | |
| | | | ASSEMBLY 11347D | | PART NO. 1347D-PD |
| | | | DES. BY SSR | | DRAWING NO. |
| | | | DR. BY MATT DASHER | | REV 0 |
| | | | CK. BY JT | | |
| | | | SCALE NTS | | DATE: 08-07-03 DWG. SIZE: C |

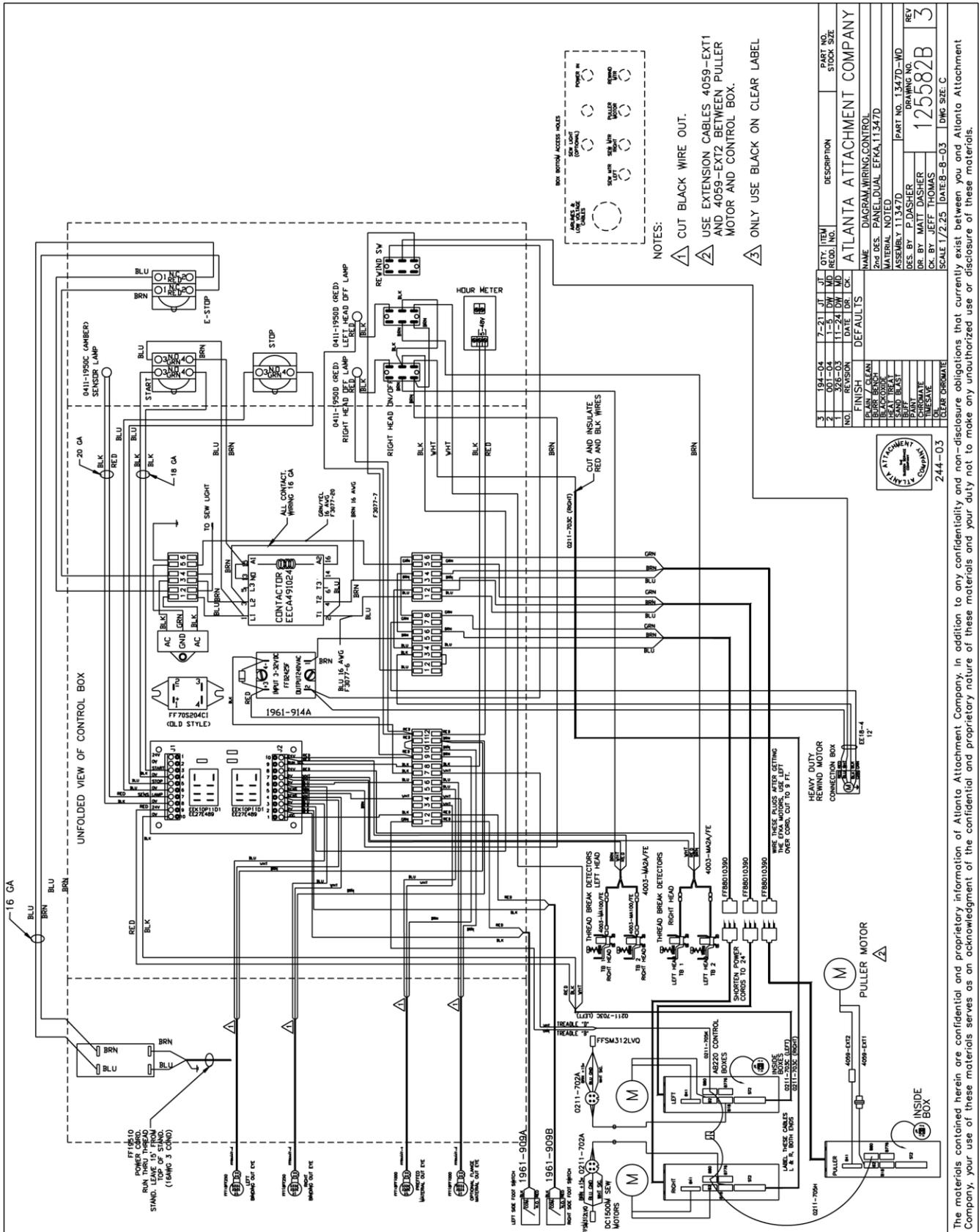
| NO. | REVISION | DATE | DR. | CHK. |
|-----|-------------|------|-----|------|
| | FINISH | | | |
| | BY | | | |
| | BENCH | | | |
| | BLACK OXIDE | | | |
| | HEAT TREAT | | | |
| | SAND BLAST | | | |
| | PAINT | | | |
| | CHROME | | | |
| | ANNEAL | | | |
| | DRILL | | | |



244-03

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1347D-WD Control 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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