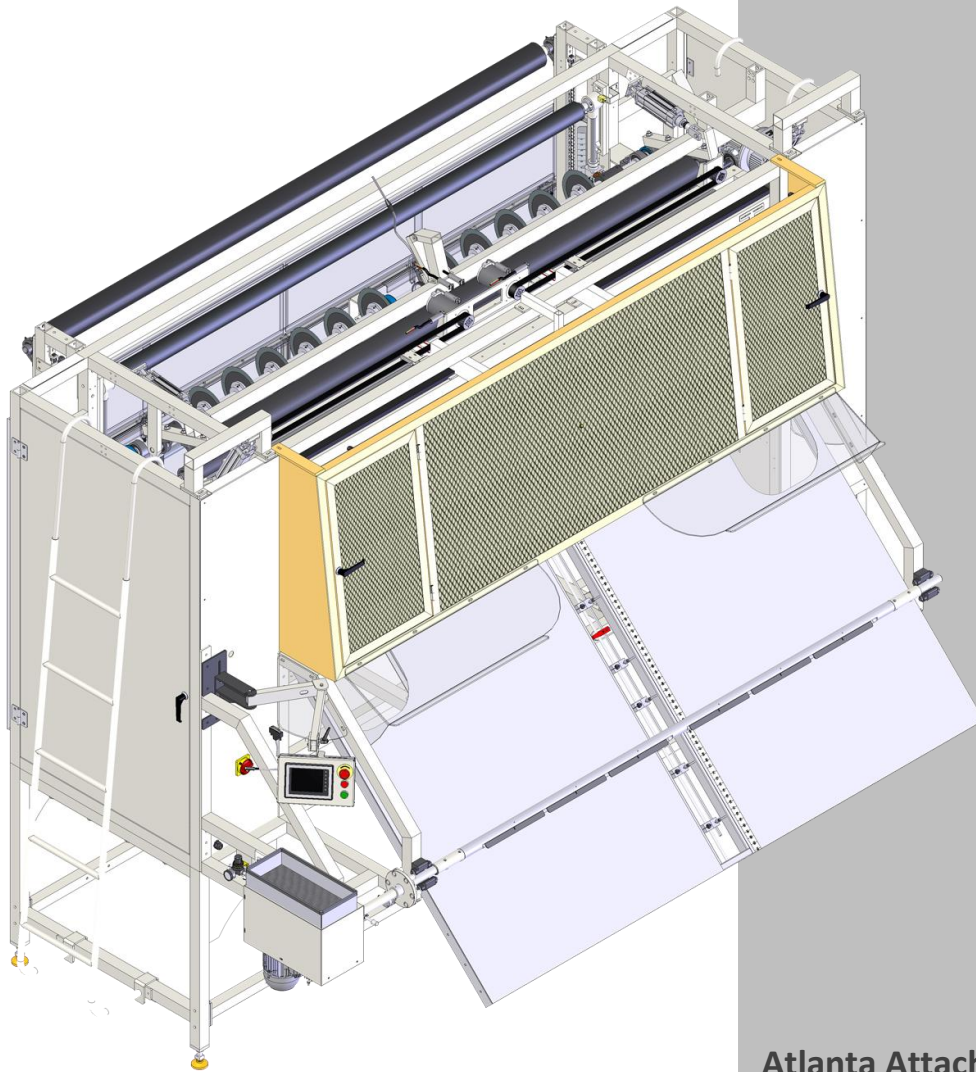




model **1393E**

Revision 1.1 Updated Feb 4, 2013

Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

Atlanta Attachment Company

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Lawrenceville, GA 30046

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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.

Contents

Important Safety Instruction	1
Liability	2
Safety Equipment on the Machines	3
Protective Eyewear	4
Important Notices.....	5
Maintenance	7
Repair	8
A Word to the End User.....	9
Safety Precautions.....	9
1.- INSTALLATION MANUAL.....	10
1.1.- Parts and Components	10
1.2.- Technical Data	11
1.3.- Installation & Set Up	12
2.- OPERATION MANUAL	13
2.1 Individual components.....	13
a.- Main Power	13
b.- Emergency Stop.....	13
c.- Touch Screen / Control	13
d.- Table Lift Operation.	14
e.- Panel Width Sensors	14
2.2.- Touch Screen	15
Main Menu.....	15
2.2.1 Edge Blade Setup & Adjustment Procedure	16
a.- Panel Cut Mode	18
b.- Border Cut Mode.....	23
c.- Position Trim Blades	27
d.- Maintenance Menu	30
e.- Panel Cut Batch	33
g.- Select Cut length.....	37
h.- Sharpen Blades	38
i.- Timer settings menu	39
j.- Control Power Start	40
k.- POWER OFF / POWER ON.....	40
l.- Control power off	40
m.- Load Material in feed roller.....	40
2.3.- Operating	41

c.- Panel Cutting.....	42
d.- Border Cutting	42
2.4.- Maintenance.....	43
a.- Daily.....	43
b.- Weekly.....	43
c.- Monthly.....	43
3.- SERVICE MANUAL	44
1.- Pneumatic	44
1393E Panel Cutter Spare Parts Kit	45
XCut Drive Motor Parameters Menu (INV1).....	47
Infeed Drive Motor Parameters Menu (INV2)	50
Assembly Drawings & Parts Lists	53
11393E Panel Cutter/Slitter	55
1388232 Sub Frame Assembly	58
1388276 Slitter Motor Drive Assembly.....	59
1388317 Top Roller Assembly	60
1388331 Infeed Roll Drive Assembly	61
1388333 Border lift Roll Assembly	62
1388337 Outfeed Motor Drive Assembly.....	63
1388347 Xcut Clamp Assembly	64
1389060 Exit Roller Assembly.....	65
1388572 Dancer Assembly	67
1389078 X cut Material Sensor	68
1393029 Slitter Sharpener Assembly.....	69
1388303 Back Panel Electrical Assembly	71
1388415 Swivel Arm Assembly	73
1389747 Touchscreen Cable Assembly.....	74
1388559 Door Stopper/Bumper Assembly.....	75
1388594 Electric Bottom Panel Assembly	76
1389229 Molex Manifold	77
1388650 Pneumatic Panel Assembly.....	79
1388664 Cross Cut Assembly.....	81
1389245 Winder Assembly.....	83
MMRV0501-30 Worm Gearbox and Motor.....	84
1389860 Split Shaft Slitter Assembly.....	85
1393149 Slitter Assembly.....	86
1389896 Slitter Sharpener Assembly.....	87

Technical Manual & Parts Lists

1393-KIT06 Weighted Slitter Bar Assembly	88
1393310 Table Stop Assembly	89
1393312 Lock Pin Valve Assembly	90
1393360 Table Pivot Assembly	91
1393676 Encoder Assembly	92
1389884 Slitters Sharpener Assembly	93
1389794 Encoder Cable Assembly	94
1393E-PD1 Pneumatic Diagram.....	96
1393E-WD1 Wiring Diagram.....	97
1393E-WD2 Wiring Diagram.....	98
1393E-WD3 Wiring Diagram.....	99
1393E-WD4 Wiring Diagram.....	100
1393E-WD5 Wiring Diagram.....	101
1393E-WD6 Wiring Diagram.....	102
1393E-WD7 Wiring Diagram.....	103
1393E-WD8 Wiring Diagram.....	104
1393E-WD9 Wiring Diagram.....	105
1393E-WD10 Wiring Diagram 1 of 12	106
1393E-WD10 Wiring Diagram 2 of 12	107
1393E-WD10 Wiring Diagram 3 of 12	108
1393E-WD10 Wiring Diagram 4 of 12	109
1393E-WD10 Wiring Diagram 5 of 12	110
1393E-WD10 Wiring Diagram 6 of 12	111
1393E-WD10 Wiring Diagram 7 of 12	112
1393E-WD10 Wiring Diagram 8 of 12	113
1393E-WD10 Wiring Diagram 9 of 12	114
1393E-WD10 Wiring Diagram 10 of 12	115
1393E-WD10 Wiring Diagram 11 of 12	116
1393E-WD10 Wiring Diagram 12 of 12	117

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 1393E Autopack 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.

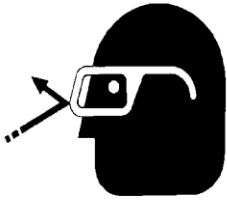
Signs on the Machine

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.

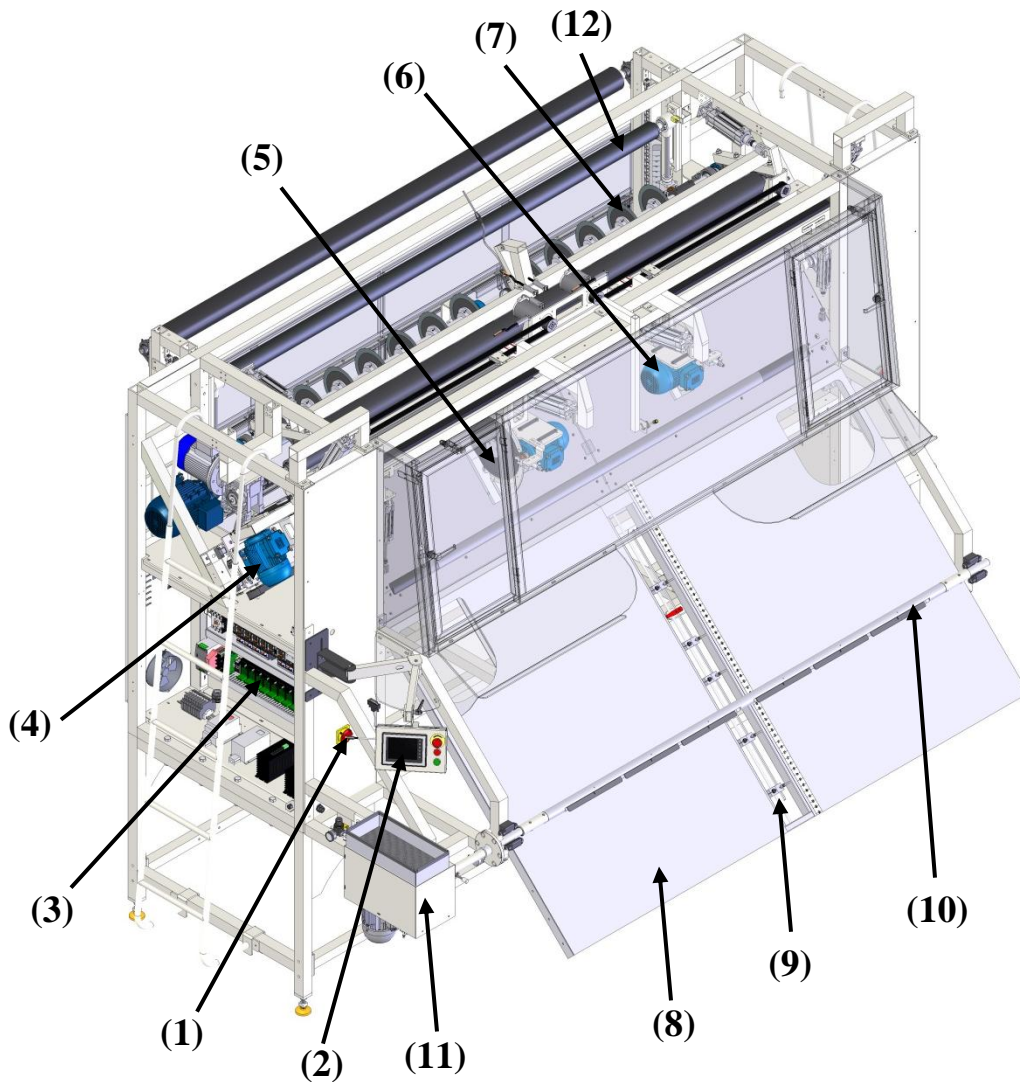
- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS operate equipment in daylight or with adequate working lights.
- Follow daily and weekly checklists, making sure hoses are tightly secured and bolts are tightened.
- ALWAYS watch and avoid holes or deep depressions.
- ALWAYS 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.

1.- INSTALLATION MANUAL



It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating.

1.1.- Parts and Components



- 1.- Main Power
- 2.- Touch Screen
- 3.- Control Panel
- 4.- Cross cut

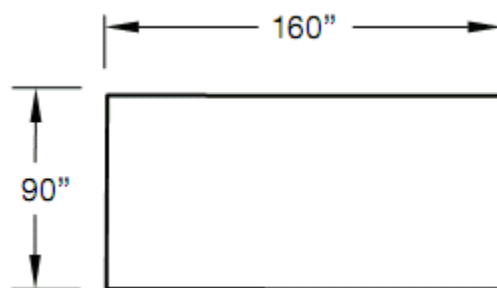
- 5.- Right Edge cut
- 6.- Left Edge cut
- 7.- Slitter knife
- 8.- Panel Table

- 9.- Width Sensors
- 10.- Drive Rod
- 11.- Winder
- 12.- Border Roll

1.2.- Technical Data

SPECIFICATIONS	
Max cutting thickness (inch)	1 1/2" (Compressed)
Min cutting thickness (inch)	1/4"
Max cutting width (inch)	102
Min cutting width (inch)	47 3/4
Max length (inch)	84
Min length (inch)	28 1/2
Voltage (v/ph/hz)	220V 3PH 50/60HZ
Current (amps)	20
Air pressure (psi)	80
Air consumption (cfm)	3
Shipping Weight (lbs)	5200
Shipping Dimensions (w/l/h, Inch)	144 x 65 x 78

PRODUCTION	
Output speed (Ft/Min.)	45



Foot Print

1.3.- Installation & Set Up



It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating

- 1.- Unpack the machine frame and install it with help of crane and forklift.
- 2.- Remove any shipping straps from machine.
- 3.- Inspect the machine for any damage that may have occurred during shipping. If damage is found, report this immediately to your supervisor. Document the damage and provide details and photographs.
- 4.- Install the rollers onto the frame and be sure they can rotate freely.
- 5.- Install the back safety guard onto the frame.
- 6.- Adjoin the inner and outer board and install onto the frame, adjust them to in one plane.
- 7.- Install the front safety guard shield onto the frame.
- 8.- Install the left and right protective shield onto the frame.
- 9.- Adjust all rollers to be sure the midlines of them are parallel.
- 10.- Connect power source and compressed air.



11.- Provide a 220VAC, Three phase, 20 Amp



12.- Provide 3/8" air supply line (90 PSI).

2.- OPERATION MANUAL

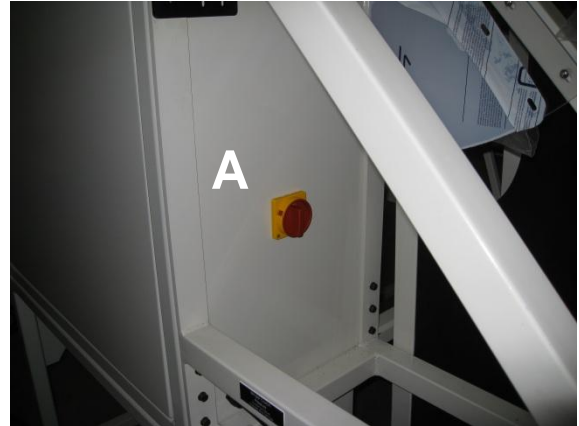


It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating

2.1 Individual components

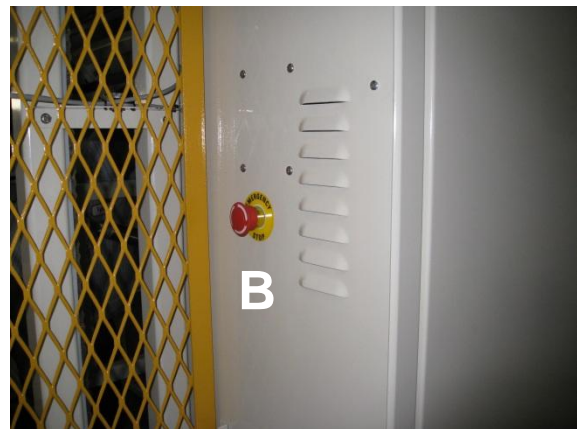
a.- Main Power

It is located below the touch screen panel. Is the main power switch ¼ turn to the right will supply power to the machine. This switch has provision to lockout the power when performing maintenance.



b.- Emergency Stop

There are red push buttons located in 4 places around the machine. After pushing it the machine will be disconnected from the energy source. You will need to turn the knob 1/8 revolution before reactivating the power



c.- Touch Screen / Control

1.- Emergency Stop - This button serves the same function as the other 3 red “E-Stop” push buttons located on each of the four corners of the machine.

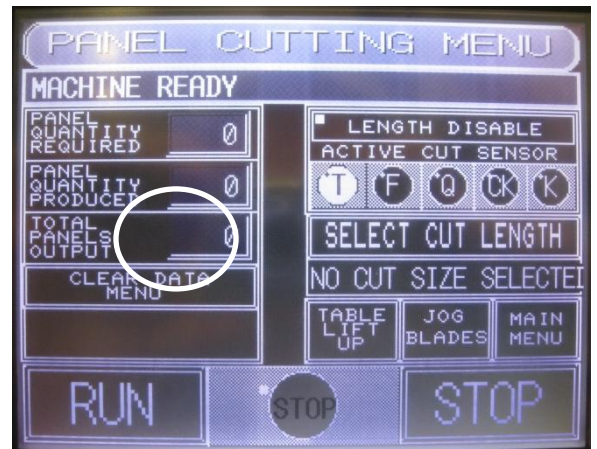
2.- Power Off – Push off button for turning off power to the control panel and the machine.

3.- Power On – Activates main power to the control panel and machine (not control power)



d.- Table Lift Operation.

This allows the operator to select the position of the out-feed table. If “Table Lift Up” is selected, the table will lift and lock in place for cutting panels. If “Table Lift Down” is selected, the table will lower to allow the windup roller to be used to wind up material. This option is available on 3 different menu screens. (Panel Mode, Border Mode, & Maint. Menus)



e.- Panel Width Sensors

These sensors are what determine the width of the panel being cut. The top sensor is for Twins, the 2nd for Fulls, The 3rd for Queens, The 4th for Cal Kings, and the bottom for Kings. These sensors are only active when in the Panel mode with the table in the UP position. The scale next to the sensors is the actual width of the panel being cut. When switching to a different thickness of panel the widths can be adjusted by moving the lever at the right of the table.



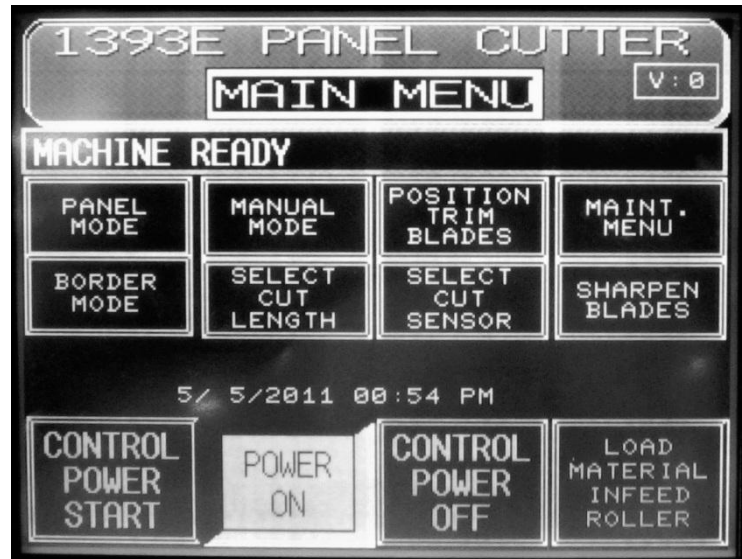
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2.2.- Touch Screen

Main Menu

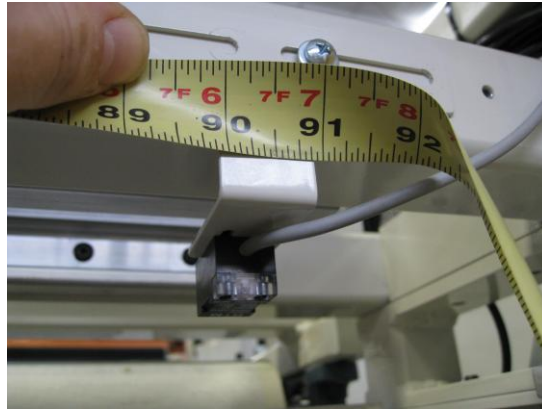
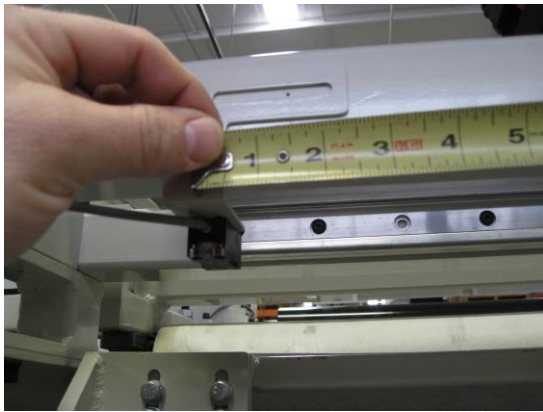
This menu is displayed at the startup of the machine. Press any of the frames in the screen and you will be transfer to the following sub-menu

- PANEL MODE
- BORDER MODE
- MANUAL MODE
- SELECT CUT LENGTH
- POSITION TRIM BLADES
- SELECT CUT SENSOR
- MAINTENANCE MENU
- SHARPEN BLADES
- CONTROL POWER START
- POWER ON/OFF INDICATOR
- CONTROL POWER OFF
- LOAD MATERIAL IN FEED ROLLER



2.2.1 Edge Blade Setup & Adjustment Procedure

- 1) Set the center distance between the LEFT and RIGHT edge trim blade home position proximity switches to 90.5" (2300mm)



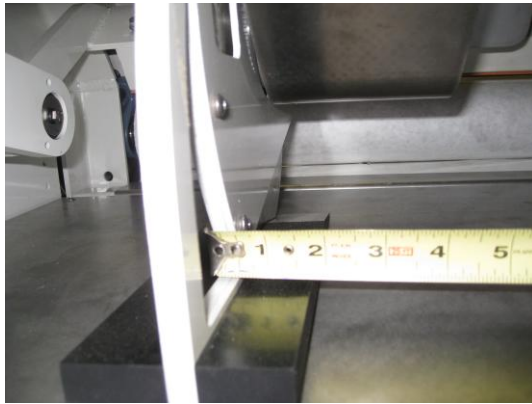
- 2) On the touchscreen menu.....Select Blade Position. Set a Left Offset value to 5.00" (127mm) and Cut Length value to 85.00" (2159mm).



- 3) Press the Blade Position button. As soon as the edge trim blades are at the LEFT and RIGHT home position proximity switches press the E-Stop button. YOU WILL HAVE ONLY A FEW SECONDS TO HIT THE E-STOP. If the trim blades come off the proximity switches, then retry again.



- 4) Assuming Step 3 was completed correctly, measure the center distance (blade to blade) between the blades. It should measure 90.5" (2300mm).



- 5) If the distance between the blades is not 90.5" (2300mm) recheck the center distance between the home left and right home position proximity switches. Move the proximity target / flag on each edge trim blade in the direction needed to get 90.5" (2300mm) and repeat Steps 3 & 5 until the distance between the blades measure 90.5" (2300mm).

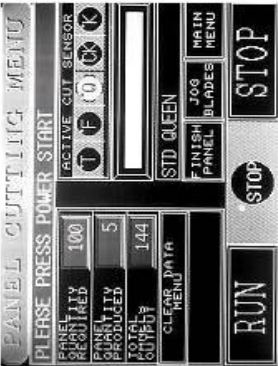


- 6) Once Step 5 is completed, return to the Blade Position menu and confirm your settings from Step 2 are still 5.00" (127mm) and 85.0" (2159mm). If these values have changed please reset to 5.00" (127mm) and 85.0" (2300mm).
- 7) Press the Blade Position button and measure the distance between the blades to confirm a cut length of 85.0" (2159mm). If they are off, adjust the edge trim proximity target / flag and repeat Step 7 again.

a.- Panel Cut Mode

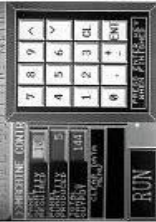
Only on machine with Batch Mode Function

1.- [PANEL QUANTITY REQUIRED] For the selection of the amount of panel you will need




a.- [PANEL CUTTING MENU].


2.- [PANEL QUANTITY PRODUCED] Number panels ALREADY produce




3.- [TOTAL PANELS OUTPUT]




4.- [CLEAR DATA MENU] To erase the data on the 3 top screens.




5.- [ACTIVE CUT SENSOR] Refer to the sensors locate on the cutting table. The highlight filed is the active one. [T]:Twin [F]: Full [Q]: Queen [K]: California King [K] King




6.- [PANEL CUT LENGTH]




7.- [FINISH PANEL]




8.- [JOG BLADES]



9.- [MAIN MENU] Return to main menu



After pressing any of the number fields you will get a key board were you can set the value required. Press enter key when finish with the value.



[CLEAR PANEL QTY PRODUCE]

[CLEAR TOTAL PANEL OUTPUT]

[PREV MENU]

6.1 [CHANGE CUT SIZE SETTINGS] after pressing this field the screen STANDARD PANEL CUT SIZES is show. You will get all the actual dimensions the panels' sizes

	TWIN	KING	QUEEN	CALIFORNIA KING
WIDTH	39.00	39.00	55.00	55.00
LENGTH	76.00	81.00	76.00	81.00
WIDTH	61.00	71.00	84.00	84.00
LENGTH	81.00	81.00	81.00	72.00


6.2 [CANCEL SIZE CHANGE]. return to the original values

6.3 [ACCEPT SIZE CHANGE]. record any change made on dimensions

NOTE

TO MAKE THIS CUT LENGTH CHANGE, YOU MUST PLACE THE BLADE POSITION SENSOR SWITCH FROM 'OFF' TO 'POSITION'.

6.1.1.- To change dimensions, press on top of the number and modify the values.



6.1.2.- [EDIT PUSLH SETTINGS] to change the rest of the sizes.

6.1.3.- [EDIT PILLOW TOP SETTINGS] to change the rest of the sizes.

6.1.4.- [RETURN TO CUT LENGTH MENU] to exit the

Starting at Main Menu

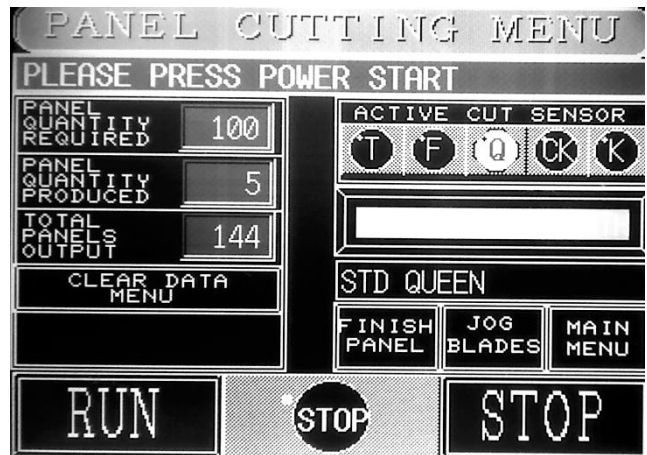
- Select **PANEL CUT MODE** from the Main Menu screen
- You will get a NOTE Screen
- Manually change the position of the Selector to PANEL
- Press **CONTINUE TO PANEL MODE**



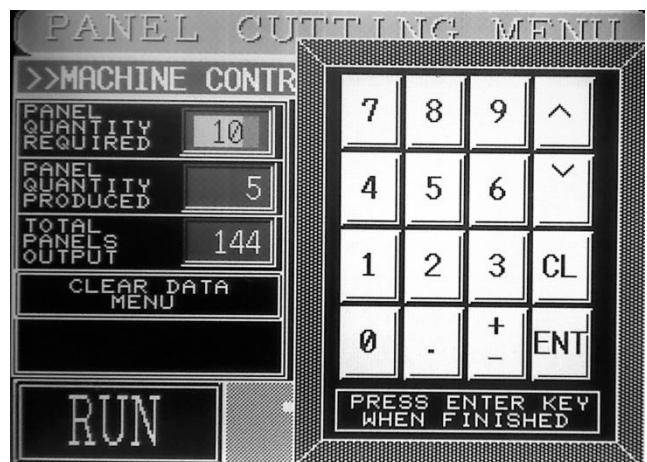
PANEL CUTTING MENU:

1.- PANEL QUANTITY REQUIRED

Enter the number of panels to cut. Machine will stop automatically when that number is reached.



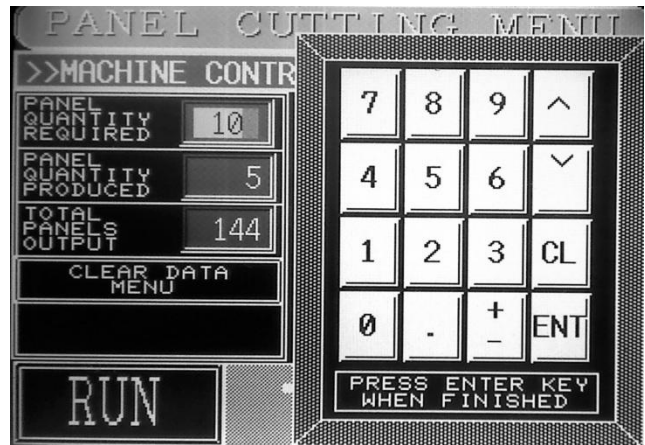
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



2.- PANEL QUANTITY PRODUCED

The number of panels ALREADY produced since that number was last cleared.

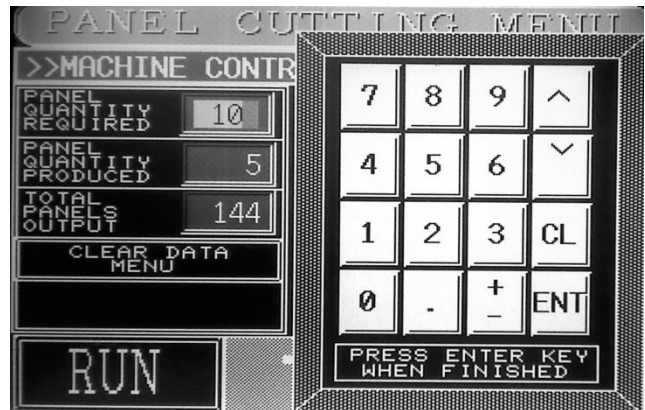
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



3. TOTAL PANELS OUTPUT

The number of panels produced since the total output number was last cleared.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.

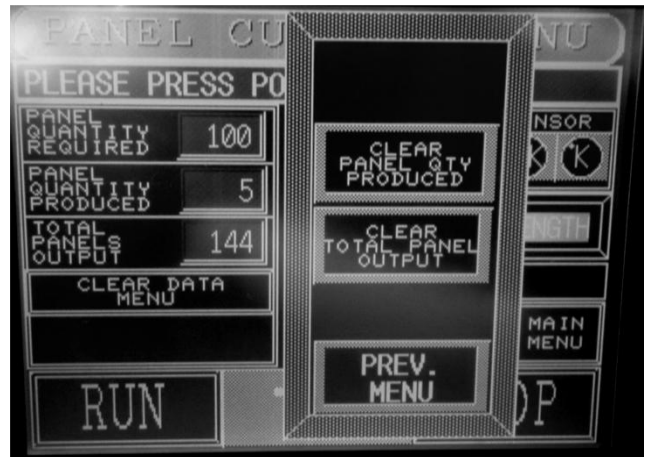


4. CLEAR DATA MENU

To erase the data on the 3 top screens.

You will get 3 options:

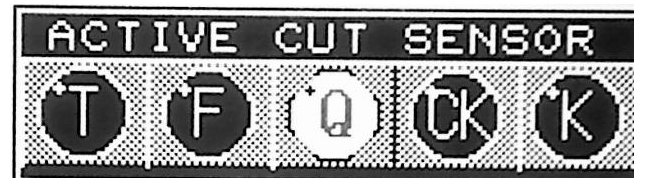
- CLEAR PANEL QTY PRODUCED
- CLEAR TOTAL PANEL OUTPUT
- PREV MENU



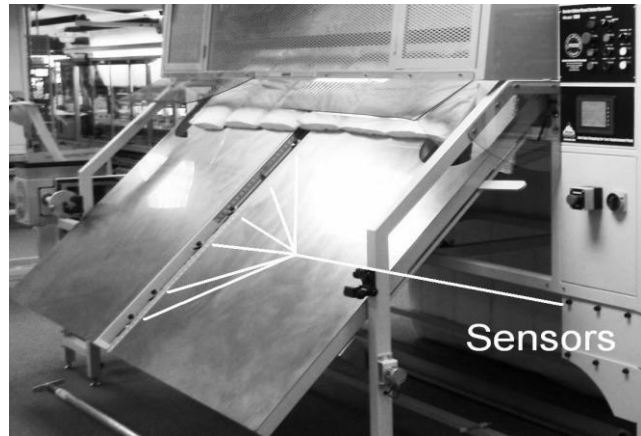
5. ACTIVE CUT SENSOR

Refers to the sensors located on the cutting table. The highlighted field is the active one.

[T]: Twin [F]: Full [Q]: Queen [CK]: California King [K] King



Location of the sensors on the panel table.



After pressing the blank space you will get the

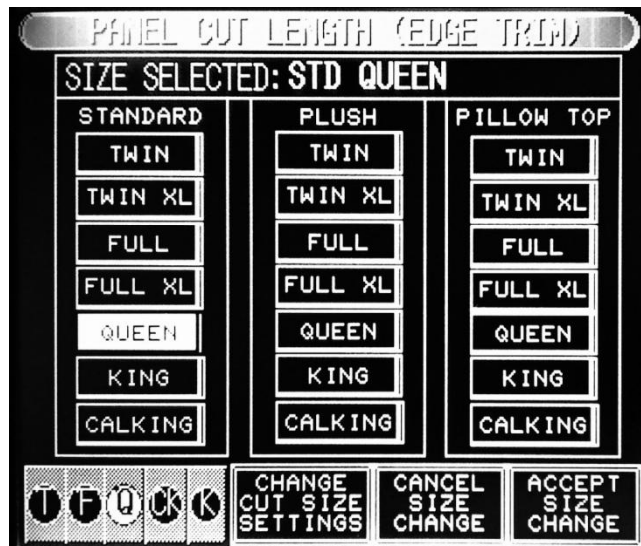


6. PANEL CUT LENGTH screen

This screen is divided in 3 main columns.

- STANDARD for normal thickness.
- PLUSH for thick panels.
- PILLOW TOP for extra thick panels.

The highlighted fields are the ones active as this time.

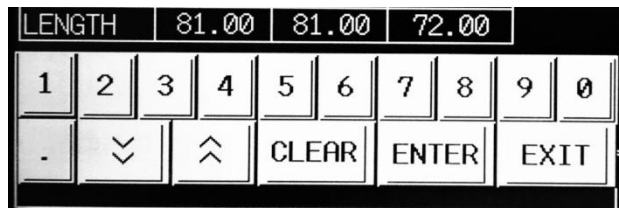


6.1 CHANGE CUT SIZE SETTINGS after pressing this field the screen STANDARD PANEL CUT SIZES is shown. You will get all the actual dimensions of the panels' cut sizes.

	Twin	Twin XL	Full	Full XL
WIDTH	39.00	39.00	55.00	55.00
LENGTH	76.00	81.00	76.00	81.00
	Queen	King	Calking	
WIDTH	61.00	77.00	84.00	
LENGTH	81.00	81.00	72.00	

EDIT PLUSH SETTINGS	EDIT PILLOW TOP SETTINGS	RETURN TO CUT LENGTH MENU
---------------------	--------------------------	---------------------------

6.1.1- To change dimensions, press on top of the number and modify the values



6.1.2- **EDIT PLUSH SETTINGS** to change the rest of the sizes.

6.1.3- **EDIT PILLOW TOP SETTINGS** to change the rest of the sizes.

6.1.4.- **RETURN TO CUT LENGTH MENU** to exit the screen

6.2 **CANCEL SIZE CHANGE** return to the original values.

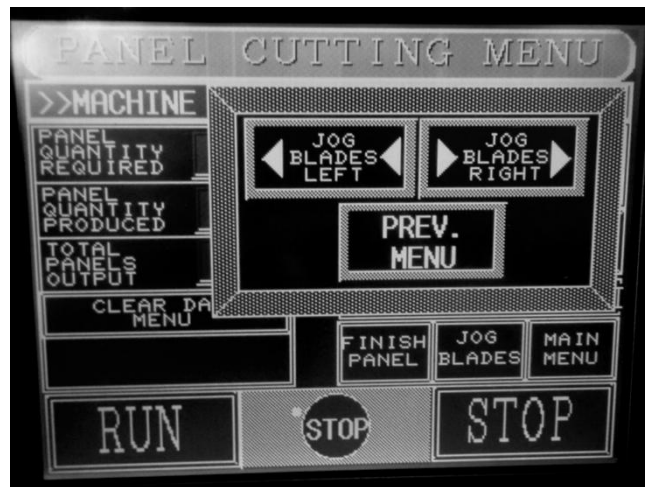
6.3 **ACCEPT SIZE CHANGE** record any change made on dimensions



7.- **FINISH PANEL** allows operator to finish the panel that is presently in the machine.

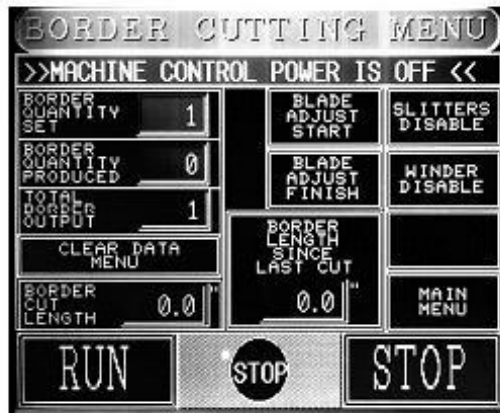
8.- **JOG BLADE** allows the operator to jog both side trim blades equally in either direction to allow for shifting of the quilted material without changing the dimension.

9.- **MAIN MENU** Return to main menu



b.- Border Cut Mode

b.- [BORDER CUT MODE]



1.- [BORDER QUANTITY SET]
pressing the number field you will get a keyboard were you can change the numbers of pieces to be produce



2.- [BORDER QUANTITY PRODUCE]



3.- [TOTAL BORDER OUTPUT]



4.- [CLEAR DATA MENU]
Reset the [BORDER QUANTITY PRODUCE]



5.- [BORDER CUT LENGTH]



6.- [TOTAL BORDER OUTPUT]

7.- [BLADE ADJUST START]

Blink

8.- [BLADE ADJUST FINISH]

9.- [SLITTERS DISABLE]

Blink

10.- [WINDER DISABLE]

Blink

11.- [BORDER LENGTH SINCE LAST CUT]

N/S

12- [MAIN MENU] Return to Main Menu

13.- [RUN]

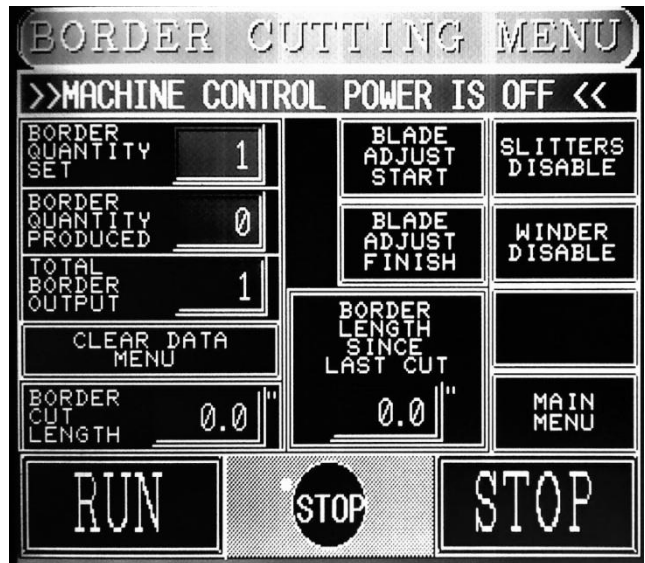
14.- [STOP]

Starting at Main Menu

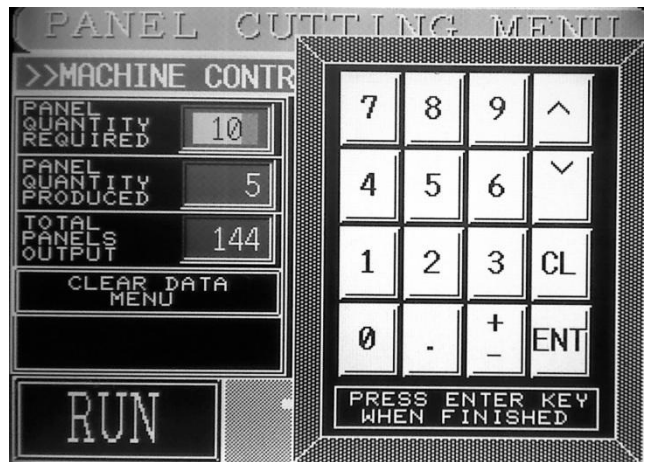
- Select **BORDER CUT MODE** from the Main Menu screen
- You will get a NOTE Screen
- Manually change the position of the Selector to BORDER
- Press **CONTINUE TO BORDER MODE**



After pressing **BORDER CUT MODE** from the MAIN MENU you will arrive to the **BORDER CUTTING MENU**



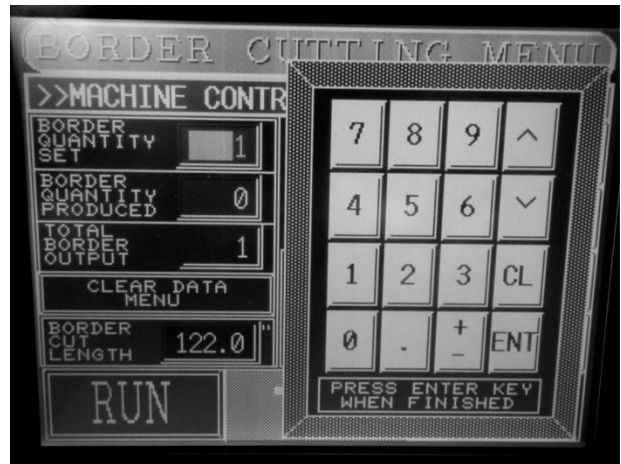
1. - **BORDER QUANTITY SET** pressing the number field you will get a keyboard were you can change the numbers of pieces to be produced. It is important to note that the machine will do a cross cut at the desired length of border. To deactivate the measuring function set the quantity to zero.



2.- BORDER QUANTITY PRODUCED

This is the number of preselected border lengths produced since this value was last cleared.

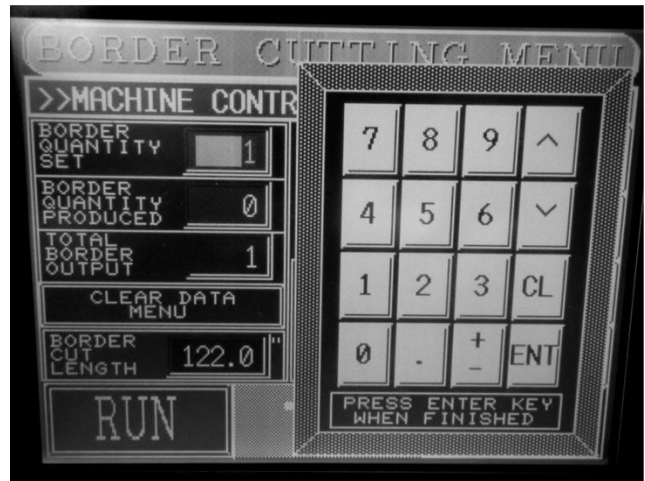
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



3.- TOTAL BORDER OUTPUT

This is the total number of border lengths produced since this value was last cleared.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.

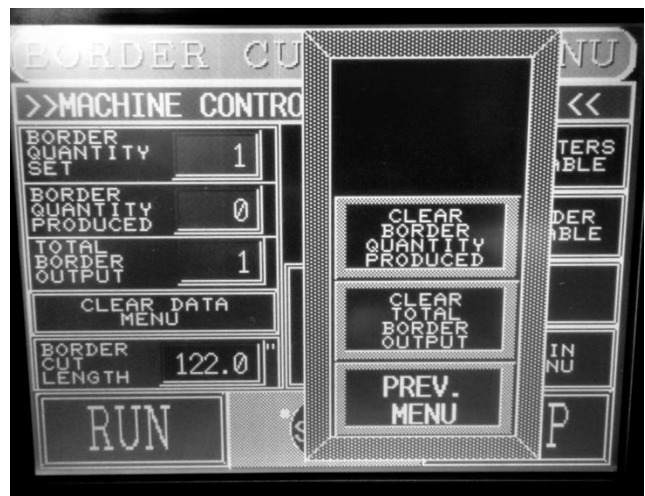


4.- CLEAR DATA MENU

To erase the data on the 3 top screens.

You will get 3 options:

- CLEAR BORDER QTY PRODUCED
- CLEAR TOTAL BORDER OUTPUT.
- PREV. MENU



5.- BORDER CUT LENGTH

This is to set the length of border to be produced. When this length is reached the border will be cross cut. The units are in inches.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



6.- BLADE ADJUST START

When you press this button it will start blinking and the slitters will disable and the material will feed forward until the dancer bar reaches the upper sensor. At this position the operator will have access via the front access doors to reposition the slitter blades as desired. Note: When the access doors are opened the power will automatically shut off to the motors to prevent any possibility of the power being inadvertently turned on to the slitters while the operator is making adjustments.

7.- BLADE ADJUST FINISH

When the operator is finished adjusting the blades he/she will have to reset the power on button in the Main Menu to re-energize the panel. Once the power is on, press Border Mode. In the Border Mode select Blade Adjust Finish and the material will reverse feed until the dancer bar returns to the middle position. Note: if it is necessary to feed more material through to get back to where the slitters were reset this will have to be done in the Manual mode.

8.- SLITTERS DISABLE

When this button is pressed the IN-FEED guide roller will lift to prevent the border from coming in contact with the slitters. This is useful if rolling border to be slit at a later date.

9.- WINDER DISABLE

When this button is pressed the winder will be disabled. This is useful if slitting border into a box rather than winding it on a roll.

10.- BORDER LENGTH SINCE LAST CUT

The distance in inches since the cross cut was last activated.

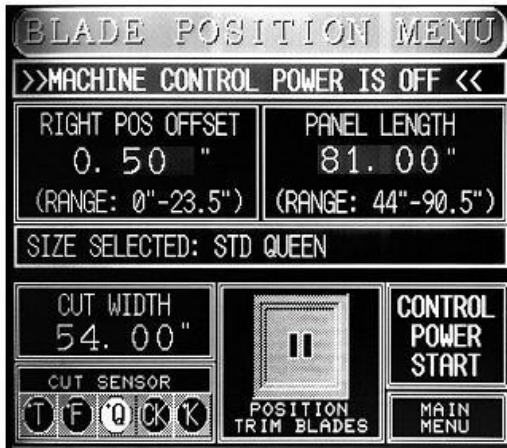
11.- MAIN MENU Return to Main Menu

12.- RUN Machine will start running on this mode

13.- STOP Machine will Stop

c.- Position Trim Blades

c.- [POSITION TRIM BLADES]



1.- RIGHT POS OFFSET



2.- PANEL LENGTH



3.- SIZE SELECT



4.- CUT WIDTH

N/S

5.- CUT SENSOR. Press Letter and size will be highlighted



6.- POSITION TRIM BLADES

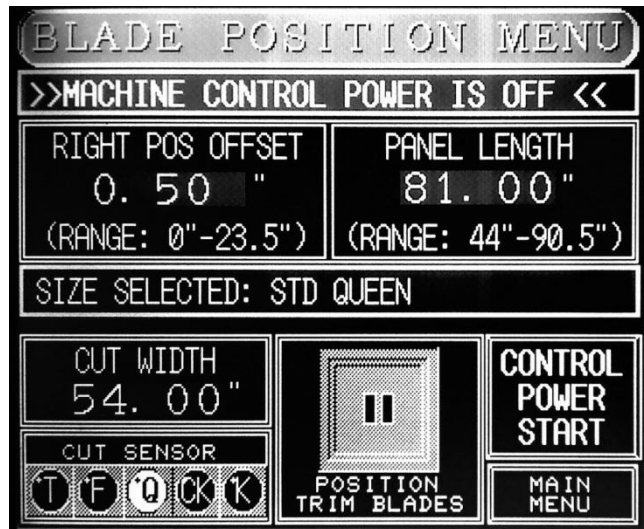
7.- CONTROL POWER START

8.- MAIN MENU



Starting at Main Menu

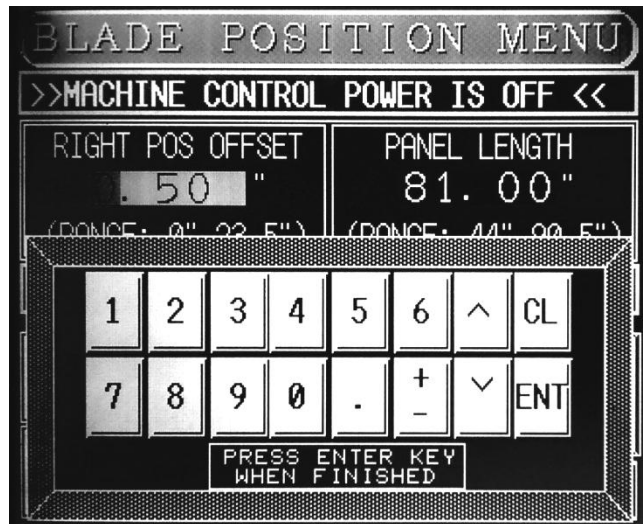
Press **POSITION TRIM BLADES** you will get the **BLADE POSITION MENU** screen.



1.- RIGHT POSITION OFFSET

This sets the distance from the right side (near the touch screen) that the trim knife will be set.

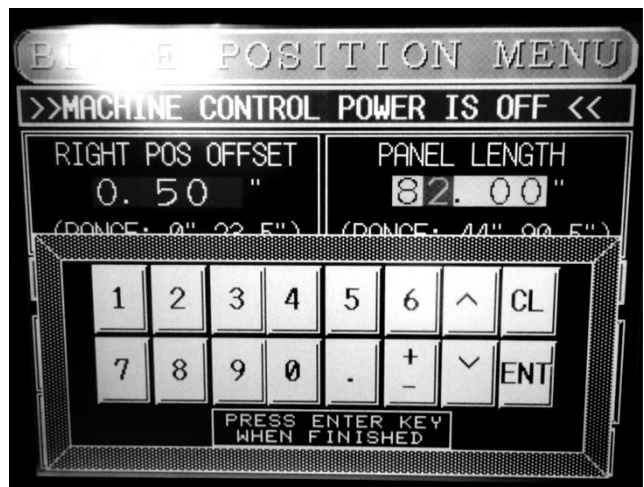
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



2.- PANEL LENGTH

This sets the actual length of the panel to be cut (the distance between the two trim knives)

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



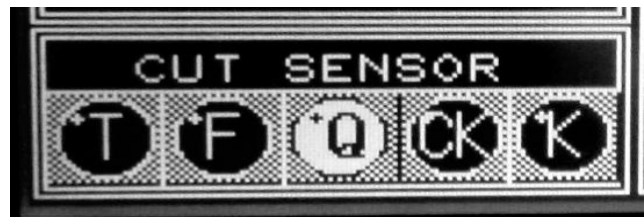
3.- SIZE SELECT.

This is useful to select a preset cut setting for a desired panel length.



4.- CUT WIDTH Show the value of the actual cut width according to the width sensor selected.

5.- CUT SENSOR Press Letter and size will be highlighted



6.- POSITION TRIM BLADES

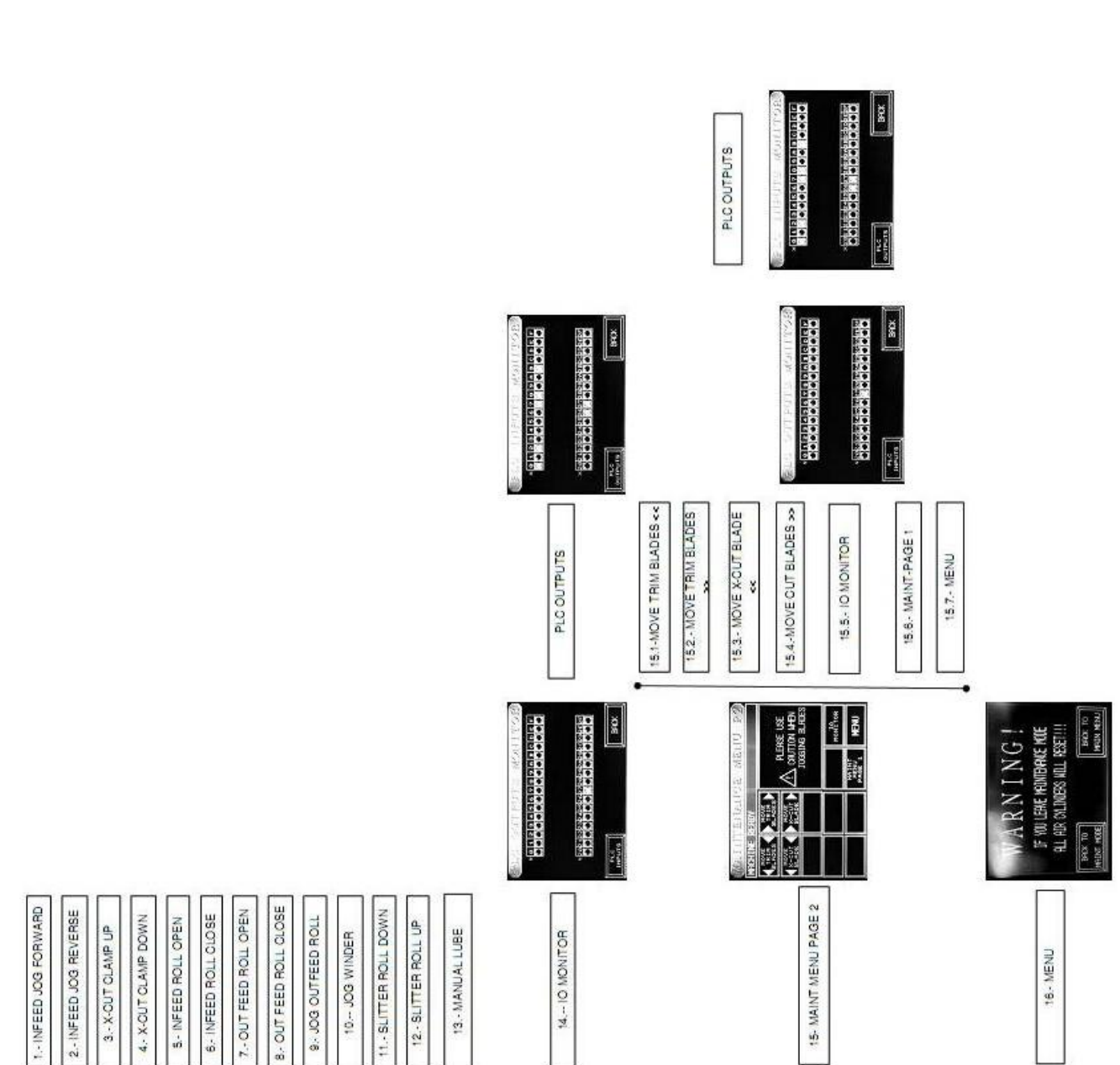
When the desired changes have been entered move the “Position/Off” selector on the panel to “Position” and push “Position Trim Blades”. The blades will now readjust to the new setting.

7.- CONTROL POWER START

If the power was shut off for whatever reasons this will need to be pressed to restore control panel power.

8.- MAIN MENU Return to main Menu.

d.- Maintenance Menu



Starting at Main Menu

Press **MAINT. MENU** you will get the MAINTENANCE MENU P1 screen.



1.- IN-FEED JOG FORWARD The main rollers will turn in the direction to advance material.

2.- IN-FEED JOG REVERSE The main rollers will turn in the direction to reverse the material

3.- X-CUT CLAMP UP The crosscut clamp bar will rise.

4.- X-CUT CLAMP DOWN The crosscut clamp bar will lower.

5.- IN-FEED ROLL OPEN The main IN-FEED pressure rollers will open.

6.-IN-FEED ROLL CLOSE The main IN-FEED pressure rollers will close

7.- OUT FEED ROLL OPEN The pressure roller at the back of the machine will rise.

8.- OUT FEED ROLL CLOSE The pressure roller at the back of machine will drop.

9.- JOG OUT FEED ROLL The lower OUT FEED roller will turn in the normal direction of movement.

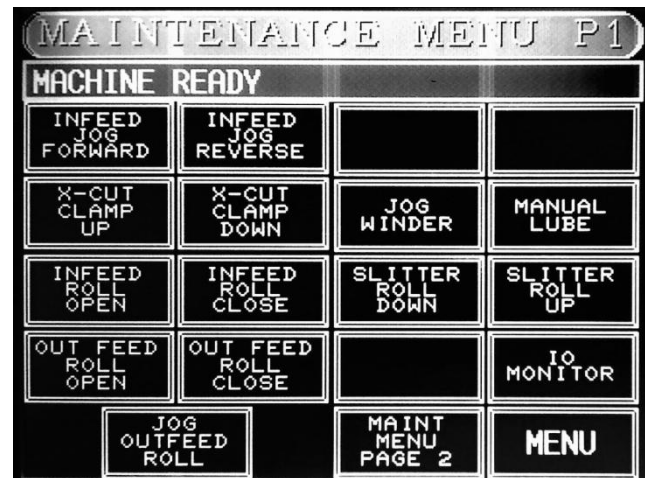
10.- JOG WINDER The windup roller motor will activate.

11.- SLITTER ROLL DOWN The slitter bypass roller will lower.

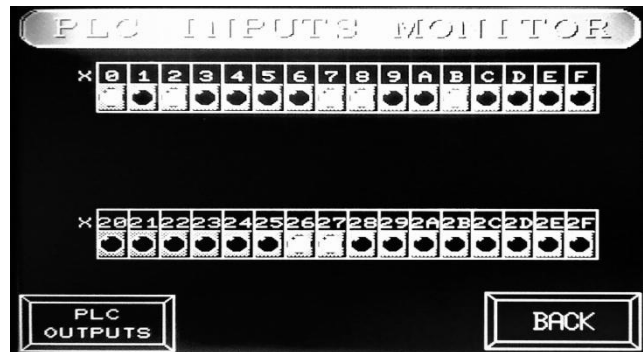
12.- SLITTER ROLL UP The slitter bypass roller will lift.

13.- MANUAL LUBE The automatic lubrication cycle will activate momentarily.

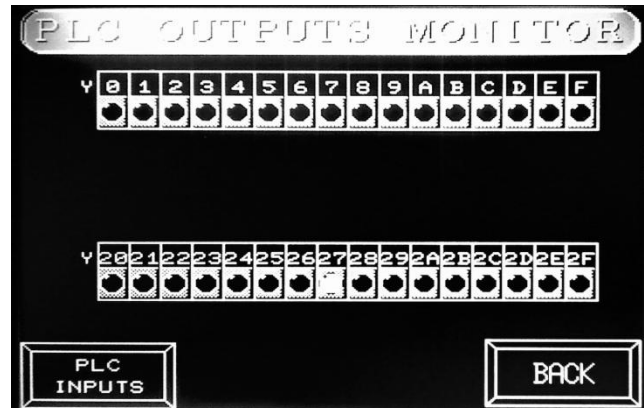
14.- IO MONITOR Has two pages, INPUTS and OUTPUTS from the PLC.



14.1 - PLC INPUTS



14.2 - PLC OUTPUTS



15- MAINT MENU PAGE 2

15.1-MOVE TRIM BLADES

It will jog both side trim blades in the direction of the arrows (left).

15.2.- MOVE TRIM BLADES

Will jog both side trim blades in the direction of the arrows (right).

15.3.-MOVE X-CUT BLADE

It will jog the crosscut blade in the direction of the arrows (left).

15.4.-MOVE CUT BLADE

Will jog the crosscut blade in the direction of the arrows (right).

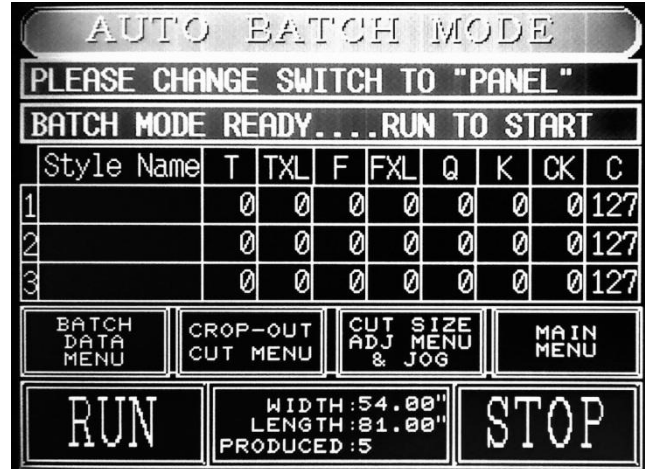
15.5.- IO MONITOR (Same as in Main. I)

15.6.- MAINT.-PAGE 1 Return to the Maint 1 page

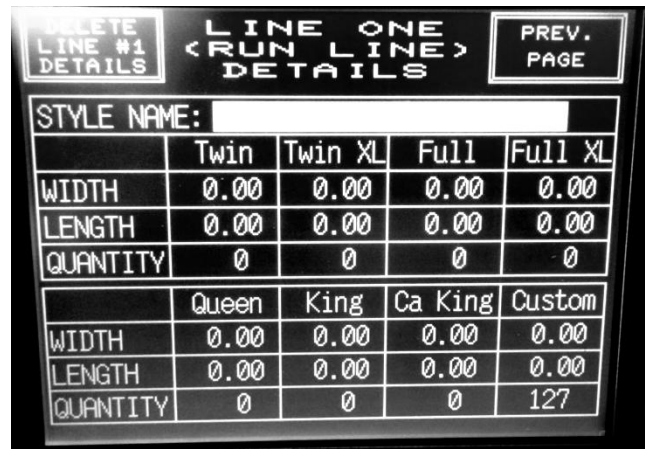
15.7.- MENU Return to the main Menu



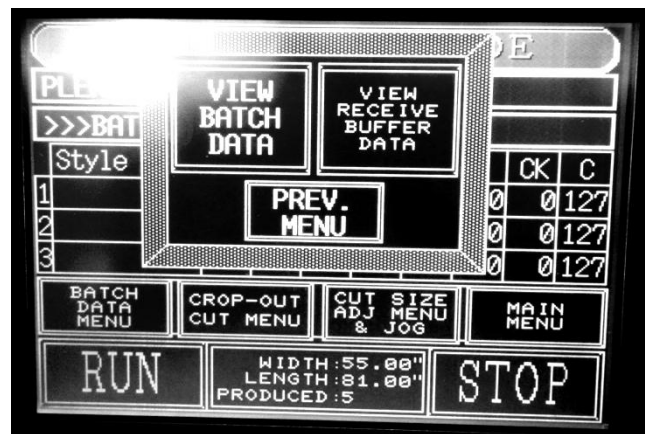
e.- Panel Cut Batch



1.- NUMBER FIELDS



2.- BATCH DATA MENU



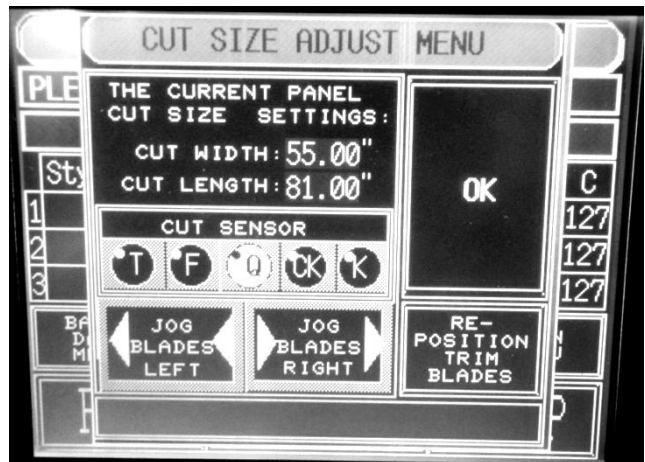
2.1 VIEW DATA MENU

MANAGE BATCH DATA	BATCH STACK DATA MONITOR				SAVE DATA		PREV PAGE	
Style Name	T	TXL	F	FXL	Q	K	CK	C
1	0	0	0	0	0	0	0	127
2	0	0	0	0	0	0	0	127
3	0	0	0	0	0	0	0	127
4	0	0	0	0	0	0	0	127
5	0	0	0	0	0	0	0	127
6	0	0	0	0	0	0	0	127
7	0	0	0	0	0	0	0	127
8	0	0	0	0	0	0	0	127
9	0	0	0	0	0	0	0	127
0	0	0	0	0	0	0	0	127

3.- CROP-OUT CUT MENU



4.- CUT SIZE ADJUST MENU



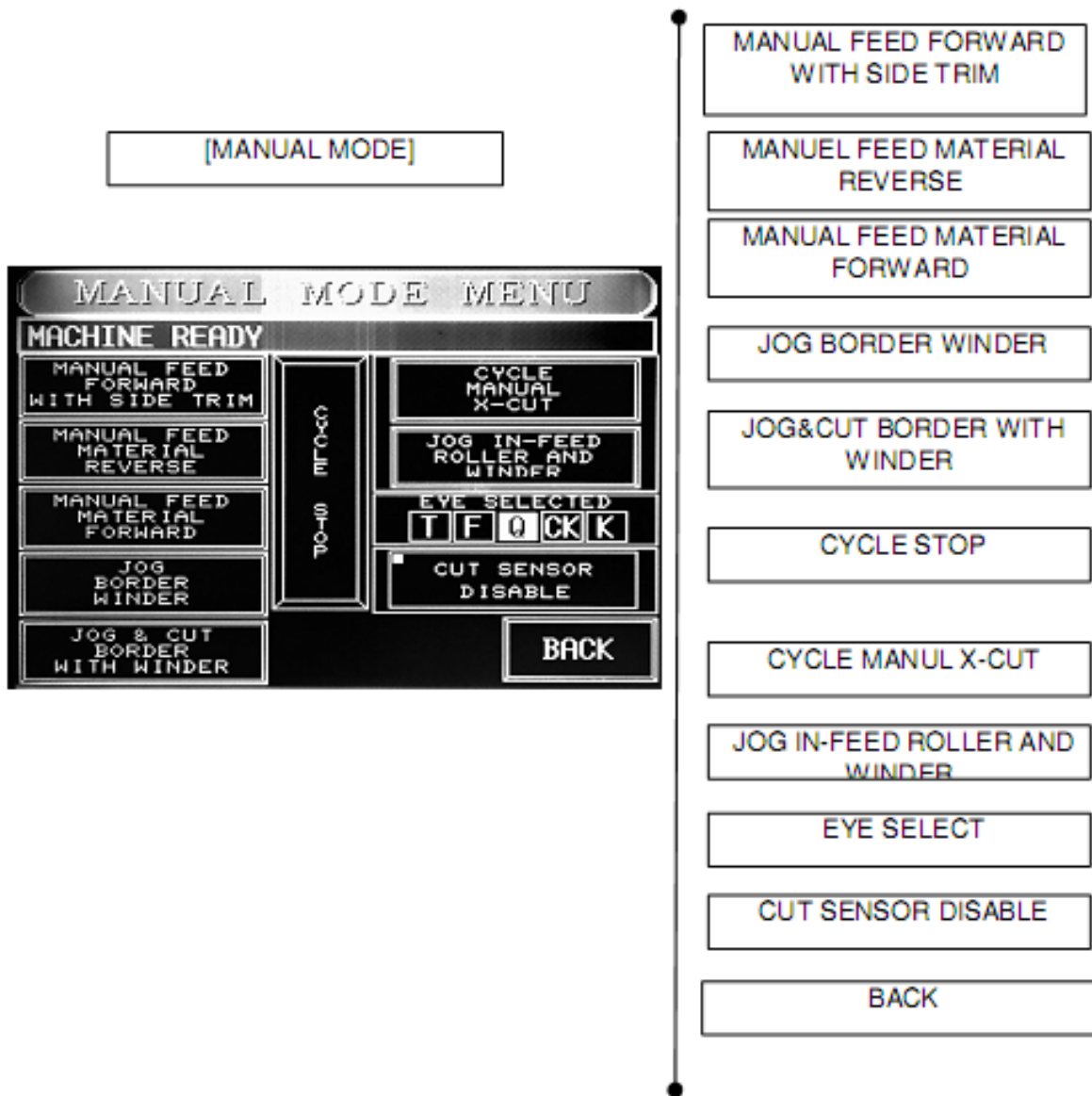
5.- MAIN MENU

6.- RUN

7.- WITH : LENGTH : PRODUCE

8.- STOP

f.- Manual Mode



1.- MANUAL FEED FORWARD WITH SIDE TRIM Will advance material while side trimming.

2.- MANUAL FEED MATERIAL REVERSE Will reverse material with side trim knives not running.

3.- MANUAL FEED MATERIAL FORWARD Will advance material without side trimming.

4.- JOG BORDER WINDER The border winder motor will turn.

5.- JOG & CUT BORDER WITH WINDER The material will feed and side trim with winder motor turning.

6.- CYCLE STOP Interrupt selected cycle.

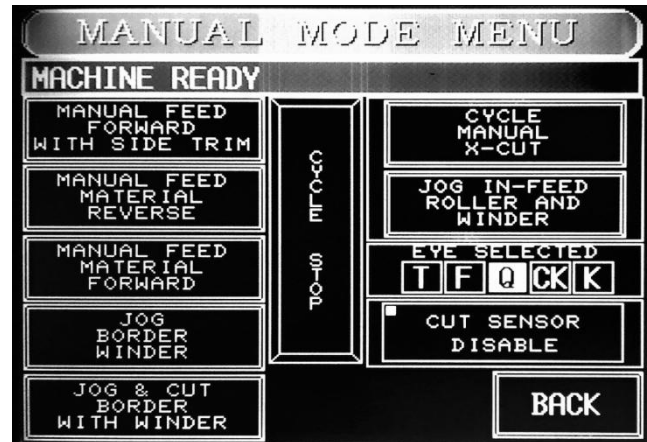
7.- CYCLE MANUAL X-CUT Performs one cross cut cycle.

8.- JOG IN-FEED ROLLER AND WINDER Will advance material without trimming while the windup motor turns.

9.- EYE SELECTED Shows which cut sensor is active.

10.- CUT SENSOR DISABLE Disables cut sensor.

11.- BACK Return to previous screen

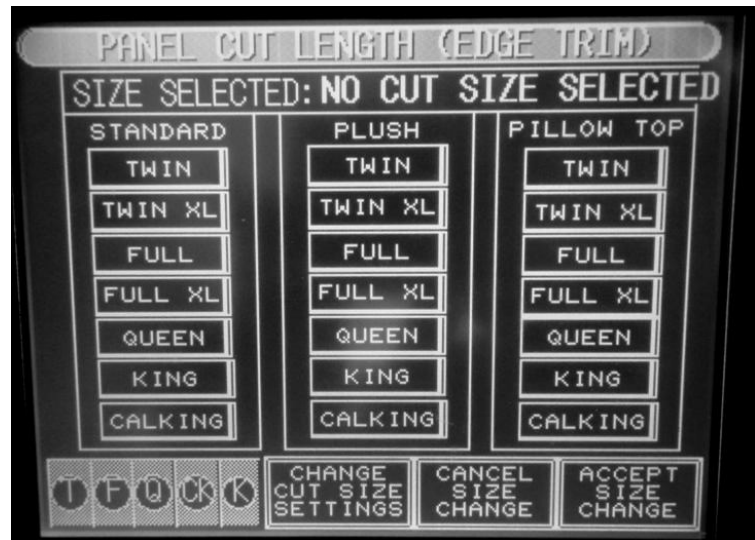


g.- Select Cut length

This screen is divided in 3 main columns.

- STANDARD for normal thickness
- PLUSH for thick panels
- PILLOW TOP for extra thick

The highlighted fields are the ones active as this time

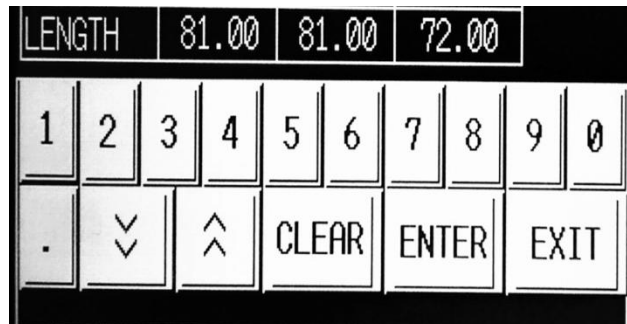


1.- CHANGE CUT SIZE SETTINGS after pressing this field the screen **STANDARD PANEL CUT SIZES** is shown. You will get all the actual dimensions the panels' sizes

	Twin	Twin XL	Full	Full XL
WIDTH	39.00	39.00	55.00	55.00
LENGTH	76.00	81.00	76.00	81.00
	Queen	King	Calking	
WIDTH	61.00	77.00	84.00	
LENGTH	81.00	81.00	72.00	

Buttons: EDIT PLUSH SETTINGS, EDIT PILLOW TOP SETTINGS, RETURN TO CUT LENGTH MENU

To change dimensions, press on top of the number and modify the values.



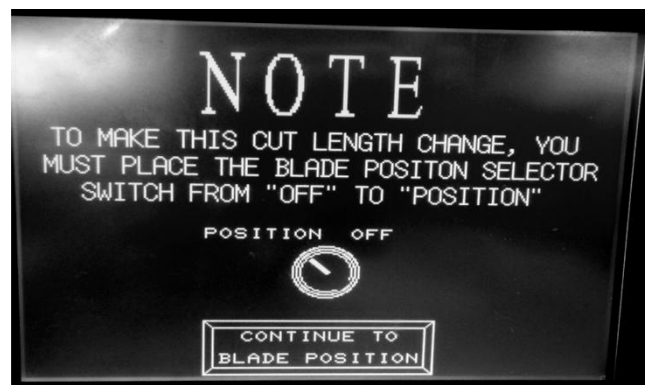
1.1.- EDIT PLUSH SETTINGS To change the rest of the sizes

1.2.- EDIT PILLOW TOP SETTINGS to change the rest of the sizes.

1.3.- RETURN TO CUT LENGTH MENU to exit the screen

2.- CANCEL SIZE CHANGE . Return to the original values without accepting the changes.

3.- ACCEPT SIZE CHANGE record any change made in dimensions



h.- Sharpen Blades

1.- **SHARPEN RIGHT BLADE** – This will turn on the right trim knife motor and activate the sharpener for the predetermined time.

2.- **SHARPEN LEFT BLADE** – This will turn on the left trim knife motor and activate the sharpener for the predetermined time.

3.- **SHARPEN X-CUT BLADE**

4.- **SHARPEN SLITTER BLADE**

5.- **SHARPEN TIME**

6.- **SHARPEN CYCLE STOP**

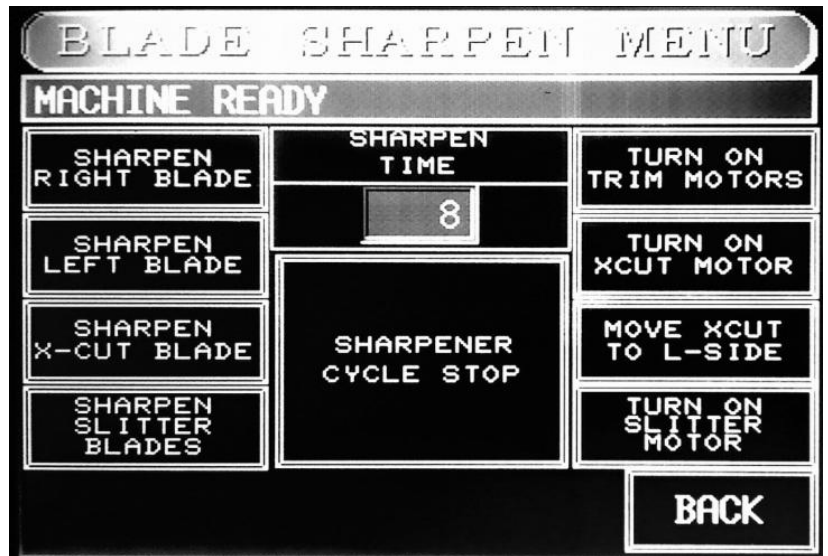
7.- **TURN ON TRIM MOTORS**

8.- **TURN ON XCUT MOTOR**

9.- **MOVE XCUT TO L-SIDE**

10.- **TURN ON SLITTER MOTOR**

11.- **BACK**



i.- Timer settings menu

1.- LUBE INTERVAL Control the activation trimming of the automatic grease system. (OPTIONAL EQUIP.)



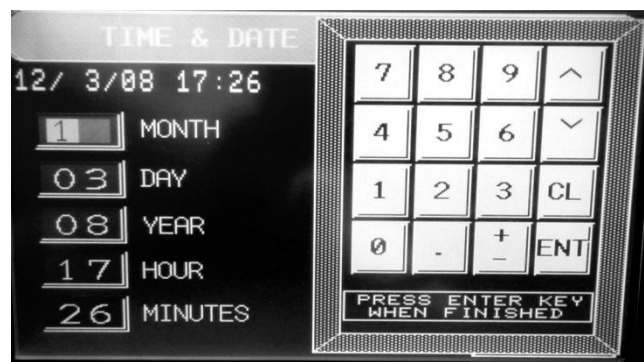
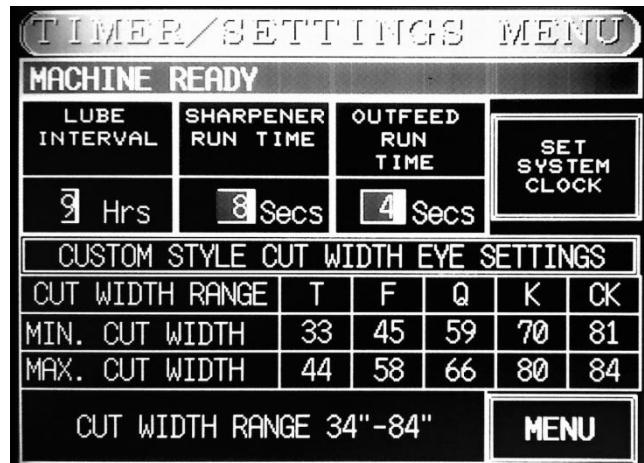
2.- SHARPENER RUN TIME

3.- OUT FEED RUN TIME

4.- SET SYSTEM CLOCK

Press any of the field and change values on the Keypad. Press enter Key when finish

5.- MENU Return to Main Menu



j.- Control Power Start

Press this button to energize the control power to the machine

k.- POWER OFF / POWER ON

This is an indicator to show when the control power is energized (Not a Button)

l.- Control power off



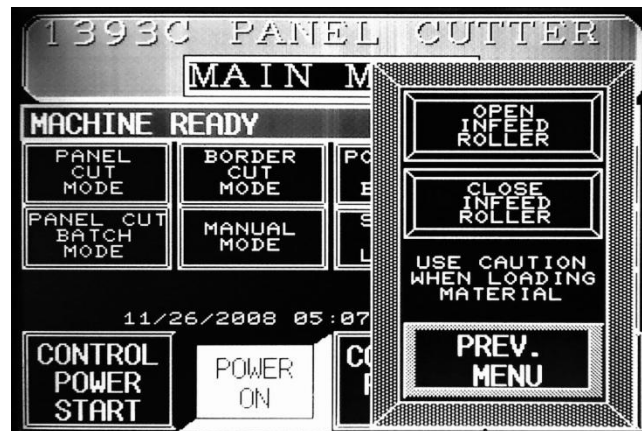
Press this button to de-energize all the control power to the machine.

(PLEASE NOTE: THIS IS NOT THE SAME AS THE MAIN POWER)

m.- Load Material in feed roller

Press **LOAD MATERIAL IN FEED** on the Main Menu roller and you will get 3 options

- OPEN IN FEED ROLLER
- CLOSE IN FEED ROLLER
- PREV MENU Return to the Main menu



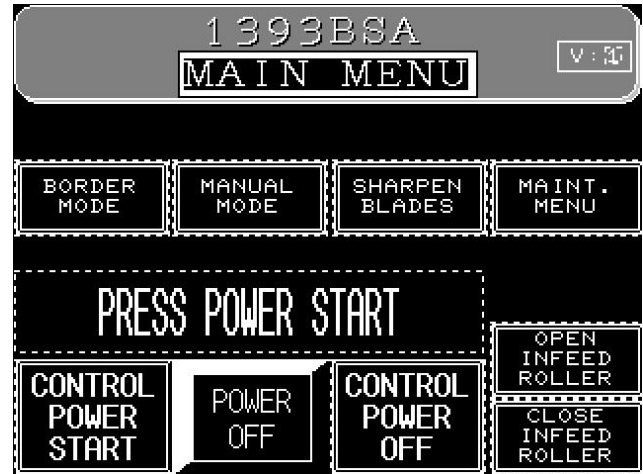
2.3.- Operating



It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating

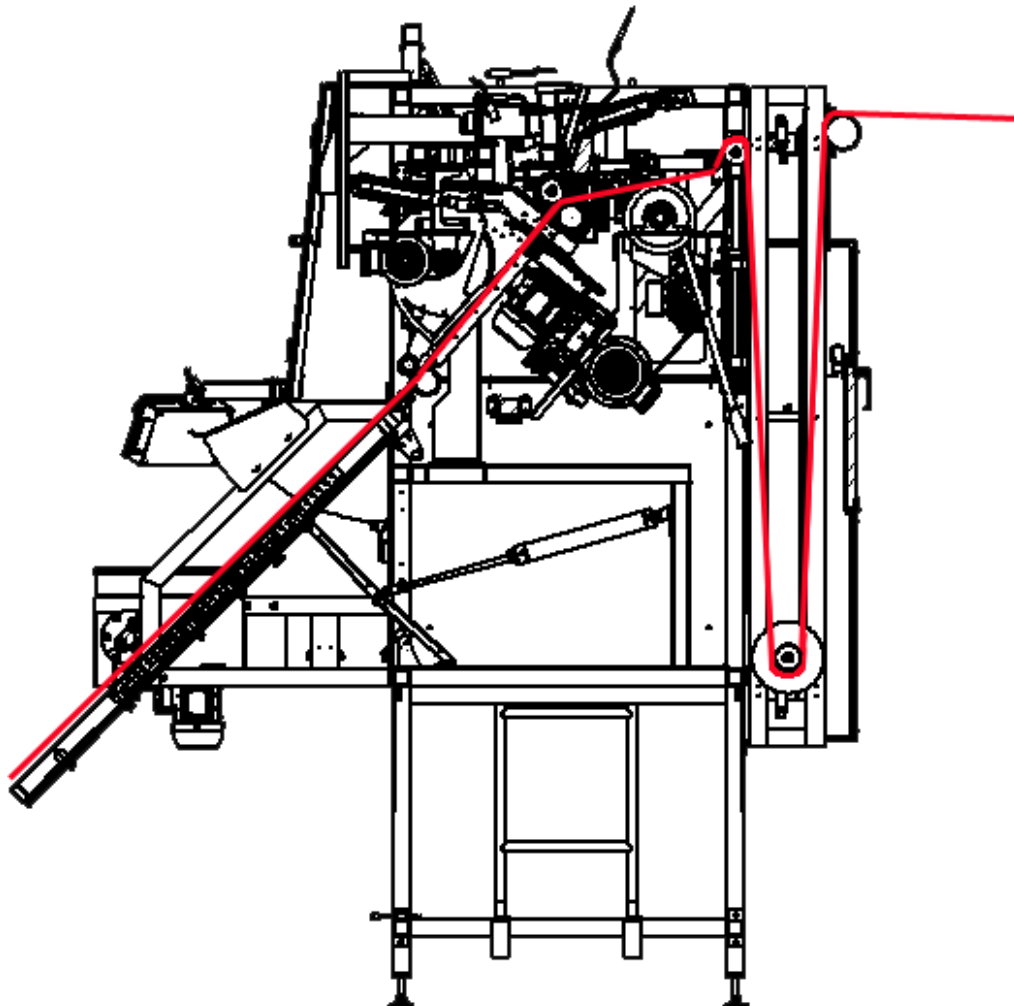
A.- Turning ON

- a.- Make Sure that the Main Power switch is on the "ON" position
- b.- Press the "ON" button on the Control Panel
Machine will show Atlanta Attachment logo and will power ON



B.- Load the material

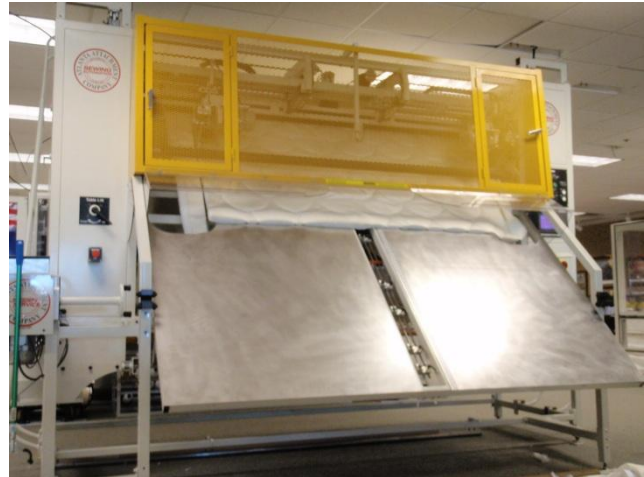
- a.- With the machine ON, Press **LOAD MATERIAL IN FEED** on the Main Menu
- b.- Press **OPEN IN FEED ROLLER**,
- c.- Open the safety doors You will be able to load material through the machine. Follow the picture for a correct loading of the material.



- d.- close the safety doors and press **CLOSE IN FEED ROLLER** from the loading menu.
- e.- Press **PREV MENU** to Return to the Main menu

c.- Panel Cutting

- a.- Set the table Lift switch to “Up” and remove the re-winder shaft
- b.- Make sure machine is loaded with material and all doors are close
- c.- Press **CONTROL POWER START** from the Main Menu Screen
- d.- Press **PANEL CUTTING MENU** on the same screen.
- e.- Load the production required (Panel quantity, dimensions, etc.)
- f.- Press **RUN**.



“ATTENTION “Never leaves the machine unattended”

d.- Border Cutting

- a.- Carefully adjust manually the cutting blades to the right border width.
- b.- Set the table Lift switch to “down” and install the re-winder shaft
- b.- Make sure machine is loaded with material and all doors are close
- c.- Press **CONTROL POWER START** from the Main Menu Screen
- d.- Press **BORDER CUT MENU** on the same screen.
- e.- Load the production required (Border quantity, length, etc.)
- f.- Press **RUN**.
- g.- Readjust the re-winder air pressure if required.



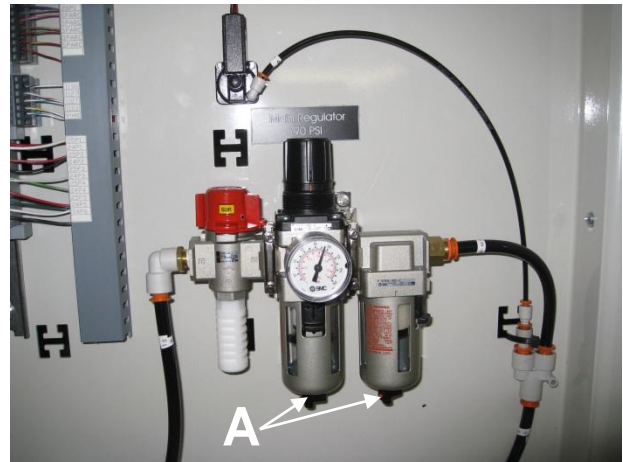
“ATTENTION “Never leaves the machine unattended”



2.4.- Maintenance

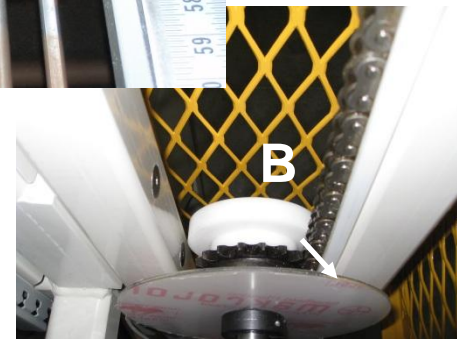
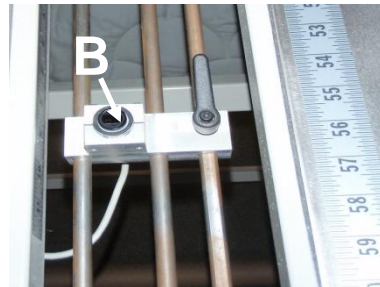
a.- Daily

- 1.- Drain water from water trap in air pressure regulator.
- 2.- Clean any lint or debris from around bearings, blades and motors.
- 3.- Clean work area and check for any signs of abnormality or wear.



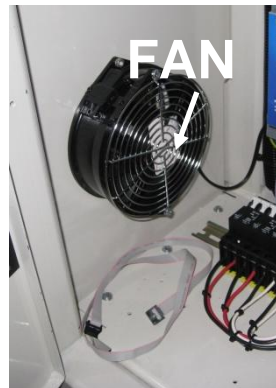
b.- Weekly

- 1.- Clean dancer bar guide chains and sprocket.
- 2.- Clean lint and debris from inside machine around XCut linear rail bearings and belt.
- 3.- Clean lint and debris from Right & Left Trim blade bearing rails and belts.
- 3.- Clean panel width sensors.
- 4.- Check for any areas of wear or potential problems.



c.- Monthly

- 1.- Thoroughly clean machine inside and out.
- 2.- Check condition of all drive belts.
- 3.- Check security of all blades.
- 4.- Check setting of blade sharpening stones.
- 5.- Clean threads from around all shafts and rollers.
- 6.- Clean cabinet cooling fan and filter.
- 7.- Check condition of dancer bar guide chain and sprocket alignment on both sides..
- 8.- Check and grease pillow block bearings as needed. (Look for rust or fine metal particles)



3.- SERVICE MANUAL



It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating.

1.- Pneumatic

a.- Re-winder pressure.

Control the pressure of the clutch Determine how tight the roll will be winder.

(Factory adjustment: 30 psi)

b.- Main air regulator

Determine the pressure for the whole machine.

(Factory adjustment 90 psi)

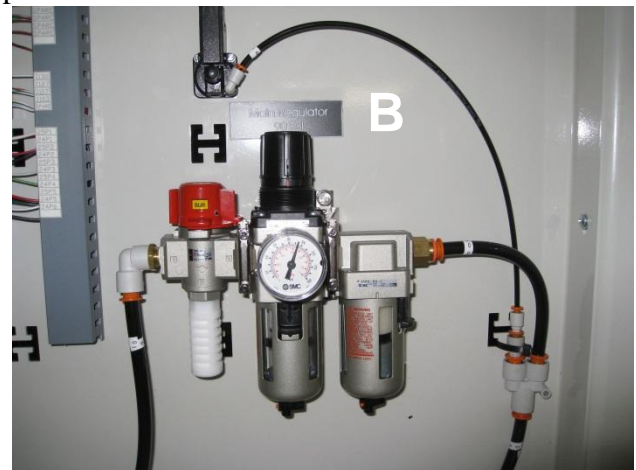
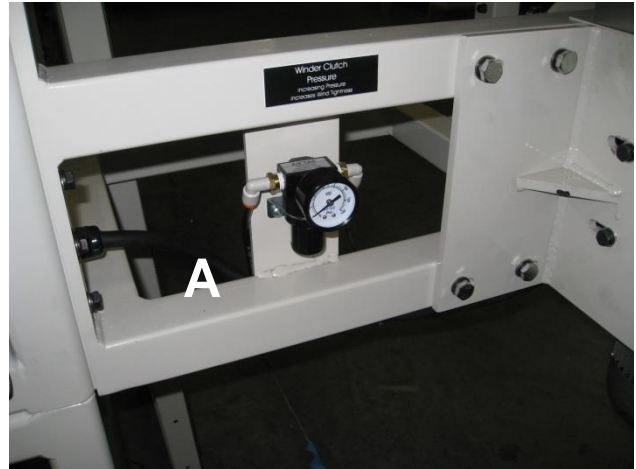
c.- Blade Sharpeners.

Control the reassure of the blade sharpeners.

(Factory adjustment 30 psi)

d.- Infeed Roll regulator. Control de pressure of the top in feed roll.

(Factory adjustment 20 to 40 psi)



1393E Panel Cutter Spare Parts Kit

NO.	QTY	PART #	DESCRIPTION
1	2	1393003	SHARPENER STONE MNT
2	1	AAE4V21008	VALVE, 1/4" PORTED, 24VDC
3	2	BBGER205-25	BEARING, BALL, 25MM B, CLAMP
4	2	CJ2090200	BLADE, TRIM & XCUT, 280MM OD
5	2	CJ21100900	BLADE, SLITTER, 205MM OD
6	1	EEMC12B11	CONTACTOR, IEC, 230VAC
7	1	EEMC32A22	CONTACTOR, IEC, 230VAC
8	1	EENI5Q18AN6X	LIMIT SW SENSOR
9	1	EERM699V3011	RELAY, REPLACEMENT

Programming ACTech SCL/SCM Drive (1393E Only)

The drive is already pre-programmed** with settings specifically for the 1393E Unit by Atlanta Attachment Co. These settings are listed in the chart on the following page. Password protection is currently disabled so that control of the parameters is immediately available to the user. After the controller settings have been "fine-tuned", you can use parameter 44 to set a password value between 1-999 to "lock" the control setting for the motors.

The buttons and display on the front of the motor controller can be used to change any specific parameter. Pressing the mode button will take you to the last parameter viewed. Parameters are designated with a "P" as the first character on the display. The arrow up and arrow down buttons will scroll through to the desired parameter. Pressing "Mode" displays the current parameter setting (point "above" decimal point blinks). This setting can be changed by using the arrow up and arrow down buttons. When the desired setting is found press the mode button to store the new value. This will store the new value and exit the program mode. To change another parameter value, press the mode key again and repeat the procedure.

**In the event the controller has not been pre-programmed by AAC, the default password from the factory is 225.

Every SCL/SCM Series drive has an Electronic Programming Module (EPM) installed on the main control board. The EPM stores the user's parameter settings and special OEM default settings (if programmed). The EPM is removable, allowing it to be installed in another drive for quick set-up. For example, if a drive is being replaced with a new one, the EPM can be taken out of the first drive and installed in the new drive. Downtime is minimized because the new drive does not require programming - it is ready to run when the EPM is installed.

NOTE: The drive will not operate without the EPM installed. The drive will display "F1" if the EPM is missing or damaged.

WARNING!

Do not remove the EPM while power is applied to the drive. Damage to the EPM and/or drive may result.

See tables on following pages...

XCut Drive Motor Parameters Menu (INV1)

AAC custom setting shown in last column.

NO.	PARAMETER NAME	RANGE OF ADJUSTMENT	FACTORY DEFAULT	AAC SETTING
01	LINE VOLTAGE	High (01), LOW (02)	HIGH (01)	02
02	CARRIER FREQUENCY	4kHz (01), 6kHz (02), 8 kHz (03), 10 kHz (04)	6 KHZ (02)	04
03	START METHOD	NORMAL (01), START ON POWER UP (02), START WITH DC BRAKE (03), AUTO RESTART WITH DC BRAKE (04), FLYING RESTART 1 (05), FLYING RESTART 2 (06), FLYING RESTART 3 (07)	NORMAL (01)	---
04	STOP METHOD	COAST (01), COAST W/ DC BRAKE (02), RAMP (03), RAMP W/ DC BRAKE (04)	COAST (01)	04
05	STANDARD SPEED SOURCE	KEYPAD (01), PRESET #1 (02), 0-10VDC (03), 4-20mA (04)	KEYPAD (01)	02
06	RELAY OUTPUT	NONE (01), RUN (02), FAULT (03), INVERSE FAULT (04), FAULT LOCKOUT (05), AT SET SPEED (06), ABOVE PRESET #3 (07), CURRENT LIMIT (08), AUTO SPEED (09), REVERSE (10)	NONE (01)	06
10	TB-13A FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #1 (04), START FORWARD (05), RUN REVERSE (06), START REVERSE (07), EXTERNAL FAULT (08), INVERSE EXT FAULT (09), AUXILARY STOP (10), ACCEL/DECEL #2 (11)	NONE (01)	06
11	TB-13B FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #2 (04), DECREASE FREQ (05), START FORWARD (06), JOG FORWARD (07), JOG REVERSE (08), EXTERNAL FAULT (09), INVERSE EXT FAULT (10), AUXILARY STOP (11), ACCEL/DECEL #2 (12), REMOTE KEYPAD (13)	NONE (01)	04
12	TB-13E INPUT FUNCTIONS TB-13 OUTPUT FUNCTIONS OTHER FUNCTIONS	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #3 (04), INCREASE FREQ (05), START FORWARD (06), EXTERNAL FAULT (07), INVERSE EXT FAULT (08), AUX STOP (09), ACCEL/DECEL #2 (10), RUN (11), FAULT (12), INVERSE FAULT (13), FAULT LOCKOUT (14), AT SET SPEED (15), ABOVE PRESET #3 (16), CURRENT LIMIT (17), AUTO SPEED (18), REVERSE (19), DYNAMIC BRAKING (20), REMOTE KEYPAD (21)	NONE (01)	---

Technical Manual & Parts Lists

14	CONTROL	TERMINAL STRIP ONLY (01) REMOTE KEYPAD ONLY (02)	TERMINAL STRIP ONLY (01)	---
16	UNITS EDITING	TENTHS OF UNITS (01), WHOLE UNITS (02)	WHOLE UNITS (02)	---
17	ROTATION	FORWARD ONLY (01), FORWARD AND REVERSE (02)	FORWARD ONLY (01)	02
19	ACCELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	1.0
20	DECELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	0.2
21	DC BRAKE TIME	0.0 - 3600.0 SEC	0.0 SEC	0.3
22	DC BRAKE VOLTAGE	0.0 - 30.0%	0.0 %	1.5
23	MINIMUM FREQUENCY	0.0 - MAXIMUM FREQUENCY	0.0 Hz	---
24	MAXIMUM FREQUENCY	MINIMUM FREQUENCY - 240 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	80
25	CURRENT LIMIT	30 - 180 %	180 %	150
26	MOTOR OVERLOAD	30 - 100 %	100 %	---
27	BASE FREQUENCY	25.0 - 500 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	60
28	FIXED BOOST	0.0 - 30.0 %	1.0 %	20
29	ACCEL BOOST	0.0 - 20.0 %	0.0 %	---
30	SLIP COMPENSATION	0.0 - 5.0 %	0.00%	---
31	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	70
32	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	35
33-37			0.0	0.0
38	SKIP BANDWIDTH	0.0 - 10 Hz	0.0 Hz	---
39	SPEED SCALING	0.0 - 6500.0	0.0	---
42	ACCEL/DECEL #2	0.1 - 3600.0 SEC	20.0 SEC	---
44	PASSWORD	000 - 999	225	*000
45	SPD AT MIN SIGNAL	MINIMUM FREQUENCY - 999 Hz	0.0 Hz	---
46	SPD AT MAX SIGNAL	MINIMUM FREQUENCY - 999 Hz	SCL = 50.0Hz SCM = 60.0Hz	---
47	CLEAR HISTORY	MAINTAIN (01), CLEAR (02)	MAINTAIN (01)	---

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48	PROGRAM SELECTION	USER SETTINGS (01), OEM SETTINGS (02), RESET OEM (03), RESET 60 (04), RESET 50 (05), TRANSLATE (06)	SCL = RESET 50 (05) SCM = RESET 60 (04)	---
50	FAULT HISTORY	(VIEW ONLY)	(N/A)	---
51	SOFTWARE CODE	(VIEW ONLY)	(N/A)	---
52	DC BUS VOLTAGE	(VIEW ONLY)	(N/A)	---
53	MOTOR VOLTAGE	(VIEW ONLY)	(N/A)	---
54	LOAD VOLTAGE	(VIEW ONLY)	(N/A)	---
55	0-10 VDC INPUT	(VIEW ONLY)	(N/A)	---
56	4-20mA INPUT	(VIEW ONLY)	(N/A)	---
57	TB STRIP STATUS	(VIEW ONLY)	(N/A)	---
58	KEYPAD STATUS	(VIEW ONLY)	(N/A)	---
* PASSWORD IS SET TO "000" WHICH DISABLES THE PASSWORD FUNCTION				

Infeed Drive Motor Parameters Menu (INV2)

AAC custom setting shown in last column.

NO.	PARAMETER NAME	RANGE OF ADJUSTMENT	FACTORY DEFAULT	AAC SETTING
01	LINE VOLTAGE	High (01), LOW (02)	HIGH (01)	02
02	CARRIER FREQUENCY	4kHz (01), 6kHz (02), 8 kHz (03), 10 kHz (04)	6 kHz (02)	04
03	START METHOD	NORMAL (01), START ON POWER UP (02), START WITH DC BRAKE (03), AUTO RESTART WITH DC BRAKE (04), FLYING RESTART 1 (05), FLYING RESTART 2 (06), FLYING RESTART 3 (07)	NORMAL (01)	---
04	STOP METHOD	COAST (01), COAST W/ DC BRAKE (02), RAMP (03), RAMP W/ DC BRAKE (04)	COAST (01)	04
05	STANDARD SPEED SOURCE	KEYPAD (01), PRESET #1 (02), 0-10VDC (03), 4-20mA (04)	KEYPAD (01)	02
06	RELAY OUTPUT	NONE (01), RUN (02), FAULT (03), INVERSE FAULT (04), FAULT LOCKOUT (05), AT SET SPEED (06), ABOVE PRESET #3 (07), CURRENT LIMIT (08), AUTO SPEED (09), REVERSE (10)	NONE (01)	06
10	TB-13A FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #1 (04), START FORWARD (05), RUN REVERSE (06), START REVERSE (07), EXTERNAL FAULT (08), INVERSE EXT FAULT (09), AUXILARY STOP (10), ACCEL/DECEL #2 (11)	NONE (01)	06
11	TB-13B FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #2 (04), DECREASE FREQ (05), START FORWARD (06), JOG FORWARD (07), JOG REVERSE (08), EXTERNAL FAULT (09), INVERSE EXT FAULT (10), AUXILARY STOP (11), ACCEL/DECEL #2 (12), REMOTE KEYPAD (13)	NONE (01)	04
12	TB-13E INPUT FUNCTIONS TB-13 OUTPUT FUNCTIONS OTHER FUNCTIONS	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #3 (04), INCREASE FREQ (05), START FORWARD (06), EXTERNAL FAULT (07), INVERSE EXT FAULT (08), AUX STOP (09), ACCEL/DECEL #2 (10), RUN (11), FAULT (12), INVERSE FAULT (13), FAULT LOCKOUT (14), AT SET SPEED (15), ABOVE PRESET #3 (16), CURRENT LIMIT (17), AUTO SPEED (18), REVERSE (19), DYNAMIC BRAKING (20), REMOTE KEYPAD (21)	NONE (01)	---

14	CONTROL	TERMINAL STRIP ONLY (01) REMOTE KEYPAD ONLY (02)	TERMINAL STRIP ONLY (01)	---
16	UNITS EDITING	TENTHS OF UNITS (01), WHOLE UNITS (02)	WHOLE UNITS (02)	---
17	ROTATION	FORWARD ONLY (01), FORWARD AND REVERSE (02)	FORWARD ONLY (01)	02
19	ACCELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	1.0
20	DECELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	0.3
21	DC BRAKE TIME	0.0 - 3600.0 SEC	0.0 SEC	0.5
22	DC BRAKE VOLTAGE	0.0 - 30.0%	0.0 %	1.0
23	MINIMUM FREQUENCY	0.0 - MAXIMUM FREQUENCY	0.0 Hz	---
24	MAXIMUM FREQUENCY	MINIMUM FREQUENCY - 240 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	80
25	CURRENT LIMIT	30 - 180 %	180 %	150
26	MOTOR OVERLOAD	30 - 100 %	100 %	---
27	BASE FREQUENCY	25.0 - 500 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	60
28	FIXED BOOST	0.0 - 30.0 %	1.0 %	20
29	ACCEL BOOST	0.0 - 20.0 %	0.0 %	---
30	SLIP COMPENSATION	0.0 - 5.0 %	0.00%	---
31	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	60
32	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	35
33-37			0.0	0.0
38	SKIP BANDWIDTH	0.0 - 10 Hz	0.0 Hz	---
39	SPEED SCALING	0.0 - 6500.0	0.0	---
42	ACCEL/DECEL #2	0.1 - 3600.0 SEC	20.0 SEC	---
44	PASSWORD	000 - 999	225	*000
45	SPD AT MIN SIGNAL	MINIMUM FREQUENCY - 999 Hz	0.0 Hz	---
46	SPD AT MAX SIGNAL	MINIMUM FREQUENCY - 999 Hz	SCL = 50.0Hz SCM = 60.0Hz	---
47	CLEAR HISTORY	MAINTAIN (01), CLEAR (02)	MAINTAIN (01)	---

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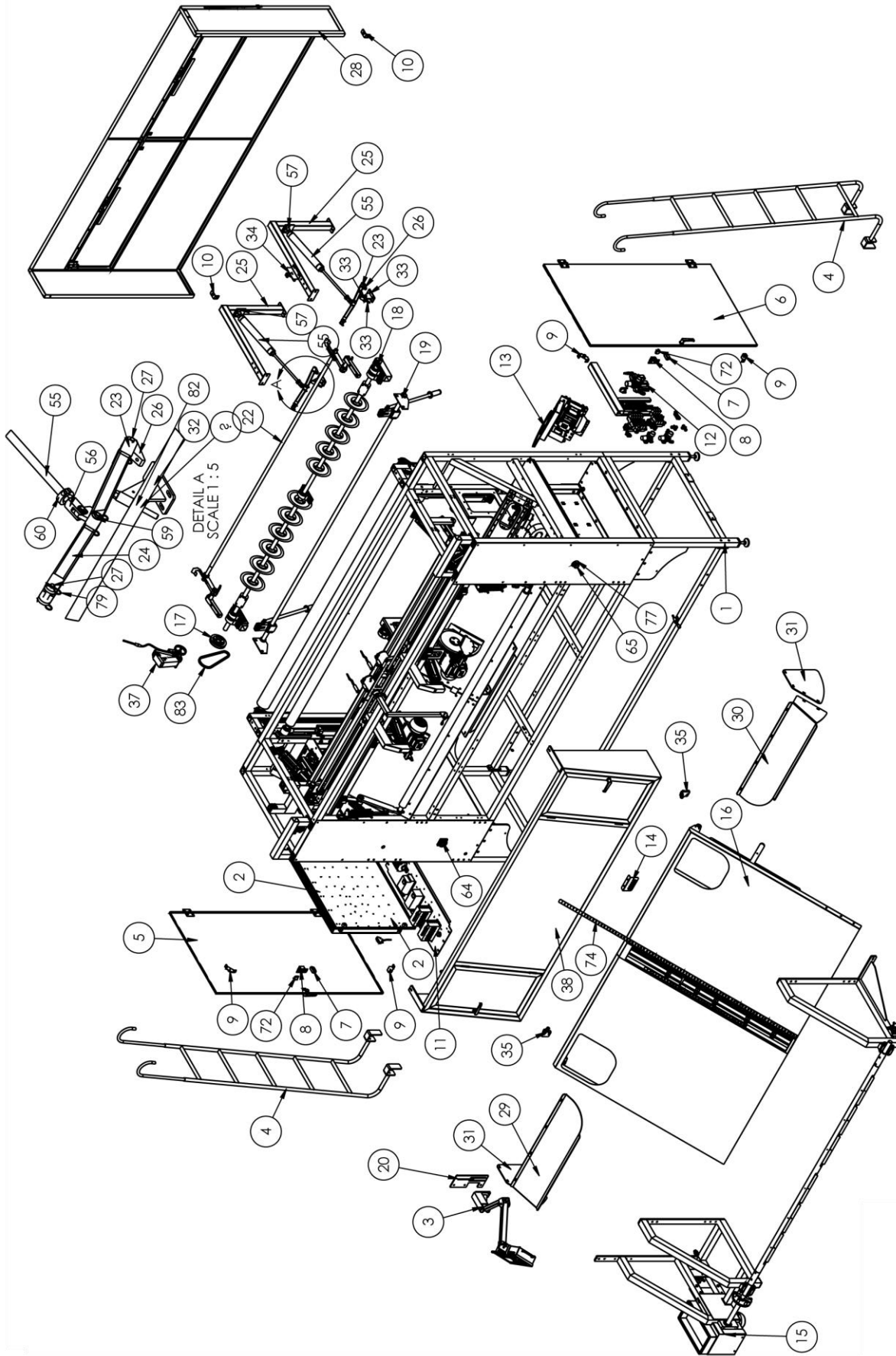
48	PROGRAM SELECTION	USER SETTINGS (01), OEM SETTINGS (02), RESET OEM (03), RESET 60 (04), RESET 50 (05), TRANSLATE (06)	SCL = RESET 50 (05) SCM = RESET 60 (04)	---
50	FAULT HISTORY	(VIEW ONLY)	(N/A)	---
51	SOFTWARE CODE	(VIEW ONLY)	(N/A)	---
52	DC BUS VOLTAGE	(VIEW ONLY)	(N/A)	---
53	MOTOR VOLTAGE	(VIEW ONLY)	(N/A)	---
54	LOAD VOLTAGE	(VIEW ONLY)	(N/A)	---
55	0-10 VDC INPUT	(VIEW ONLY)	(N/A)	---
56	4-20mA INPUT	(VIEW ONLY)	(N/A)	---
57	TB STRIP STATUS	(VIEW ONLY)	(N/A)	---
58	KEYPAD STATUS	(VIEW ONLY)	(N/A)	---
* PASSWORD IS SET TO "000" WHICH DISABLES THE PASSWORD FUNCTION				

Assembly Drawings & Parts Lists

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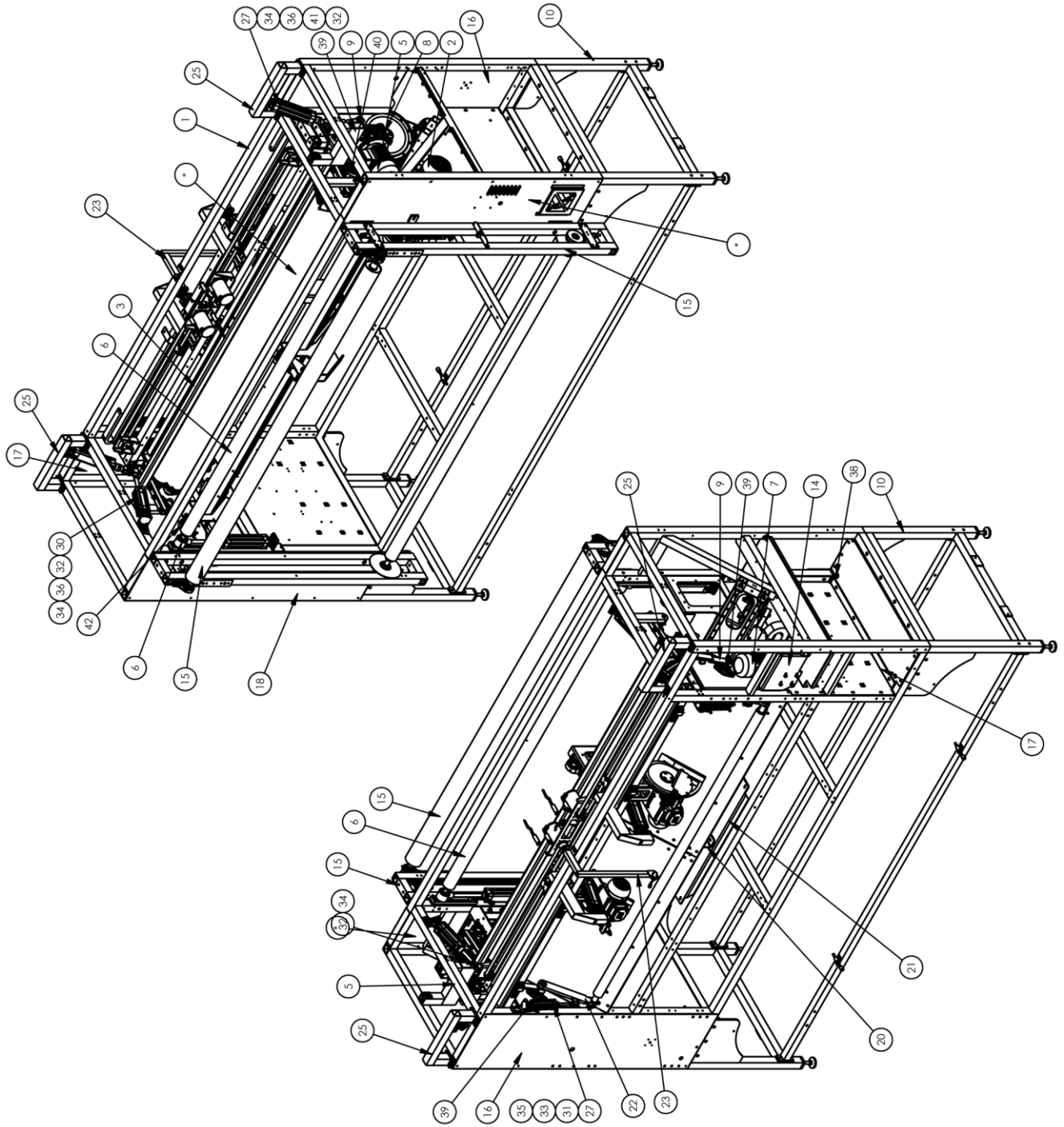


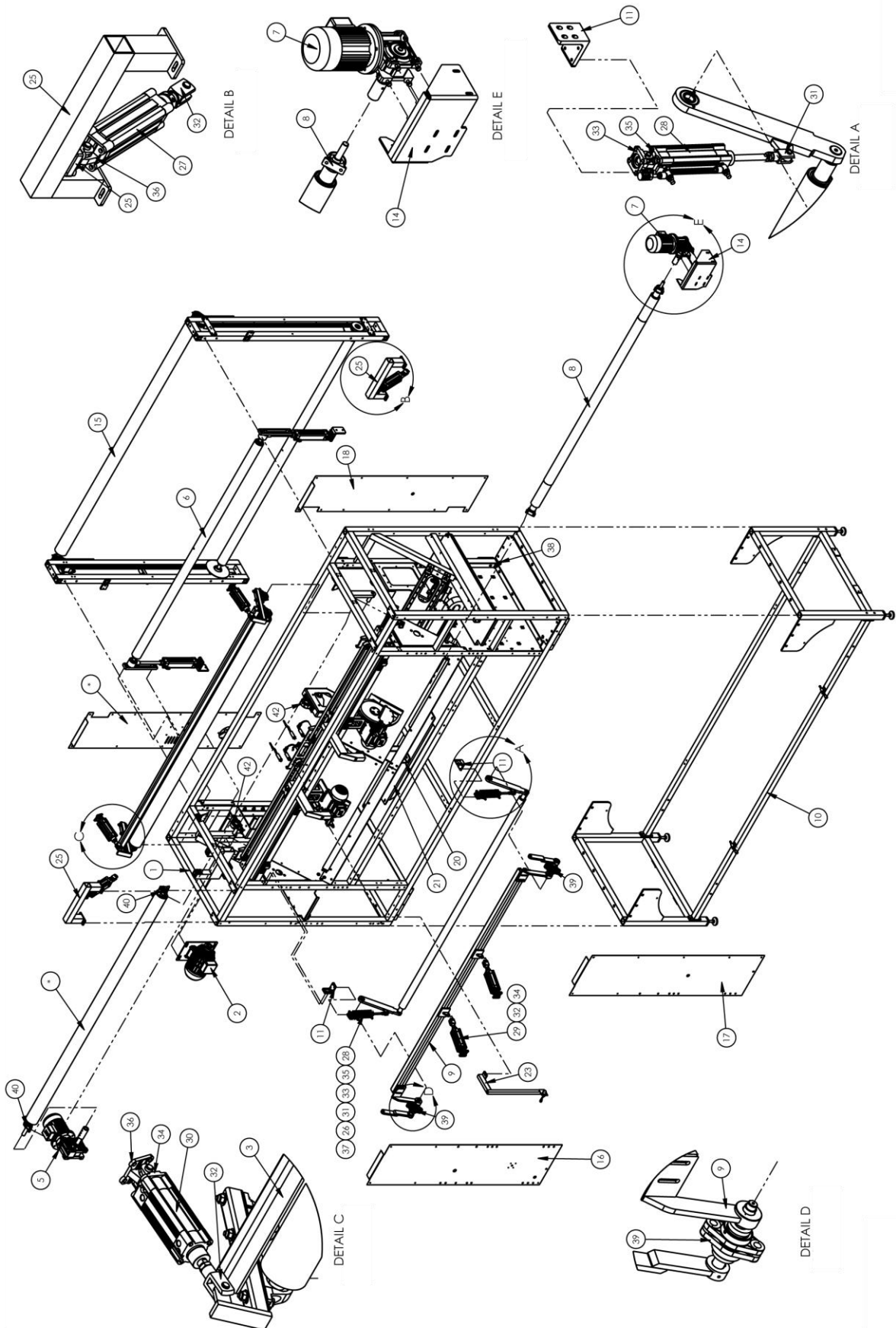
11393E Panel Cutter/Slitter

AAC Drawing Number 9002885 Rev 5

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1388232	1393E SUB-FRAME ASSEMBLY	43	*AR	1393E-PD1	DIAGRAM,PNEUMATIC
2	1	1388303	BACK PANEL ELECTRICAL ASM	44	*AR	1393E-WD1	DIAGRAM,WIRING
3	1	1388415	SWIVEL ARM ASSEMBLY	45	*AR	1393E-WD10	DIAGRAM,WIRING
4	2	1388520	LADDER, LONG, 1393E	46	*AR	1393E-WD2	DIAGRAM,WIRING
5	1	1388549	SIDE DOOR ASSEMBLY, RH	47	*AR	1393E-WD3	DIAGRAM,WIRING
6	1	1388550	SIDE DOOR ASSEMBLY, LH	48	*AR	1393E-WD4	DIAGRAM,WIRING
7	2	1388555	DOOR LATCH	49	*AR	1393E-WD5	DIAGRAM,WIRING
8	2	1388558	BOX,SAFETY SENSOR,DOOR	50	*AR	1393E-WD6	DIAGRAM,WIRING
9	4	1388559	DOOR STOP/BUMPER ASM	51	*AR	1393E-WD7	DIAGRAM,WIRING
10	2	1388592	BRACKET, REAR GUARD MNT	52	*AR	1393E-WD8	DIAGRAM,WIRING
11	1	1388594	BOTTOM PANEL, ELEC, ASM	53	*AR	1393E-WD9	DIAGRAM,WIRING
12	1	1388650	PNEUMATIC PANEL ASM	54	*AR	1394282	BRACKET,SHIPPING 11393
13	1	1388664	CROSS CUT ASSY	55	2	AACM3112DXP	CYLINDER,AIR,2" BORE
14	1	1389229	MOLEX MANIFOLD	56	2	AAFD2313	CLEVIS, AIR CYL 7/16-20
15	1	1389245	WINDER ASSEMBLY	57	2	AAFD620	REAR PIVOT BRKT
16	1	1389258	PANEL TABLE ASSEMBLY	58	*10FT	AATPWL1	WIRE LOOM,SLIT,.92"ID
17	1	1389605	PULLEY, SLITTER MOTOR	59	4	BBTRA613	WASHER,THRUST,STL,.375B
18	1	1389860	SLITTER ASBLY,SPLIT SHAFT	60	2	CCCL10F	CLAMP COLLAR- 5/8 ID
19	1	1389896	SLITTER SHARPENER ASBLY	61	1	EE07100SP072	CORD, FAN, 72" STRAIGHT
20	1	1389902	PLATE, TOUCHSCREEN MOUNT	62	1	EE194EE631753	63AMP DISCON
21	2	1389913	CABLE, ASSEMBLY, STEPPER	63	1	EE194EE63PE	GROUND TERMINAL
22	1	1393-KIT06	WEIGHTED SLITTER BAR ASM	64	1	EE194LHE6N175	DISCONNECT HANDLE,RED/YEL
23	2	1393096	LINKAGE, TOP	65	3	EE2AML4	OPERATOR, E-STOP,RED
24	2	1393098	LINKAGE, LOWER	66	*32FT	EED78W308	DUCT,WIRE,3/4 X 3/4
25	2	1393100	MOUNTING WELDMENT	67	*32FT	EED78W332	DUCT,WIRE COVER
26	2	1393109	PIVOT, BOLT ON	68	*32FT	EEDC15X15	DUCT,WIRE COVER
27	6	1393133	PIVOT PIN	69	*32FT	EEDC15X15	DUCT,WIRE
28	1	1393160	REAR GUARD	70	6	EES2	CONTACT BLOCK, NC
29	1	1393186	GUARD, EXIT, LEFT	71	*100FT	FF822427	CABLE,SOOW,4X14AWG,600V
30	1	1393199	GUARD, EXIT	72	2	FFE6930A	SWITCH,INTEROCK,DOOR,SPDT
31	2	1393201	GUARD, SIDE TABLE	73	1	FFMPI-650-230	TRANSFORMER, 5.6A
32	1	1393240	ARM STOP WELDMENT	74	1	MM1910A25M	RULER,SILVER MYLAR 108"
33	1	1393310	TABLE STOP ASSY	75	*1	MM19155K98	FAN,FINGER GUARD,5.9"
34	1	1393312	LOCK PIN VALVE ASSY	76	1	MM1976K78	FAN, COOLING, 230VAC
35	2	1393360	TABLE PIVOT ASST	77	3	MM800E15YE112	E-STOP LEGEND PLATE
36	1	1393615	GRABBER TOOL, 36"	78	*6	MM9307K69	GROMMET,1" OD
37	1	1393676	ENCODER ASSEMBLY	79	12	MM98335A04	SPRING CLIP, .06 WIRE
38	1	1393770	FRONT GUARD ASSY	80	1	MMT9945	TAPE,REFLECTIVE,2" WIDE
39	*1	1393E-CAB1	CABLE PACKAGE, 1393E	81	1	NNH3/8-16	NUT,HEX,3/8-16
40	*1	1393E-LAB1	BACK PLATE,LABEL	82	1	SSHC25224F	3/8-16 X 3.5 HEX CAP, FULL THD
41	*1	1393E-LAB2	TERMINAL WIRING LABELS,1393E	83	1	ZX5031	V-BELT,1/2X31
42	*1	1393-LAB4	LABELS,DOORS CLOSED				

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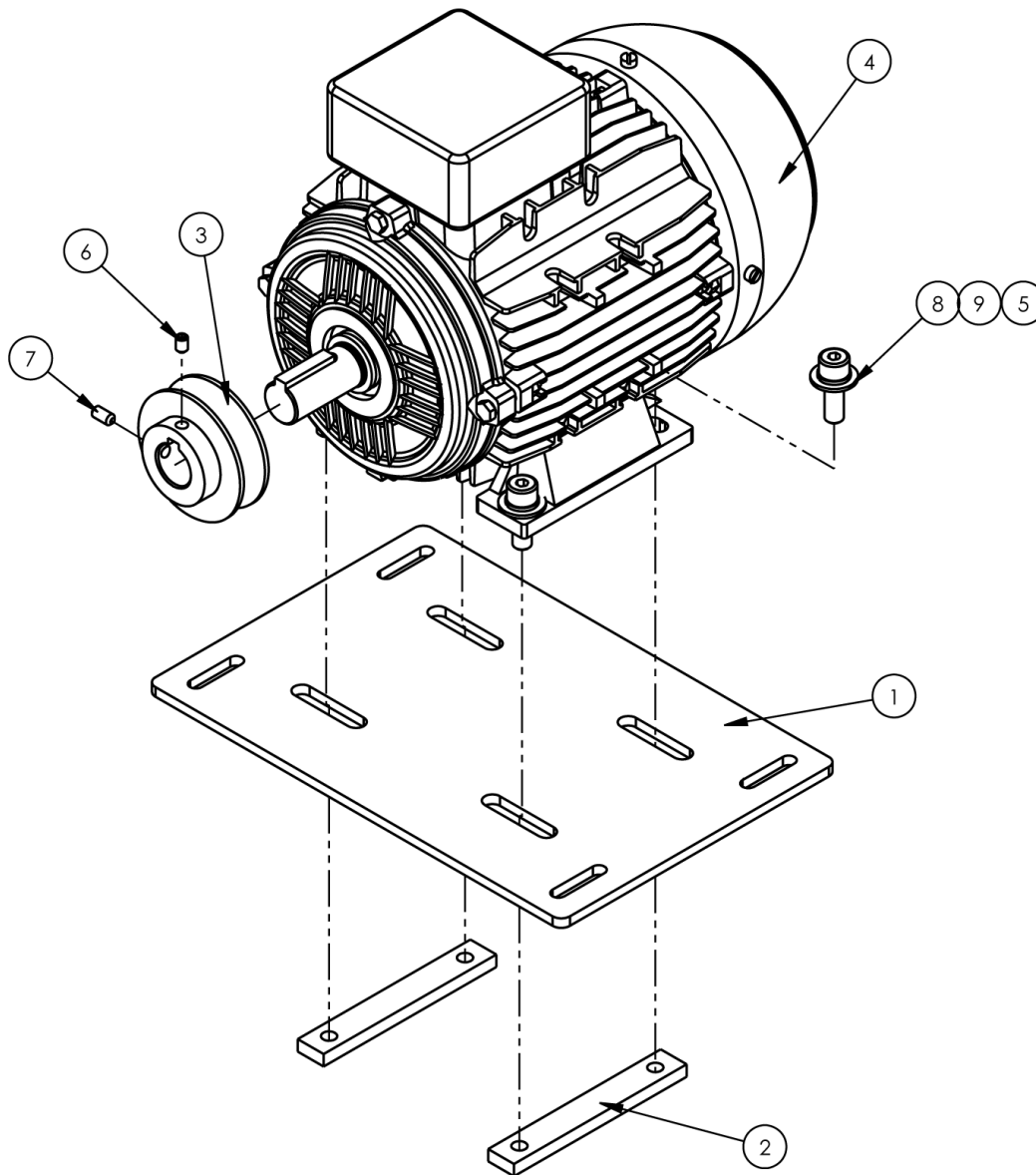




1388232 Sub Frame Assembly

AAC Drawing Number 1388232 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	1388233	FRAME, ASSEMBLY
2	1	1388276	SLITTER, MOTOR DRIVE ASM
3	1	1388317	TOP ROLLER ASSEMBLY
4	1	1388328	INFEEED DRIVE ROLLER ASM
5	1	1388331	INFEEED ROLL DRIVE ASM
6	1	1388333	BORDER LIFT ROLL ASM
7	1	1388337	OUTFEED MOTOR DRIVE ASM
8	1	1388343	OUTFEED DRIVE ROLL ASM
9	1	1388347	XCUT CLAMP ASSEMBLY
10	1	1388351	PANEL CUTTER LEG ASSEMBLY
11	2	1388381	CYLINDER BKT, MOUNTING
12	1	1388407	BRACKET, SHARPENER, RH
13	2	1388568	WASHER PLATE, OUTFEED ROL
14	1	1388569	PLATE,VERT, OUTFEED DRV,L
15	1	1388572	DANCER ASSEMBLY
16	1	1388581	PANEL,BACK RIGHT
17	1	1388582	PANEL,BACK LEFT
18	1	1388583	PANEL,FRONT LEFT
19	1	1388584	PANEL, FRONT LEFT WELDMNT
20	1	1388642	BRACKET,CUT TABLE
21	1	1388662	PLATE, TABLE SUPPORT
22	1	1389060	EXIT ROLLER ASSEMBLY
23	1	1389078	MATERIAL SENSOR, X CUT
24	1	1393029	SLITTER SHARPENER ASSY
25	2	1393716	CYLINDER BRIDGE, LEFT
26	4	AA198RA408U	FLOW CONTROL,RC 1/8X1/4
27	2	AACDNC50150PPV	CYLINDER,AIR,50B,150S
28	2	AACDNCB3280PPVA	CYLINDER,AIR,ISO,32X80
29	2	AACDNCB50100PPVA	CYLINDER,AIR,ISO,50BX100
30	2	AACDNCB5080PPVA	CYLINDER,AIR,ISO,50BX80
31	2	AAFSGM10X1_25	CLEVIS,ROD,M10X1.25
32	6	AAFSGM16X1.5	CLEVIS ROD M16X1.5
33	2	AAFSNC32	FLANGE,SWIVEL,DNCB-32
34	6	AAFSNC50	FLANGE, SWIVEL, FOR DNCB50
35	2	AAFSNCS32	FLANGE,SWIVEL,SNCS-32
36	6	AAFSNCS50	CLEVIS SINGLE REAR W/PIN
37	2	AAN103X235	MUFFLER,1/4" PUSH IN
38	1	AAQBU-3-3	Bulkhead Union
39	4	BBGRFT205-25	BEARING, FLANGE,25MM
40	2	BBNAP205-25	BEARING, PILLOWBLOCK
41	2	CCCLMSP20F	CLAMP COLLAR- M20
42	3	MMUCP206-20	PILLOW BLOCK BEARING,UCP-206-20

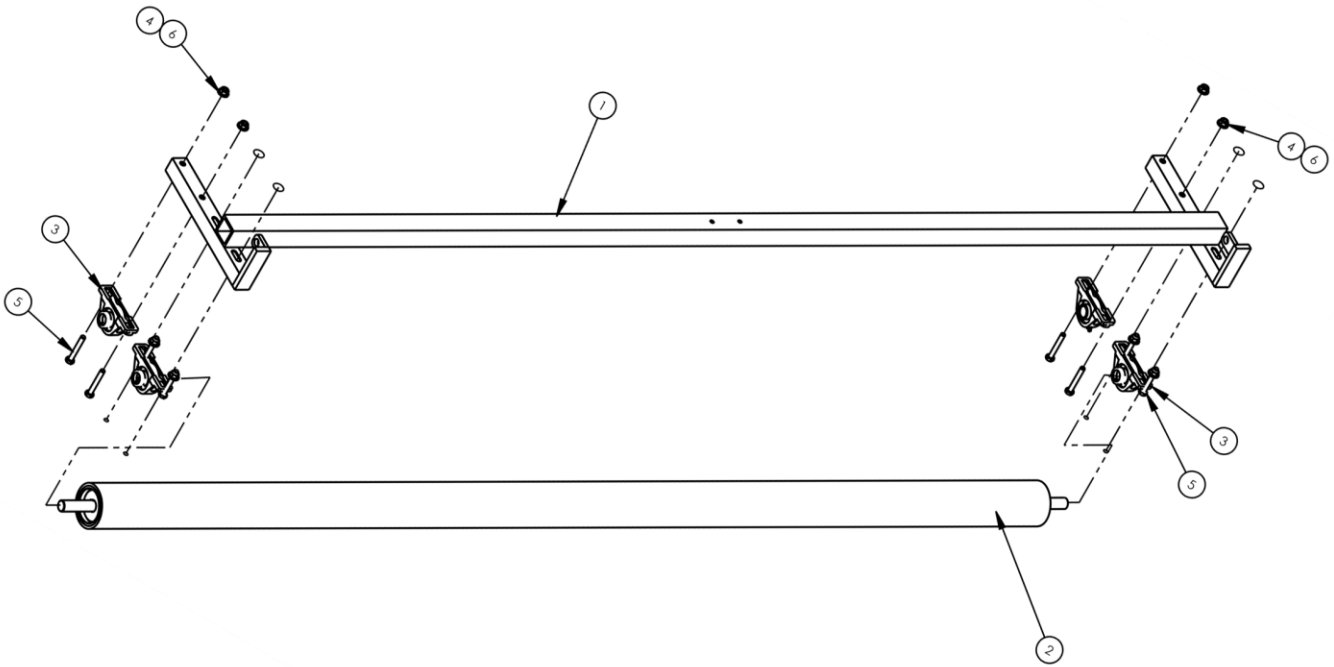


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1388276 Slitter Motor Drive Assembly

AAC Drawing Number 1388276 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1388263	PLATE, MOTOR MOUNT
2	2	1388264	NUT PLATE, MOTOR MOUNT
3	1	1389606	PULLEY, SLITTER MOTOR
4	1	MM90S11B3	MOTOR, 1.1KW, IEC, B3, 1.5HP
5	4	SSSCM10X30	10M X 30MM, SOC CAP
6	1	SSSS01024	SCREW, SET, 1/4-20 X 3/8
7	1	SSSS01032	1/4-20 X 3/8 NYLON PT
8	4	WWFM10	WASHER, FLAT, M10 I.D.
9	4	WWLM10	M10 LOCK WASHER

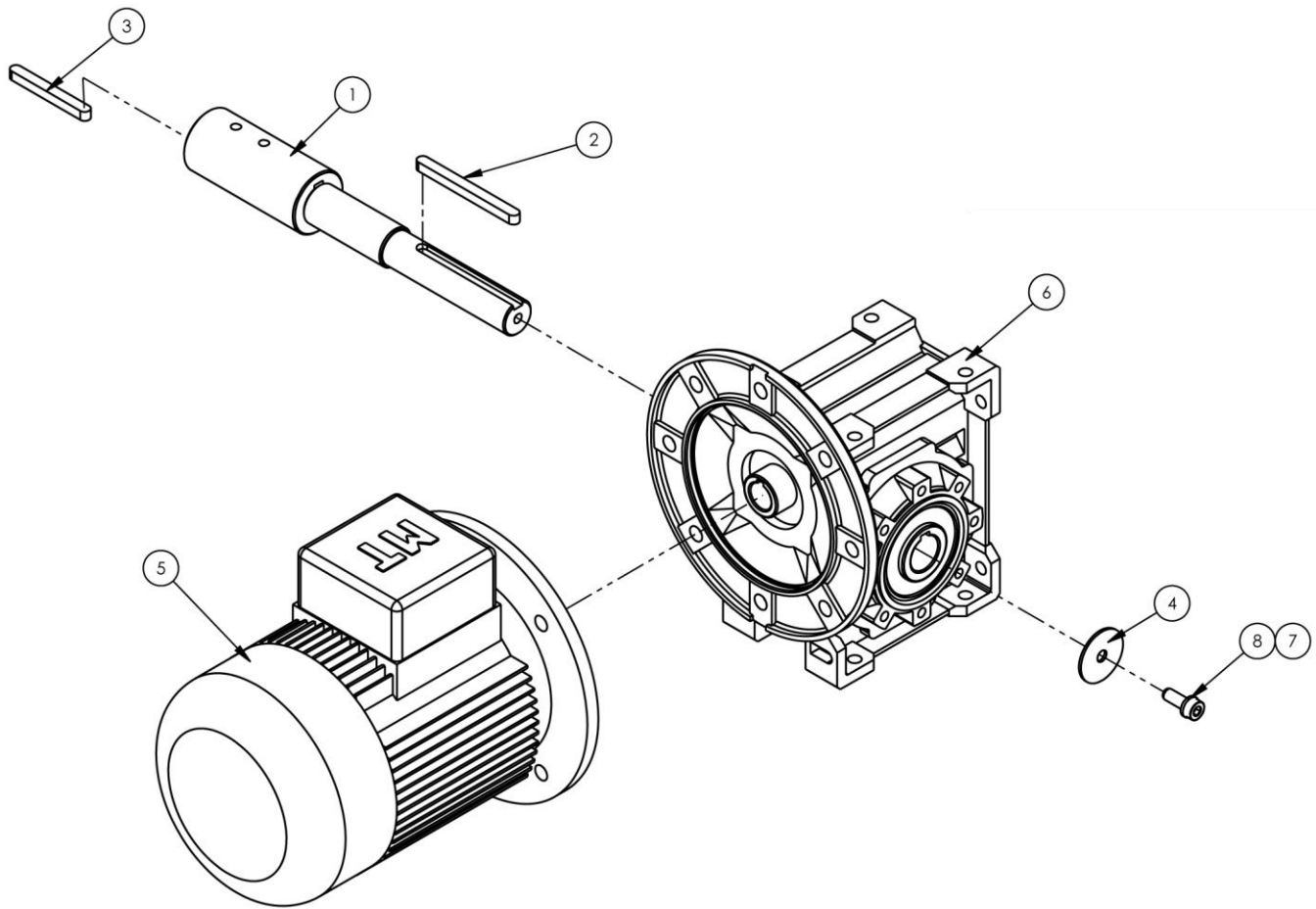


From the library of: Diamond Needle Corp

1388317 Top Roller Assembly

AAC Drawing Number 1388317 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1388318	TOP ROLLER WELDMENT
2	1	1388325	INFEED PINCH ROLLER ASM
3	4	BBNAP205-25	BEARING, PILLOWBLOCK
4	8	NNEM10-1.5	NUT,ELASTIC LOCK,M10
5	8	SSHCM10X70	SCREW,HEX CAP,M10-1.5X70
6	8	WWFM10	WASHER, FLAT, M10 I.D.

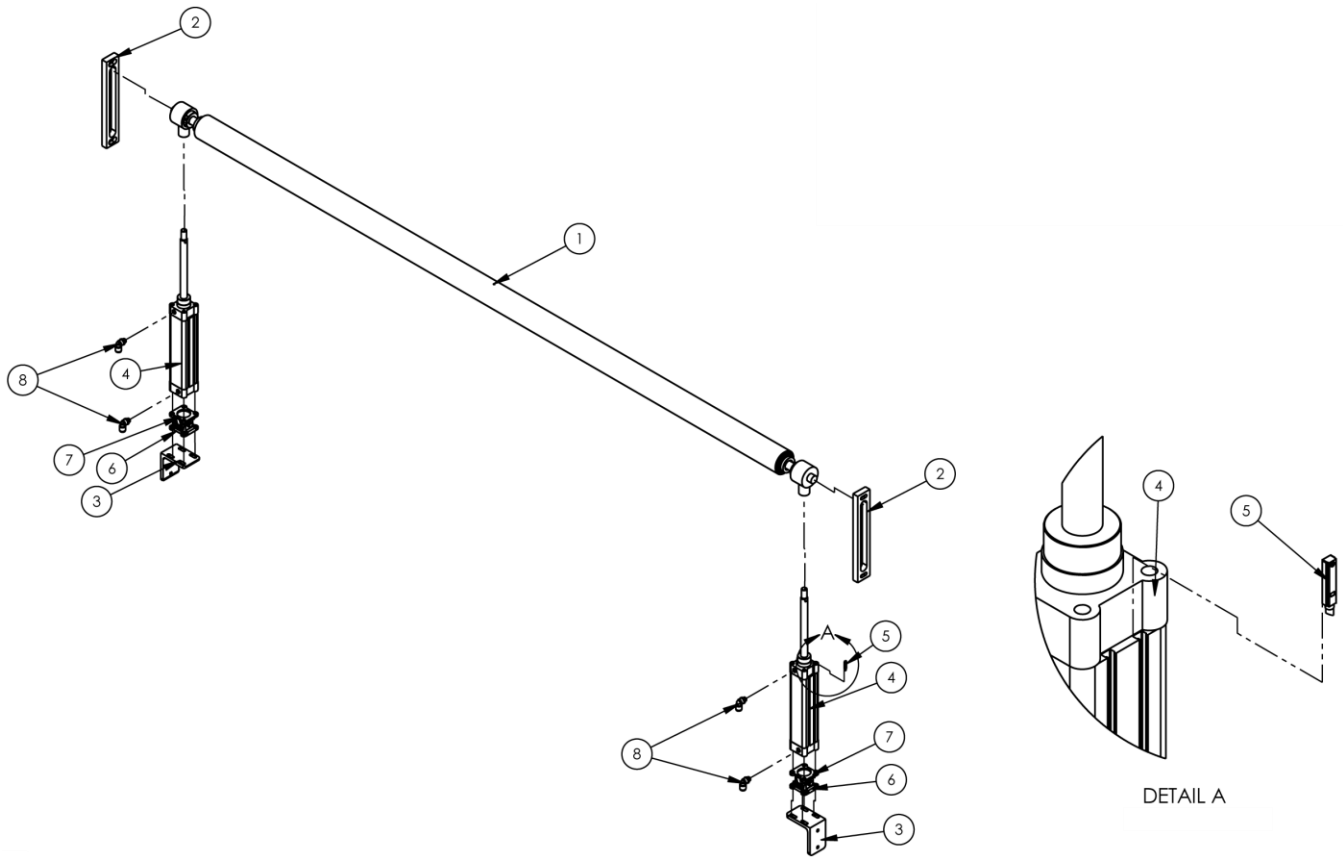


From the library of: Diamond Needle Corp

1388331 Infeed Roll Drive Assembly

AAC Drawing Number 1388331 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1388329	STUB,DRIVE SHAFT BEARBOX
2	1	1388330	KEY, INFEED DRIVE
3	1	1388332	KEY, INFEED PULL ROLLER
4	1	1393364	RETAINER WASHER
5	1	MM80B4B5	MOTOR,.75KW,IEC,B5,D80
6	1	MMRV6340D80	GEARBOX, WORM,RV63,40:1
7	1	SSSCM8X20	M8X20 SOC CAP
8	1	WWLM8	M8 LOCK WASHER

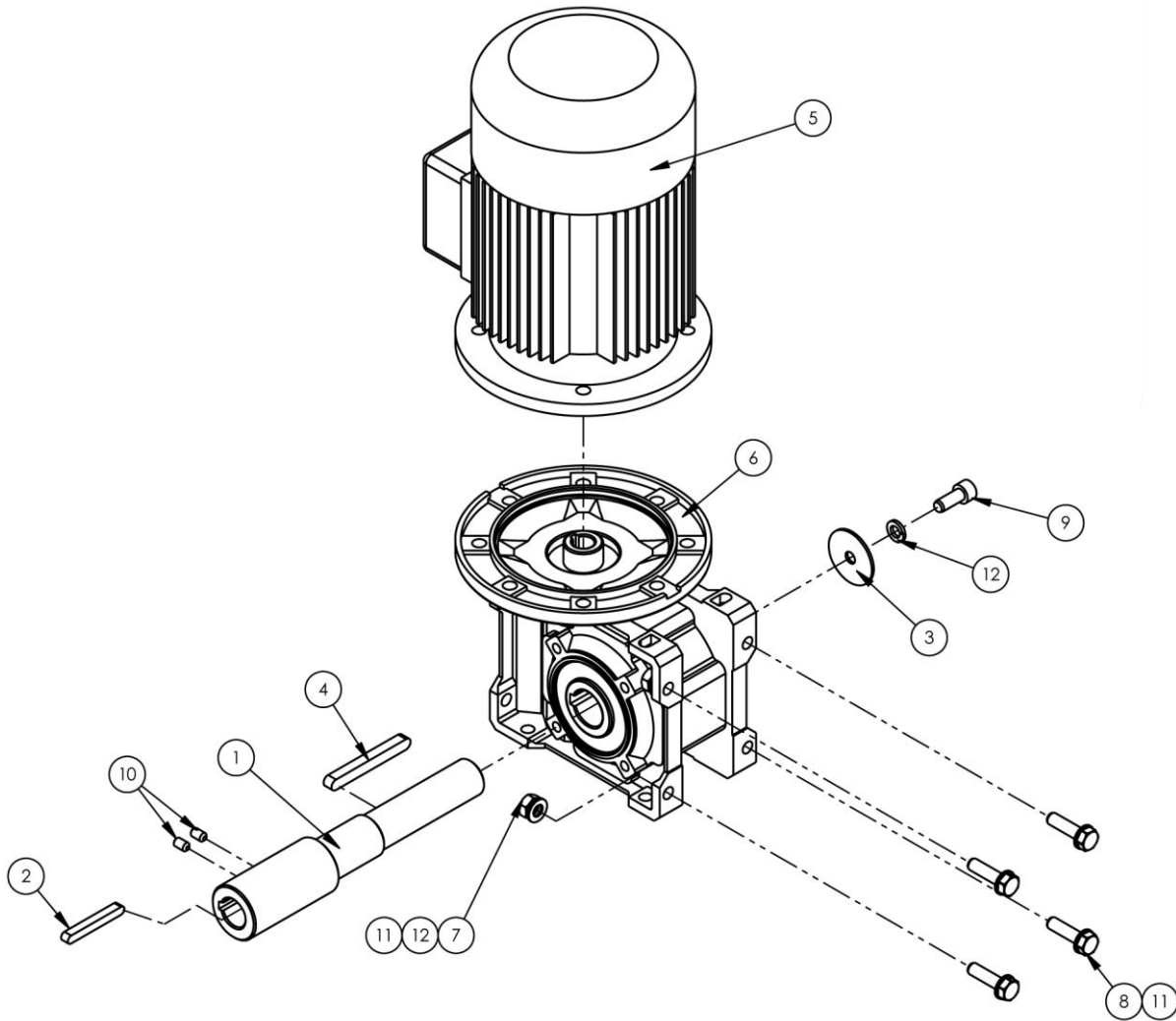


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1388333 Border lift Roll Assembly

AAC Drawing Number 1388333 Rev 1

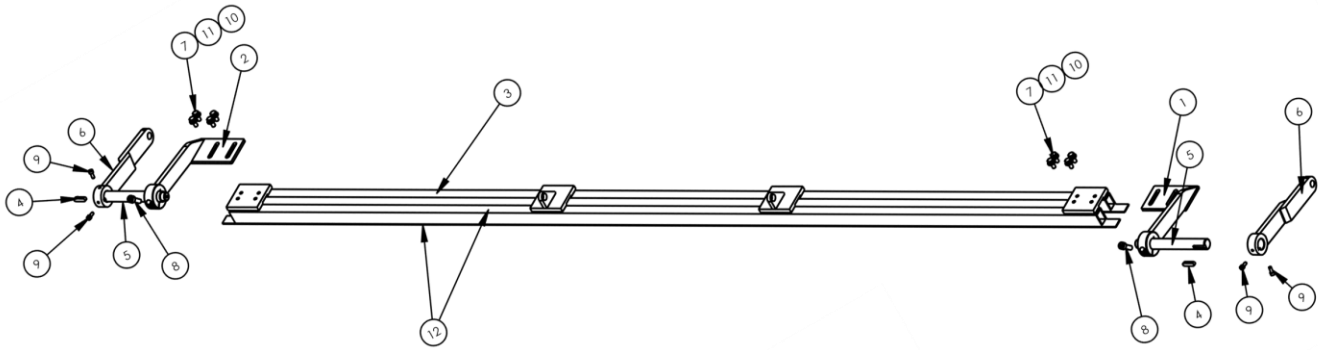
NO.	QTY	PART #	DESCRIPTION
1	1	1388273	SLITTER ROLLER LIFT ASM
2	2	1389087	GUIDE
3	2	1389122	CYLINDER MOUNT
4	2	AACDNC50200PPVA	CYLINDER,AIR,ISO,50B,200S
5	1	AAESME8KLED24	SENSOR FOR FESTO DNCB CYL
6	3	AAFSNC50	FLANGE, SWIVEL, FOR DNCB50
7	2	AAFSNCS50	CLEVIS SINGLE REAR W/PIN
8	4	AAQME-3-4U	MALE ELBOW,3/8OD TUBE 1/4



1388337 Outfeed Motor Drive Assembly

AAC Drawing Number 1388337 Rev 0

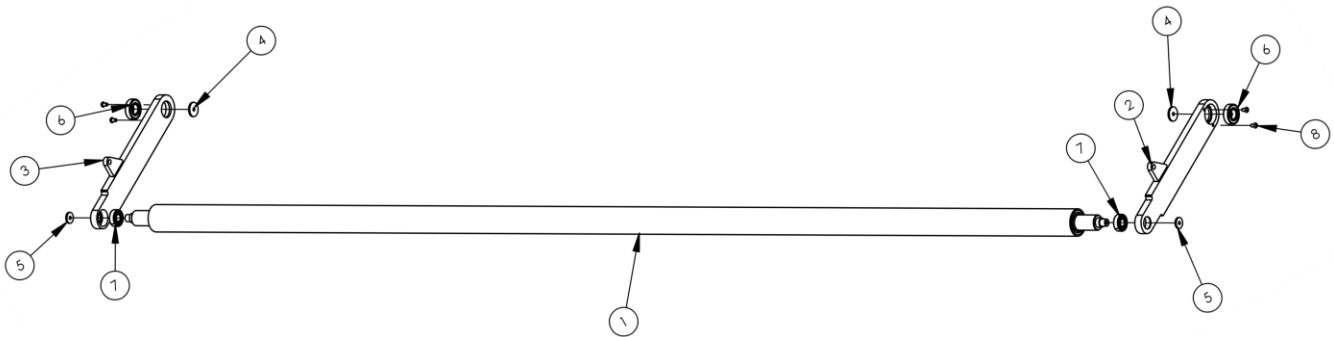
NO.	QTY	PART #	DESCRIPTION
1	1	1388336	STUB, DRIVE SHAFT GEARBOX
2	1	1388338	KEY, 6X6X50
3	1	1393364	RETAINER WASHER
4	1	1393369	KEY, GEARMOTOR
5	1	MM71B4B5	MOTOR, .37KW, IEC, B5
6	1	MMRV5030D71	GEARBOX, WORM, RV50, 30:1
7	4	NNHM8X1.25	M8 X 1.25 HEX NUT
8	4	SSHCM8X30	SCREW, HEX CAP M8X40
9	1	SSSCM8X20	M8X20 SOC CAP
10	2	SSSSM6X10	M6 SET SCREW, 10MM L
11	8	WWFM8	WASHER, FLAT, M8 I.D.
12	5	WWLM8	M8 LOCK WASHER



1388347 Xcut Clamp Assembly

AAC Drawing Number 1388347 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1388176	CLAMP ARM,LEFT, WELDMNT
2	1	1388344	CLAMP ARM,RIGHT,WELDMNT
3	1	1388348	CROSS CUT CLAMP WELDMNT
4	2	1388350	KEY,M8X7X32
5	2	1389062	PIVOT SHAFT
6	2	1393710	LEVER ARM WELDMENT
7	8	SSHCM8X20	SCREW,HEX CAP
8	2	SSSCM10X30	10M X 30MM, SOC CAP
9	4	SSSCM6X15	M6X15 SOC CAP SCREW
10	8	WWF1/4	WASHER, FLAT, 1/4", COM
11	8	WWLM8	M8 LOCK WASHER
12	2	MM5109K25	FOAM SILICONE 3/32 X 1"

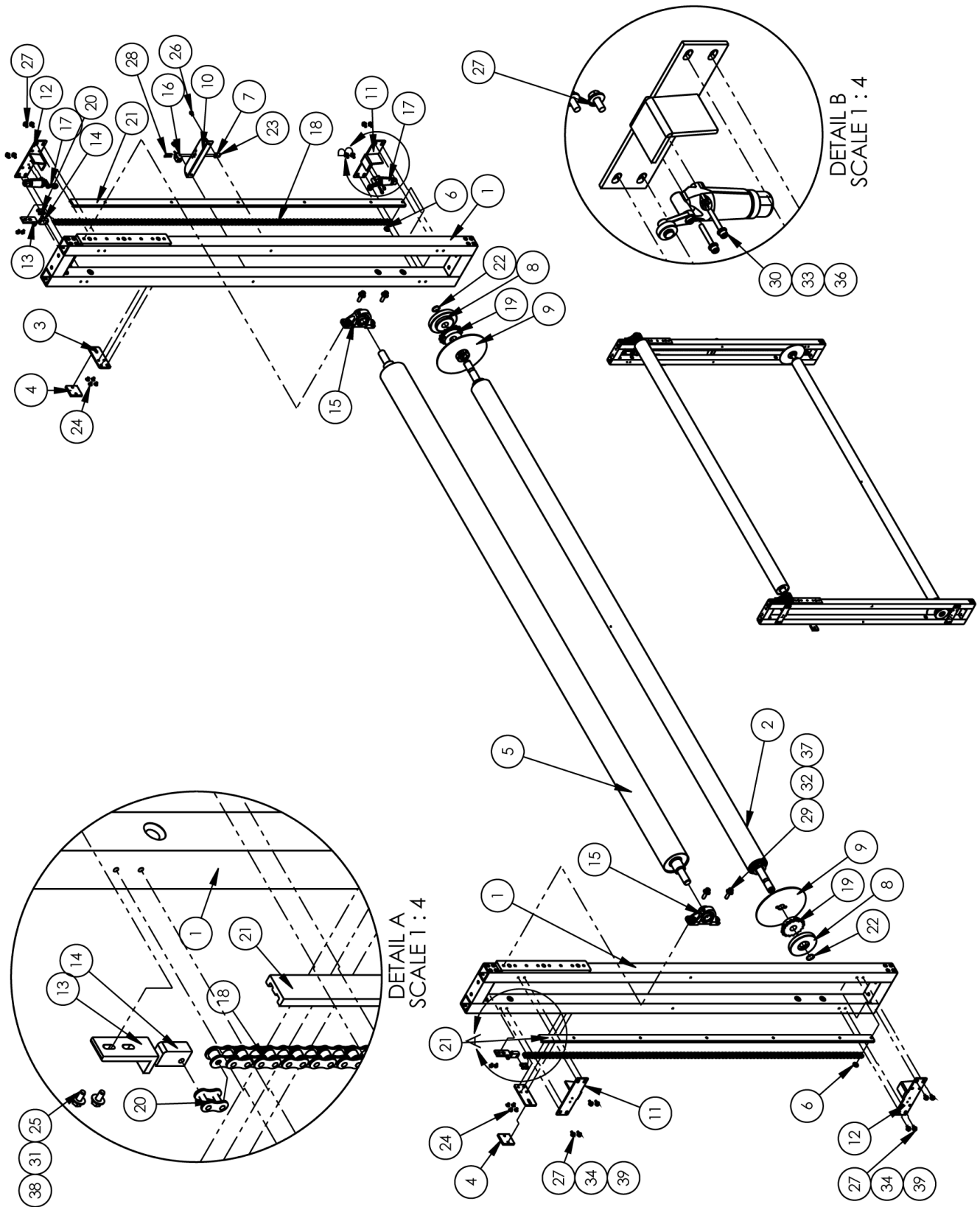


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1389060 Exit Roller Assembly

AAC Drawing Number 1389060 Rev 2

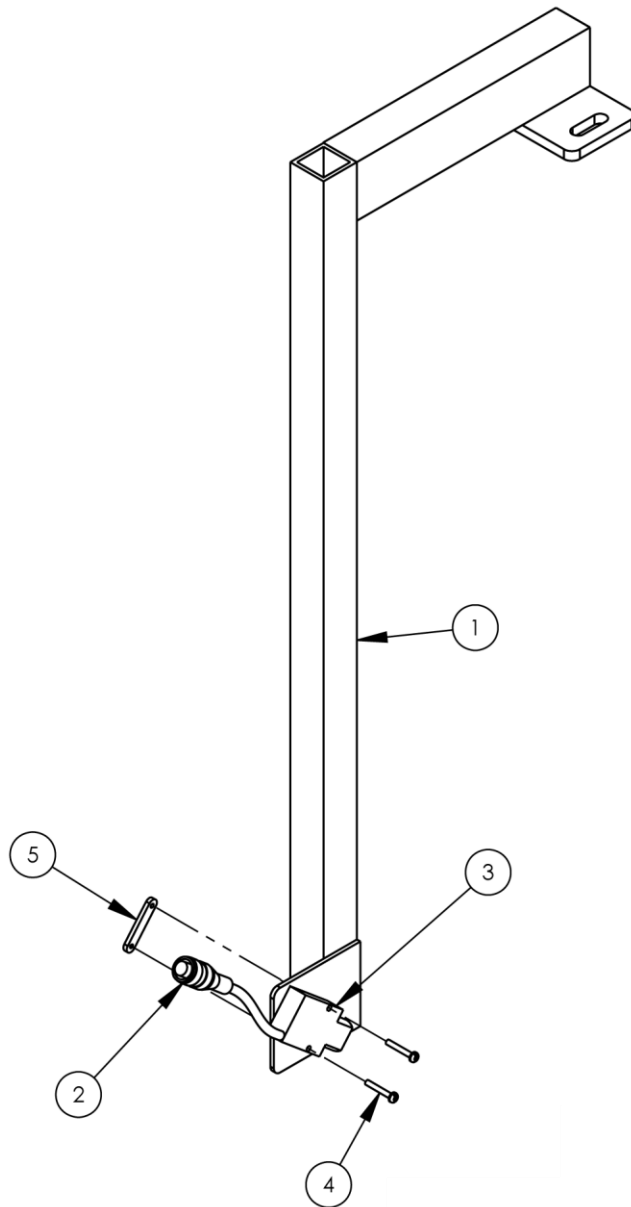
NO.	QTY	PART #	DESCRIPTION
1	1	1388429	OUTFEED UPPER ROLLER ASM
2	1	1389058	PIVOT ARM WELDMENT RT
3	1	1389059	PIVOT ARM WELDMENT LEFT
4	2	1389063	BEARING KEEPER
5	2	1389132	BEARING KEEPER
6	2	BB60042RS	BEARING,BALL,20 ID,42 OD
7	2	BB62022RS	BEARING, RADIAL, SEALED
8	4	SSBCM6X10	SCREW,SOCKET CAP



1388572 Dancer Assembly

AAC Drawing Number 1388572 Rev 4

NO.	QTY	PART #	DESCRIPTION
1	2	1388571	DANCER FRAME ASSEMBLY
2	1	1388578	DANCER ROLLER ASM
3	2	1388593	PLATE, REAR GUARD MOUNT
4	2	1388676	PLATE,NUT,M8 TAPPED
5	1	1389110	ROLLER, BSW
6	2	1392900	WASHER, CHAIN HOLDOWN
7	1	1393373	PLATE, NUT, 4-40
8	2	1493222	WHEEL, RETAINER FOR
9	2	1493226	EDGE GUIDE ASSY
10	1	1493232	MOUNT, ACCUMULATOR PROX.
11	2	1493233	BRACKET, LIMIT, LOWER
12	2	1493234	BRACKET, LIMIT, UPPER
13	2	1493507	BRKT,BELT TENSION
14	2	1493508	BLOCK,TENSION
15	2	BBNAP205-25	BEARING, PILLOWBLOCK
16	1	EENI5Q18AN6X	SENSOR, PROX. NPN,10-30DC
17	2	FFEVN2000A	LIMIT SWITCH ASSEMBLY
18	2	MM50	CHAIN, SINGLE STRAND
19	2	MM50B17M	STEEL SPROCKET,17T,5/8P
20	2	MM50L	LINK,MASTER,5/8P,SGL STRD
21	2	MM93095K32M	GUIDE, CHAIN WITH HOLES
22	2	MMSH-98	RING,SNAP,EXTERNAL
23	2	NNH4-40	NUT,HEX,#4-40
24	8	SSFCM6X10	M6 X 20 FLAT ALLEN
25	4	SSHCM5X12	SCREW, HEX CAP
26	2	SSHCM6X12S	SCREW, HEX M6X12 SS
27	16	SSHCM6X16	SCREW, HEX M6X16
28	2	SSSC70064	4-40 X 1 SOCKET CAP
29	4	SSSCM10X35	CAP SCREW 10MM X 35MM
30	2	SSSCM4X30	SCREW,SOC CAP,M4-0.7X30
31	4	WWF10	WASHER, FLAT, #10, COM
32	4	WWFM10	WASHER, FLAT, M10 I.D.
33	2	WWFM4.3	WASHER, FLAT, M4
34	16	WWFS1/4	WASHER,FLAT,SAE,1/4
35	2	WWL4	WASHER,LOCK,#4
36	2	WWL8	WASHER,LOCK,#8
37	4	WWLM10	M10 LOCK WASHER
38	4	WWLM5	M5 LOCK WASHER
39	18	WWLM6	M6 LOCK WASHER

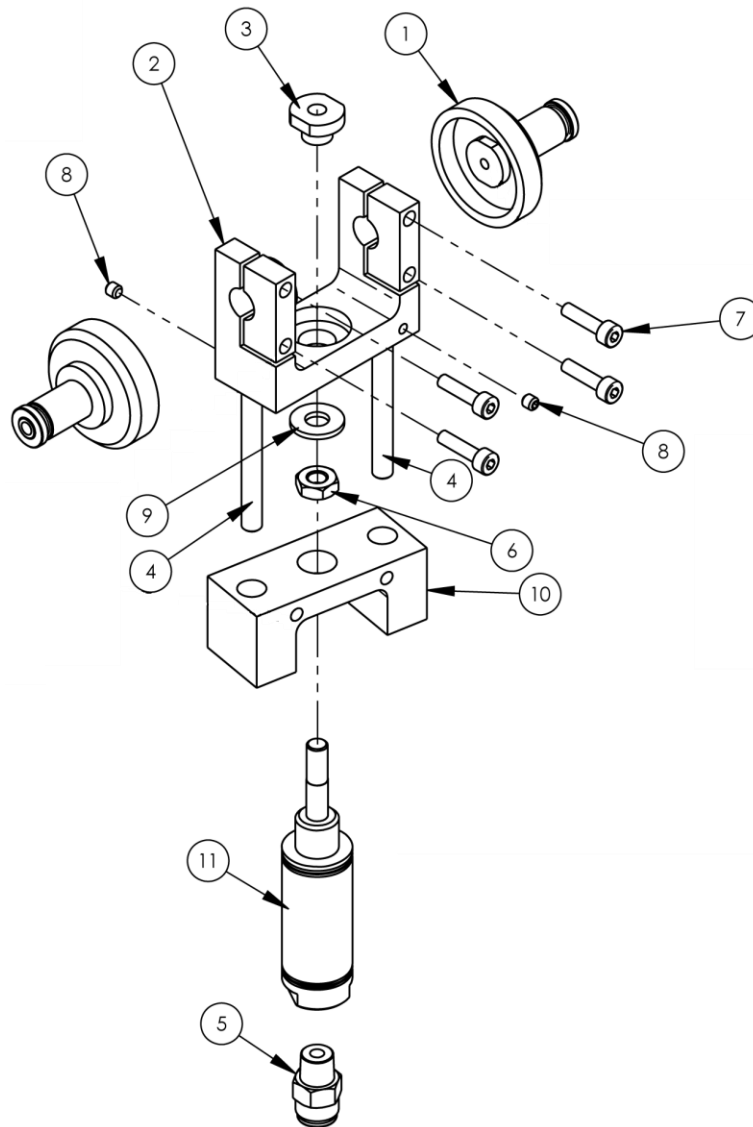


From the library of: Diamond Needle Corp

1389078 X cut Material Sensor

AAC Drawing Number 1389078 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1389075	EYE MOUNTING BRACKET
2	1	FFRK44T-4	CABLE,EYE,12',NO END
3	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
4	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
5	1	1975-412A	PLATE,NUT,4-40,.95CTC

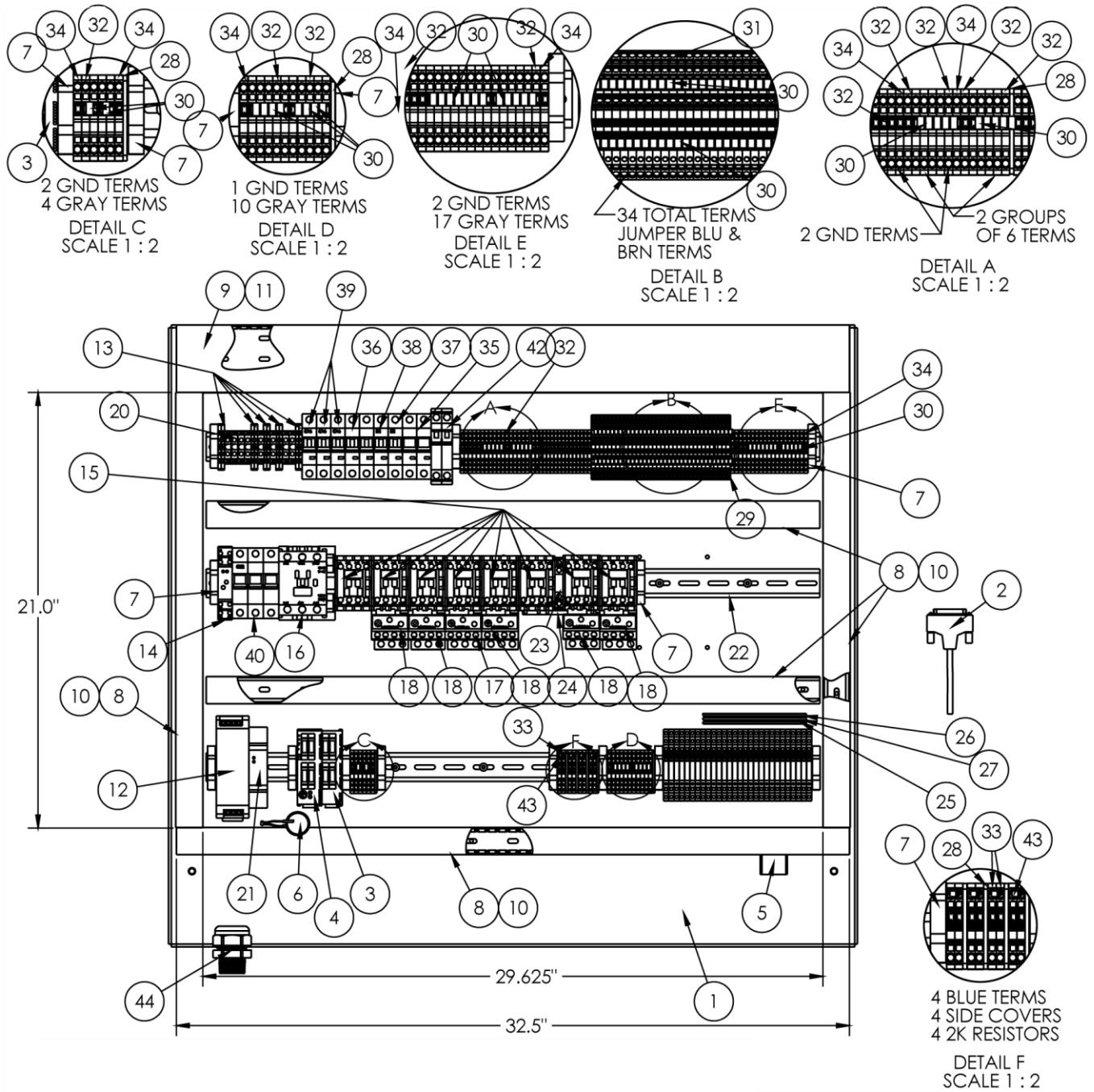


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1393029 Slitter Sharpener Assembly

AAC Drawing Number 1393029 Rev 4

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	1393003	SHARPENER STONE MT	7	4	SSSCM4X16	SCREW, SOCKET CAP
2	1	1393028	BRKT, STONE MTG	8	2	SSSSM4X4	M4 SET SCREW, 4MM L
3	1	1393030	NUT, FLOATING, M6	9	1	WWFS1/4	WASHER, FLAT, SAE, 1/4
4	2	1393031	ROD, GUIDE, 6MM DIA	10	1	1393032	BRKT, CYL MTG
5	1	AAQMC-4-8	QUICK MALE CONN, 1/4X1/8	11	1	AAC7S-.5	CYLINDER, AIR, SA
6	1	NNJ1/4-28	NUT, HEX, JAM, 1/4-28				



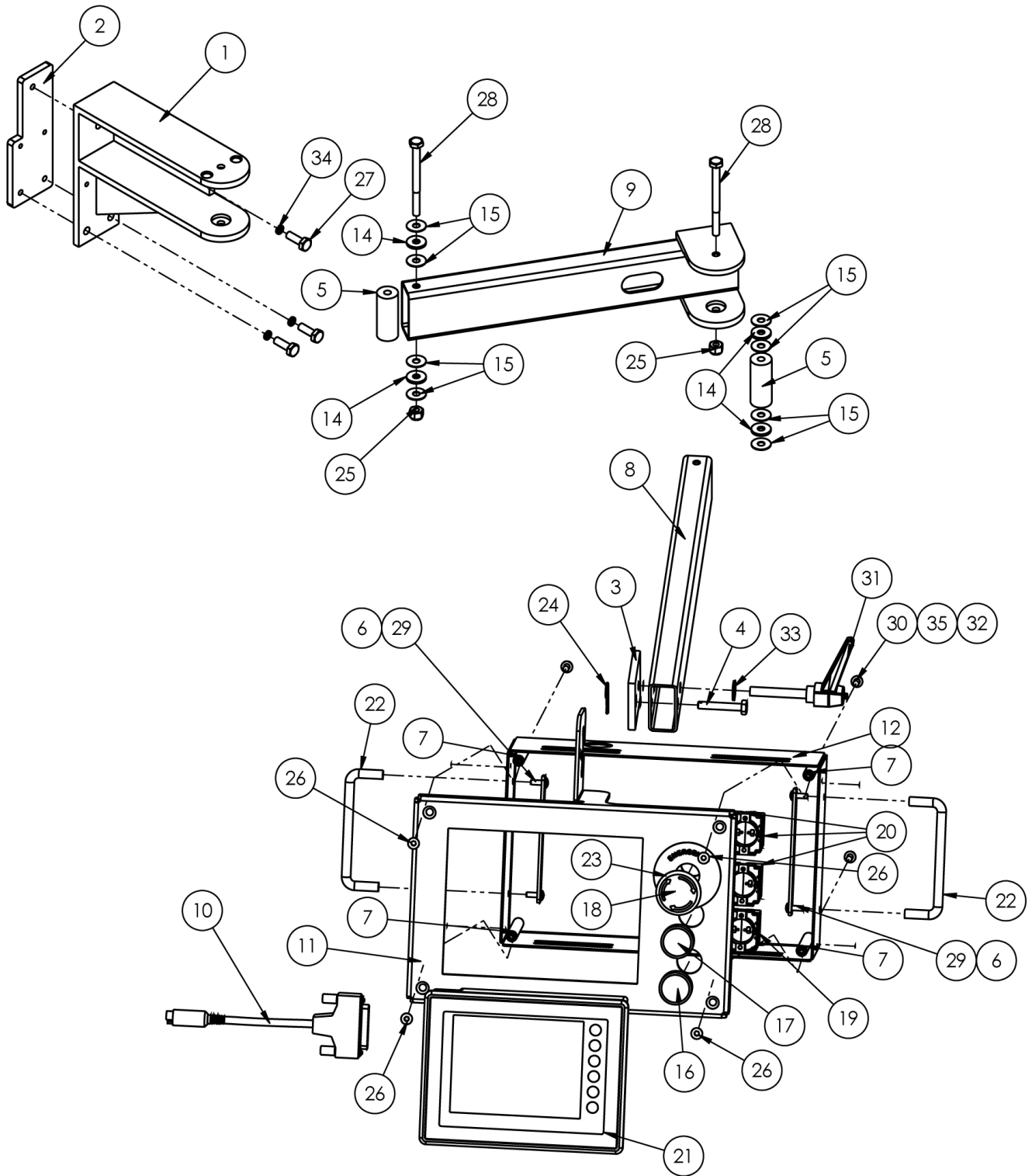
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1388303 Back Panel Electrical Assembly

AAC Drawing Number 1388303 Rev 8

NO.	QTY	PART #	DESCRIPTION
1	1	1388306	BACK PANEL WELDMENT
2	1	1389882	CABLE, TOUCHSCREEN, ASSY
3	1	AAFP0-E32T-A	EXPANSION UNIT, PLC
4	1	AAFG-C32TH	CONTROLLER, PLC, SIGMA
5	1	EE64151B	FERRITE CORE,SPLIT,CABLE
6	1	EEAFPG804	BATTERY,BACKUP,PLC
7	13	EECLIPFIX	ANCHOR,DIN RAIL
8	3.5 FT	EEDC1LG	DUCT,WIRE COVER,1"
9	2.7 FT	EEDC3X2	DUCT,WIRE COVER,3"
10	3.5 FT	EEDF1X2	DUCT,WIRE,1X2
11	2.7 FT	EEDF3X2	DUCT,WIRE,3X2
12	1	EEDR12024	POWER SUPPLY, 24VDC
13	5	EEEK635	TERMINAL BLOCK, EK2.6/35
14	1	EEHRN56240	RELAY,3-PHASE MONITOR
15	8	EEMC12B11	CONTACTOR,IEC,230VAC
16	1	EEMC32A22	CONTACTOR,IEC,230VAC
17	1	EEMT32S6A	RELAY,OVERLOAD,4.0-6.0A
18	5	EEMT32S25A	RELAY,OVERLOAD,1.6-2.5A
19	28	EEPIR6W1P24	RELAY,INTERFACE,24VDC
20	8	EESAK6EN	TERMINAL BLOCK, SAK6/EN
21	1	EESR103AM01	SAFETY RELAY, DUAL CHAN.
22	88.88"	EETS35X7.5A	DIN RAIL-AMERICAN
23	1	EEUR02	MECHANICAL INTERLOCK
24	1	EEUW22	WIRE KIT, REVERSING
25	* 2	EEZG20-1	JUMPER,RELAY,RED
26	* 2	EEZG20-2	JUMPER,RELAY,BLACK
27	* 2	EEZG20-3	JUMPER,RELAY,BLUE
28	7	FF280-308	TERMBLK ENDPLATE, WAGO,280
29	1	FF280-319	TERMBLK,WAGO,SENSOR,DIN
30	100	FF280-402	JUMPER,WAGO,TOP,SNGL
31	34	FF280-560	TERMBLK,WAGO,SENSOR,DIN
32	62	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY
33	8	FF280-904	TERMBLK,WAGO,TOP,SNGL
34	7	FF280-907	TERMBLK,WAGO,TOP,SNGL,GRN
35	1	FFL722C	BREAKER, CIRCT. THERM-MAG
36	1	FFL762C	CIRCUIT BREAKER,THERM-MAG
37	1	FFL821B	CIRCUIT BREAKER,B-CURVE
38	1	FFL841B	CIRCUIT BREAKER,B-CURVE
39	3	FFL7161C	CIRCUIT BREAKER,THERM-MAG
40	1	FFL7323C	CIRCUIT BREAKER,THERM-MAG
41	700	FFLS11427	LABELS,AAC ROUND,BLK/WHT
42	1	FFQL213DMKM10	CIRCUIT BREAKER,10A,2P
43	4	FFR2K	RESISTOR, 2K, 1/4W
44	1	MM69915K72	STRAIN RELIEF, LIQ TIGHT
45	21	SSBCM5X8	SCREW,BUTTON CAP

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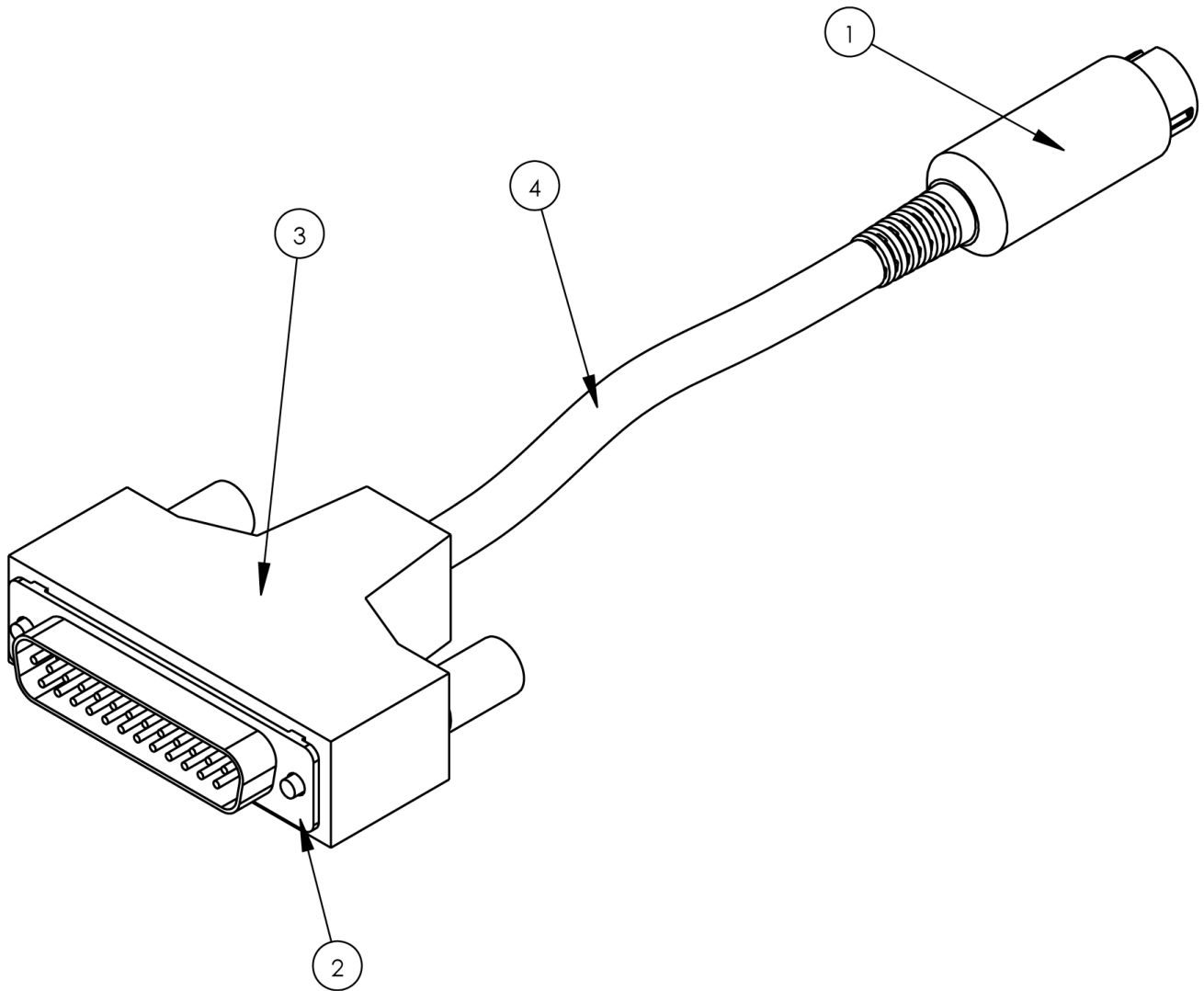


1388415 Swivel Arm Assembly

AAC Drawing Number 1388415 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	0411-114	WELDMENT,SWIVEL BASE
2	1	0411-3705	NUT PLATE,BASE MOUNT
3	1	0411-3708	NUT PLATE,BOX MOUNT
4	1	0411-3709	LOCK PIN
5	2	0411-3712	TUBE, SPACER, TALL
6	2	1379215	PLATE, WASHER, HANDLE
7	4	1388685	STANDOFF, .5" X 3",M5
8	1	1389681	TUBE,12 L,PIVOT ARM
9	1	1389701	WLDMT,PIVOT ARM
10	1	1389747	CABLE, TOUCHSCREEN, ASSY
11	1	1389870	MOUNT,TOUCHSCREEN
12	1	1389872	COVER,BACK,TOUCHSCREEN
*13	1	1393E-LAB1	PANEL BACK,LABEL
14	4	BBNTA411	BEARING,THRUST, .250B
15	8	BBTRA411	WASHER,THRUST,STEEL
16	1	EE2AF3	OPERATOR, FLUSH,GREEN
17	1	EE2AF4	OPERATOR, FLUSH,RED
18	1	EE2AML4	OPERATOR, E-STOP,RED
19	2	EES1	CONTACT BLOCK, NO
20	3	EES2	CONTACT BLOCK, NC
21	1	EEV606EM20	TOUCH SCREEN FOR 1393
22	2	MM1568A45	HANDLE,DOOR,PULL
23	1	MM98335A04	SPRING CLIP, .06 WIRE
24	2	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
25	4	SSFCM5X10	SCREW,FLAT ALLEN CAP
26	3	SSHCO1048	1/4-20 X 3/4 HEX CAP
27	2	SSHCO1192	HEX HEAD BOLTS, 1/4-20 X
28	4	SSPP90032	SCREW, PAN HD PHILLIPS,8-32X1/2
29	4	SSPP98032	10-32 X 1/2 PAN PHIL
30	1	TTH32429	HANDLE,THRD,5/16-18X2.0
31	4	WWFM5	WASHER, FLAT, M5 I.D.
32	1	WWFS5/16	WASHER,FLAT,SAE,5/16
33	3	WWL10	WASHER,LOCK,#10
34	4	WWLM5	M5 LOCK WASHER
35	1	MM800E15YE112	E-STOP LEGEND PLATE

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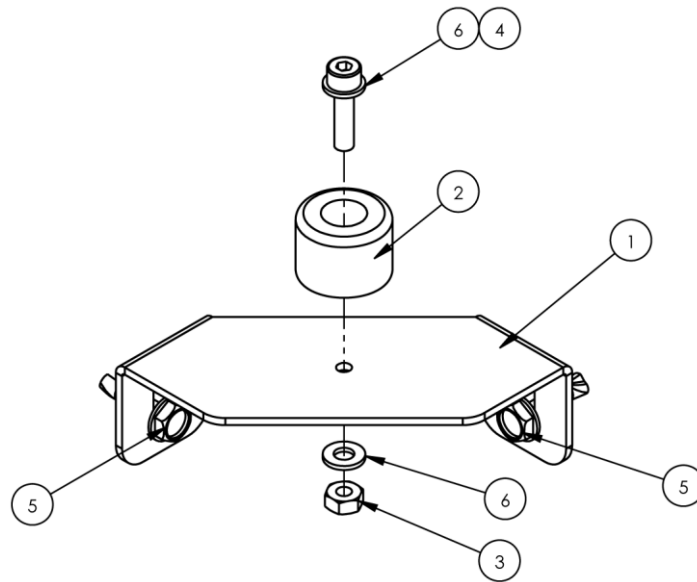


From the library of: Diamond Needle Corp

1389747 Touchscreen Cable Assembly

AAC Drawing Number 1389747 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	EEMD50	CONN, MINI DIN, 5 PIN, F
2	1	FF17454968	CONN,25 PIN D,M,IDC, 22-2
3	1	FF7451341	CONN,25PIN D,F,SHIELD,BLK
4	* 20 FT	FF8302	CABLE,4 COND,22 AWG

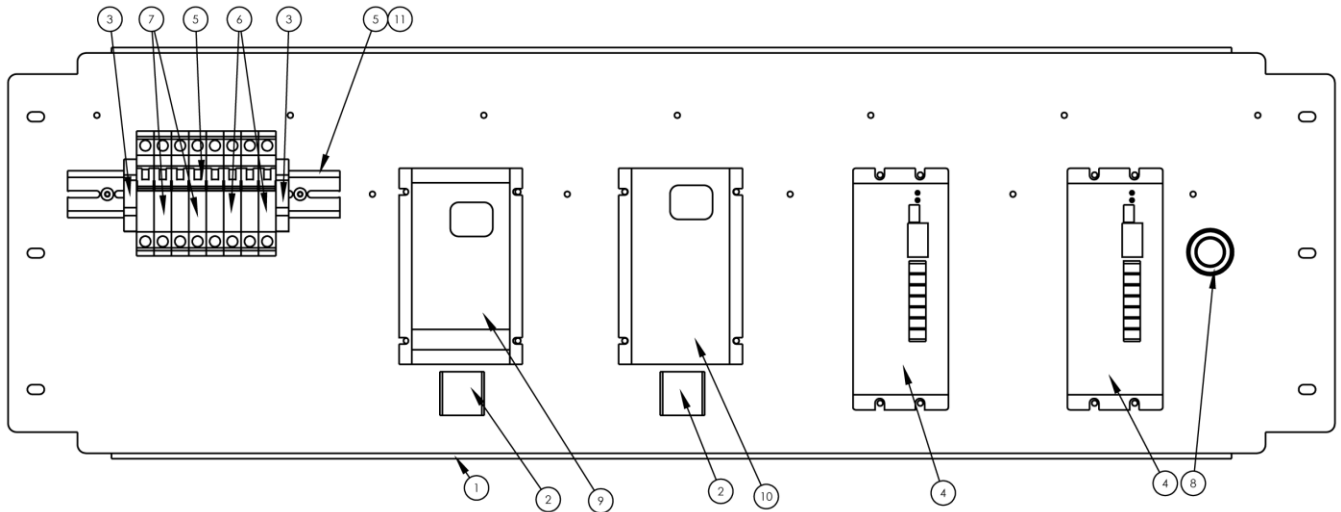


From the library of: Diamond Needle Corp

1388559 Door Stopper/Bumper Assembly

AAC Drawing Number 1388559 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1388557	PLATE, DOOR STOP
2	1	MM9540K22	BUMPER, 3/4 DIA
3	1	NNHM4X0.7	NUT, HEX, M4-0.7
4	1	SSSCM4X16	SCREW, SOCKET CAP
5	2	SSZS93048	SCREW, SHT. METAL 10 ZIP
6	2	WWFM4.3	WASHER, FLAT, M4

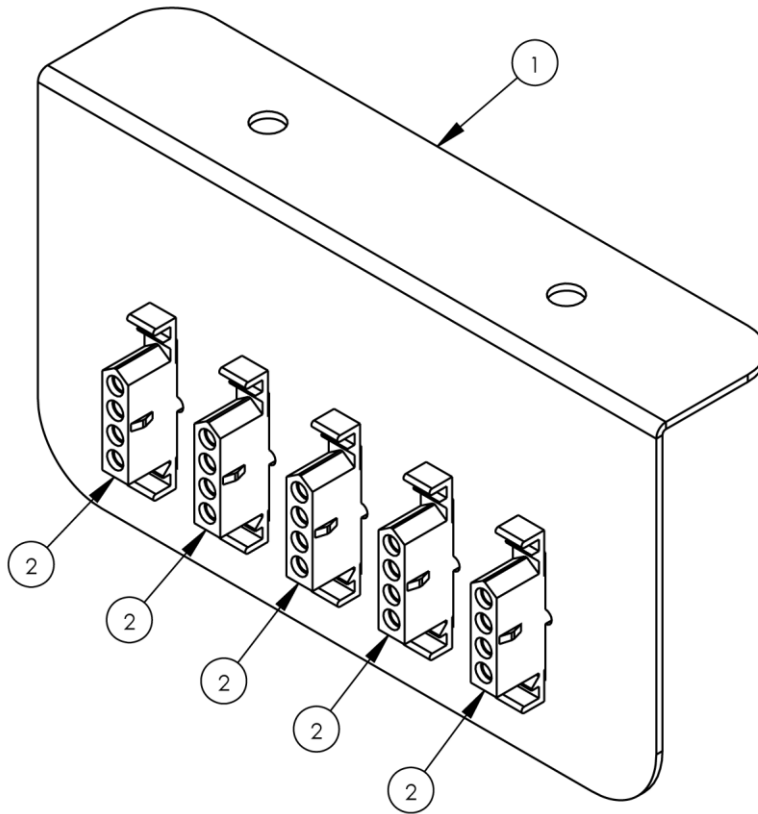


From the library of: Diamond Needle Corp

1388594 Electric Bottom Panel Assembly

AAC Drawing Number 1388594 Rev 2

NO.	QTY	PART	DESCRIPTION
1	1	1388595	BOTTOM PANEL, ELEC
2	2	EE64151B	FERRITE CORE,SPLIT,CABLE
3	2	EECLIPFIX	ANCHOR,DIN RAIL
4	2	EESH21006C	MOTOR, STEPPER DRV, HYB
5	8"	EETS35X7.5A	DIN RAIL-AMERICAN
6	2	FFQL213DMKM05	CIRCUIT BREAKER,5A,2P
7	2	FFQL213DMKM15	CIRCUIT BREAKER,15A,2P
8	1	MM69915K72	STRAIN RELIEF, LIQ TIGHT
9	1	MMSL208S	DRIVE, VAR, FREQ. .75HP, 1PH
10	1	MMSM210S	DRIVE,VARIABLE FREQUENCY
11	2	SSBCM5X8	SCREW,BUTTON CAP

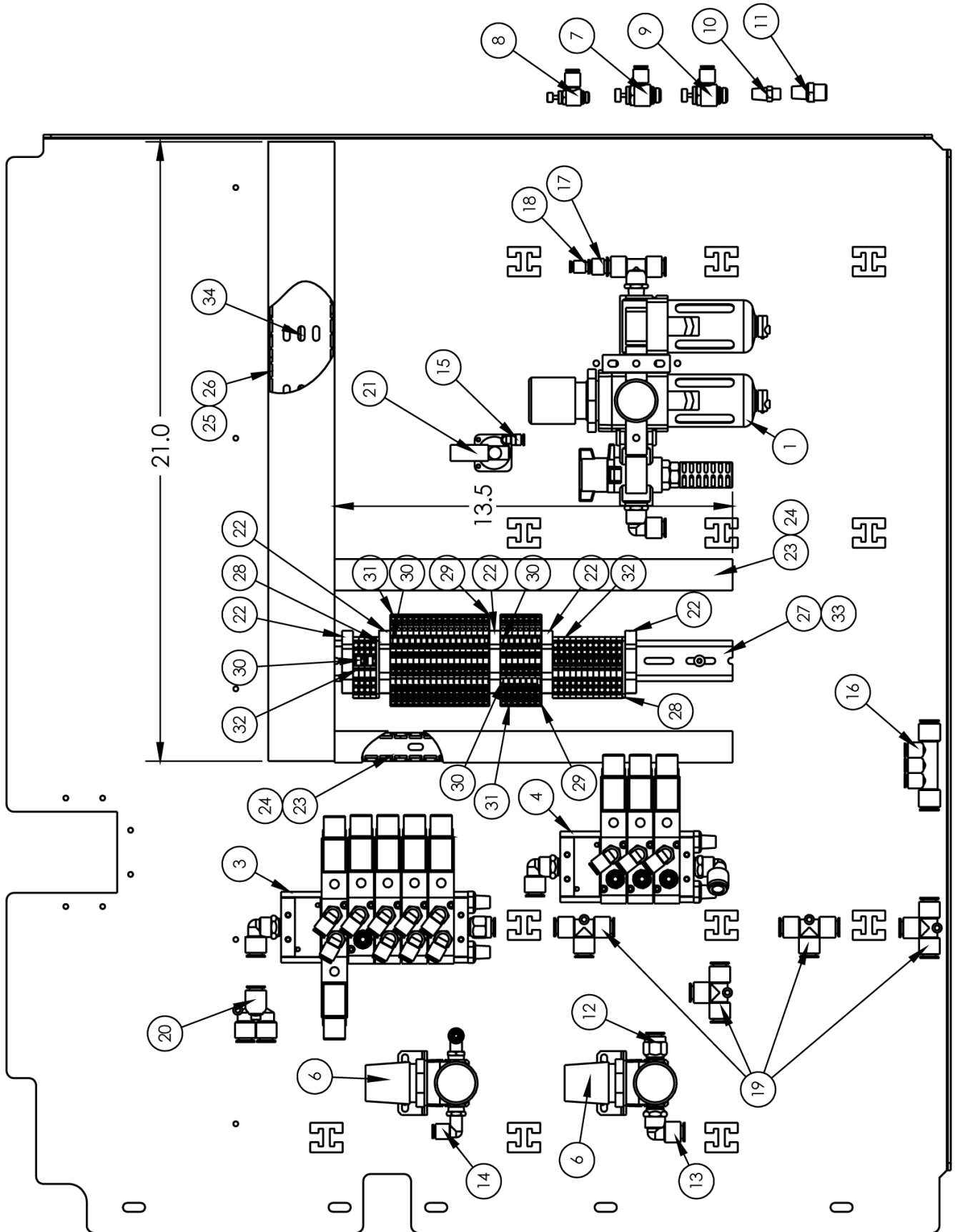


From the library of: Diamond Needle Corp

1389229 Molex Manifold

AAC Drawing Number 1389229 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1393705	MANIFOLD PLATE, TABLE EYE
2	5	FF274-234	4 PIN FEMALE CONNECTOR

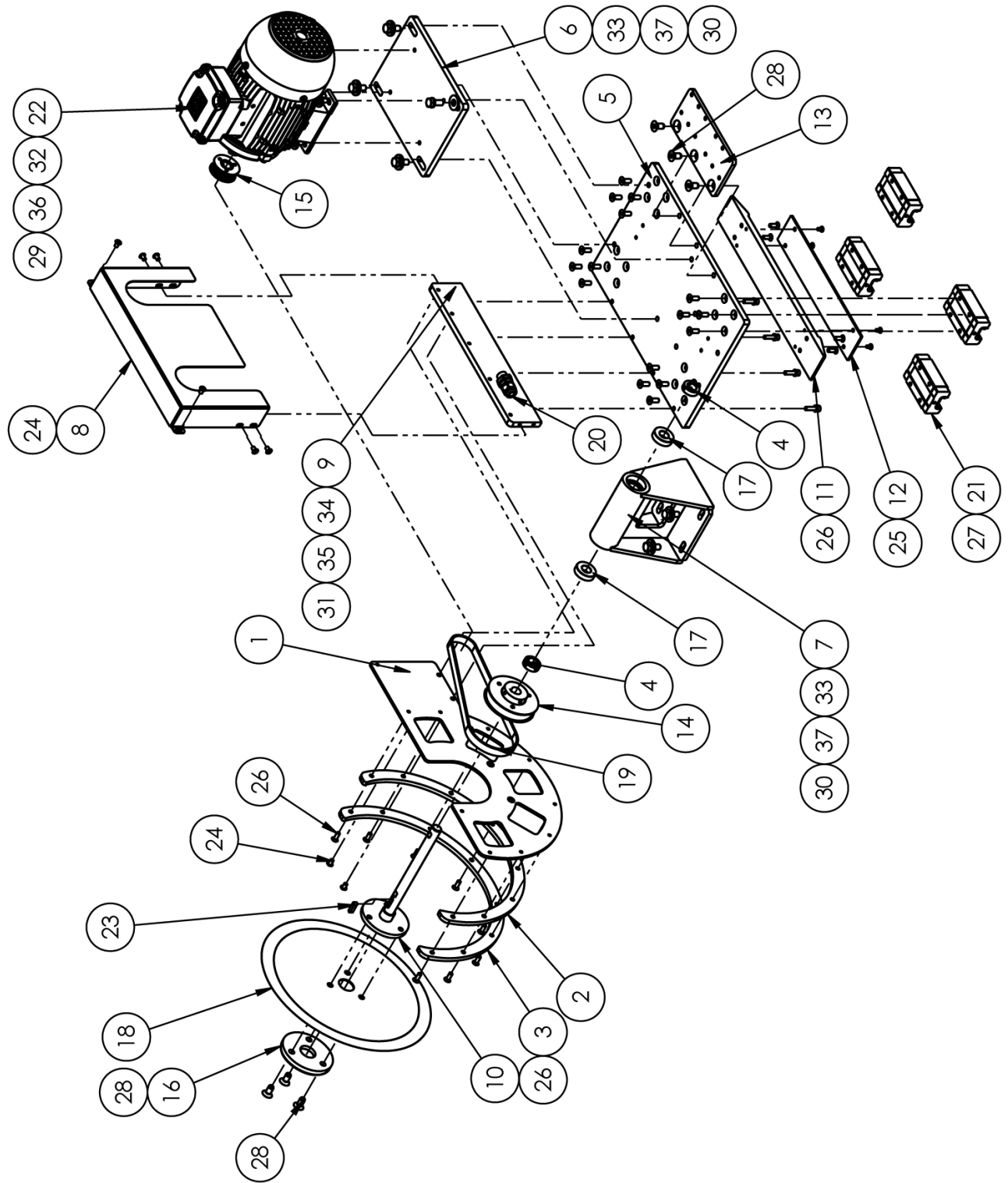


1388650 Pneumatic Panel Assembly

AAC Drawing Number 1388560 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	1388335	FRL ASSEMBLY, 1393E
2	1	1388570	BACK PANEL, PNUEMATIC
3	1	1388653	SOLENOID,6 VALVE ASM
4	1	1388654	SOLENOID,4 VALVE ASM
5	9	1391160	CABLE ASSY,VALVE,DIN,3M
6	2	AA198-508	REGULATOR,0-160 W/GAUGE &
7	* 16	AA198RA404U	FLOW CONTROL,1/4PTX1/4
8	* 2	AA198RA408U	FLOW CONTROL,RC 1/8X1/4
9	* 2	AA198RR404U	FLOW CONTROL,1/4PTX1/4
10	* 2	AAFP18	MUFFLER,1/8 NPT, BRONZ
11	* 2	AAFP28	MUFFLER,1/4 NPT
12	1	AAQMC-3-4U	MALE CONNECTOR,3/8OD TUBE 1/4
13	1	AAQME-3-4U	MALE ELBOW,3/8OD TUBE 1/4
14	2	AAQME-4-4U	ELBOW, MALE,1/4X1/4NPT
15	1	AAQME-5-10	ELBOW, MALE,5/32X10-32
16	1	AAQMF-144	6-STATION AIR MANIFOLD
17	1	AAQPR-3-4	QUICK REDUCER 3/8-1/4
18	1	AAQPR-5-4	QUICK PLUG-IN REDUCER
19	4	AAQUT-3-3	QUICK UNION T 3/8X3/8
20	1	AAQUY-3-3	QUICK UNION Y,3/8X3/8
21	1	AAVF51FM1B	AIR/ELEC PRESSURE SW
22	5	EECLIPFIX	ANCHOR,DIN RAIL
23	1.42 FT	EED78W308	DUCT,WIRE,.75 X .75
24	1.42 FT	EED78W332	DUCT,WIRE COVER,.75"
25	1.75 FT	EEDC2X2	COVER,WIRE DUCT
26	1.75 FT	EEDF2X2	DUCT,WIRE,2X2, MOD
27	13.50"	EETS35X7.5A	DIN RAIL-AMERICAN
28	2	FF280-308	TERMBLK ENDPLATE,WAGO,280
29	2	FF280-319	TERMBLK,WAGO,SENSOR,DIN
30	30	FF280-402	JUMPER,WAGO,TOP,SNGL
31	24	FF280-560	TERMBLK,WAGO,SENSOR,DIN
32	16	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY
33	3	SSBCM5X8	SCREW,BUTTON CAP
34	* 47"	ZZZSH-310	TAPE, DOUBLE SIDED,3/4"W

From the library of: Diamond Needle Corp

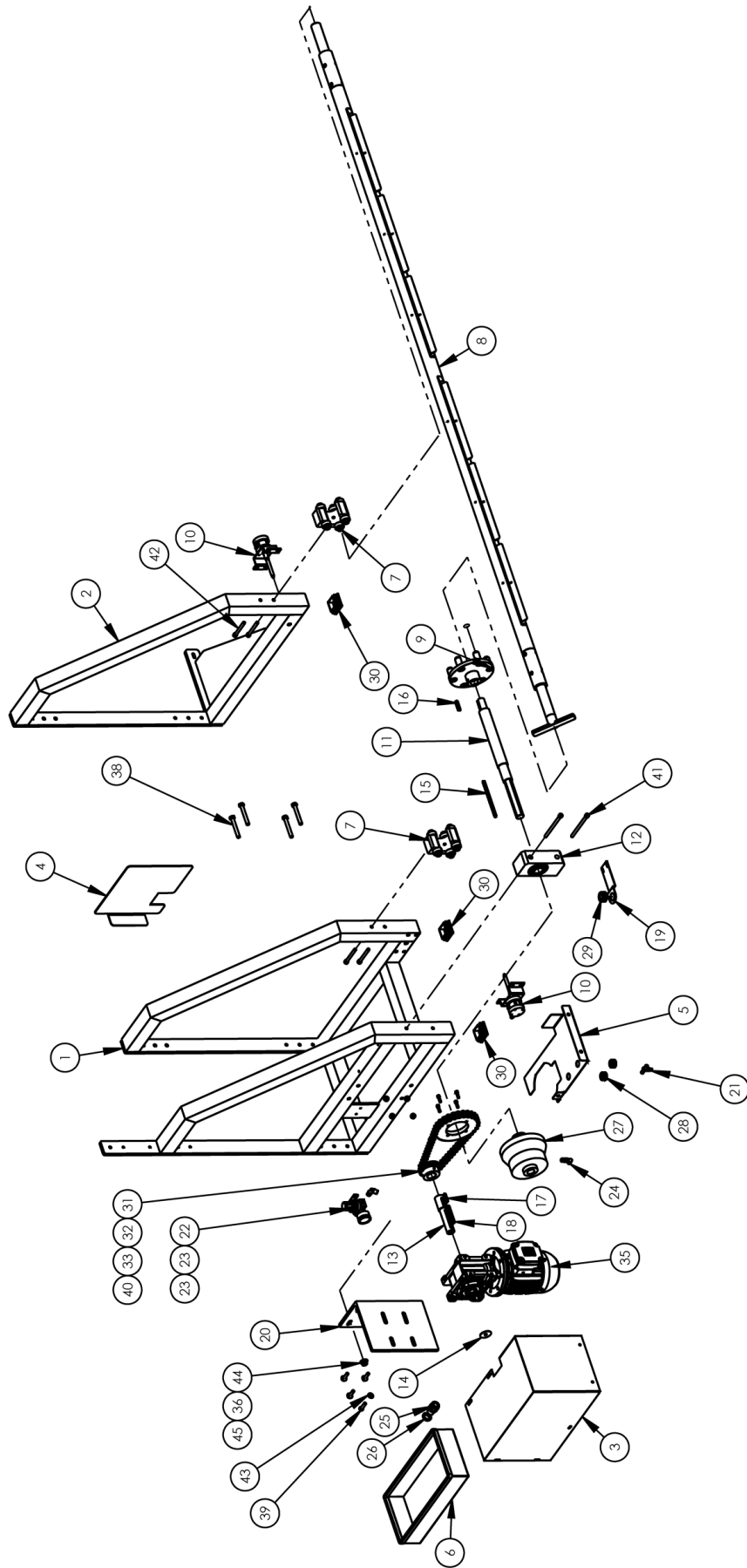


1388664 Cross Cut Assembly

AAC Drawing Number 1388664 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1388029	GUARD, BLADE, CROSS CUT
2	1	1388030	GUARD, BLADE, LOWER
3	1	1388031	GUARD, BLADE, LOWER
4	2	1388474	COLLAR, SET RETAINER
5	1	1388475	MOUNTING PLATE, CROSS CUT
6	1	1388476	MOTOR PLATE,X CUT
7	1	1388479	BEARING BLOCK, CROSS CUT
8	1	1388482	COVER, BELT, CROSS CUT
9	1	1388483	PLATE, BLADE GUARD XCUT
10	1	1388486	BLADE MOUNT, XCUT,WLDMNT
11	1	1388488	PLATE, PROX FLAG, XCUT
12	1	1388491	PLATE, PROX FLAG
13	1	1388492	PLATE, XCUT BELT DRIVE
14	1	1389203	FLANGED PULLEY
15	1	1389895	PULLEY ASSY
16	1	1393390	HUB CAP, BLADE RETAINER
17	2	BB6002-ZZ	BEARING,BALL,.590B
18	1	CJ2090200	280mm BLADE
19	1	GG220XL050	BELT, GEAR, 1/5P,3/8W
20	1	MM7310K32	STRAIN RELIEF, 12mm
21	4	MMAGH25CAN	LINEAR BEARING
22	1	MMJW7124	MOTOR,IEC,1/2 HP,0.37 KW
23	1	MMKEY5X5	KEY STOCK, 5 X 5 MM
24	8	SSBCM5X8	SCREW,BUTTON CAP
25	4	SSFCM4X8	SCREW,FLAT CAP,M4X8
26	12	SSFCM5X14	M5-0.8X14, FLAT ALLEN
27	16	SSFCM6X16	M6 X 20 FLAT ALLEN
28	6	SSFCM8X16	M8 X 16 FLAT CAP SCR
29	4	SSHCM6X16	SCREW, HEX M6X16
30	8	SSHCM8X20	SCREW,HEX CAP
31	4	SSSCM5X20	M5-0.8X20,SCREW,SOCKET CA
32	4	WWF1/4	WASHER, FLAT, 1/4", COM
33	8	WWF5/16	WASHER,FLAT,5/16
34	4	WWFM5	WASHER, FLAT, M5 I.D.
35	4	WWLM5	M5 LOCK WASHER
36	4	WWLM6	M6 LOCK WASHER
37	8	WWLM8	M8 LOCK WASHER

From the library of: Diamond Needle Corp

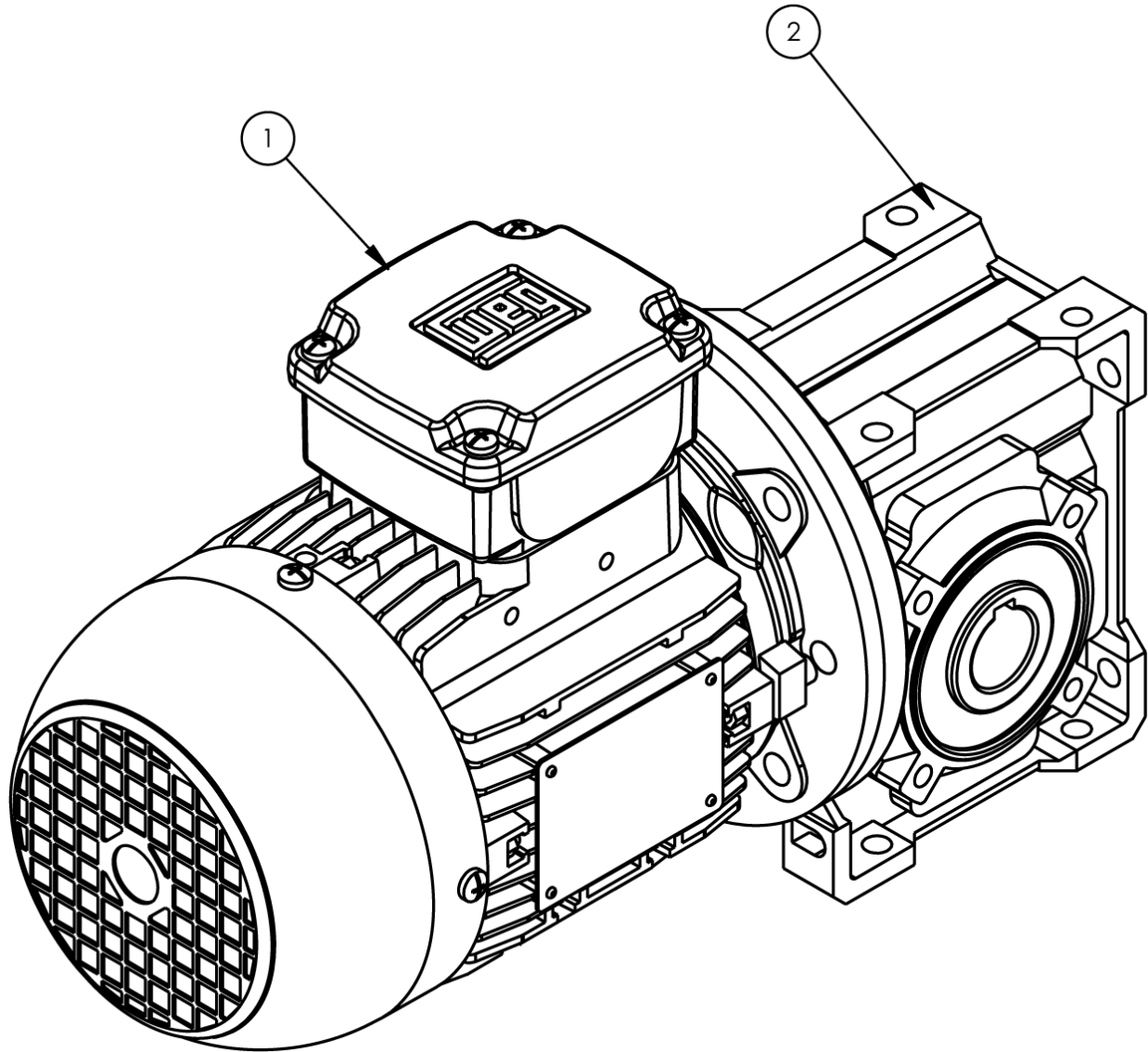


1389245 Winder Assembly

AAC Drawing Number 1389245 Rev 8

NO.	QTY	PART #	DESCRIPTION
1	1	1389241	DRIVE SUPPORT WELDMENT
2	1	1389250	ROD SUPPORT WELDMENT
3	1	1389261	COVER, MOTOR WINDER
4	1	1389263	BELT GUARD, INNER
5	1	1389472	CLOSURE PLATE, GUARD, LOWE
6	1	1389491	TRAY ASSEMBLY
7	2	1393058	CRADLE ASSY
8	1	1393139	TAKE UP DRIVE ROD
9	1	1393260	DRIVE DOG
10	2	1393301	TABLE LOCKING ASSY
11	1	1393333	CLUTCH SHAFT
12	1	1393334	BLOCK, BEARING, 30MM
13	1	1393357	SHAFT, OUTPUT
14	1	1393364	RETAINER WASHER
15	1	1393365	KEY, CLUTCH
16	1	1393366	KEY, DRIVE DOG
17	1	1393368	KEY, SMALL PULLEY
18	1	1393369	KEY, GEARMOTOR
19	1	1393491	BRKT, ANTI-ROTATION
20	1	1961-331	MOUNT, MOTOR
21	1	AA2001F-03	FLOW CONTROL, INLINE, 5/32
22	1	AAMSR20008	REG, 0-140 W/GAUGE & BRKT
23	2	AAQME-4-4	ELBOW, MALE, 1/4X1/4NPT
24	1	AAQMEL-5-8	QUICK MALE ELBOW, LONG
25	1	FF3200	STRAIN RELIEF, 1/2 NPT
26	1	FF8463	NUT, LOCK, 1/2NPT, NYLON, BLK
27	1	MM805275	CLUTCH, AIR, 1.0 B, 370 IN-L
28	2	MM9307K63	GROMMET, 1/2ID, 13/16 HOLE
29	1	MM9307K69	GROMMET, 5/8, 1.125, .125GV
30	3	MM9565K8	DONT USE SEE MM9565K56
31	*32"	MMD35 (32" LG)	CHAIN, STEEL, DBL #35-2 X 32IN LG
32	1	MMD35B22M1	SPROCKET, 22T, DBL, NO35
33	1	MMD35B48M1	SPROCKET, 48T, DBL, NO35, MO
34	1	MMD35CL	MASTER LINK, DBL, #35 CHAIN
35	1	MMRV0501-30	MOTOR, GEARBOX, 0.37KW, 3PH
36	4	NNHM10X1.5	NUT, HEX, M10X1.5
37	4	NNHM8X1.25	M8 X 1.25 HEX NUT
38	4	SSHCM10X75	SCREW, HEX CAP, M10-1.5X70
39	4	SSHCM8X30	SCREW, HEX CAP M8X40
40	4	SSSC01048	1/4-20 X 3/4" SOC CAP SC
41	2	SSSCM8X120	SOCKET HEAD SCREW M8x120
42	4	SSSCM8X70	SCREW, SOC CAP, M8X25
43	4	WWF1/4	WASHER, FLAT, 1/4", COM
44	4	WWFM10	WASHER, FLAT, M10 I.D.
45	4	WWLM10	M10 LOCK WASHER
46	4	WWLM8	M8 LOCK WASHER

From the library of: Diamond Needle Corp

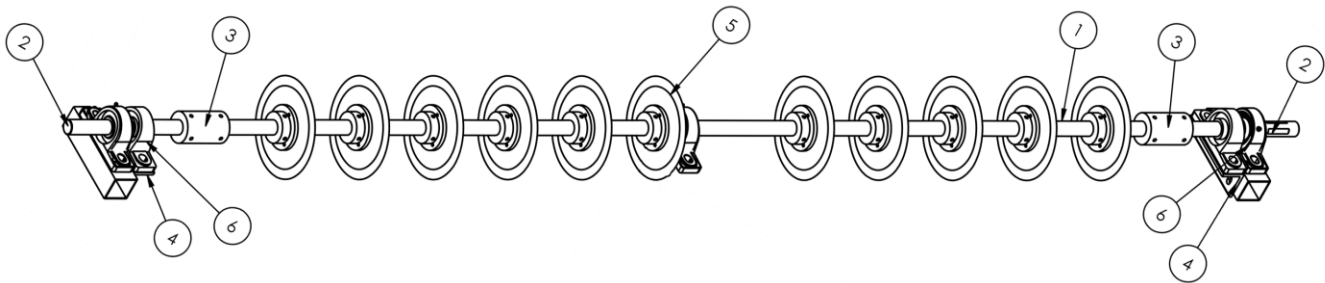


From the library of: Diamond Needle Corp

MMRV0501-30 Worm Gearbox and Motor

AAC Drawing Number 9004350 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	MM71B4B5	MOTOR, .37KW, IEC, B5, 230/380VAC, 1750 RPM
2	1	MMRV5030D71	MOTOR, GEARBOX, 0.37KW, 3PH

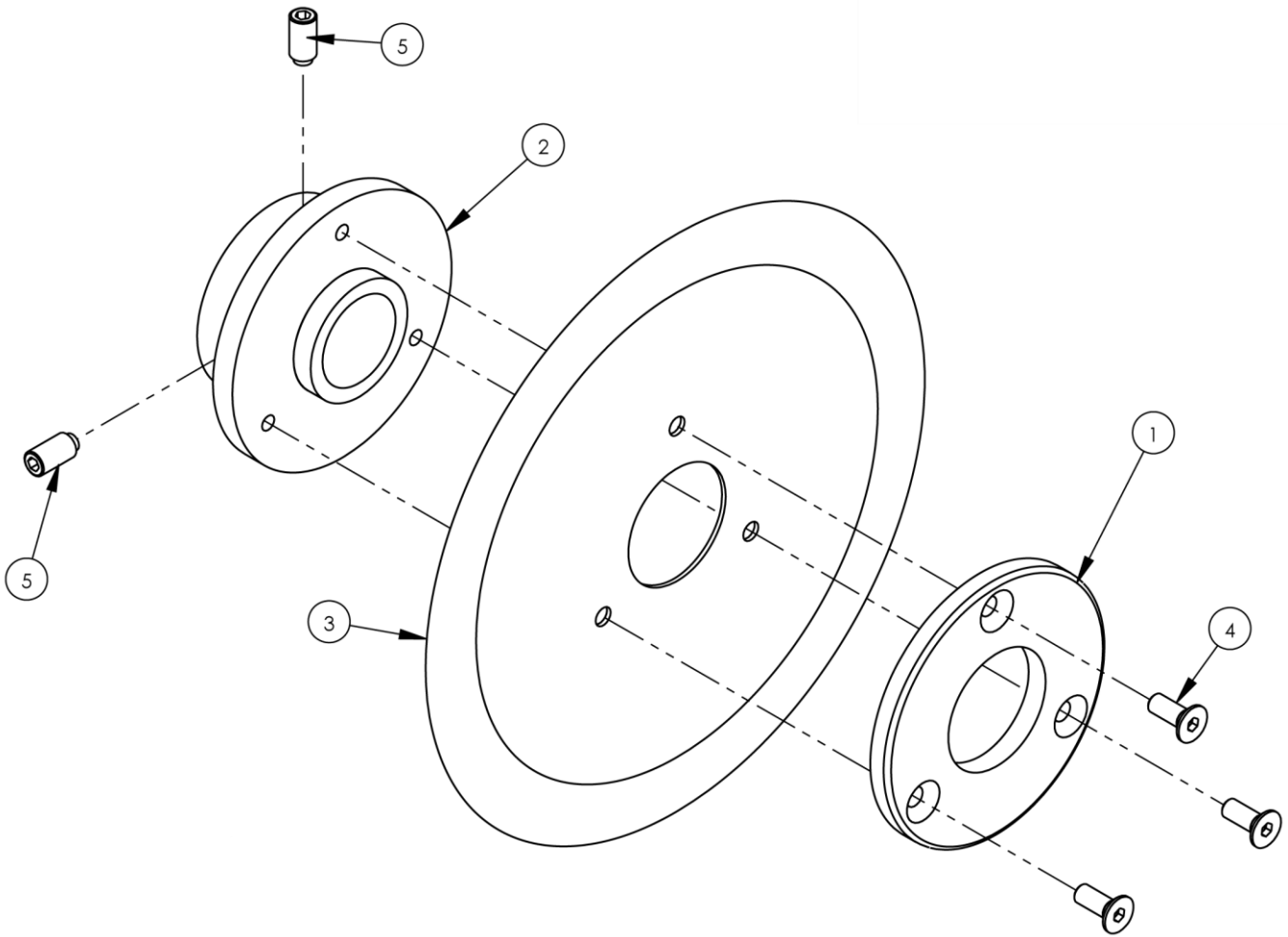


From the library of: Diamond Needle Corp

1389860 Split Shaft Slitter Assembly

AAC Drawing Number 1389860 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	1389857	DRIVE SHAFT, 30MM X 2300MM
2	2	1389858	DRIVE SHAFT, 30MM X 300MM
3	2	1389859	COUPLING, 30MM X 4 IN
4	2	1389874	MOUNT, ANGLE, BEARING
5	11	1393149	BSW SLITTER ASSEMBLY
6	5	BBUCP206	BEARING, PILLOWBLOCK

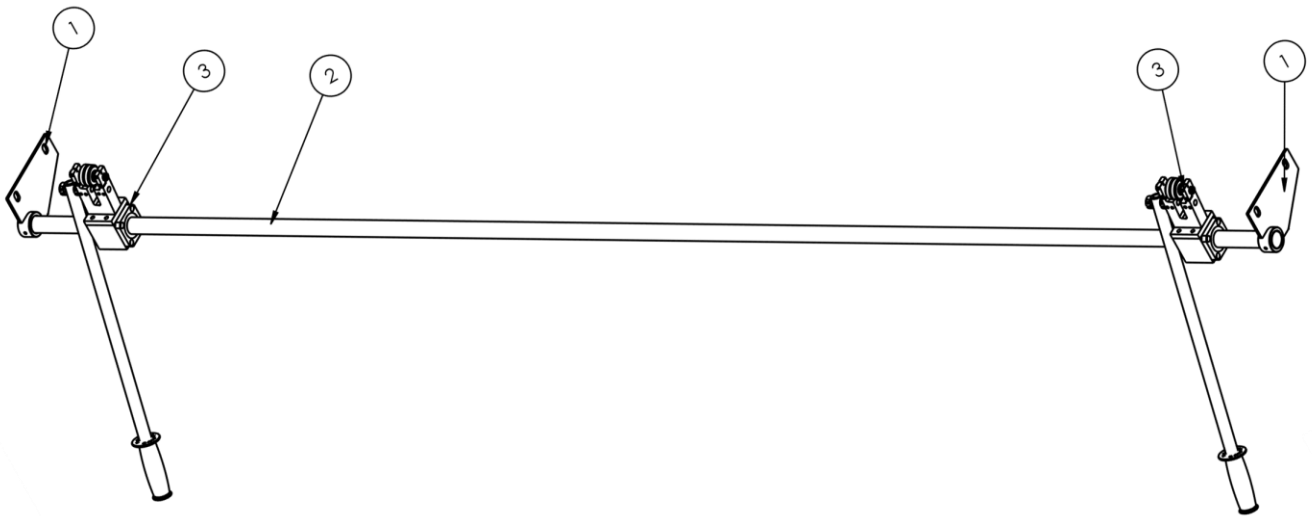


From the library of: Diamond Needle Corp

1393149 Slitter Assembly

AAC Drawing Number 1393149 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	1389079	BLADE RETAINER
2	1	1389873	BLADE HOLDER
3	1	CJ21100900	BLADE, 40MM ID, 205MM OD
4	3	SSFCM6X16	M6-1.0 X 16 FLAT ALLEN
5	2	SSSSM8X16BT	M8X16 SOC SET, BRASS TIP

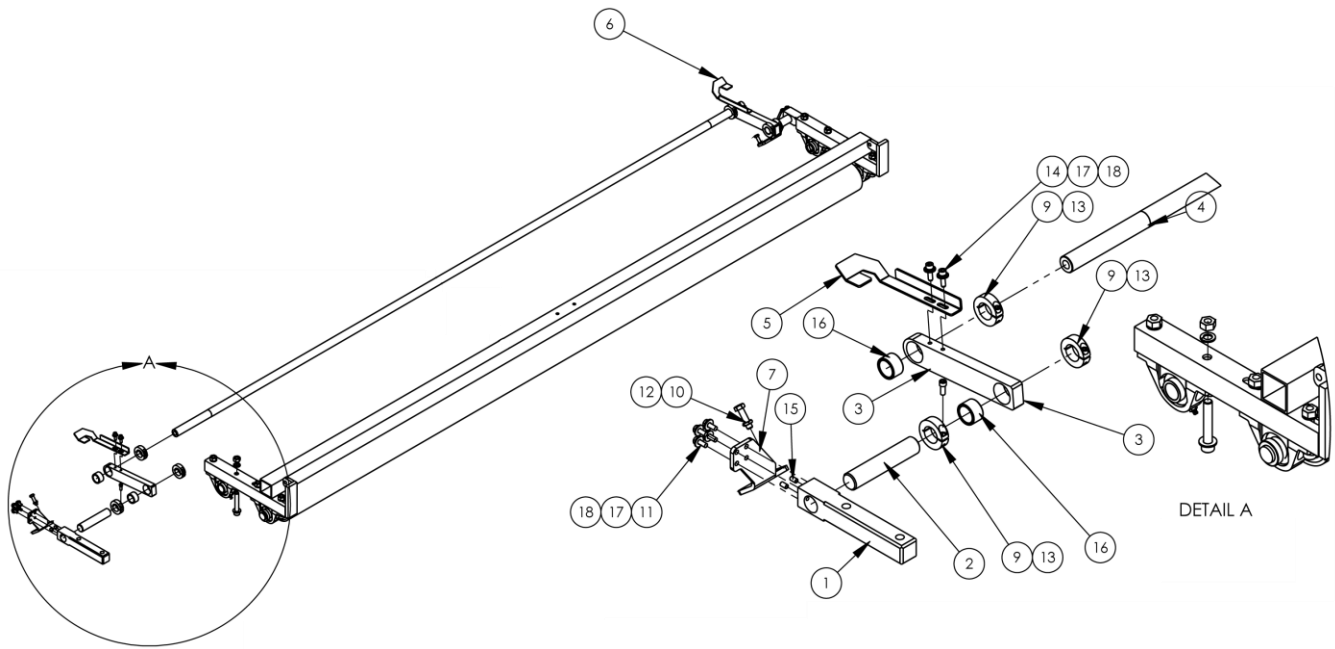


From the library of: Diamond Needle Corp

1389896 Slitter Sharpener Assembly

AAC Drawing Number 1389896 Rev 1

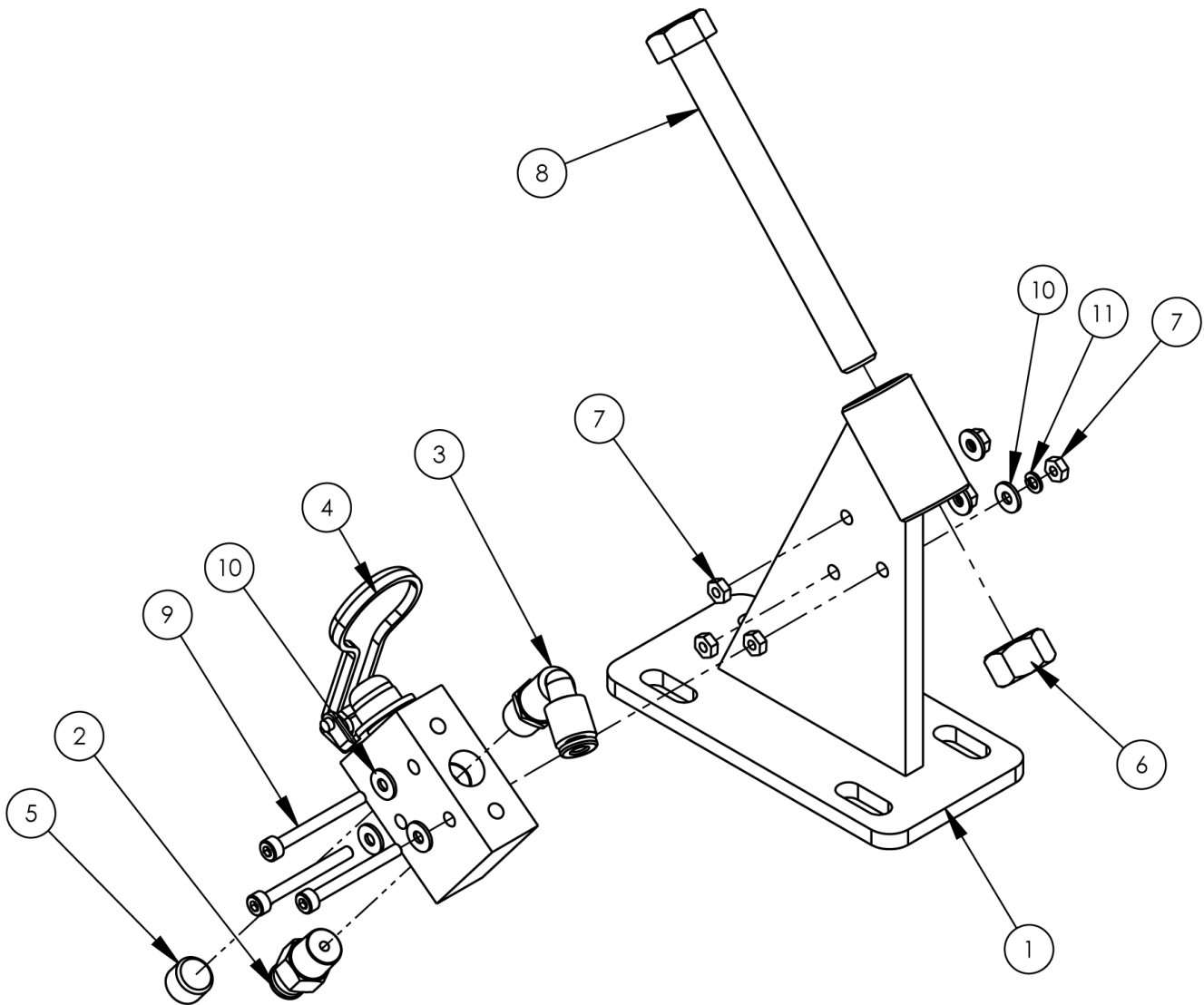
NO.	QTY	PART #	DESCRIPTION
1	2	1389875	MOUNT, END, 30MM SHAFT
2	1	1389877	ROD, 30MMX2720, 60 CASE
3	2	1389884	SHARPENER ASBLY, SLITTERS



1393-KIT06 Weighted Slitter Bar Assembly

AAC Drawing Number 9002643 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	2	1388141	MOUNT, PIVOT SHAFT
2	2	1388142	SHAFT, STUB, 1" X 5"
3	2	1388143	ARM, SLITTER WEIGHTED BAR
4	1	1388144	BAR, WEIGHTED
5	1	1388145	PLATE, SUPPORT, BAR
6	1	1388146	PLATE, SUPPORT, BAR
7	1	1388677	PLATE, WEIGHTED BAR STOP
8	1	1388678	PLATE, WEIGHTED BAR STOP
9	6	CCCL16F	COLLAR, 1" CLAMP TYPE
10	2	NNJM8	NUT, JAM, M8, ZINC PLATED
11	8	SSHCM6X16	SCREW, HEX M6X16
12	2	SSHCM8X30	SCREW, HEX CAP M8X40
13	6	SSSC05032	1/4-28 X 1/2, SOC CAP
14	4	SSSCM6X20	SCREW, SOCKET CAP
15	4	SSSSM6X12	M6 SET SCREW, 12MM L
16	4	UUAA102-6	BEARING, BRZ, 1.003ID 1.254OD .75L
17	12	WWFS1/4	WASHER, FLAT, SAE, 1/4
18	12	WWL1/4	WASHER, LOCK, 1/4

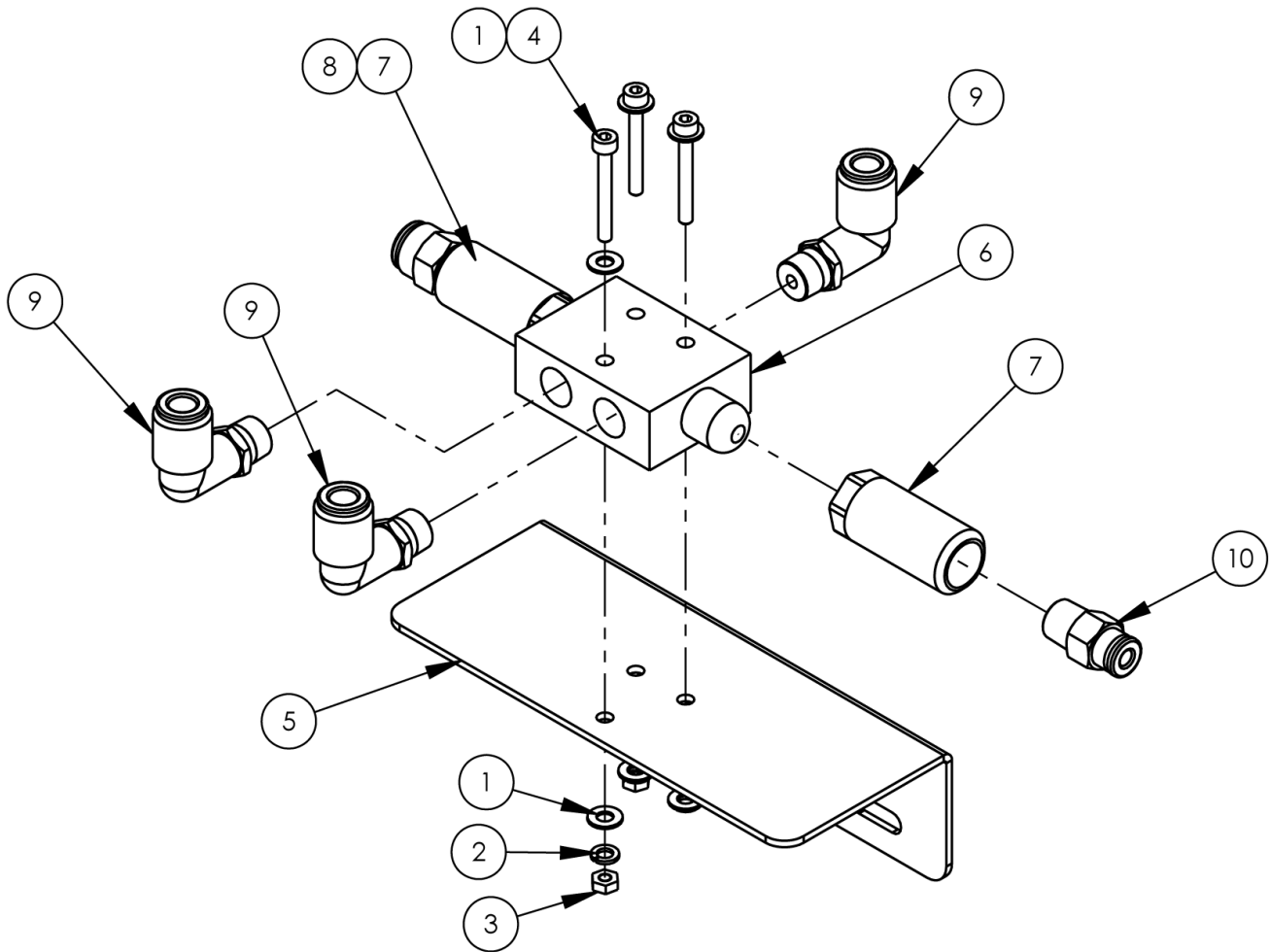


From the library of: Diamond Needle Corp

1393310 Table Stop Assembly

AAC Drawing Number 1393310 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1393240	ARM STOP WELDMENT
2	1	AAQMC-5-8	QU. MALE CONN 5/32X1/8
3	1	AAQME-5-8	QUICK MALE ELBOW
4	1	AAV41-P34T	VALVE,SPOOL,4-WAY
5	1	MM4554K11	PLUG, 1/8" PIPE
6	1	NNH3/8-16	3/8-16 HEX NUT
7	6	NNHM3X0.5	NUT,HEX,M3-0.5
8	1	SSHC25224F	3/8-16 X 3-1/2 HEX HEAD FULL THD
9	3	SSSCM3X30	M3-0.5 X 30 SOC CAP
10	6	WWF4	WASHER, FLAT #4
11	3	WWL4	#4 LW

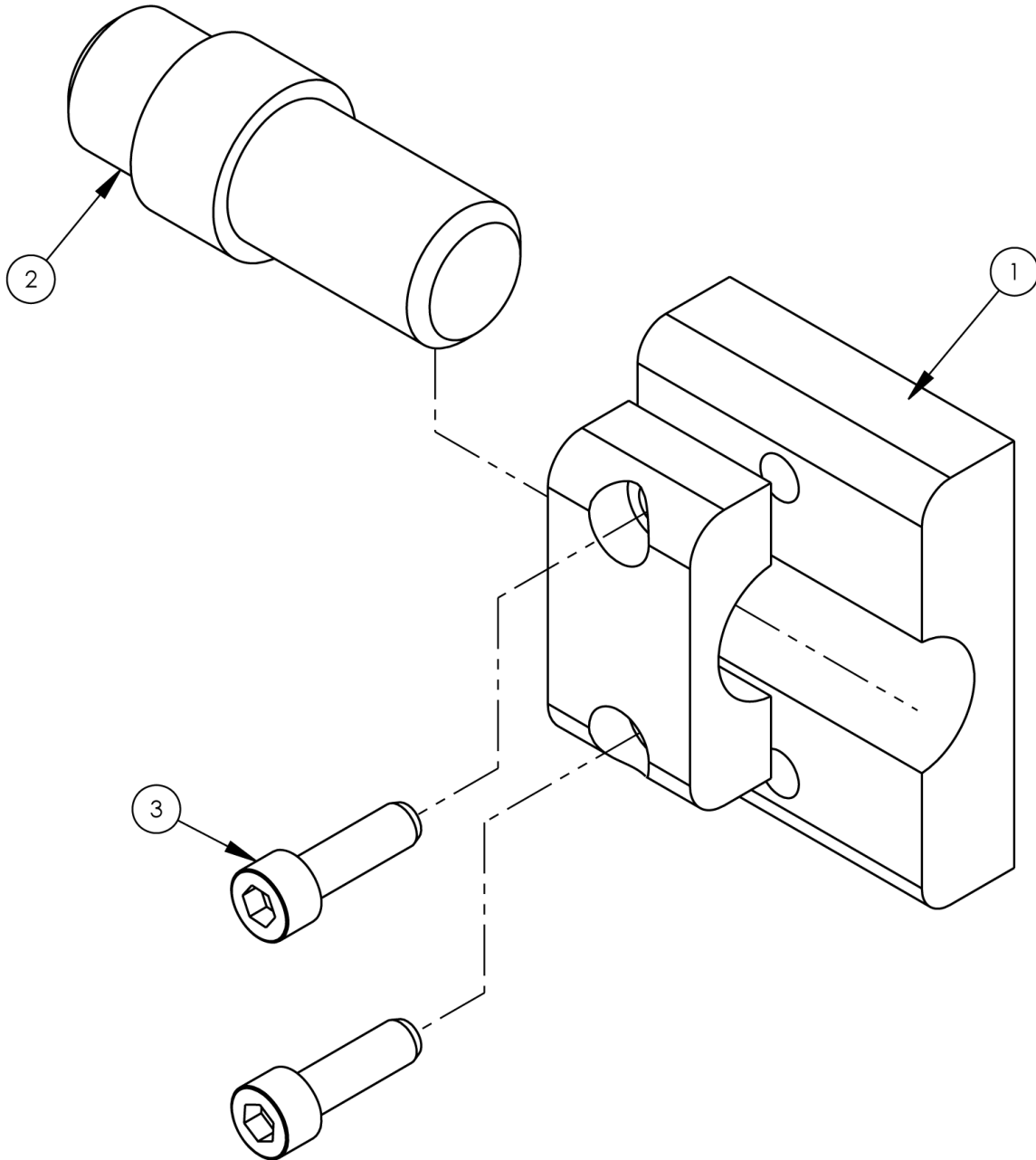


From the library of: Diamond Needle Corp

1393312 Lock Pin Valve Assembly

AAC Drawing Number 1393312 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1393311	MOUNTING BRACKET
2	1	AAQMC-4-8	QUICK MALE CONN,1/4X1/8
3	1	AAQMC-5-8	QU. MALE CONN 5/32X1/8
4	3	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8
5	2	AAV341A	HUMPHREY VALVE
6	1	AAV41-PP	HUMPHREY VALVE,4 WAY
7	3	NNHM3X0.5	NUT,HEX,M3-0.5
8	3	SSSCM3X25	SCREW,SOCKET CAP,M3 X 30MM
9	6	WWFS6	WASHER, FLAT, #6
10	3	WWL6	WASHER,LOCK,#6

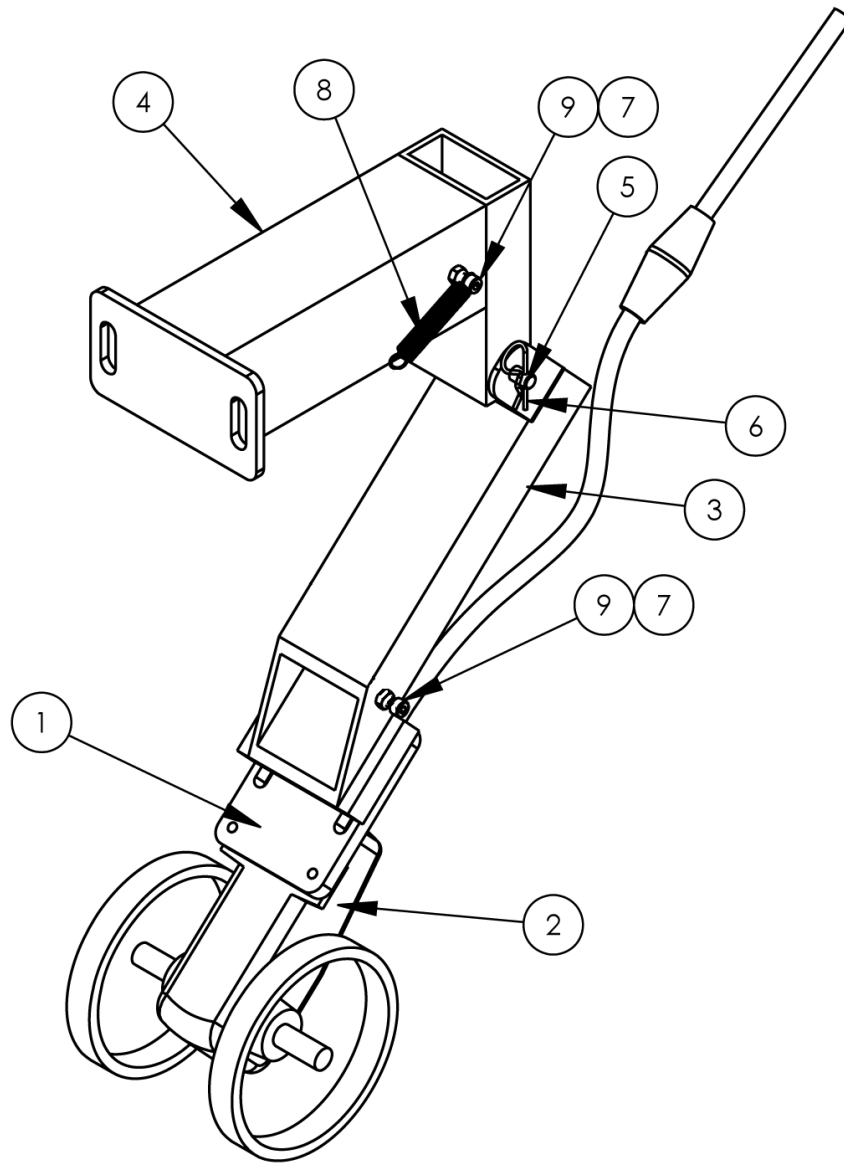


From the library of: Diamond Needle Corp

1393360 Table Pivot Assembly

AAC Drawing Number 1393360 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1393358	PIVOT BLOCK, TABLE
2	1	1393359	PIVOT PIN, TABLE
3	2	SSSCM6X20	SCREW, SOCKET CAP

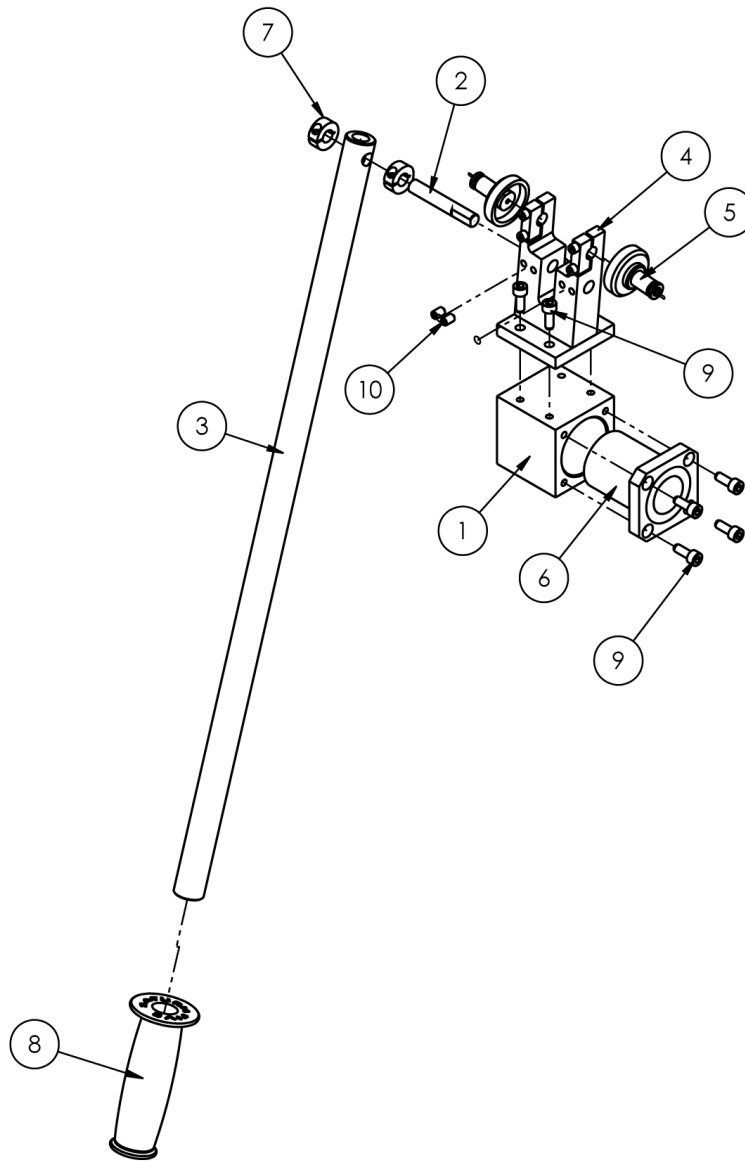


From the library of: Diamond Needle Corp

1393676 Encoder Assembly

AAC Drawing Number 1393676 Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1	1388420	PLATE, ENCODER MOUNT
2	1	1389794	CABLE, ENCODER, ASSEMBLY
3	1	1393668	COUNTER ARM, MOVING
4	1	1393670	BRACKET, STAND-OFF WELD
5	1	1393675	PIVOT PIN ASSEMBLY
6	1	MM98335A04	SPRING CLIP, .06 WIRE
7	2	NNHM4X0.7	NUT, HEX, M4-0.7
8	1	RRLE030CD7	SPRING, EXT, .030X.31X2.0
9	2	SSSCM4X16	SCREW, SOCKET CAP

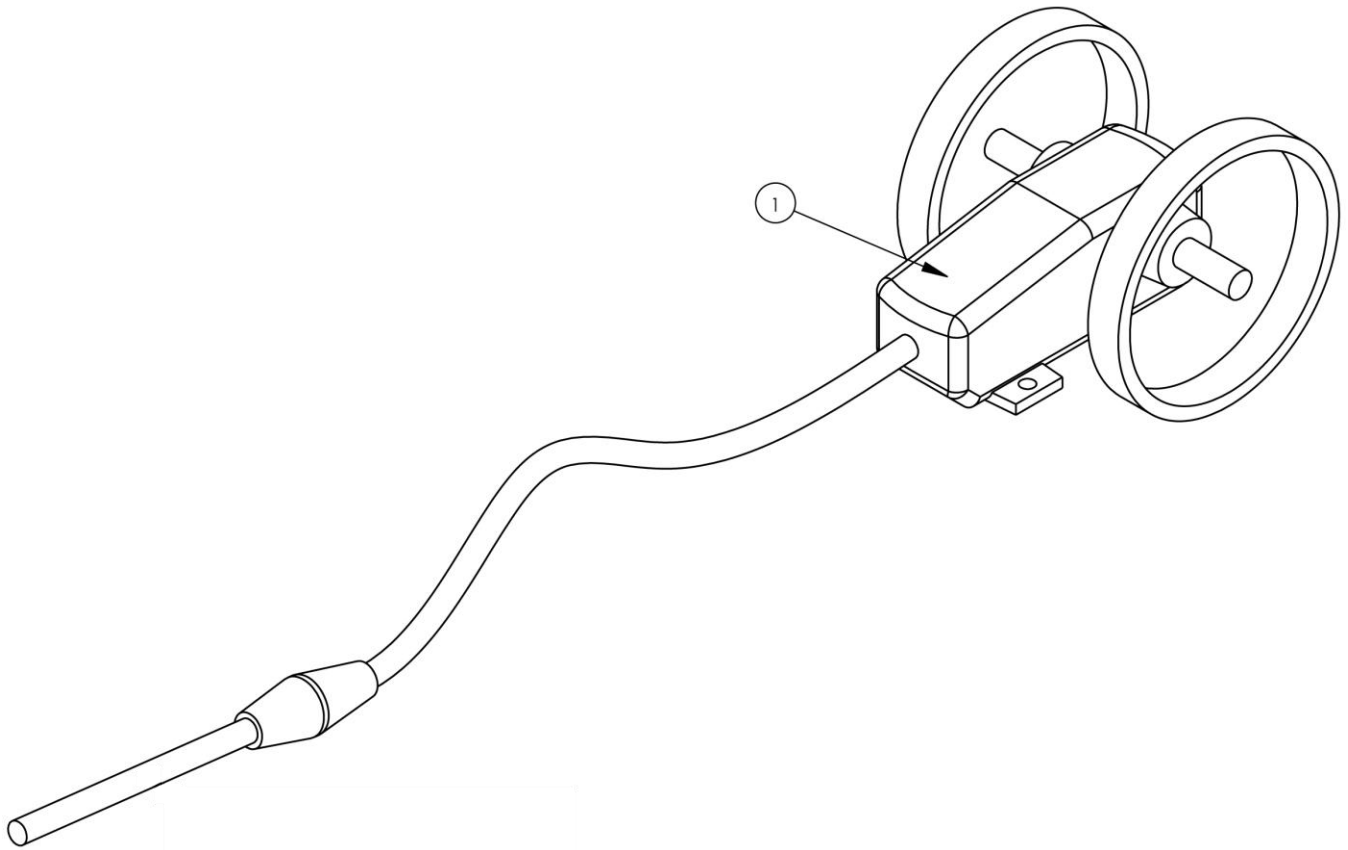


From the library of: Diamond Needle Corp

1389884 Slitters Sharpener Assembly

AAC Drawing Number 1389884 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	1389883	BLOCK,SLIDE,SHARPENER
2	1	1389889	ROD,10MM X 63MM
3	1	1389890	TUBE,HANDLE,7/8X24
4	1	1389892	SHARPENER STONE HOLDER
5	2	1393003	SHARPENER STONE MT
6	1	BBSMK30GUU	BEARING,LIN,FLG,30MM
7	2	CCCLM10F	COLLAR,10MM CLAMP
8	1	PPP97045K57	GRIP,RIBBED VINYL
9	8	SSSCM6X16	M6X16 SOC CAP SCREW
10	2	SSSSM6X10	M6 SET SCREW, 10MM L



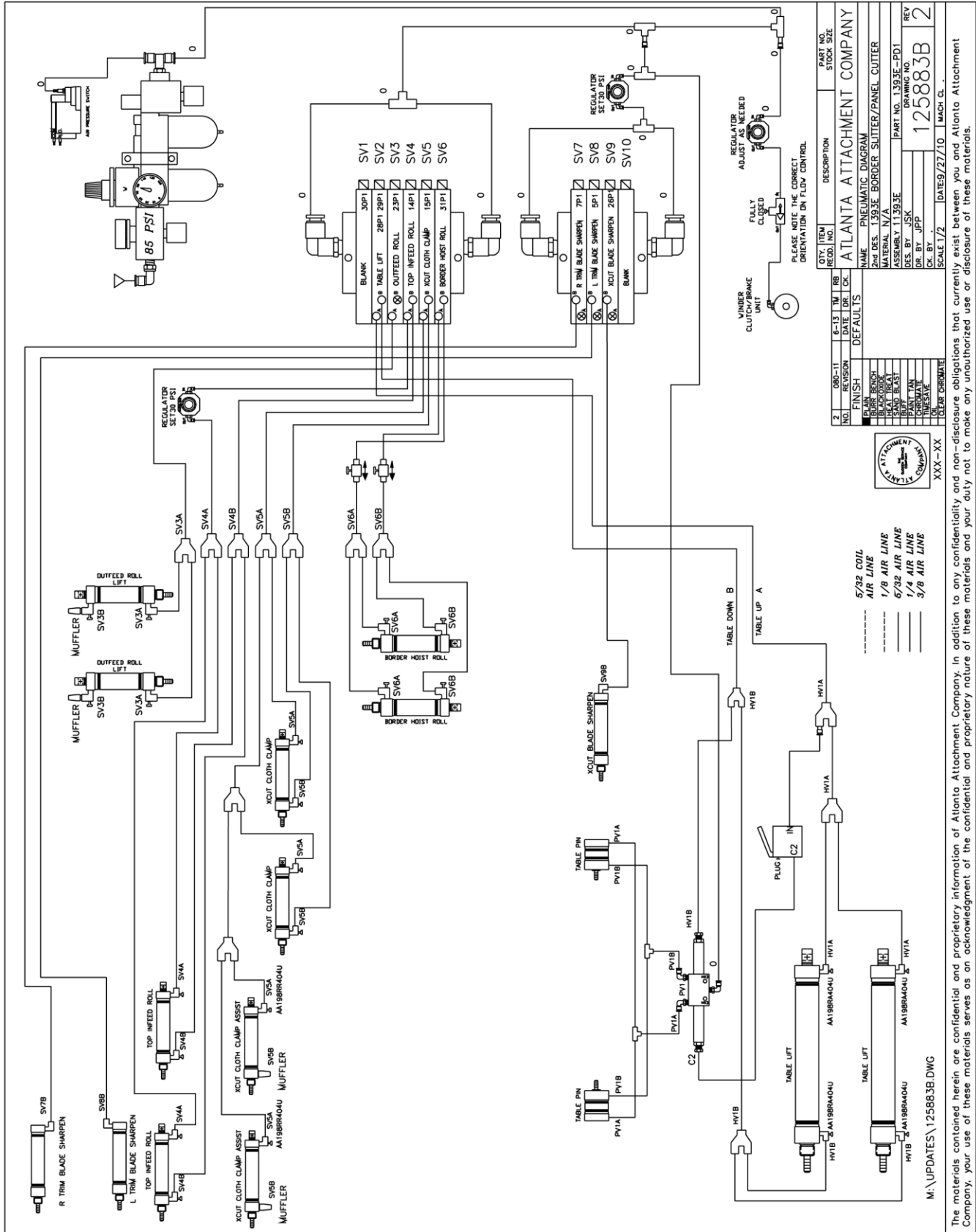
From the library of: Diamond Needle Corp

1389794 Encoder Cable Assembly

AAC Drawing Number 1389794 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	PL-D3M	ENCODER
2	1	1389794 (125627B)	WIRING DIAGRAM

1393E-PD1 Pneumatic Diagram



NO.	REV.	DATE	DR.	CR.	DESCRIPTION	PART NO.	STOCK SIZE
2		6-13	TM	FRB	DEFAULTS		
ATLANTA ATTACHMENT COMPANY NAME: PNEUMATIC DIAGRAM 2nd DES: 1393E BORDER SLITTER/PANEL CUTTER MATERIAL: N/A ASSEMBLY: 1393E DES. BY: JSK DR. BY: JPP COMPANY: ATLANTA ATTACHMENT COMPANY DRAWING NO.: 125883B REV: 2 DATE: 6/27/10 MACH. G.:							

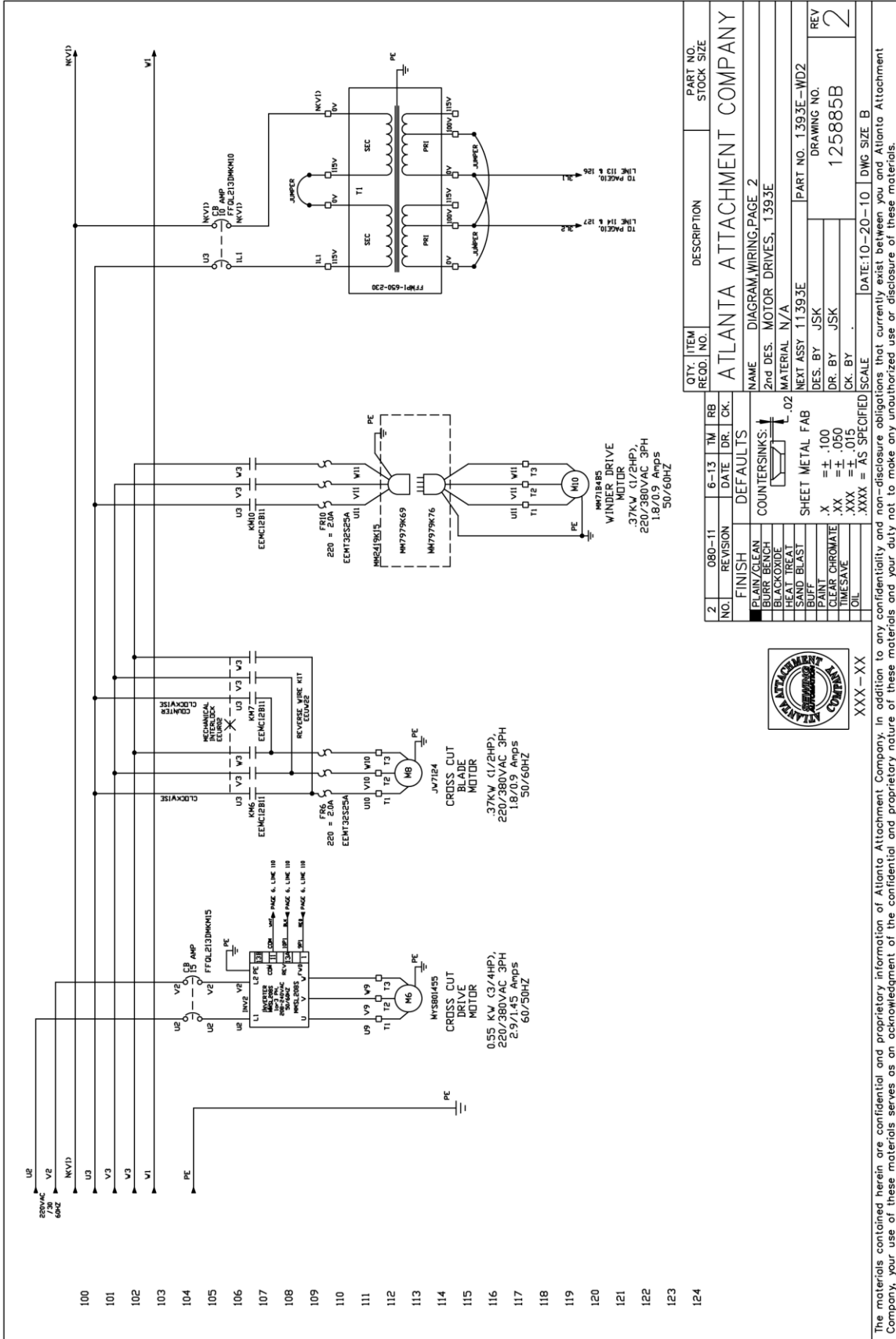


- 5/32 COIL AIR LINE
- 1/8 AIR LINE
- 6/32 AIR LINE
- 1/4 AIR LINE
- 3/8 AIR LINE

M:\UPDATES\125883B.DWG

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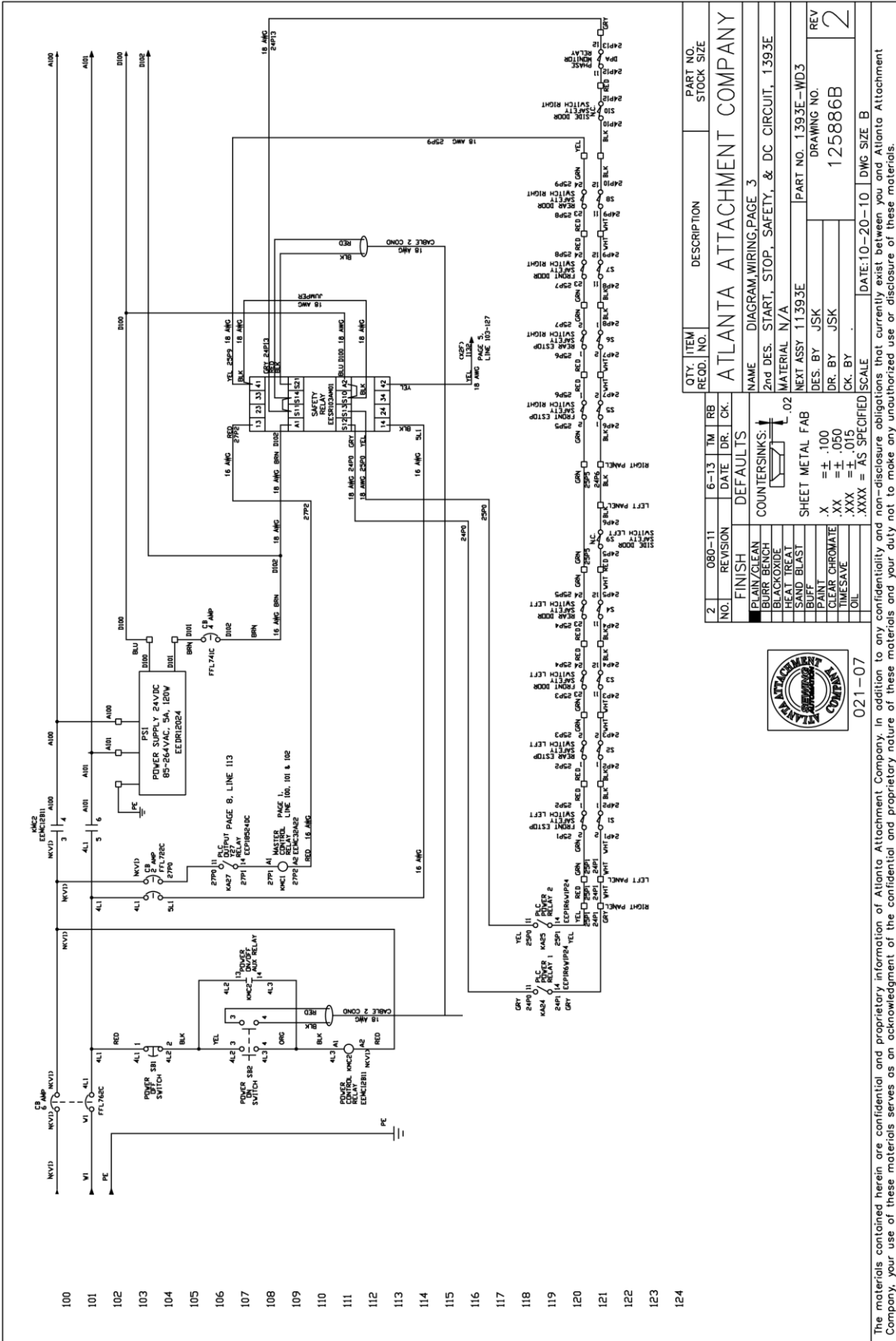
1393E-WD2 Wiring Diagram



QTY	ITEM RECD. NO.	DESCRIPTION	PART NO.	STOCK SIZE
2	080-11	6-13 TM RB		
		FINISH		
		BLANK/CLEAN		
		BURR/BENCH		
		BLACK/OXIDE		
		HEAT TREAT		
		SAND BLAST		
		PAINT		
		BUFF		
		CLEAR CHROMATE		
		PRIMER		
		W/SAVE		
		XXX-XX		
ATLANTA ATTACHMENT COMPANY				
NAME: DIAGRAM WIRING, PAGE 2				
MATERIAL: N/A				
NEXT ASSY: 11393E				
PART NO. 1393E-WD2				
DRAWING NO. 125885B				
DATE: 10-20-10 DWG SIZE: B				
REV 2				

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1393E-WD3 Wiring Diagram



- 100
- 101
- 102
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- 110
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- 120
- 121
- 122
- 123
- 124

QTY	ITEM	DESCRIPTION	PART NO.	STOCK SIZE
2	080-11	6-13 TM RE		
	REVISION	DATE	DR	CK
ATLANTA ATTACHMENT COMPANY				
NAME: DIAGRAM, WIRING, PAGE 3				
2nd DES: START, STOP, SAFETY, & DC CIRCUIT, 1393E				
MATERIAL: N/A				
NEXT ASSY: 11393E				
PART NO.: 1393E-WD3				
DRAWING NO.: 125886B				
REV: 2				
DES. BY: JSK				
DR. BY: JSK				
CK. BY:				
SCALE: DATE: 10-20-10 DWG SIZE: B				

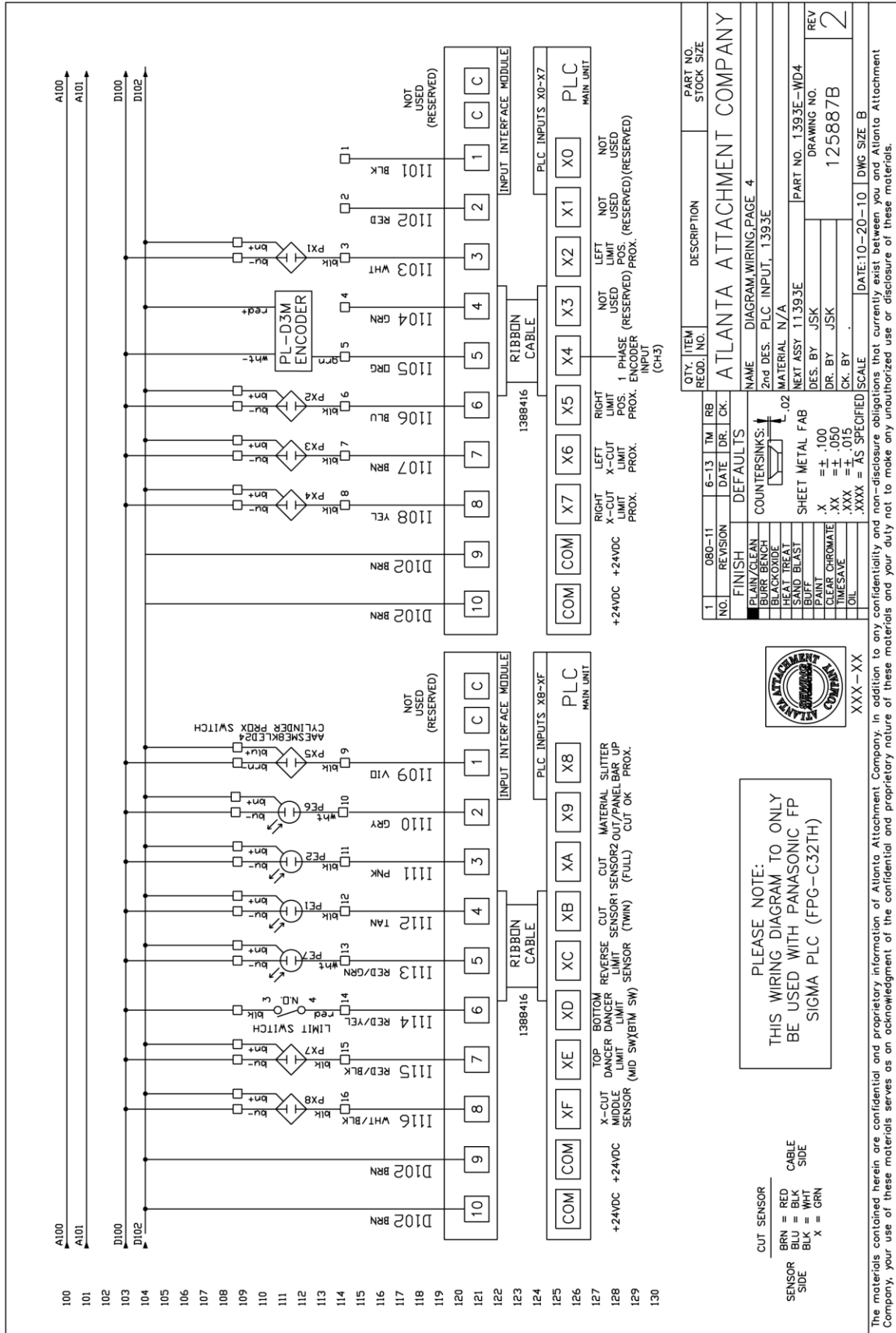


021-07

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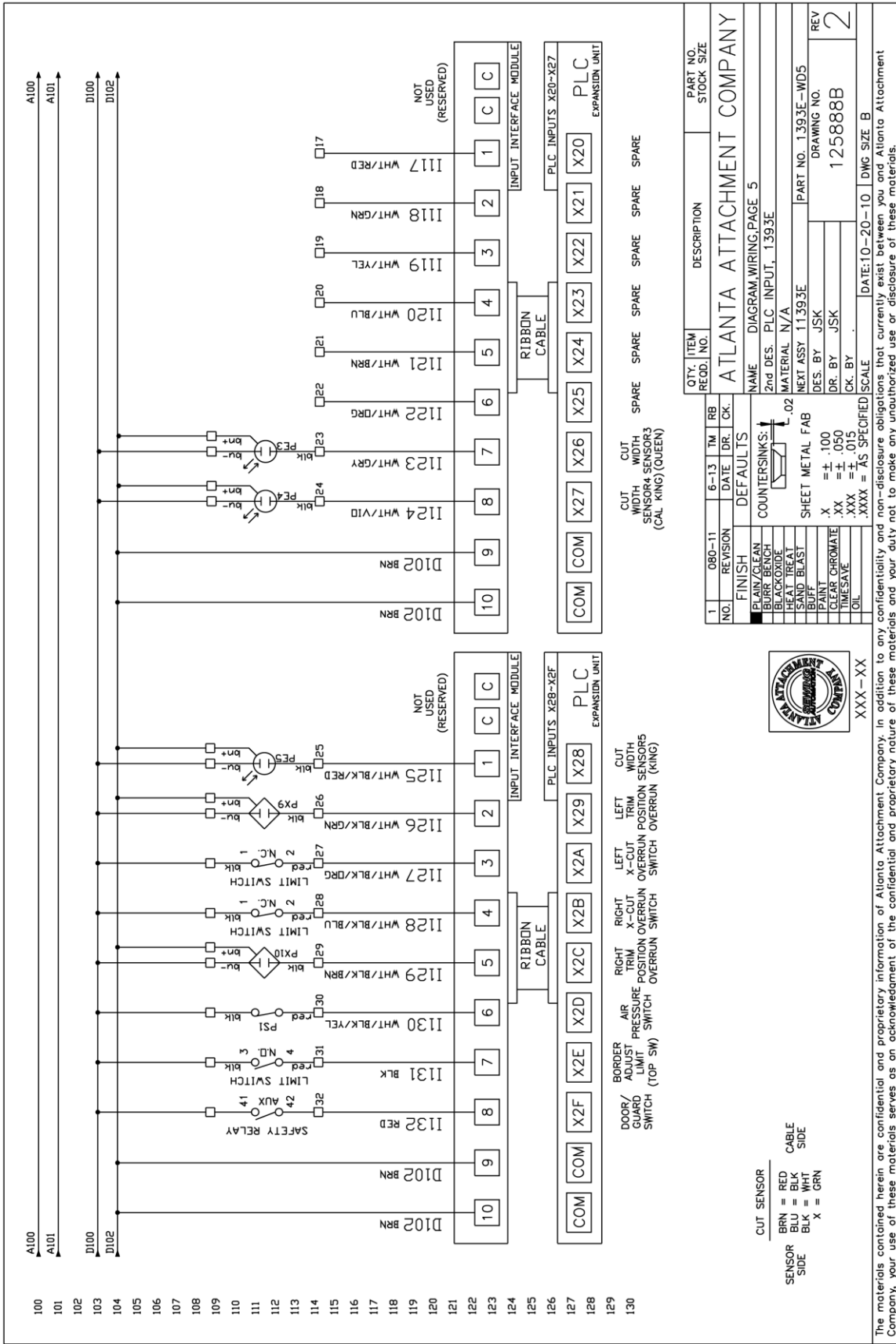
From the library of: Diamond Needle Corp

1393E-WD4 Wiring Diagram



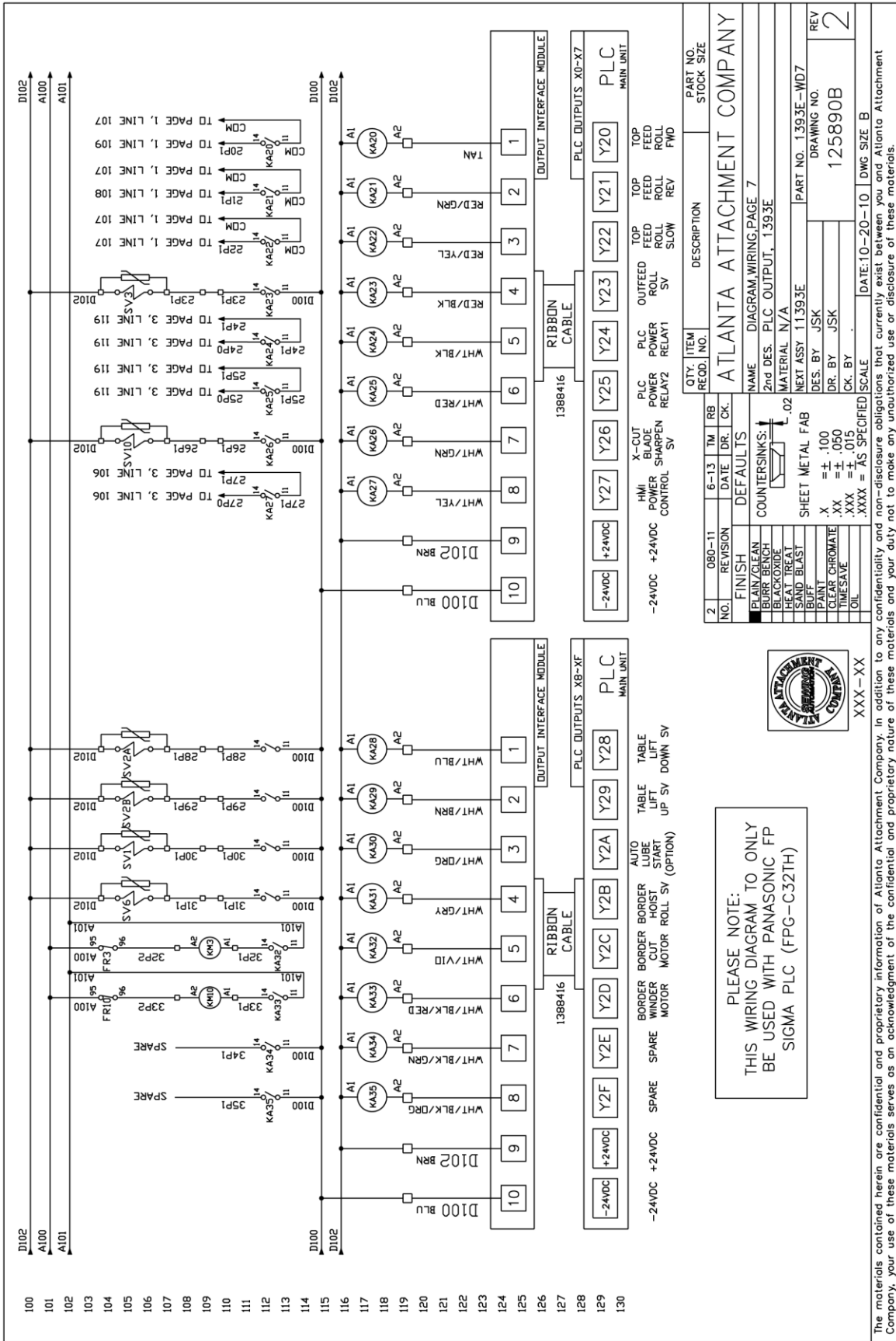
From the library of: Diamond Needle Corp

1393E-WD5 Wiring Diagram



From the library of: Diamond Needle Corp

1393E-WD7 Wiring Diagram



PLEASE NOTE:
THIS WIRING DIAGRAM TO ONLY
BE USED WITH PANASONIC FP
SIGMA PLC (FPG-C32TH)

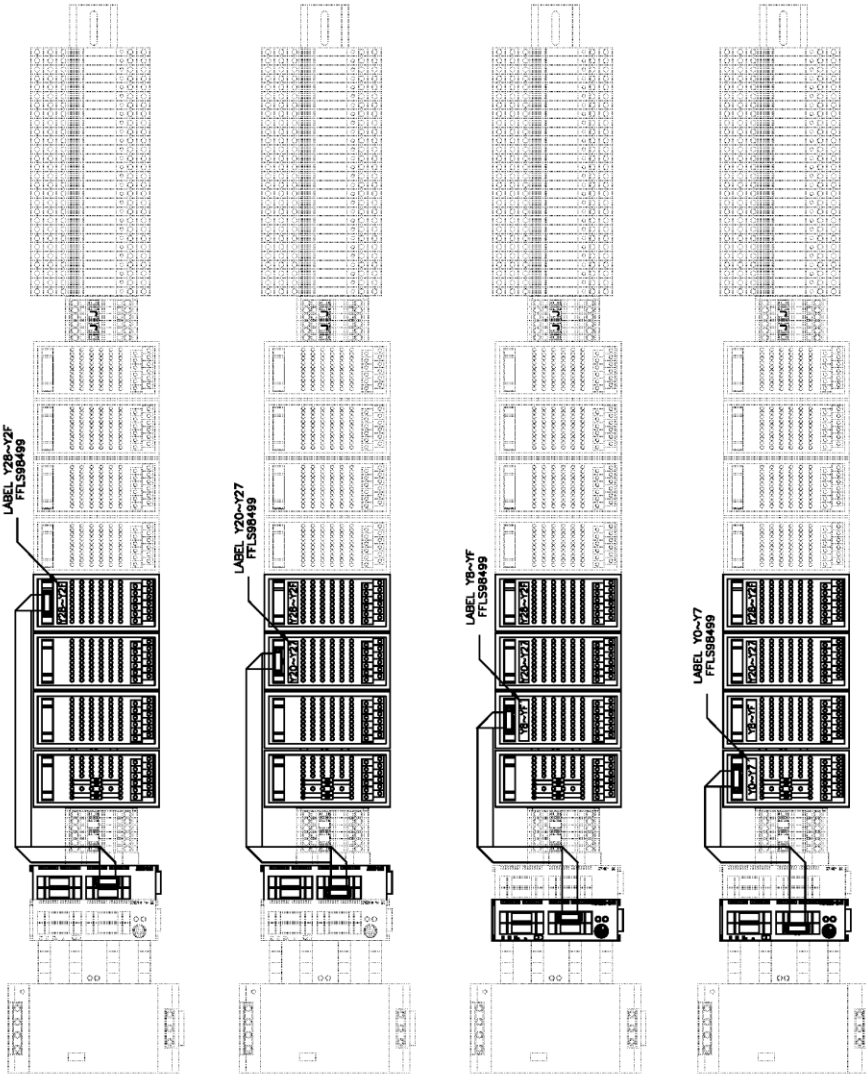


NO.	080-11	6-13	TM	RB	REVISION	DATE	DR.	CK.	DESCRIPTION	PART NO.	STOCK SIZE
2									ATLANTA ATTACHMENT COMPANY		
NAME										DIAGRAM, WIRING, PAGE 7	
2nd DES.										PLC OUTPUT, 1393E	
MATERIAL										N/A	
NEXT ASSY										1393E-WD7	
DES. BY										JSK	
DR. BY										JSK	
CK. BY										JSK	
SCALE										DATE: 10-20-10 DWG. SIZE B	
SHEET METAL FAB										DRAWING NO.	
X = ± .100										125890B	
XX = ± .050										REV	
XXX = ± .015										2	
.XXX = AS SPECIFIED											
OIL											

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1393E-WD10 Wiring Diagram 1 of 12

PLC OUTPUT RIBBON CABLE ROUTING DIAGRAM



PLC OUTPUTS Y28~Y2F

PLC OUTPUTS Y20~Y27

PLC OUTPUTS Y8~YF

PLC OUTPUTS Y0~Y7

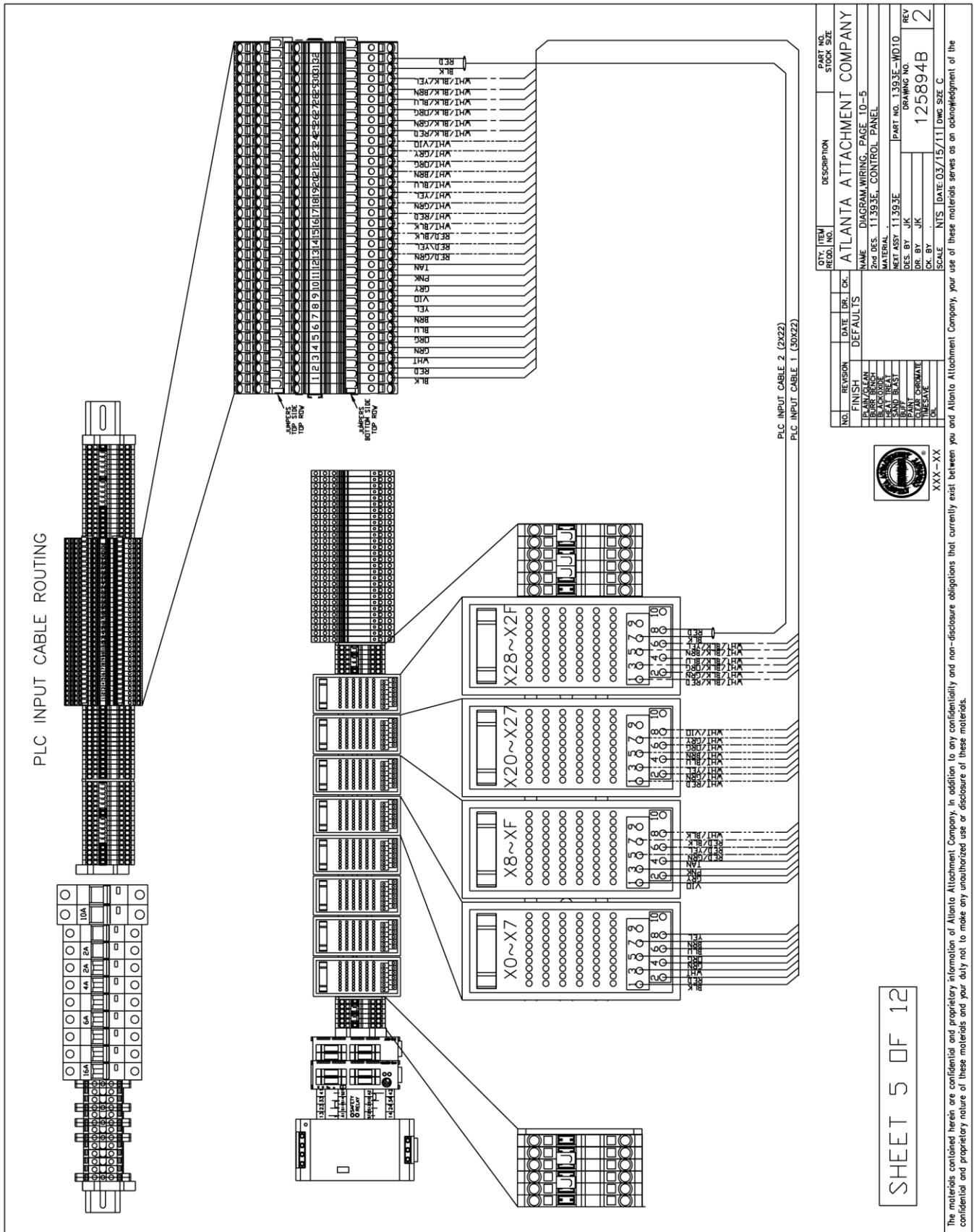
SHEET 1 OF 12

REV	DATE	DESCRIPTION	PART NO.
2	11/15/11	ATLANTA ATTACHMENT COMPANY	125894B
1	11/15/11	DIAGRAM WIRING, PAGE 10-1	
PART NO. 1393E-WD10		DRAWING NO. 125894B	
REV 2		DATE 03/15/11 DWG SIZE C	



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1393E-WD10 Wiring Diagram 5 of 12

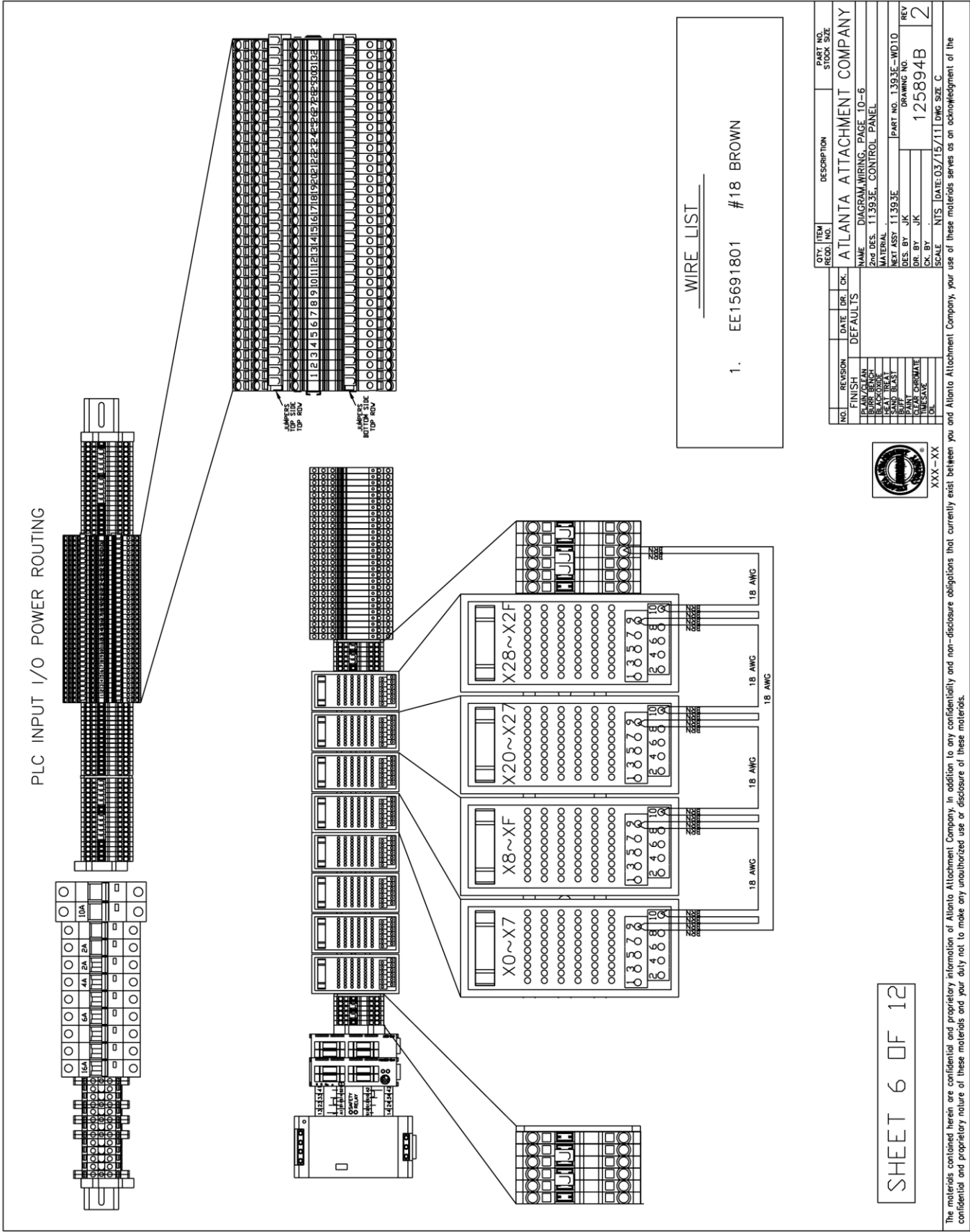


SHEET 5 OF 12

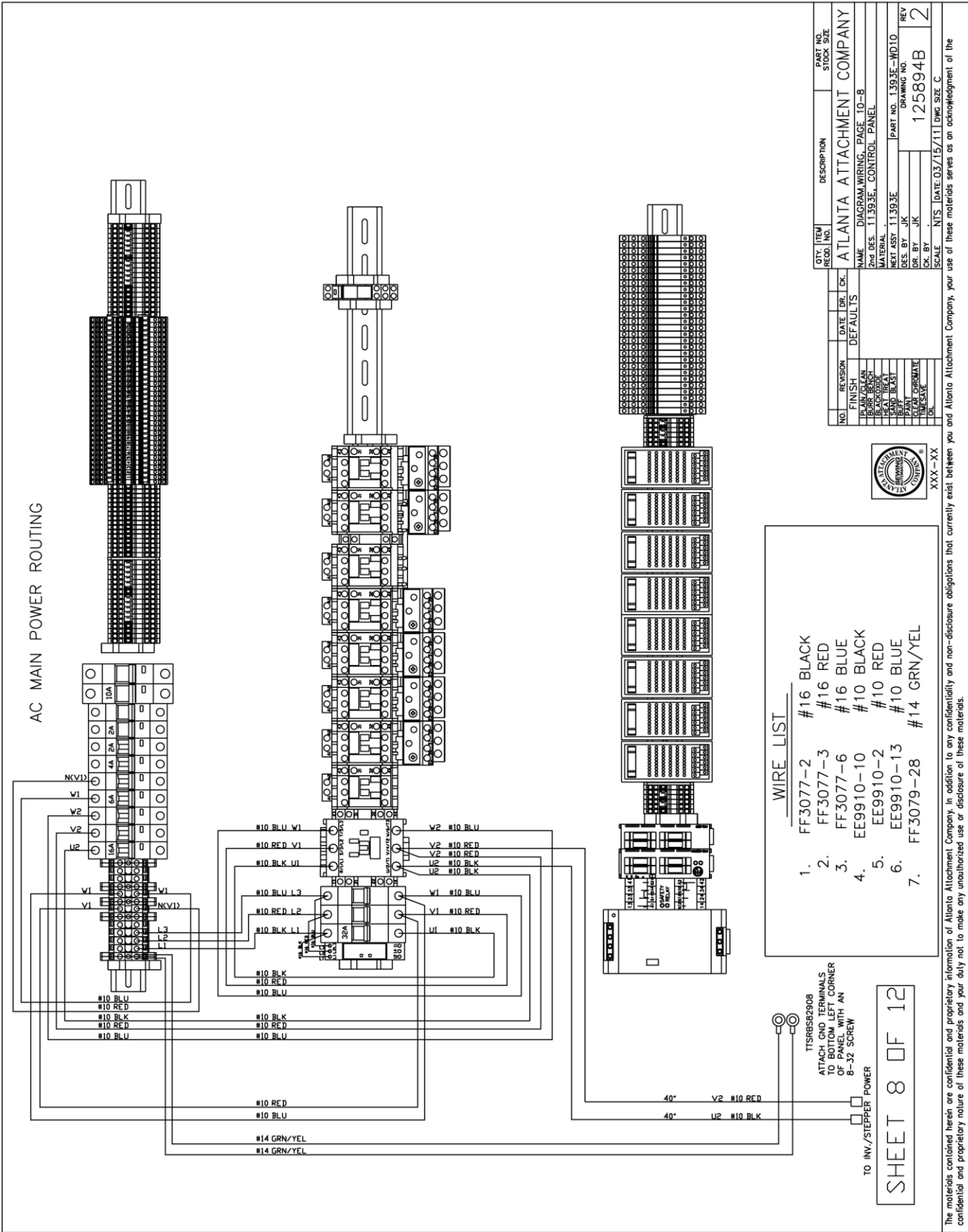
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1393E-WD10 Wiring Diagram 6 of 12



1393E-WD10 Wiring Diagram 8 of 12



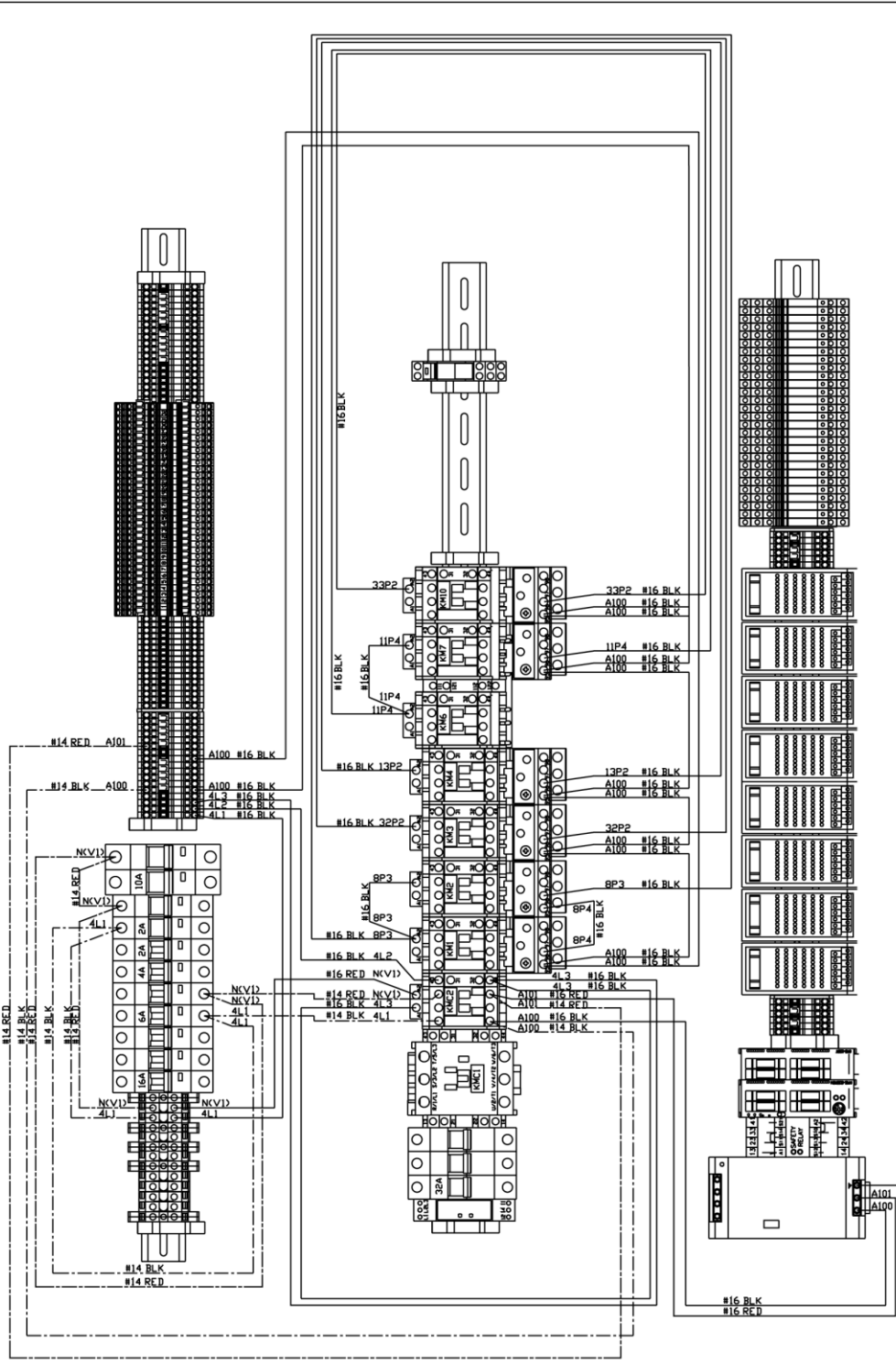
QTY.	ITEM	DESCRIPTION	PART NO.
REVISION	DR. I. OK.	ATLANTA ATTACHMENT COMPANY	STOR. SIZE
NO.	REVISION	DATE	DR. I. OK.
	FINISH	DEFAULTS	
	BAR FINISH		
	IS. AD. COOL		
	SAND BLAST		
	BLT		
	CLEAN CHROMATE		
	TIN PLATE		
	DR. BY	JK	
	CHK. BY	JK	
	SCALE	NTS	DATE: 03/15/11
			DWG. SIZE: C
			DRAWING NO. 125894B
			REV 2



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1393E-WD10 Wiring Diagram 9 of 12

AC CONTROL POWER ROUTING (PART 1)



WIRE LIST

1. FF3077-2 #16 BLACK
2. FF3077-3 #16 RED
3. FF3079-2 #14 BLACK
4. FF3079-3 #14 RED
5. FF3079-28 #14 GRN/YEL

TTSRBS2908
ATTACH GND TERMINALS
TO BOTTOM LEFT CORNER
OF PANEL WITH AN
8-32 SCREW

SHEET 9 OF 12

QTY.	ITEM	DESCRIPTION	PART NO.	STOCK SIZE
		ATLANTA ATTACHMENT COMPANY		
		DIAGRAM WIRING PAGE 10-9		
		204 DES. 11393E, CONTROL PANEL		
		MATERIAL		
		NET ASSY 11393E	PART NO. 1393E-WD10	
		DES. BY JJK	DRAWING NO.	REV
		DR. BY JJK		2
		CK. BY	125894B	
		SCALE NTS DATE: 03/15/11 DWG SIZE C		



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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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