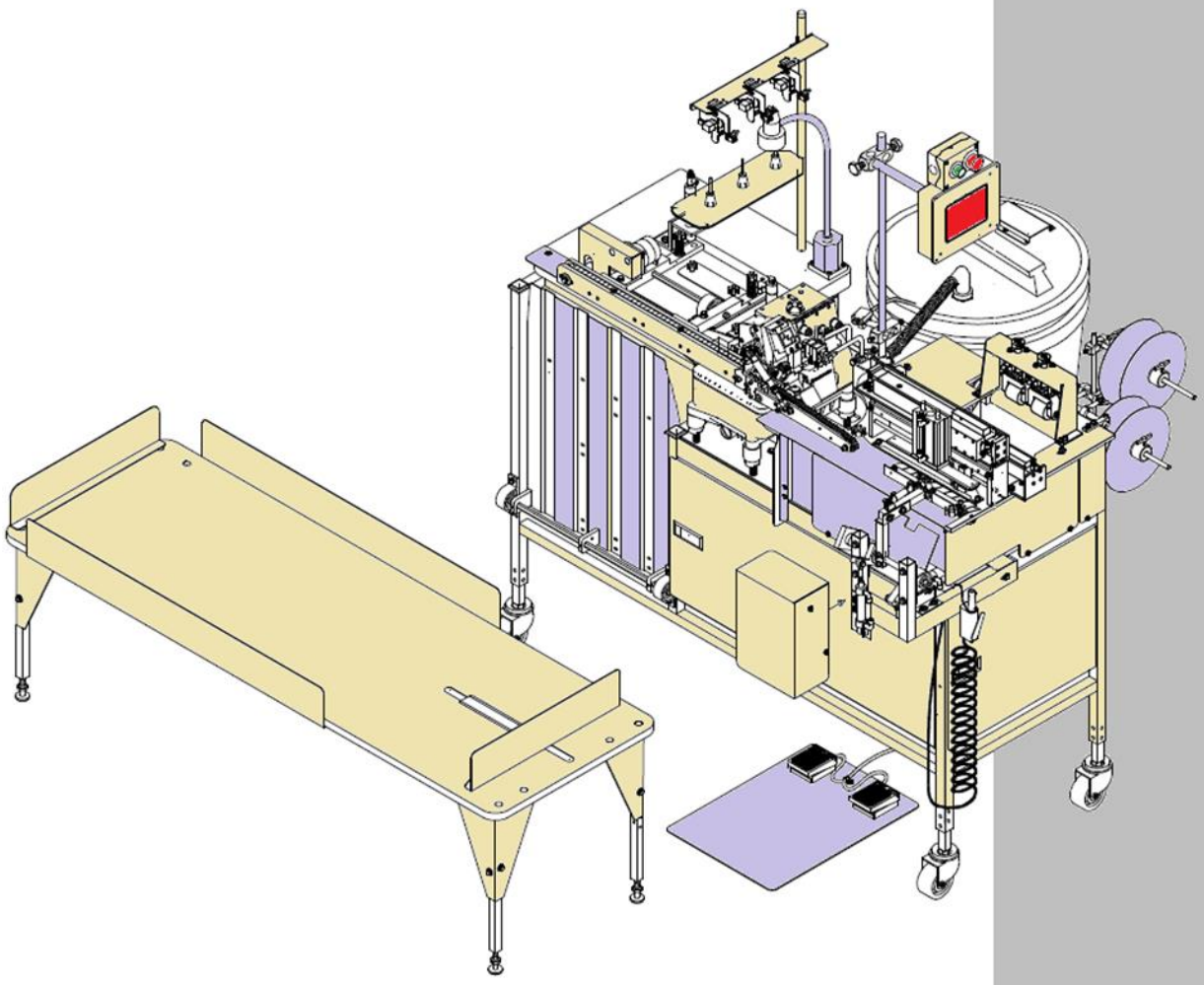
Model **11996BQ65ES**

Revision 2 Updated April 02, 2024(wr)

Parts Manual



362 Industrial Park Drive
Lawrenceville, GA 30046
+1 (770-963) 7369
www.atlatt.com

Atlanta Attachment Company, Inc.

Confidential and Proprietary Information

The materials contained herein are confidential and proprietary information of Atlanta Attachment Company. In addition to any confidentiality and non-disclosure obligations that currently exist between you and Atlanta Attachment Company, your use of these materials serves as an acknowledgment of the confidential and proprietary nature of these materials and your duty not to make any unauthorized use or disclosure of these materials.

All materials contained herein are additionally protected by United States Copyright law and may not be used, disclosed, reproduced, distributed, published, or sold without the express written consent of Atlanta Attachment Company, which consent may be withheld in Atlanta Attachment Company's sole discretion. You may not alter or remove any copyright, trademark, or other notice from copies of these materials.

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.

Patents & Patents Pending

The sale of this product does not sell or otherwise transfer any license or other rights under any U.S. Patent or other corresponding foreign patent.

This equipment is manufactured under one or more of the following patents:
4,280,421 ● 4,432,294 ● 4,466,367 ● 4,644,883 ● 5,134,947 ● 5,159,889 ● 5,203,270 ● 5,373,798 ● 5,437,238 ● 5,522,332 ● 5,524,563 ● 5,562,060 ● 5,634,418 ● 5,647,293 ●5,657,711 ● 5,743,202 ● 5,865,135 ● 5,899,159 ● 5,915,319 ● 5,918,560 ● 5,924,376 ●5,979,345 ● 6,035,794 ● 6,055,921 ● 6,202,579 ● 6,279,869 ● 6,295,481 ● 6,494,225 ●6,523,488 ● 6,574,815 ● 6,802,271 ● 6,834,603 ● 6,968,794 ● 6,994,043 ● 7,543,364 ●7,574,788 ● 7,647,876 ● 7,735,439

Foreign Patents: 9-520,472 ● 0,537,323 ● 92,905,522.6 ● 96,936,922.2 ● 2,076,379 ● 2,084,055
Other U.S. and Foreign Patents Pending.

Contents

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

Scope of the Instruction Material

The Instruction Material comprises:

- Safety information
- Operator Instructions
- Electrical and Pneumatic diagrams

And may also include.

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

Intended Use

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

Exclusion of Misuse

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

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

Liability

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

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

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

The Instruction Material should be supplemented by instructions, including supervisory and notification duties with due regard for special operational features, such as the organization of work, work sequences, the personnel deployed, etc.
The personnel's awareness of the dangers and compliance with the safety regulations should be checked at irregular intervals.

Choice and Qualification of Personnel

Ensure that work on the machine is only carried out by reliable persons who have been appropriately trained for such work - either within the company, by our field staff or at our office - and who have not only been duly appointed and authorized but are also fully familiar with the local regulations. Work on the machine should only be carried out by skilled personnel, under the management and supervision of a duly qualified engineer.
This not only applies when the machine is used for production, but also for special work associated with its operation (start-up and maintenance), especially when it concerns work on the hydraulic or electrical systems, as well as on the software/serial bus system.

Training

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

Responsibilities

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

A Word to the Operator

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

Always be conscious of these dangers!

Safety Equipment on the Machines

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

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

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

Damage

If any changes capable of impairing safety are observed in the machine or its mode of operation, such as malfunctions, faults or changes in the machine or tools, appropriate steps must be taken immediately, the machine switched off and a proper lockout tagout procedure followed. The machine should be examined for obvious damage and defects at least once per shift. Damage found shall be immediately remedied by a duly authorized person before resuming operation of machine.
The machine should only be operated when in perfect working order and when all protective mechanisms and safety equipment, such as detachable protective mechanisms, emergency STOP systems, etc. are in place and operational.

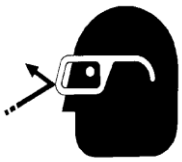
Faults or Errors

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

Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.
Clothing, Jewelry, Protective Equipment
Long loose hair, loose-fitting clothes, gloves, and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

A clear working area without any obstructions whatsoever is essential for safe operation of the machine. The floor should be level and clean, without any waste.
The workplace should be well lit, either by the general lighting or by local lights.

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

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

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

Electrical Power Supply

Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.
In practice, this may mean that the technician, electrician, and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.
Energy sources (electrical/pneumatic/hydraulic, etc.) for the equipment shall be turned off or disconnected and the switches locked or labeled with a warning tag. It is the responsibility of the employer to establish control procedures. Follow lockout/tagout procedures before, setup and/or any service or maintenance work is performed, including lubrication, cleaning, or clearance of jams.

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

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.

- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected, and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

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

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.
All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.
Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.
Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.
Protect against unauthorized access.
Ensure that the machine and accessories are set up in a stable position.
Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Local Regulations

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

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill, and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.
Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.
Retighten all screw connections that have to be loosened for the maintenance and repair work.
Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

The activities and intervals specified in the Instruction Manual for carrying out adjustments, maintenance and inspections must be observed, and parts replaced as specified.
All hydraulic and pneumatic lines should be examined for leaks, loose connections, rubbing and damage whenever the machine is serviced. Any defects found must be remedied immediately.

Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard.
Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control.
When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

Repair

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

Repair, Electrical

The power supply must be switched off (master switch off) and secured so that it cannot be switched on again inadvertently before starting any work on live parts.
Those parts of the machine and plant on which inspection, maintenance or repair work is to be carried out must be isolated from the power supply, if specified. The isolated parts must first be checked to determine that they are truly de-energized before being grounded and short-circuited. Adjacent live parts must also be isolated.
The protective measures implemented (e.g. grounding resistance) must be tested before restarting the machine after all assembly or repair work on electric parts.
Signal generators (limit switches) and other electrical parts on the safety mechanisms must not be removed or bypassed. Only use original fuses or circuit overloads with the specified current rating. The machine must be switched off immediately if a fault develops in the electrical power supply.
The electrical equipment of our machines must be checked at regular intervals and any defects found must be remedied immediately.
If it is necessary to carry out work on live parts, a second person should be on hand to operate the emergency OFF switch or master switch with voltage release in the event of an emergency. The working area should be cordoned off and marked by a warning sign. Only use electrically insulated tools.

Ventilation/Hazardous Gases

It is the end users responsibility to ensure adequate ventilation is provided to exhaust any and all noxious or hazardous gases that may be present in the working environment.
Hydraulic and Pneumatic Systems
Work on hydraulic or pneumatic equipment shall only be carried out by persons with training, knowledge, and experience of hydraulic systems. Pressure lines shall be depressurized before starting any repair work.

General Liability

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

Starting Machine Movements

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

A Word to the End User

The end user has sole responsibility to enforce the use of safety procedures and guards on the machine. Any other safety devices or procedures due to local regulations should be 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.

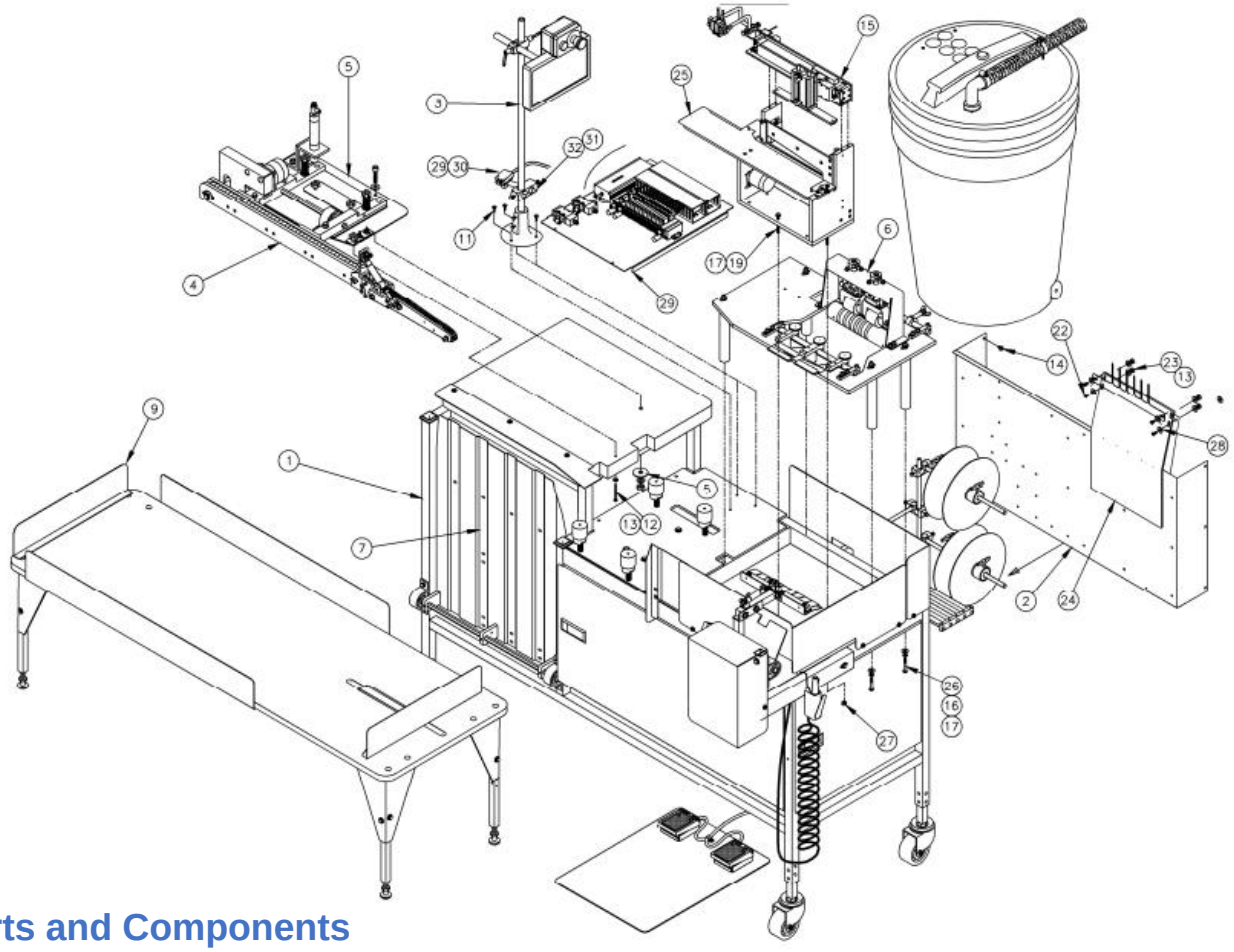
- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS operate equipment in daylight or with adequate working lights.
- Follow daily and weekly checklists, making sure hoses are tightly secured and bolts are tightened.
- ALWAYS watch and avoid holes or deep depressions.

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

NOTE: It is important that the machine technician read the Installation Manual and is familiar with all the functions and safety concerns of the unit before Installing and operating.



Parts and Components

	Part Number	Description		Part Number	Description
1	1996-01D	Table Stand Motor	17	WWFS1/4	Washer, Flat
2	1996005	Electric Box Assy	18	1996B-PD	Diagram, Pneumatic
3	97-1700A	Control Box Assy	19	SSHC01192	Screw, Hex, 1/4-20 x 3
4	1996-05	Top Conveyor Assy	20	1996ES-WD	Diagram, wiring
5	1996-06	Conveyor MT Kit	21	SSTS98040	Screw, Truss, 10-32 x 5/8
6	1996-08B	Feed Assy	22	NNK10-32	Kep nut
7	1996-12	Stacker Door	23	1996-038	Plate, SLK Loop
8	1996010	Cable Package	24	1996-300A	Guillotine Assy
9	1996-15A	Indexing Table	25	SSHC01160	Screw, Hex, 1/4-20 x 2-1/2
10	1996-Label	Label Package	26	NNK1/4-20	Kep nut
11	SSFP01048	Screw, Phillips, 1/4-20 x 3/4	27	1996-23	Stripper Fingers
12	SSPS95128	screw, Pan Slotted, 10-24 x 2	28	1996007	Panel, Pneu Control
13	WWFS10	Washer	29	FFSM312LVQ	Photocell
14	SSZS93032	Screw, sheet metal 10-16 x 1/2	30	265155A	Holder, eye
15	1996-10B	Transfer Sub-assy	31	1740BB-43	Rod, straight
16	WWL1/4	Washer, 1/4 lock	32	28201	Rod, connector

Technical Data

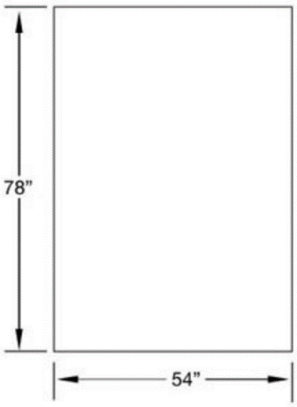
Voltage (v/ph/hz)	220v 1ph
Current (amps)	5
Air pressure (psi)	90
Air consumption (cfm)	10
Shipping weight (lbs)	1100
Shipping dimensions (w/l/h, inch)	96 x 55 x 60

Production: Approximately 487 pieces per hour. Estimate based on cycle time, material changeover, and machine program time.
Cycle time: Approx. 17" (43.2 cm) strip - .066 min 30" (76.2 cm) strip .086 min
Changeover time: Approx. 30 seconds, by the operator
Capacity: Width minimum 2" (5.08 cm) to 8" (20.32 cm) roll or 4"(dual roll).
Band Length: 15" (38.1 cm) to 52" (132 cm) (7 1/2" (19.05 cm) to 26" (66.04 cm) folded)
Seamer: Yamato 8003 3 thread (504 stitch)
Controls trim-off: 1/4" (6.4 mm) o 1/8" (3.2 mm)
Cut length: Programmable in 1/10" increments

Tolerances
Alignment: Side +/-1/16" (1.2mm), Ends +/-1/16" (1.2mm),
Length Repeatability:+/-1/8" (3.2 mm) (rib knit). Length Is Adjustable to Nearest 1/10 (2,5mm)
Cutting Accuracy: Within 1/8" (3.2 mm) of programmed length
Seam ply alignment: Within 1/8" (3.2 mm) obtainable

Footprint

Machine footprint is 78" x 54" (198x137 cm) Leave enough free space around to be able to open all doors and have access for maintenance.



Machine Identification Label

Machine identification is located on top of the table behind the sewing head. Its contents are the machine class and the Serial Number. Ex: 218427031707
Serial number is divided as follow.
First number identify the order number 218427
Next number month of manufacturing (03)
Next number the year of manufacturing (17)
Following a correlative number 07

2. SERVICE

NOTE: Maintenance should only be performed by trained, qualified personnel.

Lockout/Tagout Program

"Lockout/Tagout (LOTO)" refers to specific practices and procedures to safeguard employees from the unexpected energization or startup of machinery and equipment, or the release of hazardous energy during service or maintenance activities. This requires that a designated individual turns off and disconnects the machinery or equipment from its energy source(s) before performing service or maintenance and that the authorized employee(s) either lock or tag the energy-isolating device(s) to prevent the release of hazardous energy and take steps to verify that the energy has been isolated effectively. The following references provide information about the LOTO process.

Equipment Energy Control Procedure Lockout/Tagout Program				
Description: **Band / Collar Maker**			Model: **1996B**	
Manufacturer: **Atlanta Attachment Co.**			Location:	
Energy		Location	Magnitude	Control Method
Electrical:	X	Disconnect/Ctrl Box	**220V**	Lockout & Tag
Pneumatic:	X	Main Regulator	**80 PSI**	Lockout & Tag
Gravity:	X	Belts		
Remember to Release All Stored Energy!				
Shutdown Procedure:				
Inform all affected personnel that the machine will be in Lockout status. Turn the power and pneumatic disconnects to the OFF position. Fill out the tag with necessary information of the Lockout. Install the Lockout device. Verify all stored electrical energy has been released by pressing the power on button. Also, use meter to test circuits in the electrical panel to insure stored energy is released there as well. Perform necessary maintenance, services and/or repairs.				
Startup Procedure:				
Inform all affected personnel that the Lockout of this machine is being removed. Replace any guards or safety devices which may have been removed during maintenance. Remove the Lockout device and tag. Turn the power and pneumatic disconnects to the ON position. Push the green button on the back of the control panel to turn the machine on. Inform all affected personnel that the Lockout has been removed and that the machine is ready for normal production operation.				

Approved By: _____ Date: _____

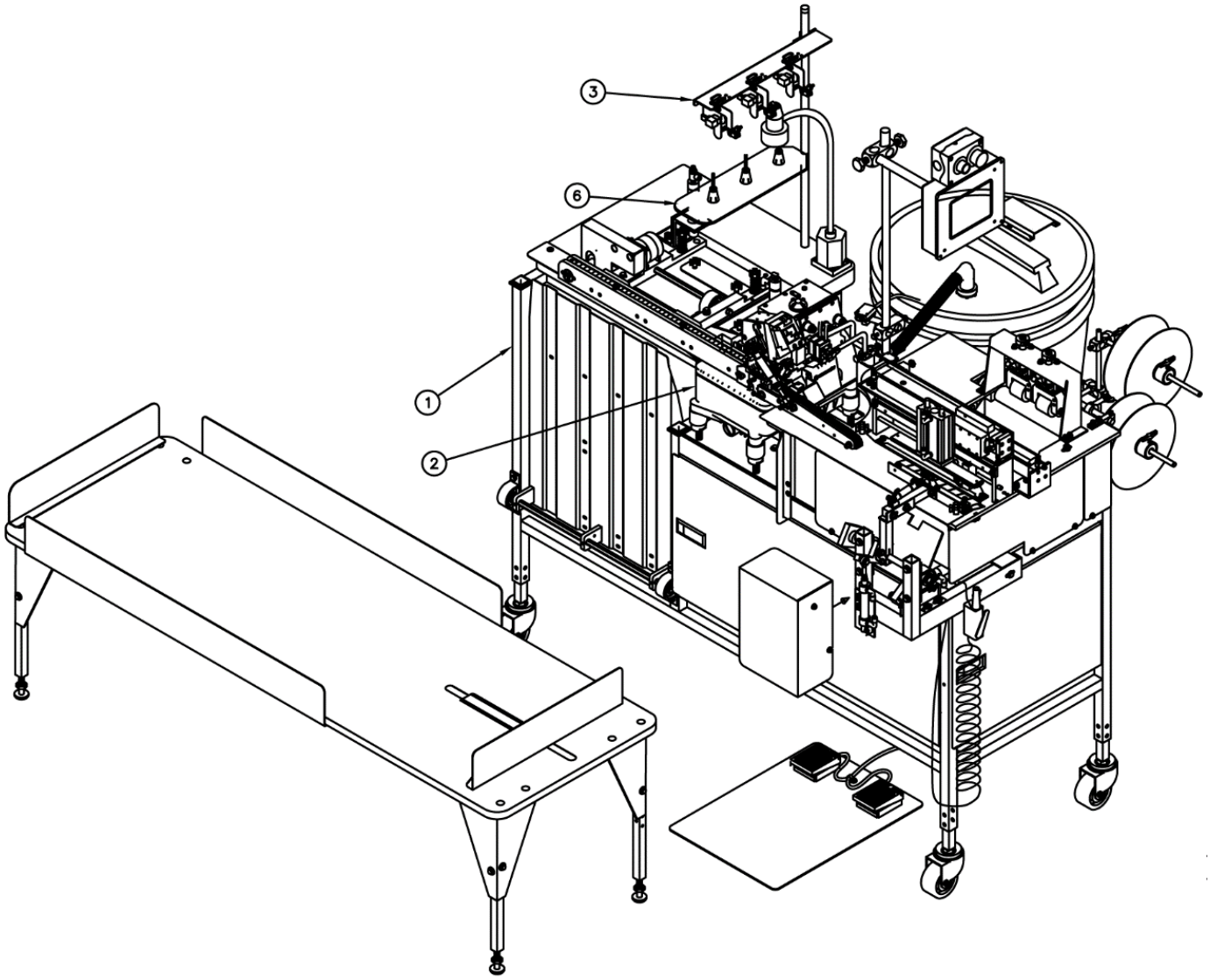
Notes:

3. Assembly Drawings & Parts Lists

The materials contained herein are confidential and proprietary information of Atlanta Attachment Company. In addition to any confidentiality and non-disclosure obligations that currently exist between you and Atlanta Attachment Company, your use of these materials serves as an acknowledgment of the confidential and proprietary nature of these materials and your duty not to make any unauthorized use or disclosure of these materials.

11996BQ65ES Auto Collar & Band, DC1500, SBUS

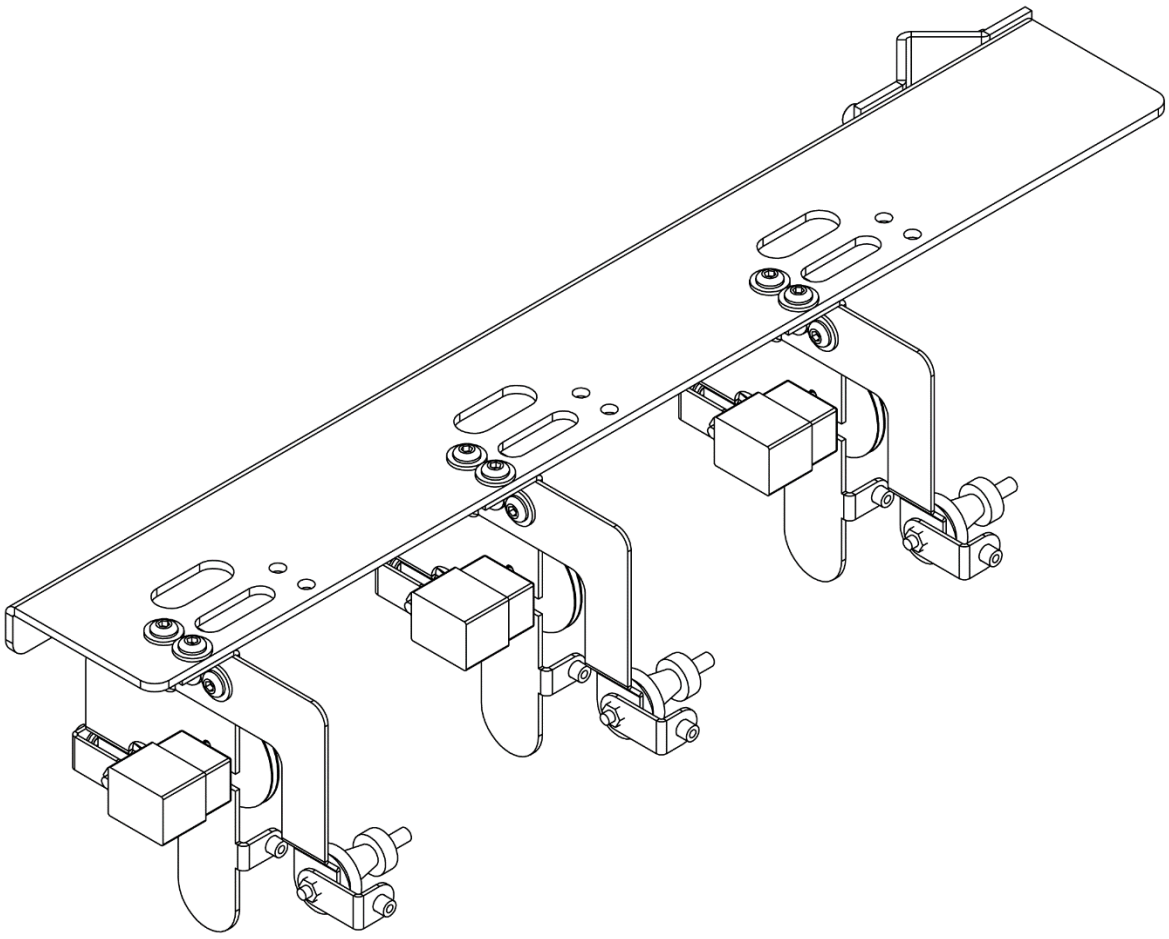
AAC Drawing Number 192206B Rev 0



NO	QTY	PART #	DESCRIPTION
1	1	1996GD	AUTO COLLAR & BAND UNIT
2	1	1996A-02Q65	JUKI SEWING HEAD & DETAIL
3	1	1996011	THREAD ASSEMBLY
4	1	1996A-EFKA	PACKAGE, EFKA DC1500
5	1	1996ES-WD	WIRING DIAGRAM
6	1	1959-161	3 POS THREAD PLATE ASSY

1996011 Three Rotary Thread Brake Assembly

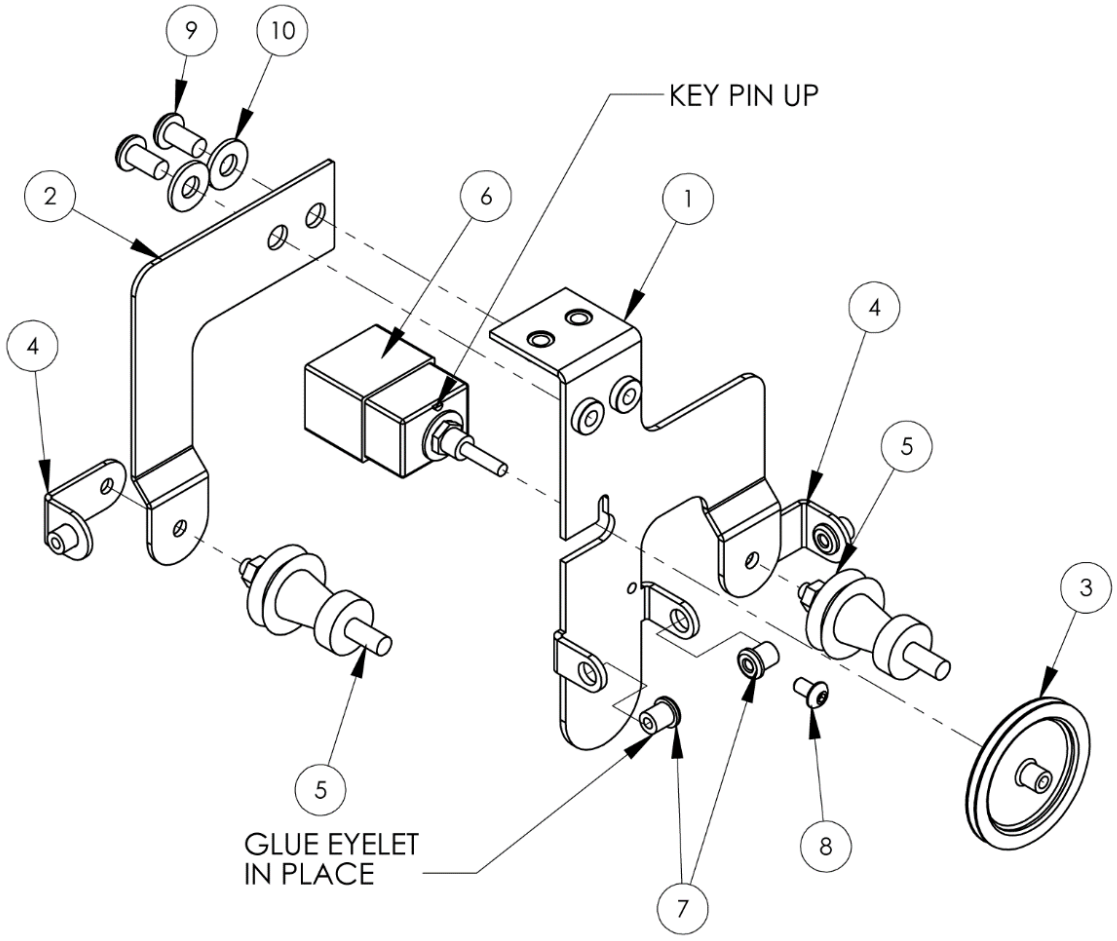
AAC Drawing Number 1996011 Rev 0



NO	QTY	PART #	DESCRIPTION
1	1	0411-069C	BRKT,THREAD BRK DETECTION
2	1	0411-070	CLAMP, SENSOR BRACKET
3	3	4003-500B	THREAD BREAK SENSOR ASSY
4	6	SSBC98024	10-32 X 3/8 BUTTON CAP SC
5	2	SSSC98048	10-32 X 3/4 SOC CAP
6	8	WWFS10	WASHER, FLAT, #10, SAE
7	2	WWL10	WASHER,LOCK,#10

4003-500B Thread Brake Sensor Assembly

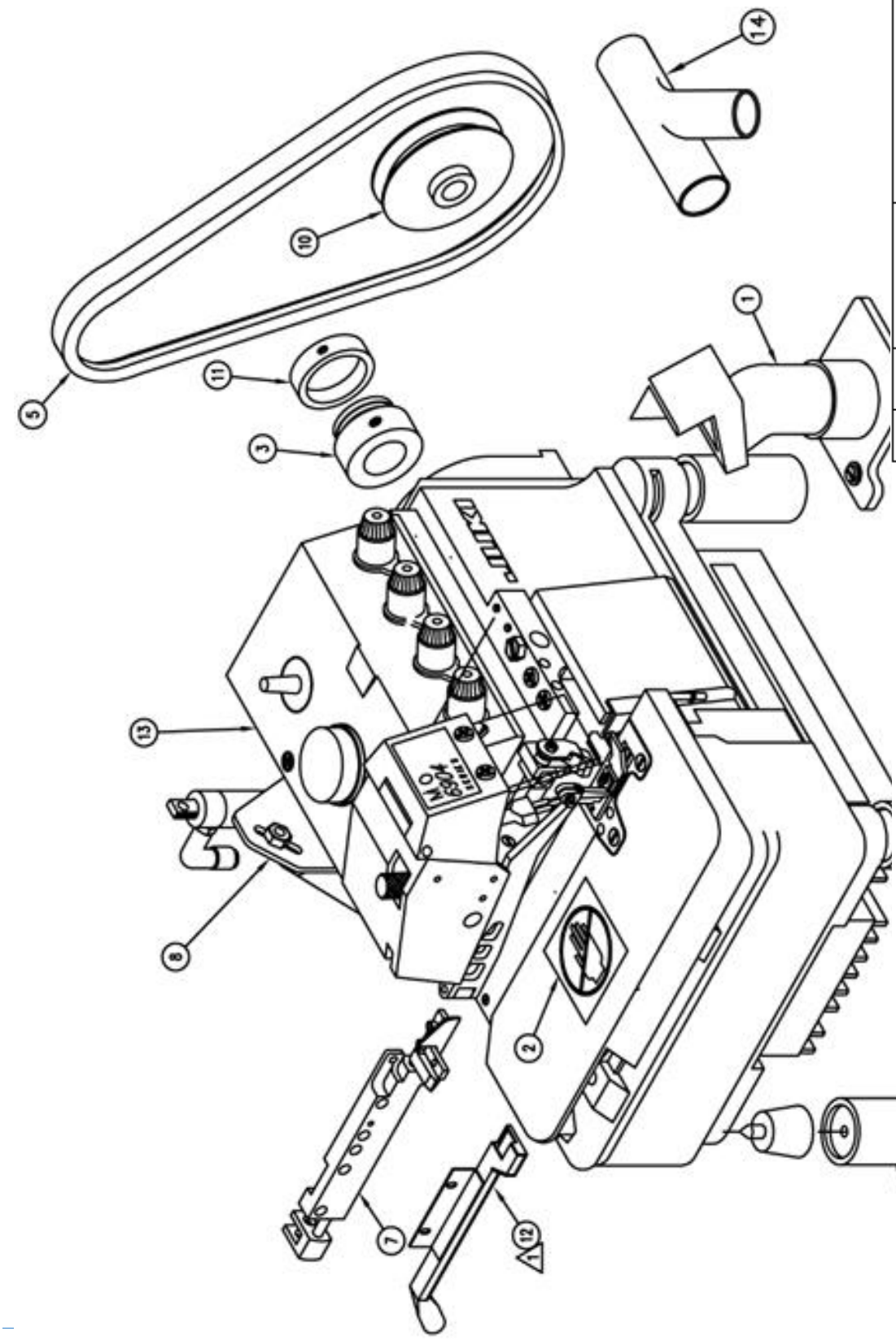
AAC Drawing Number 9002422 Rev 4



NO	QTY	PART #	DESCRIPTION
1	1	4003-501A	BRACKET,ENCODER MOUNT
2	1	4003-501B	BRKT,AUX TENSION SPRING
3	1	4003-502A	WHEEL,THREAD SENSOR
4	2	4003-504	THREAD GUIDE, IN/OUT
5	2	4003-BYW2	THREAD TENSION, EYELET
6	1	EENC025	ENCODER,SBUS,025,1/8
7	2	MMKC34	CERAMIC EYELET FOR THREAD
8	1	SSBC80012	BHCS #6-32X..25L
9	2	SSBC98024	10-32 X 3/8 BUTTON CAP SC
10	2	WWFS10	WASHER, FLAT, #10, SAE

1996A-02Q65 Sewing Head Detail

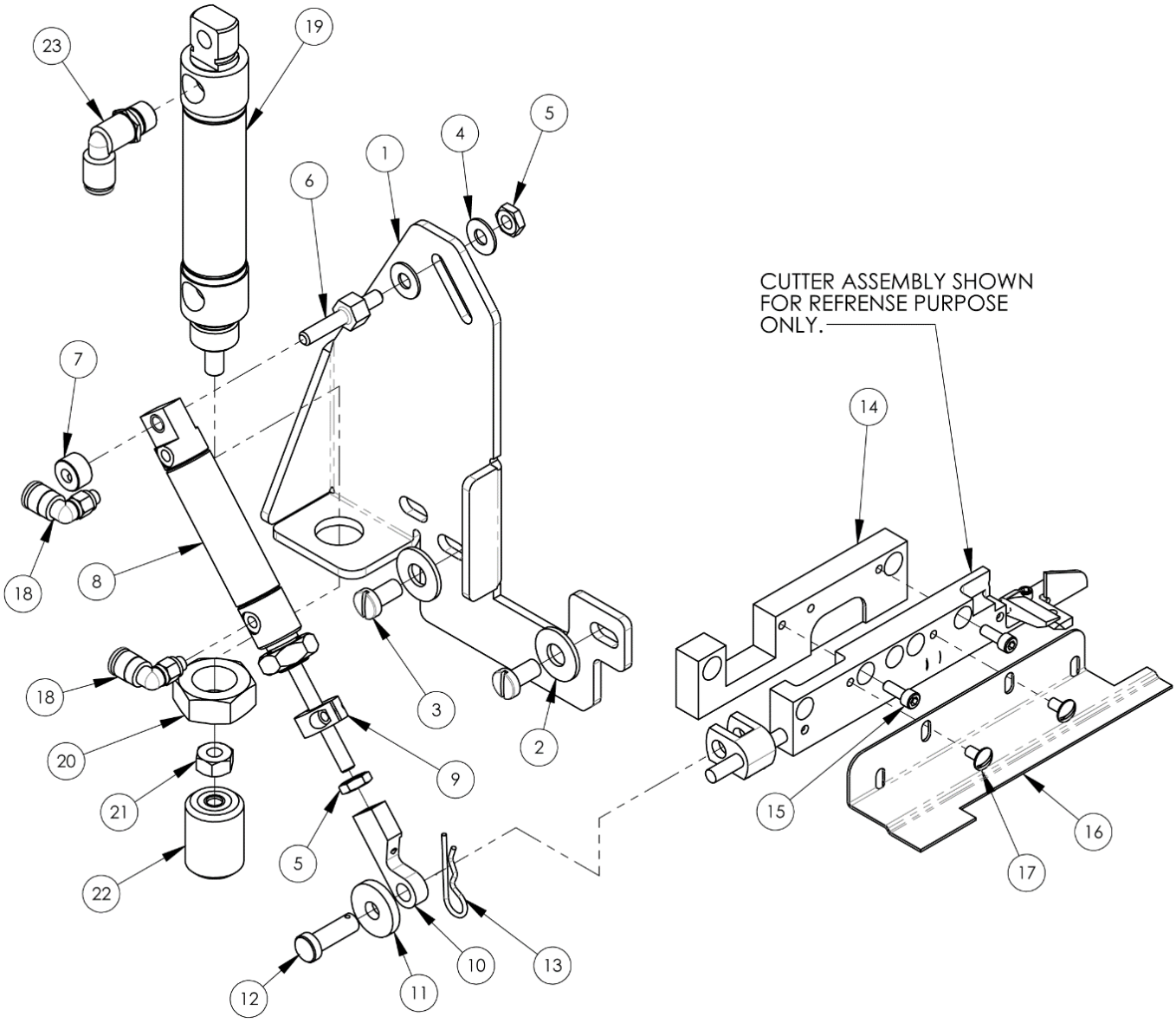
AAC Drawing Number 191054B Rev 0



NO	QTY	PART #	DESCRIPTION
1	1	MM16314B1	FUNNEL
2	1	26276E	LABEL
3	1	311-128	TAPE MOUNTING
4	4	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1
5	1	ZX3835	V BELT
6	1	AAQME-5-8	ELBOW
7	1	1975-400MG	CUTTER ASSEMBLY, 3/4 CUT
8	1	1975-400Y	CUTTER AND FOOTLIFT COMP.
9	4	23275	ISOLATOR MOUNT
10	1	4059-PM63	MOTOR PULLEY
11	1	311-129	TAPE MOUNTING
12	1	217-J001A	CHUTE, CHAIN SCRAP, 3/4 CUT
13	1	SJUKI-6916S	SEWING HEAD
14	1	AAV#TBV400	CHAIN & WASTE VAC

1975-400Y Cutter & Foot lift Comp.

AAC Drawing Number 9006412 Rev 5

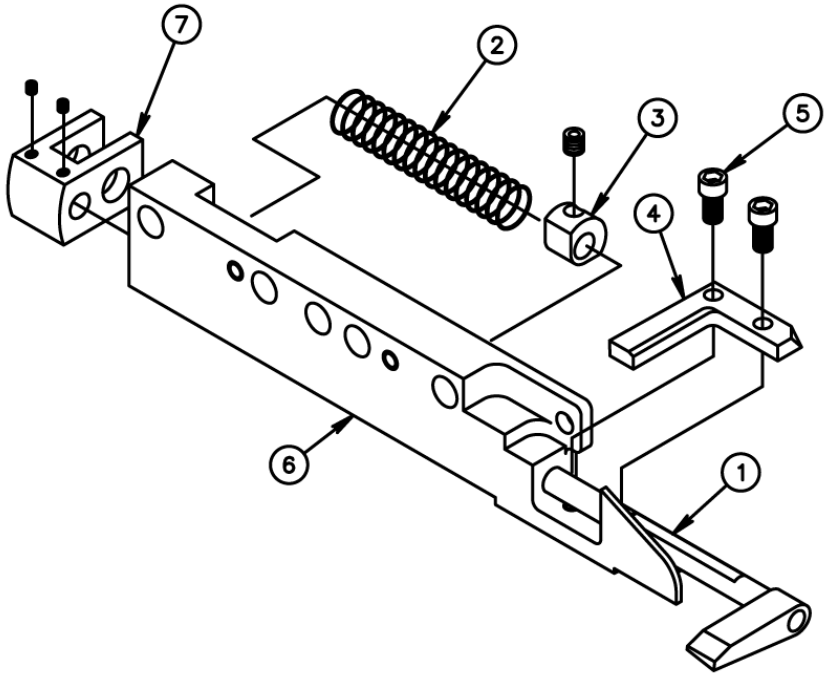


1975-400Y parts list

NO	QTY	PART #	DESCRIPTION
1	1	1975-452	MOUNT, COMB. CYLINDER
2	2	WWF1/4	WASHER, FLAT, 1/4", COM
3	2	SSM7151210	SCREW, 15/64-28X7/16
4	2	WWF10	WASHER, FLAT, #10, COM
5	2	NNH10-32	HEX-NUT 10-32 REG.
6	1	1976-048	STUD, CYLINDER MOUNT
7	1	CCSC33/16	COLLAR,SET,3/16"
8	1	1975-213A	CYL,AIR,DA,9/16 B,1S
9	1	CCCL3F	CLAMP COLLAR- 3/16
10	1	1975-408	LINK, DRIVE
11	1	WWFF1/4A	WASHER,FLAT,FELT
12	1	MM92390A15	PIN,CLEVIS, 14"D X 3/4"L
13	1	MM98335A04	SPRING CLIP
14	1	1975-451	SPACER, CUTTER BODY
15	2	SSSC85024	6-40 X 3/8 SOC CAP SC
16	1	1975-445	GAURD, MATERIAL
17	2	SSTS85016	#6-40 X 1/4 TRUSS HEAD
18	2	AAQME-5-10	AIR ELBOW, 10-32 X 5/32
19	1	AAC7DP-1	CYL.,AIR,DA 3/4 BORE,1STR
20	1	NNJ5/8-18	NUT-HEX JAM 5/8-18
21	1	NNH1/4-28	NUT,HEX,1/4-28
22	1	11200	BUMPER,1/4-28
23	1	AAQME-5-8	QUICK MALE ELBOW

1975-400MG Cutter Assembly

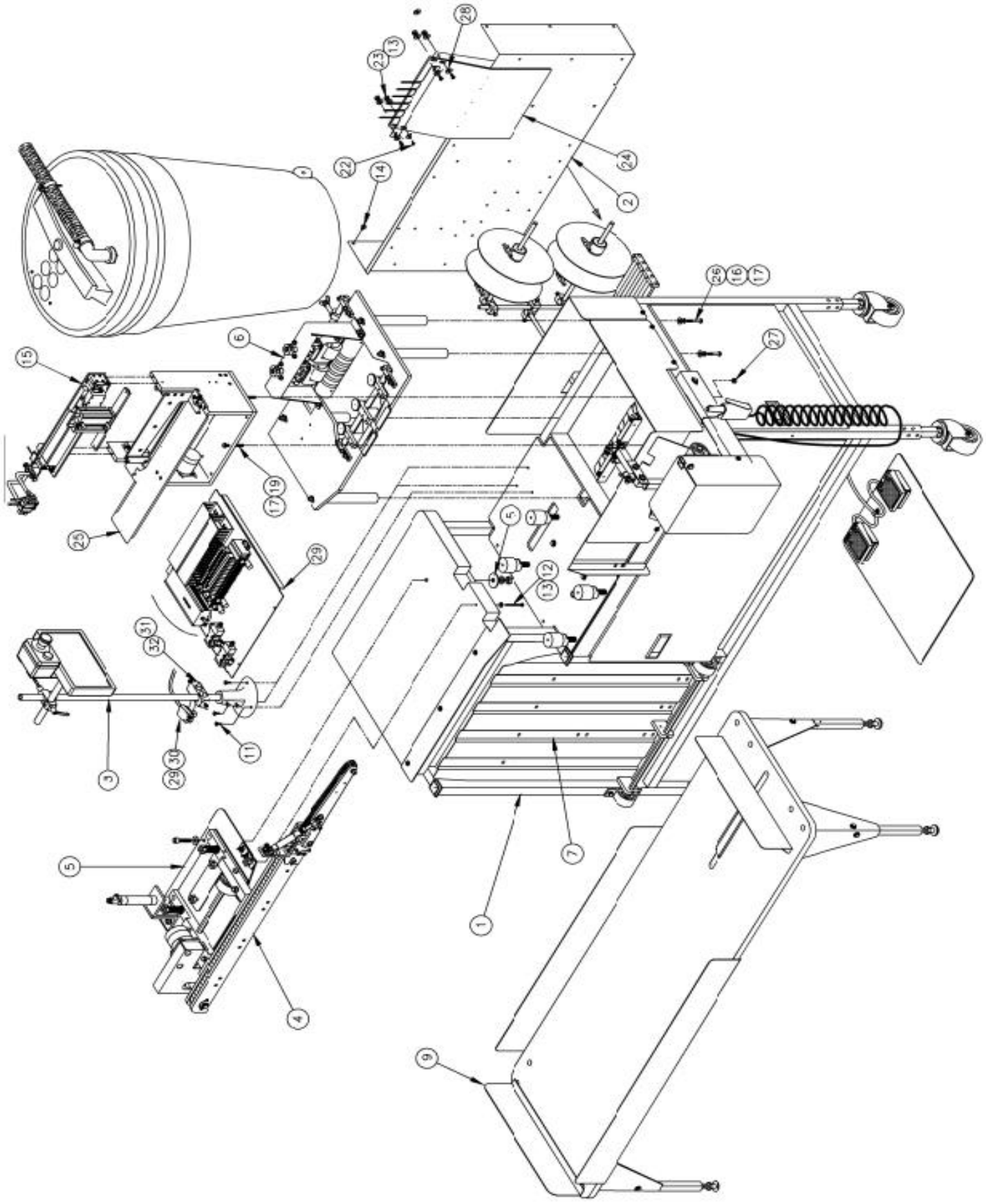
AAC Drawing Number 191731C Rev 1



NO	QTY	PART #	DESCRIPTION
1	1	ATC2-Y2302	UPPER CUTR ASSY
2	1	RRLC026CD15S	SPRING
3	1	1976-002	RETAINER
4	1	ATC2-Y2303	LOWER CUTTER
5	2	SSSC70016	SCREW, SOCKET, CAP 4-40 X .25
6	1	1975-432	CUTTER BODY
7	1	1975-407	CLEVIS

1966GD Console, SBUS, EFKA

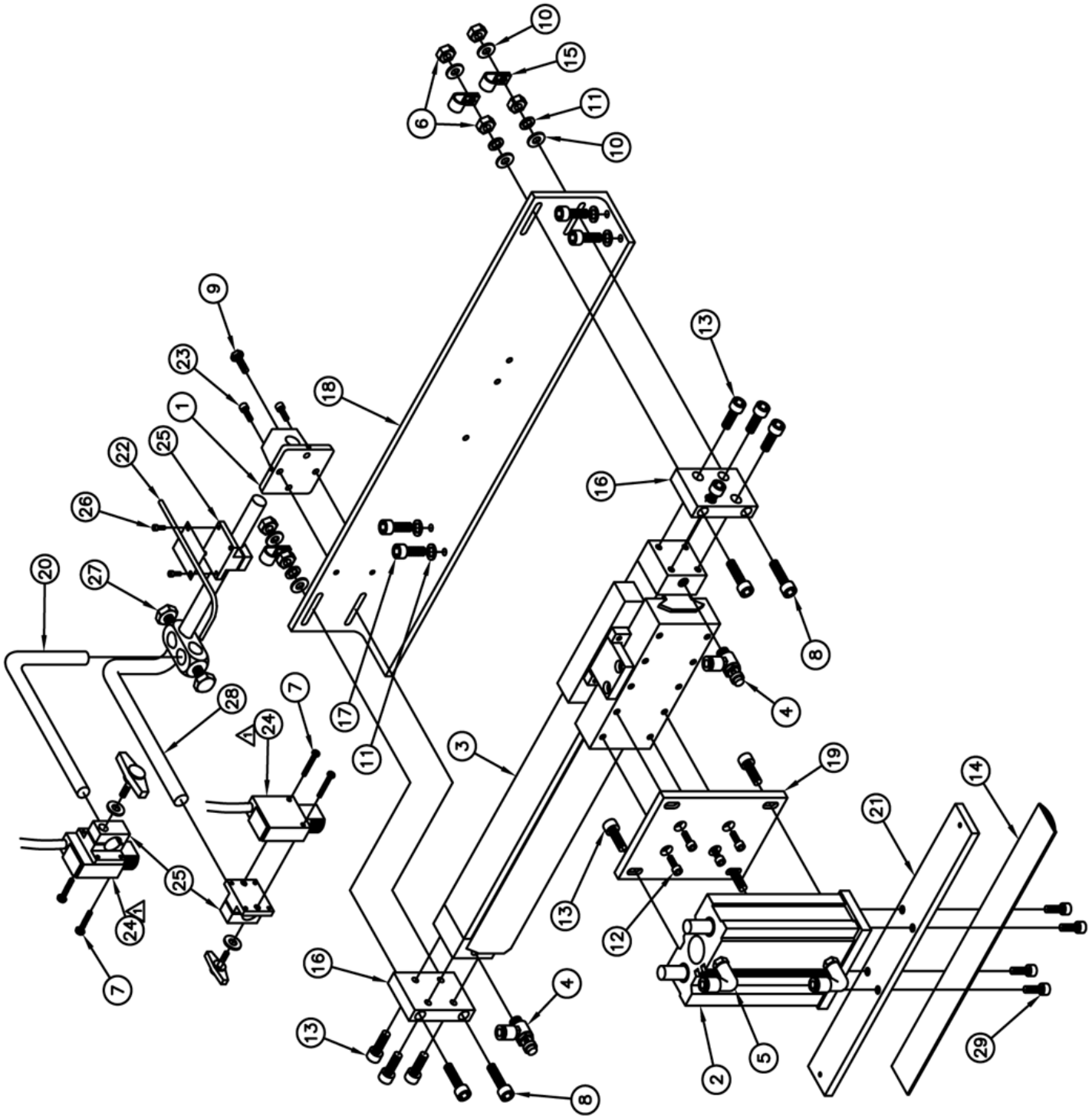
AAC Drawing Number 192205B Rev 2



	Part Number	Description			Part Number	Description
1	1996-01D	Table Stand Motor		17	WWFS1/4	Washer, Flat
2	1996005	Electric Box Assy		18	1996B-PD	Diagram, Pneumatic
3	97-1700A	Control Box Assy		19	SSHC01192	Screw, Hex, 1/4-20 x 3
4	1996-05	Top Conveyor Assy		20	1996ES-WD	Diagram, wiring
5	1996-06	Conveyor MT Kit		21	SSTS98040	Screw, Truss, 10-32 x 5/8
6	1996-08B	Feed Assy		22	NNK10-32	Kep nut
7	1996-12	Stacker Door		23	1996-038	Plate, SLK Loop
8	1996010	Cable Package		24	1996-300A	Guillotine Assy
9	1996-15A	Indexing Table		25	SSHC01160	Screw, Hex, 1/4-20 x 2-1/2
10	1996-Label	Label Package		26	NNK1/4-20	Kep nut
11	SSFP01048	Screw, Phillips, 1/4-20 x 3/4		27	1996-23	Stripper Fingers
12	SSPS95128	screw, Pan Slotted, 10-24 x 2		28	1996007	Panel, Pneu Control
13	WWFS10	Washer		29	FFSM312LVQ	Photocell
14	SSZS93032	Screw, sheet metal 10-16 x 1/2		30	265155A	Holder, eye
15	1996-10B	Transfer Sub-assy		31	1740BB-43	Rod, straight
16	WWL1/4	Washer, 1/4 lock		32	28201	Rod, connector

1996-10B Transfer Sub-Assembly

AAC Drawing Number 192118C Rev 4

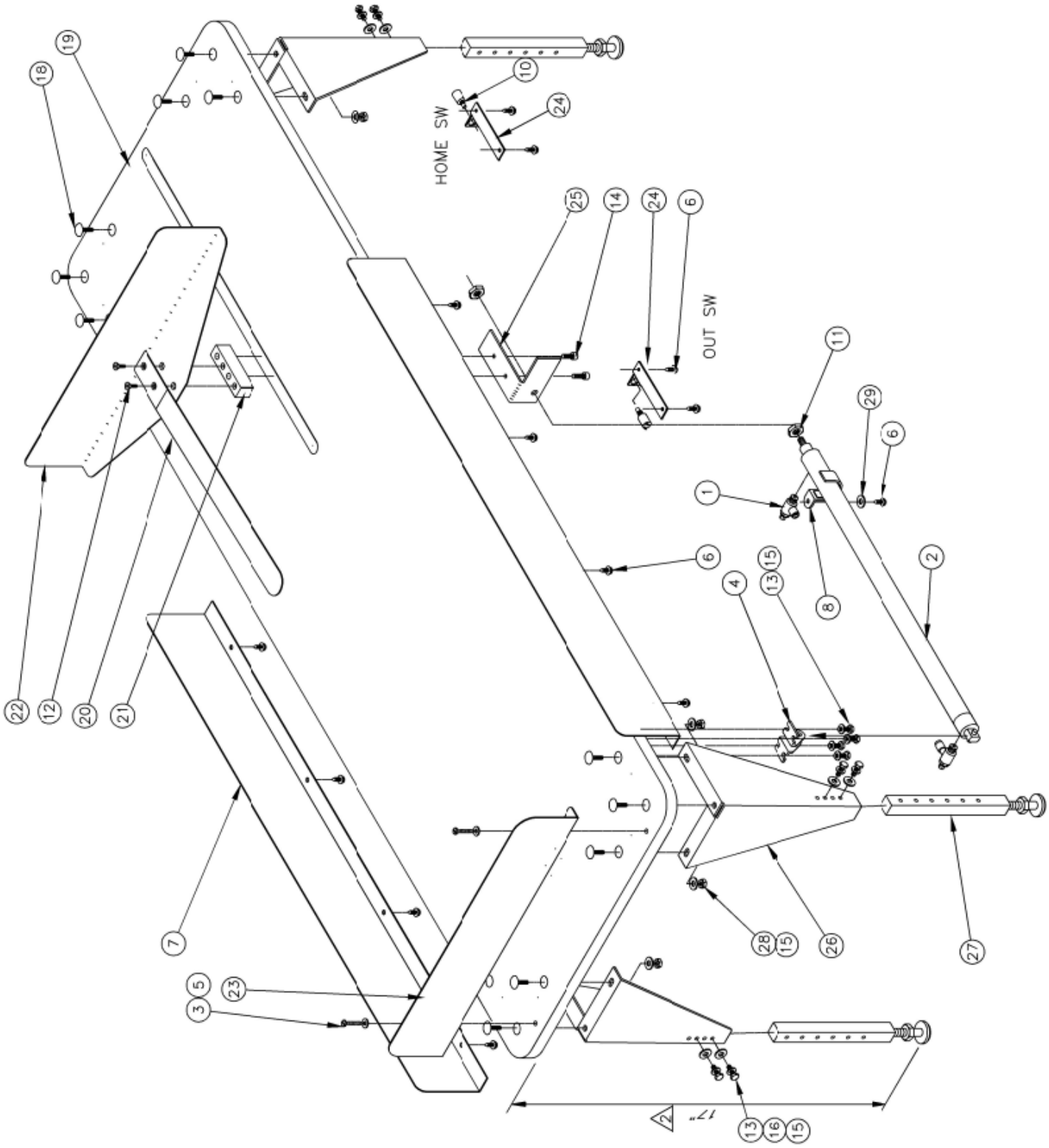


1996-10B part list

NO	QTY	PART #	DESCRIPTION
1	1	265160A	BASE, EMERG
2	1	AACMGQ2075	CYL.,AIR DUAL ROD
3	1	AACR203010	AIR CYLINDER
4	2	AA198RA408	FLOW CONTROL
5	2	AAQME-5-8	QUICK MALE ELBOW
6	8	NNH10-32	HEX NUT, 10-32
7	4	SSPS70048	SCREW, PAN HD SLOTTED 4-40 X 3/4
8	4	SSSC98144	SCREW, SOCKET CAP 10-32 X 2 1/4
9	1	SSHC10064	SCREW, HEX CAP 5/16-18 X 1
10	8	WWFS10	SAE FLAT WASHER
11	8	WWL10	WASHER, LOCK
12	4	SSSCM6X20	SCREW, SOCKET CAP M6 X 20
13	11	SSCM5X16	SCREW, SOCKET CAP 5MM X 16MM LONG
14	.9'	MM93085K15	GROM. STRIP, RUB.
15	4	AAF3/16	CLAMP, BLACK
16	2	0411-3123	BLOCK, MOUNTING
17	4	SSSC98040	SCREW, SOCKET CAP 10-32 X 5/8
18	1	1996-101A	BEAM, TRANSFER
19	1	1996-102A	PLATE, TRANSFER
20	1	350-5913	ROD, 1/2"
21	1	1996-104	PAD, TRANSFER
22	1	1996-107	UNCURLER BLOW TUBE
23	2	SSSC98032	SCREW, SOCKET CAP 10-32 X 1/2
24	2	FFSM312LVQ	ELECTRIC EYE
25	3	265155A	HOLDER, EYE
26	2	SSSC70016	SCREW, SOCKET CAP 4-40 X 1/4
27	1	A-U	ROD CONNECTOR
28	1	1996-103A	ROD, 1/2" 90 DEGREES X 2
29	4	SSSCM5X10	SCREW, SOCKET CAP M5 X 10

1996-15A Indexing Table

AAC Drawing Number 191083 Rev 0

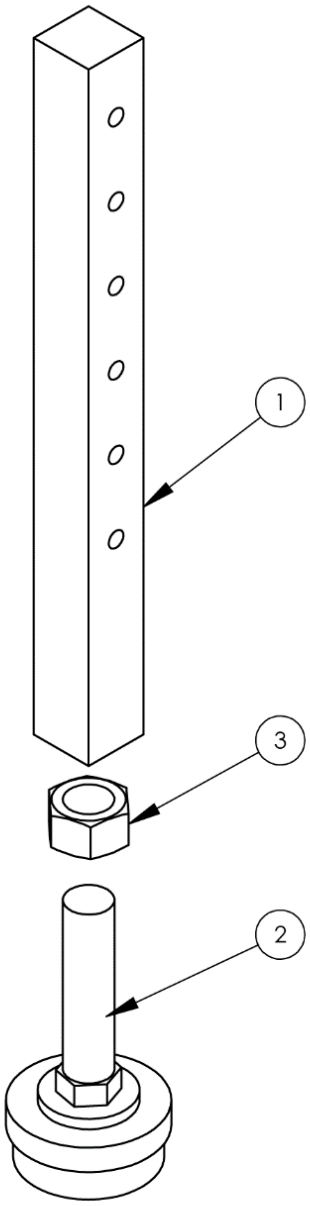


QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
24	15	1/4 WASHER	WWFS1/4
2	14	SCREW, SOCKET CAP 10-32 x 1/2	SSSC98032
12	13	SCREW, HEX CAP 1/4-20 x 3/4	SSHC01048
2	12	SCREW, FLAT ALLEN CAP 10-32 x 1/2	SSFC98032
2	11	5/16-24 JAM NUT	NNJ5/16-24
2	10	N.O. SWITCH	FF23F439
8'	9	5/32 AIRLINE	AATP5/32
1	8	1 1/4 STRAP	MM2235
2	7	EDGE GUIDE	311-127
13	6	SCREW, HEX SHEET METAL NO. 10 x 1/2	SSZH#10032
2	5	NO. 10 WASHER	WWF10
1	4	PIVOT BRACKET	AAFFD-167
2	3	SCREW, PAN SLOTTED 10-32 x 1	SSPS98064
1	2	AIR CYLINDER	AAC6DP-18
2	1	FLOW CONT	AA198RA508

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	29	SAE FLAT WASHER	WWFS10
12	28	NUT, KEP	NNK1/4-20
4	27	LEG ASSEMBLY	26238
4	26	LEG MOUNT	1996-152
1	25	CYL MOUNT BRKT	26196
2	24	BUTTON VALVE BRACKET	1904-13
1	23	MATERIAL STOP	025-030
1	22	MATERIAL PUSHER	025-029
1	21	GUIDE BLOCK	025-028
1	20	SLIDE TONGUE	1996-153
1	19	TABLE TOP	1996-151
12	18	BOLT, CARRIAGE 1/4-20 x 1 1/2	SSBK01096
1	17	PNEUMATIC DIAGRAM	1996-154
8	16	1/4 LOCK WASHER	WWL1/4

26238 Leg Sub-Assembly

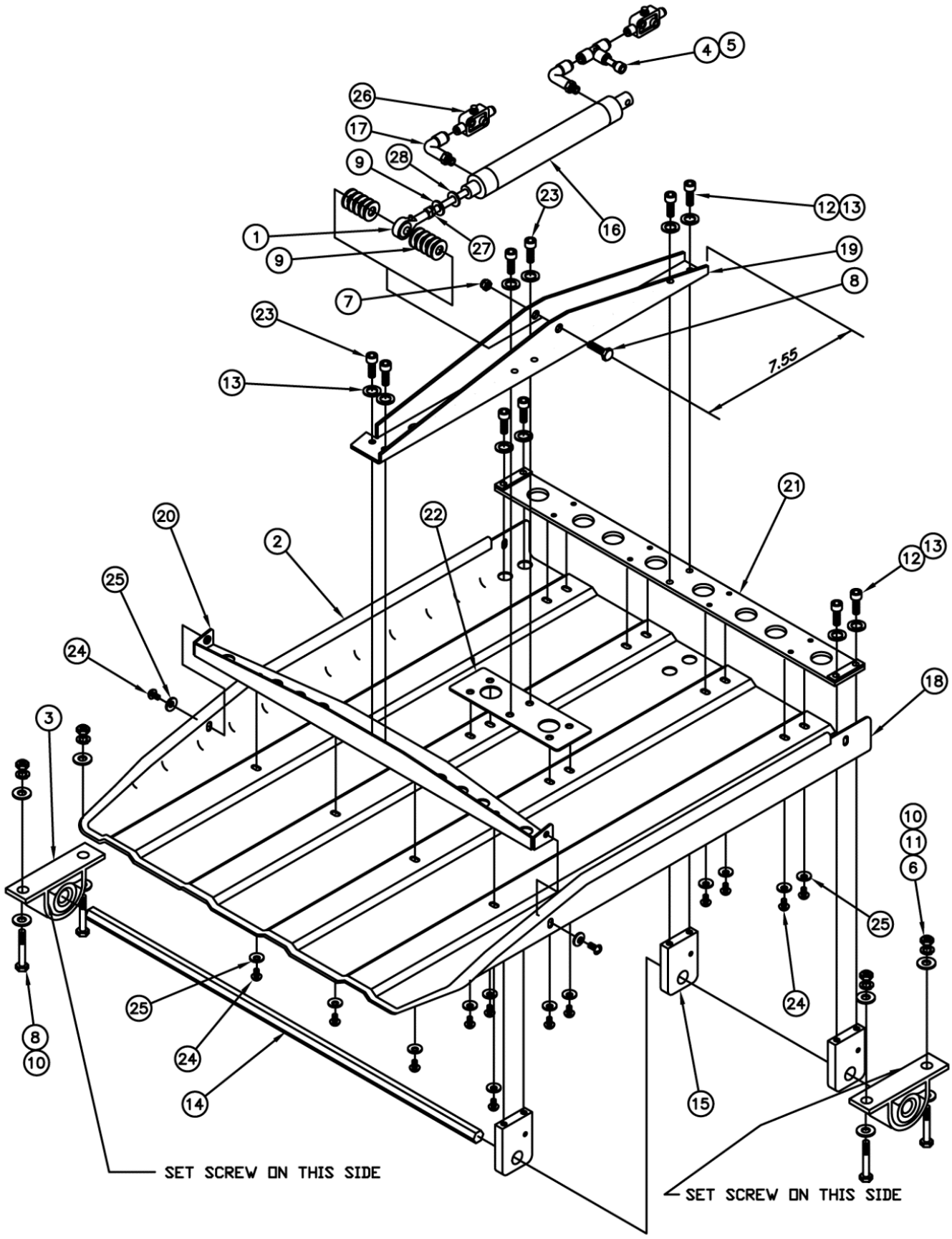
AAC Drawing Number 9001599 Rev 2



NO	QTY	PART #	DESCRIPTION
1	1	26127	LEG FOR AP-26-02
2	1	MMFB4444	FOOT, RUBBER
3	1	NNH1/2-13	NUT,HEX,1/2-13

1996-12 Stacker Door Assembly

AAC Drawing Number 191379C Rev 5

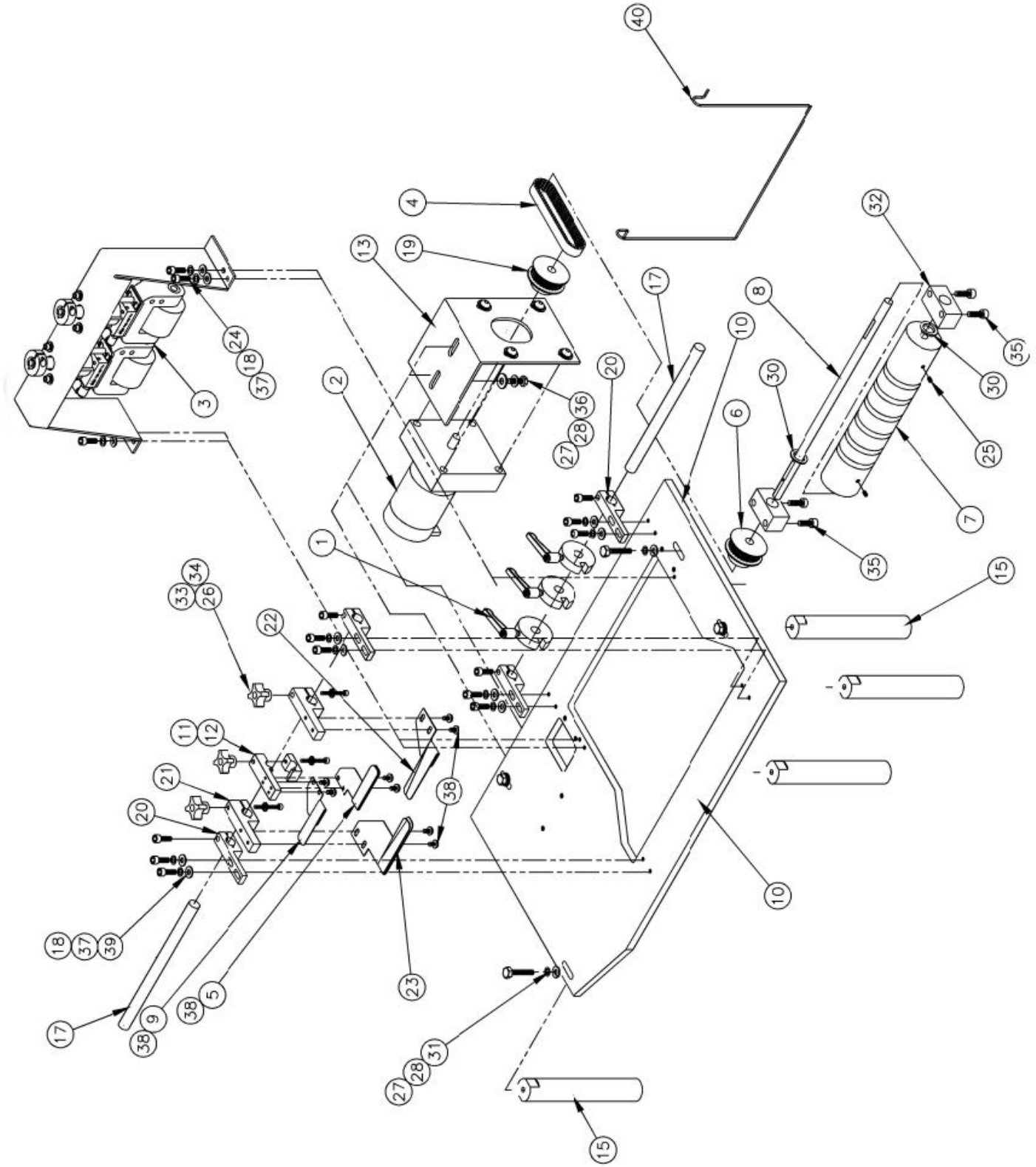


1996-12 parts list

NO	QTY	PART #	DESCRIPTION
1	1	BBAW-5Z	ROD END BEARING
2	5'	MM100-1/8	DOOR TRIM-BLK
3	2	MM2X897	BLOCK, PILLOW
4	1	AAQUT-4-4	QUICK UNION T
5	1	AAQPR-5-4	REDUCER
6	4	NNH5/16-18	NUT, HEX
7	1	NNE5/16-18	ELASTIC NUT
8	5	SSHC10112	SCREW, HEX CAP 5/16-18 X 1 3/4
9	11	WWFS5/16	SAE FLAT WASHER
10	8	WWF5/16	SAE FLAT WASHER
11	4	WWL5/16	WASHER, LOCK
12	6	SSSC98048	SCREW, SOCKET CAP 10-32 X 3/4
13	10	WWL10	WASHER, LOCK
14	1	23105	ROD, STRAIGHT
15	3	23112A6	HINGE
16	1	23634	MOD DAMPER CYL
17	2	AAQME-4-8	QUICK MALE ELBOW
18	1	23112A1	SCREEN
19	1	1996-121	LEVER
20	1	23112A3	STIFFENER
21	1	23112A4	MOUNT
22	1	23112A5	SUPPORT
23	4	SSSC98024	SCREW, SOCKET CAP 10-32 X 3/8
24	18	SSPP98024	SCREW, PAN HD PHILLIPS 10-32 X 3/8
25	18	WWB1/4	BONDED WASHER
26	2	AA3000F-07	FLOW CONTROL, AIR
27	1	NNJ5/16-24	JAM NUT
28	1	273-4-503	1/4 LEATHER WASHER

1996-08B Feed Assembly

AAC Drawing Number 192116C Rev 5



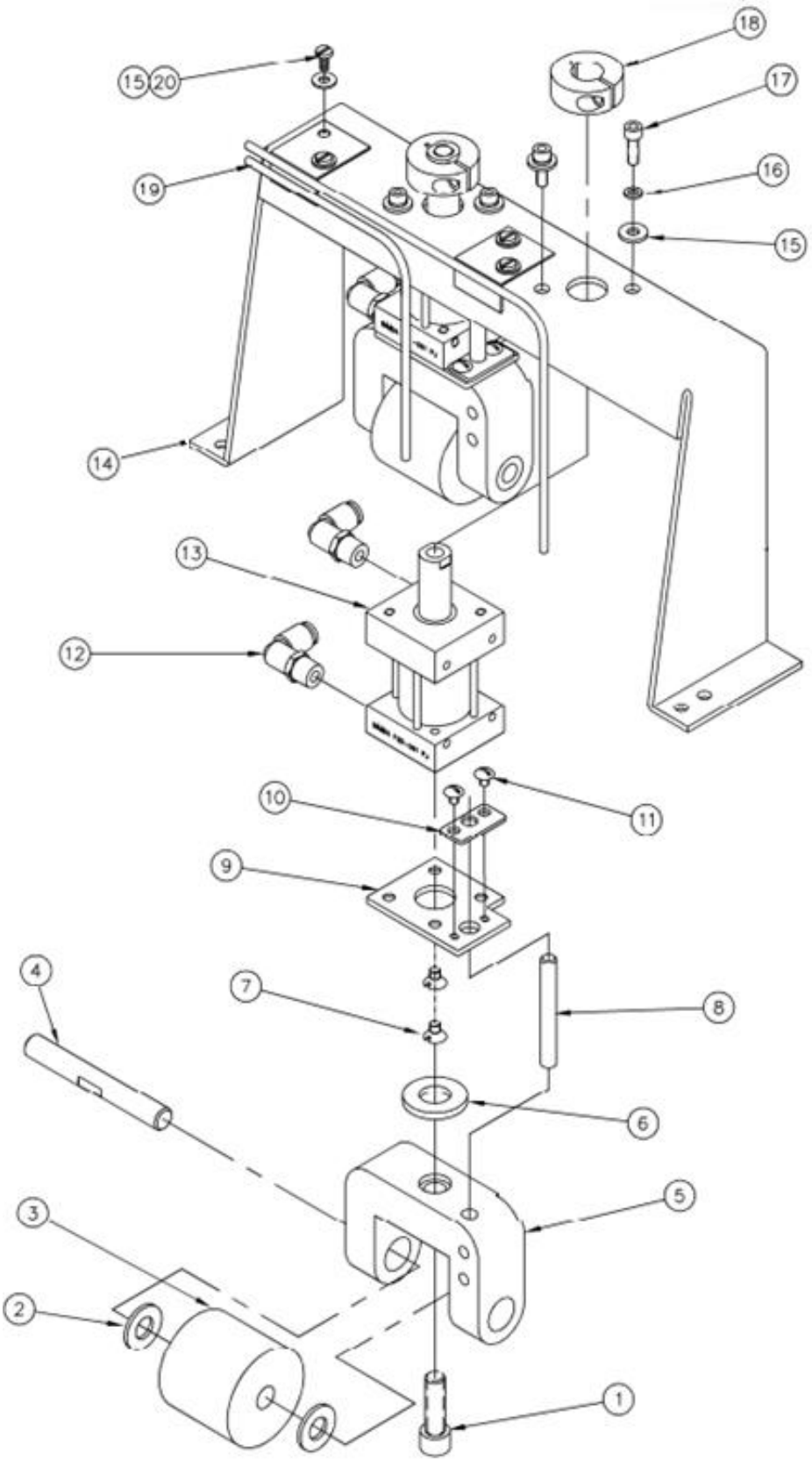
1996-08B parts list

NO	QTY	PART #	DESCRIPTION
1	1	A-4-032A	EDGE GUIDE
2	1	EE540201B1	MOTOR WITH GEAR HD.
3	1	1996-21	DOUBLE PULLER
4	1	GG100XL037	BELT, GEAR
5	1	1996-088A	RIGHT CENTER GUIDE
6	1	1535E-079	PULLEY, GEAR 22T
7	1	1996-22	BOT ROLLER, URETHANE
8	1	1917-21	SHAFT, BOT ROLLER
9	1	1996-089A	LEFT CENTER GUIDE
10	1	1996-314	PLATE, PREFEED
11	1	1996-123	LOWER CENTER BRKT
12	1	1996-122	UPPER CENTER BRKT
13	1	1996-0812	MOUNT, BAND PUL MTR
14			
15	4	1996-24	SUPPORT, F & C ASSY
16			
17	2	1996017	ROD, CRS
18	16	WWFS10	SAE FLAT WASHER
19	1	1995-017	PULLEY, MOTOR
20	4	1996-086	MOUNT, FABRIC GUIDE

NO	QTY	PART #	DESCRIPTION
21	2	1996-087	MOUNT, FAB EDGE GUIDE
22	1	1996-088	FABRIC GUIDE, RIGHT
23	1	1996-089	FABRIC GUIDE, LEFT
24	4	SSSC98056	SCREW, SOCKET CAP 10-32X 7/8
25	2	SSSS01024	SCREW, SOCKET, SET 1/4-20 X 3/8
26	3	TTCL1APPK1	KNOB, 10-32
27	6	WWL1/4	WASHER, LOCK
28	6	WWFS1/4	SAE FLAT WASHER
29			
30	2	3517	BEARING, BRONZE, THRUST
31	4	SSHC01048	SCREW, HEX CAP 1/4-20 X 3/4
32	2	1917-22	MOUNT, BOTTOM ROLL
33	3	SSPS98096	SCREW, PAN SLOTTED, 10-32 X 1-1/2
34	3	WWSI10	WASHER, LOCK, INTERNAL TOOTH
35	4	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1
36	2	SSHC01040	SCREW, HEX CAP 1/4-20 X 5/8
37	16	WWL10	WASHER, LOCK
38	8	SSPS90024	SCREW, PAN HD SLOTTED 8-32 X 3/8
39	12	SSSC98040	SCREW, SOCKET CAP 10-32 X 5/8
40	1	1996002	UNCURL WIRE

1996-21 Double Puller Assembly

AAC Drawing Number 191754C Rev 1

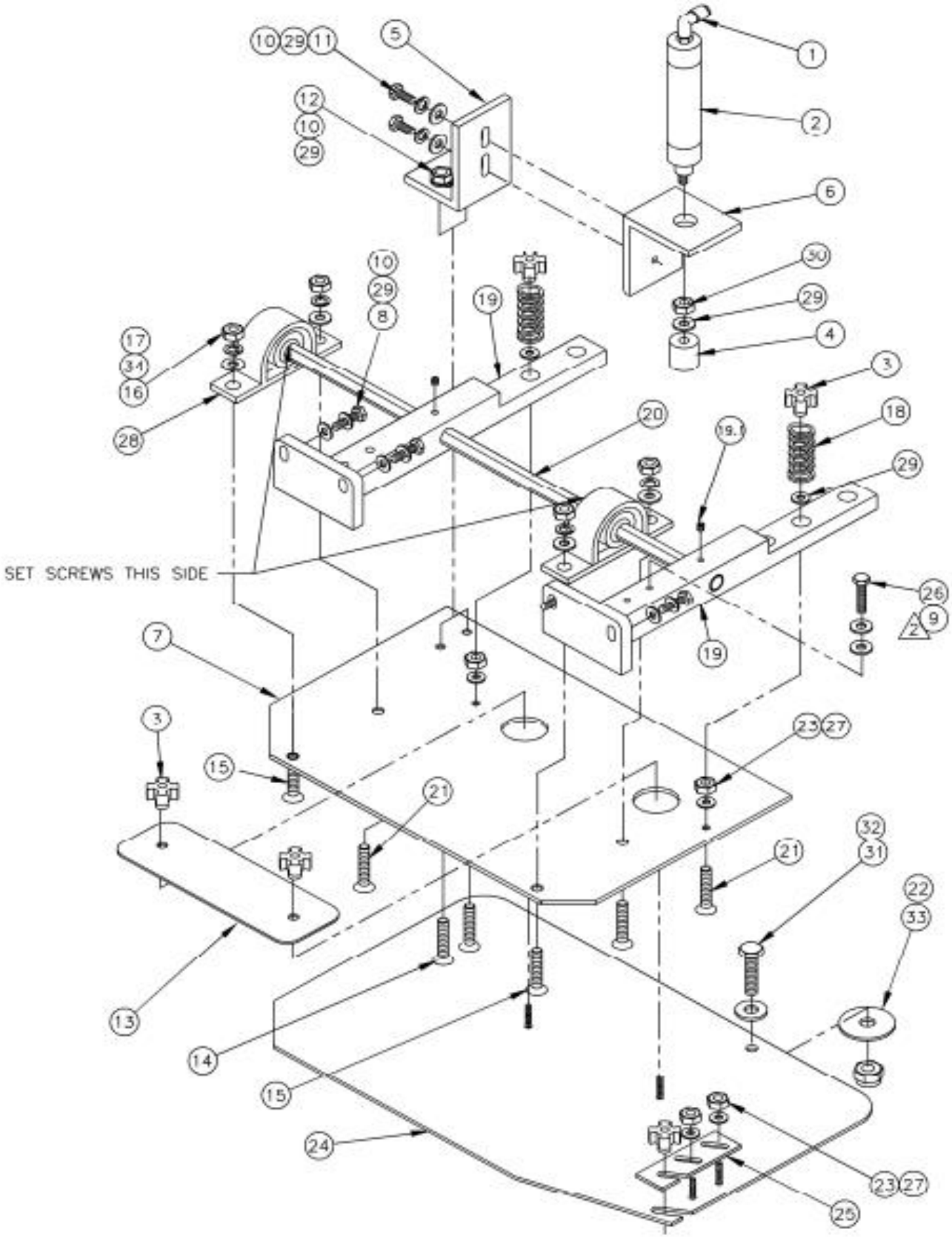


QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
4	20	SCREW, PAN HEAD SLOTTED 8-32 x 3/16	SSPS90012
1	19	DOUBLE BLOWER	1996-2104
2	18	1/2" CLAMP COLLAR	CCCL8F
4	17	SCR, SOCKET CAP #8-32 x 1/2	SSSC90032
4	16	#8 LOC WASHER	WWL8
8	15	#8 FLAT WASHER	WWF8
1	14	BRACKET	1996-2101
2	13	AIR CYLINDER	AACFSD091
4	12	QUICK CONN. ELBOW	AAQME-5-8
4	11	SCR, TRUSS SLOTTED #6-40 x 3/16	SSTS85012

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	10	ALIGNMENT PLATE	350198
2	9	ALIGNMENT BRACKET	350199
2	8	1/4 x 2" DOWEL PIN	IID016X128
4	7	SCR, FLAT SLOTTED #8-32 x 1/4	SSFS90016
2	6	FELT WASHER	WWFF1/2
2	5	ROLLER YOKE	3511AZ096M
2	4	SHAFT, ROLLER	3513-300
2	3	ROLLER, AL	3514A5
4	2	THRUST WASHER	3517
2	1	SCR, SOCKET CAP 5/16-24 x 1	SSSC20064

1996-06 Conveyor Mount Assembly

AAC Drawing Number 191373C Rev 7

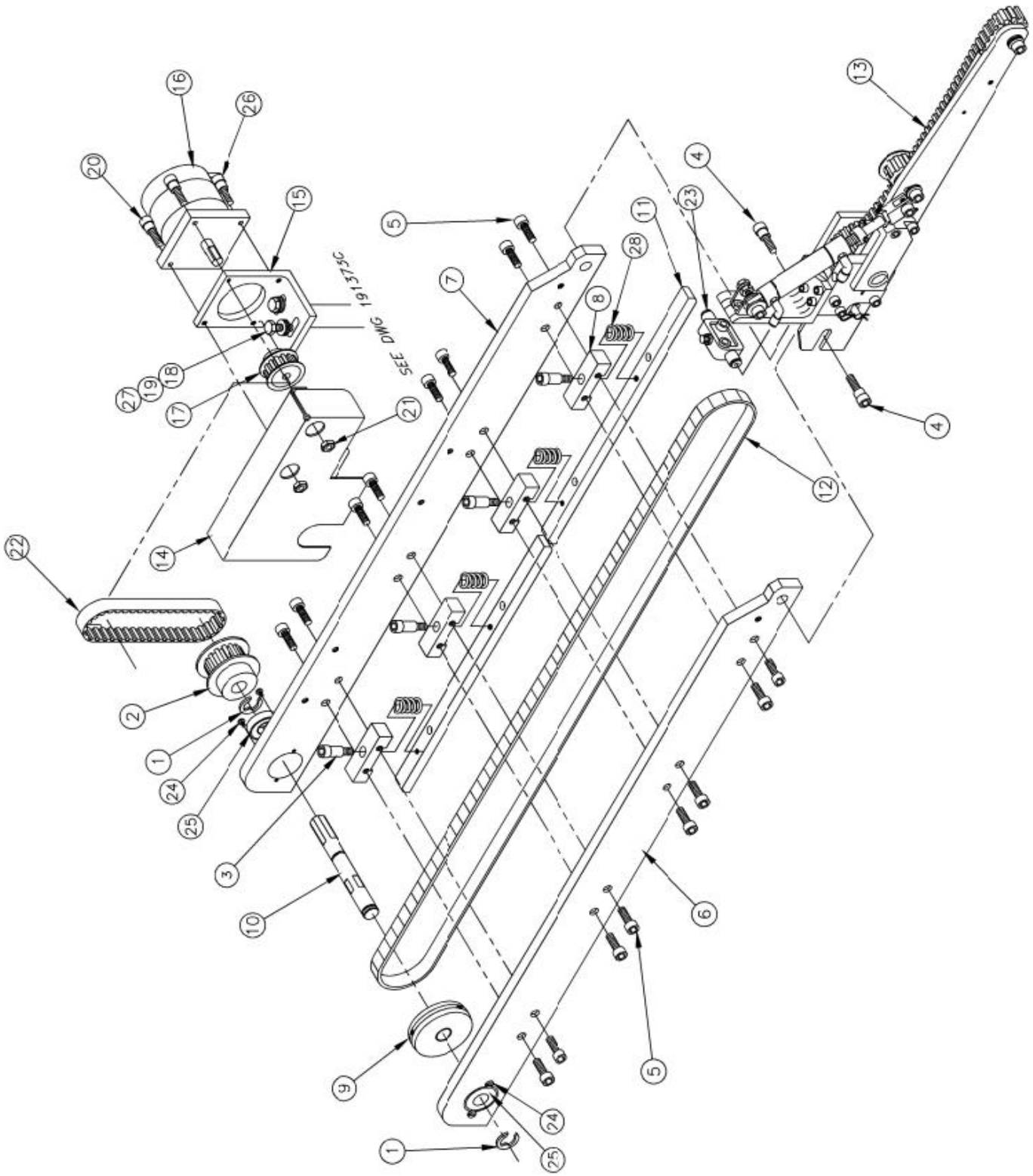


1996-06 parts list

NO	QTY	PART #	DESCRIPTION
1	1	AAQME-5-8	QUICK MALE EL
2	1	AAC7D-1	AIR CYLINDER
3	5	TTCL1BPPK1	TORQ KNOB
4	1	11200	BUMPER
5	1	265018	LIFT CYL BRKT
6	1	265019	LIFT CYL MOUNT
7	1	1996-063	CONV. MNT PLATE
8	4	SSHC01056	SCREW, HEX CAP 1/4-20 X 7/8
9	2	WWSE1/4	WASHER, STAR
10	8	WWL1/4	WASHER, LOCK
11	2	SSHC01040	SCREW, HEX CAP 1/4-20 X 5/8
12	3	NNH1/4-20	NUT, HEX
13	1	1996-061	PLATE, CONV ADJUSTER
14	2	SSFS01048	SCREW, FLAT SLOTTED 1/4-20 X 3/4
15	4	SSFC10056	SCREW, FLAT CAP 5/16-18 X 7/8
16	4	NNH5/16-18	NUT, HEX
17	4	WWFS5/16	WASHER, FLAT SAE
18	2	RRLC045G5	SPRING
19	2	23056	SUPPORT, WELDMENT
19.1	2	SSSS01012	SCREW, SOCKET SET 1/4-20 X 3/16
20	1	1996-066	SHAFT, HEX
21	2	SSFC95176F	SCREW, FLAT CAP 10-24 X 2 3/4 (FULL THRD)
22	1	NNE5/16-18	ELASTIC NUT
23	4	NNH10-24	NUT, HEX
24	1	1996-062	PLATE, CONV. SWG OUT
25	1	1996-064	ADJUSTER, CONV SWG OUT
26	1	SSHC01032	SCREW, HEX CAP 1/4-20 X 1/2
27	4	WWFS10	WASHER, FLAT
28	2	MM2X897	PILLOW BLOCK
29	11	WWFS1/4	WASHER, FLAT SAE
30	1	NNJ1/4-28	NUT, JAM
31	1	SSHC10128	SCREW, HEX CAP 5/16-18 X 2
32	1	WWF5/16	WASHER, FLAT
33	1	WWFE020	WASHER, LG FENDER
34	4	WWL5/16	LOCK WASHER
35	1	TT552514	TERM,RING,1/4",14-16GA
36	2'	FF3077-28	WIRE,STR,#16,PVC,GRN/YEL

1996-05 Top Conveyor Assembly

AAC Drawing Number 191372C Rev 4

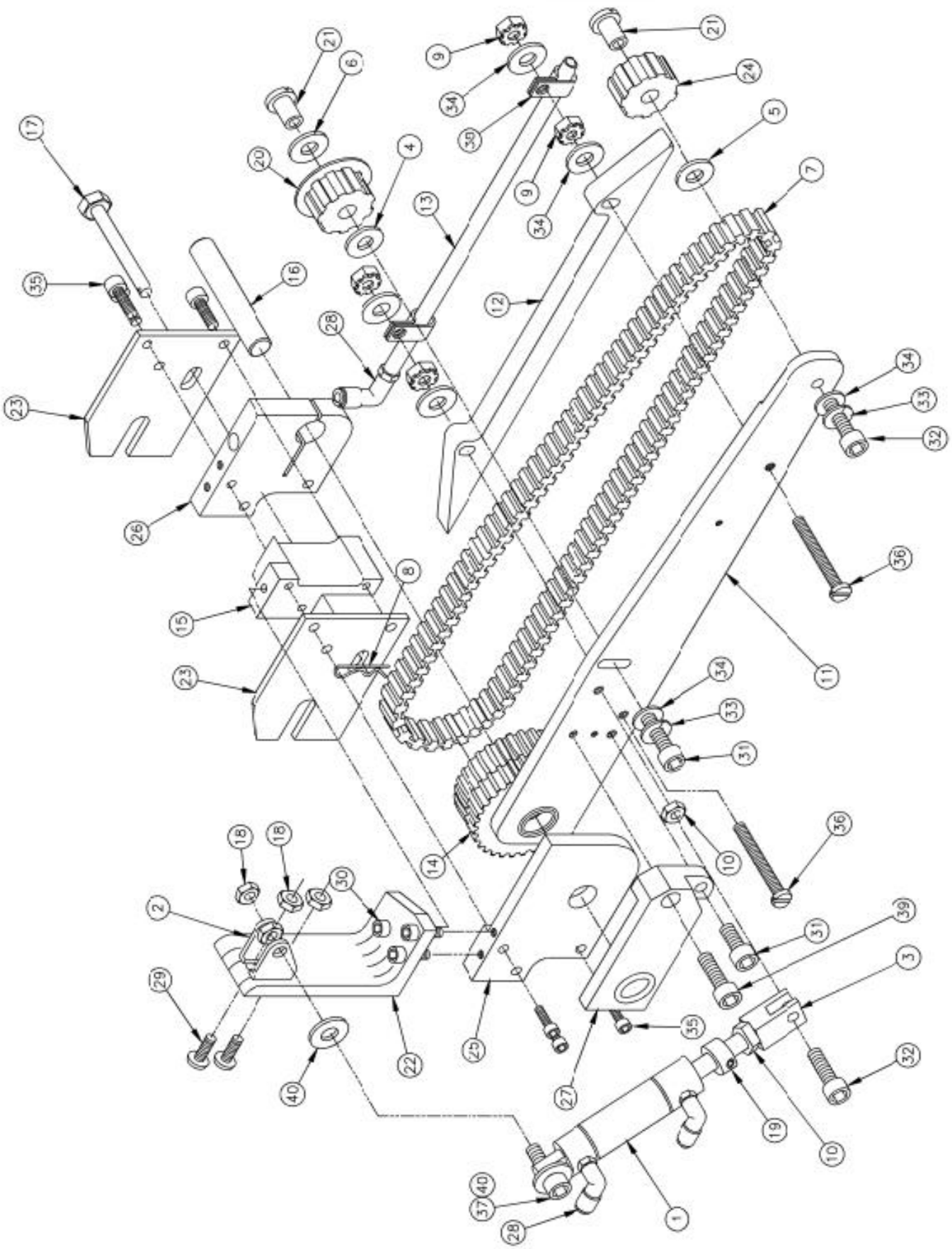


1996-05 parts list

NO	QTY	PART #	DESCRIPTION
1	2	MM8407A138	"E " RING, 1/2
2	1	PP24XLB37M	GEAR PULLEY, MOD
3	4	SSAS016048	SCREW, SOCKET SHOULDER 1/4 X 3/4. 10-24
4	2	SSAS020016	SCREW, ALLEN SHOULDER 5/16 X 1/4, 1/4-20
5	16	SSSC01024	SCREW, SOCKET CAP 1/4-20 X 3/8
6	1	1996-051	BRKT, BEARING LFT
7	1	1996-052	BRKT, BEARING RGT
8	4	1996-053	SPACER
9	1	1996-054	ROLLER
10	1	1996-055	SHAFT, DRV 0.5X4.0
11	2	1996-056	SLIDE PLATE, CONV
12	1	1996-057	BELT, URETHANE
13	1	1996-07	FRONT CONVEYOR
14	1	26006	BELT GUARD
15	1	26017	MOUNT,STEP MOTOR
16	1	AP-22E-103	STEP MOTOR MOD
17	1	PP12XL037	GEAR, PULLEY
18	2	SSHC01048	SCREW, HEX CAP 1/4-20 X 3/4
19	2	WWL1/4	1/4 LOCK WASHER
20	2	SSSC98048	SCREW, SOCKET CAP 10-32 X 3/4
21	2	NNK10-32	10-32 KEP NUTS
22	1	GG120XL037	BELT, GEAR
23	1	AA2000F-03	FLOW CONTROL, AIR
24	4	SSPS80016	SCREW, PAN HD SLOTTED 6-32 X 1/4
25	2	BBIL005	BALL BEARING
26	2	SSSC98032	SCREW, SOCKET CAP 10-32 X 1/2
27	2	WWFS1/4	WASHER,FLAT
28	4	RRLC026E1	SPRING

1996-07 Front Conveyor Assembly

AAC Drawing Number 191374C Rev 5

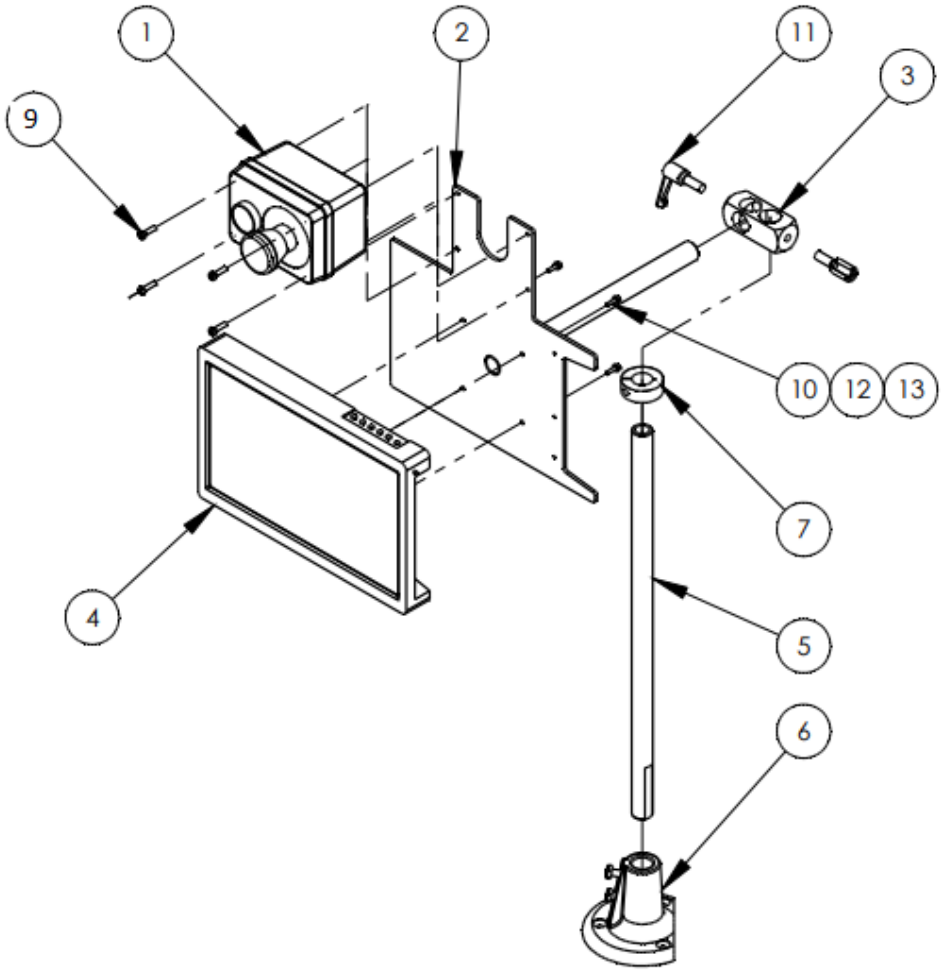


QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	40	WASHER, NO. 8	WWF8
1	39	SCREW, SOCKET CAP 10-32 x 5/8	SSSC98040
2	38	AIRLINE CLAMP	AAF3/16
1	37	SCREW, SOCKET CAP 8-32 x 1 1/4	SSSC90080
2	36	SCREW, PAN HD SLOTTED 10-32 x 1 1/4	SSPS98080
6	35	SCREW, SOCKET CAP 8-32 x 3/4	SSSC90048
6	34	10 SAE FL WASHER	WWFS10
2	33	10 LOCK WASHER	WWL10
2	32	SCREW, SOCKET CAP 10-32 x 3/4	SSSC98048
2	31	SCREW, SOCKET CAP 10-32 x 1/2	SSSC98032
3	30	SCREW, SOCKET CAP 8-32 x 1/2	SSSC90032
2	29	SCREW, PAN HD SLOTTED 8-32 x 1/2	SSPS90032
3	28	QUICK MALE ELBOW	AAQME-5-10
1	27	SUPPORT BEARING	265064
1	26	RT FRT PLATE	265061
1	25	LFT FRT PLATE, TOP	265060
1	24	PULLEY, MOD. 18T	26183
2	23	ADAPTER PLATE	26181
1	22	BRACKET, CYLINDER	26180
2	21	BUSHING,IDL PULLEY	26179

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	20	IDLER, TENSION	26169
1	19	COLLAR, 3/16" CLAMP	CCCL3F
4	18	8-32 HEX NUT	NNH8-32
1	17	LOCK PIN	1996-077
1	16	SHAFT,FRT CNV PIV	1996-076
1	15	SPACER, FNT CONV	1996-075
1	14	PULLEY, PIVOT BELT	1996-074
1	13	TUBE, CNV MNTED	1996-073
1	12	GUIDE, BELT	1996-072
1	11	MNT PLT, FT CONV	1996-071
2	10	10-32 HEX NUT	NNH10-32
4	9	10-32 KEP NUT	NNK10-32
1	8	COTTER KEY	MM98335A04
1	7	GEAR BELT, 125T	GGD250XL37
1	6	BEARING, BRONZE	BBTT602
1	5	THRUST WASHER	BBTRA411
1	4	HARD. STEEL WASH	BCD1-2
1	3	HUMPHREY CLEVIS	AAFCT-8
1	2	PIVOT BRACKET	AAFBP-8C
1	1	CYLINDER, AIR 1/2	AAC8DP-1

97-1700A Touch Screen Assembly

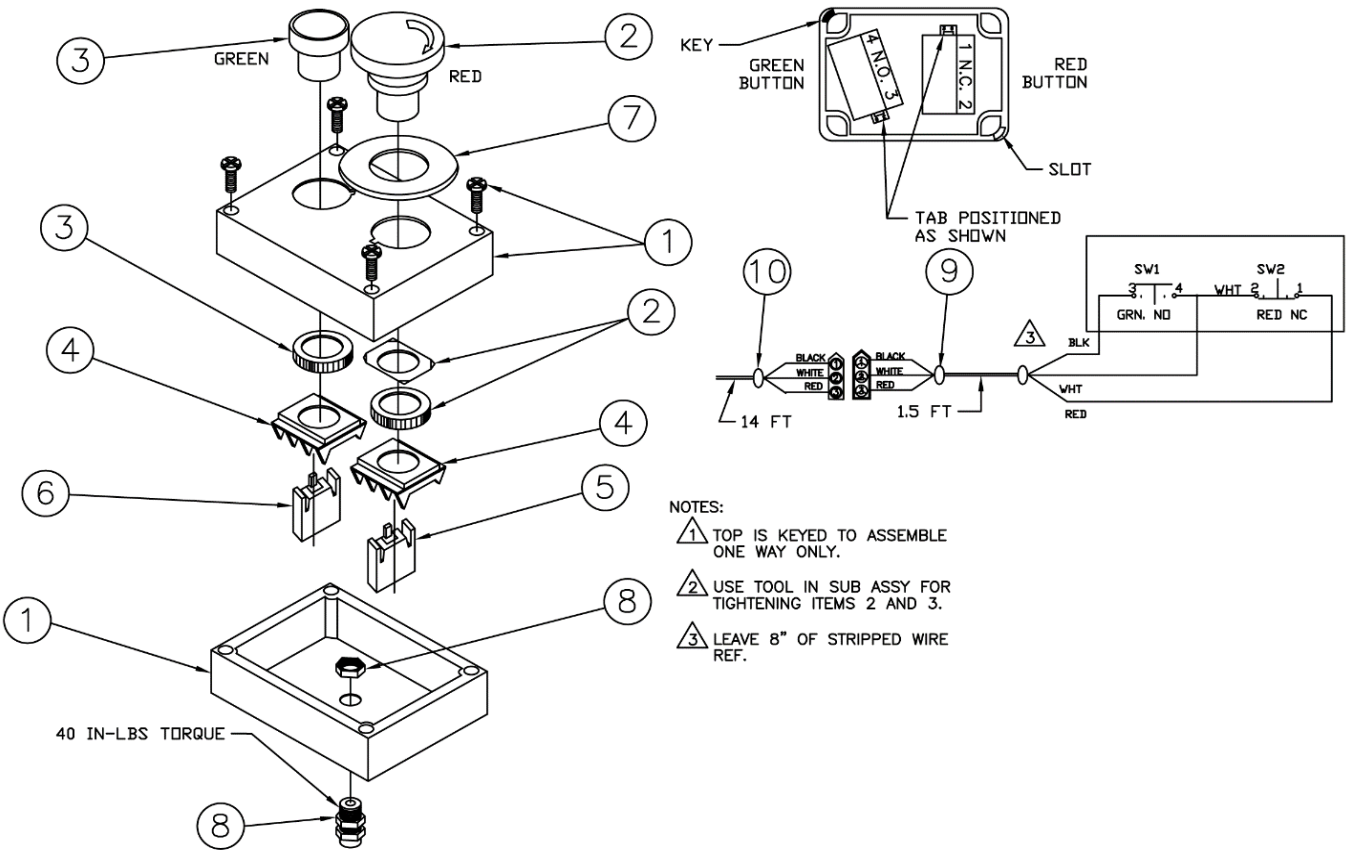
AAC Drawing Number 192617C Rev 5



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1278-6010	START/STOP BUTTON ASSY
2	1	13351060	MOUNT, 10" TOUCH SCREEN
3	1	28201	CONNECTOR, ROD, LARGE
4	1	4082105	TOUCHSCREEN. 10", SUB ASSEMBLY
5	1	97-1711	TUBE, 3/4 OD X 30.0L
6	1	AP-1721	STAND BASE,COMPLETE
7	1	CCCL12F	CLAMP COLLAR- 3/4
8	10'	EE16-3C2406	CABLE, 3 COND
9	4	SSPS90040	8-32 X 5/8 PAN HD
10	4	SSSCM3X12	M3-0.5X12 ,SOCKET CAP
11	2	TTH6324K63	HANDLE,THREADED,M8 X 20MM
12	4	WWFM3	FLAT WASHER, M3
13	4	WWLM3	WASHER, LOCK, M3

1278-6010 Start/Stop Button Assembly

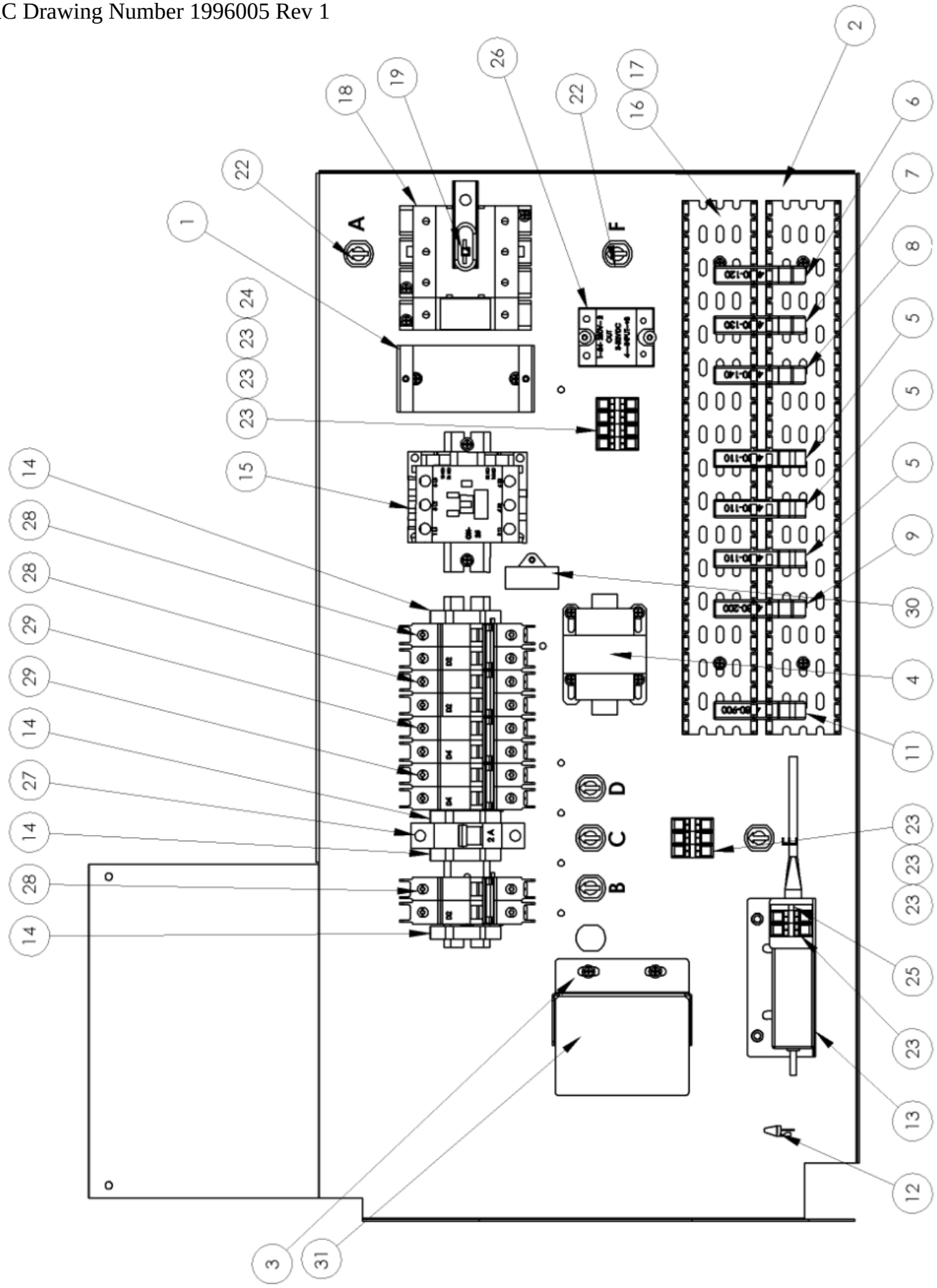
AAC Drawing Number 191058B Rev 3



NO	QTY	PART #	DESCRIPTION
1	1	EEPCB65GM	ENCLOSURE MODIF.
2	1	EEPMTS44	E-STOP BUTTON
3	1	EEPF3	START BUTTON
4	2	EEA3L	MOUNTING LATCH
5	1	EE3X01	CONTACT BLOCK N.C.
6	1	EE3X10	CONTACT BLOCK N.O.
7	1	EE15Y	LEGEND PLATE
8	1	FF3210	STRAIN RELIEF, 9MMHUB
9	1	4080-4214	CABLE, 1.5 FT
10	1	4080-4215	CABLE

1996005 Control Box, Pneumatic/Electric

AAC Drawing Number 1996005 Rev 1

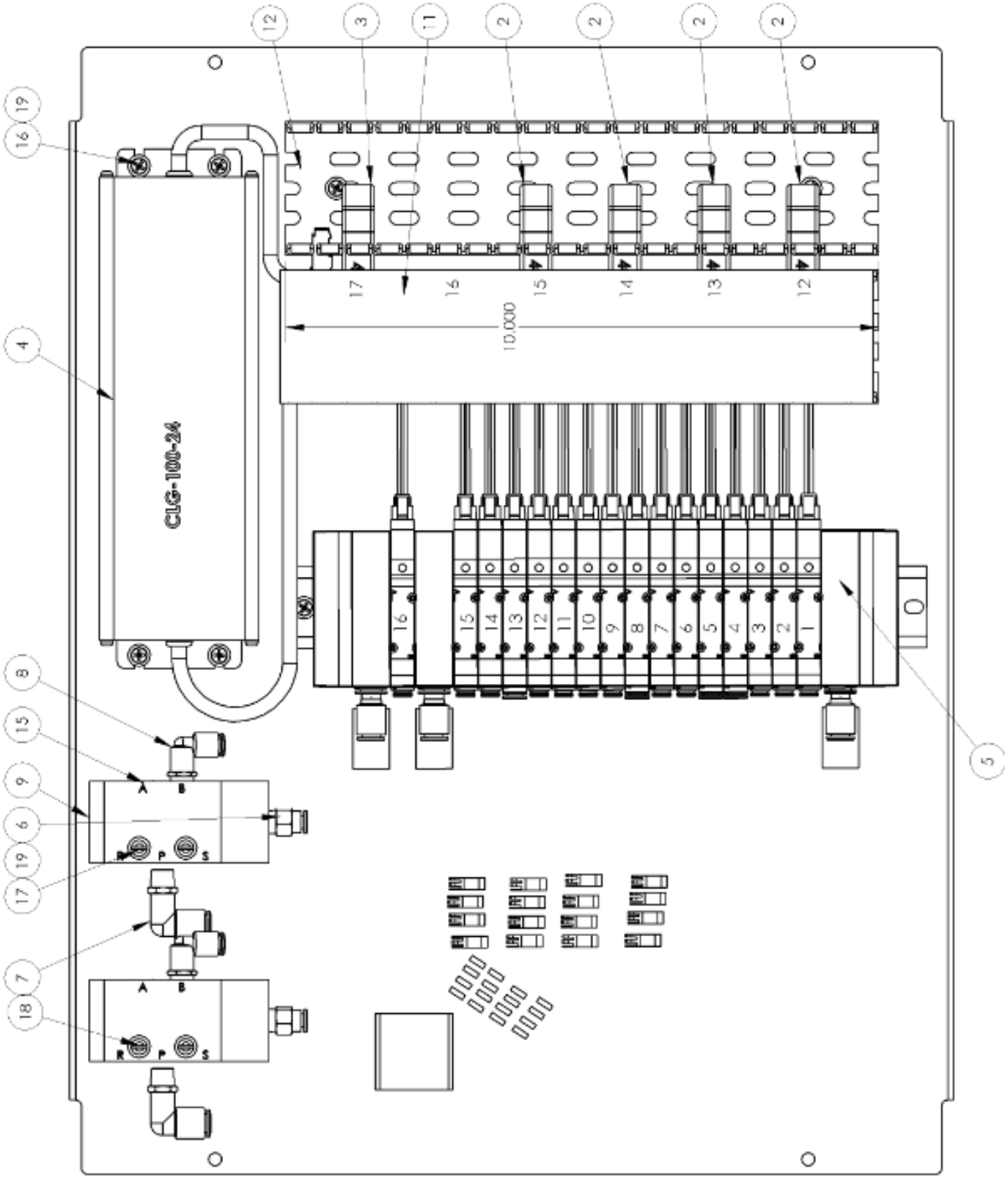


1996005 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1996-035	BRACKET SPEED CONTROL MT.
2	1	1996006	PNEUMATIC/ ELEC. BOX
3	1	3210159	COVER, TRANSFORMER
4	1	4030	TRANSFORMER,220 INPUT
5	3	4080-110	MODULE,QUAD INPUT
6	1	4080-120	MODULE,SBUS, DUAL OPTO-ISO, INPT
7	1	4080-130	MODULE,QUAD OPTO-ISO
8	1	4080-140	MODULE,QUAD OUTPUT
9	1	4080-200	MODULE,AIR PRESSURE
10	1	4080-4617	CABLE, SBUS
11	1	4080-900	SBUS MODULE, USB GATEWAY, INTERFACE
12	1	4080-940	MODULE,TERMINATOR
13	1	4082004	PC POWER BLOCK BRACKET
14	4	EECLIPFIX	ANCHOR,DIN RAIL
15	1	EECN25RB6	CONTACTOR,IEC,24VAC COIL
16	2	EEDC2X2	COVER,WIRE DUCT
17	2	EEDF2X2	DUCT,WIRE,2X2, MOD
18	1	EEM30U3M	DISCONNECT ASSY, 3PH, 30A
19	1	EESPA210-3.40	DISCONNECT SHAFT,MOD
20	1	EETS35X7.5A	DIN RAIL-AMERICAN
21	1	EETS35X7.5A	DIN RAIL-AMERICAN
22	6	FF1724	STRAIN RELIEF
23	8	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
24	1	FF264-347	TERMBLK,WAGO,TOP,DUAL,GRN
25	1	FF264-371	TERMBLK,WAGO,TOP,END
26	1	FF89F957	RELAY,SSR,24VAC,25A
27	1	FFFAZD21NA	BREAKER,1P,2A,UL489,240VT-MAG
28	3	FFFAZD22NA	BREAKER,2P, 2A,UL489,240VT-MAG
29	2	FFFAZD42NA	BREAKER,2P,4A,UL489,240VT-MAG,D-CURVE
30	1	FFRAV781BW	MODULE, TVS, 240 VAC
31	1	FFTX28	TRANSFORMER,28V,2AMP
32	21	SSPP80024	#6-32X3/8 PAN PHILLIPS
33	23	WWF6S	WASHER, FLAT, #6

1996007 Pneumatic Control Panel

AAC Drawing Number 1996007 Rev 0

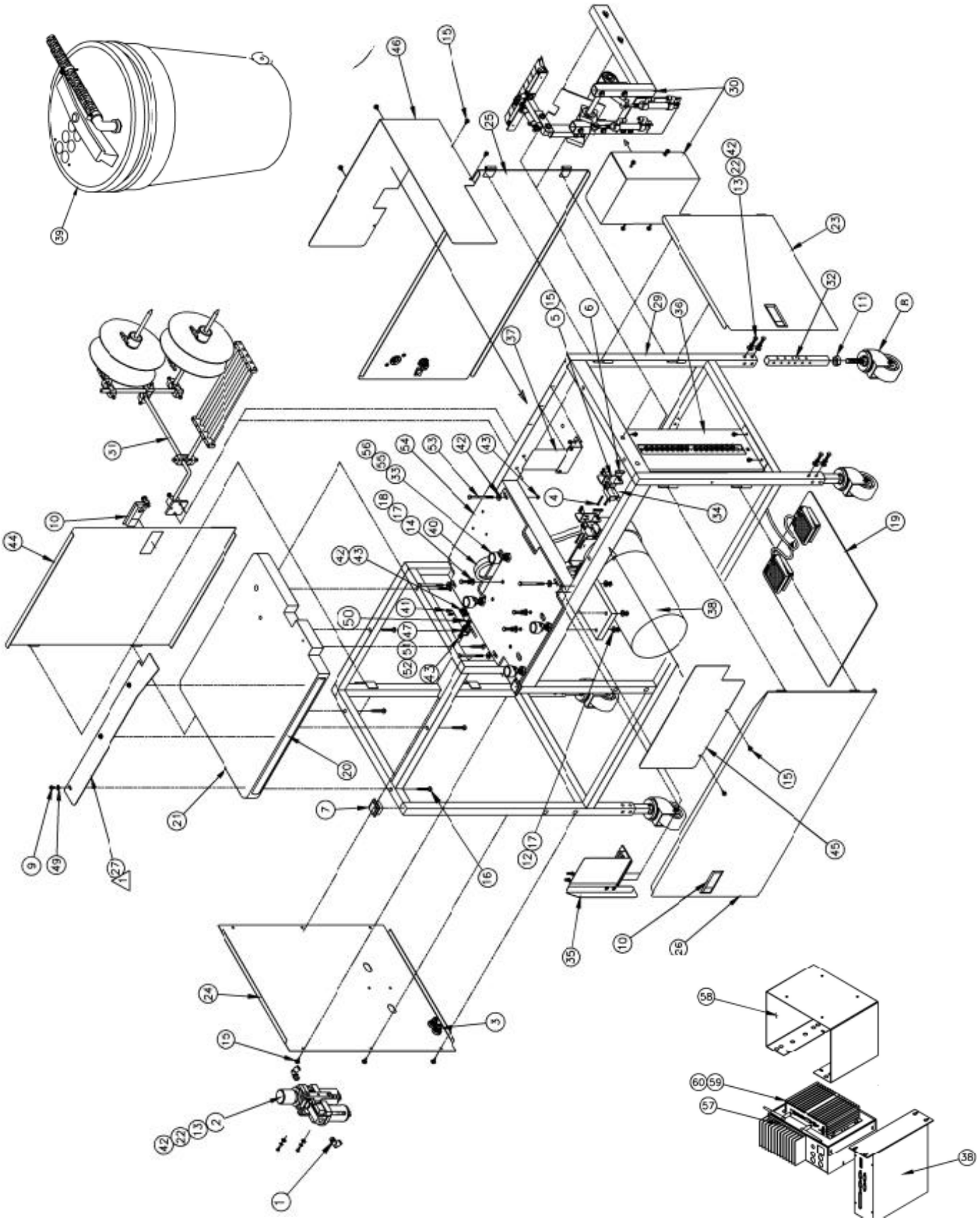


1996007 parts list

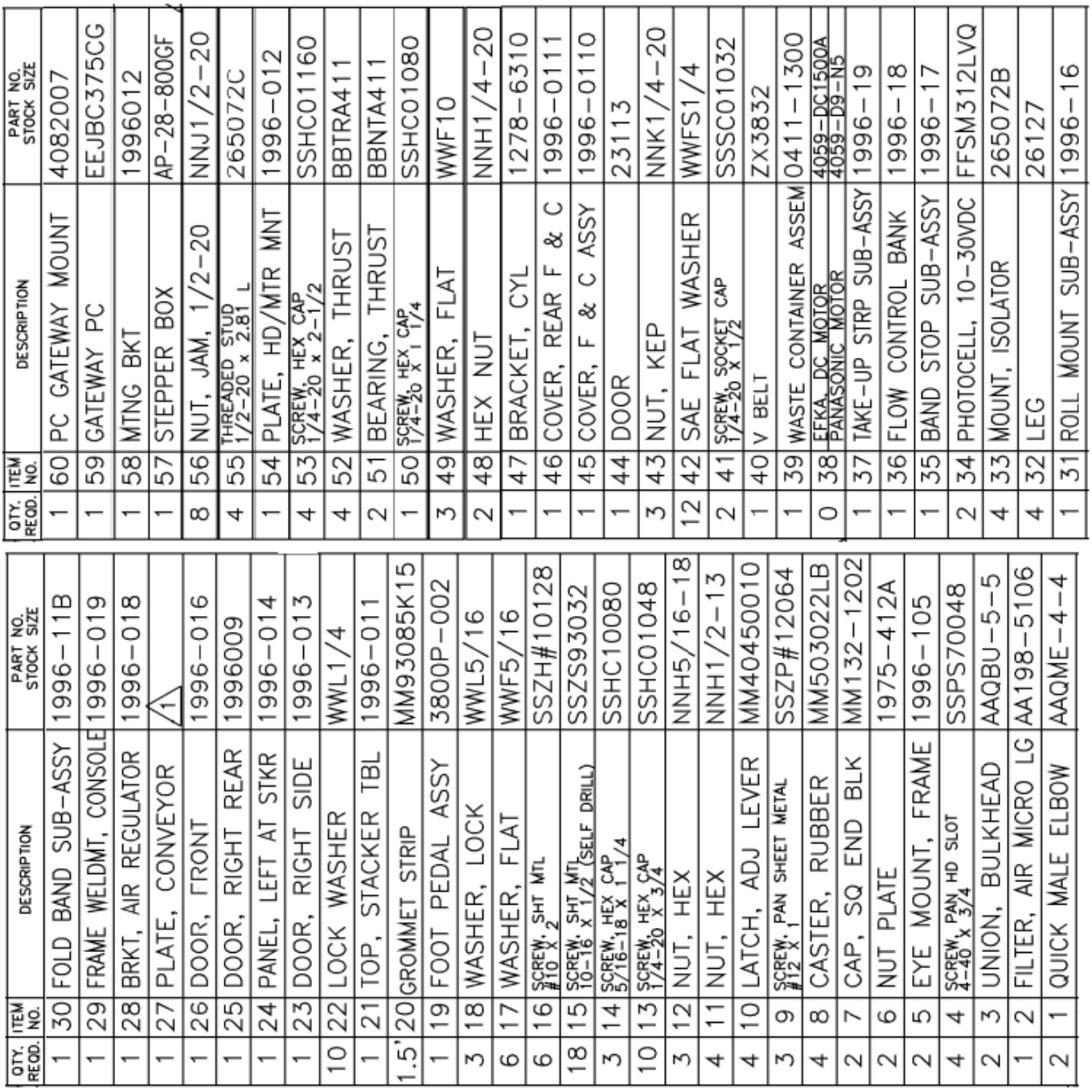
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1996004	PANEL, PHEUMATIC , SBUS 1996
2	4	4080-140	MODULE,QUAD OUTPUT
3	1	4080-950	MODULE,POWER
4	1	4080-990B	POWER SUPPLY, SBUS,
5	1	AAE1996-16	SOLENOID ASSY,8 STATION
6	3	AAQMC-5-8	QU. MALE CONN 5/32X1/8
7	3	AAQME-4-8	QUICK MALE ELBOW, 1/4T
8	3	AAQME-5-8	QUICK MALE ELBOW
9	3	AAV125B	PILOT VALVE
10	1	EE64151B	FERRITE CORE,SPLIT,CABLE
11	2	EEDC2X2	COVER,WIRE DUCT
12	2	EEDF2X2	DUCT,WIRE,2X2, MOD
13	16	FF100F2202	CONNECTOR,2 PIN,RED
14	16	FFSC10002	COVER,STRAIN RELIEF
15	3	MM4554K11	PLUG, 1/8" PIPE
16	10	SSPP80020	#6-32 X 5/16 PAN PHILLIPS
17	2	SSPS80080	#6-32 X 1 1/4 LG PAN HD
18	2	SSPS80128	#6-32 X 2 PAN HD SLTD
19	14	WWF6S	WASHER, FLAT, #6

1996-01D Table Stand and Motor

AAC Drawing Number 192204B Rev 3



1996-01D parts list

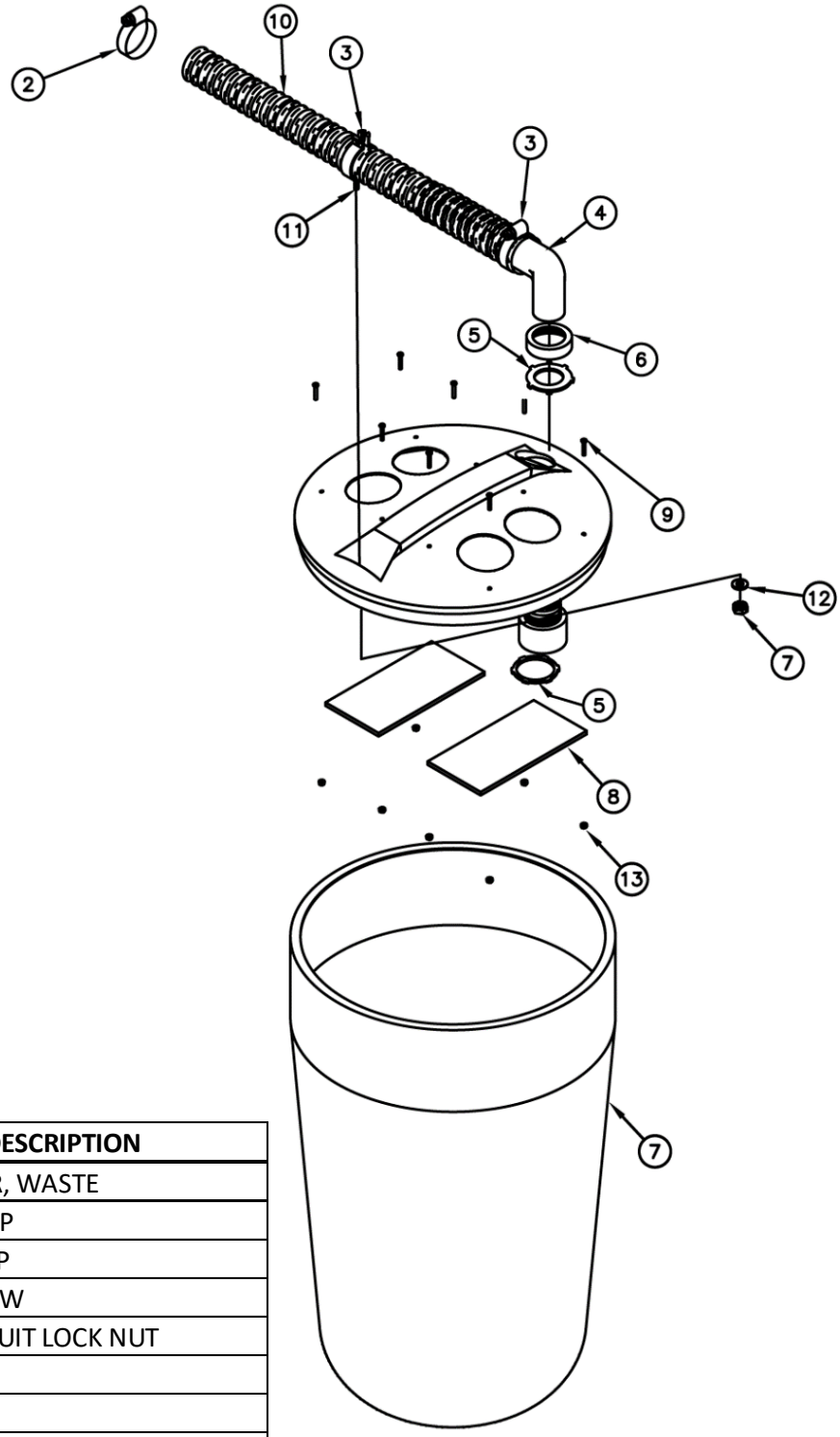


QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	30	FOLD BAND SUB-ASSY	1996-11B
1	29	FRAME WELDMT, CONSOLE	1996-019
1	28	BRKT, AIR REGULATOR	1996-018
1	27	PLATE, CONVEYOR /1	
1	26	DOOR, FRONT	1996-016
1	25	DOOR, RIGHT REAR	1996009
1	24	PANEL, LEFT AT STKR	1996-014
1	23	DOOR, RIGHT SIDE	1996-013
10	22	LOCK WASHER	WWL1/4
1	21	TOP, STACKER TBL	1996-011
1.5'	20	GROMMET STRIP	MM93085K15
1	19	FOOT PEDAL ASSY	3800P-002
3	18	WASHER, LOCK	WWL5/16
6	17	WASHER, FLAT	WWF5/16
6	16	SCREW, SHT MTL #10 X 2	SSZH#10128
18	15	SCREW, SHT MTL 10-16 X 1/2 (SELF DRILL)	SSZS93032
3	14	SCREW, HEX CAP 5/16-18 X 1 1/4	SSHC10080
10	13	SCREW, HEX CAP 1/4-20 X 3/4	SSHC01048
3	12	NUT, HEX	NNH5/16-18
4	11	NUT, HEX	NNH1/2-13
4	10	LATCH, ADJ LEVER	MM40450010
3	9	SCREW, PAN SHEET METAL #12 X 1	SSZP#12064
4	8	CASTER, RUBBER	MM503022LB
2	7	CAP, SQ END BLK	MM132-1202
2	6	NUT PLATE	1975-412A
2	5	EYE MOUNT, FRAME	1996-105
4	4	SCREW, PAN HD SLOT 4-40 X 3/4	SSPS70048
2	3	UNION, BULKHEAD	AAQBU-5-5
1	2	FILTER, AIR MICRO LG	AA198-5106
2	1	QUICK MALE ELBOW	AAQME-4-4

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	60	PC GATEWAY MOUNT	4082007
1	59	GATEWAY PC	EEJBC375CG
1	58	MTNG BKT	1996012
1	57	STEPPER BOX	AP-28-800GF
8	56	NUT, JAM, 1/2-20	NNJ1/2-20
4	55	THREADED STUD 1/2-20 x 2.81 L	265072C
1	54	PLATE, HD/MTR MNT	1996-012
4	53	SCREW, HEX CAP 1/4-20 x 2-1/2	SSHC01160
4	52	WASHER, THRUST	BBTRA411
2	51	BEARING, THRUST	BBNTA411
1	50	SCREW, HEX CAP 1/4-20 X 1 1/4	SSHC01080
3	49	WASHER, FLAT	WWF10
2	48	HEX NUT	NNH1/4-20
1	47	BRACKET, CYL	1278-6310
1	46	COVER, REAR F & C	1996-0111
1	45	COVER, F & C ASSY	1996-0110
1	44	DOOR	23113
3	43	NUT, KEP	NNK1/4-20
12	42	SAE FLAT WASHER	WWFS1/4
2	41	SCREW, SOCKET CAP 1/4-20 X 1/2	SSSC01032
1	40	V BELT	ZX3832
1	39	WASTE CONTAINER ASSEM	0411-1300
0	38	EFKA DC MOTOR	4059-DC1500A
		PANASONIC MOTOR	4059-D9-N5
1	37	TAKE-UP STRP SUB-ASSY	1996-19
1	36	FLOW CONTROL BANK	1996-18
1	35	BAND STOP SUB-ASSY	1996-17
2	34	PHOTOCELL, 10-30VDC	FFSM312LVQ
4	33	MOUNT, ISOLATOR	265072B
4	32	LEG	26127
1	31	ROLL MOUNT SUB-ASSY	1996-16

0411-1300 Waste Container Assembly

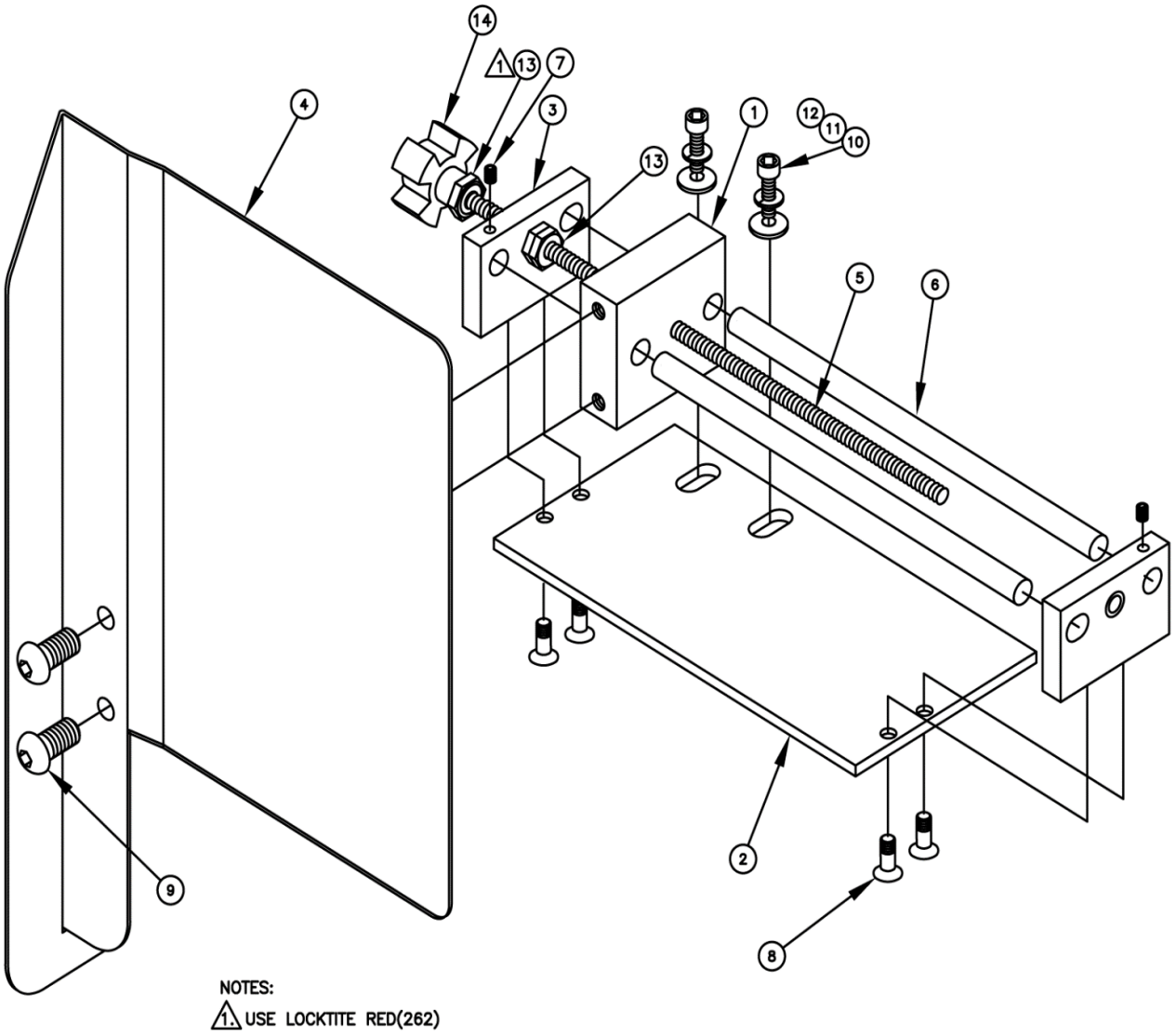
AAC Drawing Number 191225C Rev 10



NO	QTY	PART #	DESCRIPTION
1	1	MMTC32GTAN	CONTAINER, WASTE
2	2	MM5415K16	HOSE CLAMP
3	1	MM16300	TUBE CLAMP
4	1	MMRPL150	PLAIN ELBOW
5	2	MMTC32GLN	1 1/2 CONDUIT LOCK NUT
6	1	MMTC32GR	REDUCER
7	1	NNK1/4-20	NUT
8	2	26285A	FILTER, WASTE SYS
9	8	SSPS90064	SCREW, PAN HD SLOTTED 8-32 X 1
10	6FT	MMFH150	FLEX HOSE
11	1	SSHC01032	SCREW, HEX CAP 1/4-20 X 1/2
12	1	WWF1/4	WASHER, FLAT
13	8	NNK8-32	8-32 KEP NUT

1996-17 Band Stop Sub-Assembly

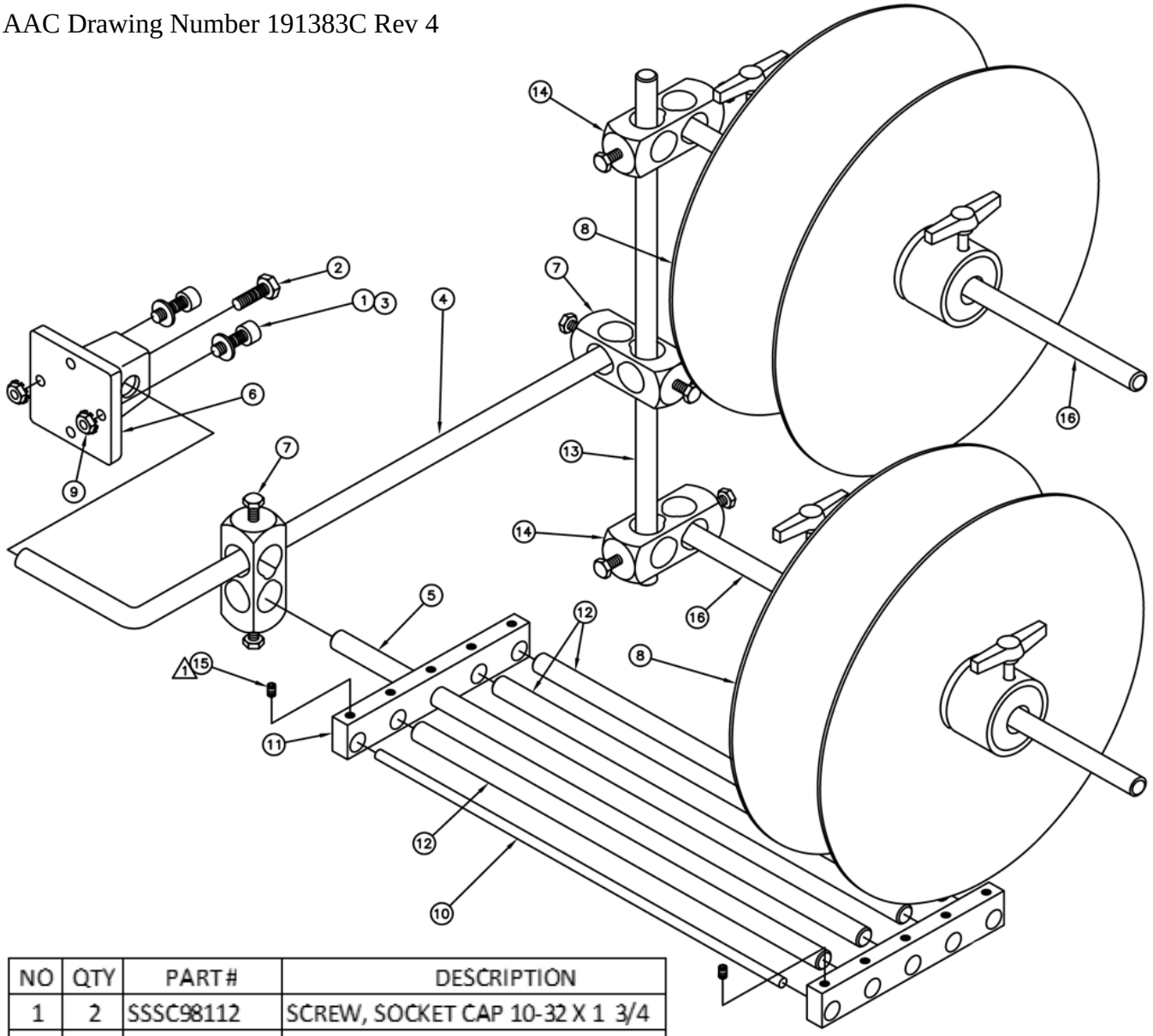
AAC Drawing Number 191423C Rev 3



NO	QTY	PART #	DESCRIPTION
1	1	1996-171	BLOCK, SLIDE, B S
2	1	1996-172	PLATE, BASE, B S
3	2	1996-173	MOUNT, B S ADJUSTER
4	1	1996-174	STOP, BAND TWIST
5	1	1996-175	ROD, THREADED
6	2	1996-176	ROD, D2
7	2	SSSS80016	SCREW, SOCKET, SET 6-32 X 1/4
8	4	SSFC80024	SCREW, FLAT ALLEN 6-32 X 3/8
9	2	SSBC98016	SCREW, BUTTON CAP 10-32 X 1/4
10	2	SSSC98024	SCREW, SOCKET CAP 10-32 X 3/8
11	2	WWFS10	WASHER, FLAT SAE
12	2	WWL10	WASHER, LOCK
13	3	NNH10-24	HEX NUT
14	1	TTCL1BPPK1	KNOB

1996-16 Roll Mount Sub-Assembly

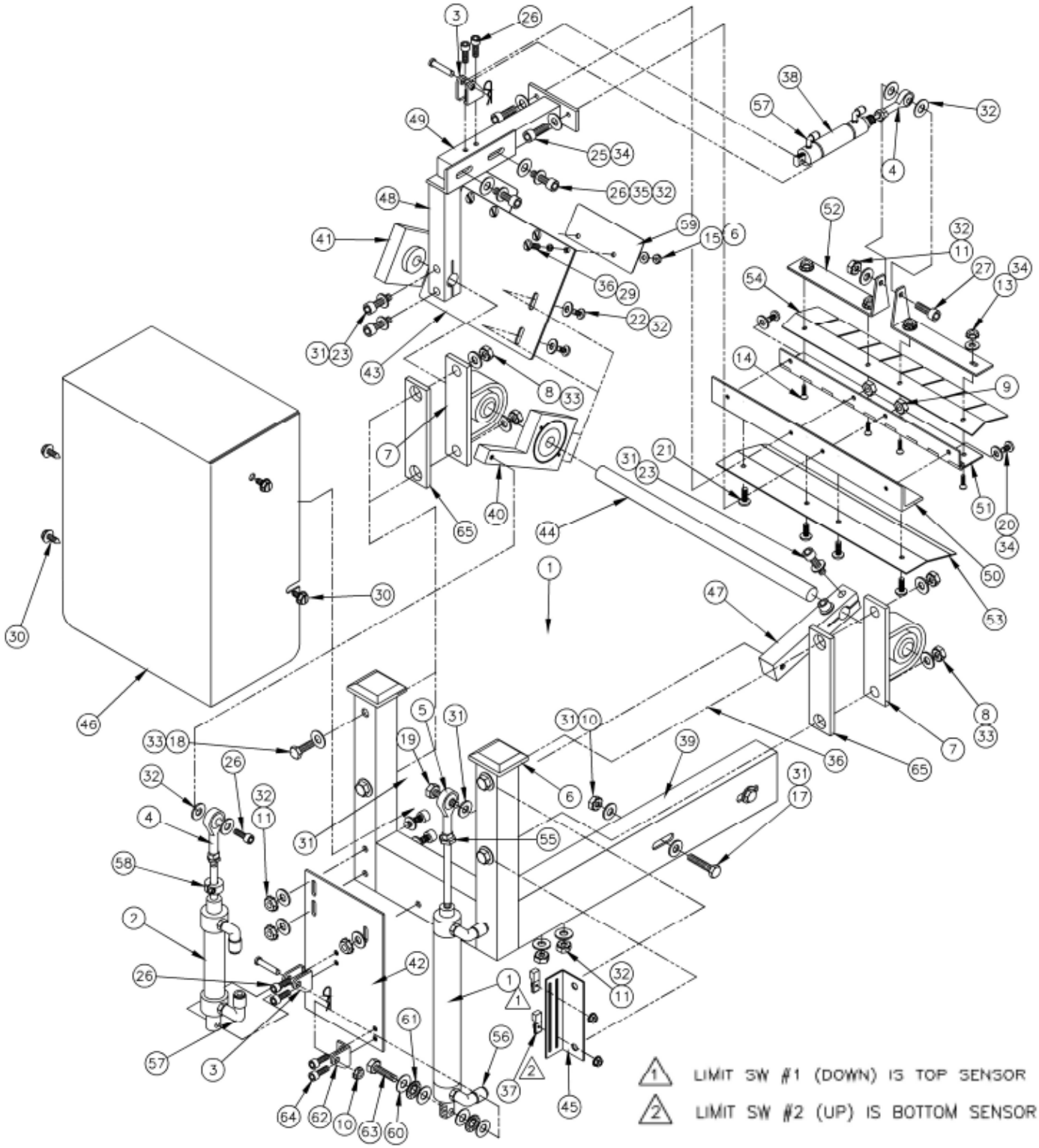
AAC Drawing Number 191383C Rev 4



NO	QTY	PART #	DESCRIPTION
1	2	SSSC98112	SCREW, SOCKET CAP 10-32 X 1 3/4
2	1	SSHC10032	SCREW, HEX CAP 5/16-18 X 1/2
3	2	WWFS10	10 SAE FLAT WASHER
4	1	1278-6587	ROD, EMER STOP
5	1	4012-04-12	14" ROD FOR 12"
6	1	265160A	BASE, EMER OFF SW
7	2	28201	CROSS BLOCK (LG)
8	4	781-1-1224	BALL BEARING DISC
9	2	NNK10-32	10-32 KEP NUT
10	1	1996-0818	ROD, STRAIGHT
11	2	4012-03	TENSION ROD HLDR
12	3	23196	ROD, STRAIGHT
13	1	8732-0896	1/2 X 14 ROD
14	2	A-U	ROD CONNECTOR
15	2	SSSS98032	SCREW, SOCKET SET 10-32 X 1/2
16	2	1996-161	ROD, POINT ON END

1996-11B Fold Band Sub-Assembly

AAC Drawing Number 192119C Rev 3

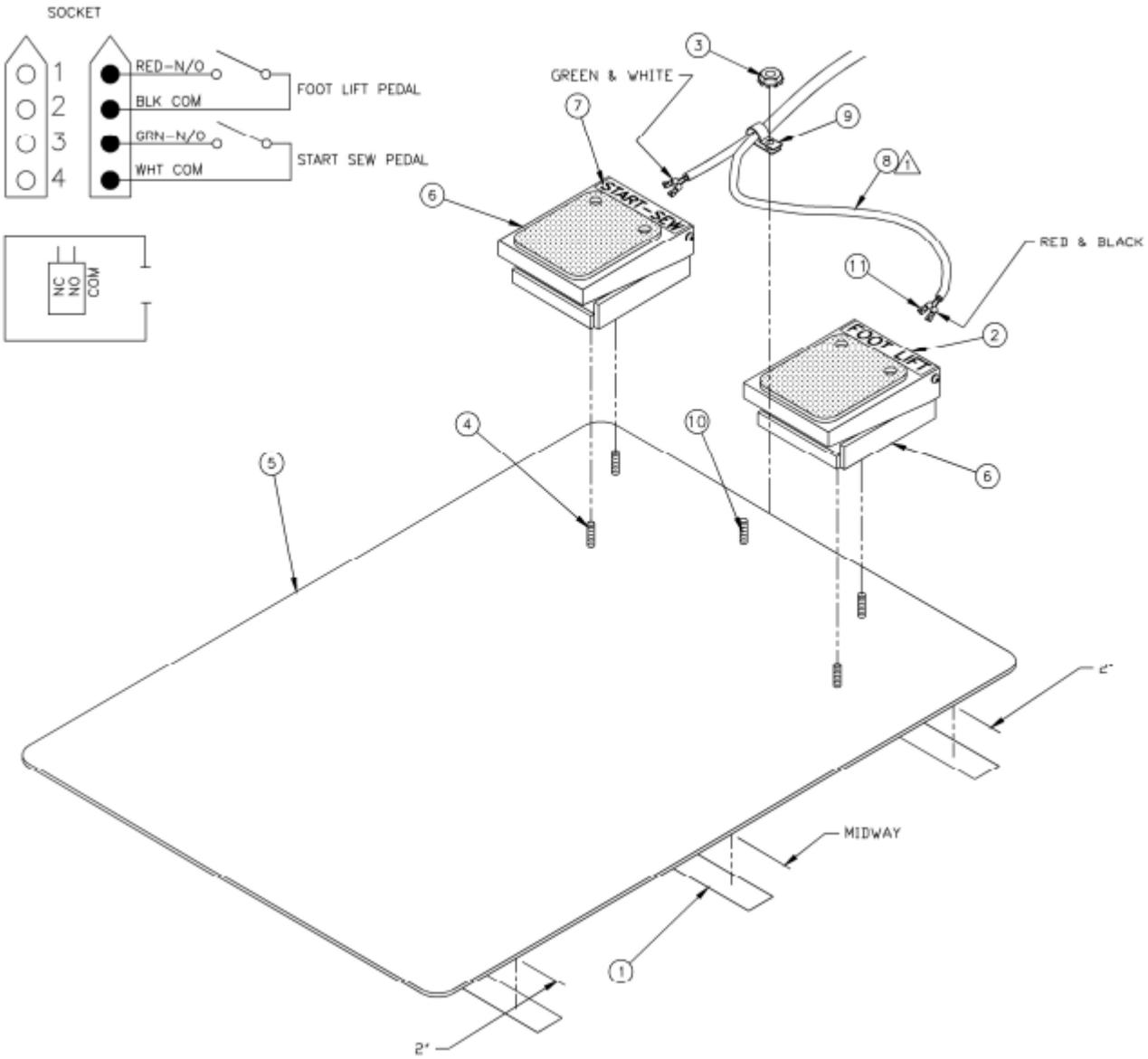


1996-11B parts list

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	AAC7DP-3	CYL, AIR 3/4	34	8	WWFS6	WASHER, FLAT SAE
2	1	AAC8DP-3	CYL, AIR 9/16	35	2	WWL10	WASHER, LOCK
3	2	AAFBP-8C	BRKT, PIVOT	36	4	SSPS90024	SCREW, PAN HD SLOTTED 8-32 X 3/8
4	2	BBAW-3Z	BEARING, ROD END	37	2	1278-7055A	PROX SW, W/PLUG
5	1	BBAW-4	ROD END, PRECISION	38	1	AAC8DP-.5	CYL, AIR, DA
6	2	MM132-1202	CAP, SQ END BLK	39	1	1996-111	WELDMT, FOLD ASSY
7	2	MM2X897	BLOCK, PILLOW	40	1	1996-1110	BEARING BLK, BAND
8	4	NNH5/16-24	NUT, HEX	41	1	1996-1111	BEARING SUPT, BAND
9	2	NNH6-32	NUT, HEX	42	1	1996-1112	BRKT, CYL MT
10	4	NNK1/4-20	NUT, KEP	43	1	1996-124	PLATE, BAND HOLD
11	6	NNK10-32	NUT, KEP	44	1	1996-1114	SHAFT
12	4	NNH8-32	#8-32 HEX NUT	45	1	1996-1115A	BRKT, PROX SW
13	3	NNK6-32	NUT, KEP	46	1	1996-1116	COVER, FIH ASSY
14	4	SSFC80024	SCREW, FLAT ALLEN 6-32 X 3/8	47	1	1996-112	LEVER, CYL ROD
15	4	WWF8	#8 FLAT WASHER	48	1	1996-113	WELDMT, FOLD ASSY
16	1	SSHC01064	SCREW, HEX CAP 1/4-20 X 1	49	1	1996-114	WELDMT, UPPER FOLD
17	2	SSHC01160	SCREW, HEX CAP 1/4-20 X 2 1/2	50	1	1996-115	ANGLE, FOLD JAW ASSY
18	4	SSHC10112	SCREW, HEX CAP 5/16-18 X 1 3/4	51	1	1996-116	HINGE, FOLDER ASSY
19	1	SSSC01064	SCREW, SOC CAP 1/4-20 X 1	52	2	1996-117	BRKT, CYL ROD PIVOT
20	2	SSPS80016	SCREW, PAN HD SLOT 6-32 X 1/4	53	1	1996-118	JAW, BOTTOM FOLDER
21	4	SSPS80024	SCREW, PAN HD SLOT 6-32 X 3/8	54	1	1996-119	JAW, UPPER FOLDER
22	4	SSPP98032	SCREW, BUTTON CAP 10-32 X 1/2	55	1	NNJ1/4-20	NUT, JAM
23	4	SSSC01048	SCREW, SOCKET CAP 1/4-20 X 3/4	56	2	AAQME-5-8	QUICK MALE ELBOW
24	1	SSSC10064	SCREW, SOCKET CAP 5/16-18 X 1	57	4	AAQME-5-10	QUICK MALE ELBOW
25	2	SSSC80024	SCREW, SOCKET CAP 6-32 X 3/8	58	1	CCCL3F	3/16 CLAMP COLLAR
26	7	SSSC98048	SCREW, SOCKET CVAP 10-32 X 3/4	59	2	1996-125	PRESSURE TABS
27	1	SSSC98096	SCREW, SOCKET CAP 10-32 X 1 1/2	60	4	BBTRA411	WASHER, THRUST
28	2	SSSC98112	SCREW, SOCKET CAP 10-32 X 1 3/4	61	2	BBNTA411	BEARING, THRUST
29	4	WWL8	#8 LOCK WASHER	62	1	1278-6310	MOUNT, CYLINDER
30	4	SSZS93032	SCREW, SHT MTL 10-16 X 1/2 (SELF DRILL)	63	1	SSHC01080	SCREW, HEX CAP 1/4-20 X 1-1/4
31	11	WWFS1/4	WASHER, FLAT	64	2	SSSC98024	SCREW, SOC CAP 1/4-20 X 3/8
32	18	WWFS10	WASHER, SAE FLAT	65	2	23154	SPACER
33	9	WWF5/16	WASHER, FLAT				

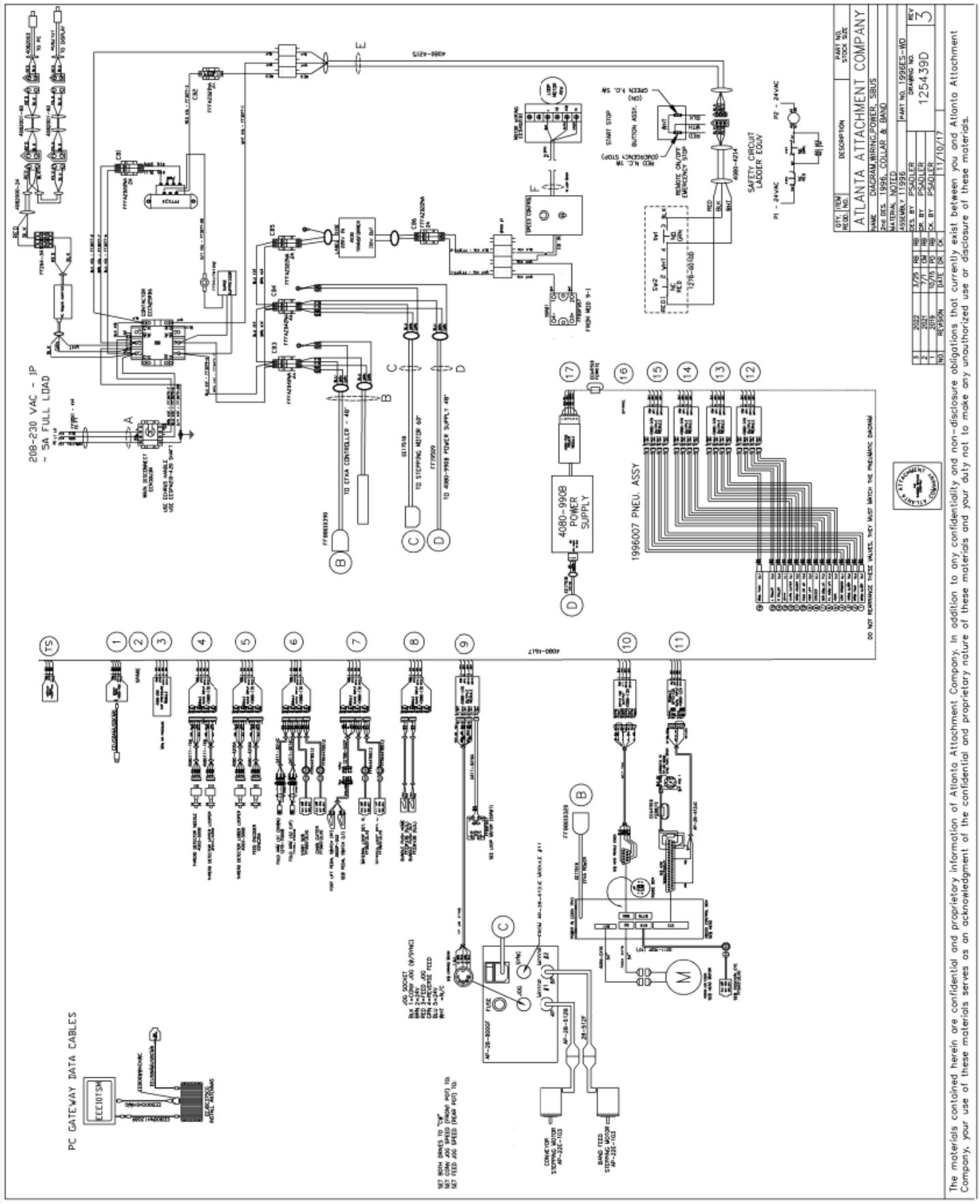
3800P-002 Foot Switch Assembly

AAC Drawing Number 190638C Rev 7

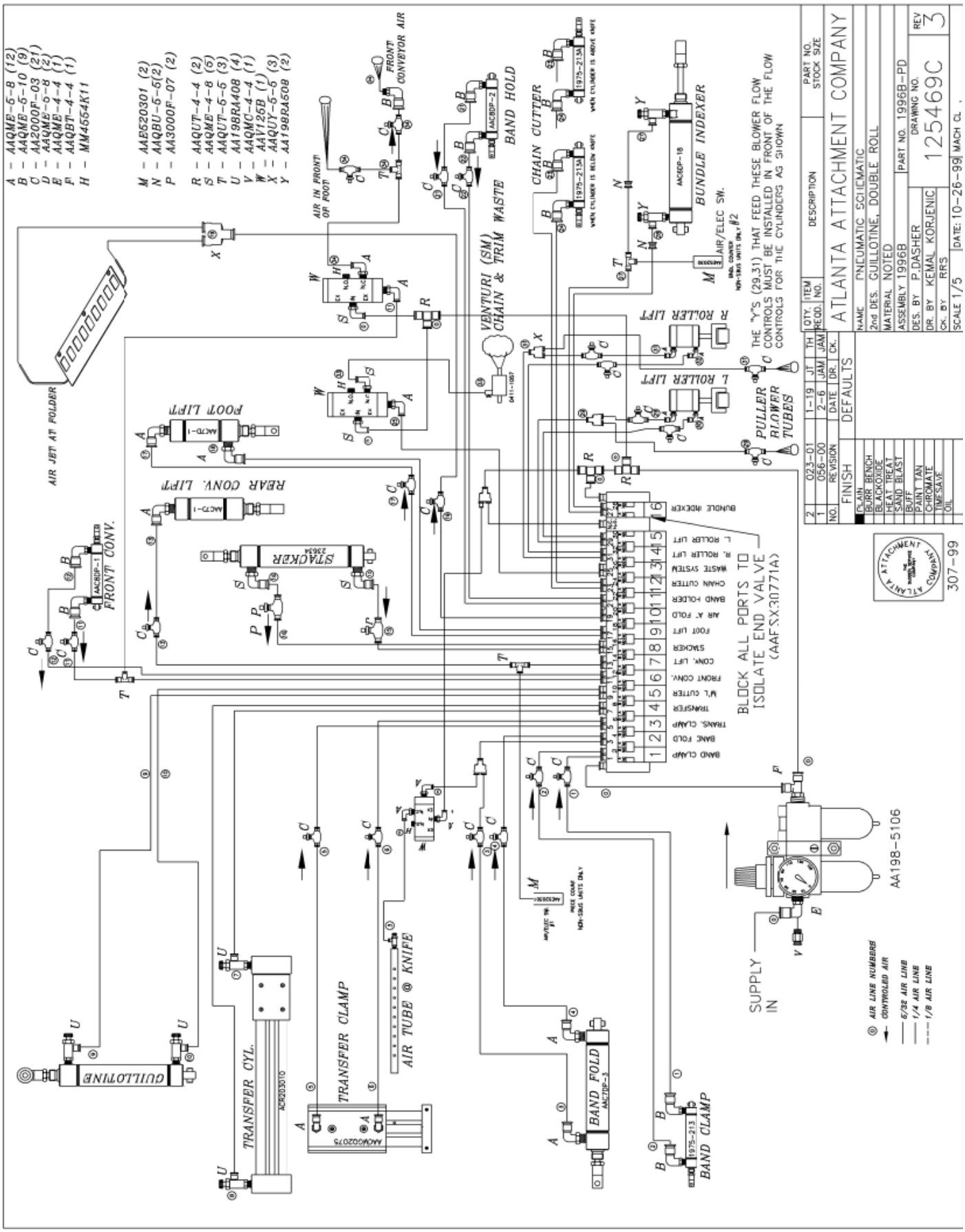


NO	QTY	PART #	DESCRIPTION
1	3FT	MM6970T64	3/4"ABRASIVE TAPE
2	0	3844P-119B	LABEL, FOOT-LIFT
3	1	NNK6-32	KEP NUT
4	4	SSFC80016	SCREW, FLAT ALLEN 6-32 X 1/4
5	1	1278-5051	PLATE,FOOT PEDAL
6	2	1278-6161	FOOT PEDAL MOD.
7	0	3844P-119A	LABEL, START-SEW
8	1	3800P-C02	CABLE, GEN
9	1	AAF3/8	PLASTIC CLAMP
10	1	SSFC80024	SCREW, FLAT ALLEN 6-32 X 3/8
11	4	TT1818	FEMALE QUICK SLIDE

1996ES-WD Wiring Diagram, Power, Serial Bus



1996B-PD Pneumatic Diagram



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 período de ochocientas (800) horas.
- Componentes mecánicos que fallen por defectos de materiales o de fabricación que han sido manu-facturados 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 a la 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 con 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.

Atlanta Attachment Company Inc.
362 Industrial Park Drive
Lawrenceville, GA 30046
Phone: +1 (770) 963-7369
www.atlatt.com

Printed in USA
Digital Version of this Manual Available at:
http://atlatt.com/tech_manuals.php