Model 1337HEHLJ28CN

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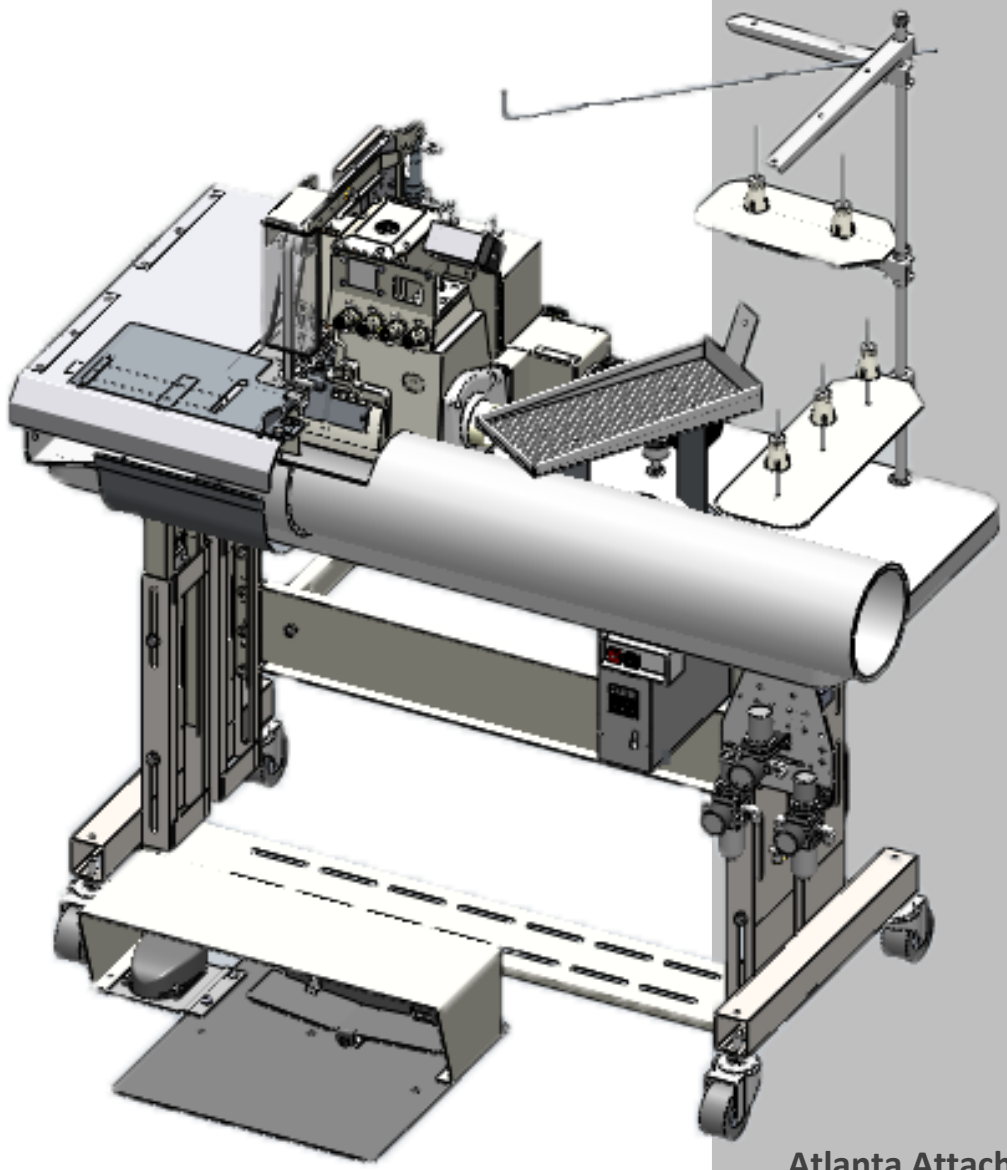
Technical Manual & Parts Lists



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ATLANTA ATTACHMENT COMPANY, INC.

Confidential and Proprietary Information

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.

Content

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 1337HEH 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.

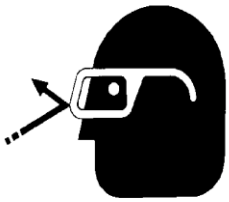
Faults or Errors

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.

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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.

General Machine Data

Electrical & Pneumatic Specifications

Electrical: 220 VAC, 5amp, 50/60 Hz Single Phase
Pneumatic: 70 PSI, 20 SCFM avg. (3/8" Airline).

- Set the MAIN regulator to 70 PSI
- Set the WASTE regulator to 70 PSI.
- Set the FOOT DOWN regulator to 40 PSI.

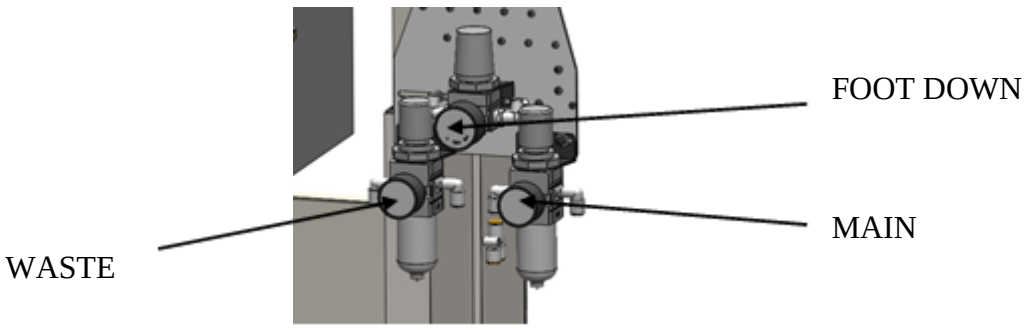
Installation & Setup

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

Operation

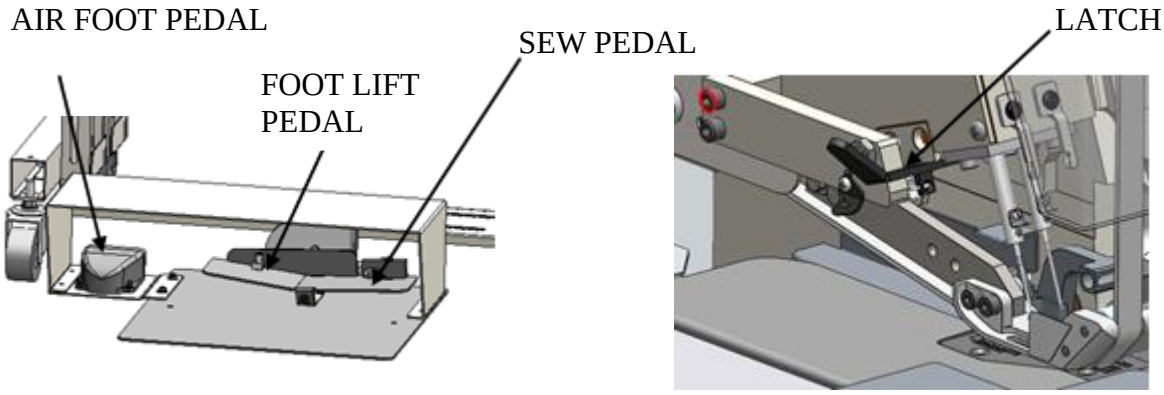
Air Regulators:

There are three regulators mounted on the right side of the stand. The regulator on the right is the MAIN regulator. It is set to 70 psi. The regulator on the left is for the WASTE system and is also set to 70 psi. Both regulators have a water trap and filter element. The water should be drained daily, and the filter changed every 6 months. The center regulator is for the DOWN foot pressure and is usually set to 40 psi but can be adjusted as necessary.



Swinging Out the Presser Foot

Two air regulators control the foot pressure. The main regulator supplies the high pressure needed to lift the foot and the FOOT DOWN pressure regulator controls the foot pressure while sewing. The DOWN foot pressure should be preset to about 60 psi but can be adjusted as desired. In order to swing out the foot for access to sewing fittings, etc. there is an AIR FOOT PEDAL mounted on the left side of the treadle assembly that will relieve the DOWN pressure on the foot so the foot can be swung out.



Foot Pressure Release Pedal (Left Air Pedal)

While stepping on the left AIR FOOT PEDAL, with the left hand, push down on the swing out LATCH, and with the right hand, push the foot down and to the left.
DO NOT ATTEMPT TO RUN THE SEWING HEAD WITH THE FOOT SWUNG OUT. DAMAGE TO THE DRIVE MAY RESULT.
To turn the sewing head over by hand to set timing, etc., swing the foot back in as close to the needles as possible without hitting the needles. Always use the left AIR FOOT PEDAL to release foot pressure whenever moving the presser foot.
Reverse the procedure to swing the foot back in. Be sure the latch is engaged. This same AIR FOOT PEDAL is used to lift the presser foot to its intermediate height WITHOUT lifting the needles from their sewing position. Use the air foot pedal to lift the foot without lifting the needles when stopping in the needle down position.

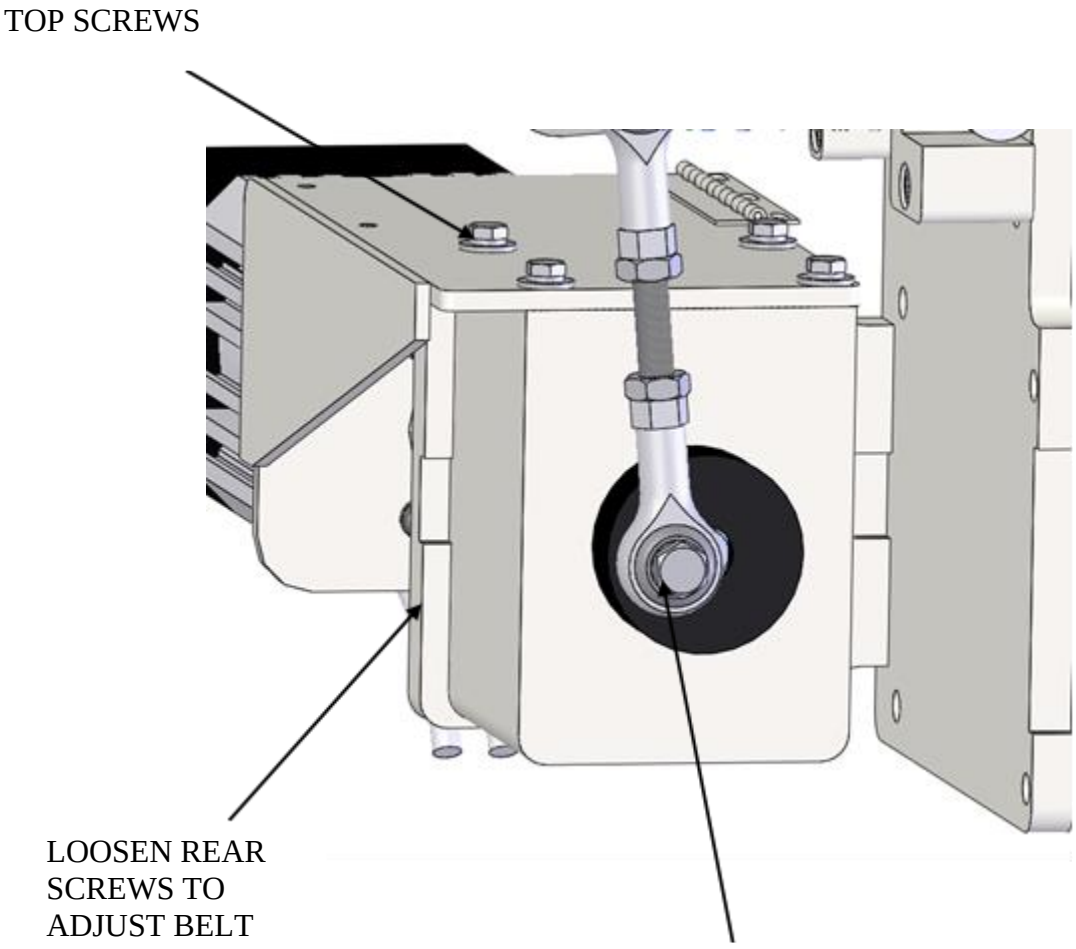
Foot Lift Pedal (Center Pedal)

The center position on the treadle assembly is the FOOT LIFT PEDAL. Stepping on it will lift the presser foot all the way up to its maximum height. When the foot comes up, the needles will also retract to their highest position. Be sure the machine stops at the needle top dead center position to prevent the foot from hitting the needle bars.
Sew Pedal (Right Pedal):
The right pedal on the treadle assembly is the SEW PEDAL. It controls the sewing speed.

Adjustments

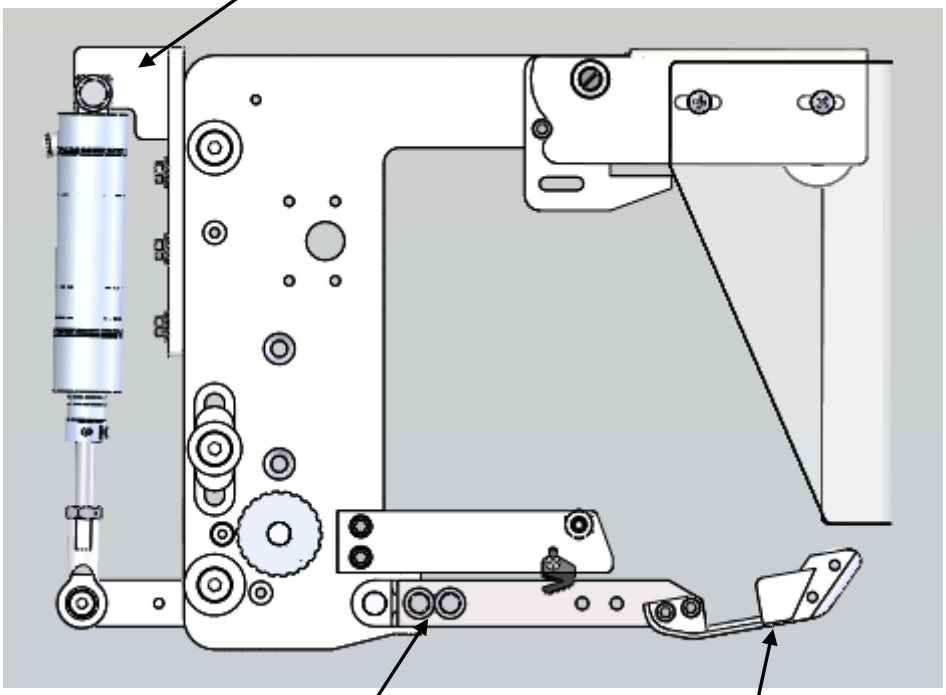
Synchronizing the Belt Feed to the Feed Dog

When the needles are at top dead center the eccentric drive screw should be all the way to the rear. Adjustment is made by removing the motor and bracket assembly (4 screws on top), and then loosening the drive belt and repositioning the teeth of the pulleys to the belt.



Adjusting the Foot Lift Cylinder

When the foot lift cylinder is fully extended (Foot Lift on), the lower belt should be lifted and parallel to the cloth plate. Adjust by loosening the three screws that hold the air cylinder mounting bracket and slide the bracket up or down as necessary

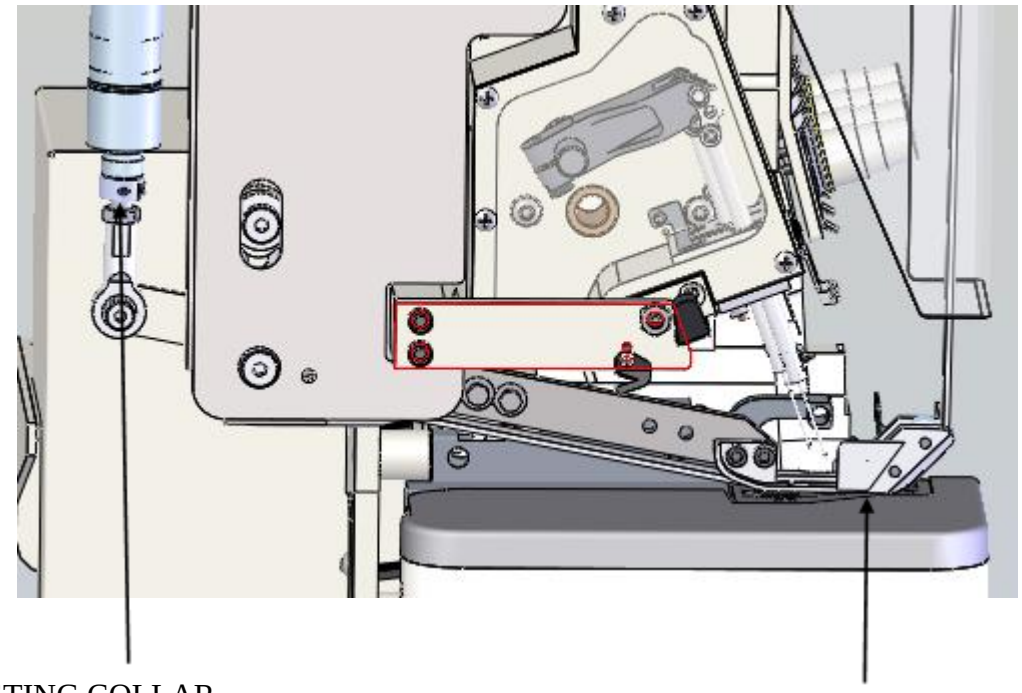


Adjusting the Presser Foot Position

The presser foot must be positioned front to rear so that the chaining finger can never hit the upper looper when the foot is lifted. Loosen the two-presser arm mounting screws, step on the left AIR FOOT PEDAL to relieve the foot pressure, manually lift the foot, and slide the presser arm forward or backward as needed so the chaining finger cannot hit the looper as it moves up and down

Adjusting the Presser Foot down Position

Adjust the clamp collar position so that when the foot is down the bottom of the foot does not touch the feed dog teeth. There should be about 1mm clearance between the teeth and the bottom of the foot when the feed dog is in its highest position.

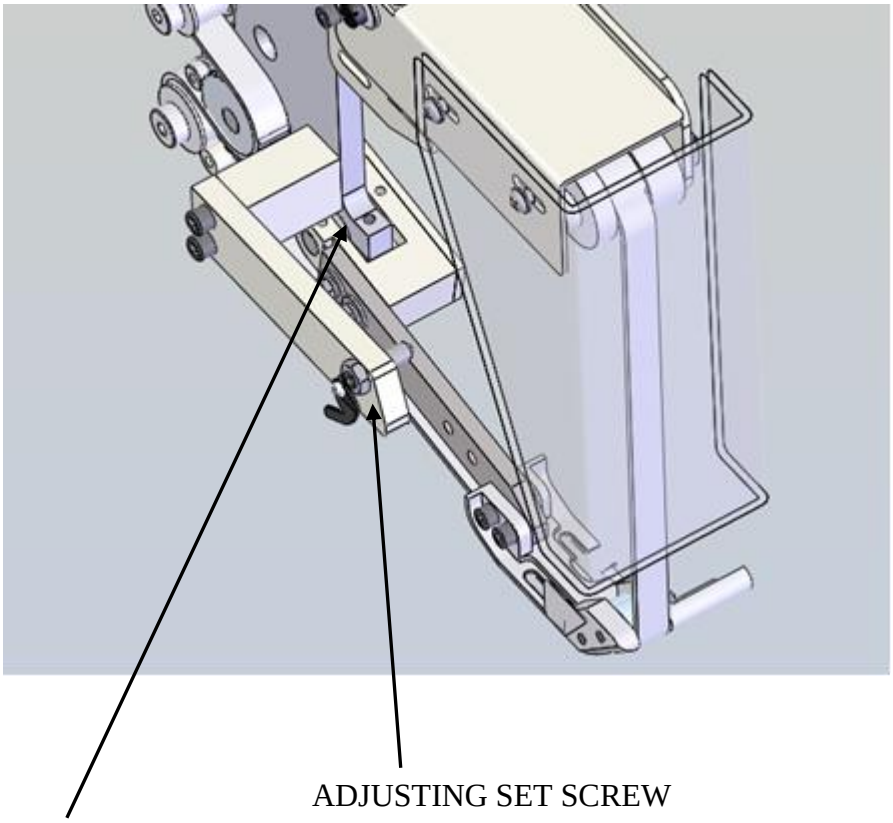


ADJUSTING COLLAR

1MM CLEARANCE ABOVE FEED DOG TEETH

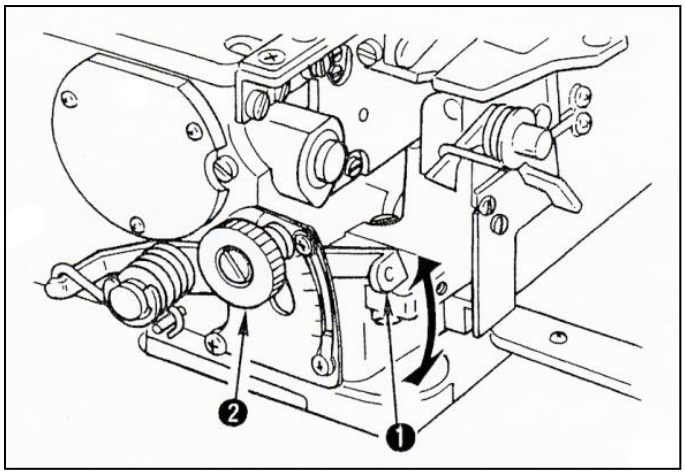
Adjusting the Presser Foot Position Left to Right

Adjust the set screw located near the latch to remove any “play” in the latch. Adjust the bushing left to right to center the needles on the needle slots in the foot.

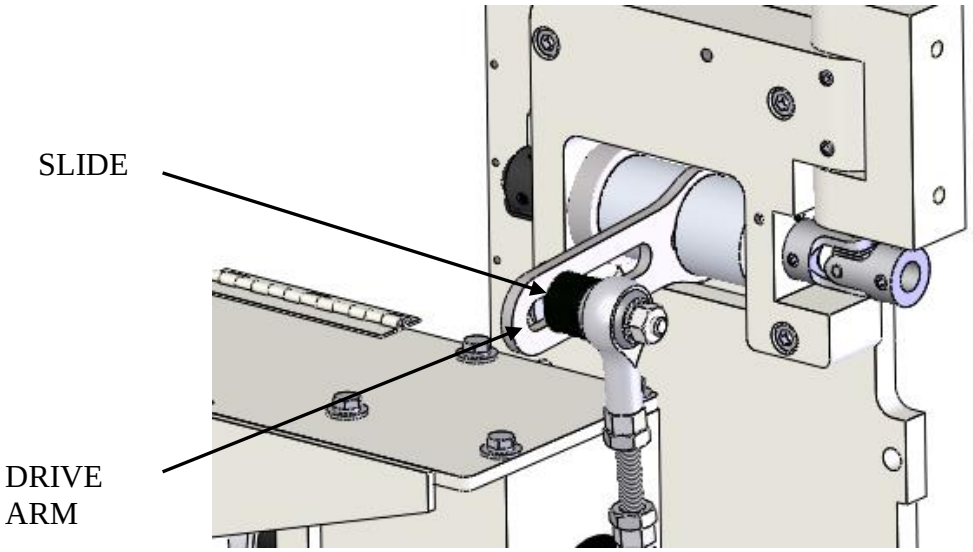


Adjusting the Stitch Length

1. The FEED DOG is mounted to the differential feed mechanism. Loosen the differential feed lock nut (2). Turn the top knob to move the lever (1) up for shorter stitch or down for longer stitch. Run the machine on a piece of quilted panel and check that the top belt feed is feeding the top ply the same as the bottom ply. If not, adjust the top belt feed drive. The normal main feed adjustment using the button and handwheel is not used. It should be set for maximum.

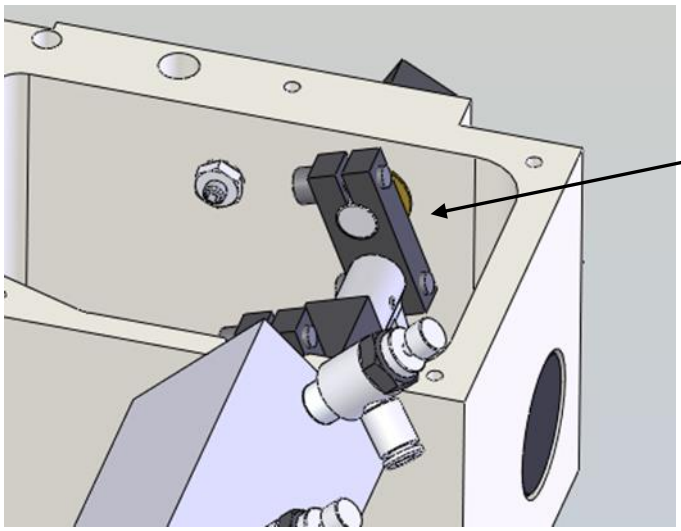


1. To adjust the top belt feed drive, move the slide in or out in the slot on the drive arm on the back of the machine to match the new stitch length. Moving the slide out shortens the feed and moving it in lengthens the feed.



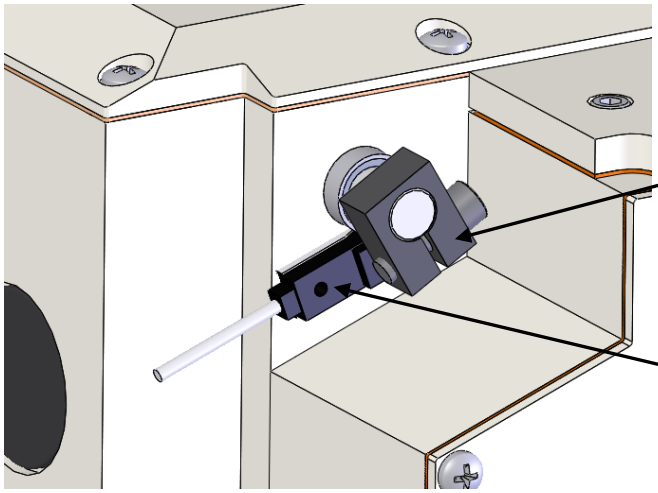
Adjusting the Needle Lifting Link

When the rotary actuator is all the way clockwise (viewed from shaft end) at the foot down position the Needle Lift Link should be tilted 20 deg. to the rear.



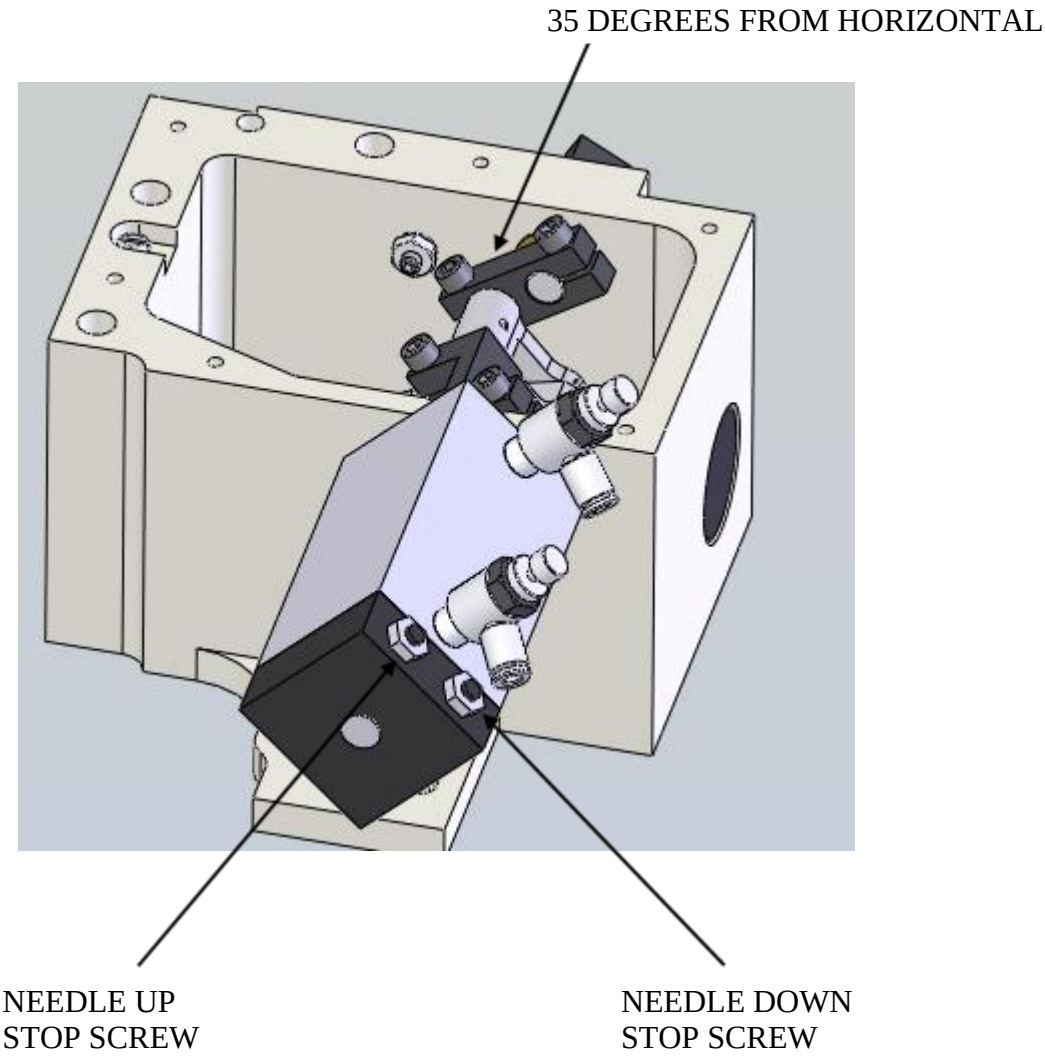
Adjusting the Needle down Safety Switch

When the rotary actuator is all the way clockwise (viewed from shaft end) the Needle Down Safety Switch SENSOR BLOCK should cover the sensor about halfway and have about one mm clearance from the sensor.



Adjusting the Rotary Actuator for Needle Lifted Position

When the rotary actuator is all the way counterclockwise (viewed from shaft end) at the foot up position the needle lift link should be rotated to a position about 35 degrees from horizontal. This adjustment is made by loosening the locknut and turning the NEEDLE UP STOP SCREW. Adjust so the needles are lifted as high as possible without the needle bar thread guides hitting the frame.

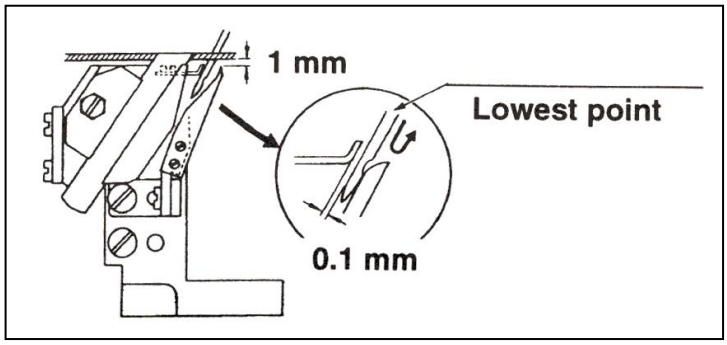


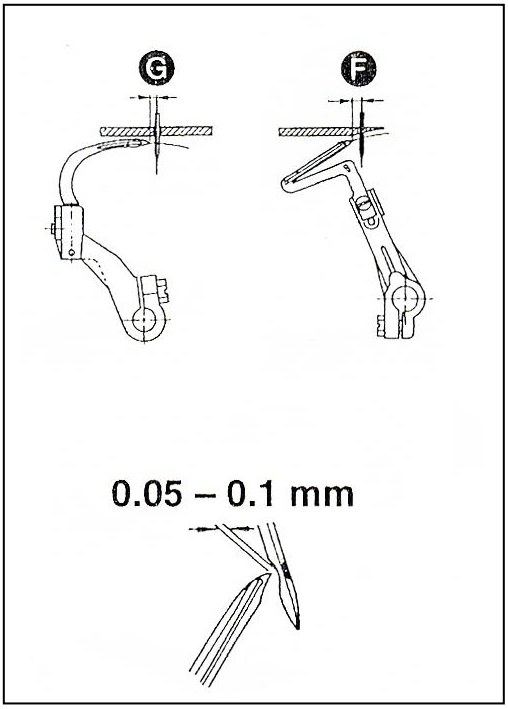
Adjusting the Timing of Loopers and the Needle Guards

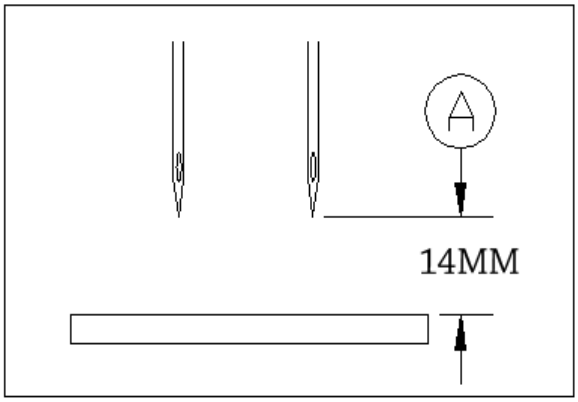
The looper and needle guard are set according to the dimensions in the illustrations on this page at the factory. Needle Top Dead Center is 14mm above throat plate.

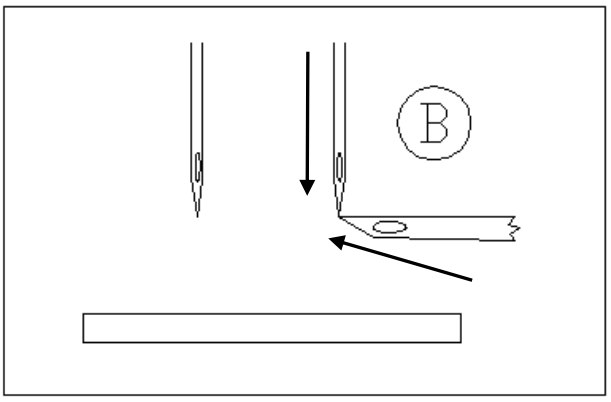
Warning: These adjustments should be made by a qualified technician. To avoid injury, disconnect the power source before adjusting. Be sure that all screws are tightened and that none of the components come in contact with each other before restoring power to the machine.

14mm
F=3mm
G=2mm





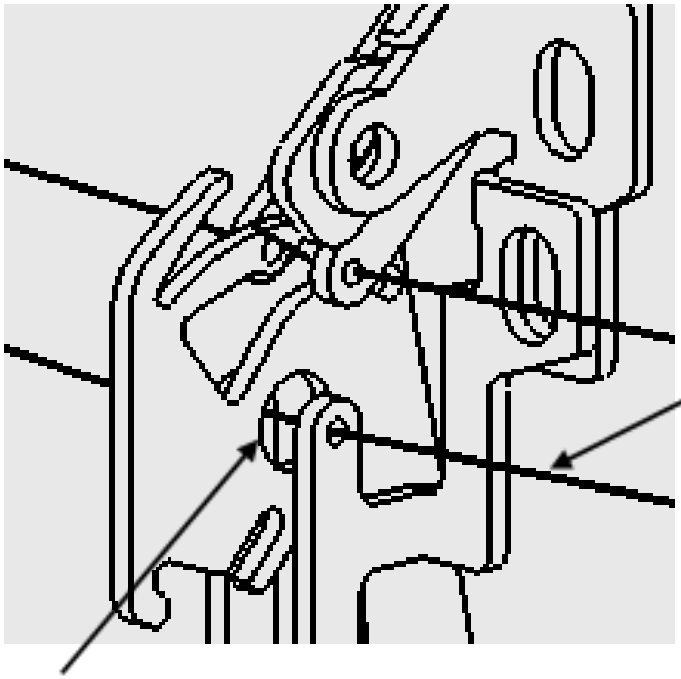




Point of needle and point of looper align as looper rises (B).

Threading the Needle Take-ups

The overedge needle thread goes thru the upper eyelets and over the top of the take-up. The safety stitch thread goes thru the lower eyelets and thru the large hole in the center of the take-up.



1337HSEHLPAR4 Parameter Settings

PARAMETER	RANGE	VALOR	DESCRIPTION
Primero esto	*****	****	Perform a master reset before programming, see below
290		5	Mode of operation. MUST SET THIS PARAMETER FIRST!
026	0-5	0	F-026=0 to disable the EB401 selection after power on.
111	200-9900 rpm	3500	Maximum speed.
019	0-4	1	Sew Foot Disable in seam
161	0-1	1=CCW	Motor rotation
202	0-500	500	Start delay after foot lift. (0.5 sec.)
240	0-66	6	Machine run blocked with OPEN contact in1
270	0-5	0	External handwheel sensor configuration. (NO SENSOR)
272	020-255	1000	Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111.
436		0	Must use code "5913". This disables an input that was causing box to reset itself.
401	0	1	Change setting from 0 to 1 and press enter to save all settings.

Set Needle Positions (270 MUST BE "0")

Set to 1st needle position “Down” and 2nd Needle position “UP”.
Go into programming mode with code "3112".
Go to parameter 171
Press [E], display shows SR2
Press [>>] display shows P1E (Start pos1, Ndl Down)
    Turn handwheel in direction of sew until needle is at Down position.
    Needles rising and loopers past scarf. Note parameter setting.
Press [E]
Display shows P2E = (Start pos2) rotate handwheel to needle UP position.
    Needles Top Dead Center. Note parameter setting.
Press [E]
Display shows P1A = (End pos1) rotate handwheel to same number as P1E+42.
Press [E]
Display shows P2A = (End pos2) rotate handwheel to same number as P2E+42.
Press [E]
Press [P]
Press [P]
Run machine and heel back to save settings.

Front panel LED's:

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

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" to move cursor and enter the number "5913"
3. Press "E" once and "4.0.0." is displayed. This is a parameter.
4. Press ">>" to move cursor and enter the parameter number. X.X.X.
5. Press "E" to display value.
6. With the value on the screen, adjust to desired setting with + & - buttons.
7. Press "E" to save value. Next parameter is displayed.
8. Repeat at step 4.
9. Use par 401 to save settings at end.
10. Press "P" once when complete.

To Perform Master Reset of Parameters:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "591"
3. Press "E" twice and "093" is displayed.

Setting Needle up Position

Set to 1st needle position “UP” and 2nd Needle position “UP”.

Go to parameter 171
Press [E], display shows SR2
Press [>>] display shows P1E (Start pos1, Needle Dn)
Turn handwheel in direction of sew until display changes and needle is at Down position (Needles rising and loopers past scarf). Note parameter setting.
Press [E]
Display shows P2E = (Start pos2, Needle Up) rotate handwheel to Needle Up position (Top Dead Center). Note parameter setting.
Press [E]
Display shows P1A = (End pos1) rotate handwheel to same number as P1E+42.
Press [E]
Display shows P2A = (End pos2) rotate handwheel to same number as P2E+42.
Press [E]
Press [P]
Press [P]

Front panel LED's:
LED 1: Off
LED 2: Off
LED 3: Off
LED 4: Off
LED 5: On, Stop needle down in the seam.*
LED 6: Off, (Stop at needle up.)
LED 7: Off
LED 8: Off

*Note: P1E should be set to stop needle down. When stopping needle down use the air foot switch to lift the foot without raising the needles.

Machine Maintenance

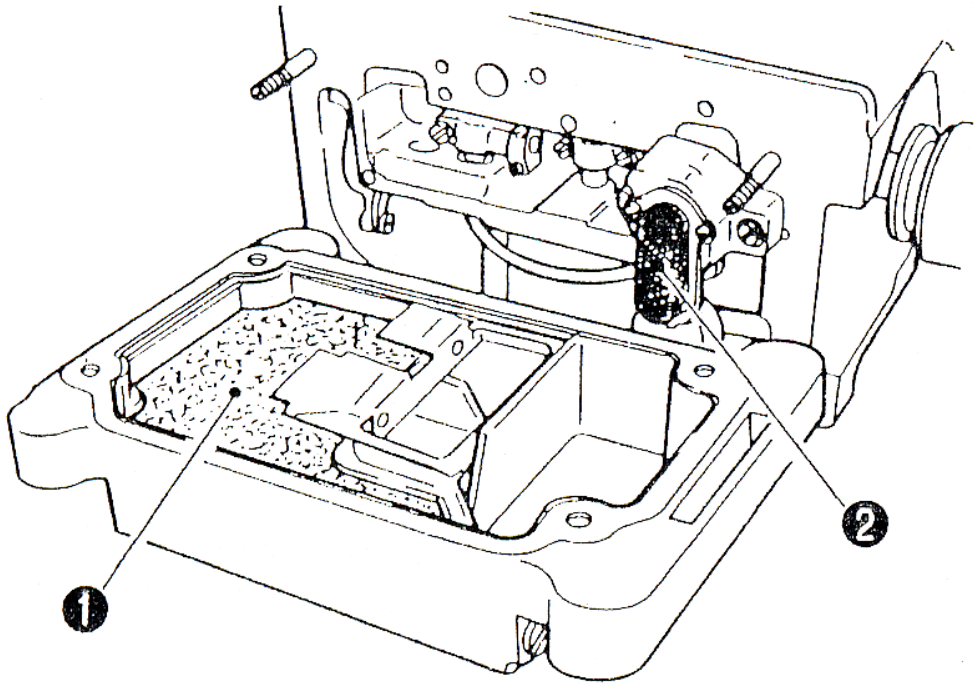
Regularly scheduled maintenance of the model 1337H unit reduces possible problems and downtime. Proper care will also ensure a longer life and better performance of the machine.

Perform the following procedures to properly maintain the machine.

1. Clean the machine once or twice a day.
   a) Wipe off any electric photo eyes with a clean, nonabrasive, dry cloth.
   b) Use a blow-off hose to remove any excess lint, thread, or other clippings.
   c) Clean any lint or threads from the top feed drive belt and pulleys.
2. Refer to the Juki sewing head manuals for the manufacturer's recommendations and guidelines for maintenance and lubrication of the sewing head.
3. Check the air regulator filters weekly. Change the filter elements once every 6 months.
4. Change the oil in the sewing machine every 3 to 4 months.
   If the pointer bar of the oil gauge falls below the lower marker line of the gauge, add oil.
   Apply two or three drops of oil to the needle bar and upper looper guide and presser spring regulator before operating the machine for the first time and after a long period of disuse.

Cleaning the Filter and Pump Net

1. Clean the oil filter (1) and pump strainer (2) periodically: two or three times a year. If the filter and strainer are clogged with dust, etc., the machine components may not get proper oiling.
2. If the lubricating oil in the machine is discolored, change the oil also at the time of cleaning.



Recommended Spare Parts List

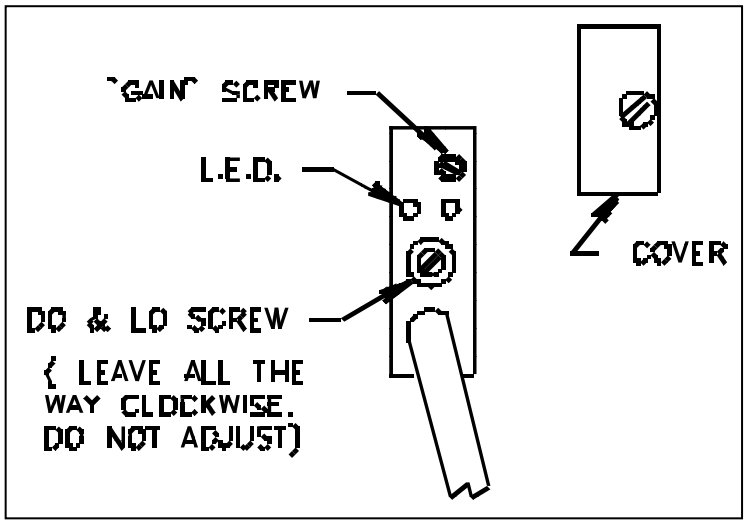
SP1337HEHLJ28CN		
PART NUMBER	DESCRIPTION	QTY
115-65900	CUTTER, UPPER, CARBIDE	2
115-66502	CUTTER, LOWER	2
118-90001	NEEDLE GUARD, LOWER	1
120-15400	NEEDLE HOLDER (GUARD)	1
120-15301	NEEDLE HOLDER (GUARD)	1
123-84509	NEEDLE HOLDER (GUARD)	1
123-83501	LOOPER, UPPER	1
123-84202	LOOPER, LOWER	1
123-84400	LOOPER, CHAIN	1
1325-12	ROD END, BALL BEARING	1
1337335	NEEDLE BAR AND BUSHING	1
1342Z-201A	ROLLER DELRIN	1
1342Z-201B	ROLLER DELRIN, TOP	1
3524-02M	U-JOINT	1
AAEVQZ2121	VALVE, BODY PORTED	1
BBB-65	BEARING, NEEDLE, .375 B	2
BBB-66	BEARING, NEEDLE, .375B	2
BB1L005	BEARING, BALL, 1/2 ID	1
GG210L050	BELT, GEAR, 3/8 P, 1/2 W, 56TH	1
GG414XL050UK	BELT, GEAR, KEVLAR	1
1337870	MAIN FEED DOG	1
1337874	PLATE, THROAT, 3/4GA	1
RRLE030CD7	SPRING, EXT, .030X.31X2.0	1
RRLE045D1	SPRING, EXT .045X.38X1.0	1
RRLE055DE9	SPRING, EXT .055X.44X2.5	1
SNTVX722-140GB	NEEDLE, SYS TVX7, 22/140 GROZ BECKERT(149X7)	100
SS8080310TP	SCREW, SET, SLTD, 1/8-44 2.8L, MOG-3716 JUKI	2
SSM22735	SCREW, SHOULDER .182-40X17/64, .257D	4
SSSS80012	SCREW, SKT SET, KNURL PT 6-32 X 3/16	6
SSSS90012	SCREW, SKT SET, KNURL PT 8-32X3/16	6

Contact AAC's sales department to order replacement parts.

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

Electric Eye Sensor Adjustment (If present)

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



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

Reflective Tape Maintenance

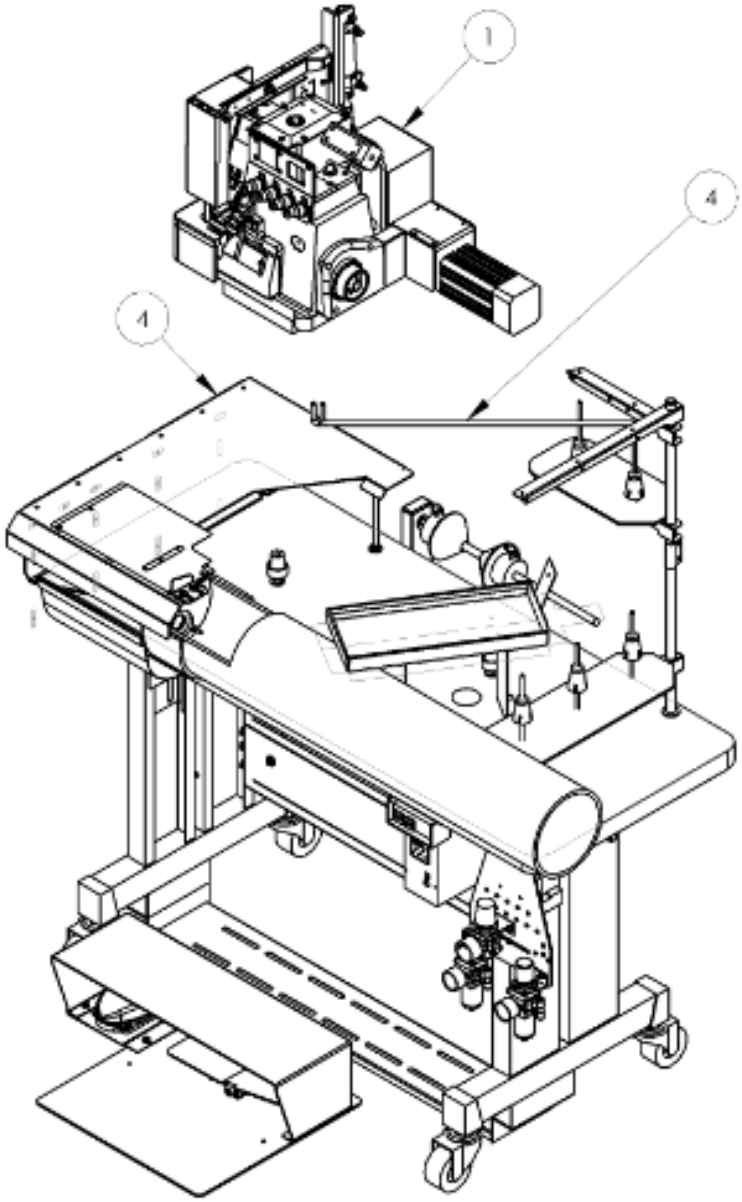
- Use a soft cloth for cleaning.
- Do not use chemicals or abrasives to clean it.
- Avoid any contact with oils and liquids.
- Do not touch the tape with bare fingers.
- If tape is dirty or opaque, the eye may not function correctly.

Assembly Drawings & Parts Lists

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.

11337HEHLJ28CN Panel Flanger Workstation, 5mm Gauge

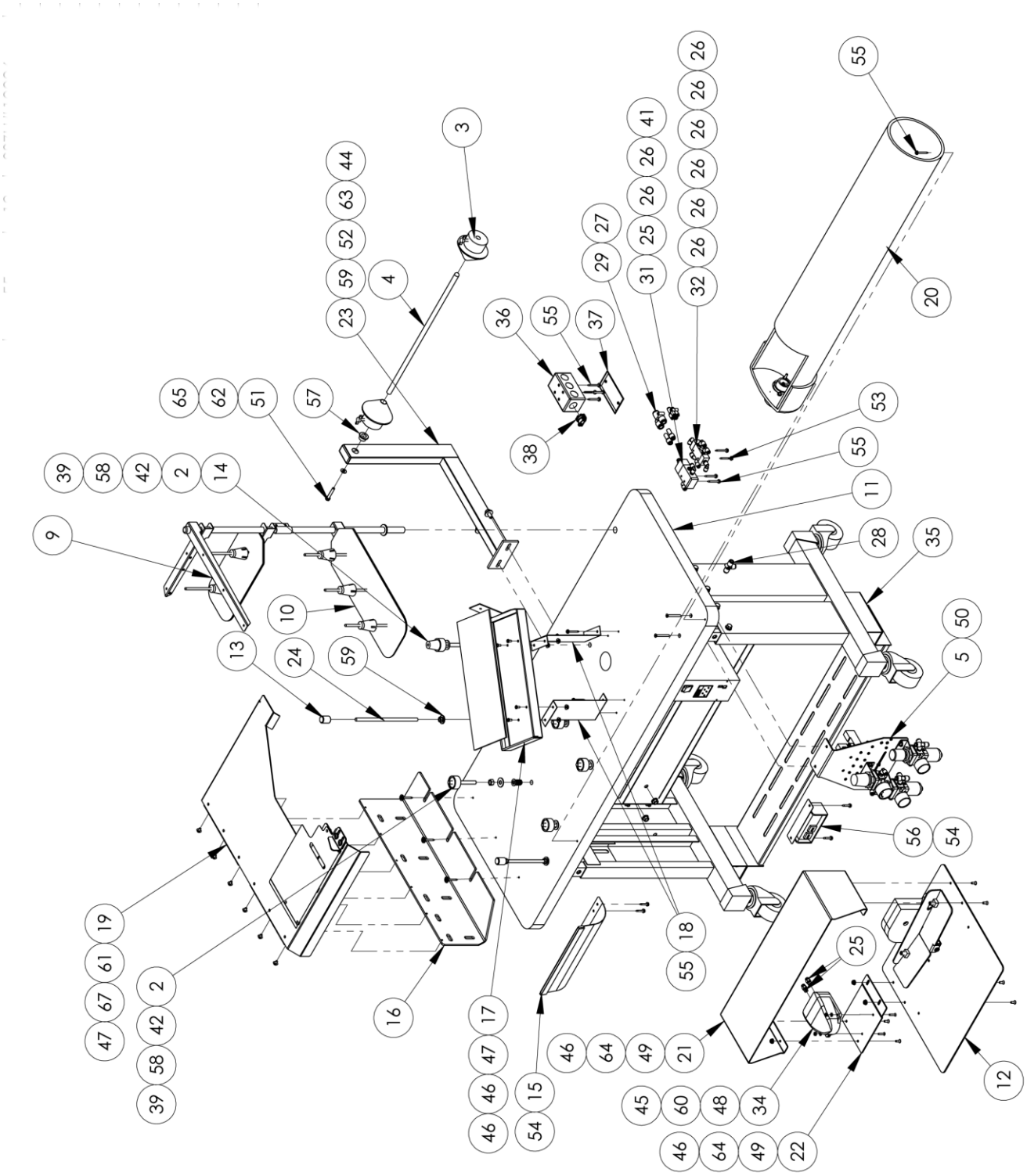
AAC Drawing Number 90041003 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	11337HSEHLJ28CN	PANEL FLANGER WORK STATION,5MM GA
2	1	1278-8201	ROD,THREAD GUIDE EXTNSN
4	1	1337884	GENERIC CONSOLE ASSY,HL
5	*1	1337H-PD	DIAGRAM,PNEUMATIC,HEJ28A
6	*1	1337H-WD	DIAGRAM, WIRING,HEJ28A
7	1	1337HE-WD	DIAGRAM, WIRING
8	1	1337HEC-PD	DIAGRAM, PNEUMATIC
9	*1	1337HSEHLPAR4	PARAMETER LIST
10	*1	4059-DC09	CABLE, STEPPER,6 FT

1337884 Generic Console Assembly, HL

AAC Drawing Number 1337884 Rev 2

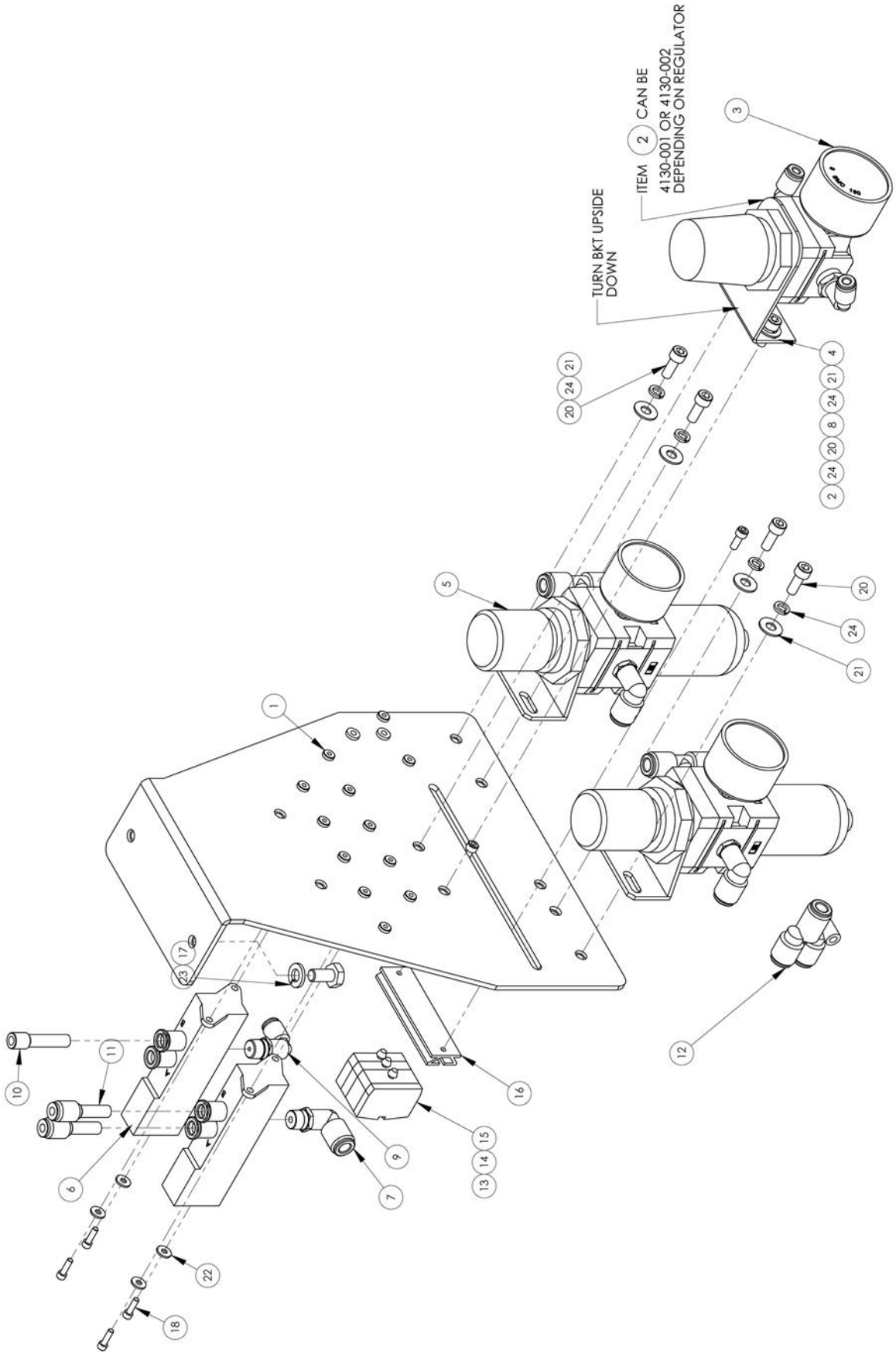


1337884 parts list

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	0211-701EA	CABLE,I/O,FL,SAFETY SW	35	1	K-4DS	HD T LEG ADJ STAND SHORT
2	5	0411-128B	ISOLATOR MOUNT ASSEMBLY	36	1	K-230	BOX,METAL, 2X4X2
3	2	787-4A-032	CONE BEARING ASSY.	37	1	K-231	COVER, 2X4
4	1	1335-816	ROD,SS, 1/2 X 15.0 L	38	2	K-235	CONNECTOR,ROMEX,1/2"
5	1	1337-1500A	PNEUMATIC PANEL, 3 REG.	39	5	K-340I-3/8	INSERT,LEG,1" LONG
6	*1	1337-LAB2	LABELS	40	1	MM132-1496	PLUG 1 X 2
7	*1	1337HE-WD	DIAGRAM, WIRING	41	1	MM4554K11	PLUG, 1/8" PIPE
8	*1	1337HEC-PD	DIAGRAM, PNEUMATIC	42	5	NNH3/8-16	NUT,HEX,3/8-16
9	1	1959-112	2 POS THREAD PLATE ASSY	43	5	NNJ5/16-24	NUT,JAM,5/16-24
10	1	1959-161	3 POS THREAD PLATE ASSY.	44	2	NNK5/16-18	NUT,KEP,5/16-18
11	1	4048-11337HSE	TABLE TOP 20X48,6900 JUKI	45	2	NNK8-32	NUT,KEP,8-32
12	1	4059-FP301D	FOOT PEDAL ASSY,EFKA	46	10	NNK10-32	KEP NUT, 10-32
13	2	11200A	BUMPER 5/16-24	47	10	SSBC98024	10-32 X 3/8 BUTTON CAP SC
14	1	51295A	ISOLATOR, MACHINE MOUNT	48	2	SSFC90048	8-32 X 3/4 FLAT AL CAP
15	1	1337140	MATERIAL DEFLECTOR	49	6	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
16	1	1337177	PLATE, CONNECTING, CONSOL	50	2	SSFC98112	#10-32 X 1-3/4 FLAT CAP
17	1	1337178	TOOL TRAY,1X6X14	51	1	SSHC01096	1/4-20 X 1-1/2 HHCS
18	2	1337180	MOUNT, TOOL TRAY	52	2	SSHCM8X20	SCREW,HEX CAP
19	1	1337187	FLANGER GUIDE ASS	53	3	SSZH#6096	SCREW,SHT.METAL HEX 6
20	1	1337189	WASTE CHUTE TUBE	54	4	SSZH#10064	SCREW,SHT.METAL HEX 10
21	1	1337224	COVER,FOOT PEDAL,UPPER	55	18	SSZH#10096	SCREW,SHT.METAL HEX 10, 1
22	1	1337225	BRKT,PEDAL	56	1	T75	ON/OFF 1PH SWITCH BOX, ONLY
23	1	1959335	ROLL HOLDER ARM	57	1	UUFF707-05	BEARING,BRONZE,.502ID
24	2	4400025	THREADED ROD, 5/16-24 X 8	58	5	WWF3/8	WASHER,FLAT,3/8 OR 10MM
25	3	AAQMC-5-8	QU. MALE CONN 5/32X1/8	59	10	WWF5/16	WASHER,FLAT,5/16
26	8	AAQME-5-8	QUICK MALE ELBOW	60	2	WWF8	WASHER, FLAT, #8
27	2	AAQPR-3-4	QUICK REDUCER 3/8-1/4	61	10	WWF10	WASHER, FLAT, #10, COM
28	2	AAQUT-4-4	QUICK UNION T 1/4X1/4	62	4	WWFS1/4	WASHER,FLAT,SAE,1/4
29	1	AAQUY-3-3	QUICK UNION Y,3/8X3/8	63	2	WWFS5/16	WASHER,FLAT,SAE,5/16
30	2	AAQUY-5-5	QUICK UNION Y, 5/32	64	6	WWFS10	WASHER, FLAT, #10, SAE
31	1	AAV125B	PILOT VALVE	65	1	WWL1/4	WASHER,LOCK, 1/4
32	1	AAV180-4A2	DOUBLE PILOT VALVE	66	7	WWL5/16	WASHER,LOCK, 5/16
33	1	FFHBL4579C	RECEPTACLE,3 POLE,3W	67	6	WWL10	WASHER,LOCK,#10
34	1	K-3C30A2S	FOOT AIR SWITCH PURCHASED				

1337-1500A Pneumatic Panel Assembly

AAC Drawing Number 9003202 Rev 1

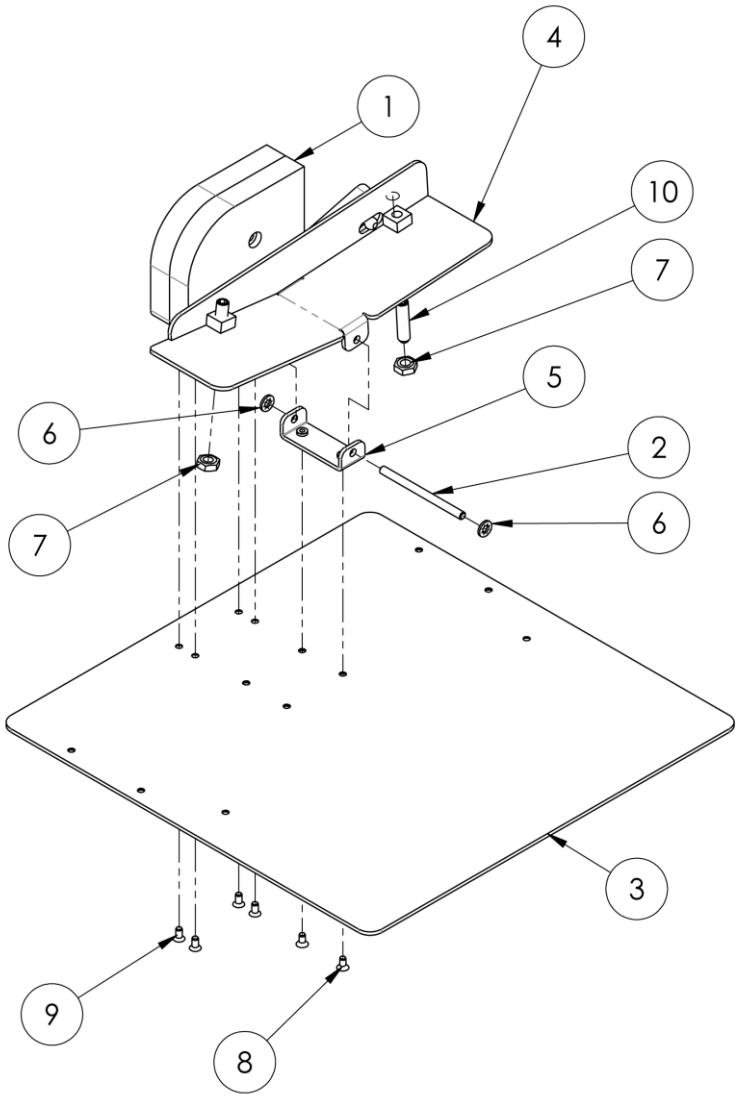


1337-1500A parts list

NO	QTY	PART #	DESCRIPTION
1	1	1338-024	PANEL, PNEUMATIC
2	1	4130-001	REGULATOR BRACKET
3	1	AA198-5031	0-160PSI AIR GAGE 1/8NPT
4	1	AA198-503A	REG,0-125 W/GAUGE& BRKT
5	2	AA198-5102	REGULATOR W/GAUGE & NUT
6	2	AAEVQZ2121	VALVE, BODY PORTED
7	1	AAQME-4-8	QUICK MALL ELBOW, 1/4 T
8	2	AAQME-5-4	ELBOW, MALE 5/32X1/4NPT
9	1	AAQME-5-8	QUICK MALE ELBOW
10	1	AAQPP-07	QUICK PLUG 1/4
11	2	AAQPR-5-4	QUICK PLUG-IN REDUCER
12	1	AAQUY-5-4	Y UNION, 5/32X1/4
13	2	FF264-311	TERMBLK,WAGO,TOP,SINGLE,GRY
14	1	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
15	1	FF264-371	TERMBLK,WAGO,TOP,END
16	1	FF264-3BKT2.5	MOUNT, WAGO, 2" LONG
17	2	SSHC01032	1/4-20 X 1/2 HHCS
18	4	SSSC70024	4-40 X 3/8 SOCKET CAP
19	2	SSSC80024	6-32 X 3/8 SOC CAP SC
20	6	SSSC98032	10-32X1/2, SOC CAP
21	6	WWF10	WASHER, FLAT, #10, COM
22	4	WWF4	WASHER, FLAT, #4
23	2	WWL1/4	WASHER,LOCK, 1/4
24	6	WWL10	WASHER,LOCK,#10

4059-FP301D Foot Pedal Assembly

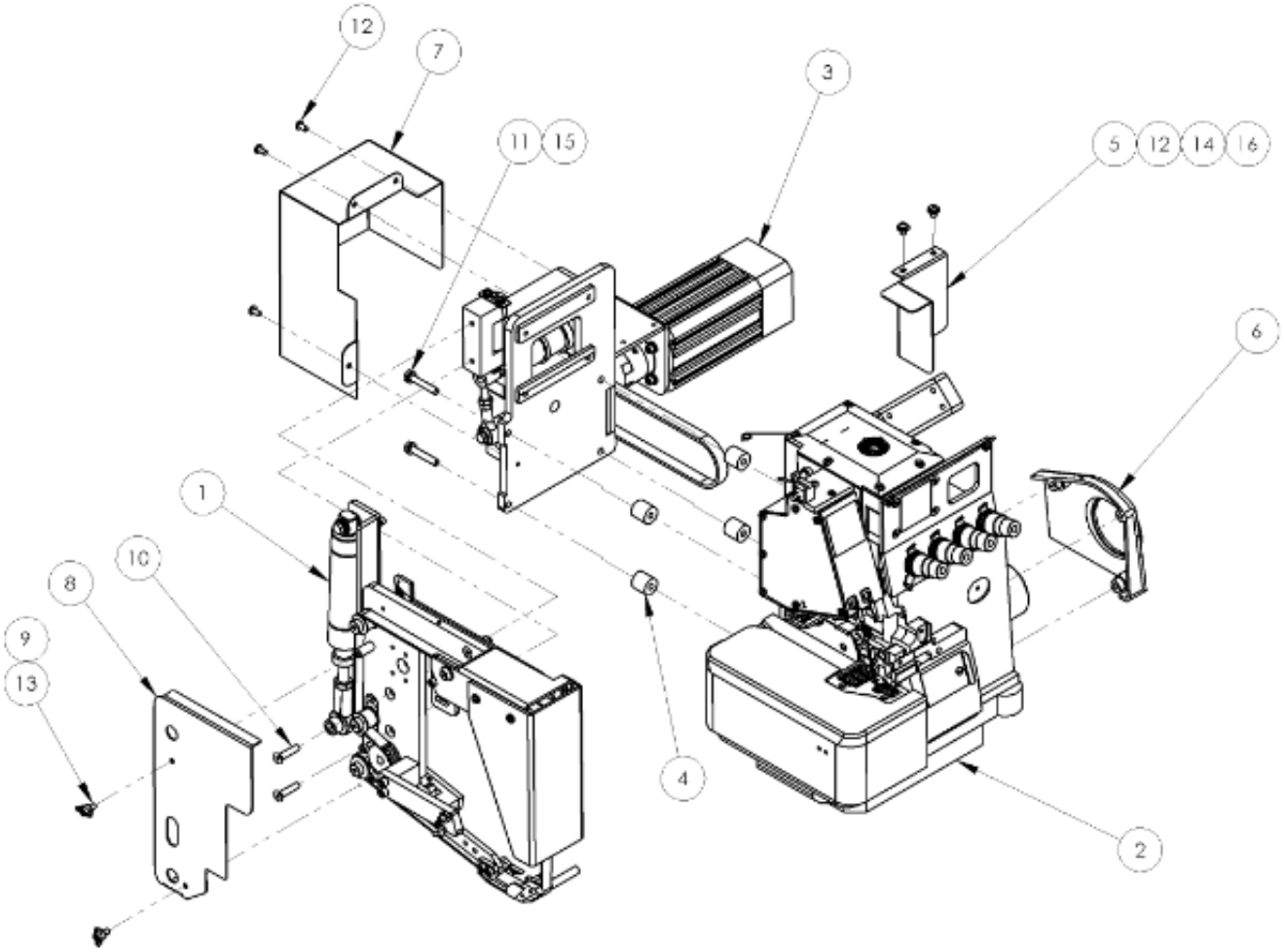
ACC Drawing Number 9000033 Rev.6



NO	QTY	PART #	DESCRIPTION
1	AR	4059-EB301A	ACTUATOR,TREADLE,9 PIN
2	1	26058	ROD, STRAIGHT, 1018
3	1	4059030	BASE, FOOT PEDAL, 12X18
4	1	4059033	FOOT PEDAL WELDMENT
5	1	A3502-4	
6	2	MM94807A029	PUSHNUT,ROUND,1/4 DIA
7	2	NNJ3/8-16	3/8-16 JAM NUT
8	2	SSFC98024	#10-32 X .375 FLAT CAP
9	4	SSFPM5X10	SCREW,FLAT PHILLIPS
10	2	SSSS25096	3/8-16 SET SCREW, 1-1/2"

11337HSEHLJ28CN Sew Head Assembly

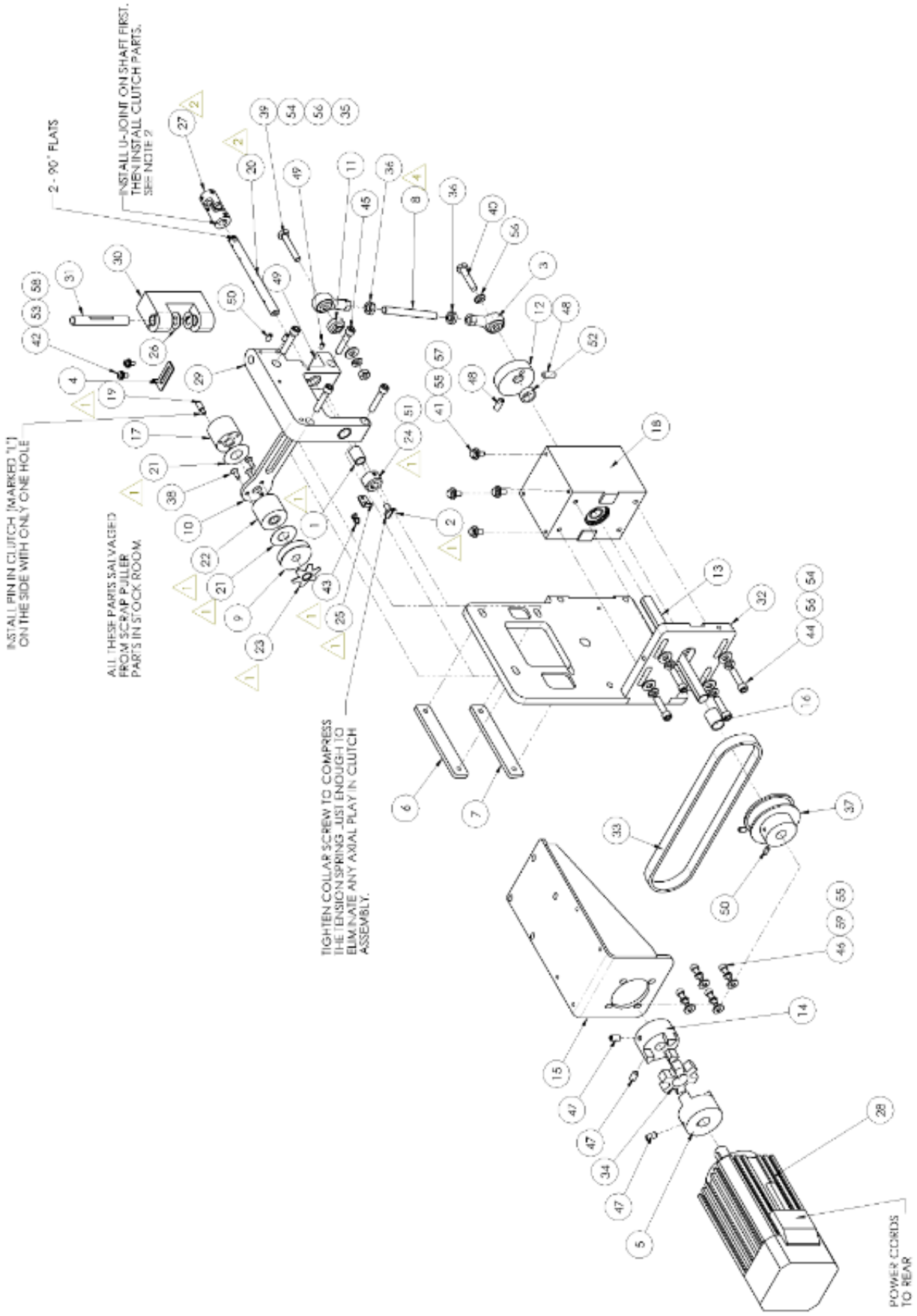
AAC Drawing Number 90001065 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	13371042	BELT FEED ASSY
2	1	13371043	SEWING HEAD ASSEMBLY
3	1	1337304	DRIVE ASSY,HEAVY DUTY
4	4	1337306	SPACER,3/4OD,1/4ID,3/4L
5	1	1337369	GUARD, BELT, REAR
6	1	1337370	BELT COVER, JUKI 6916
7	1	1337414	GUARD,BELT DRIVE
8	1	1337482	BELT COVER
9	3	NNW10-32	#10-32 WING NUT
10	4	SSFC01072	1/4-20 X 1-1/8 FLAT CAP
11	4	SSHC01096	1/4-20 X 1-1/2 HHCS
12	5	SSPP98024	10-32 X 3/8 PAN HD PHILIP
13	2	SSSC98032	10-32X1/2, SOC CAP
14	2	WWF10	WASHER, FLAT, #10, COM
15	4	WWL1/4	WASHER,LOCK, 1/4
16	2	WWL10	WASHER,LOCK,#10

1337304 Drive Assembly, HD

AAC Drawing Number 1337304 Rev 2

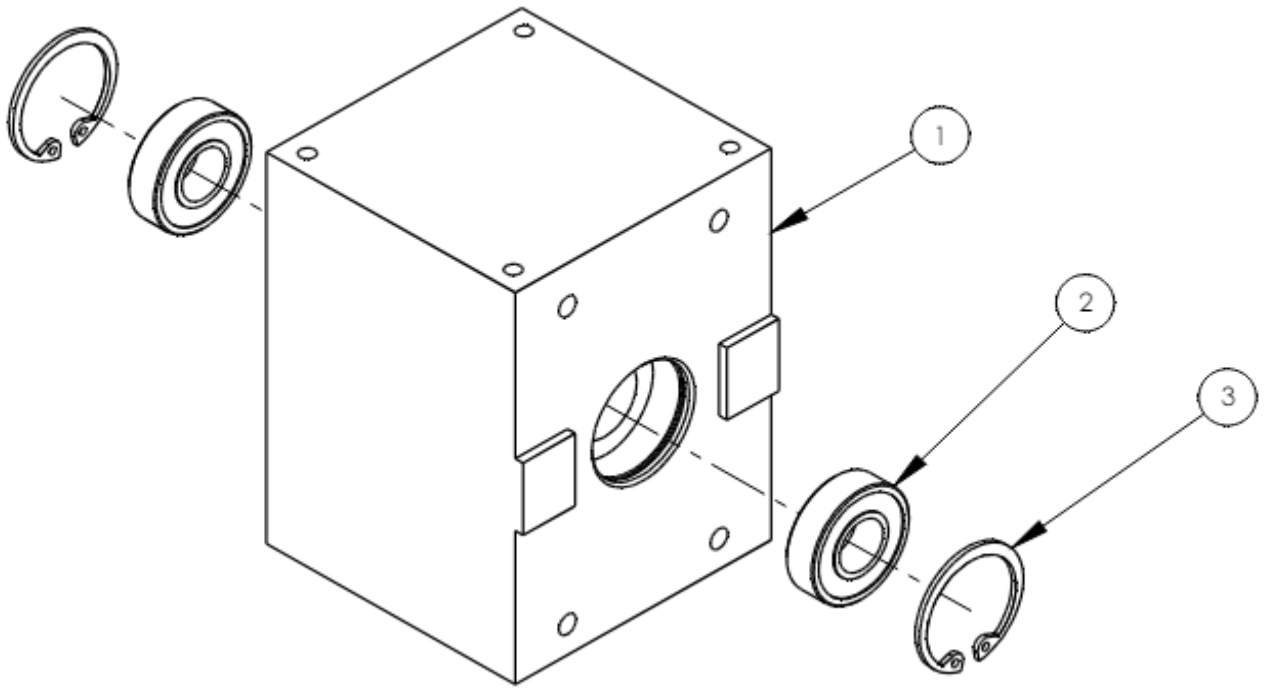


1337304 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	AR	65421	CLUTCH TENSION SLEEVE
2	AR	110097	SCREW,M5-0.8X12
3	2	1325-12	DRIVE ARM CONN W/BEARING
4	1	1325-39C	SPRING CLIP
5	1	1337191	COUPLING,14MM BORE,W/KEY
6	1	1337264	PLATE, NUT, 2 PL,3.63 CT
7	1	1337265	PLATE,NUT,1/4-20,ANGLED
8	1	1337266	THREADED ROD,5/16-24 THD
9	1	1337270	SPACER,CLUTCH BEARING
10	1	1337271	CRANK ARM,CLUTCH BEARING
11	1	1337272	STUD,TIE ROD MOUNT
12	1	1337273	ECCENTRIC HUB
13	1	1337274	DRIVE SHAFT
14	1	1337279	COUPLING,.500 BORE
15	1	1337286	MOTOR MTG BRACKET,WELD
16	1	1337346	SPACER, DRIVE SHAFT
17	1	1337347	CLUTCH SLEEVE,MOD.,LEFT
18	1	1337933	BEARING BLOCK, W/ BEARINGS
19	AR	180005	SCREW,M4-0.7X6
20	1	3501270A	CLUTCH DRIVING SHAFT
21	AR	3501272	THRUST PLATE
22	AR	3501276	CLUTCH SLEEVE (RIGHT)
23	AR	3501282	CLUTCH TENSION SPRING
24	AR	3501283	ADJUSTING COLLAR
25	AR	3501284	ADJUSTING SCREW STAY
26	2	3517	WASHER,THRUST,BRONZE
27	1	3524-02M	3/8" X 10MM U JOINT
28	1	4059-DC50	MOTOR, LOW SPD, HIGH TORQ
29	1	49012A	BLOCK,TRANSFER,ASSY
30	1	49014B	BLOCK,PIVOT,ASSY
31	1	49015A	PIVOT SHAFT
32	1	49018D	BRACKET,WELDMENT
33	1	GG210L050	BELT, 3/8P, 56T, 1/2W
34	1	MML075B	SPIDER,BUNA-N
35	1	NNH1/4-20	NUT,HEX,1/4-20
36	2	NNJ5/16-24	NUT,JAM,5/16-24
37	1	PP18LB050M	PULLEY,GEAR,3/8P,.50B,18T
38	3	SSFCM4X12	SCREW,FLAT ALLEN CAP
39	1	SSHC01096	1/4-20 X 1-1/2 HHCS
40	1	SSHC05080	1/4-28 X 1-1/4 HEX CAP
41	4	SSHC98032	10-32X1/2 HEX HD
42	2	SSPP90024	8-32X3/8 PAN PHLPS
43	AR	SSPSM3X5	M3-0.5 x 5MM
44	4	SSSC01064	1/4-20 X 1 SOC CAP
45	4	SSSC01080	1/4-20 X 1-1/4 SOC CAP
46	4	SSSCM5X16	M5-0.8 X 16,SOC CAP SCR
47	3	SSSS01032	SCREW, SET, 1/4-20 X 1/2
48	2	SSSS05040F	SET SCREW1/4-28X5/8
49	1	SSSS90016	#8-32 X 1/4 SET SCREW
50	4	SSSS98024	10-32X 3/8 SOC SET SC
51	AR	SSSSM5X5	M5 X 5 SET SC,CUP PT
52	1	UUAA618-16	BEARING,BRONZE,.504 ID
53	2	WWF8	WASHER, FLAT, #8
54	5	WWFS1/4	WASHER,FLAT,SAE,1/4
55	8	WWFS10	WASHER, FLAT, #10, SAE
56	6	WWL1/4	WASHER,LOCK, 1/4
57	4	WWL10	WASHER,LOCK,#10
58	2	WWL8	WASHER,LOCK,#8
59	4	WWLM5	M5 LOCK WASHER

1337933 Bearing Block

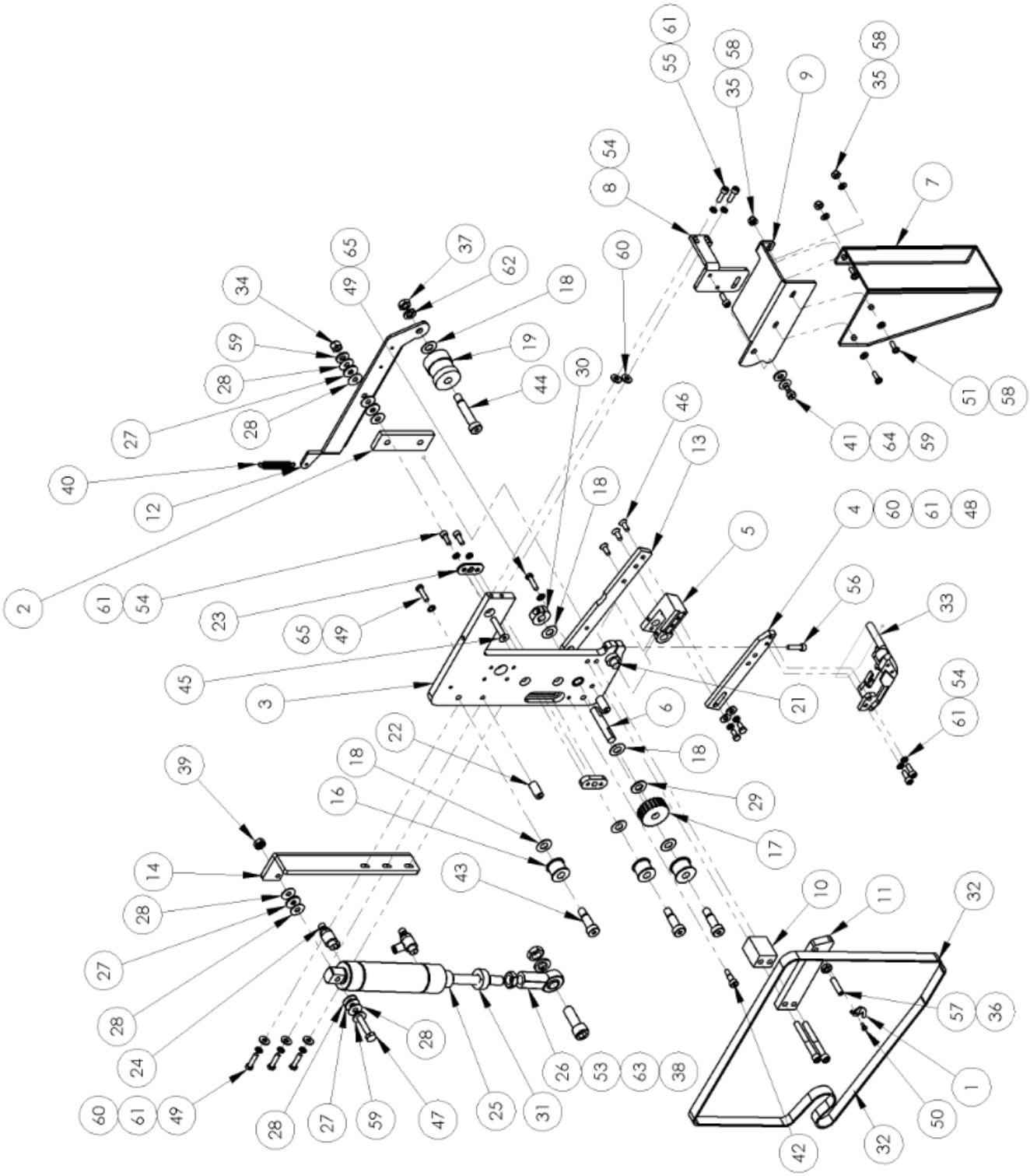
AAC Drawing Number 1337933 Rev 0



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1337269	BEARING BLOCK
2	2	BB1L005	BEARING,BALL,.500D
3	2	MM98409A221	RETAINING RING,INT,1.125B

13371042 Belt Feed Assembly

AAC Drawing Number 13371042 Rev 0



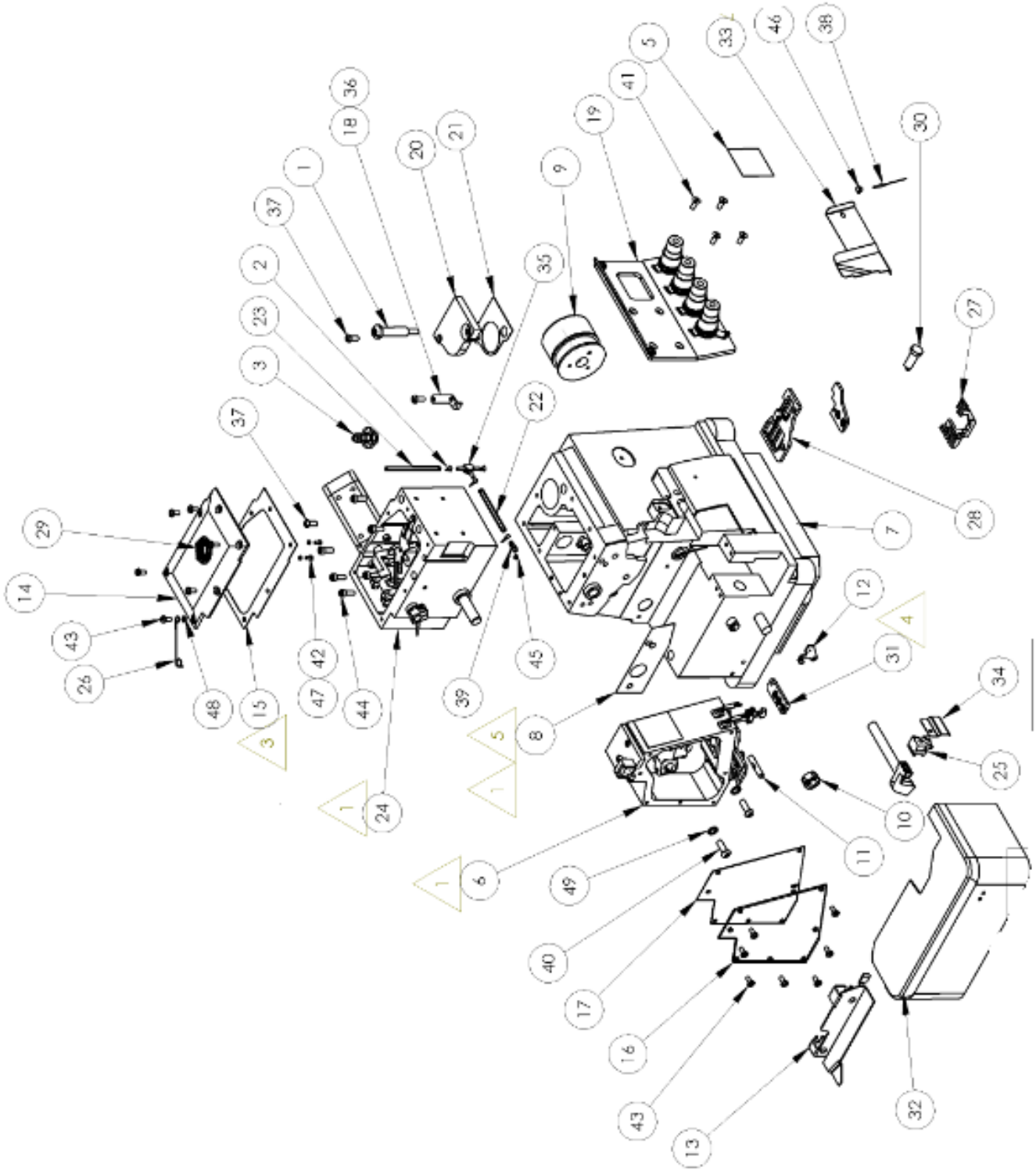
13371042 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	13116702	THREAD TRIMMER
2	1	13371049	SPACER,1/4X1X3X1.87CTC
3	1	1337297	MOUNT,MAIN,HD
4	1	1337298	ARM,PRESSER,HVY DUTY
5	1	1337299	BLOCK,PRESSER ARM PIVOT
6	1	1337901	SHAFT,DRIVE,.375X2.0L
7	1	1337320	GUARD,BELT
8	1	1337325	TOP SUPPORT LATCH BKT
9	1	1337326	BRKT,GUARD,BELT
10	1	13371051	SPACER, LATCH
11	1	1337468	LATCH ARM
12	1	1337483	ARM,BELT TENSION,LONG
13	1	1337579	ARM,FOOTLIFT,LONG
14	1	1337582	MOUNT,FOOTLIFT CYL,1-*1/4
15	1	1342Z-201A	ROLLER,DELRIN,TOP BELT FD
16	2	1342Z-201B	ROLLER,DELRIN,TOP BELT FD
17	1	311-3004	PULLEY,GEAR,1/5 PITCH
18	6	3517	WASHER,THRUST,BRONZE
19	1	49023A	ROLLER,FRONT
20	1	49031	SPACER,IDLER ROLLER
21	1	49035A	PIVOT SHAFT & SLEEVE
22	2	49038A	BELT COVER SPACER
23	1	49049	PLATE,WASHER
24	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"
25	1	AACM122DP	CYLINDER,AIR,DA W/MAGNET
26	1	BBAW-7	BEARING,ROD END,FEMALE
27	4	BBNTA411	BEARING,THRUST,.250B
28	8	BBTRA411	WASHER,THRUST,STEEL
29	1	BBTT710-01	WASHER, THRUST, BRNZ.
30	1	CCCL6F	CLAMP COLLAR- 3/8
31	1	CCSCL7F	CLAMP COLLAR- 7/16
32	1	GG414XL050UK	BELT,GEAR,KEVLAR CORE,URE
33	1	M1J28-009	FOOT ASBLY, TBF, 3/4 GA

ITEM	QTY.	PART NUMBER	DESCRIPTION
34	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
35	3	NNE8-32	NUT,ELASTIC LOCK, 8-32
36	1	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
37	1	NNJ5/16-18	NUT,JAM,5/16-18
38	1	NNJ7/16-20	NUT,JAM,7/16-20
39	1	NNK1/4-20	NUT,KEP,1/4-20
40	1	RRLE049D9	SPRING,EXT,.049X.375X2.5
41	1	SSAS016012	SHOULDER BOLT, 1/4 X 3/16
42	1	SSAS016024	SHOULDER BOLT #10 X .375L
43	3	SSAS024048	SHOULDER BOLT,3/8X3/4X5/16-18
44	1	SSAS024096	SHULDER BOLT 3/8 X 1.50L
45	1	SSFC01080	1/4-20 X 1-1/4 FLAT CAP
46	3	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
47	1	SSHC01096	1/4-20 X 1-1/2 HHCS
48	2	SSHC98024	10-32 X 3/8 HEX CAP
49	5	SSHC98048	SCREW, HEX CAP #10-32X.75
50	1	SSPP70016	4-40 X 1/4 PAN HD PHILLIP
51	3	SSPP90032	SCREW,#8-32 X 1/2, PAN HD, PHIL
52	2	SSSC01144	1/4-20 X 2.25 SOC CAP
53	1	SSSC40080	7/16-20 X 1-1/4 SOC CAP
54	5	SSSC98032	10-32X1/2, SOC CAP
55	2	SSSC98040	10-32 X 5/8 SOC CAP
56	1	SSSC98048	10-32 X 3/4 SOC CAP
57	1	SSSS05064	SET SCREW1/4-28X1
58	6	WWF8	WASHER, FLAT, #8
59	3	WWFS1/4	WASHER,FLAT,SAE,1/4
60	7	WWFS10	WASHER, FLAT, #10, SAE
61	11	WWL10	WASHER,LOCK,#10
62	1	WWL5/16	WASHER,LOCK, 5/16
63	1	WWL7/16	WASHER,LOCK,7/16
64	1	WWS307-1	WASHER,SPRING,BELVEL
65	2	WWSI10	WASHER,INTERNAL TOOTH,10

13371043 Sew Head Sub Assembly

ACC Drawing Number 13371043 Rev.0

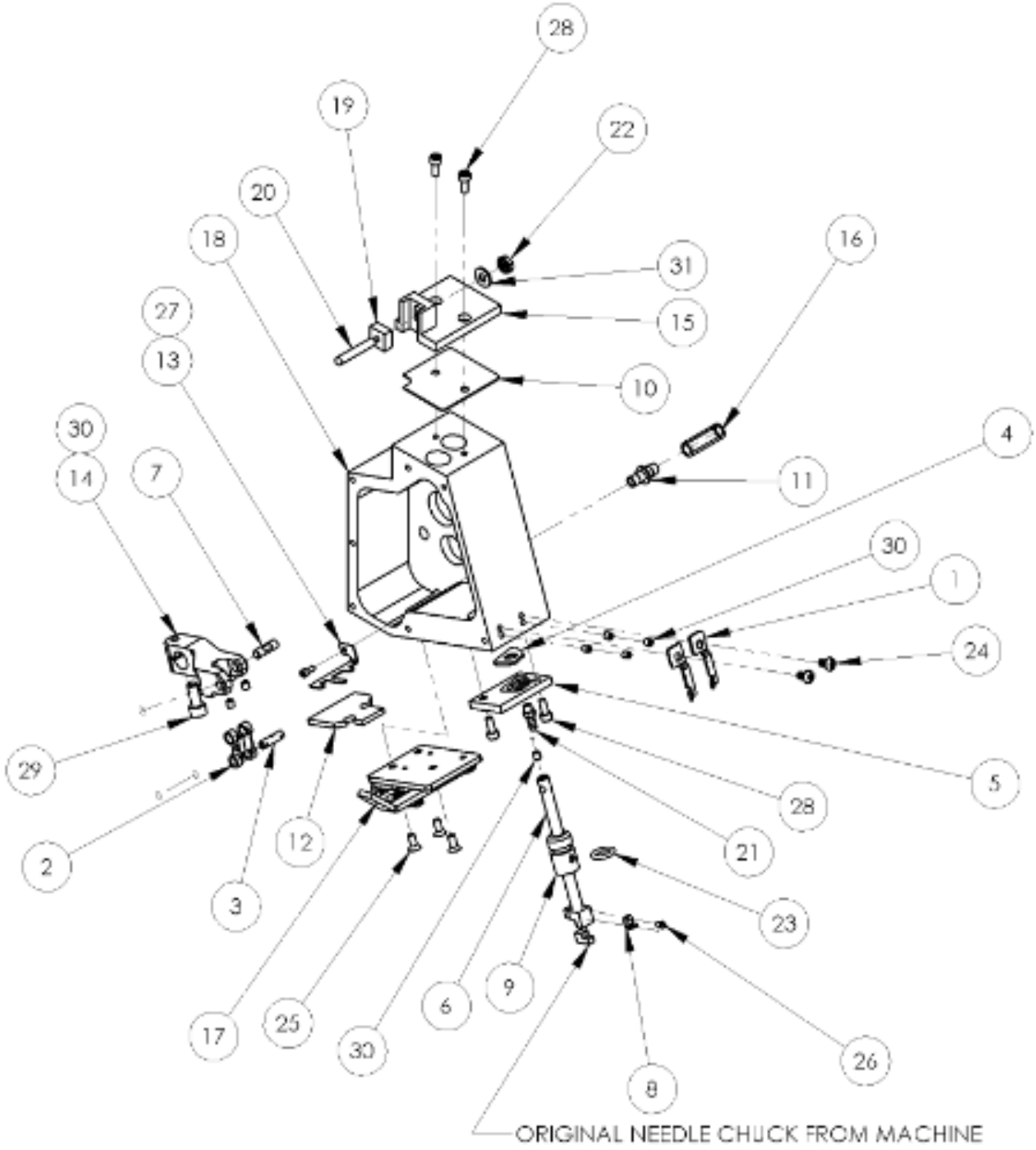


ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	13104500	OIL DRAIN SCREW
2	4	13142609	OIL TUBE HOLDER
3	1	13143300	OIL GAUGE
4	1	1337-LAB1	LABEL, S/S THREADING
5	1	1337-LAB4	LABEL, NEEDLE SIZE
6	1	13371040	NEEDLE BAR DRIVE ASBLY
7	1	1337255	CASTING, MODIFIED, 6916G
8	1	1337257	SHIM, NDL DRIVE ASBLY
9	1	1337278	HAND KNOB PULLEY ASSY
10	1	1337310	THRUST COLLAR, MODIFIED
11	1	1337341	OIL INJECTOR
12	1	1337373	THREAD GUIDE, MODIFIED
13	1	1337374	SIDE COVER, MODIFIED
14	1	1337389	COVER, LIFT LINK BOX
15	1	1337391	GASKET, LIFT LINK BOX
16	1	1337392	COVER,NEEDLE BAR DRIVE
17	1	1337393	GASKET,NEEDLE BAR DRIVE
18	1	1337397	OIL GUAGE GUIDE
19	1	1337403	PLATE,THREAD TENS. MOUNT
20	1	1337404	COVER,OIL FILTER
21	1	1337405	GASKET MOD,OIL FILTER
22	1	1337411	TUBE, OIL, 2.62" LONG
23	1	1337412	TUBE, OIL, 4.88" LONG
24	1	1337465	NEEDLE LIFT ASBLY
25	1	1337486	MODIFICATION, KNIFE SUP.

ITEM	QTY.	PART NUMBER	DESCRIPTION
26	1	1337644	THREAD GUIDE
27	1	1337870	MAIN FEED DOG
28	1	1337874	PLATE, THROAT, 3/4 GA,
29	1	22924708	OIL SIGHT GLASS
30	1	49001	STUD,PUSH BUTTON,MOD
31	1	49005	REAR THROAT PLATE MT.
32	1	49021B	PLATE,CLOTH MOD.
33	1	49065	CHIP DEFLECTOR
34	1	49066	TRIM DEFLECTOR
35	1	7267	TEE CONNECTOR,BARB,3MM
36	1	SM4050855SP	M5X8 PAN SLOTTED
37	2	SM4051255SP	M5X12 PAN SLOTTED
38	2	SNTVX722-140GB	NEEDLE,SIZE 140/22
39	1	SQ1110451MZ	FITTING,OIL JET
40	2	SSBC01048	SCREW,BUTTON CAP,1/4-20X3/4
41	4	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
42	2	SSPP70016	4-40 X 1/4 PAN HD PHILLIP
43	13	SSPP90024	8-32X3/8 PAN PHLPS
44	6	SSSCM5X14	SCREW,SOC CAP,M5-0.8 X 14
45	1	SSSS90008	8-32X1/8 SET SCREW
46	1	SSTS85012	6-40 X 3/16 TRUSS HEAD
47	2	WWL4	WASHER,LOCK,#4
48	1	WWL8	WASHER,LOCK,#8
49	2	WWSI1/4	WASHER,INTERNAL TOOTH,1/4

13371040 Needle Bar Drive Assembly

AAC Drawing Number 13371040 Rev 0

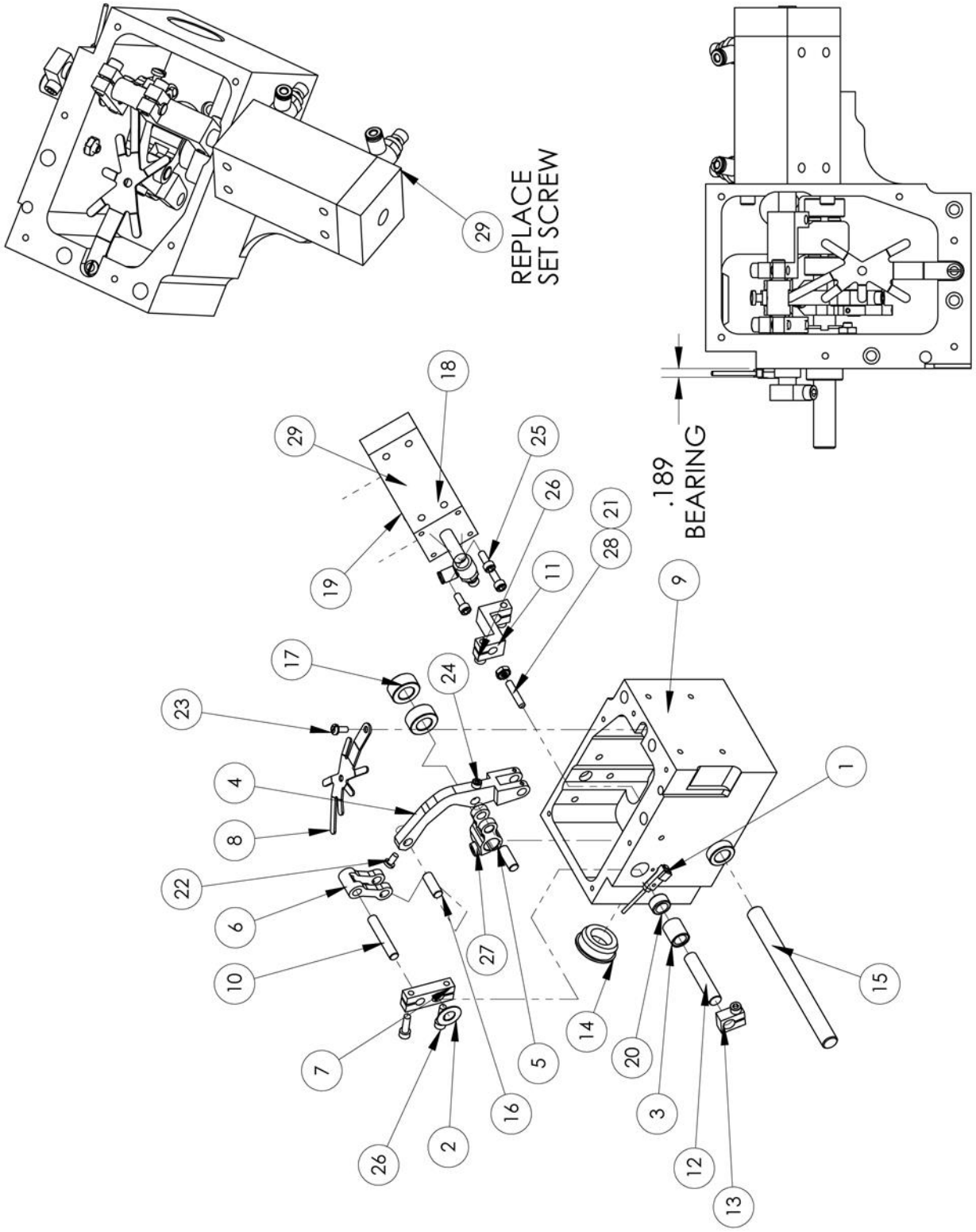


13371040 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	12372405	THREAD EYELET
2	1	13208004	NEEDLE DRIVING LINK
3	1	13209507	NEEDLE DRIVING PIN "B"
4	1	13371041	OIL WICK PAD, NDL BARS
5	1	13371044	OIL GUARD, NDL BARS
6	1	13371050	NEEDLE BAR, MOD.
7	1	1337260	NDL DRIVE PIN, 5.5MM
8	1	1337261	NDL BAR EYELET
9	1	1337312	NEEDLE BAR BUSHING, MOD
10	1	1337336	GASKET, TOP GUIDE
11	1	1337344	BARB COUPLING, 1/4 TUBE
12	1	1337371	OIL FELT, NEEDLE BAR
13	1	1337372	BRKT, OIL FELT
14	1	1337383	DRIVE YOKE
15	1	1337402	LATCH BLOCK
16	1	1337413	PVC TUBING, 3/8OD X 3/4L
17	1	1337472	LATCH ASSEMBLY
18	1	1337478	NEEDLE BAR DRIVE HOUSING
19	1	49044	LATCH PIN NUT
20	1	49053	STUD, LATCH
21	1	AAF11752-3	10-32 TO 1/8 BRASS
22	1	NNK10-32	KEP NUT, 10-32
23	1	R0108240100	O-RING
24	2	SSBC90020	8-32X3/8 BUTTON CAP
25	3	SSFC90024	8-32 X 3/8 FL ALN CAP
26	1	SSPS50012	2-56 X 3/16 PAN HD SC
27	1	SSSC70016	4-40 X 1/4 SOCKET CAP
28	4	SSSC90024S	#8-32 X 3/8 SOC CAP SC
29	1	SSSCM6X15	M6X15 SOC CAP SCREW
30	7	SSSS90012	8-32 X 3/16 SOC SET SC
31	1	WWFS10	WASHER, FLAT, #10, SAE

1337465 Needle Lift Assembly

AAC Drawing Number 1337465 Rev 1

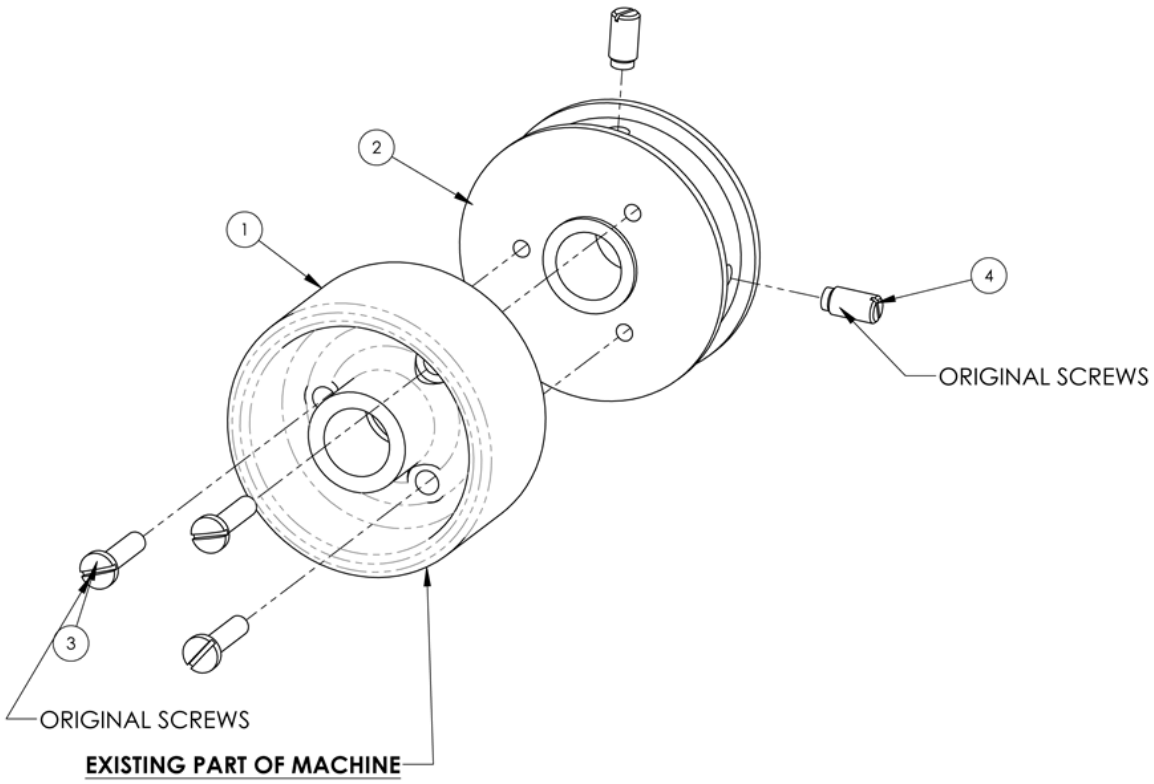


1337465 parts list

NO	QTY	PART #	DESCRIPTION
1	1	1278-7055D	PROX SWITCH W/PLUG,12"
2	1	3517	WASHER,THRUST,BRONZE
3	1	3523	ROLLER BEARING,.375B
4	1	1337377	NEEDLE BAR DRIVE LEVER
5	1	1337378	FEED CRANK
6	1	1337384	CAM LINK
7	1	1337387	NEEDLE LIFT LINK
8	1	1337396	OIL JET BRACKET
9	1	1337459	HOUSING, HIGH LIFT LINK
10	1	1337461	PIN, 7MM 1.58 IN
11	1	1337462	NEEDLE ROT. LINK
12	1	1337463	PIN, 3/8 X 1.81
13	1	1337464	SENSOR FLAG
14	*AR	10753309	RUBBER PLUG, 28MM
15	*AR	13110606	NEEDLE DRIVING SHAFT
16	2	13122304	CRANK PIN D, .2850 DIA
17	*AR	13172705	THRUST COLLAR
18	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"
19	1	AACS3204	ACTUATOR,ROTARY,32IP,3/8
20	1	BBB-65	BEARING,NEEDLE,.375B
21	1	NNK10-32	KEP NUT, 10-32
22	1	SS7110840SP	SCREW,11/64-40X7.8MM
23	1	SSPS90024	#8-32 X 3/8 LG PAN HD
24	1	SSSC90032	#8-32 X 1/2 SOC CAP SC
25	3	SSSC95032	10-24 X1/2, SOC CAP
26	5	SSSC98040	10-32 X 5/8 SOC CAP
27	1	SSSCM6X12	M6X12 SOC CAP SCREW
28	1	SSSS98064	10-32 X 1 SOC SET SC
29	1	SSSS98080	SCREW,SKT SET,FLAT POINT

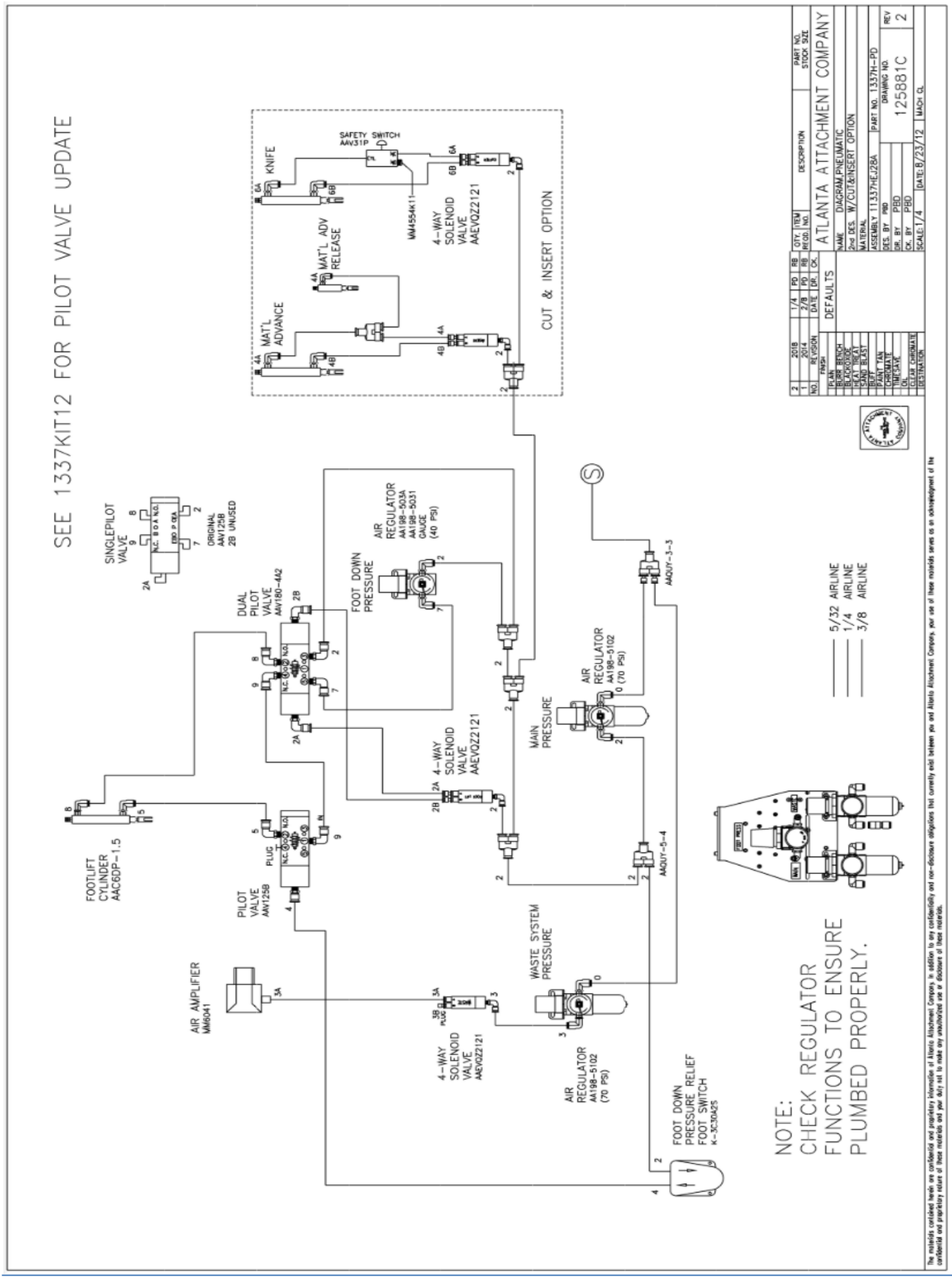
1337278 Handwheel Puller Assembly

AAC Drawing Number 1337278 Rev 2

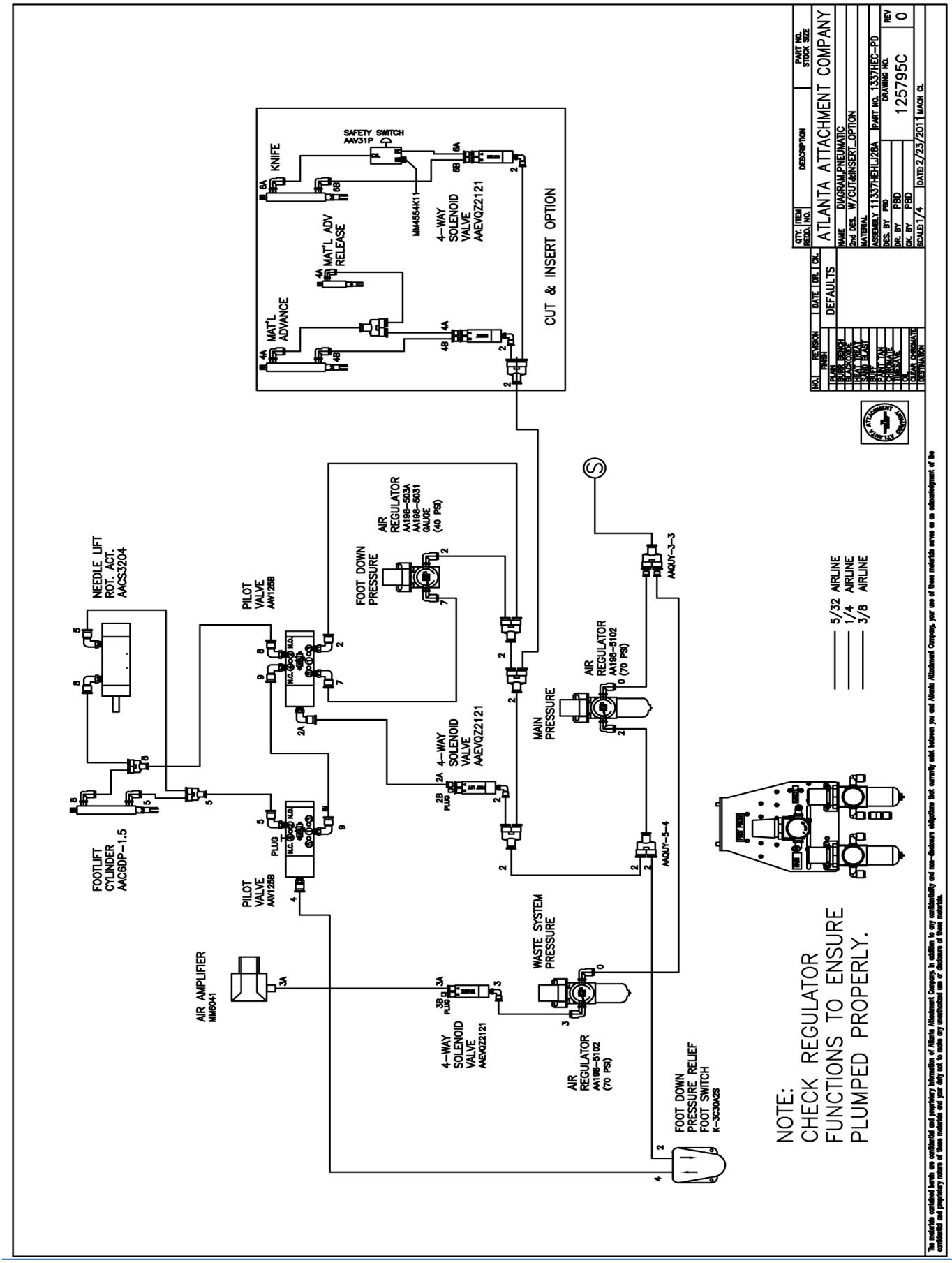


NO	QTY	PART #	DESCRIPTION
1	AR	120-25706	HAND KNOB
2	1	1317028	PULLEY, DRIVE,18T,3/8P
3	AR	SS7111810TP	SCREW,11/64-40X18MM
4	AR	SS8151150TP	15/64-28 X 10.5MM SET SC

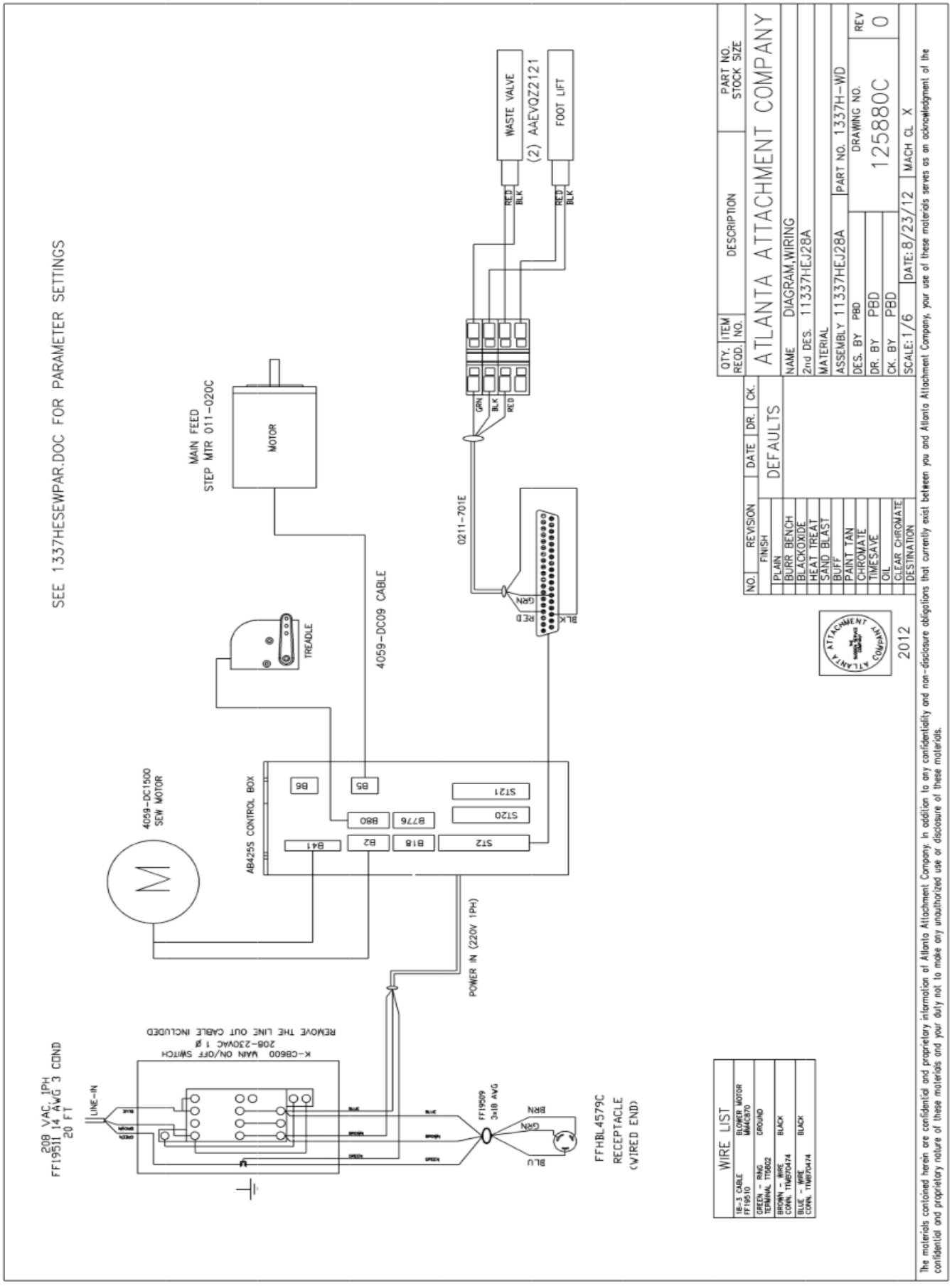
1337H-PD Pneumatic Diagram



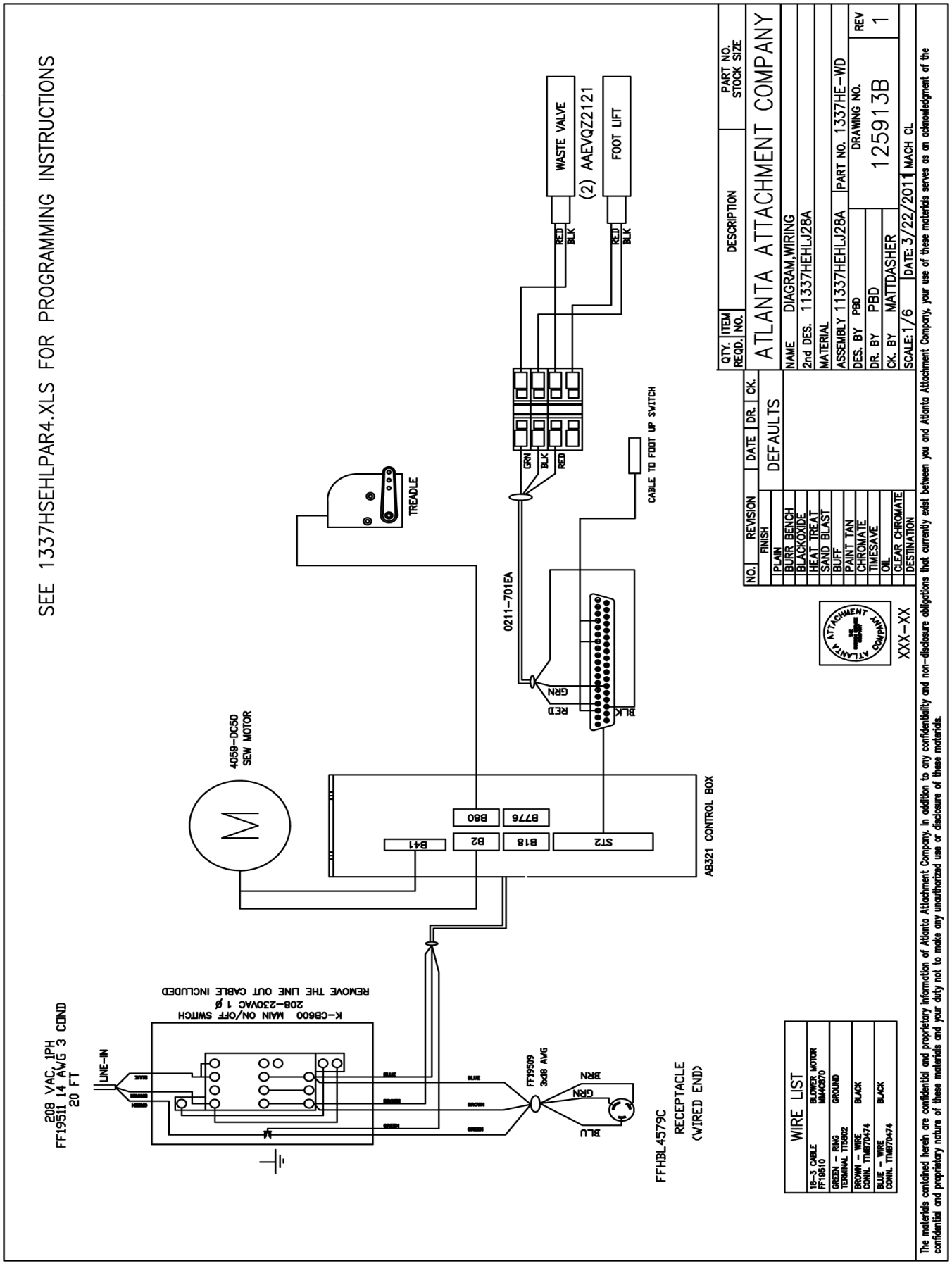
1337HEC-PD Pneumatic Diagram



1337H-WD Wiring Diagram



1337HE-WD Wiring 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 período 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 se reserva el derecho de exigir el retorno de cada pieza defectuosa con un formulario de reclamo de garantía.
- AAC va, según su criterio, a reparar o reemplazar las máquinas o piezas defectuosas devueltas a AAC.
- AAC se 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 cambiada o modificada y no está sujeto a cualquier otra garantía implicada por otro agente o distribuida 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 hayan 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 hayan sido manufacturados por AAC, son garantizados por un período 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 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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