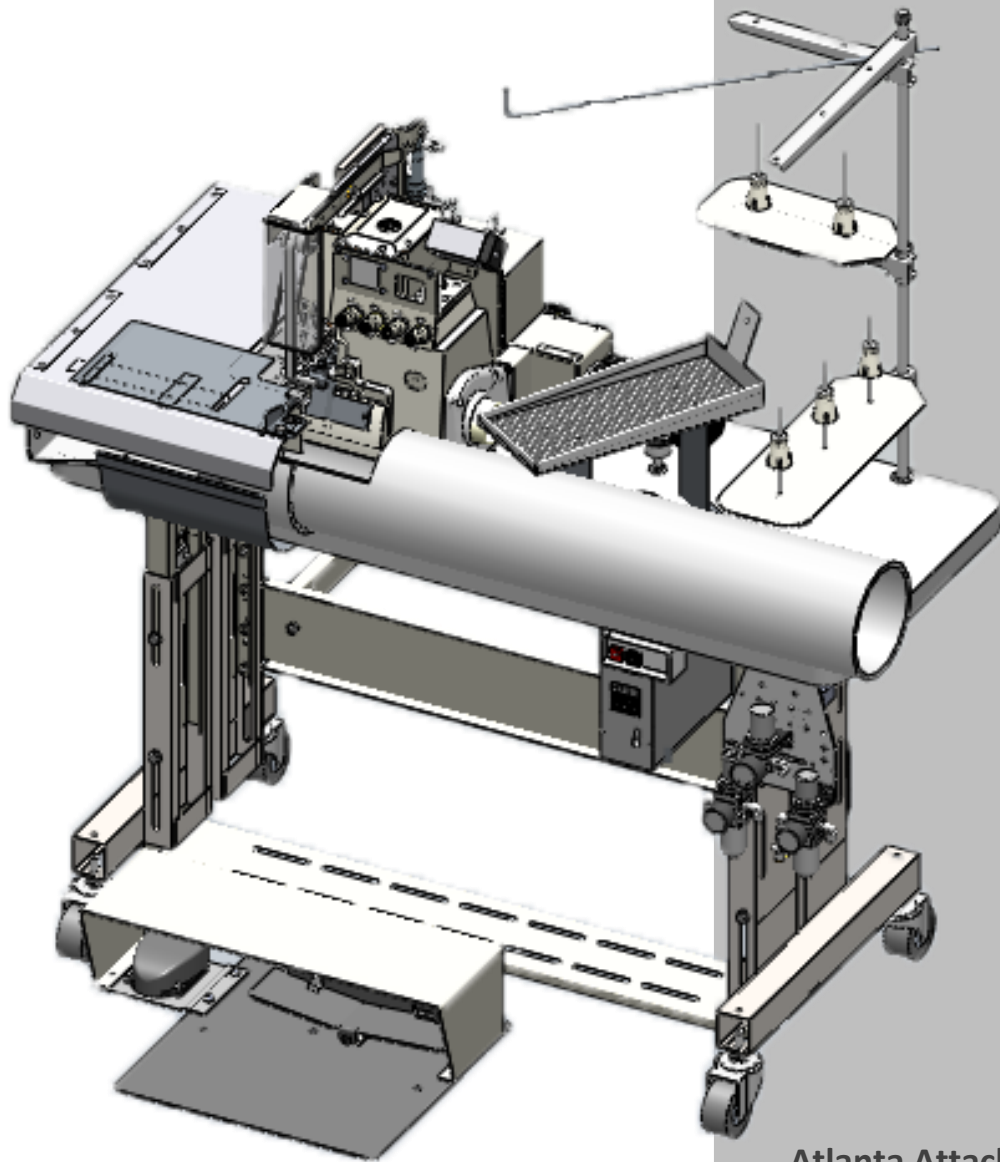




Model **1337HEH**

Revision 3.3 Updated Jan 14, 2014

Technical Manual & Parts Lists



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ATLANTA ATTACHMENT COMPANY, INC.

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IMPORTANT
It is important to read and understand the information contained within this manual before attempting to operate the machine. Atlanta Attachment Co., Inc. shall not be held liable for damage resulting from misuse of the information presented within, and reserves the right to change the information contained within, without prior notification.

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Important Safety Instruction



This part of the Instruction Material is provided for the safe use of your equipment. It contains important information to help work safely with the unit and describes the dangers inherent in machinery. Some of these dangers are obvious, while others are less evident.

Mandatory Information

All persons operating and/or working on the 1337HEHLJ28C Panel Flanger should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

- The Instruction Material comprises:
- Safety information
- Operator Instructions
- Electrical and Pneumatic diagrams

And may also include;

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

Intended Use

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

Exclusion of Misuse



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

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

Liability

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

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

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

The Instruction Material should be supplemented by instructions, including supervisory and notification duties with due regard for special operational features, such as the organization of work, work sequences, the personnel deployed, etc.

The personnel's awareness of the dangers and compliance with the safety regulations should be checked at irregular intervals.

Choice and Qualification of Personnel

Ensure that work on the machine is only carried out by reliable persons who have been appropriately trained for such work - either within the company, by our field staff or at our office - and who have not only been duly appointed and authorized, but are also fully familiar with the local regulations. Work on the machine should only be carried out by skilled personnel, under the management and supervision of a duly qualified engineer.

This not only applies when the machine is used for production, but also for special work associated with its operation (start-up and maintenance), especially when it concerns work on the hydraulic or electrical systems, as well as on the software/serial bus system.

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines



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

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

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

Damage

If any changes capable of impairing safety are observed in the machine or its mode of operation, such as malfunctions, faults or changes in the machine or tools, appropriate steps must be taken immediately, the machine switched off and a proper lockout tagout procedure followed. The machine should be examined for obvious damage and defects at least once per shift. Damage found shall be immediately remedied by a duly authorized person before resuming operation of machine.

The machine should only be operated when in perfect working order and when all protective mechanisms and safety equipment, such as detachable protective mechanisms, emergency STOP systems, etc. are in place and operational.

Faults or Errors

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

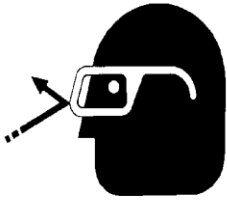
Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.

Clothing, Jewelry, Protective Equipment

Long loose hair, loose-fitting clothes, gloves and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

A clear working area without any obstructions whatsoever is essential for safe operation of the machine. The floor should be level and clean, without any waste.

The workplace should be well lit, either by the general lighting or by local lights.

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

The following fire extinguishers may be used:

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

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

A qualified person should be consulted to repair the damage after a fire.

Electrical Power Supply



Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.

In practice, this may mean that the technician, electrician and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.

Energy sources (electrical/pneumatic/hydraulic, etc.) for the equipment shall be turned off or disconnected and the switches locked or labeled with a warning tag. It is the responsibility of the employer to establish control procedures. Follow lockout/tagout procedures before, setup and/or any service or maintenance work is performed, including lubrication, cleaning or clearance of jams.

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

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.
- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

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

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.

All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.

Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.

Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.

Protect against unauthorized access.

Ensure that the machine and accessories are set up in a stable position.

Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Local Regulations

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

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.

Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.

Retighten all screw connections that have to be loosened for the maintenance and repair work. Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

The activities and intervals specified in the Instruction Manual for carrying out adjustments, maintenance and inspections must be observed and parts replaced as specified.

All hydraulic and pneumatic lines should be examined for leaks, loose connections, rubbing and damage whenever the machine is serviced. Any defects found must be remedied immediately.

Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard. Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control.

When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

Repair

Replacement Parts

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

Repair, Electrical

The power supply must be switched off (master switch off) and secured so that it cannot be switched on again inadvertently before starting any work on live parts.

Those parts of the machine and plant on which inspection, maintenance or repair work is to be carried out must be isolated from the power supply, if specified. The isolated parts must first be checked to determine that they are truly de-energized before being grounded and short-circuited. Adjacent live parts must also be isolated.

The protective measures implemented (e.g. grounding resistance) must be tested before restarting the machine after all assembly or repair work on electric parts.

Signal generators (limit switches) and other electrical parts on the safety mechanisms must not be removed or bypassed. Only use original fuses or circuit overloads with the specified current rating. The machine must be switched off immediately if a fault develops in the electrical power supply.

The electrical equipment of our machines must be checked at regular intervals and any defects found must be remedied immediately.

If it is necessary to carry out work on live parts, a second person should be on hand to operate the emergency OFF switch or master switch with voltage release in the event of an emergency. The working area should be cordoned off and marked by a warning sign. Only use electrically insulated tools.

Ventilation/Hazardous Gases

It is the end users responsibility to ensure adequate ventilation is provided to exhaust any and all noxious or hazardous gases that may be present in the working environment.

Hydraulic and Pneumatic Systems

Work on hydraulic or pneumatic equipment shall only be carried out by persons with training, knowledge and experience of hydraulic systems. Pressure lines shall be depressurized before starting any repair work.

General Liability

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

Starting Machine Movements

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

A Word to the End User

The end user has sole responsibility to enforce the use of safety procedures and guards on the machine. Any other safety devices or procedures due to local regulations should be should be retrofitted in accordance to these regulations and/or the EC Directive on the safety of machines.

Operator's position must always be readily accessible. Escape routes must always be kept clear and safety areas should be identified.

Safety Precautions

Safety should be a constant concern for everyone. Always be careful when working with this equipment. While normal safety precautions were taken in the design and manufacture of this equipment, there are some potential safety hazards.

Everyone involved with the operation and maintenance of this equipment should read and follow the instructions in this manual.

Operate the equipment only as stated in this manual. Incorrect use could cause damage to the equipment or personal injury.

It is the owner's responsibility to make certain that the operator reads and understands this manual before operating this equipment. It is also the owner's responsibility to make certain that the operator is a qualified and physically able individual, properly trained in the operation of this equipment.

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

- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS maintain a safe distance from people when operating.
- 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.

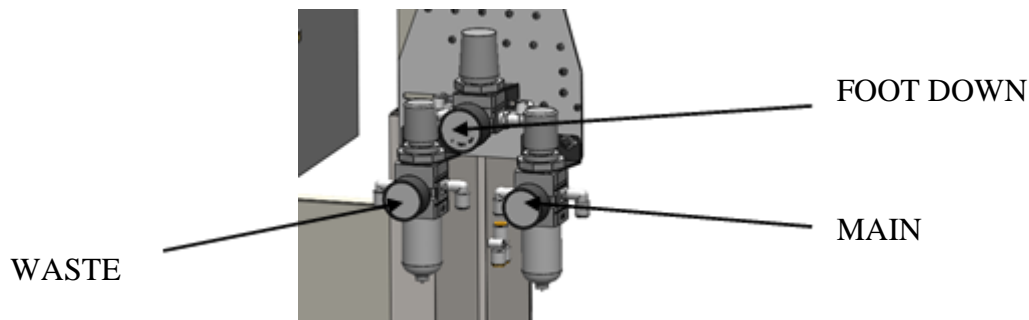
Installation & Setup

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

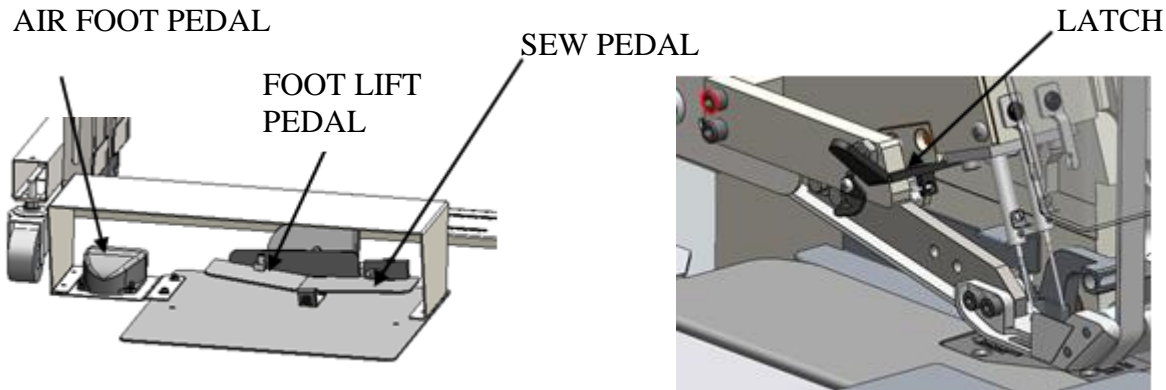
Air Regulators:

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):

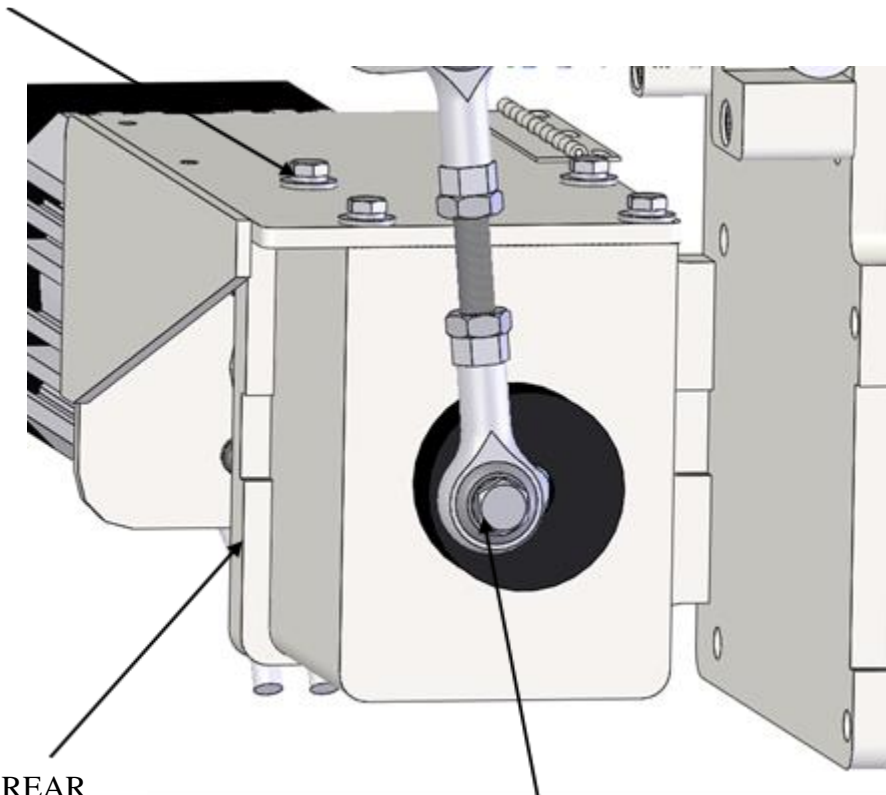
The right pedal on the treadle assembly is the SEW PEDAL. It controls the sewing speed.

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.

TOP SCREWS

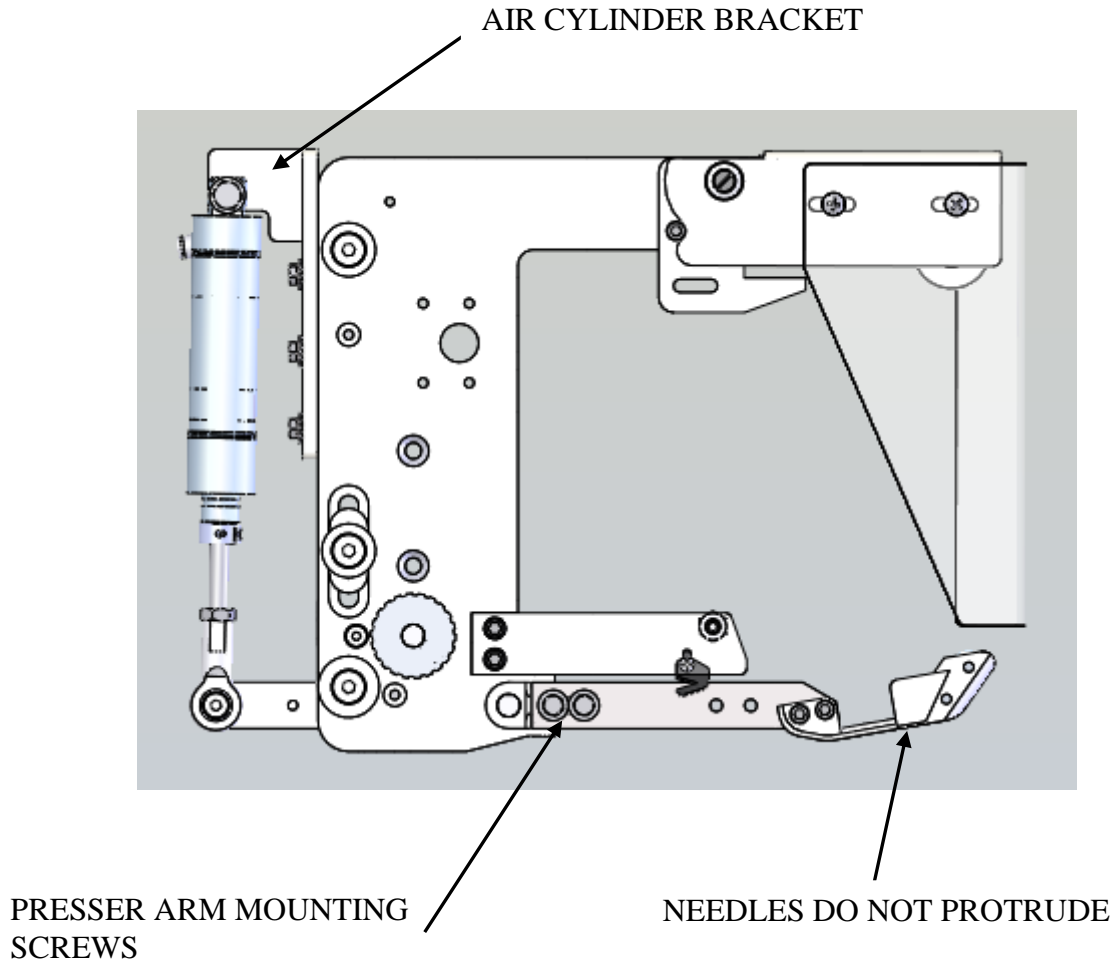


LOOSEN REAR
SCREWS TO
ADJUST BELT

ECCENTRIC DRIVE SCREW
TO REAR POSITION @
NEEDLE TOP DEAD CENTER

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

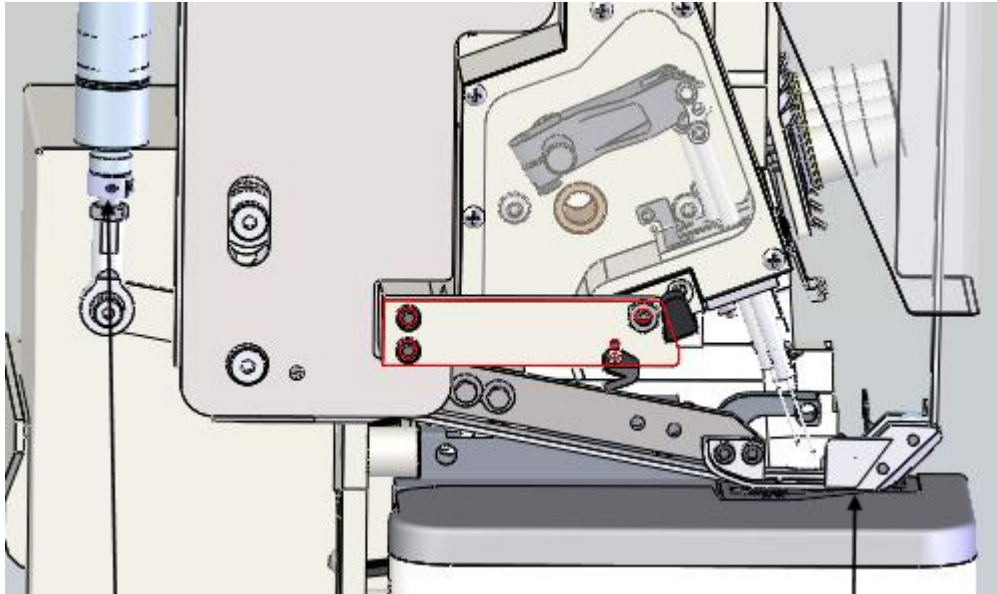


Adjusting the Presser Foot Position

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.

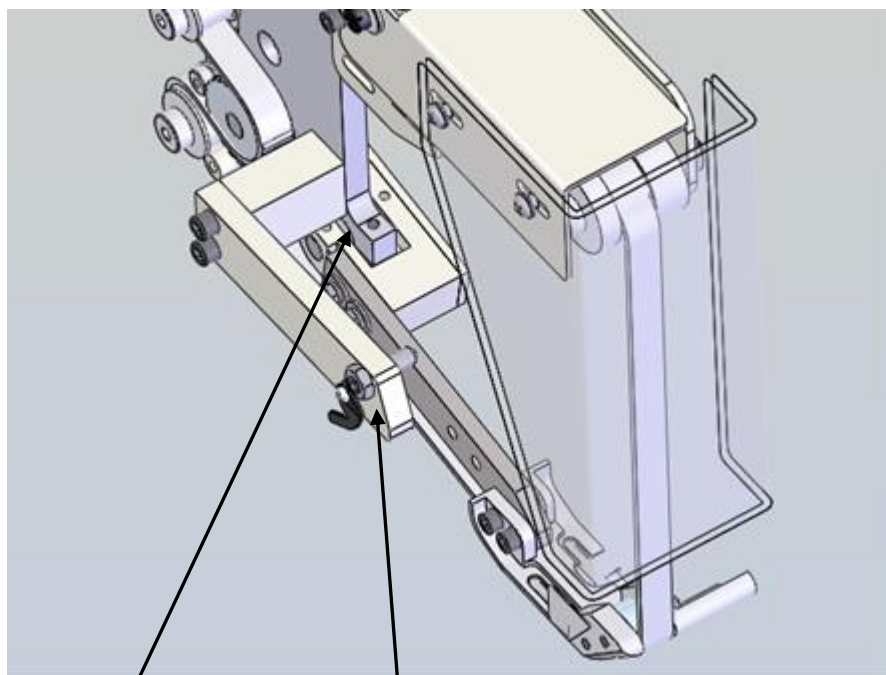


ADJUSTING COLLAR

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.

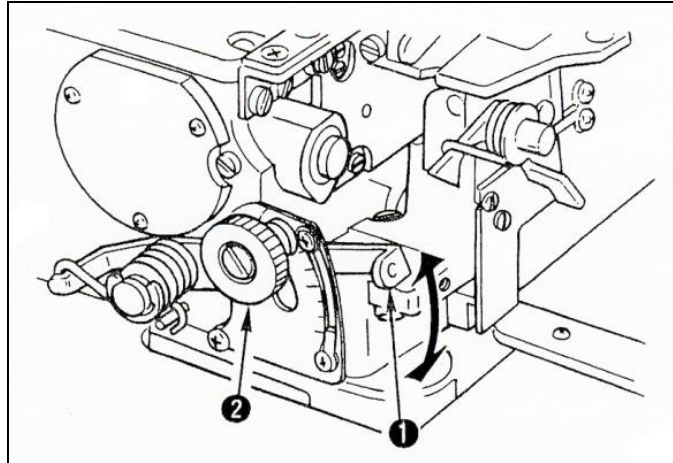


ADJUSTING SET SCREW

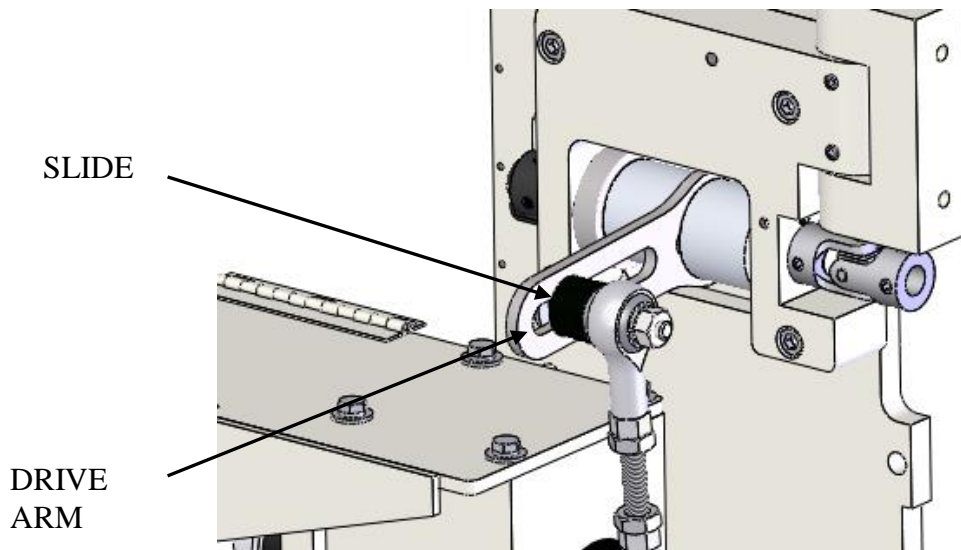
ADJUSTING BUSHING

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.

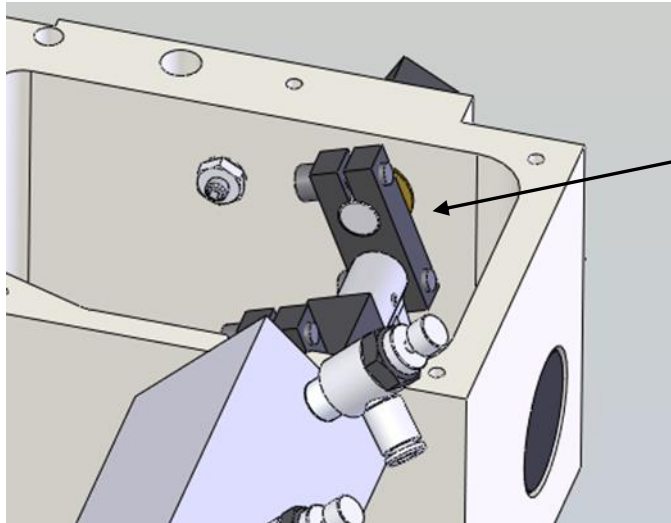


1. To adjust the top belt feed drive, move the slide in or out in the slot on the drive arm on the back of the machine to match the new stitch length. Moving the slide out shortens the feed and moving it in lengthens the feed.



Adjusting the Needle Lifting Link

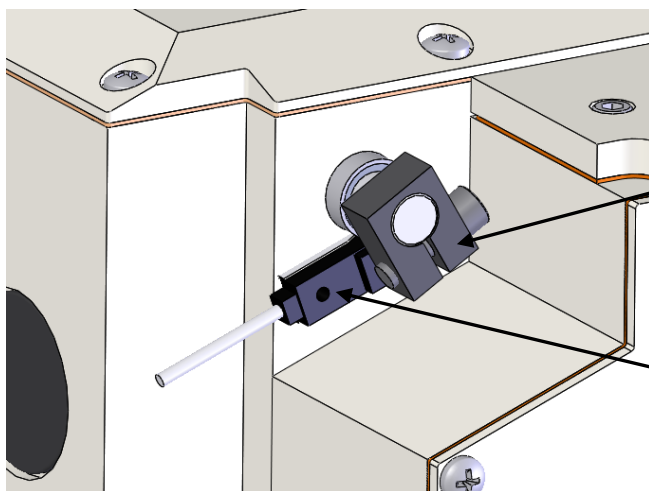
When the rotary actuator is all the way clockwise (viewed from shaft end) at the foot down position the Needle Lift Link should be tilted 20 deg. to the rear.



NEEDLE LIFT LINK TILTED
20 DEG. TO 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 half way and have about one mm clearance from the sensor.

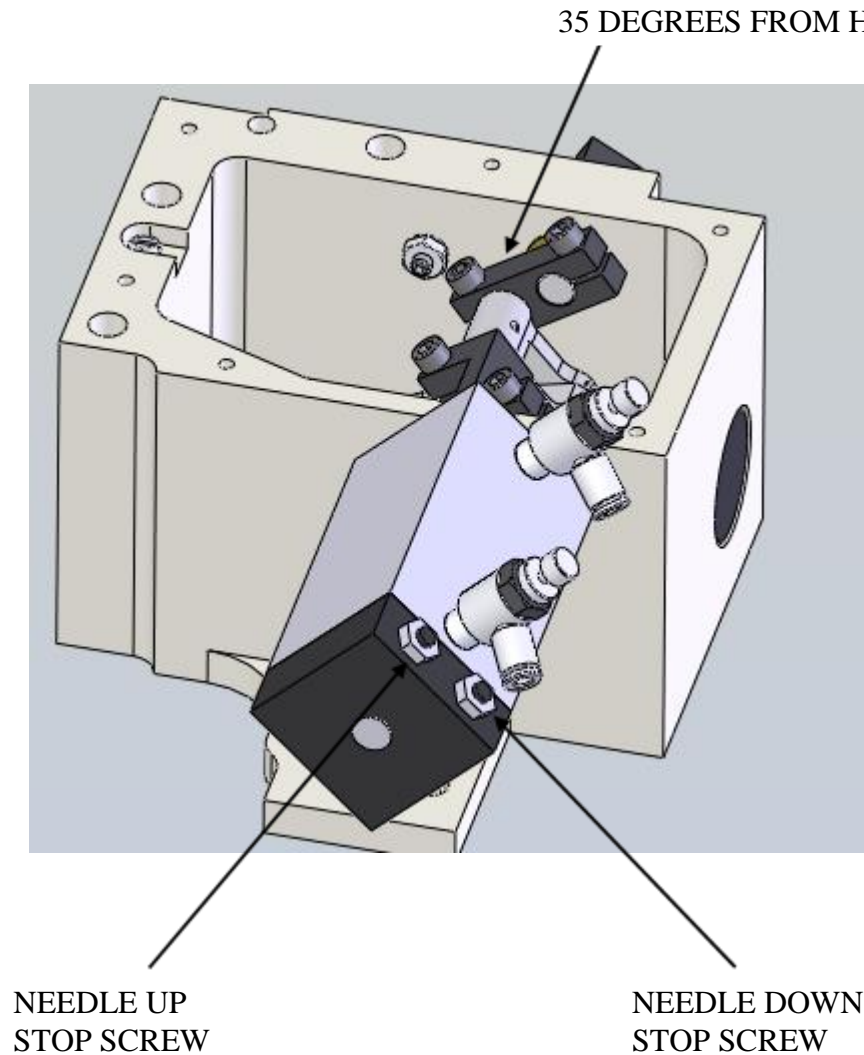


SENSOR
BLOCK

SENSOR

Adjusting the Rotary Actuator for Needle Lifted Position

When the rotary actuator is all the way counter-clockwise (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.

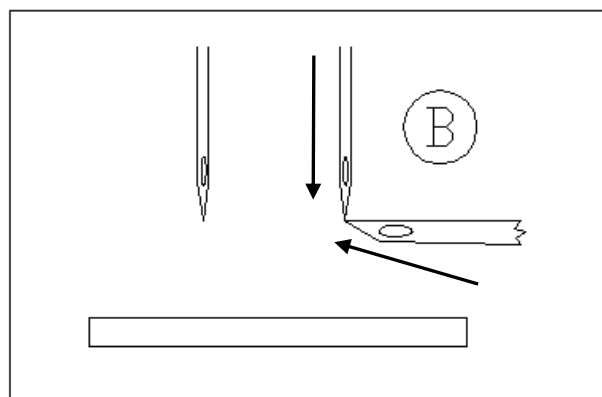
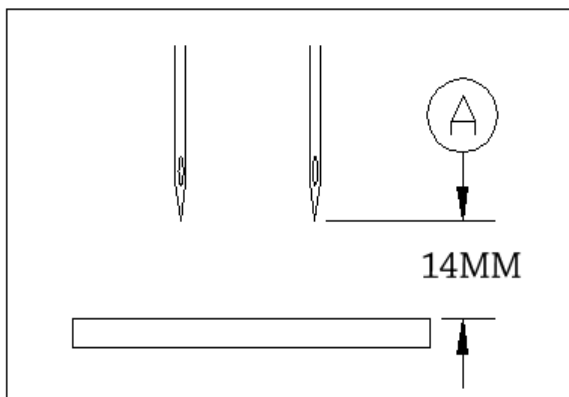
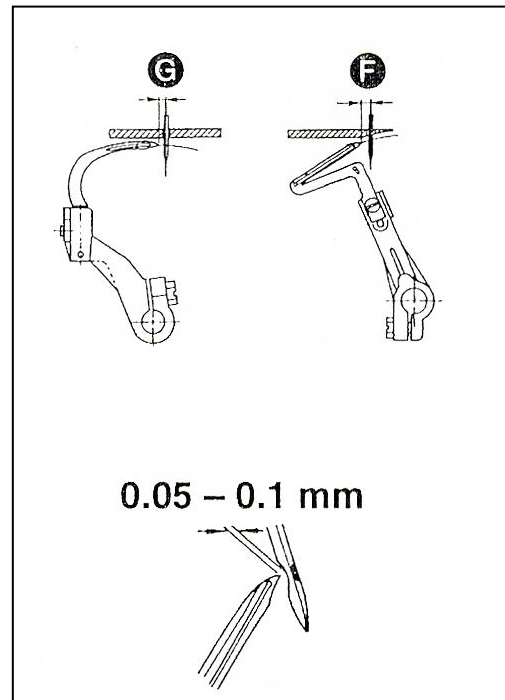
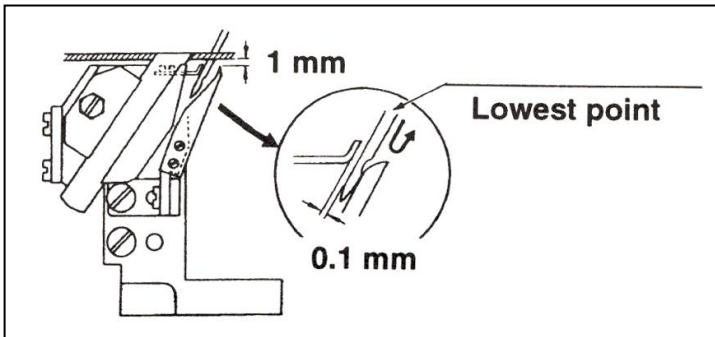


Adjusting the Timing of Loopers and the Needle Guards

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 making adjustments. Be sure that all screws are tightened and that none of the components come in contact with each other before restoring power to the machine.

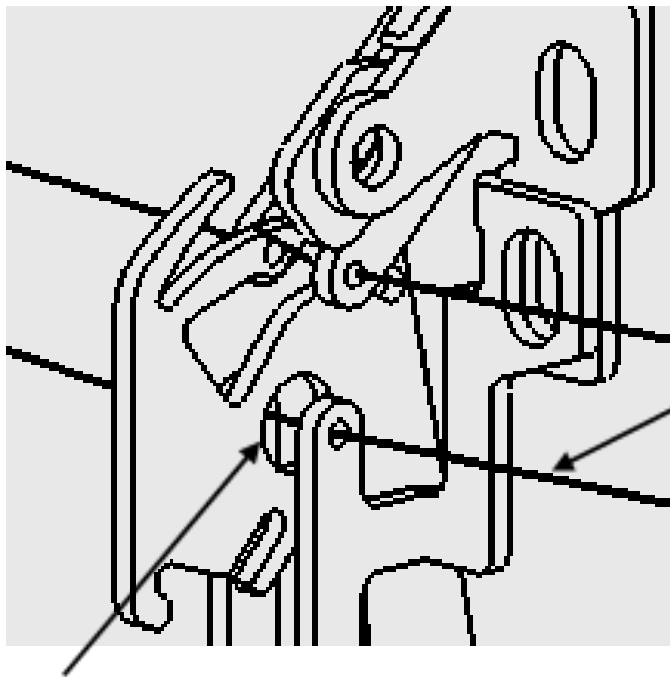
14mm
F=3mm
G=2mm



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.



SAFETY STITCH THREAD

LARGE HOLE IN THE TAKE-UP

1337HSEHLPAR4 Parameter Settings

Perform a master reset before programming, see below

PARAMETER	RANGE	VALUE	DESCRIPTION
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
026	0-7	1	Treadle function. 0=oldstyle 1=new
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 closed 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]

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, Ndl 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, Ndl 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.

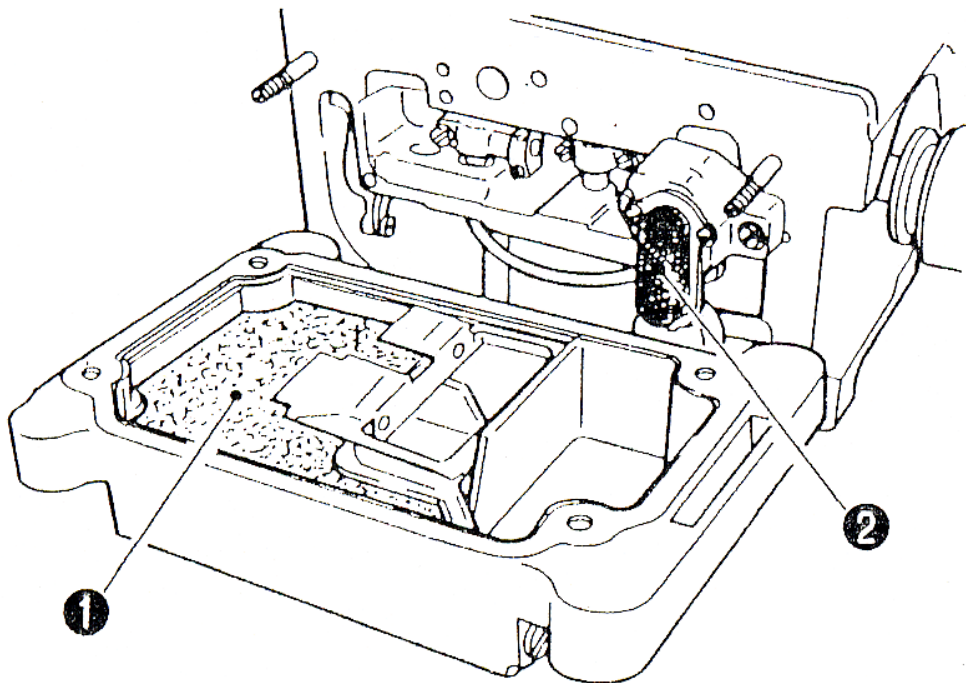
Perform the following procedures to properly maintain the machine.

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

SP1337HHJ28A SPARE PARTS SET

PART #	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
123-83501	LOOPER,UPPER	1
123-84202	LOOPER,LOWER	1
123-84400	LOOPER,CHAIN,MOG-371	1
1325-12	ROD END,BALL BEARING	1
1337001	GUARD,FRONT NEEDLE	1
1337002	GUARD,REAR NEEDLE	1
1337335	NEEDLE BAR & 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,.375B	2
BBB-66	BEARING,NEEDLE,.375B	2
BBB-66	BEARING,NEEDLE,.375B	2
BB1L005	BEARING,BALL,1/2ID	1
GG210L050	BELT,GEAR,3/8P, 1/2W,56TH	1
GG414XL050UK	BELT,GEAR,KEVKAR	1
M2J28-006	FEED DOG	1
M3J28-003	PLATE,THROAT,3/4GA	1
RRLE030CD7	SPRING,EXT,.030 X 2	1
RRLE045D1	SPRING,EXT .045X.38X	1
RRLE055DE9	SPRING,EXT .055X.44X	1
SNTVX722-140GB	NEEDLE,SYS TVX7,22/1	100
SS8080310TP	SCREW,SET,SLOTTED	2
SSM22735	SCREW,SHOULDER	4
SSSS80012	SCREW,SET,6-32 X 3/16	6
SSSS90012	SCREW,SET,8-32 X 3/16	6

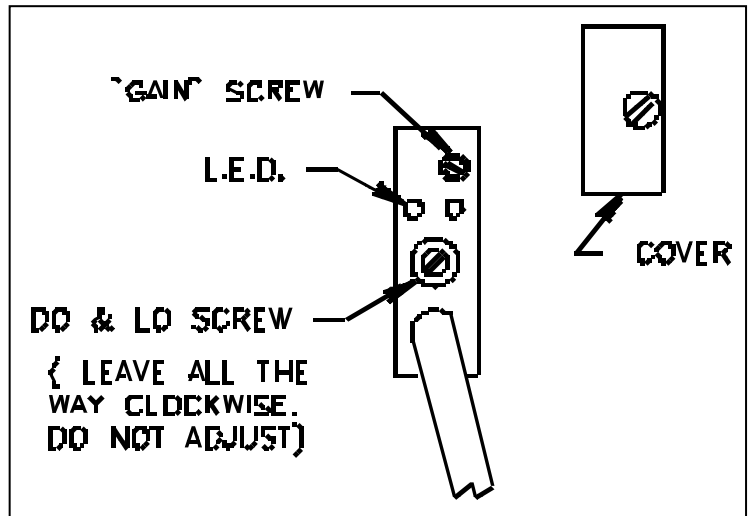
Contact AAC's sales department to order replacement parts.

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 counter-clockwise until the red LED indicator is off. Then turn the “GAIN” screw clockwise until the LED indicator comes on. Then turn the “GAIN” screw one full turn clockwise. The LED indicator should be blinking slowly. Cover the eye so that the sensor cannot see the reflective tape and the LED should go off.



Reflective Tape Maintenance

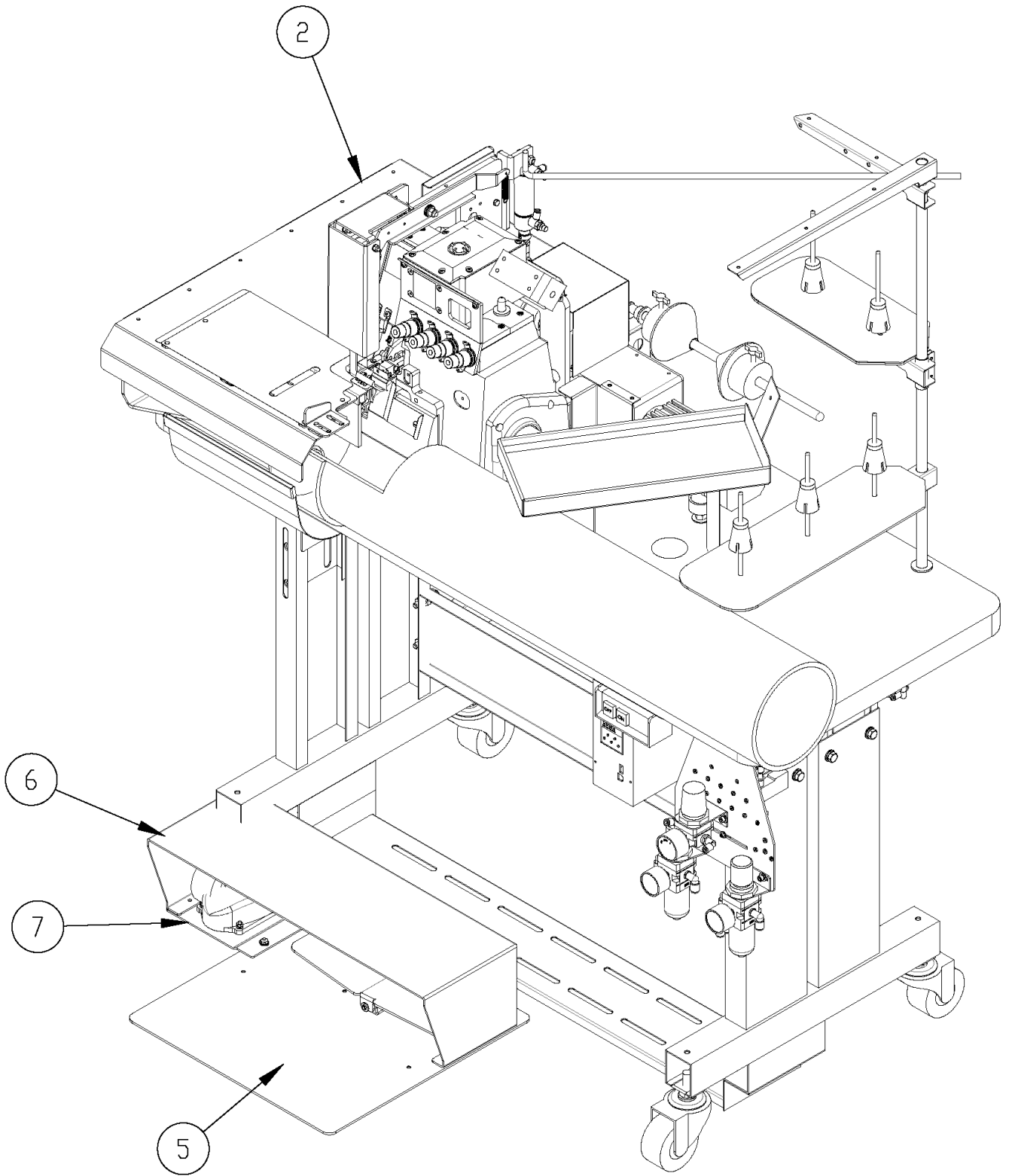
- Use a soft cloth for cleaning.
- Do not use chemicals or abrasives to clean it.
- Avoid any contact with oils and liquids.
- Do not touch the tape with bare fingers.
- If tape is dirty or opaque, the eye may not function correctly.

Assembly Drawings & Parts Lists

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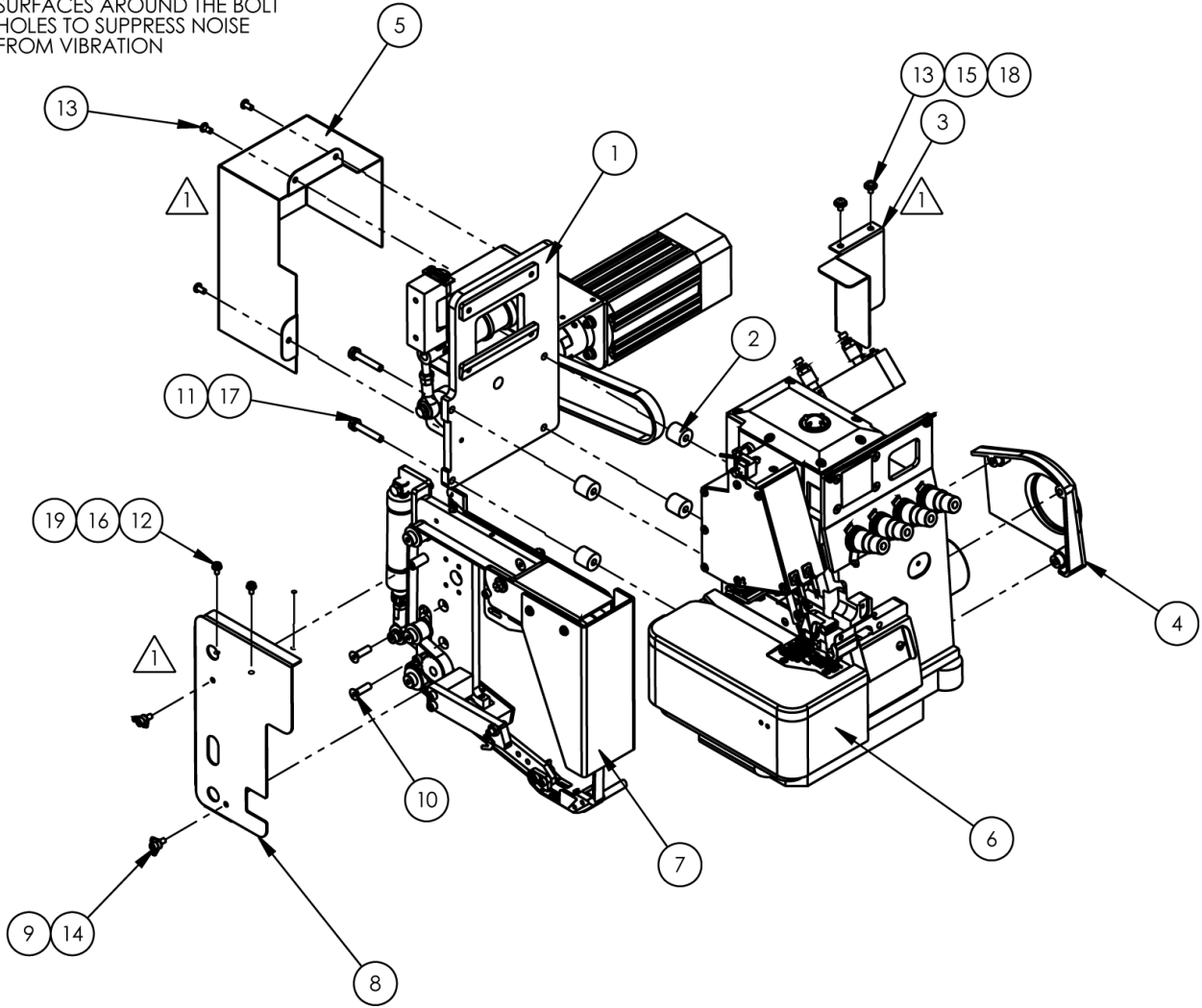


11337HEHLJ28C Panel Flanger, High Lift

AAC Drawing Number 9004045 Rev 1

NO.	QTY	PART#	DESCRIPTION
2	1	1337H-1002	CONSOLE ASSY,HL PANEL FLN
3	AR	1337HE-WD	DIAGRAM, WIRING
4	AR	1337HEC-PD	DIAGRAM, PNEUMATIC
5	1	4059-FP301D	FOOT PEDAL ASSY,EFKA
6	1	1337224	COVER,FOOT PEDAL,UPPER
7	1	1337225	BRKT,PEDAL
8	2	NNK8-32	NUT,KEP,8-32
9	2	NNK10-32	KEP NUT, 10-32
10	2	SSFC90048	8-32 X 3/4 FLAT AL CAP
11	2	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
12	2	WWF8	WASHER, FLAT, #8
13	2	WWFS10	WASHER, FLAT, #10, SAE

1 ADD MM130-10A7 TAPE TO ALL SURFACES AROUND THE BOLT HOLES TO SUPPRESS NOISE FROM VIBRATION



11337HSEHLJ28C Sew Head

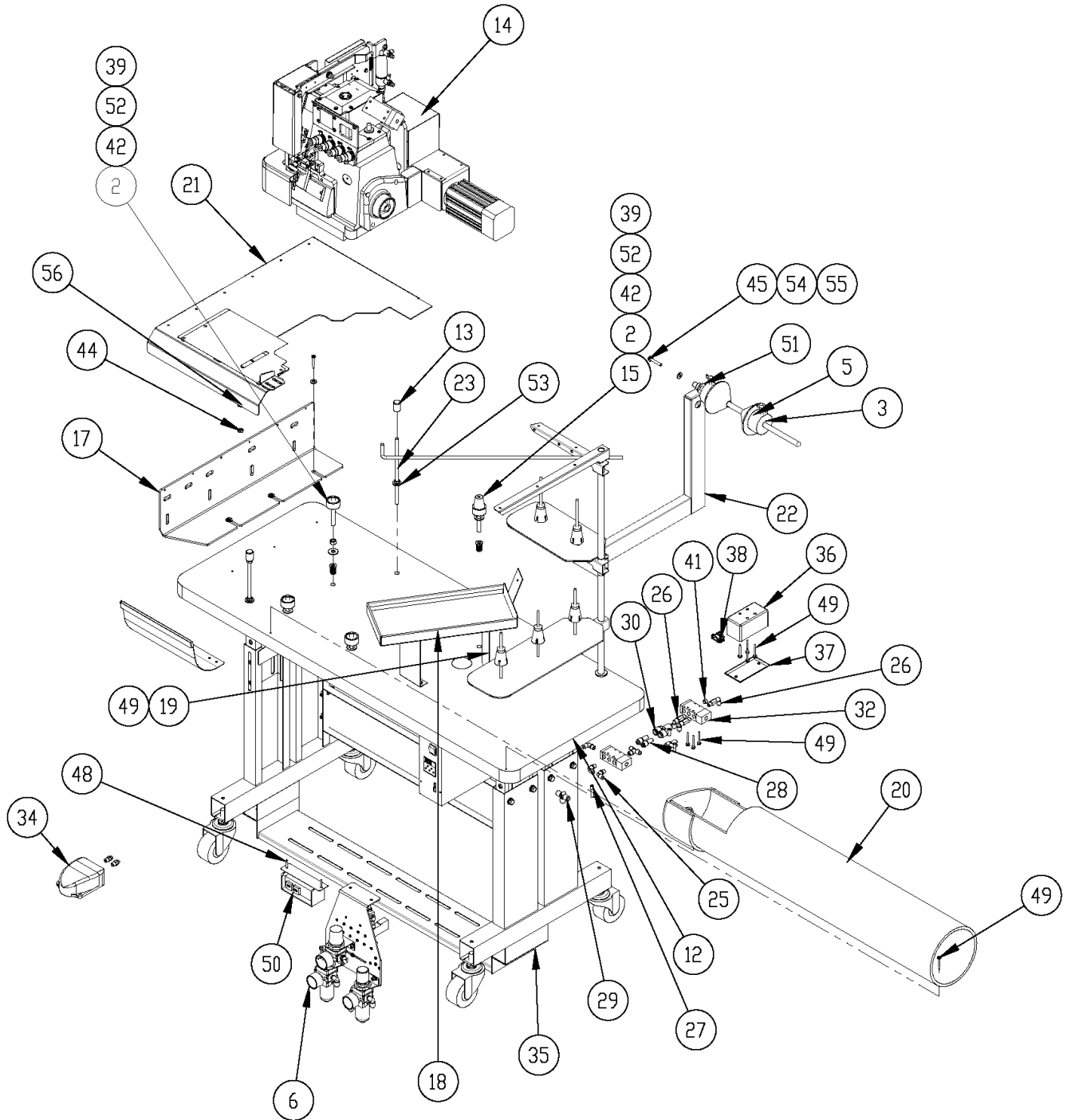
AAC Drawing Number 9004042 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1337304	DRIVE ASSY,HEAVY DUTY
2	4	1337306	SPACER,3/4OD,1/4ID,3/4L
3	1	1337369	GUARD, BELT, REAR
4	1	1337370	BELT COVER, JUKI 6916
5	1	1337414	GUARD,BELT DRIVE
6	1	1337460	SEWING HEAD ASSEMBLY
7	1	1337466	BELT FEED ASSY
8	1	1337482	BELT COVER
9	3	NNW10-32	#10-32 WING NUT
10	2	SSFC01056	1/4-20 X 7/8 FLAT CAP
11	4	SSHC01096	1/4-20 X 1-1/2 HHCS
12	2	SSPP90024	8-32X3/8 PAN PHLPS
13	5	SSPP98024	10-32 X 3/8 PAN HD PHILIP
14	2	SSSC98032	10-32X1/2, SOC CAP
15	2	WWF10	WASHER, FLAT, #10, COM
16	2	WWF8	WASHER, FLAT, #8
17	4	WWL1/4	WASHER,LOCK,1/4
18	2	WWL10	WASHER,LOCK,#10,S/S
19	2	WWL8	WASHER,LOCK,#8

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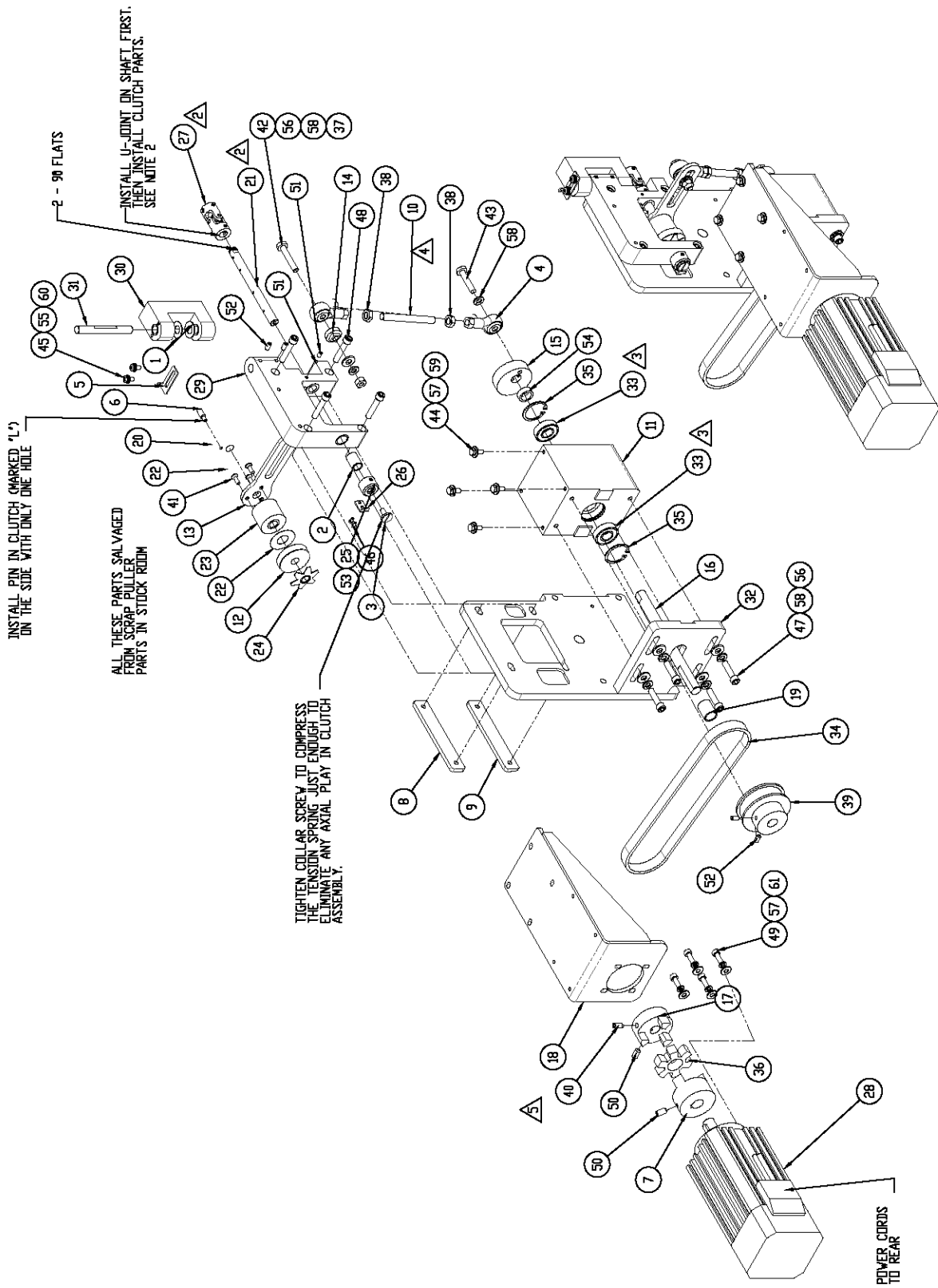
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1337H-1002 Console Assembly

AAC Drawing Number 9003084 Rev 3

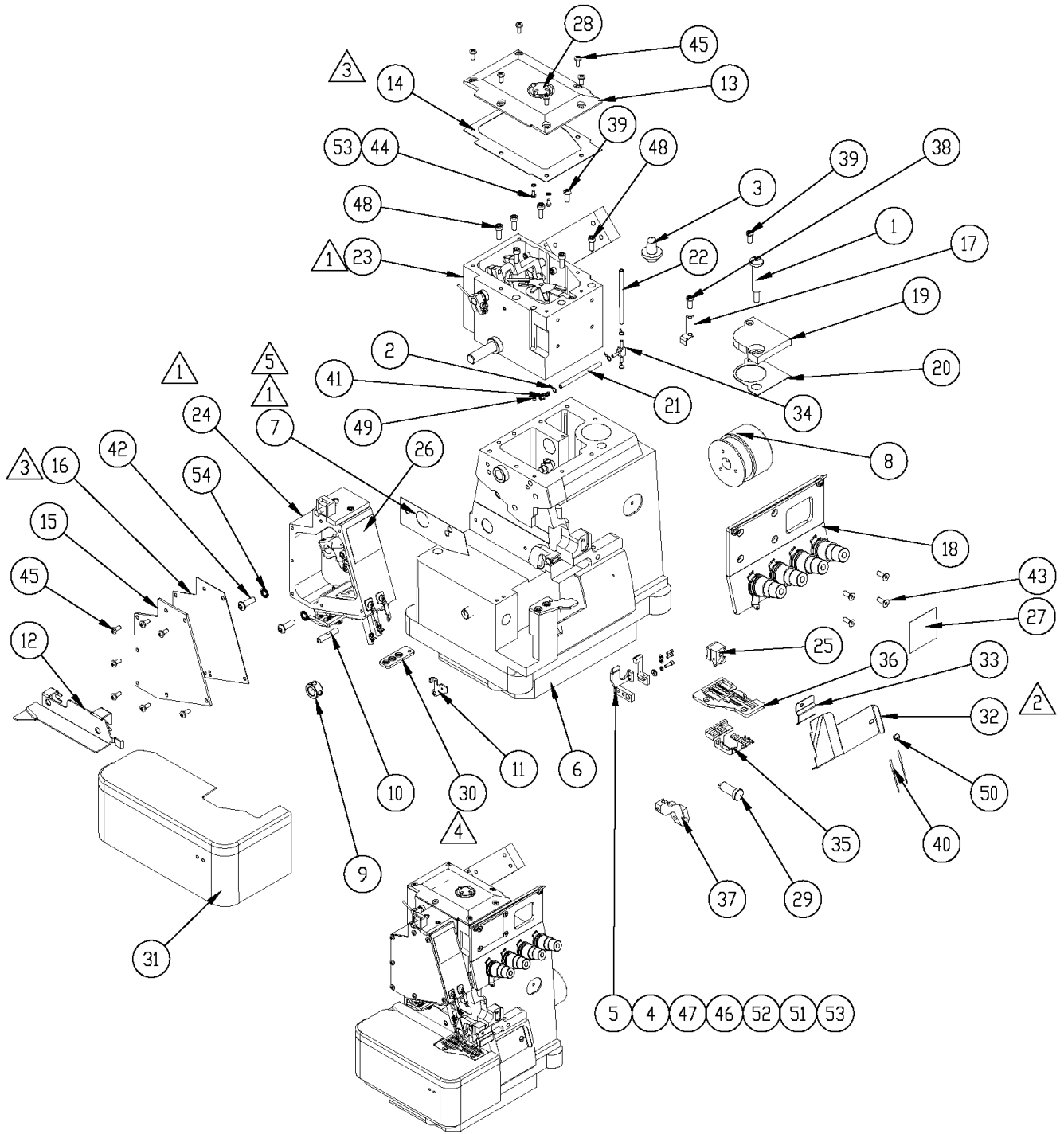
NO.	QTY	PART#	DESCRIPTION	NO.	QTY	PART#	DESCRIPTION
1	1	0211-701EA	CABLE,I/O,FL, SAFETY	30	1	AAQUY-3-3	QUICK UNION Y,3/8X3/8
2	5	0411-128B	ISOLATOR MOUNT ASSY	31	2	AAQUY-5-5	QUICK UNION Y, 5/32
3	2	787-4A-032	CONE BEARING ASSY.	32	2	AAV125B	PILOT VALVE
4	1	1278-8201	ROD,THREAD GUIDE	33	1	FFHBL4579C	RECEPTACLE,3 POLE,3W
5	1	1335-816	ROD,SS, 1/2 X 15.0 L	34	1	K-3C30A2S	FOOT AIR SWITCH
6	1	1337-1500A	PNEUMATIC PANEL, 3	35	1	K-4DS	HD T LEG ADJ STAND
7	*AR	1337-LAB2	LABELS	36	1	K-230	BOX,METAL, 2X4X2
8	1	1337HE-WD	DIAGRAM, WIRING	37	1	K-231	COVER, 2X4
9	1	1337HEC-PD	DIAGRAM, PNEUMATIC	38	2	K-235	CONNECTOR,ROMEX,1/2"
10	1	1959-112	2 POS THREAD PLATE	39	5	K-340I-3/8	INSERT,LEG,1" LONG
11	1	1959-161	3 POS THREAD PLATE	40	1	MM132-1496	PLUG 1 X 2
12	1	4048-11337HSE	TABLE TOP 20X48,6900	41	1	MM4554K11	PLUG, 1/8" PIPE
13	2	11200A	BUMPER 5/16-24	42	5	NNH3/8-16	NUT,HEX,3/8-16
14	1	11337HSEHLJ28C	SEW HEAD, FLANGER	43	1	NNHM8X1.25	M8 X 1.25 HEX NUT
15	1	51295A	ISOLATOR, MACHINE	44	6	NNJ5/16-24	NUT,JAM,5/16-24
16	1	1337140	MATERIAL DEFLECTOR	45	1	SSH01096	1/4-20 X 1-1/2 HHCS
17	1	1337177	PLATE, CONNECTING	46	2	SSHCM8X20	SCREW,HEX CAP
18	1	1337178	TOOL TRAY,1X6X14	47	1	SSZH#6096	SCREW,SHT.METAL HEX 6
19	2	1337180	MOUNT, TOOL TRAY	48	4	SSZH#10064	SCREW,SHT.METAL HEX 10
20	1	1337189	WASTE CHUTE TUBE	49	19	SSZH#10096	SCREW,SHT.METAL HEX 1
21	1	1337375	FLANG GUIDE ASBLY	50	1	T75	ON/OFF 1PH SWITCH BOX
22	1	1959335	ROLL HOLDER ARM	51	1	UUFF707-05	BEARING,BRONZE,.502ID
23	2	4400025	THREADED ROD, 5/16	52	5	WWF3/8	WASHER,FLAT,3/8
24	2	AAQMC-5-8	QU. MALE CONN 5/32	53	10	WWF5/16	WASHER,FLAT,5/16
25	5	AAQME-5-8	QUICK MALE ELBOW	54	4	WWF51/4	WASHER,FLAT,SAE,1/4
26	3	AAQMEL-5-8	QUICK MALE ELBOW	55	1	WWL1/4	WASHER,LOCK,1/4
27	1	AAQPP-07	QUICK PLUG 1/4	56	7	WWL5/16	WASHER, LOCK, 5/16
28	2	AAQPR-3-4	QUICK REDUCER 3/8-1/4	57	1	WWLM8	M8 LOCK WASHER
29	2	AAQUT-4-4	QUICK UNION 1/ 4X1/4				



1337304 Heavy Duty Drive Assembly

AAC Drawing Number 1337304 Rev 1

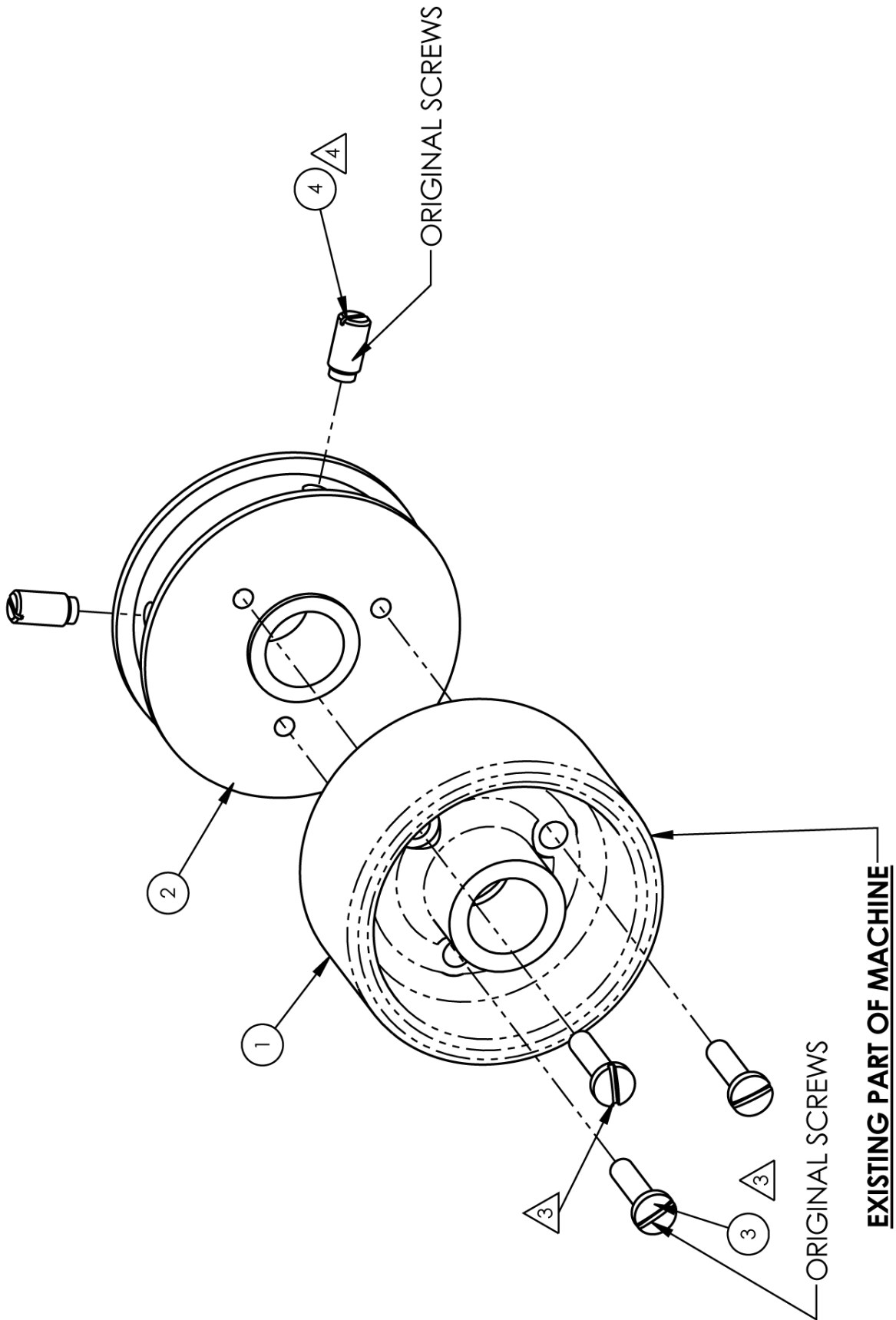
NO.	QTY	PART#	DESCRIPTION	NO.	QTY	PART	DESCRIPTION
1	2	3517	WASHER,THRUST,BRONZE	32	1	49018D	BRACKET,WELDMENT
2	AR	65421	CLUTCH TENSION SLEEVE	33	2	BB1L005	BEARING,BALL,.500D
3	AR	110097	SCREW,M5-0.8X12	34	1	GG210L050	BELT, 3/8P, 56T, 1/2W
4	2	1325-12	DRIVE ARM CONN W/BEARING	35	2	MM98409A221	RETAINING RING,INT
5	1	1325-39C	SPRING CLIP	36	1	MML075B	SPIDER,BUNA-N
6	AR	180005	SCREW,M4-0.7X6	37	1	NNH1/4-20	NUT,HEX,1/4-20
7	1	1337191	COUPLING,14MM	38	2	NNJ5/16-24	NUT,JAM,5/16-24
8	1	1337264	PLATE, NUT, 2 PL,3.63 CT	39	1	PP18LB050M	PULLEY,GEAR,3/8P
9	1	1337265	PLATE,NUT,1/4-20,ANGLED	40	AR	SS8151150TP	15/64-28 X 10.5MM
10	1	1337266	THREADED ROD,5/16-24 THD	41	3	SSFCM4X12	SCREW,FLAT ALLEN
11	1	1337269	BEARING BLOCK	42	1	SSH01096	1/4-20 X 1-1/2 HHCS
12	1	1337270	SPACER,CLUTCH BEARING	43	1	SSH05080	1/4-28 X 1-1/4 HEX CAP
13	1	1337271	CRANK ARM,CLUTCH	44	4	SSH098032	10-32X1/2 HEX HD
14	1	1337272	STUD,TIE ROD MOUNT	45	2	SSPP90024	8-32X3/8 PAN PHLPS
15	1	1337273	ECCENTRIC HUB	46	AR	SSPSM3X5	M3-0.5 x 5MM
16	1	1337274	DRIVE SHAFT	47	4	SSSC01064	1/4-20 X 1 SOC CAP
17	1	1337279	COUPLING,.500 BORE	48	4	SSSC01080	1/4-20X1-1/4, SOC CAP
18	1	1337286	MOTOR MTG BRACKET	49	4	SSSCM5X16	SCREW,SOC CAP,M5
19	1	1337346	SPACER, DRIVE SHAFT	50	4	SSSS01032	SCREW, SET, 1/4-20
20	1	1337347	CLUTCH SLEEVE,MOD.,LEFT	51	1	SSSS90016	#8-32 X 1/4 SET SCREW
21	1	3501270A	CLUTCH DRIVING SHAFT	52	4	SSSS98024	10-32X 3/8 SOC SET SC
22	AR	3501272	THRUST PLATE	53	AR	SSSSM5X5	M5 X 5 SET SC,CUP PT
23	AR	3501276	CLUTCH SLEEVE (RIGHT)	54	1	UUAA618-16	BEARING,BRONZE,.504
24	AR	3501282	CLUTCH TENSION SPRING	55	2	WWF8	WASHER, FLAT, #8
25	AR	3501283	ADJUSTING COLLAR	56	5	WWFS1/4	WASHER,FLAT,SAE,1/4
26	AR	3501284	ADJUSTING SCREW STAY	57	8	WWFS10	WASHER, FLAT, #10
27	1	3524-02M	3/8" X 10MM U JOINT	58	6	WWL1/4	WASHER,LOCK,1/4
28	1	4059-DC50	MOTOR, LOW SPD, HIGH	59	4	WWL10	WASHER,LOCK,#10
29	1	49012A	BLOCK,TRANSFER,ASSY	60	2	WWL8	WASHER,LOCK,#8
30	1	49014B	BLOCK,PIVOT,ASSY	61	4	WWLM5	M5 LOCK WASHER
31	1	49015A	PIVOT SHAFT				



1337460 Sewing Head Assembly

AAC Drawing Number 1337460 Rev 0

NO.	QTY	PART#	DESCRIPTION	NO.	QTY	PART	DESCRIPTION
1	*AR	13104500	OIL DRAIN SCREW	28	*AR	22924708	OIL SIGHT GLASS
2	4	13142609	OIL TUBE HOLDER	29	1	49001	STUD,PUSH BUTTON,MOD
3	*AR	13143300	OIL GAUGE	30	1	49005	REAR THROAT PLATE MT.
4	1	1337001	FRONT NEEDLE GUARD	31	1	49021B	PLATE,CLOTH MOD.
5	1	1337002	REAR NEEDLE GUARD	32	1	49065	CHIP DEFLECTOR
6	1	1337255	CASTING, MODIFIED, 6916G	33	1	49066	TRIM DEFLECTOR
7	1	1337257	SHIM, NDL DRIVE ASBLY	34	1	7267	TEE CONNECTOR,BARB,3MM
8	1	1337278	HAND KNOB PULLEY ASSY	35	1	M2J28-006	MAIN FEED DOG
9	1	1337310	THRUST COLLAR, MODIFIED	36	1	M3J28-003	"PLATE, THROAT, 3/4 GA
10	1	1337341	OIL INJECTOR	37	1	JUKI,11337HSJ28A"	LOOPER HOLDER,3/4 GA.
11	1	1337373	THREAD GUIDE, MODIFIED	38	*AR	M5J28-001	M5X8 PAN SLOTTED
12	1	1337374	SIDE COVER, MODIFIED	39	*AR	SM4050855SP	M5X12 PAN SLOTTED
13	1	1337389	COVER, LIFT LINK BOX	40	10	SM4051255SP	NEEDLE,SIZE 140/22
14	1	1337391	GASKET, LIFT LINK BOX	41	1	SNTVX722-140GB	FITTING,OIL JET
15	1	1337392	COVER,NEEDLE BAR DRIVE	42	2	SQ1110451MZ	SCREW,BUTTON CAP,1/4
16	1	1337393	GASKET,NEEDLE BAR DRIVE	43	4	SSBC01048	10-32 X 1/2 FLAT ALLEN CAP
17	1	1337397	OIL GUAGE GUIDE	44	2	SSFC98032	4-40 X 1/4 PAN HD PHILLIP
18	1	1337403	PLATE,THREAD TENS. MOUNT	45	13	SSPP70016	8-32X3/8 PAN PHLPS
19	1	1337404	COVER,OIL FILTER	46	2	SSPP90024	2-56 X 1/4 SOCKET CAP
20	1	1337405	GASKET MOD,OIL FILTER	47	1	SSSC50016	4-40 X 3/8 SOCKET CAP
21	1	1337411	TUBE, OIL, 2.62" LONG	48	6	SSSC70024	SCREW,SOC CAP,M5-0.8 X 14
22	1	1337412	TUBE, OIL, 4.88" LONG	49	1	SSSCM5X14	8-32X1/8 SET SCREW
23	1	1337465	NEEDLE LIFT ASBLY	50	1	SSSS90008	6-40 X 3/16 TRUSS HEAD
24	1	1337470	NEEDLE BAR DRIVE ASBLY	51	2	SSTS85012	WASHER, FLAT, #2
25	1	1337486	MODIFICATION, KNIFE SUP.	52	1	WWF2	WASHER, FLAT, #4
26	AR	1337-LAB1	LABEL, S/S THREADING	53	3	WWF4	WASHER,LOCK,#4
27	1AR	1337-LAB4	LABEL, NEEDLE SIZE	54	2	WWL4	WASHER,INTERNAL TOOTH



1337278 Hand Knob Pulley 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

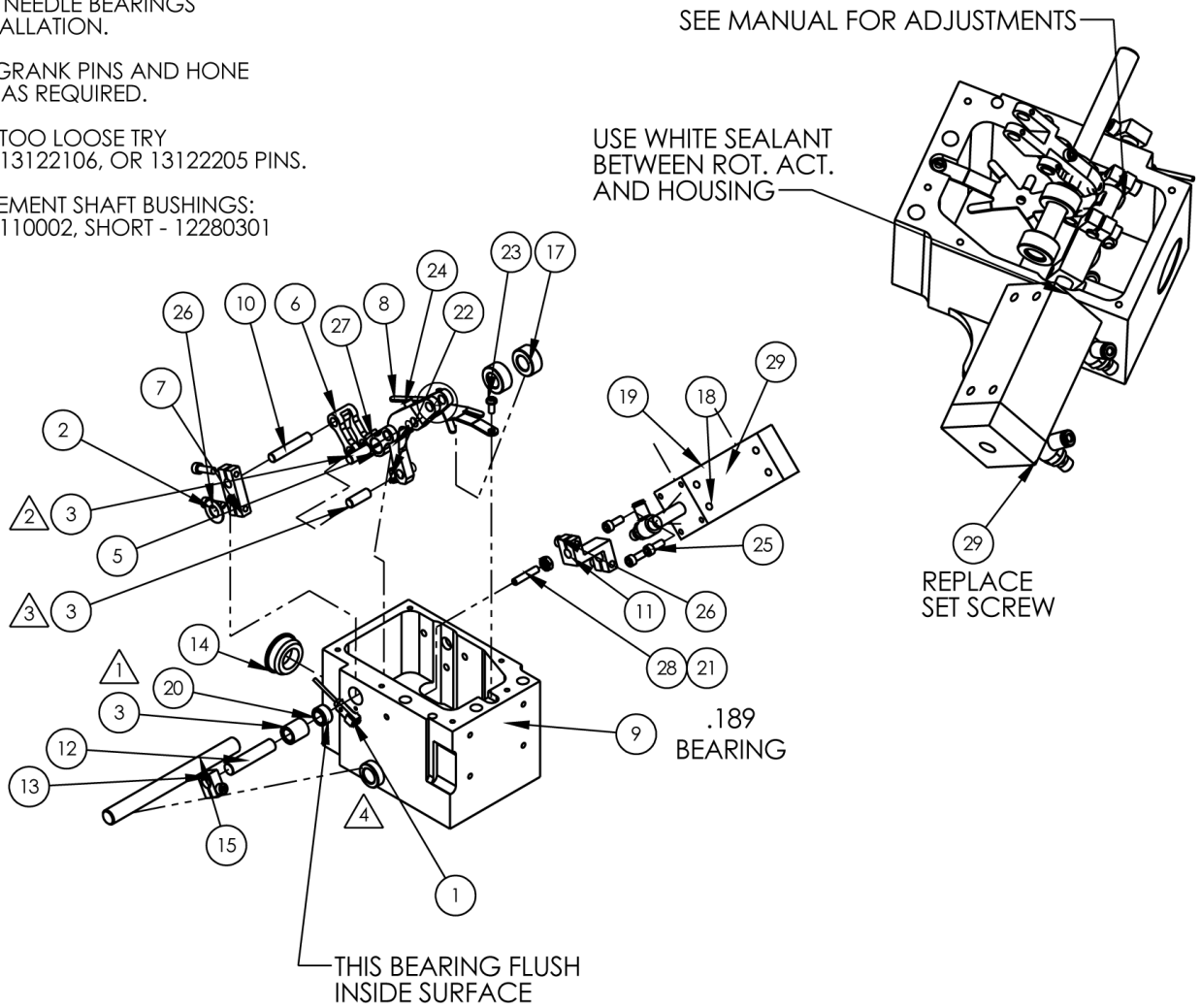
NOTES:

1. GREASE NEEDLE BEARINGS AFTER INSTALLATION.

2. TEST FIT GRANK PINS AND HONE BRACKETS AS REQUIRED.

3. IF PIN IS TOO LOOSE TRY 13122007, 13122106, OR 13122205 PINS.

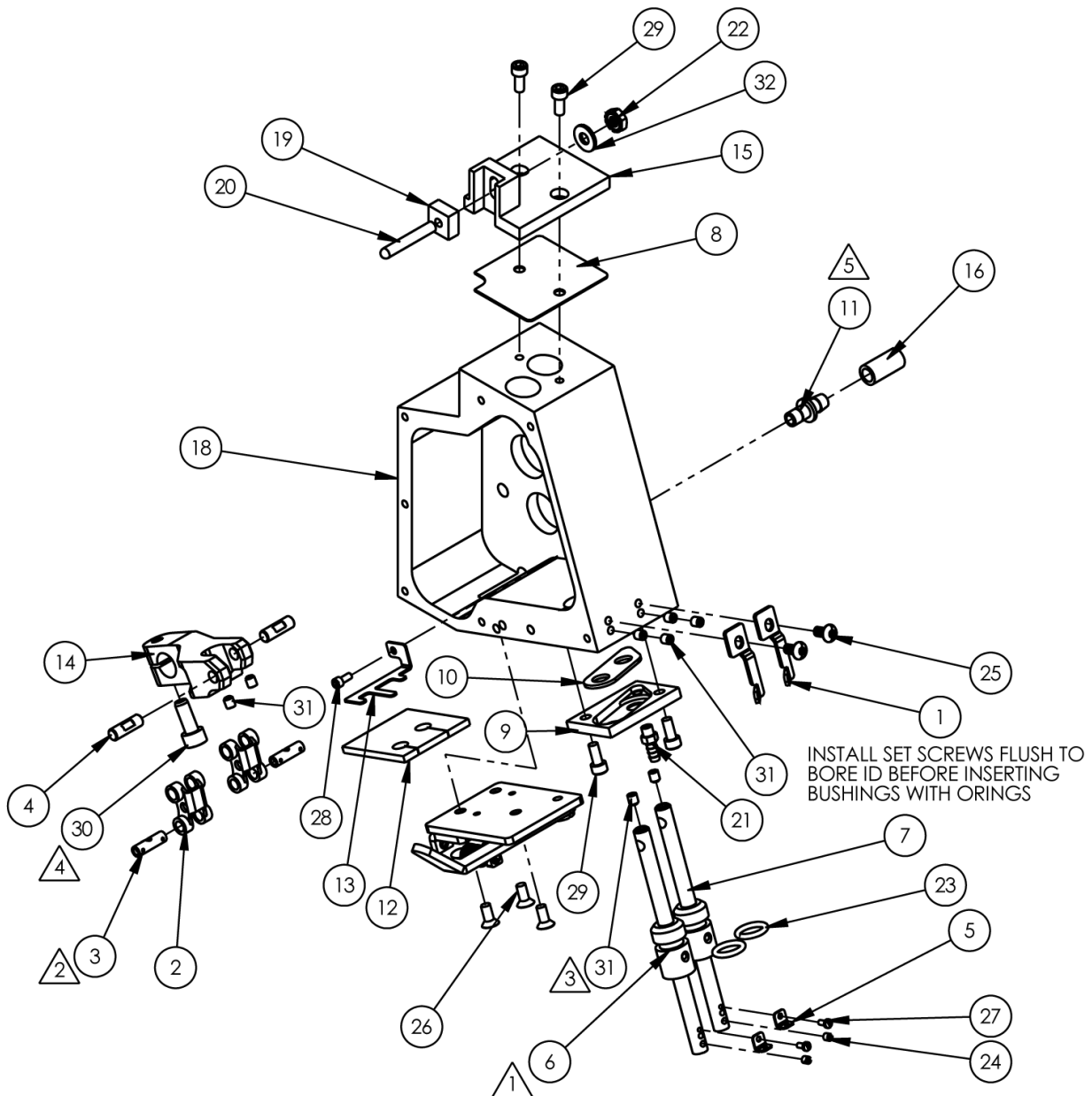
4. REPLACEMENT SHAFT BUSHINGS: LONG - 13110002, SHORT - 12280301



1337465 Needle Lift Assembly

AAC Drawing Number 1337465 Rev 1

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



INSTALL SET SCREWS FLUSH TO BORE ID BEFORE INSERTING BUSHINGS WITH ORINGS

USE BRASS TOOL GAUGE TO INSTALL BUSHINGS TO CORRECT DEPTH.

- NOTES:
1. COMES WITH 1337335 AS MATCHED SET
 2. TWO REQUIRED, ONE COMES WITH HEAD
 3. SOME UNITS USE 6-32 SCREWS
 4. SOME UNITS HAVE THIS SCREW ON TOP.
 5. ASSEMBLE WITH WHITE 100% SILICONE SEALANT GE281

1337470 Needle Bar Drive Assembly

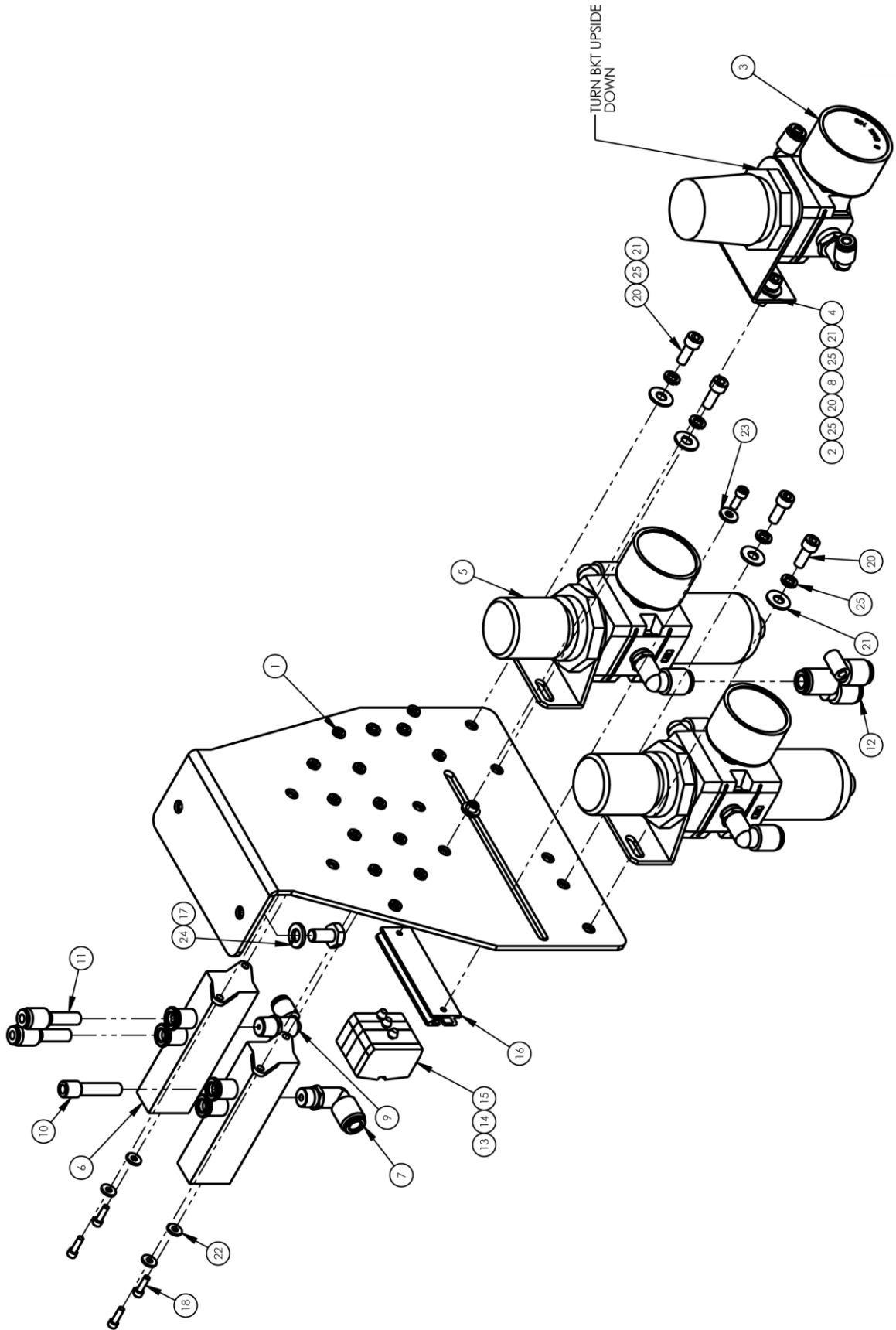
AAC Drawing Number 1337470 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	2	12372405	THREAD EYELET
2	2	13208004	NEEDLE DRIVING LINK
3	2	13209507	NEEDLE DRIVING PIN "B"
4	2	1337260	NDL DRIVE PIN, 5.5MM
5	2	1337261	NDL BAR EYELET
6	AR	1337312	NEEDLE BAR BUSHING, MOD
7	2	1337335	NEEDLE BAR, 7MM X 110MM
8	1	1337336	GASKET, TOP GUIDE
9	1	1337338	OIL GUARD, NDL BARS
10	1	1337339	OIL WICK PAD, NDL BARS
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 JOKE
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	2	R0108240100	O-RING
24	2	SS8080310TP	SCREW,SET,SLOTTED,1/8-44
25	2	SSBC90020	8-32X3/8 BUTTON CAP
26	3	SSFC90024	8-32 X 3/8 FL ALN CAP
27	2	SSPS50012	2-56 X 3/16 PAN HD SC
28	1	SSSC70016	4-40 X 1/4 SOCKET CAP
29	4	SSSC90024S	#8-32 X 3/8 SOC CAP SC
30	1	SSSCM6X15	M6X15 SOC CAP SCREW
31	8	SSSS90012	8-32 X 3/16 SOC SET SC
32	1	WWFS10	WASHER, FLAT, #10, SAE

1337466 Belt Feed Assembly

AAC Drawing Number 1337466 Rev 2

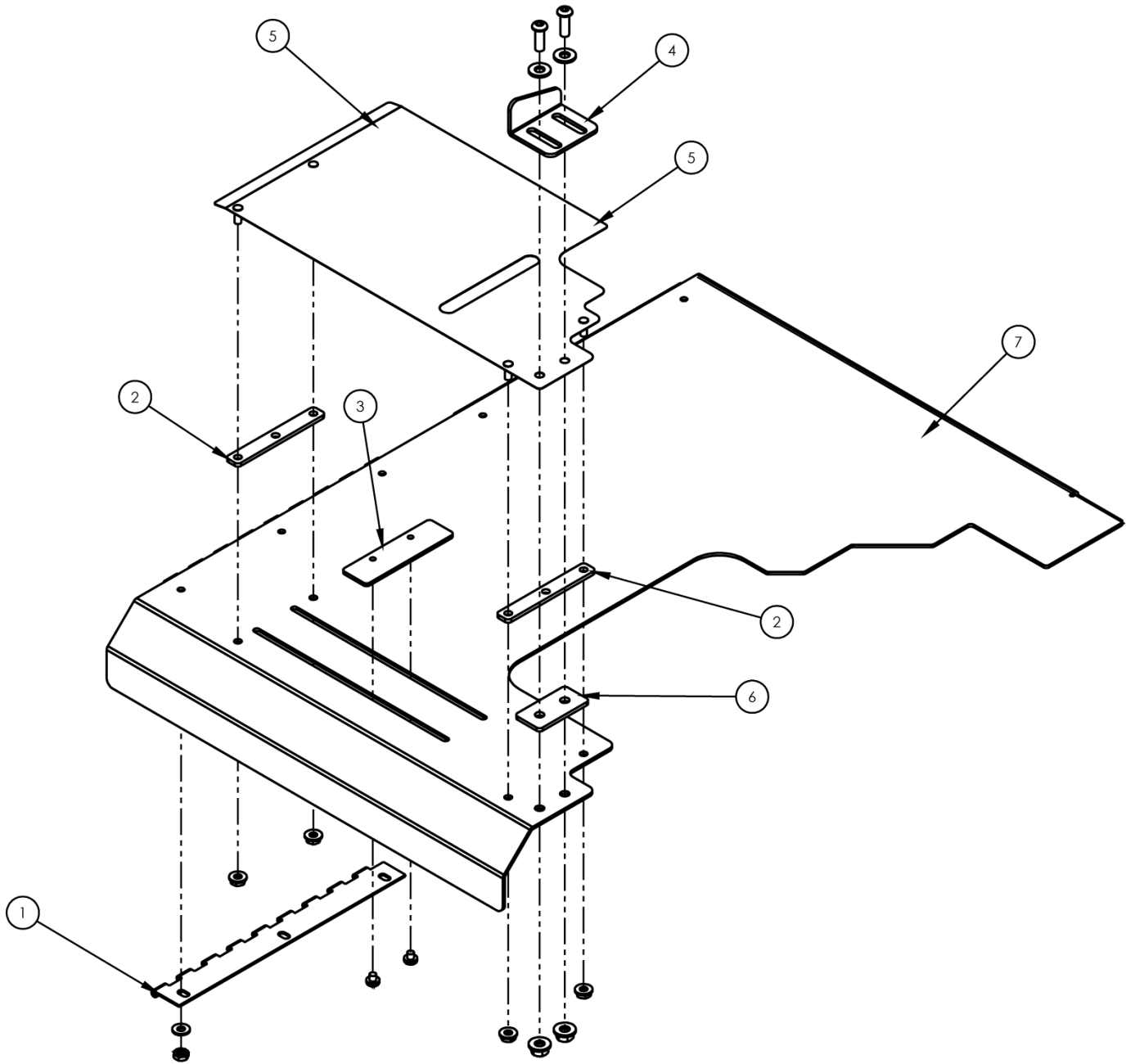
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	13116702	THREAD TRIMMER	33	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
2	1	1337297	MOUNT,MAIN,HD	34	3	NNE8-32	NUT,ELASTIC LOCK, 8-32
3	1	1337298	ARM,PRESSER,HVY DUTY	35	1	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
4	1	1337299	BLOCK,PRESSER ARM PIVOT	36	1	NNJ5/16-18	NUT,JAM,5/16-18
5	1	1337302	SHAFT,DRIVE,.375X1.75L	37	1	NNJ5/16-24	NUT,JAM,5/16-24
6	1	1337307	ARM,FOOTLIFT	38	2	NNK1/4-20	NUT,HEX,KEP,1/4-20,W/LOCK
7	1	1337320	GUARD,BELT	39	1	RRLE037D7	SPRING,EXT,.037X.375X2.0
8	1	1337325	TOP SUPPORT LATCH BKT	40	1	SSAS016012	SHOULDER BOLT, 1/4 X 3/16
9	1	1337326	BRKT,GUARD,BELT	41	1	SSAS016024	SHOULDER BOLT #10 X .375L
10	1	1337362	MOUNT,FOOTLIFT CYL	42	1	SSAS020032	SHOULDER BOLT 5/16 X 1/2L
11	1	1337467	SPACER, LATCH	43	3	SSAS024048	SHULDER BOLT 3/8 X .75L
12	1	1337468	LATCH ARM	44	1	SSAS024096	SHULDER BOLT 3/8 X 1.50L
13	1	1337483	ARM,BELT TENSION, LONG	45	1	SSFC01080	1/4-20 X 1-1/4 FLAT CAP
14	1	1342Z-201A	ROLLER,DELTRIN, TOP BELT FD	46	3	SSFC98024	#10-32 X .375 FLAT CAP
15	2	1342Z-201B	ROLLER,DELTRIN, TOP BELT FD	47	1	SSHCO1064	1/4-20 X 1 HHCS
16	1	311-3004	PULLEY,GEAR,1/5 PITCH	48	2	SSHCO98024	10-32 X 3/8 HEX CAP
17	6	3517	WASHER,THRUST,BRONZE	49	5	SSHCO98048	SCREW, HEX CAP #10-32X.75
18	1	49023A	ROLLER,FRONT	50	1	SSPP70016	4-40 X 1/4 PAN HD PHILLIP
19	1	49031	SPACER, IDLER ROLLER	51	3	SSPP90048	#8-32 X 3/4 PAN HD PHIL
20	1	49035A	PIVOT SHAFT & SLEEVE	52	2	SSSC01144	SHCS, 1/4 D X 2 1/4" L
21	2	49038A	BELT COVER SPACER	53	5	SSSC98032	10-32X1/2, SOC CAP
22	1	49049	PLATE,WASHER	54	2	SSSC98040	10-32 X 5/8 SOC CAP
23	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"	55	1	SSSC98048	10-32 X 3/4 SOC CAP
24	1	AAC6DP-1.5	CYLINDER,AIR,DA,PIVOT	56	1	SSSS05064	SET SCREW1/4-28X1
25	1	BBAW-5Z	ROD END, SPHERICAL .5/16ID	57	6	WWF8	WASHER, FLAT, #8
26	2	BBNTA411	BEARING,THRUST,.250B	58	2	WWFS1/4	WASHER,FLAT,SAE,1/4
27	4	BBTRA411	WASHER,THRUST,STEEL	59	7	WWFS10	WASHER, FLAT, #10, SAE
28	1	BBTT710-01	WASHER, THRUST, BRNZ.	60	9	WWL10	WASHER,LOCK,#10
29	1	CCCL5F	CLAMP COLLAR,5/16" BORE	61	1	WWL5/16	WASHER, LOCK, 5/16
30	1	CCCL6F	CLAMP COLLAR- 3/8	62	2	WWS307-1	WASHER,SPRING,BELVEL
31	1	GG414XL050UK	BELT,GEAR,KEVLAR CORE,URE	63	2	WWSI10	WASHER,INTERNAL TOOTH,10
32	1	M1J28-005	FOOT ASBLY, TBF, 3/4 GA				



1337-1500A Pneumatic Panel

AAC Drawing Number 9003202 Rev 1

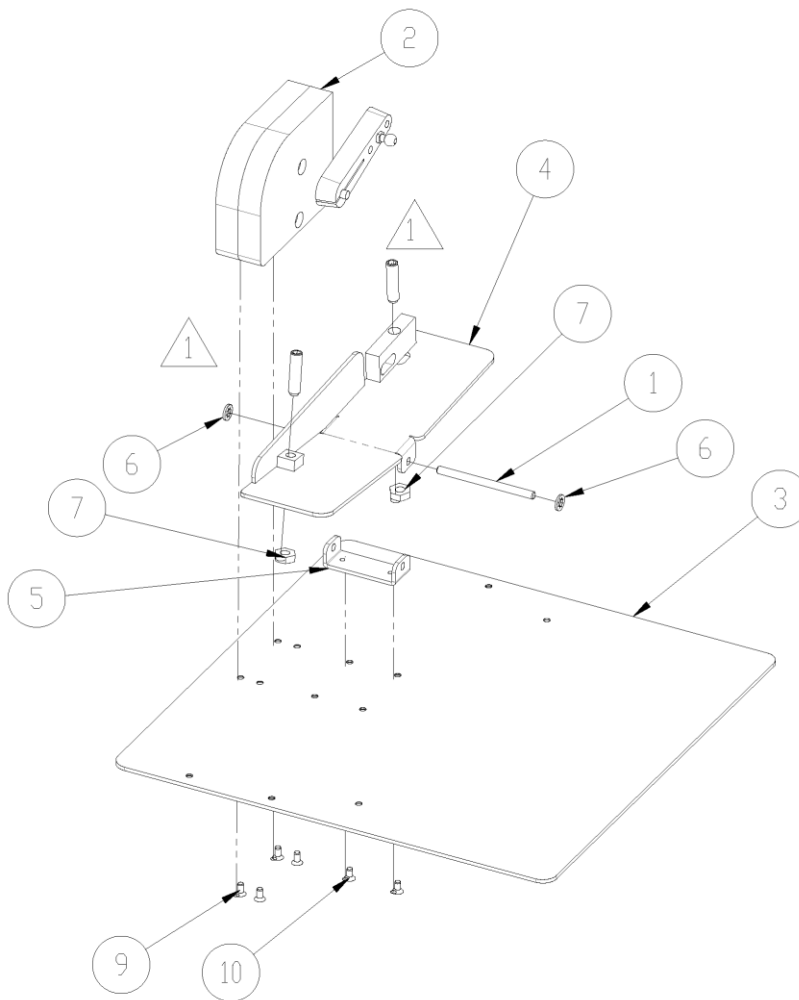
NO.	QTY	PART #	DESCRIPTION
1	1	1338-024	PANEL, PNEUMATIC
2	1	4130-001	REGULATOR BRACKET
3	1	AA198-5031	0-160PSI AIR GAGE 1/8NPT
4	1	AA198-503A	REG,0-30 W/GAUGE& BRKT, REL'G
5	2	AA198-5102	REGULATOR W/GAUGE & NUT
6	2	AAEVQZ2121	VALVE, BODY PORTED
7	1	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8
8	2	AAQME-5-4	ELBOW, 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	WWF6	DO NOT USE - SEE WWFS6
24	2	WWL1/4	WASHER,LOCK,1/4
25	6	WWL10	WASHER,LOCK,#10,S/S



1337375 Flange Guide Assembly

AAC Drawing Number 1337375 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	2	1337-4217	HINGE,PIANO,S/S, 2W, .06THK.
2	2	1337-4302	SPACER
3	1	1337-4304	PLATE, ADJUSTMENT
4	1	1337138	GUIDE, EDGE, RIGHT
5	1	1337176	PLATE,FOLDER TOP
6	1	1337188	SPACER,FLANGER GUIDE
7	1	1337376	PLATE, FLANGE GUIDE
8	1	MM1910A22ML	RULER,SILVER MYLAR 18"
9	2	NNH1/4-20	NUT,HEX,1/4-20
10	10	NNK10-32	KEP NUT, 10-32
11	2	SSBC01048	SCREW,BUTTON CAP,1/4-20X3/4,SS
12	2	SSPS98012	10-32 X 3/16 PAN HD SLOT
13	4	WWFS1/4	WASHER,FLAT,SAE,1/4
14	10	WWFS10	WASHER, FLAT, #10, SAE



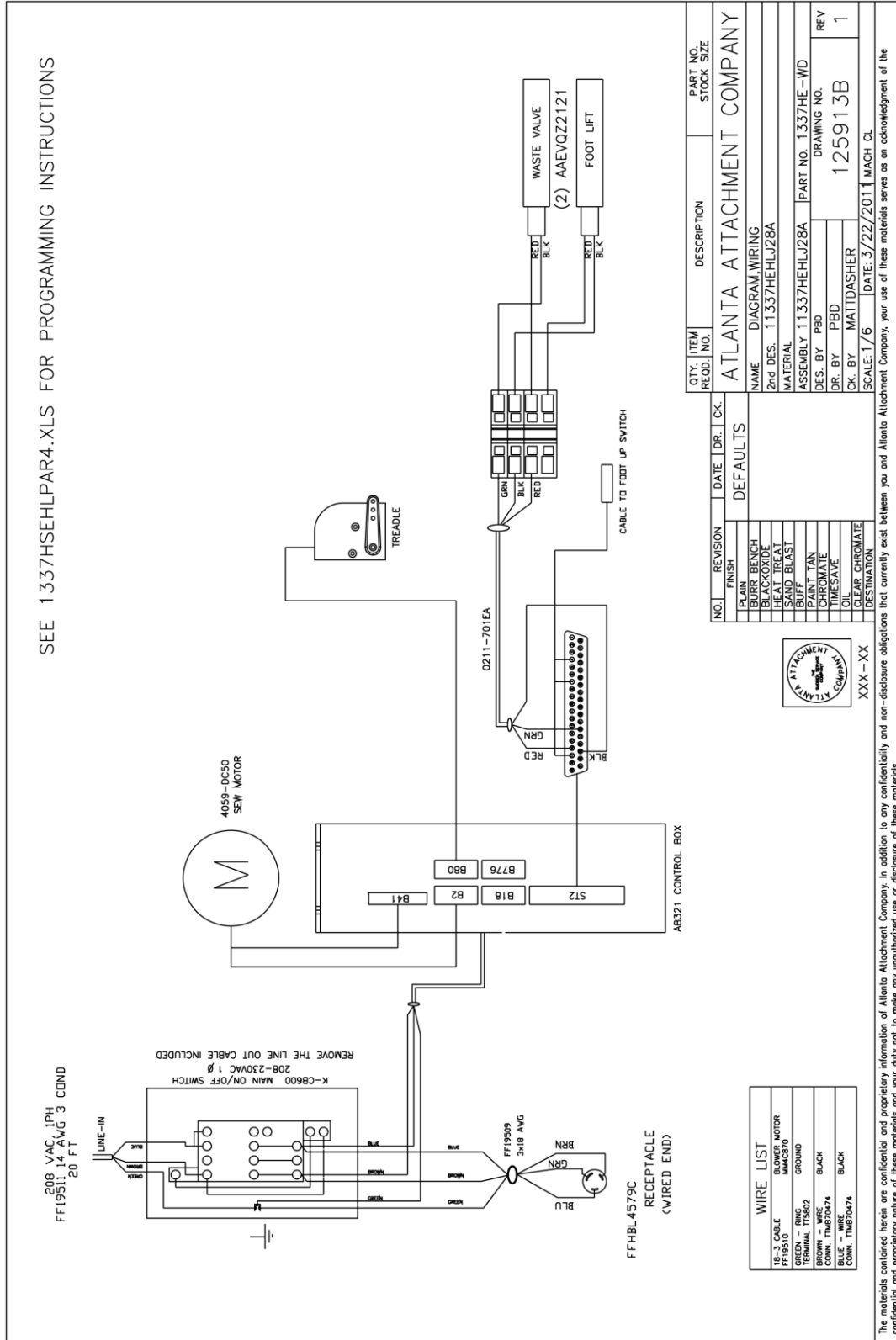
4059-FP301D Foot Pedal Assembly

AAC Drawing Number 9000033 Rev 3

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

1337HE-WD Wiring Diagram

SEE 1337HSEHLPAR4.XLS FOR PROGRAMMING INSTRUCTIONS



QTY.	ITEM	DESCRIPTION	PART NO.	STOCK SIZE
		ATLANTA ATTACHMENT COMPANY		
		NAME	DIAGRAM, WIRING	
		2nd DES.	11.337HEHLJ28A	
		MATERIAL		
		ASSEMBLY	11.337HEHLJ28A	PART NO. 1.337HE-WD
		DES. BY	PBD	DRAWING NO.
		CK. BY	MATTDASHER	125913B
		SCALE:	1/6	DATE: 3/22/2011
				MACH. CL.
				REV
				1

NO.	REVISION	DATE	DR.	CHK.	DEFAULTS
	FINISH				
	PLAIN				
	BLACK				
	BLACK				
	HEAT TREAT				
	SAND BLAST				
	BUFF				
	PAINT TAN				
	CHROMATE				
	PHOSPHATE				
	OIL				
	CLEAR CHROMATE				
	DESTINATION				

NO.	REVISION	DATE	DR.	CHK.
	FINISH			
	PLAIN			
	BLACK			
	BLACK			
	HEAT TREAT			
	SAND BLAST			
	BUFF			
	PAINT TAN			
	CHROMATE			
	PHOSPHATE			
	OIL			
	CLEAR CHROMATE			
	DESTINATION			

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Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

Atlanta Attachment Company warrants manufactured products to be free from defects in material and workmanship for a period of eight hundred (800) hours of operation or one hundred (100) days whichever comes first. Atlanta Attachment Company warrants all electrical components of the Serial Bus System to be free from defects in material or workmanship for a period of thirty six (36) months.

Terms and Conditions:

- AAC Limited Warranty becomes effective on the date of shipment.
- AAC Warranty claims may be made by telephone, letter, fax or e-mail. All verbal claims must be confirmed in writing.
- AAC reserves the right to require the return of all claimed defective parts with a completed warranty claim form.
- AAC will, at its option, repair or replace the defective machine and parts upon return to AAC.
- AAC reserves the right to make the final decision on all warranty coverage questions.
- AAC warranty periods as stated are for eight hundred (800) hours or one hundred (100) days whichever comes first.
- AAC guarantees satisfactory operation of the machines on the basis of generally accepted industry standards, contingent upon proper application, installation and maintenance.
- AAC Limited Warranty may not be changed or modified and is not subject to any other warranty expressed or implied by any other agent, dealer, or distributor unless approved in writing by AAC in advance of any claim being filed.

What Is Covered

- Electrical components that are not included within the Serial Bus System that fail due to defects in material or workmanship, which are manufactured by AAC are covered for a period of eight hundred (800) hours.
- Mechanical parts or components that fail due to defects in material or workmanship, which are manufactured by AAC.
- Purchased items (sewing heads, motors, etc.) will be covered by the manufacturers (OEM) warranty.
- AAC will assist in the procurement and handling of the manufacturers (OEM) claim.

What Is Not Covered

- Parts that fail due to improper usage, lack of proper maintenance, lubrication and/or modification.
- Damages caused by; improper freight handling, accidents, fire and issues resulting from unauthorized service and/or personnel, improper electrical, plumbing connections.
- Normal wear of machine and parts such as Conveyor belts, "O" rings, gauge parts, cutters, needles, etc.
- Machine adjustments related to sewing applications and/or general machine operation.
- Charges for field service.
- Loss of time, potential revenue, and/or profits.
- Personal injury and/or property damage resulting from the operation of this equipment.

Declaración de Garantía

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libres de defectos de material y de mano de obra durante un periodo de ochocientos (800) horas de operación o cien (100) días cual llegue primero. Atlanta Attachment Company garantiza que todos los componentes del Serial bus son libres de defectos de material y de mano de obra durante un periodo de treinta y seis (36) meses.

Términos y Condiciones:

- La Garantía Limitada de AAC entra en efecto el día de transporte.
- Reclamos de la Garantía de AAC pueden ser realizados por teléfono, carta, fax o correo electrónico. Todo reclamo verbal tiene que ser confirmado vía escrito.
- AAC reserva el derecho para exigir el retorno de cada pieza defectuosa con un formulario de reclamo de garantía.
- AAC va, según su criterio, reparar o reemplazar las máquinas o piezas defectuosas devueltas para AAC.
- AAC reserva el derecho para tomar la decisión final sobre toda cuestión de garantía.
- Las garantías de AAC tiene una validez de ochocientas (800) horas o cien (100) días cual llega primero.
- AAC garantiza la operación satisfactoria de sus máquinas en base de las normas aceptadas de la industria siempre y cuando se instale use y mantenga de forma apropiada.
- La garantía de AAC no puede ser cambiado o modificado y no está sujeto a cualquier otra garantía implicado por otro agente o distribuidor menos al menos que sea autorizado por AAC antes de cualquier reclamo.

Lo Que Está Garantizado

- Componentes eléctricos que no están incluidos dentro del sistema Serial Bus que fallen por defectos de materiales o de fabricación que han sido manufacturados por AAC son garantizados por un periodo de ochocientas (800) horas.
- Componentes mecánicos que fallen por defectos de materiales o de fabricación que han sido manufacturados por AAC son garantizados por un periodo de ochocientas (800) horas.
- Componentes comprados (Motores, Cabezales,) son protegidos debajo de la garantía del fabricante.
- AAC asistirá con el manejo de todo reclamo de garantía bajo la garantía del fabricante.

Lo Que No Está Garantizado

- Falla de repuestos al raíz de uso incorrecto, falta de mantenimiento, lubricación o modificación.
- Daños ocurridos a raíz de mal transporte, accidentes, incendios o cualquier daño como resultado de servicio por personas no autorizados o instalaciones incorrectas de conexiones eléctricas o neumáticas.
- Desgaste normal de piezas como correas, anillos de goma, cuchillas, agujas, etc.
- Ajustes de la máquina en relación a las aplicaciones de costura y/o la operación en general de la máquina.
- Gastos de Reparaciones fuera de las instalaciones de AAC
- Pérdida de tiempo, ingresos potenciales, y/o ganancias.
- Daños personales y/o daños a la propiedad como resultado de la operación de este equipo.



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