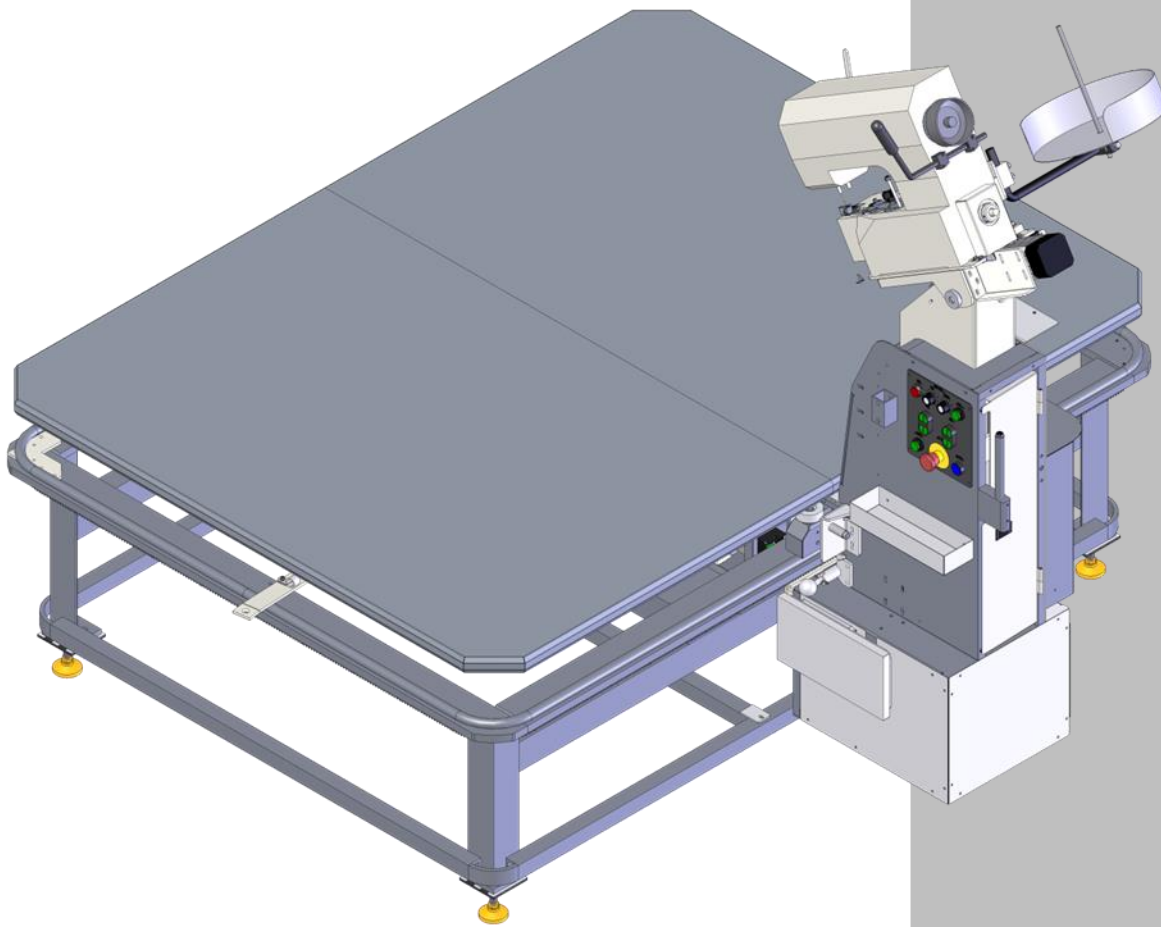




Model **1345-5P**

Revision 4.2 Updated February 26, 2025 (wr)

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 1345-6A Tape Edge Machine should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include;

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

Intended Use

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

Exclusion of Misuse



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

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

Liability

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

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

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

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

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

Choice and Qualification of Personnel

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

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

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines



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

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

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

Damage

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

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

Faults or Errors

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

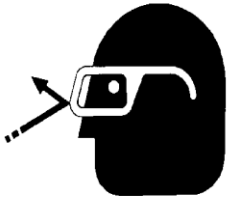
Signs on the Machine

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

Clothing, Jewelry, Protective Equipment

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

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

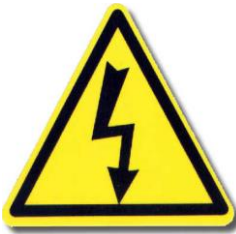
The following fire extinguishers may be used:

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

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

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

Electrical Power Supply



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

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

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

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

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

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

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

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

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

Workplace Environment

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

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

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

Protect against unauthorized access.

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

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

Local Regulations

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

Maintenance

General Safety Instructions

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

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

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

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

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

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

Repair

Replacement Parts

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

Repair, Electrical

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

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

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

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

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

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

Ventilation/Hazardous Gases

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

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

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

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

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

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

- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS operate equipment in daylight or with adequate working lights.
- Follow daily and weekly checklists, making sure hoses are tightly secured and bolts are tightened.
- ALWAYS watch and avoid holes or deep depressions.
- ALWAYS wear adequate eye protection when servicing the hydraulic system and battery.
- NEVER operate a poorly maintained machine.
- NEVER allow persons to operate this machine without proper instruction.
- NEVER put hands or feet under any part of the machine while it is running.
- NEVER attempt to make any adjustments or repairs to the machine while running. Repairs or maintenance should be performed by trained personnel only.
- NEVER work under the machine unless it is safely supported with stands, blocks or a hoist and blocks.
- NEVER touch hot parts of machine.

Machine Specifications

Voltage	220V / 1PH / 60Hz
Max Speed Sewing	3000 RPMs
Needle System	SN62X5924
Needle Size	24/180
Shipping Weight	2100 lbs
Machine Dimensions	120" x 102"

Motor Parameter Settings

There are two models of Efka controllers. The older FP220 had a three digit display. The newer AB221 has a four-digit display. Depending on the Efka Controller model, different instructions apply.

Instructions for the FP220 with three digit display

When replacing or installing a new Efka Controller, perform a master reset of the parameters using the following instructions.

***Master Reset of parameters if the Efka Controller has a three digit display:

1. Power on holding down the "P" button till the "COD" is displayed
2. Press ">>" once and enter the number "591"
3. Press "E" twice and "093" is displayed
4. Press "+" once and "094" is displayed
5. Press "P" to exit programming mode
6. Wait till the "ORE" message disappears
7. Press "E" twice to turn off LED 1 and 2
8. Press "+" twice to turn off LED 3 and 4
9. Press ">>" once to turn on LED 7 and off LED 8 so the head stops needle down
10. The new parameters must be saved before turning off power. See instructions below for saving parameters.

***Save Parameters: To save parameters after modifying parameters or doing a Master Reset, the motor should be run at least one revolution. It is normal that sometimes the Sew or Carriage motor rotates the wrong direction. When power is cycled off and back on, the motors will behave correctly. For the Sew Efka, the first few stitches will be very slow because the Efka is detecting the pulley ratio and adjusting automatically.

While the default values of the parameters cause the machine handle most mattresses well, certain parameters may be adjusted to improve performance in special cases.

***Parameters for Sew Efka Controller that has a three digit display:

Parameter 111 sets the max straight sew head speed in RPM. Min is 200, max is 9900, default is 3000 (300 displayed).

Parameter 701 sets the acceleration speed step in RPM / sec which limits the speed up of the sew motor independent of how fast the knee pad is let out. Min is 1000, max is 9990, default is 3300 (330 displayed).

Parameter 702 sets the deceleration speed step in RPM / sec which limits the slowdown of the sew motor independent of how fast the knee pad is pushed in. Min is 1000, max is 9990, default is 9990 (999 displayed).

Parameter 703 sets the max corner sew head speed in RPM. Min is 200, max is parameter 111, default is 1500 (150 displayed).

Parameter 712 holds the software revision number. Do not manually change this value.

***Parameters for Carriage Efka Controller that has a three digit display:

Parameter 111 sets the max normal straight carriage speed in RPM. Min is 200, max is 9900, default is 2700 (270 displayed).

Parameter 701 sets the acceleration speed step in RPM / sec which limits the speed up of the carriage motor independent of how fast the knee pad is let out. Min is 1000, max is 9990, default is 3300 (330 displayed).

Parameter 702 sets the deceleration speed step in RPM / sec which controls the slowdown of the motor independent of how fast the knee pad is pushed in. Min is 1000, max is 9990, default is 9990 (999 displayed).

Parameter 703 sets the max normal corner carriage speed in RPM. Min is 200, max is parameter 111, default is 1300 (130 displayed).

Parameter 704 sets the max glide straight carriage speed in RPM. Min is 200, max is parameter 111, default is 3000 (300 displayed). This parameter is effective only in machines with the "Power Glide" feature.

Parameter 705 sets the max glide corner carriage speed in RPM. Min is 200, max is/ parameter 111, default is 800 (80 displayed). This parameter is effective only in machines with the "Power Glide" feature.

Parameter 712 holds the software revision number. Do not manually change this value.

***Modify Parameters if the Efka Controller has a three digit display:

1. Power on holding down the "P" button till the "COD" is displayed
2. Press ">>" once and enter the number "311"
3. Press "E" once and "2.0.0" is displayed. This is the current parameter number
4. Proceed to the desired parameter and press "E" to display the parameter value
5. Adjust the value and press "E" to return to the parameter number
6. Repeat steps 4 and 5 until all the desired parameters have been modified
7. Press "P" to exit programming mode
8. The new parameters must be saved before turning off power. See instructions above for saving parameters.

Instructions for the AB221 with four digit display

When replacing or installing a new Efka Controller, perform a master reset of the parameters using the following instructions.

***Master Reset of parameters if the Efka Controller has a four digit display:

1. Power on holding down the "P" button till the "CODE" is displayed
2. Press ">>" once and enter the number "5913"
3. Press "E" twice and "093" is displayed
4. Press "+" once and "094" is displayed
5. Press "P" to exit programming mode
6. Wait till the "RES" message is replaced by LED indicators 1, 3, and 5
7. Press "E" twice to turn off LED 1 and 2
8. Press "+" twice to turn off LED 3 and 4
9. Press ">>" once to turn on LED 4 and off LED 5 so the head stops needle down
10. The new parameters must be saved before turning off power. See instructions below for saving parameters.

***Save Parameters: To save parameters after modifying parameters or doing a Master Reset, the motor should be run at least one revolution. It is normal that sometimes the Sew or Carriage motor rotates the wrong direction. When power is cycled off and back on, the motors will behave correctly. For the Sew Efka, the first few stitches will be very slow because the Efka is detecting the pulley ratio and adjusting automatically.

While the default values of the parameters cause the machine handle most mattresses well, certain parameters may be adjusted to improve performance in special cases.

***Parameters for Sew Efka Controller that has a four digit display:

Parameter 111 sets the max straight sew head speed in RPM. Min is 200, max is 9900, default is 3000.

Parameter 701 sets the acceleration speed step in RPM / sec which limits the speed up of the sew motor independent of how fast the knee pad is let out. Min is 1000, max is 9990, default is 3300.

Parameter 702 sets the deceleration speed step in RPM / sec which limits the slowdown of the sew motor independent of how fast the knee pad is pushed in. Min is 1000, max is 9990, default is 9990.

Parameter 703 sets the max corner sew head speed in RPM. Min is 200, max is parameter 111, default is 1500.

Parameter 706 set enables or disables the corner speed pot. Min is 0 (disable), max is 1 (enable), default is 1. If the machine does not have a corner speed pot, this value must be set to 0.

Parameter 712 holds the software revision number. Do not manually change this value.

***Parameters for Carriage Efka Controller that has a four digit display:

Parameter 111 sets the max normal straight carriage speed in RPM. Min is 200, max is 9900, default is 2700.

Parameter 701 sets the acceleration speed step in RPM / sec which limits the speed up of the carriage motor independent of how fast the knee pad is let out. Min is 1000, max is 9990, default is 3300.

Parameter 702 sets the deceleration speed step in RPM / sec which controls the slowdown of the motor independent of how fast the knee pad is pushed in. Min is 1000, max is 9990, default is 9990.

Parameter 703 sets the max normal corner carriage speed in RPM. Min is 200, max is parameter 111, default is 1300.

Parameter 704 sets the max glide straight carriage speed in RPM. Min is 200, max is parameter 111, default is 3000. This parameter is effective only in machines with the "Power Glide" feature.

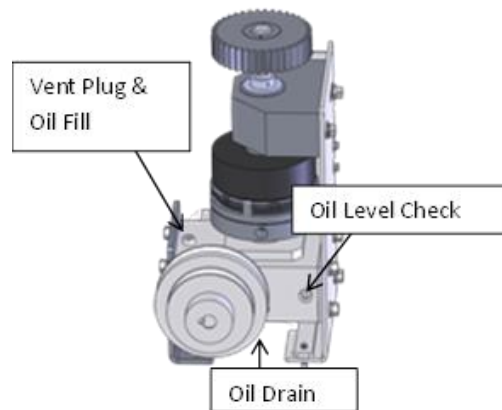
Parameter 705 sets the max glide corner carriage speed in RPM. Min is 200, max is/ parameter 111, default is 800. This parameter is effective only in machines with the "Power Glide" feature.

Parameter 712 holds the software revision number. Do not manually change this value.

***Modify Parameters if the Efka Controller has a four digit display:

1. Power on holding down the "P" button till the "CODE" is displayed
2. Press ">>" once and enter the number "3112"
3. Press "E" once and "2.0.0" is displayed. This is the current parameter number
4. Proceed to the desired parameter and press "E" to display the parameter value
5. Adjust the value and press "E" to return to the parameter number
6. Repeat steps 4 and 5 until all the desired parameters have been modified
7. Press "P" to exit programming mode
8. The new parameters must be saved before turning off power. See instructions above for saving parameters.

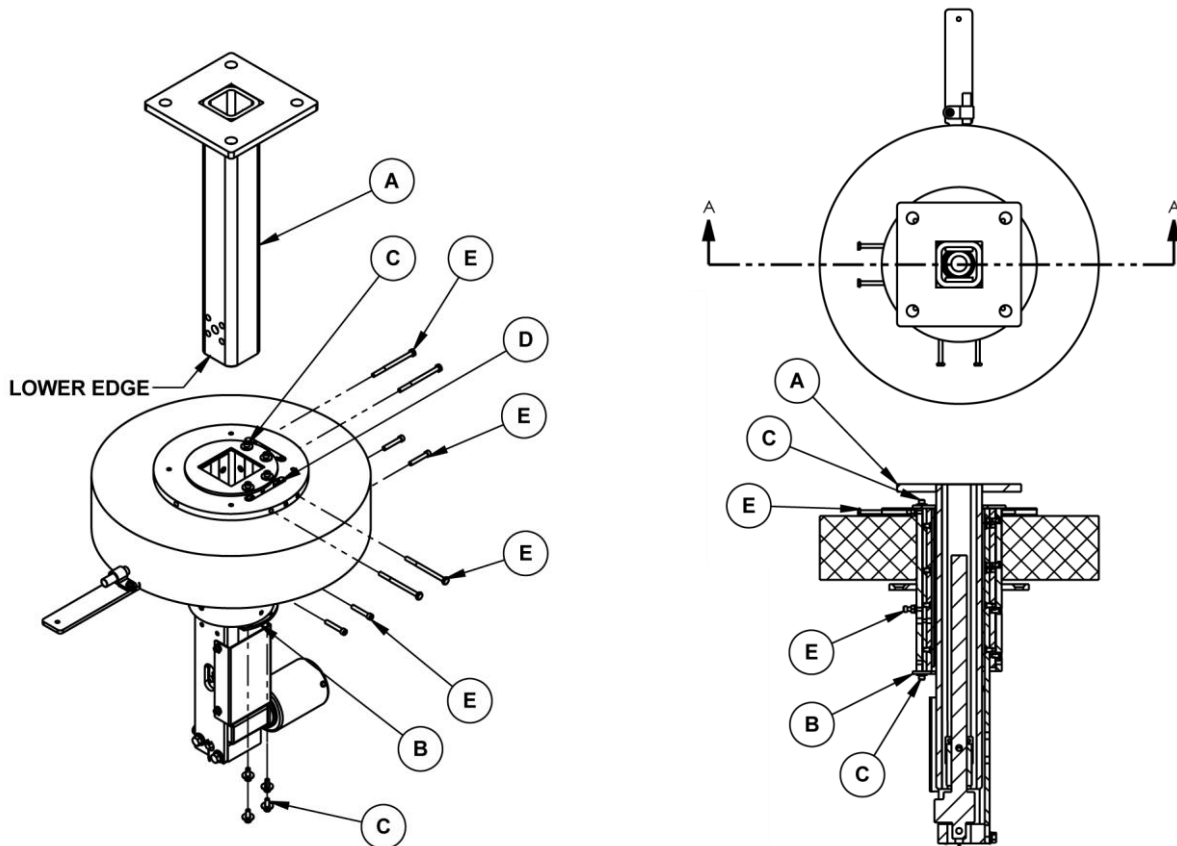
Gear Box Maintenance



- 1) Frequently check the oil level of the reducer. If oil level is low, add proper lubrication until it comes out the oil level check.
- 2) Inspect vent plug often to insure it is clean and operating.
- 3) Always check proper oil level. Do not overfill or under fill oil or damage may result.
- 4) Only use Mobil Glygoyle 460 polyglycol lubricant. Do not mix.

Assembly / Adjustment Instructions

1. Position the column assy (item A) with the lower edge below the bottom of the slide support bracket (item B).
DO NOT ADJUST WITH THE COLUMN OR TABLE IN THE "UP" POSITION.
2. Loosen the (8) screws (item C) holding the slide support bracket (item B) and the jam nuts (item D) for the top and bottom adjustment screws (item E).
3. Tighten or loosen the (4) upper and (4) lower adjustment screws (item E) as required to put pressure on the column assembly (item A) and align it in the support column.
NOTE: EXCESSIVE PRESSURE WILL CAUSE BINDING AND PREMATURE FAILURE OR WEARING OF PARTS. Apply only the minimum amount of pressure required to reduce the rotational movement of the table to an acceptable level.
4. Tighten the (8) top and (8) bottom support screws (item C).
5. Bolt the table top to the column and add shims if necessary to level the table parallel to the frame.

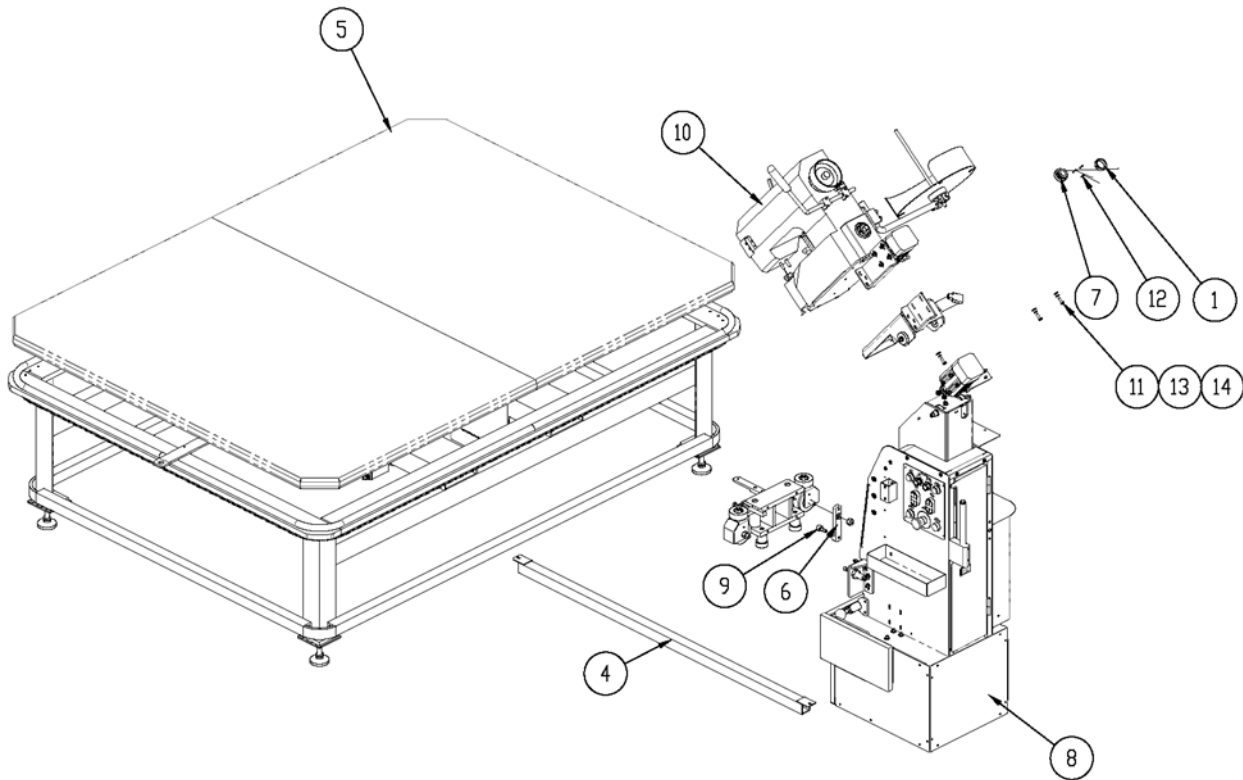


Assembly Drawings & Parts Lists

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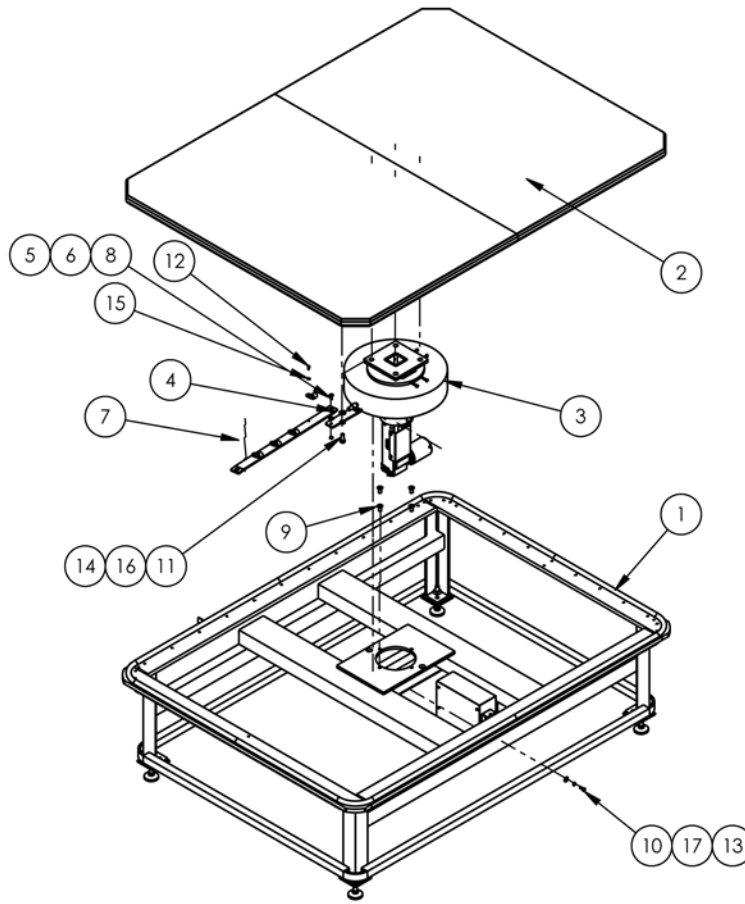
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11345-5P Tape Edge Machine

AAC Drawing Number 9004204 Rev 0

NO.	QTY	PART#	DESCRIPTION	NO.	QTY	PART#	DESCRIPTION
1	1	311-129	SLEEVE TAPE	8	1	134553000A	CARRIAGE
2	*1	1345-5WD1	DIAGRAM	9	1	MMCCF3/4SB	CAM FOLLOWER
3	*AR	1345LAB2	LABEL, TABLE	10	1	SPF5625-657-02M	HEAD, MOD, GEN, TAPE
4	1	1345152	SUPPORT	11	3	SSHHC01048GR8	1/4-20 X 3/4 HEX CAP
5	1	13452500A	TABLE ASSY	12	3	SSSC70040	4-40 X 5/8, SCREW
6	1	13453428	MOUNT, CAM	13	3	WWFS1/4	WASHER, FLAT, SAE, 1/4
7	1	13453646	TAPE MOUNT	14	3	WWL1/4	WASHER, LOCK, 1/4



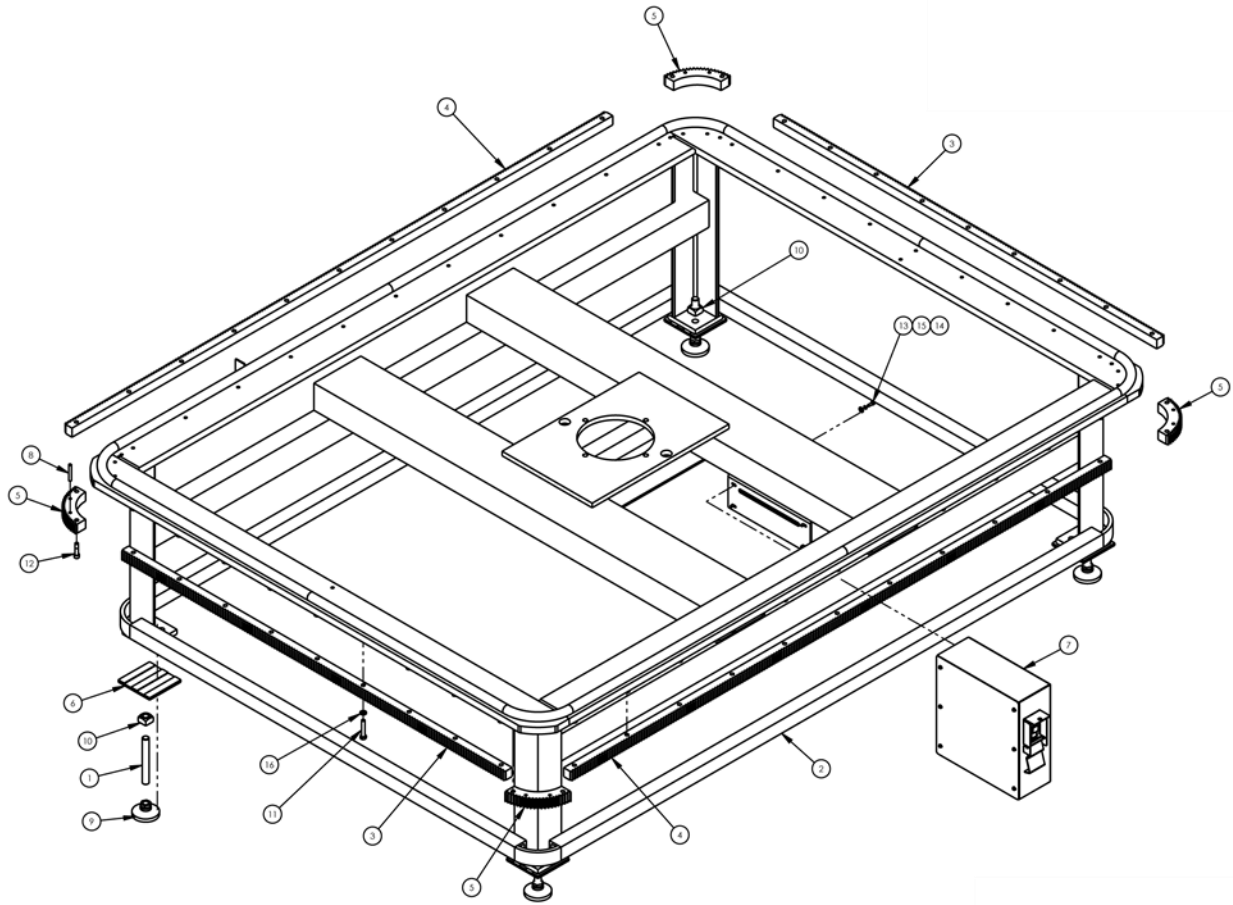
13452500A Table Assembly

AAC Drawing Number 9001366 Rev 11

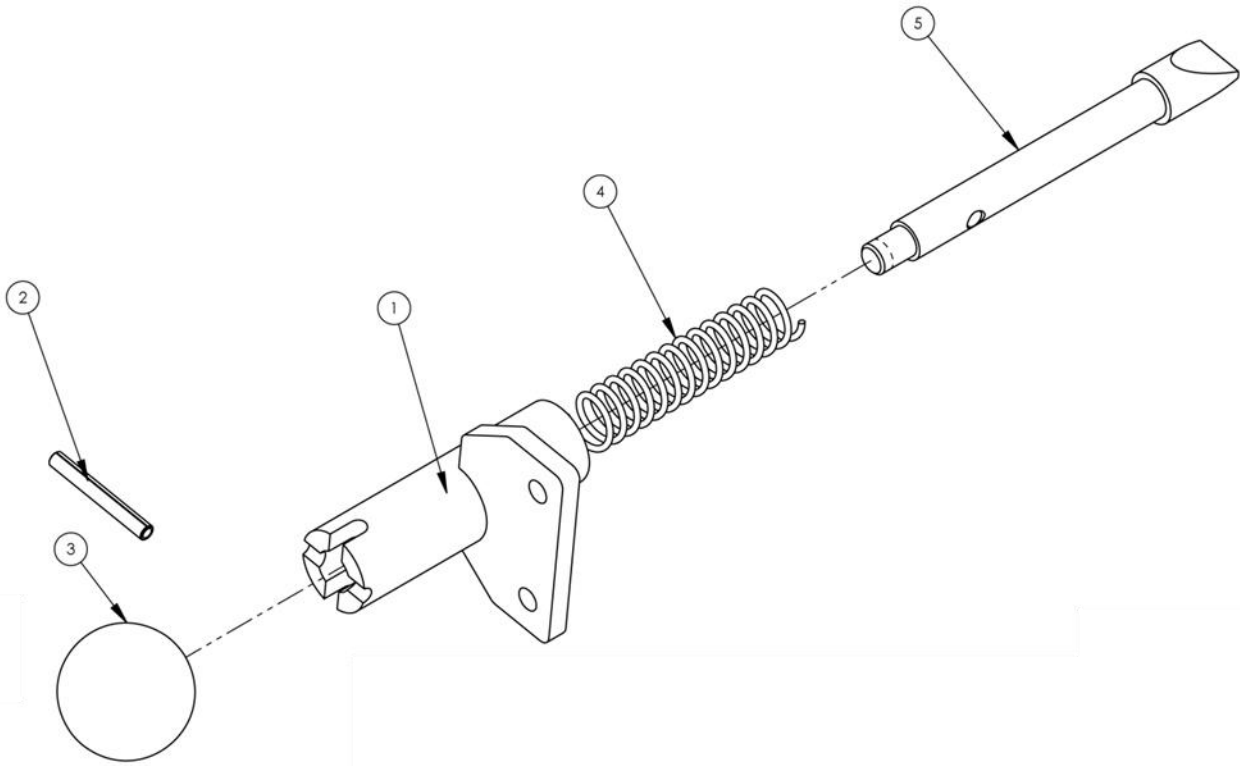
NO.	QTY	PART #	DESCRIPTION
1	1	13451000	BASE ASSY LIFT TABLE TAPE
2	1	13451200	TABLE TOP ASSY,QUEEN
3	1	13452000D	COLUMN, LIFT ASSY
4	1	13452027	LINK, CABLE ASSY,TWIN
5	2	BBTRA613	WASHER,THRUST,STL, .375B
6	1	NNJ5/16-18	NUT,JAM,5/16-18
7	4	PPP2217	WIRE CLAMP, .337I.D.
8	1	SSFC10056S	10-32 x 2 FLAT ALLEN
9	4	SSFC45064	1/2-13 X 1 SOC FLAT CAP
10	2	SSHC10048	5/16-18 X 3/4 HHCS
11	4	SSHC45080	1/2-13X1-1/4 HEX CAP
12	4	SSSC98032	10-32X1/2, SOC CAP
13	2	WWF5/16	WASHER,FLAT,5/16
14	4	WWFS1/2	WASHER,FLAT,SAE,1/2
15	4	WWFS10	WASHER, FLAT, #10, SAE
16	4	WWL1/2	1/2 LOCK WASHER
17	2	WWL5/16	WASHER, LOCK, 5/16

13451000 Table Base Assembly

AAC Drawing Number 9001365 Rev 7



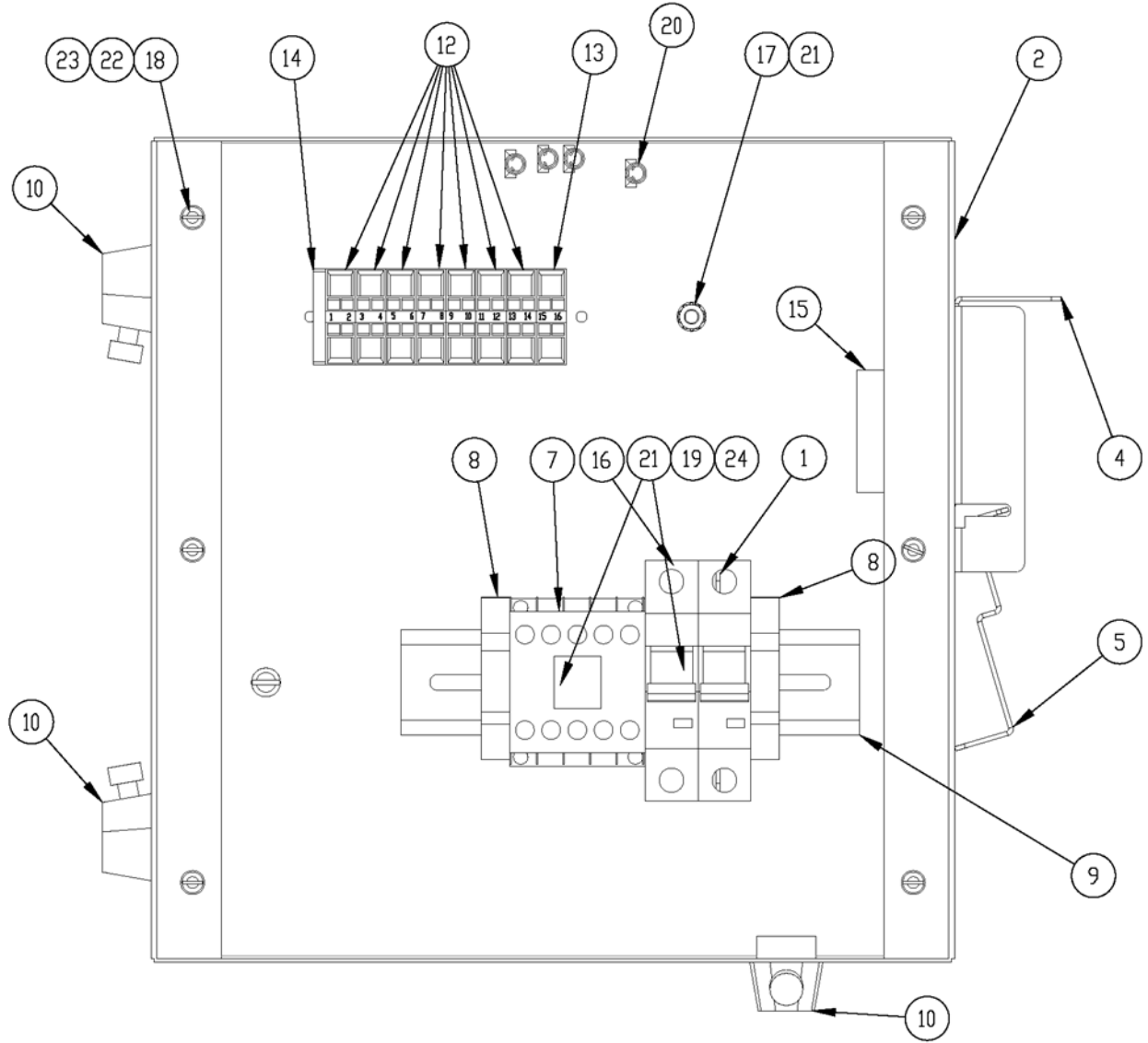
NO.	QTY	PART #	DESCRIPTION
1	4	0411-1063	ROD, THREADED, 5/8-11 X 5
2	1	1345027	FRAME, WELDMENT TAPE EDGE
3	2	13451019	GEAR RACK, SHORT
4	2	13451020	GEAR RACK, LONG
5	4	13451021	GEAR RACK, CORNER
6	4	13451029	PAD, RUBBER
7	1	13459500	CONTROL BOX
8	8	IIS016X112	ROLL PIN 1/8 DIA X 1 1/2 SS
9	4	MML-2	LEVELING PAD, 5/8-11
10	8	NNSH5/8-11	NUT, SQUARE, 5/8-11
11	40	SSHC10112	SCREW, HEX, 5/16-18X1-3/4
12	8	SSSC10080	5/16-18 X 1-1/4 SOC CAP
13	4	SSSC98032	10-32X1/2, SOC CAP
14	4	WWFS10	WASHER, FLAT, #10, SAE
15	4	WWL10	WASHER, LOCK, #10, S/S
16	40	WWL5/16	WASHER, LOCK, 5/16



13453800 Gear Lock Assembly

AAC Drawing Number 9001130 Rev 1

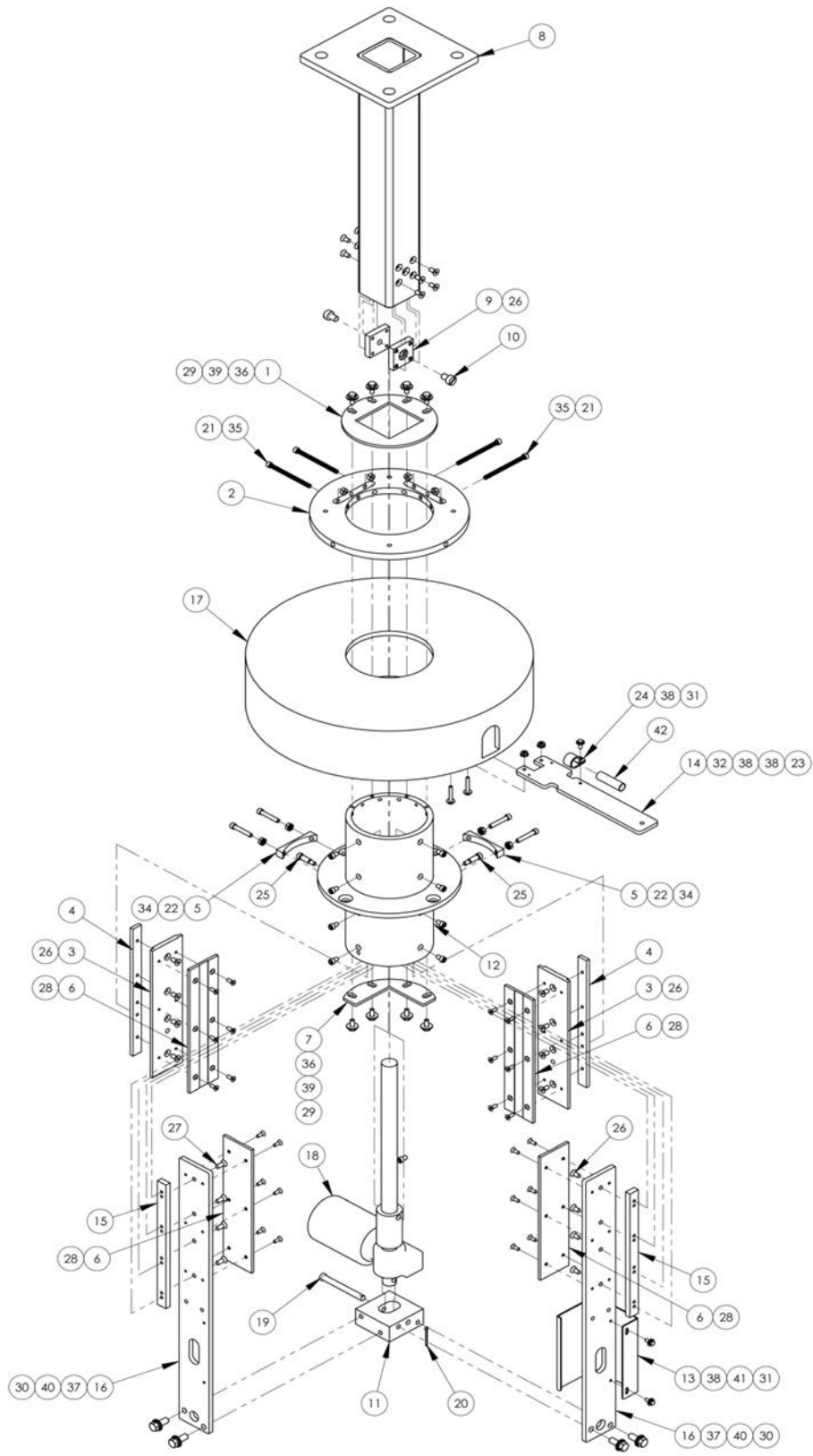
NO.	QTY	PART #	DESCRIPTION
1	1	13453801	SUPPORT GEAR LOCK ASSY.
2	1	IIS012X096	SPRING PIN, 3/16X1.5
3	1	MM61095K53	KNOB, BALL, 3/8-16 TAP
4	1	RRLC0742HJ	SPRING, COMP. .072X.66X3
5	1	13453804	MANDREL, GEAR LOCK



13459500 Control Box

AAC Drawing Number 9001947 Rev 1

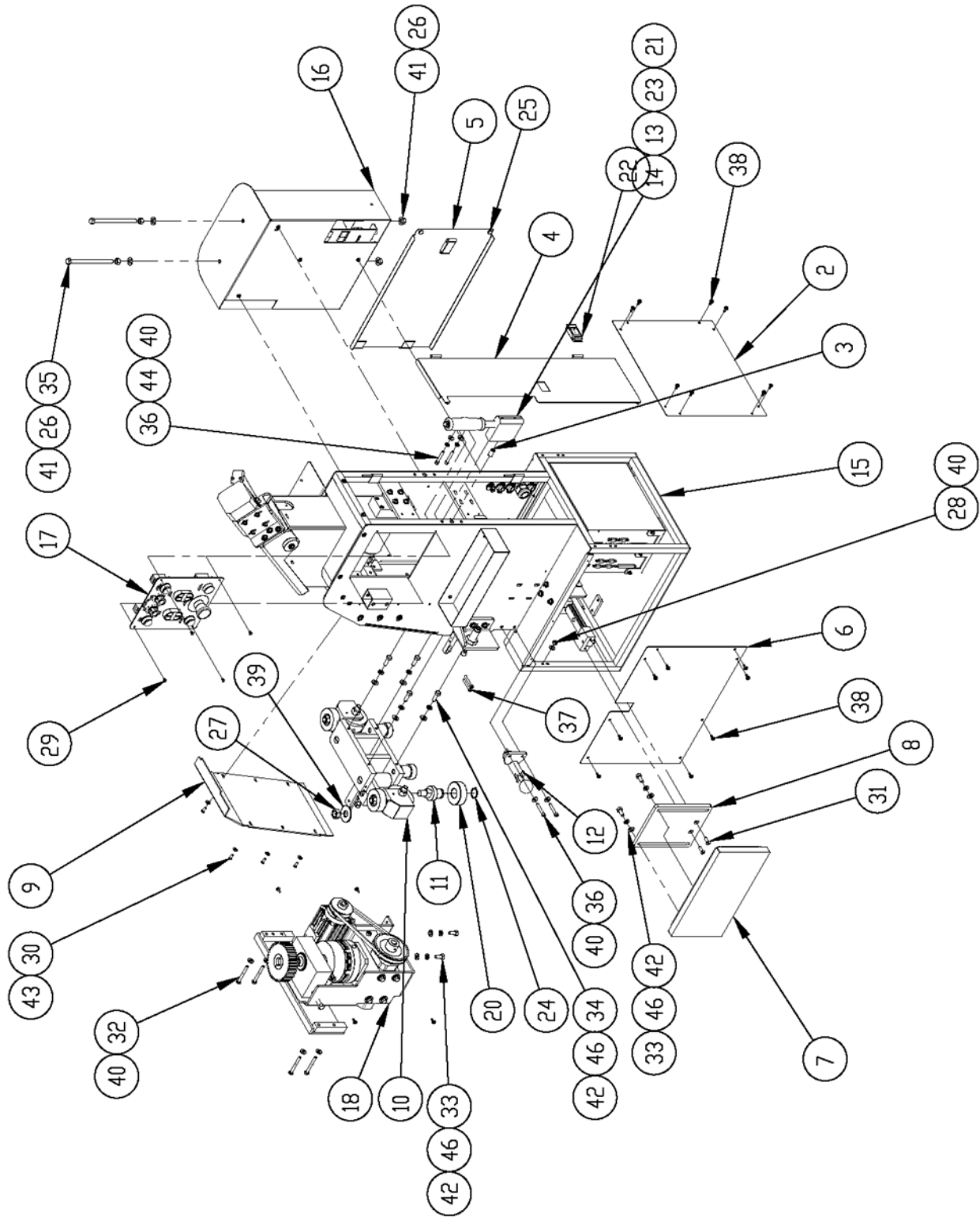
NO.	QTY	PART#	DESCRIPTION
1	1	13459004A	MOUNTING BRACKET, CAPACIT
2	1	13459501	PANEL,HIGH VOLTAGE
3	1	13459503	COVER, ELECTRICAL PANEL
4	1	40-322	BOTTOM, AC POWER LOCKOUT
5	1	40-323	TOP, AC POWER LOCKOUT
6	2	EELAK42BS	RIVET, BLIND 1/8 DIA ALUM.
7	1	EELCA491024	CONTACTOR, MINI, 240V
8	2	EELCLIPFIX	ANCHOR,DIN RAIL
9	1	EELTS35X7.5A	DIN RAIL-AMERICAN
10	4	FF1724	STRAIN RELIEF
11	15	FF19511	CABLE, 3 COND, 14GA
12	7	FF264-341	TERMBLK,WAGO, TOP,DUAL,GRY
13	1	FF264-347	TERMBLK,WAGO, TOP,DUAL,GRN
14	1	FF264-371	TERMBLK,WAGO, TOP,END
15	1	FF3120L420A	CIRCUIT BREAKER, THERMAL
16	1	FFL722C	BREAKER, CIRCT. THERM-MAG
17	1	NNK8-32	NUT,KEP,8-32
18	6	SSPS80016	#6-32 X 1/4 LG PAN HD
19	4	SSPS98024	10-32X3/8 PAN HD SLOT
20	4	TTBB5263	TERMINAL,.25 FULLY INSUL
21	5	WWF8	WASHER, FLAT, #8
22	6	WWFS6	WASHER, FLAT, #6
23	6	WWL6	WASHER,LOCK,#6
24	4	WWL8	WASHER,LOCK,#8



13452000D Column Lift Assembly

AAC Drawing Number 9002809 Rev 4

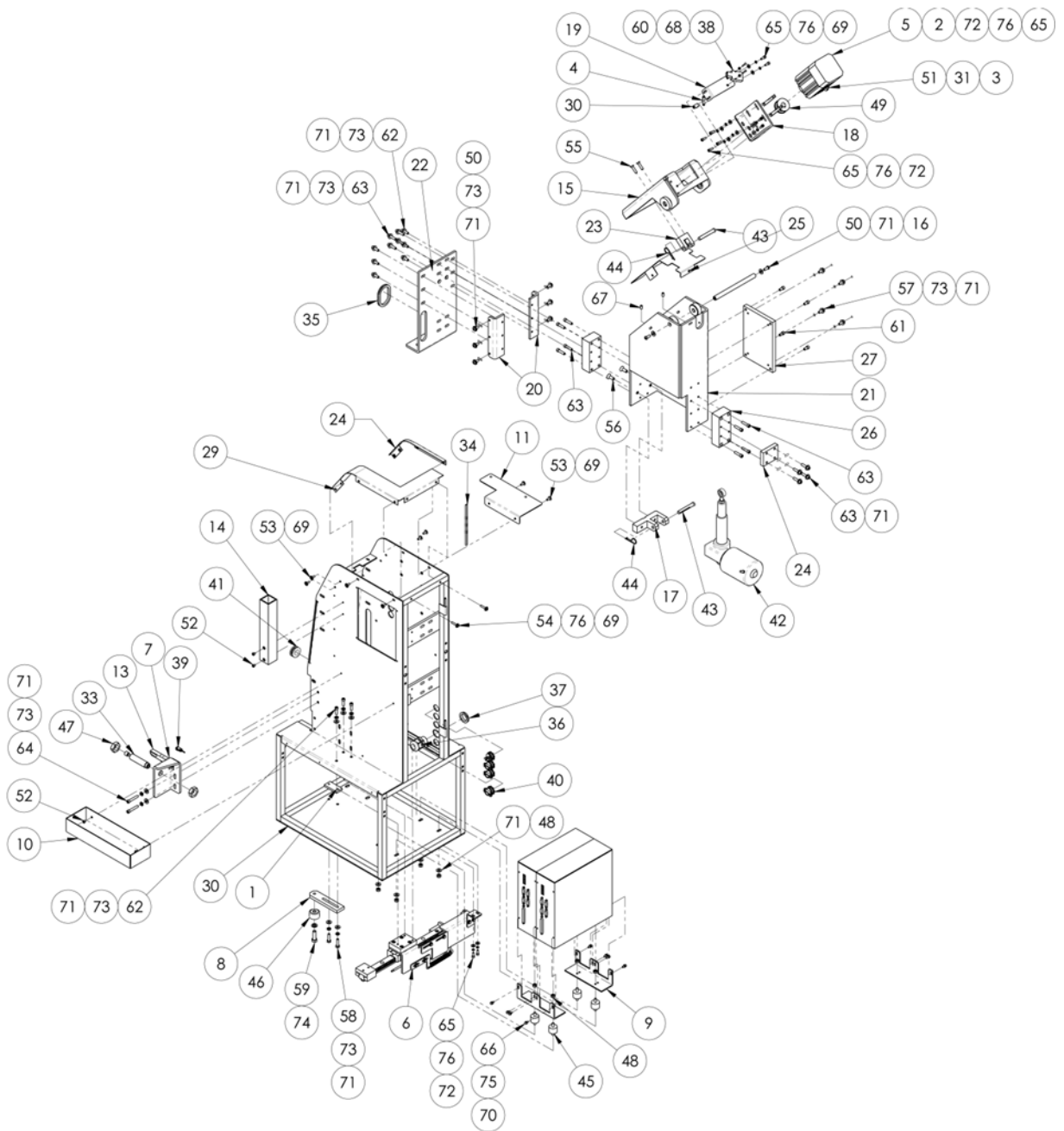
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1345093	BKT,EDGE GUIDE
2	1	1345130	TOP MOD.,SLIP RING
3	2	1345131	PLATE,SLIDE, ADJ
4	2	1345132	BAR, BRACE,.25 THK
5	2	1345134	SPACER,COLUMN CONCAVE
6	4	1345135	PLATE, SLIDE
7	1	1345136	BKT,LOWER GIB STOP
8	1	1345231	COLUMN ASSY
9	2	1345234	PLATE,ACTUATOR MNTNG,UPR
10	2	13452004A	PIN, COLUMN
11	1	13452006B	PLATE, ACTUATOR
12	1	13452020B	COLUMN, HUB ASSY.
13	1	13452023A	COVER, ACTUATOR
14	1	13452024	GUIDE ASSY,CABLE, SLIP RING 11345
15	2	13452040	BAR, BRACE
16	2	13452044A	PLATE,SLIDE SUPPORT
17	1	EERHU-B08	SLIP RING ASSY,15A,8 COND
18	1	MM85200-12.5	ACTUATOR,ELEC,220V,12.5"
19	1	MM98306A289	PIN,CLEVIS,3/8X3-1/2
20	1	MM98338A445	COTTER PIN, 1/8 X 2 1/2
21	4	NNH1/4-20	NUT,HEX,1/4-20
22	4	NNK1/4-20	NUT,KEP,1/4-20
23	2	NNK10-32	KEP NUT, 10-32
24	1	PPP2217	WIRE CLAMP, .3371.D.
25	2	SSAS020048	SCREW ,ALLEN SHOULDER
26	20	SSFC01032	1/4-20 X 1/2 FLAT ALN CAP
27	4	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
28	24	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
29	8	SSHC01040	1/4-20 X 5/8 HHCS
30	4	SSHC25064	3/8-16 X 1 HHCS
31	3	SSHC98032	10-32X1/2 HEX HD
32	2	SSHC98080	#10-32 X 1-1/4 HEX CAP
33	9	SSSC01024	1/4-20 X 3/8 SOC CAP SC
34	4	SSSC01096F	1/4-20 X 1-1/2 SOC CAP
35	4	SSSC01224T	SCR,HEX CAP 1/4-20X3-1/2
36	8	WWF1/4	WASHER, FLAT, 1/4", COM
37	4	WWFS3/8	WASHER,FLAT,SAE,3/8
38	7	WWFS10	WASHER, FLAT, #10, SAE
39	8	WWL1/4	WASHER,LOCK,1/4
40	4	WWL3/8	WASHER,LOCK, 3/8
41	2	WWL10	WASHER,LOCK,#10
42	1	ZTH1/2B	HEAT SHRINK TUBE,1/2"DIA



134553000A Carriage Assembly

AAC Drawing Number 9001641 Rev 6

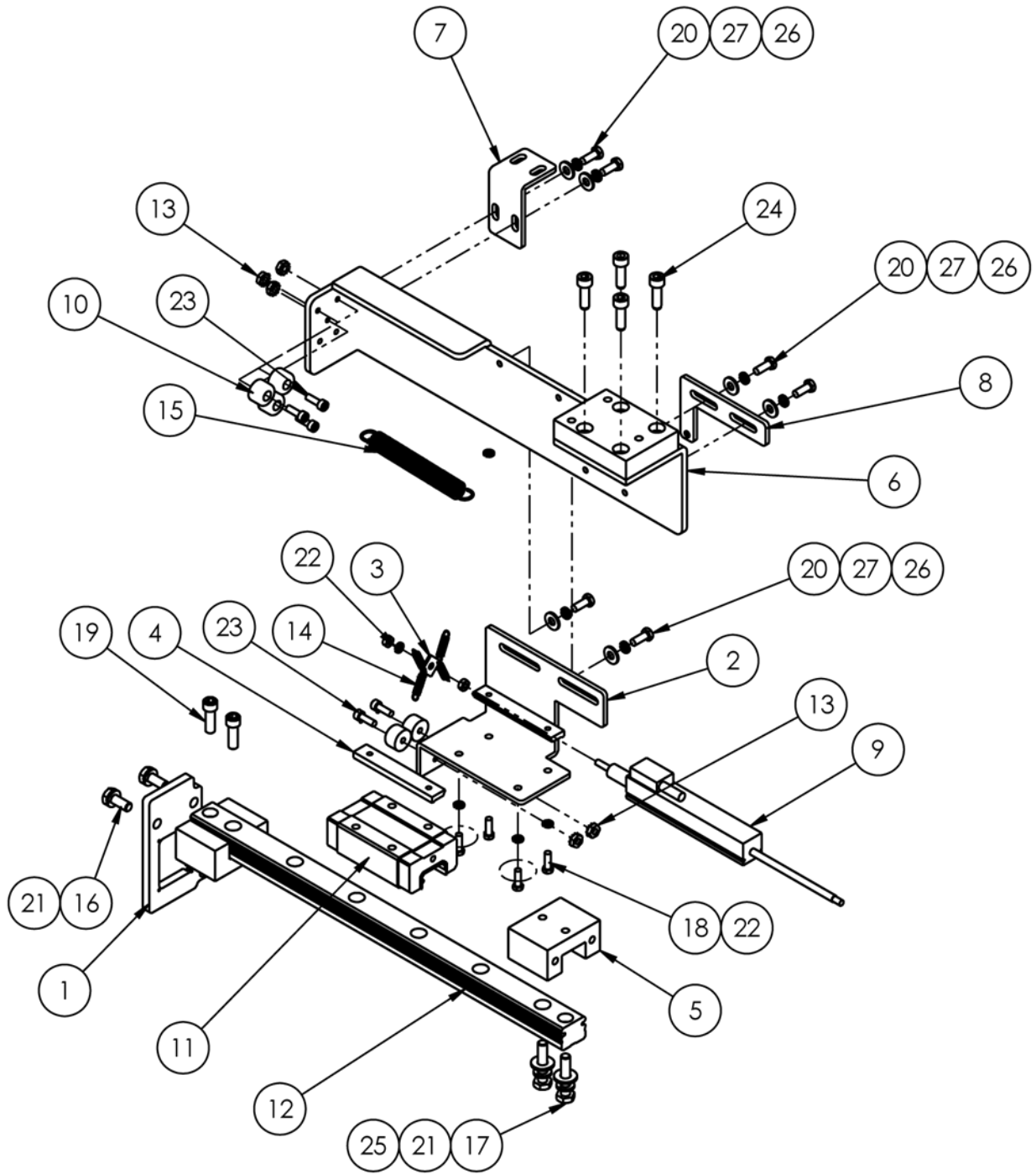
NO.	QTY	PART#	DESCRIPTION	NO.	QTY	PART#	DESCRIPTION
1	*AR	1345-5WD1	DIAGRAM, WIRING	24	1	MMSH-98	RING, SNAP, EXTERNAL
2	1	13453003A	COVER, CARRIAGE	25	4	MMSLD-ECH	1/2" DIA RUBBER
3	1	13453037	SPACER, 7/16 OD	26	4	NNH3/8-16	NUT, HEX, 3/8-16
4	1	13453060C	DOOR, CARRIAGE	27	1	NNH5/8-18	NUT, HEX, 5/8-18
5	1	13453061A	DOOR CARRIAGE	28	6	NNK1/4-20	NUT, HEX, KEP, 1/4-20
6	1	13453062A	COVER, CARRIAGE	29	4	SSBC90016	8-32 X 1/4 BUTTON
7	1	13453303	KNEE PAD ASSY.	30	6	SSBC98032	10-32 X 1/2 BUTTON
8	1	13453304	BRKT ,MNT, KNEE	31	2	SSFC01048	1/4-20 X 3/4 FLAT
9	1	13453330A	PANEL, CARRIAGE	32	4	SSHC01144	HEX HEAD BOLTS
10	1	13453400A	CARRAGE GUIDE	33	4	SSHC10048	5/16-18 X 3/4 HHCS
11	1	13453420A	BEARING STUD	34	4	SSHC10064	5/16-18 X 1 HHCS
12	1	13453800	GEAR LOCK ASSY.	35	2	SSHC25352	3/8-16X5-1/2, HEX
13	1	33005110A	HANDLE 9.25 L	36	4	SSSC01096	1/4-20 X 1-1/2 SOC
14	1	33005116B	SPACER, HANDLE	37	2	SSSC98096	10-32 X 1-1/2 SOC
15	1	134533300A	TOP CARRIAGE	38	20	SSZS93032	SCREW, SHT.METAL
16	1	134539000B	CONTROL BOX	39	1	WWF5/8	WASHER, FLAT, 5/8
17	1	134539300A	CONTROL BUTTON	40	12	WWF5/4	WASHER, FLAT, SAE, 1/4
18	1	134553500E	GEAR BOX	41	8	WWF5/8	WASHER, FLAT, SAE, 3/8
19	1	134559400	CABLE PACKAGE	42	8	WWF5/16	WASHER, FLAT, SAE, 5/16
20	1	BB305705C	BEARING, CAM	43	6	WWF5/10	WASHER, FLAT, #10
21	1	EE49111AS	PUSH BUTTON	44	2	WWL1/4	WASHER, LOCK, 1/4
22	2	MM40450010	FASTENER, SLIDE	45	4	WWL3/8	WASHER, LOCK, 3/8
23	1	MMGP-105	GRIP HANDLE	46	8	WWL5/16	WASHER, LOCK, 5/16



134533300A Top Carriage Assembly

AAC Drawing Number 9001479 Rev 17

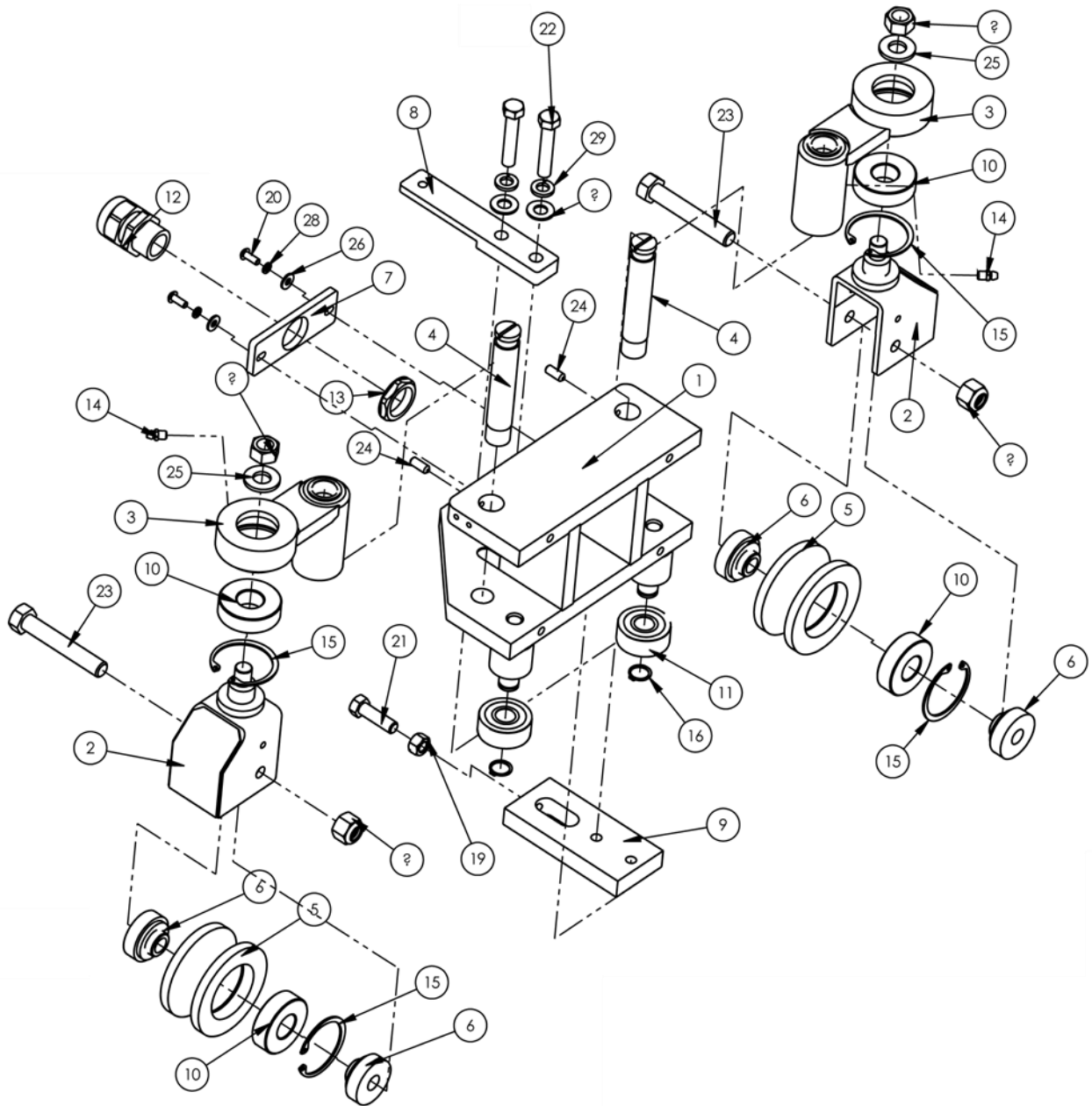
ITEM NO.	QTY	PART NUMBER	DESCRIPTION	ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	2	029-003A	PLATE, NUT, 1/4-20 @ 1.50	39	1	FFUZP101	PROX. SWITCH
2	2	0211-209	PLATE,NUT,10-32@2.25 CTC	40	4	K-235	CONNECTOR,ROMEX,1/2"
3	1	1961-126	PLATE, NUT, 6-32, 1PL	41	1	MM9307K69	GROMMET,5/8,1.125,.125GV
4	1	1975-412A	PLATE,NUT,4-40,.95CTC	42	1	MM85151-2M1	ACTUATOR, MOD
5	1	4059-DC1500ABA 1	MOTOR,W/DC CONTROLLER	43	2	MM98330A245	CLEVIS PIN 2.25LG STL
6	1	1345100	KNEE SWITCH ASSEMBLY	44	2	MM98335A064	SPRING CLIP
7	1	13453301	MOUNT, SHOCK ABSORBER	45	4	MMB6002	MOUNT,VIBRATION,MOTOR
8	1	13453313	MOUNT, CARRIAGE GUIDE, LO	46	1	MMCYR114S	FOLLOWER, CAM
9	2	13453324	BRKT, CONTROL BOX MOUNT	47	2	NNJ3/4-16	3/4-10 JAM NUT
10	1	13453341	TOOL TRAY, 2 X 3.38 X 11	48	8	NNK1/4-20	NUT,KEP,1/4-20
11	1	13453354	BRKT, THREAD GUIDE	49	1	PP10LF050M3	PULLEY, GEAR, 3/8P, 10T,
12	1	13453379	HOLDER, PROX SWITCH, BTM	50	8	SSBC01040	1/4-20 X 3/4 BUT CAP SC
13	1	13453380	HOLDER, PROX. SWITCH	51	4	SSBC80024	6-32 X 3/8 BUTTON HEAD
14	1	13453385	HOLDER, SCISSOR	52	4	SSBC98016	10-32 X 1/4 BUTTON CAP SC
15	1	13453602	PLATE, SEWING HEAD MOUNT	53	8	SSBC98032	10-32 X 1/2 BUTTON CAP SC
16	1	13453603A	SHAFT 60C 1/2 X 6.91L	54	2	SSBC98064	10-32 X 1.0 BUTTON CAP SC
17	1	13453604	PIVOT, SUPPORT, ACTUATOR	55	2	SSFC01064	1/4-20 X 1 FLAT CAP
18	1	13453608	BRKT, MOTOR MOUNT	56	2	SSFC10056	5/16-18 X 7/8 FLAT HD CAP
19	1	13453610	BRKT, EYE	57	4	SSHC01040	1/4-20 X 5/8 HHCS
20	2	13453611	MOUNT, BEARING BLOCK BRKT	58	2	SSHC01064	1/4-20 X 1 HHCS
21	1	13453615A	COLUMN, SEWING HEAD	59	1	SSHC25080	3/8-16 X 1-1/4 HHCS
22	1	13453623	BRKT, BEARING BLOCK MOUNT	60	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
23	1	13453642	CLEVIS, ACTUATOR, 2" STRO	61	4	SSSC01032	1/4-20X1/2 SOC CAP
24	1	13453645	SPACER, RAIL	62	9	SSSC01048	1/4-20 X 3/4" SOC CAP SC
25	1	13453648A.	COVER, COLUMN	63	16	SSSC01064	1/4-20 X 1 SOC CAP
26	2	13453653	SPACER, COLUMN	64	2	SSSC01096	1/4-20 X 1-1/2 SOC CAP
27	1	13453655	SPACER, COLUMN REAR	65	10	SSSC98032	10-32X1/2, SOC CAP
28	1	13453656	COVER, COLUMN REAR	66	8	SSSCM4X10	SCREW,SOC CAP,M4-0.7X8
29	1	13453657	COVER, COLUMN FRONT	67	4	SSSS01032	SCREW, SET, 1/4-20 X 1/2
30	1	134543100	CARRIAGE FRAME ASSY	68	2	WWF4	WASHER, FLAT, # 4
31	1	AAF1/8	CLAMP, BLACK PLASTIC	69	12	WWF10	WASHER, FLAT, # 10, COM
30	1	AAF3/8	CLAMP, BLACK PLASTIC	70	8	WWFM4.3	WASHER, FLAT, M4
33	1	AAOEM.5BSAL	SHOCK, 3/4-18 X 3.5	71	37	WWFS1/4	WASHER,FLAT,SAE,1/4
34	*1.4	FF2226	EDGING,GROMMET	72	8	WWFS10	WASHER, FLAT, # 10, SAE
35	*1.4	FF2230	EDGING,GROMMET,.25"	73	27	WWL1/4	WASHER,LOCK,1/4
36	1	FF3234	STRAIN RELIEF,3/4NPT	74	1	WWL3/8	WASHER,LOCK, 3/8
37	1	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK	75	8	WWL8	WASHER,LOCK,#8
38	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	76	12	WWL10	WASHER,LOCK,# 10



1345100 Knee Switch Assembly

AAC Drawing Number 1345100 Rev 5

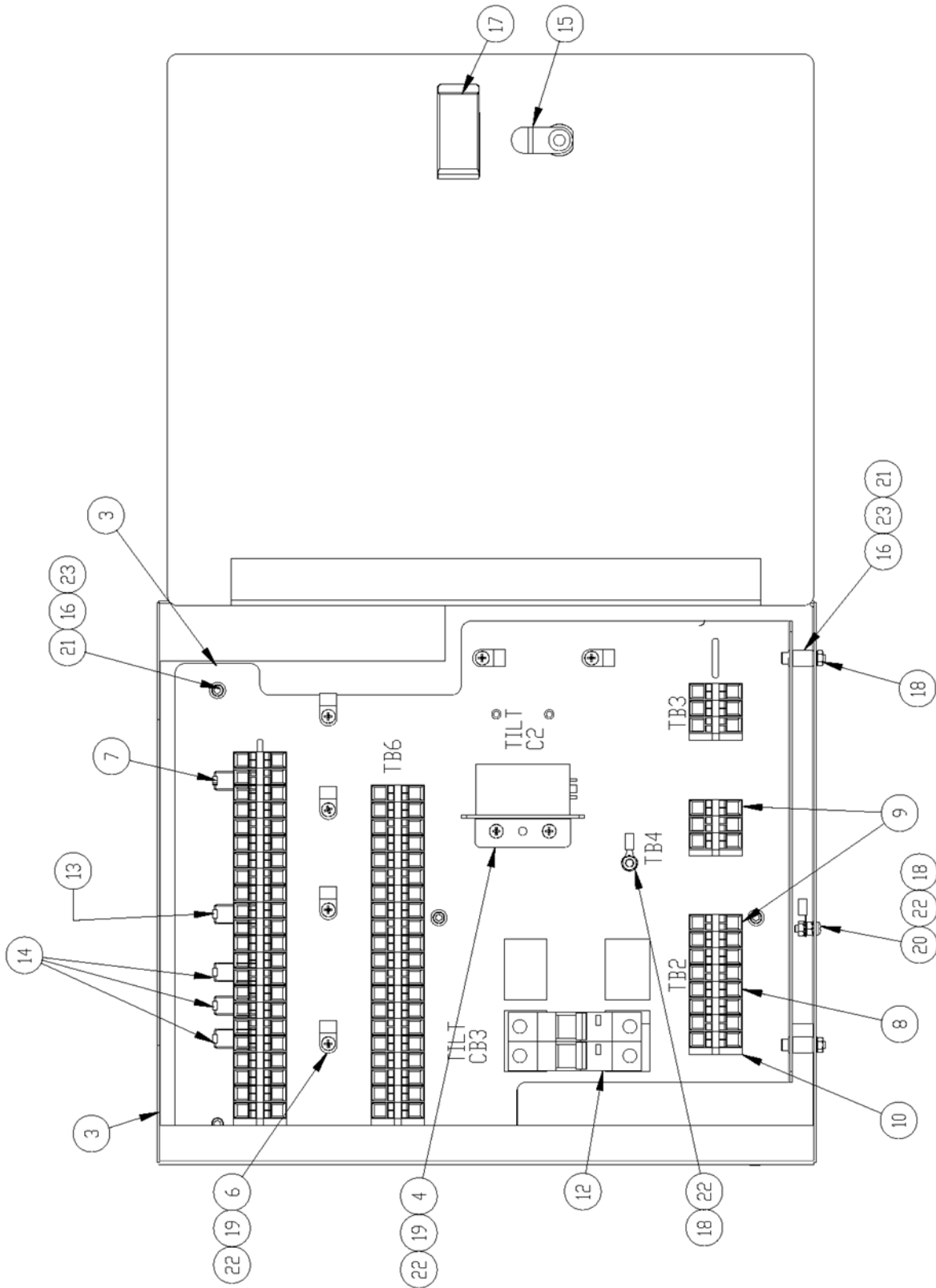
NO.	QTY	PART #	DESCRIPTION
1	1	1345101	PLATE, TRANSDUCER END
2	1	1345102	MOUNT, TRANSDUCER
3	1	1345103	PLATE, SPRING, TRANSDUCER
4	2	1345104	CLAMP, TRANSDUCER
5	2	13453306	BLOCK, RAIL STOP
6	1	13453309	RAIL BKT ASBLY
7	1	13453337	BRACKET, RAIL SUPPORT
8	1	13453361	BRKT, SPRING TENSION
9	1	FF002304A	LINEAR TRANSDUCER ASBY
10	5	MM9540K53	BUMPER, 3/4 DIA
11	1	MMAGH25CAN	LINEAR BEARING
12	1	MMAGR25360M1	RAIL, LINEAR, MODIFIED
13	5	NNK8-32	KEP NUT, 8-32
14	4	RRLE018B1	SPRING, EXT .020X.19X1.5
15	1	RRLE055E10	SPRING, EXT .020X.19X1.5
16	2	SSHC01040	1/4-20 X 5/8 HHCS
17	2	SSHC01080	1/4-20 X 1-1/4 HHCS
18	4	SSHC90032S	#8-32 X 1/2 HEX CAP
19	2	SSSC01048	1/4-20 X 3/4" SOC CAP SC
20	6	SSHC98032	10-32X1/2 HEX HD
21	4	WWL1/4	WASHER, LOCK, 1/4
22	5	WWL8	WASHER, LOCK, #8
23	5	SSSC90032	#8-32 X 1/2 SOC CAP SC
24	4	SSSCM6X20	SCREW, SOCKET CAP
25	2	WWFS1/4	WASHER, FLAT, SAE, 1/4
26	6	WWFS10	WASHER, FLAT, #10, SAE
27	6	WWL10	WASHER, LOCK, #10, S/S



13453400A Carriage Guide Assembly

AAC Drawing Number 9001193 Rev 6

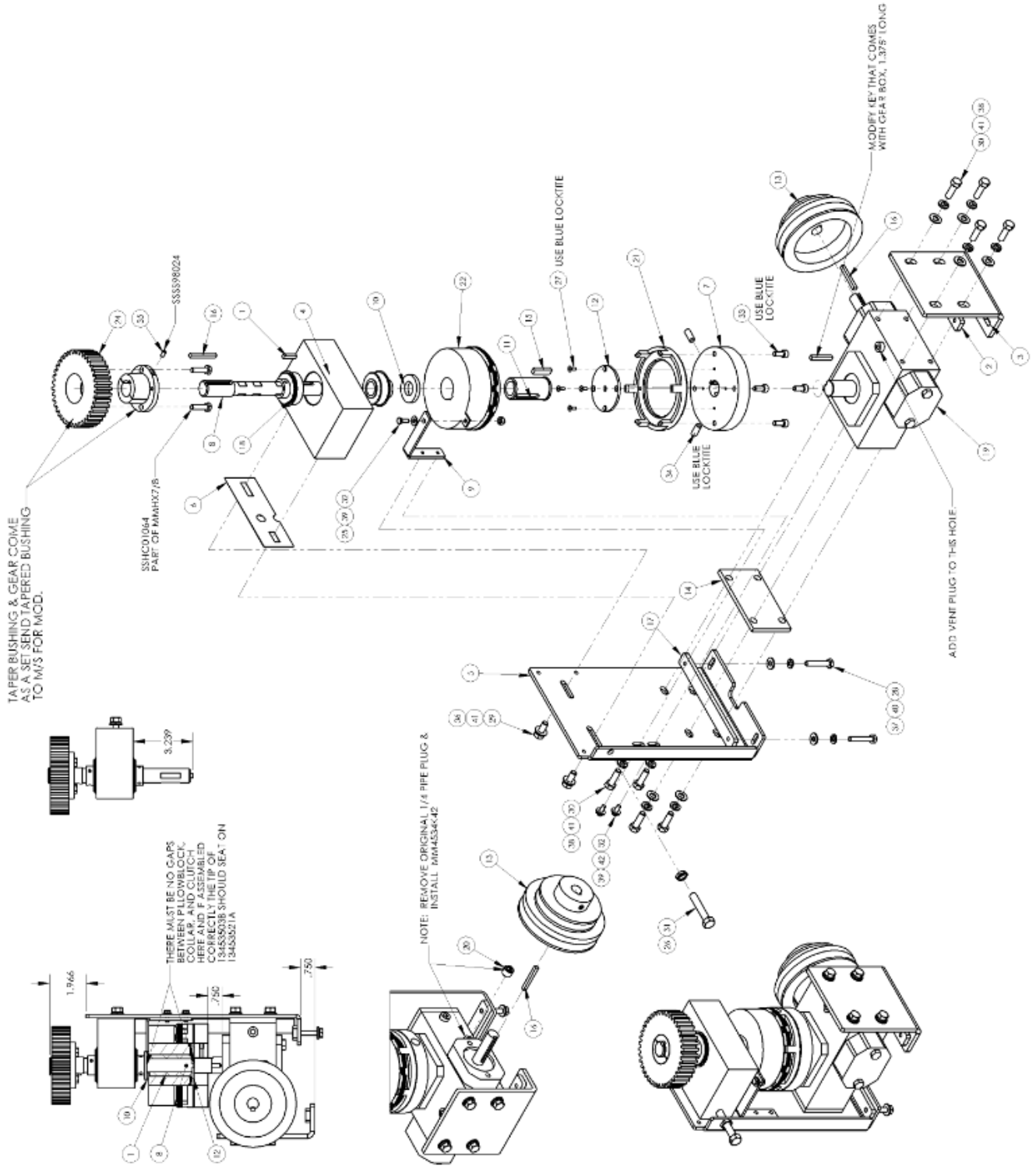
NO.	QTY	PART #	DESCRIPTION
1	1	13453401A	CARRIAGE GUIDE FRAME ASSY
2	2	13453404	ROLLER YOKE ASSY
3	2	13453408	GUIDE ARM ASSY.
4	2	13453411	STUD, ROLLER BEARING
5	2	13453413	ROLLER, GUIDE
6	4	13453414	HUB, ROLLER GUIDE
7	1	13453415	PLATE, CABLE HOLDER
8	1	13453416	MOUNT, CABLE GUIDE
9	1	13453418	MOUNT, BEARING BLOCK, REA
10	4	BB1L017	BEARING,BALL,.787B
11	2	BB305702C	BEARING,CAMROLLER
12	1	FF3460	STRAIN RELIEF,LIQ TIGHT
13	1	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK
14	2	MM1095K44	GREASE FITTING, 1/4-28
15	4	MMH0-185	CLIP RING INT,1.962 OD
16	2	MMSH-59	CLIP RING EXT, .546 ID
17	2	NNE1/2-13	NUT,NYLOCK,1/2-13
18	2	NNH1/2-13	NUT,HEX,1/2-13
19	1	NNH3/8-16	3/8-16 HEX NUT
20	2	SSBC98032	#10-32 X 1/2 BUT HEAD
21	1	SSHC25080	3/8-16 X 1-1/4 HEX HEAD
22	2	SSHC25128	3/8-16 X 2 HEX HEAD
23	2	SSHC45192	1/2-13 X 3 HEX HEAD
24	2	SSSS01040	SCREW, SET, 1/4-20 X 5/8
25	2	WWFS1/2	WASHER,FLAT,SAE,1/2
26	2	WWFS10	WASHER, FLAT, #10, SAE
27	2	WWFS3/8	WASHER,FLAT,SAE,3/8
28	2	WWL10	#10 LW
29	2	WWL3/8	WASHER, LOCK, 3/8



134539000B Control Box Assembly

AAC Drawing Number 9001397 Rev 3

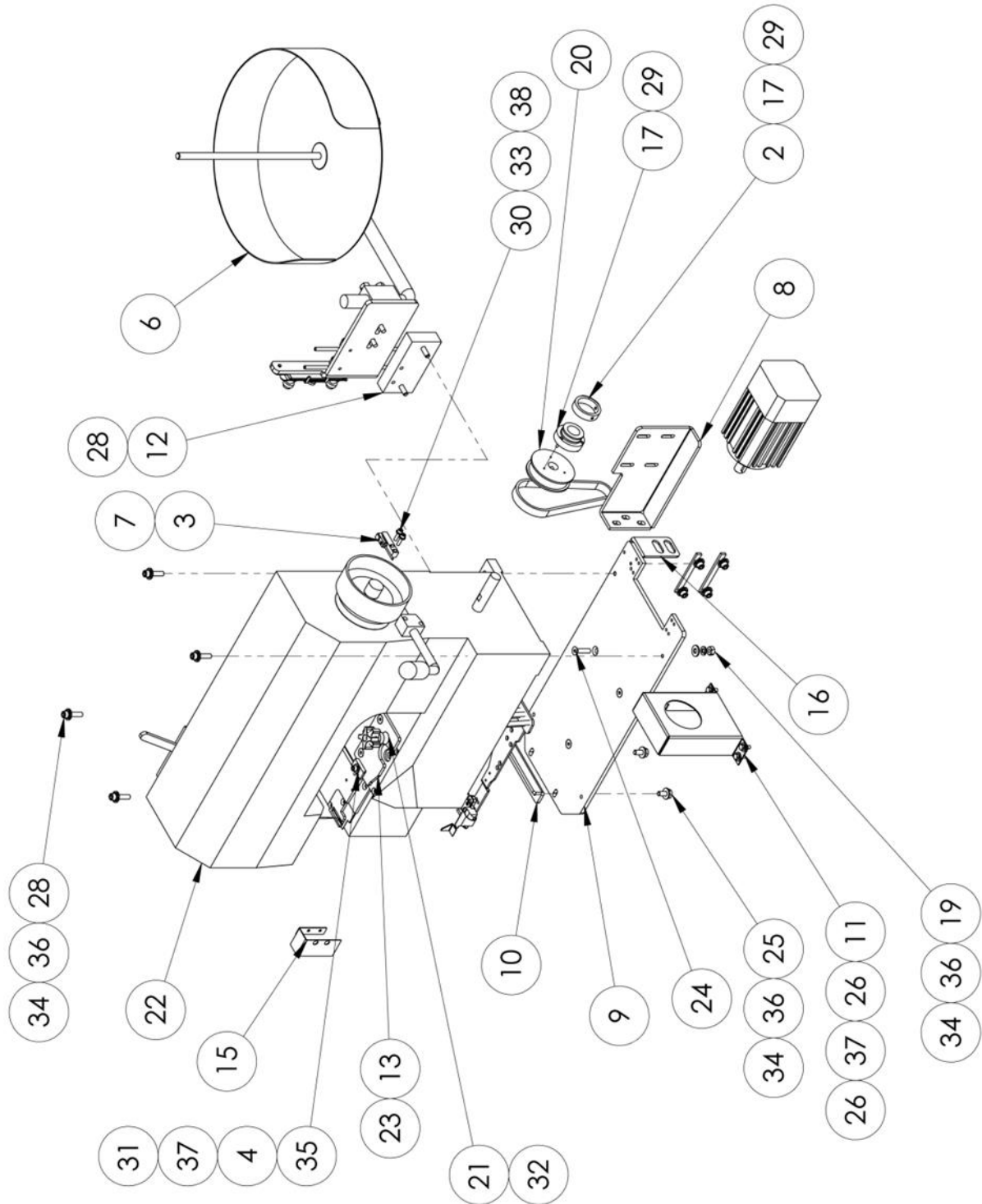
NO.	QTY	PART#	DESCRIPTION
1	1	1345-5WD1	DIAGRAM, WIRING
2	1	1345LAB1	LABEL
3	1	13459001B	SUB PANEL, CARRIAGE -3&4B
4	1	13459004A	MOUNTING BRACKET, CAPACIT
3	1	13459006	CONTROL BOX 11345
6	6	AAF3/16	CLAMP, BLACK PLASTIC
7	1	FF1N4937	DIODE,FAST 200NS,1A
8	54	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
9	2	FF264-347	TERMBLK,WAGO,TOP,DUAL,GRN
10	5	FF264-371	TERMBLK,WAGO,TOP,END
11	10'*	FF7439A	CABLE, 9 COND, 14GA
12	1	FFL722C	BREAKER, CIRCT. THERM-MAG
13	1	FFR4.7K	RESISTOR, 4.7K, 1/4W.5%
14	3	FFR47	RESISTOR, 47, 1/4W
15	1	MM1770A12	DOOR LATCH, CAM, KEYED
16	6	MM9376K141	ISOLATOR, URETHANE
17	1	MM40450010	FASTENER,SLIDE LOCK
18	10	NNK8-32	NUT,KEP,8-32
19	8	SSPP90024	8-32X3/8 PAN PHLPS
20	1	SSPP90032	SCREW,8-32 PAN HD PHIL
21	6	SSSC90056	#8-32 X 7/8 SOC CAP SC
22	2	TTSRBS82908	TERMINAL,STAR RING,#8,14-18
23	6	WWF8	WASHER, FLAT, #8
24	8	WWL8	WASHER,LOCK,#8



13453500E Gear Box Assembly

AAC Drawing Number 9003675 Rev 0

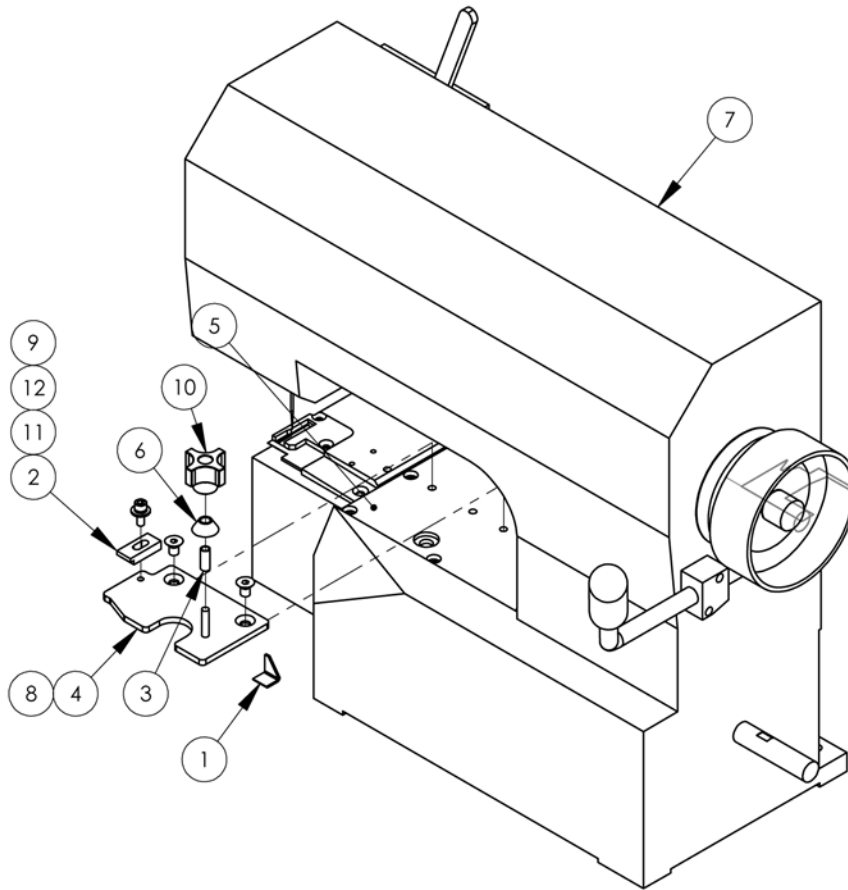
ITEM	QTY.	PART NUMBER	DESCRIPTION	ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	132556-258	KEY, 3/16 X .813 L	22	1	MM231631M1	CLUTCH, MOD, 1345
2	1	1345041	NUT PLATE, 1/4-20X3.25				
3	1	1345167	BRKT, GEAR BOX, LOWER	24	1	MMS1040	GEAR, 40T, 10P
4	1	1345176	BLOCK, BEARING MOUNTING	25	1	NNE10-32	NUT, ELASTIC LOCK
5	1	1345178	PLATE, GEAR BOX	26	1	NNJ3/8-24	3/8-24 JAM NUT
6	1	1345359	SHIM, BEARING MOUNTING	27	4	SSF80024	6-32 X 3/8 FLAT CAP
7	1	13453501	PLATE, CLUTCH ADAPTER	28	2	SSH01096	1/4-20 X 1-1/2 HHCS
8	1	13453503B	SHAFT, GEAR DRIVE	29	2	SSH010048	5/16-18 X 3/4 HHCS
9	1	13453512A	BRKT, ANTI ROTATE, CLUTCH	30	8	SSH010064	5/16-18 X 1 HHCS
10	1	13453514	SPACER, CLUTCH	31	1	SSH035128F	3/8-24 X 2.0 FULL THD
11	1	13453516	SLEEVE, CLUTCH	32	3	SSH098032	10-32X1/2 HEX HD
12	1	13453519A	PLATE, CLUTCH, LOWER	33	4	SSSCM6X15	M6X15 SOC CAP SCREW
13	1	13453521A	PULLEY, DRIVE	34	2	SSSS10048	5/16-18X3/4
14	1	13453522	SPACER, GEAR BOX	35	AR	SSSS98024	10-32X 3/8 SOC SET SC
15	1	13453523	KEY, 5MM X8MM X 1 1/4	36	2	WWF5/16S	WASHER, FLAT, 5/16 NARROW
16	2	13453524	KEY, 3/16 X 1 .68L	37	2	WWFS1/4	WASHER, FLAT, SAE, 1/4
17	1	13453532	NUT PLATE, 1/4-20X5.75	38	8	WWFS5/16	WASHER, FLAT, SAE, 5/16
18	2	BBS8703-88	BEARING, BALL, .75IDX1.75OD	39	3	WWFS10	WASHER, FLAT, #10, SAE
19	1	MM20UM1	GEAR BOX, MOD.	40	2	WWL1/4	WASHER, LOCK, 1/4
20	1	MM4534K42	PLUG, FLUSH, 1/4" PIPE	41	10	WWL5/16	WASHER, LOCK, 5/16
21	1	MM231572	COUPLING	42	2	WWL10	WASHER, LOCK, #10



SPF5625-657-02M Sewing Head

AAC Drawing Number 9002943 Rev 4

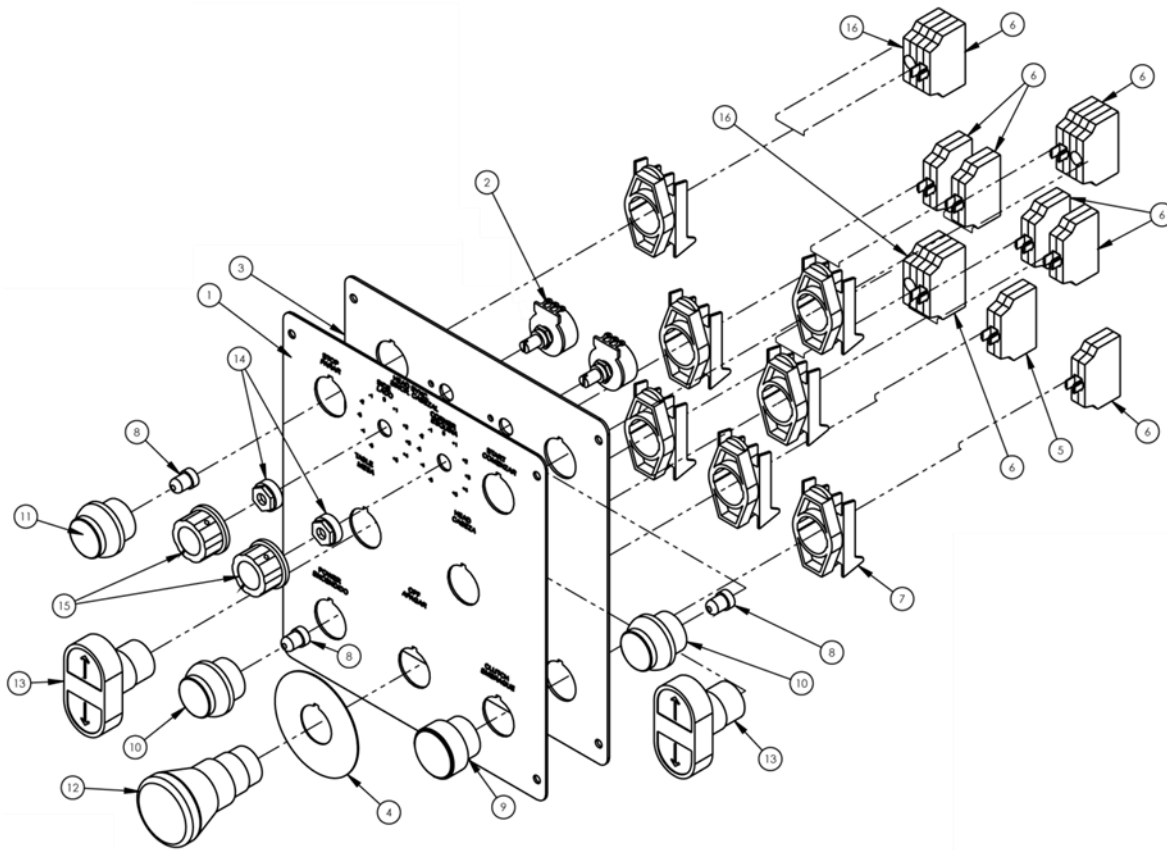
NO	QTY	PART #	DESCRIPTION
1	1*	91-149-219-	FOOT,PRESSER,LIFTING,MOD
2	1	311-129	SLEEVE TAPE MOUNT ADJUST
3	1	1278-7055D	PROX SWITCH W/PLUG,12"
4	1	1345-004	BLOCK, STOP FOR BINDER
5	1	1345-009B	SLEEVE,.25 ODX.19 IDX.5LS
6	1	1345-025	TAPE ROLL HOLDER ASSY
7	1	1345-505	BLOCK, FOOT UP SENSOR
8	1	1345137	BRKT, MOTOR MOUNT
9	1	1345138	PLATE,BASE PFAFF 5625
10	1	1345139	ANGLE, STOP, HEAD MOUNT
11	1	1345140	BELT, GUARD, PFAFF 5625
12	1	1345141	PLATE,ADAPTER
13	1	1345142	PLATE,ADAPTER,SWING OUT
14	1	1345147	PLATE,TOP MOD.
15	1	1345412	TAKE-UP GUARD, PFAFF
16	1	1366099	BRACKET, EYE MOUNT
17	1	13453646	TAPE MOUNT, PULLEY
18	1	GG150L050	BELT, 3/8P, 40T, 1/2W
19	3	NNH1/4-20	NUT,HEX,1/4-20
20	1	PP20LB050M5	PULLEY,GEAR,3/8P,15MM B
21	1	RRBEEHIVEH	SPRING,HEAVY BEEHIVE
22	1	SPF5625-65702A	HEAD,PFAFF TAPE EDGE,
23	2	SSFC01024	1/4-20 X 3/8 FLAT CAP
24	3	SSFC01064	1/4-20 X 1 FLAT CAP
25	2	SSHC01040	1/4-20 X 5/8 HHCS
26	4	SSHC98032	10-32X1/2 HEX HD
27	1	SPPS50024	2-56 X 3/8 PAN HD SC
28	6	SSSC01064	1/4-20 X 1 SOC CAP
29	3	SSSC70032	4-40 X 1/2 SOCKET CAP
30	2	SSSC90040	8-32 X 5/8 SOC CAP SC
31	1	SSSC98032	10-32X1/2, SOC CAP
32	1	TTCL1APPK1	PLASTIC KNOB, #10-32
33	2	WWB5/32	WASHER, FLAT, 5/32", BRAS
34	9	WWFS1/4	WASHER,FLAT,SAE,1/4
35	5	WWFS10	WASHER, FLAT, #10, SAE
36	9	WWL1/4	WASHER,LOCK, 1/4
37	5	WWL10	WASHER,LOCK,#10
38	2	WWSI8	WASHER,INT. TOOTH,8



SPF5625-65702A Head, Pfaff Tape Edge

AAC Drawing Number 9004887 Rev 1

NO	QTY	PART #	DESCRIPTION
1	1	91-149-219-91M1	FOOT,PRESSER,LIFTING,MOD
2	1	1345-004	BLOCK, STOP FOR BINDER
3	1	1345-009B	SLEEVE,.25 ODX.19 IDX.5LS
4	1	1345142	PLATE,ADAPTER,SWING OUT
5	1	1345147	PLATE, TOP MOD.
6	1	RRBEEHIVEH	SPRING,HEAVY BEEHIVE
7	1	SPF5625-657/02	SEWING HEAD, PFAFF
8	2	SSFC01024	1/4-20 X 3/8 FLAT CAP
9	1	SSSC98032	10-32X1/2, SOC CAP
10	1	TTCL1APPK1	PLASTIC KNOB, #10-32
11	1	WWFS10	WASHER, FLAT, #10, SAE
12	1	WWL10	WASHER, LOCK, #10

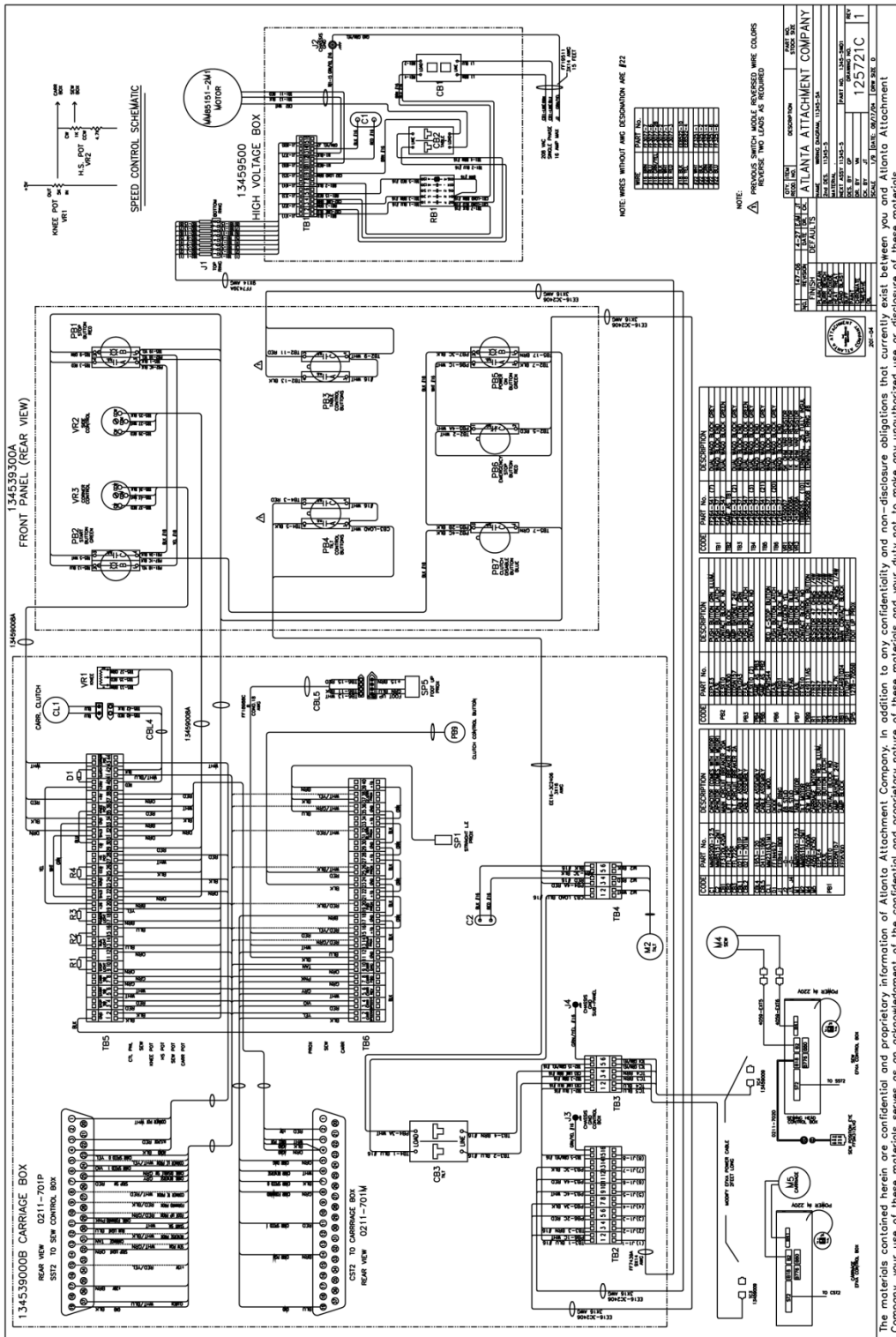


134539300A Control Button Panel

AAC Drawing Number 9001396 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	13453LAB1	LABEL, SWITCH PANEL
2	2	13459008A	CABLE, POT, IK, 4 FT.
3	1	13459301E	PANEL, CONTROL BUTTON 2
4	1	EE15Y	PLATE, LEGEND, YELLOW
5	1	EE3X01	BLOCK, P.B. CONTACT, N.C.
6	8	EE3X10	BLOCK, P.B. CONTACT, N.O.
7	7	EEA3L	LATCH, PUSH BUTTON
8	3	EED5N157	LAMP, INCONDECENT, BAYONET
9	1	EPPFA6	BUTTON, PUSH, BLU, FLUSH
10	2	EPPLE3	BUTTON, PUSH, GRN, ILLUM
11	1	EPPLE4	BUTTON, PUSH, RED, ILLUM
12	1	EPPMTS44	E-STOP BUTTON, TWIST REL.
13	2	EPPU2A3	BUTTON, PUSH 22MM, 2X, G MOM FLUSH
14	2	EESL110B	SHAFT LOCK, NYLON, 1/4"
15	2	FF274-416	KNOB, SPEED CONTROL
16	3	EED53D0	BLOCK, LAMP, 22MM P.B.

1345-5WD1 Wiring Diagram



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Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

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

Términos y Condiciones:

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

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

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



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Printed in the USA