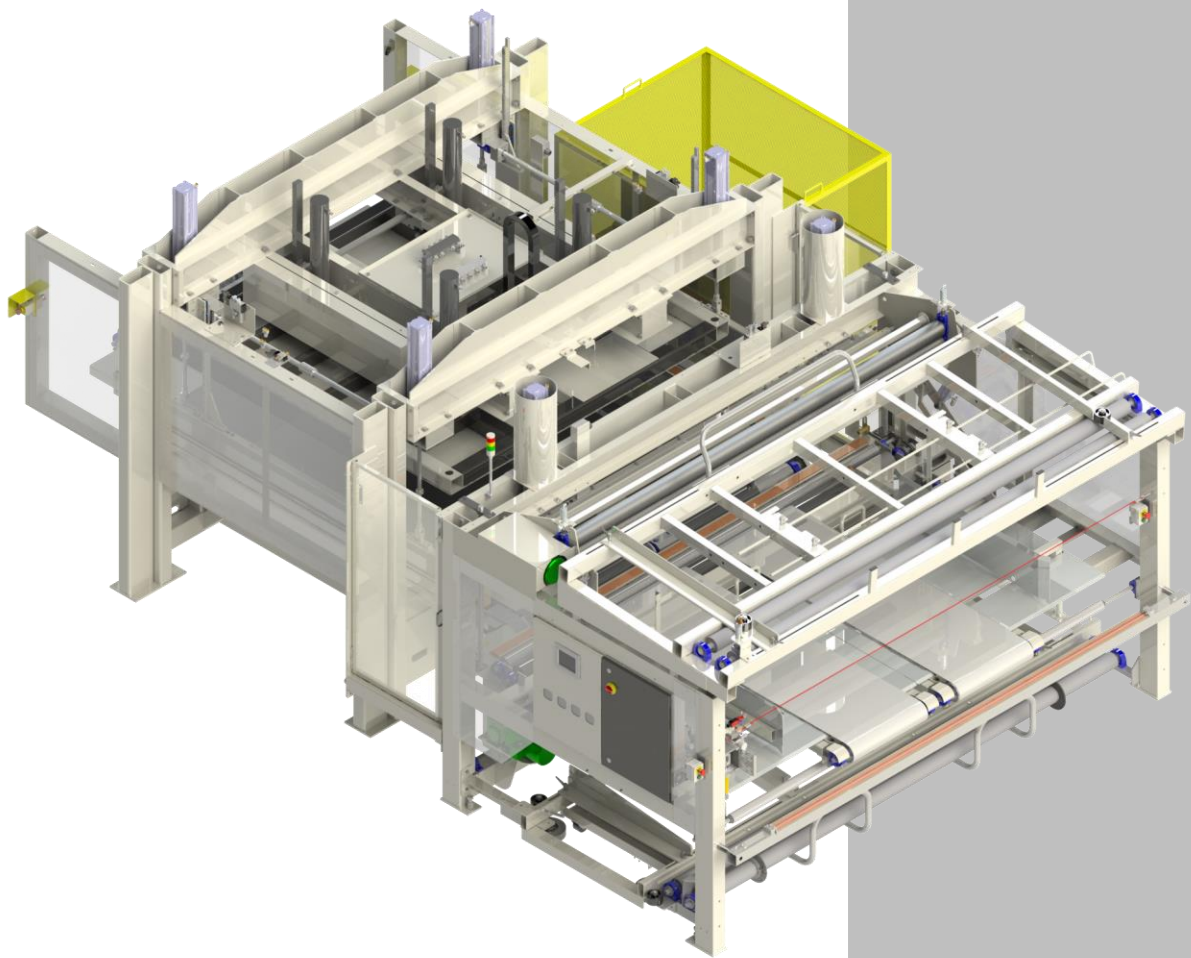




Model 1390HCB

Revision 3.2 Updated Sept.03, 2024(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 1390HCB Autopack should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include;

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

Intended Use

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

Exclusion of Misuse



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

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

Liability

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

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

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

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

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

Choice and Qualification of Personnel

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

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

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines



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

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

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

Damage

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

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

Faults or Errors

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

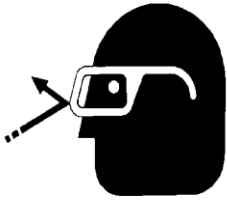
Signs on the Machine

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

Clothing, Jewelry, Protective Equipment

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

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

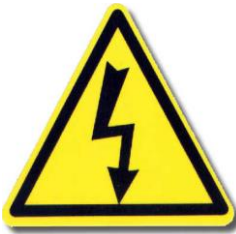
The following fire extinguishers may be used:

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

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

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

Electrical Power Supply



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

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

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

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

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

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

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

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

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

Workplace Environment

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

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

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

Protect against unauthorized access.

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

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

Local Regulations

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

Maintenance

General Safety Instructions

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

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

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

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

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

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

Repair

Replacement Parts

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

Repair, Electrical

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

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

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

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

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

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

Ventilation/Hazardous Gases

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

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

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

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

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

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

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

Component Identification

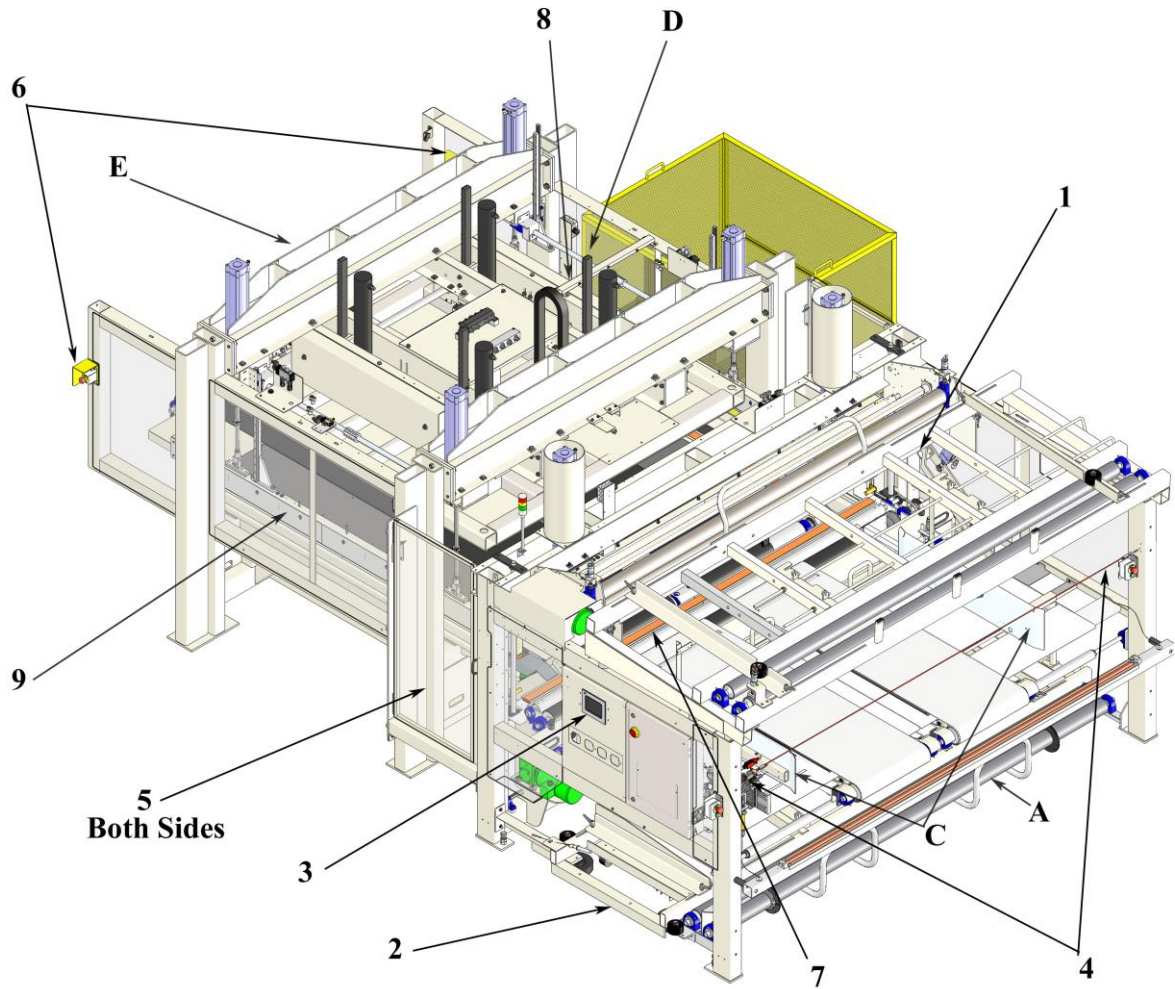


Figure 1

Machine Layout

Refer to Figure 1 on page *Error! Bookmark not defined.*

A. Infeed End

1. Top Film Roll storage
2. Bottom Film Roll Storage

B. Machine Controls

3. Touch Screen
4. Pause/Stop Cable
5. Side Doors
6. A Output Emergency Stops
6. B Input Emergency Stops

C. Alignment Area

- Right Side - Adjustable
- Left Side - Adjustable

D. Seal Area

7. Cross Seal
8. Right Side Seal – Fixed @ 94” Wide
9. Left Side Seal – Fixed @ 94” Wide
10. Compression 60 Tons

E. Outfeed End

F. Overhead roll holder and hoist Option for loading the Top Film rolls.

Machine Specifications

Capacity & Production Specs.

Max. Width of Infeed:	85”
Min. Width of Infeed:	29”
Max Height under Pressure Roller:	20”
Roll capacity, top & bottom (12” DIA)	4
Infeed/outfeed conveyor height (inch)	36.0
Overall height	108
Max Film width (inch)	120
Film width: Top (inch)	108
Film width: Bottom (inch)	108
Machine Weight (lbs.)	28,000
Shipping weight (lbs.)	30,000
Production Rate:	
2 Queens/min.	

NOTE: The machine has 3 adjustable width settings. They are typically set to 84" for Cal-Kings, 80" for Queen, XL Full and Twin beds, and 76" for regular Full and Twin beds. If required, the width settings can be set to any three positions desired, within the 72"-85" range. There is an optional 4th setting available.

Power Requirements

Volts	480 V, 3-phase 50/60 Hz
Amps	60A/Leg
Air Consumption in SCFM	35 SCFM
Air Pressure	80 Psi
Power and Air Connection	Left, Mid, Side

Physical Specs:

Infeed/Outfeed Conveyor Height	36"
Overall Dimensions	20'w X 17'l X 9'h
Overall Height w/ Hoist Option	13'
Weight (w/o Crane or Compression)	28000lbs
Max Film Width Top or Bottom	120"
Typical Film Width - Top (Up To 16in Bed Thk.)	108"
Typical Film Width - Bottom	108"
Roll Capacity (Top & Bottom)	4 Rolls (12" Dia.)

Pressure Gauge Settings:

Main Pressure	70-80psi
Film Roll Brake Pressure	5 -10psi
Input light Press. Roller (white PVC)	50psi

Mattress Size Limitations:

Feed in 84" Wide	20" mattress height
------------------------	---------------------

Machine Safety

The 1390B Auto-Pack is large machine and has many powerful drives and mechanisms.

ANYONE assigned to operate and/or maintain this machine must be properly trained by an Atlanta Attachment technician, or a trained and qualified factory mechanic. Operation and/or maintenance of this machine by untrained personnel may result in a serious injury or even death.

ANYONE assigned to operate and/or maintain this machine, must read, understand, and follow the safety instructions and guidelines listed below mentioned in following pages.

ANYONE assigned to operate or maintain this machine **MUST READ AND BE FAMILIAR** with the location and operation of ALL operator machine controls, with particular emphasis on the following:

Main Electrical Power ON/OFF switch

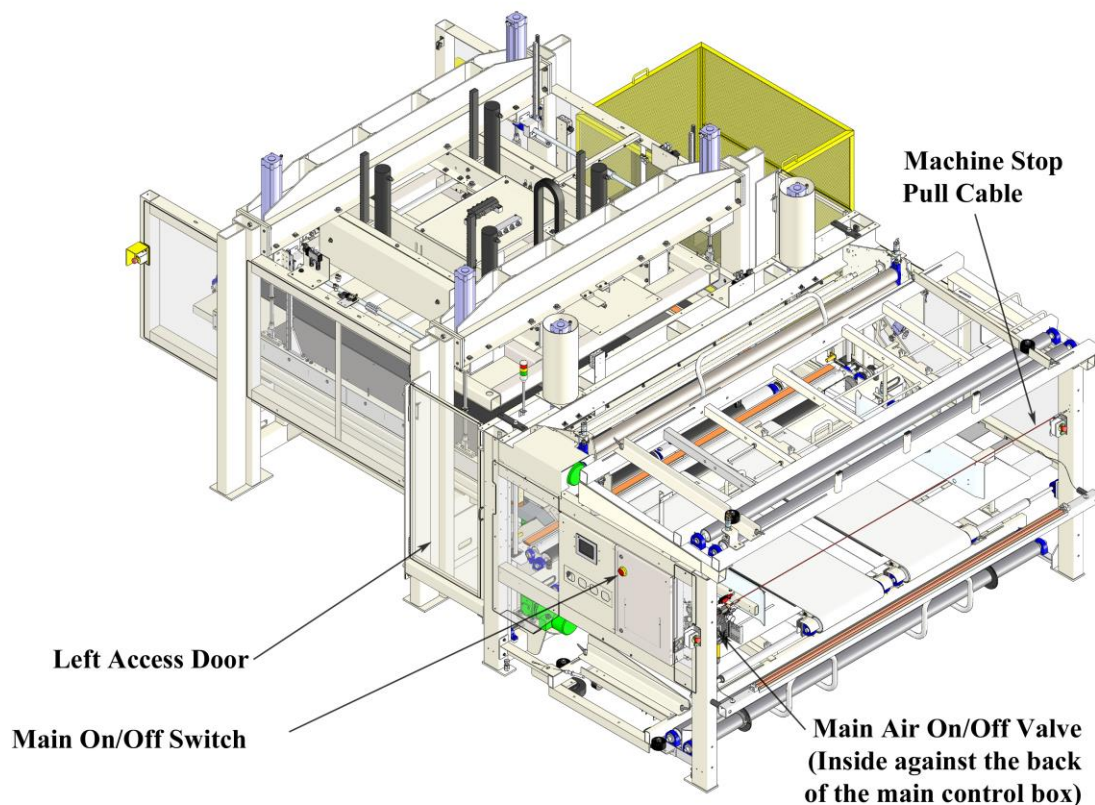
Main Air Supply ON/OFF valve

Four Emergency-Stops, located on:

- Main Control Box
- Remote Operator Box
- Left Output post
- Right Output post

Machine STOPS include:

- The Input PULL CABLE STOP
- The main panel STOP push button
- The Remote Operator Panel STOP push button
- The two side Access Doors.



WARNING 1

In auto mode, this machine can start automatically at any time. Therefore, when the machine is turned on:

- NEVER ENTER INSIDE THE MACHINE
- NEVER CRAWL UNDER THE MACHINE
- NEVER CLIMB ON TOP OF THE MACHINE
- NEVER REACH INSIDE THE MACHINE FOR ANY REASON
- NEVER PLACE ANY PART OF YOUR BODY INSIDE THE MACHINE

WARNING 2

In manual mode, this machine may be prompted to execute any of its functions. Therefore, to prevent injury or machine damage, only a properly trained operator or mechanic should use the machine in this mode of operation.

WARNING 3

To perform any machine maintenance always follow steps below:

1. FIRST, POWER DOWN THE MACHINE AND LOCK-OUT THE ELECTRICAL AND THE PNEUMATIC POWER SOURCES.
2. WAIT UNTIL SEAL BARS COOL OFF SUFFICIENTLY (APROX. 3 HOURS) BEFORE SERVICING THE SEAL BARS OR THE NEARBY AREAS OF THE MACHINE.

NOTE: If machine maintenance is absolutely necessary before seal bars have sufficiently cooled off, a service person must wear OSHA approved safety gear to protect him/her from a potential burns.

Machine Operation

Machine Start (Cold)

1. Turn the Main On/Off switch to the ON position. See Fig. 3.
2. Turn the Main Air valve to the ON position. The pressure gauge should be set to 80 PSI. See Fig. 4.
3. Press the green POWER ON push button. See Fig. 5.

The Seal Bars begin to heat up at this point. It takes approx. 30 minutes to get the Seal Bars to their operating temperature.

Note: The Standard machine Temperature Settings are:

Side Seal Bars - 325 °F (w/o boot film)

Cross Seal Bar - 345 °F

Note: Under the normal machine conditions, the start screen will appear on the touch screen. When the green light on the light tower is on, the machine has reached operating temperature and is ready to run. If the green light does not illuminate, it usually indicates that one or more Emergency Stops are not reset or other error condition exists. Refer to “Light Tower Indicator” on page 24 of this manual for further light tower color explanation.

4. Wait for all three Seal Bars to heat up to their preset temperatures. It will take approx. 20-30 minutes depending on the room temperature.

Note: The Seal Bars will not seal properly until they reach their proper temperature.

After a short delay (approx. 5 sec.) the INPUT belts will turn on. Machine is now ready for production.

5. Press the Start button on the touch screen. See Fig 6.

Machine Start (Warm)

1. Wait for all three Seal Bars to heat up to their preset temperatures. It will take approx. 20-30 minutes depending on the room temperature.

Note: The Seal Bars will not seal properly until they reach their proper temperature.

2. Press the Start button on the touch screen. See Fig 6.
After a short delay (approx. 5 sec.) the INPUT belts will turn on. Machine is now ready for production.

Note: If the machine does not start and you do not get an error message on the screen, refer to the LIGHT TOWER INDICATOR on page 24 of this manual for additional information.

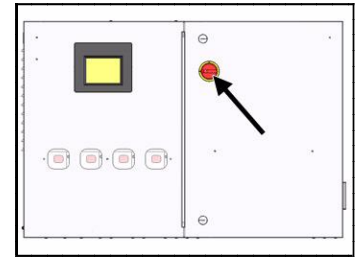


Fig. 3



Fig. 4 24 of

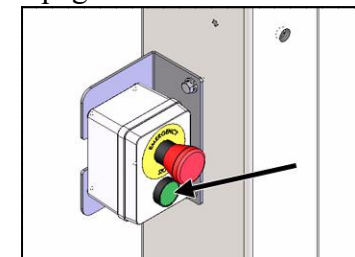


Fig. 5

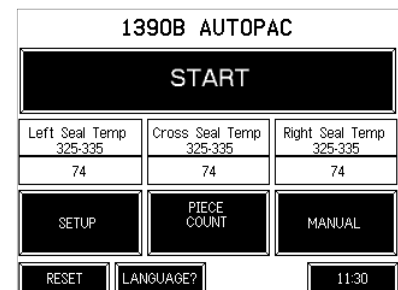


Fig. 6

Bottom Film Loading

The standard 1390HCB machine comes with a pull out Bottom Film Roll storage rack that can handle up to (3) 12” diameter x 120” long rolls of plastic film.

The Bottom Film Rack can be assembled two ways so it can be pulled out to the left or to the right of the machine for loading.

To load the rack:

1. Pull out the (2) locating/locking pins to (one on each side of the machine) unlock the rack from the rest of the machine.
2. Pull the rack out from under the machine far enough to load the rolls of film. Load three rolls using a standard fork lift or other means.

Important note!

The film rolls must be loaded such that they unwind clockwise, looking from the left side of the machine (see “Film Routing” on page 18).

3. Roll the rack back under the machine and insert the locating/locking pins.

The Bottom Film Roll Rack assembly has two roll release rods which allow the operator to advance one roll of film at a time into the Bottom Film Roll Cradle. The release rods are extended to the right end of the rack, so the rolls can be advanced with the rack assembly locked in place.



Figure 8

Top Film Loading

The standard 1390HCB machine comes with a Top Film Roll storage rack that can handle up to (4) 12” diameter x 120” long rolls of plastic film.

Important note! The film rolls must be loaded such that they unwind counter-clockwise, looking from the left side of the machine (see “Film Routing” on page 18).

Besides the standard top film roll rack, Atlanta Attachment Company offers two options to aid in the loading and storage of the Top Film Rolls:

1. Crane option - For installations with a limited space on each side of the machine. The crane lifting mechanism can be swiveled 360 degrees from the shown position this allows any orientation of rolls on the floor next to the machine.
2. Extended Top Roll Rack option - For installations where the rolls can only be loaded from the Output End of the machine. This option allows loading of up to (18) 12” diameter rolls on top of the machine. The Extended Roll Rack option excludes the Crane option due to space limitations on top of the machine.

If the side space is not limited, an operator can load the Top Film using a standard fork lift. The standard Top Film Roll Rack has (2) roll film release rods to allow the rolls to be advanced one at a time.

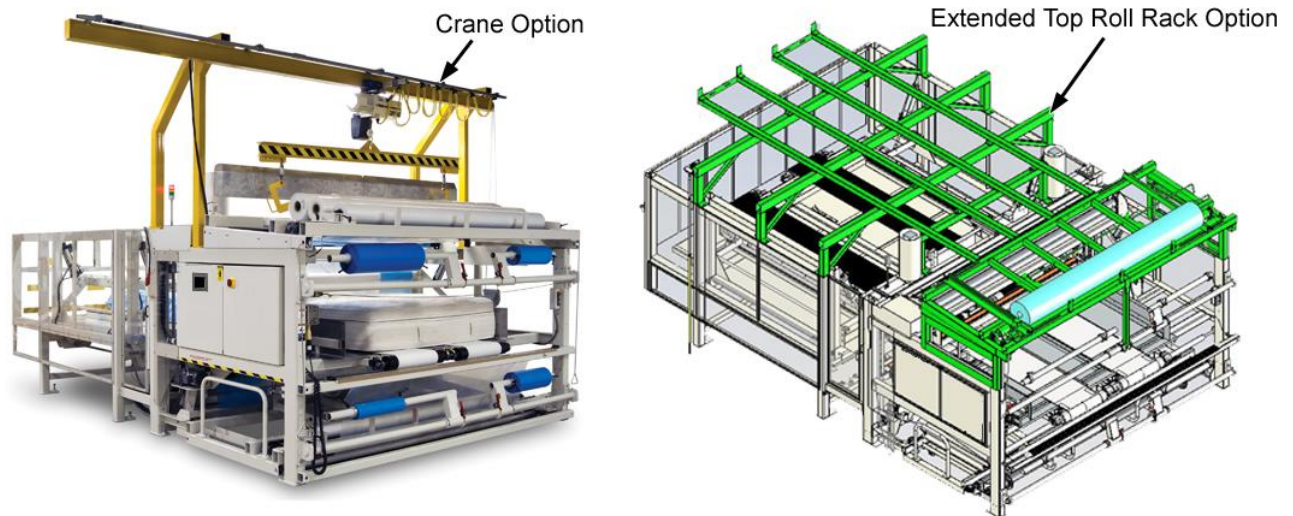


Figure 9

Film Routing

The Top and the Bottom plastic film routing is very important. The illustration below (Figure 11) must be carefully followed. For the operator's convenience, a copy of this illustration is attached to the left input post of the machine.

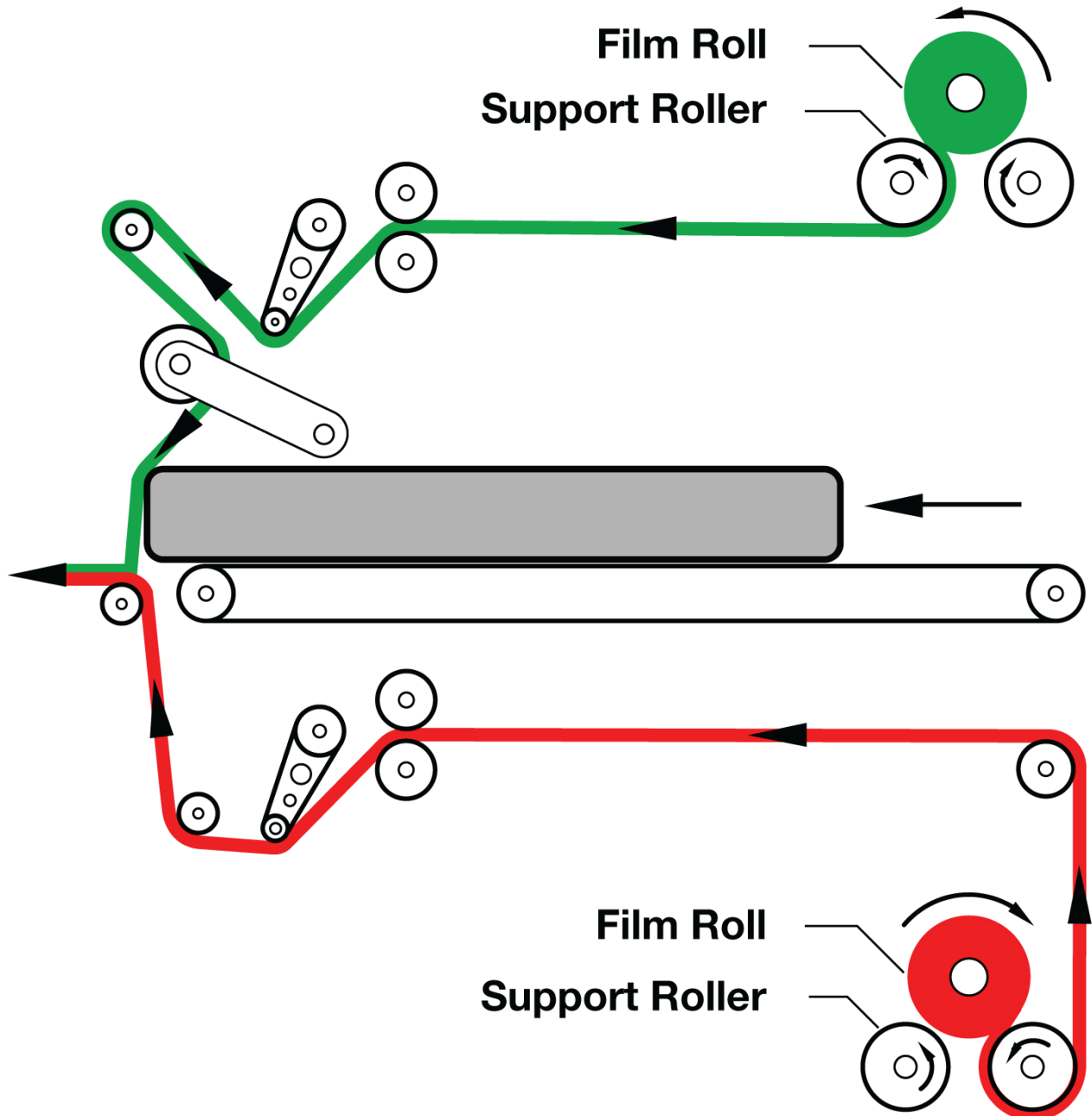


Figure 11

Film Splicing

1. When the plastic film runs out (from any roll), cut off the last 3 to 4 feet of it in order to eliminate any plastic that was adhered to the core and may have glue residue left on it. Make sure that there is no adhesive left on the film. If not removed, the adhesive will likely stick to the puller roller and wrap around causing a potential machine jam and/or machine component damage. In order to have enough film to make the splice, it may be necessary to reverse feed the roll being spliced. Before any reverse feeding top or bottom film rolls, one must feed the other film roll forward approximately the same amount.

2. Pull the emergency stop cord.

3. Use a hand held splicing tool (located in a cage on the back side of the main control box) to join the trailing edge of the old roll with the leading edge of the new roll. A specially designed splicing bar is mounted to the input end of the machine to aid the operator in holding film plies together and flat during the splicing process. This bar has (2) long angles mounted on it for guiding the sealing tool and for holding the film ends flat and in alignment.

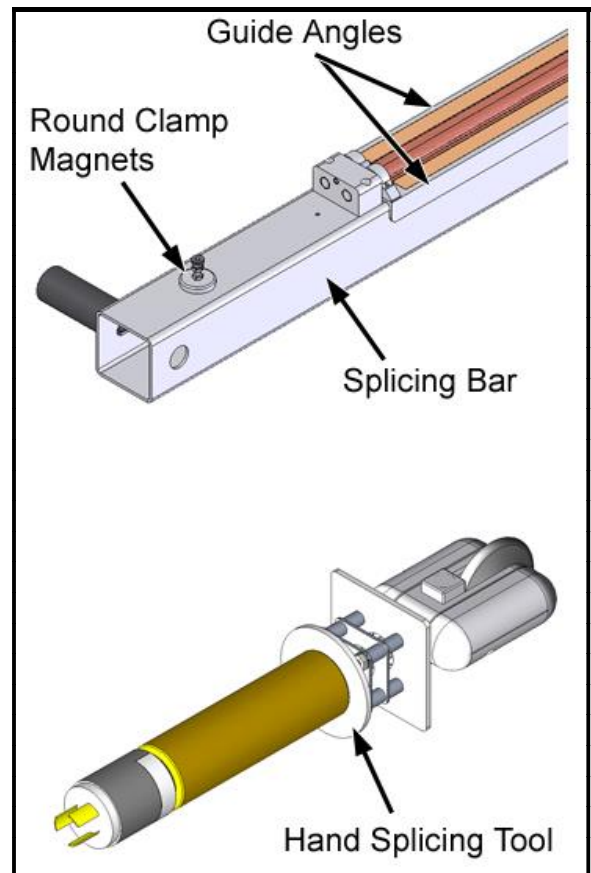
4. Lift the two angles up and rest them against one another. Insert the old film's trailing edge (approx. 3 to 4 inches of it) under the angles. Clamp the corners using the round magnets at each end.

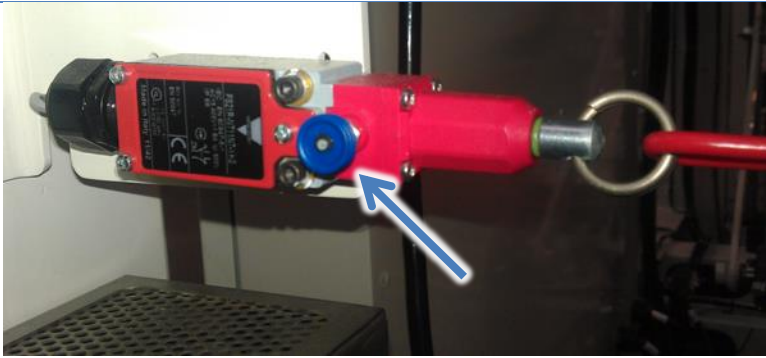
5. Pull enough plastic from the new roll and insert it under the angles on top of the old film.

6. Align the two edges and reuse the magnets to hold both corners together.

7. Lower the guide angles down and use the splicing tool to join the films. Press the tool wheel lightly against the ridge and slowly follow it to the other side. Repeat the same on the other side of the ridge on the way back.

8. Reset emergency switch by pulling the blue button.





Machine Controls

Main Screen

Figure 13

This is the main screen. From this screen you can start the machine, see the temperature of all three seal bars, and view the piece count. You can also access the setup, manual and piece count screens.

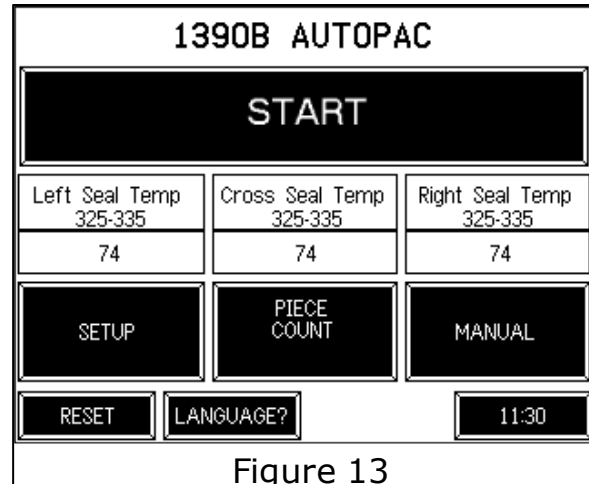


Figure 13

Piece Count

Figure 14

From this screen you can reset the piece count and/or the optional External count display.

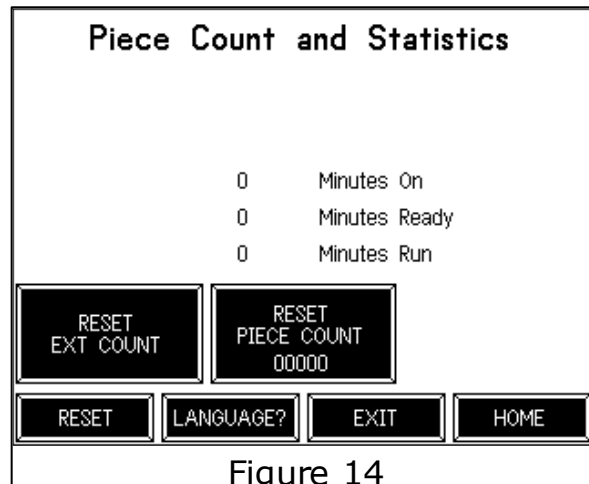


Figure 14

Manual 1

Figure 15

Pressing the Manual button on the Main screen will display the Manual 1 screen (Fig 15). Pressing the right and left arrows at the top allows access to Manual 2 (Fig 16a) and Manual 3 (Fig 16b).

Manual 1 provides controls for top and bottom film (loading, unloading, tracking, pleat correction) as well as the infeed conveyor and cross sealing.

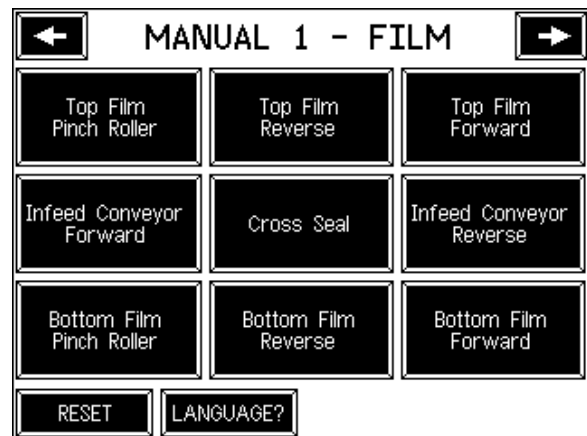


Figure 15

Manual 2

Figure 16a

Manual 2 provides controls for infeed sizing and outfeed sizing.

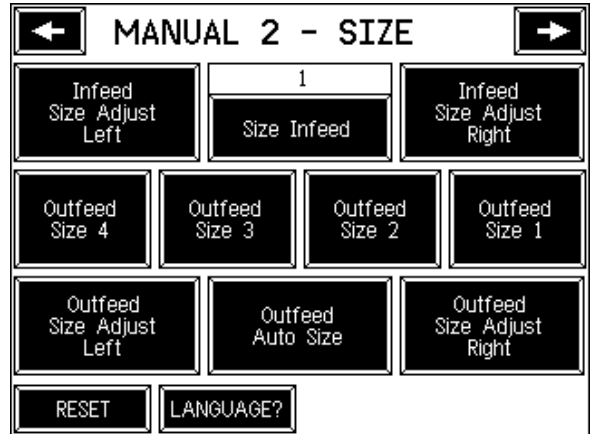


Figure 16a

Manual 3

Figure 16b

Manual 3 provides controls for the outfeed conveyor, cross sealing, side sealing. Note that pressing Reset will close the top and bottom film pinch rollers automatically.

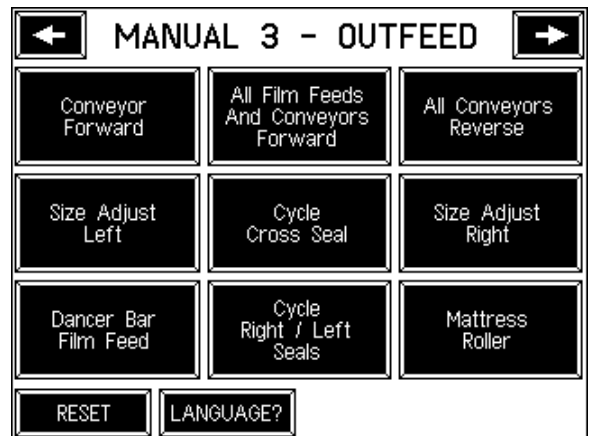


Figure 16b

Setup

Figure 17

Pressing the Setup button on the Main screen will bring you to the Setup screen. From here you can access advanced settings, advanced setup and advanced manual controls.

Note: When in the Advanced Manual screen, the heat to the seal bars is turned off.

Use extreme caution when in Advanced Manual mode.

Setup Seals

Figure 18

Pressing the Seal Setup button on the Advanced Setup screen will bring you to the Setup Seals screen. From this screen you can change the temperature and the dwell time. You can also activate the seal bars and feed film.

Note: It is recommended that the emergency stop and power on buttons be used for normal, everyday machine power up and power down needs. The main On/Off/Lockout switch should be used to turn the machine on or off during maintenance or other extended power down situations.

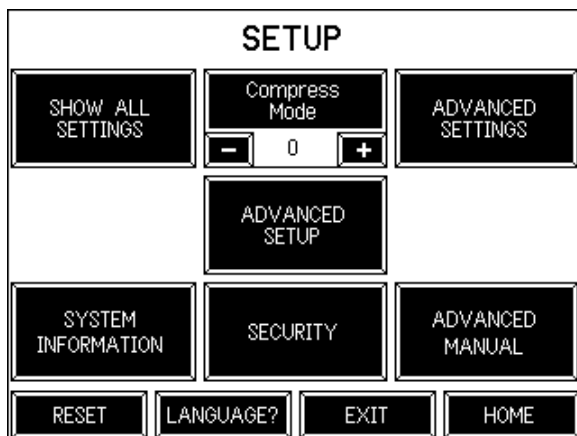


Figure 17

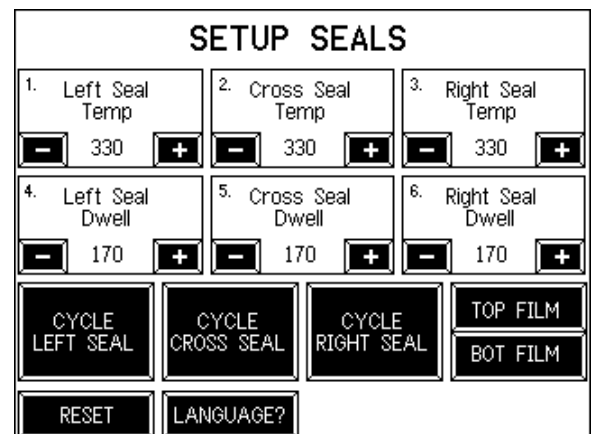
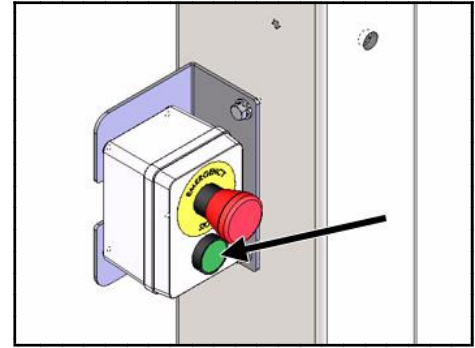


Figure 18

Other Operator Controls

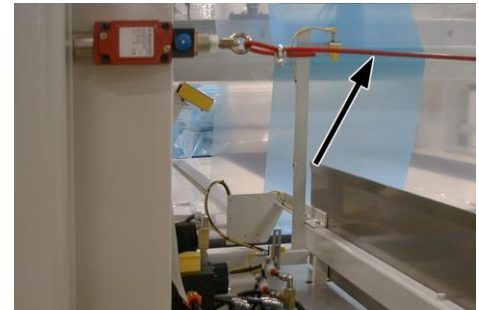
1. Emergency Stop & Power On -

allows the machine to be turned on and stopped.



2. Stop Pull Cable -

stretched above the INPUT conveyor in the loading area, allows the operator to quickly stop the machine in case of any problems.



3. Output Emergency Stops -

located on the output end of the machine. One e-stop is mounted on each end post for the operator convenience.



4. Side Doors -

located on each side of the machine, allow the mechanic easy access to the SEALING AREA to correct any problems.

Note: Side Doors can be used to stop the machine if necessary.



Light Tower Indicator

The LIGHT TOWER is designed to help the operator/mechanic in machine operation and troubleshooting.

- **YELLOW LIGHT ON** means that the machine is out of the Top or the Bottom film. (Heaters On)
- **RED LIGHT ON** means that one or both side doors are open, or the Pull (red) Cable switch is activated. (Heaters On)
- **RED LIGHT FLASHING** means the seal bars are too hot.
- **GREEN LIGHT ON** means that the machine is ready to run. It comes on as soon as the POWER ON button is pressed, and there are no faults to prevent the machine from running.
- **GREEN LIGHT FLASHING** means the seal bars are heating up and have not yet reached operating temperature.



Note: To start the machine, the MACHINE START button on the touch screen may need to be pressed.

- **ALL LIGHTS OFF** means that one or more of the E-STOP buttons are pressed, or the Main Power is turned OFF, or otherwise disabled.

Note: If the above indications do not solve the problem, please refer to “Troubleshooting” on page 43 of this manual for additional help or call Atlanta Attachment Company’s service department at 770-963-7369.

Motor Drives and Settings

The 1390B machine has four motor drives. The following images below show the physical drive locations. The table in the bottom right corner shows the drive machine parameters and their settings. These parameters may vary slightly based on the final installation requirements. To edit these drive parameters, refer to “Editing Motor Drive Parameters” on page 26. If the parameters have to be modified, record the new settings and keep them with this manual for future reference.

Note: Do not change any of the other drive parameters, leave them as defaults.



Input Conveyor Drive



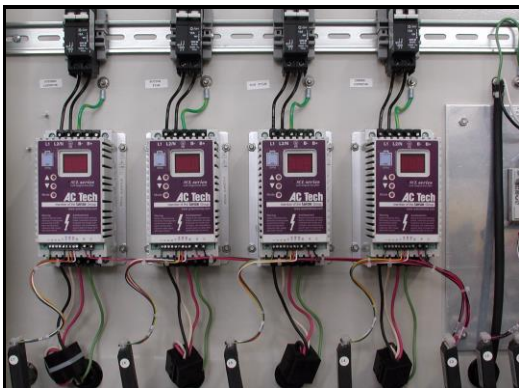
Output Conveyor Drive



Top Film Drive



Bottom Film Drive



Drive Controllers

Editing Motor Drive Parameters

In effort to minimize the amount of information that the operator/mechanic has to look through, only the pages that pertain to the drive programming and drive faults are shown here. For more information refer to the manufacturer’s (AC Tech) manual included with the machine.

Motor Drive Parameters

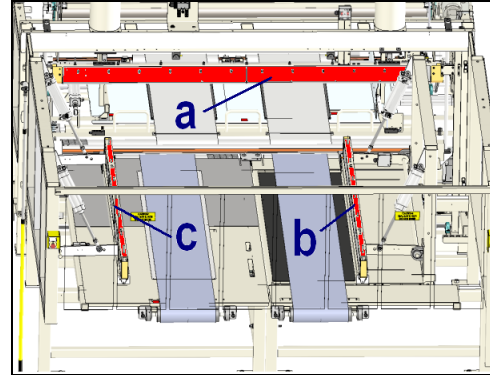
Note: A Complete Motor Drive User Manual is included in the machine documentation package.

PARAMETER	DESCRIPTION	OUTFEED DRIVE	BOTTOM FILM	TOP FILM	INFEED DRIVE
1	208/230	02/01	02/01	02/01	02/01
2	DEFAULT	02	02	02	02
3	DEFAULT	01	01	01	01
4	RAMP DECEL	03	03	03	03
5	PRESET 1	02	02	02	02
6	DRIVE OK	03	03	03	03
10	TB-13A = REVERSE	06	06	06	06
11	TB-13B = PRESETS	04	04	04	04
12	TB-13C = PRESETS	04	04	04	04
14	DEFAULT	01	01	01	01
16	DEFAULT	02	02	02	02
17	ROT. FWD AND REV	02	02	02	02
19	ACCEL	.8	0.3	0.3	.8
20	DECEL	.2	.4	.4	.2
21	DEFAULT	0.0	0.0	0.0	0.0
22	DEFAULT	0.0	0.0	0.0	0.0
23	DEFAULT	0.0	0.0	0.0	0.0
24	MAX FEQUENCY	60.0	60.0	60.0	60.0
25	208/230	150/180	150/180	150/180	150/180
26	DEFAULT	100	100	100	100
27	BASE FREQUENCY	60.0	60.0	60.0	60.0
28	208/230	20/10	20/10	20/10	20/10
29	DEFAULT	0.0	0.0	0.0	0.0
30	DEFAULT	0.00	0.00	0.00	0.00
31	SPEED 1	25.0	20.0	20.0	25.0
32	SPEED 3	40.0	56.0(51.6*)	50.0(51.6*)	40.0
33	SPEED 2	20.0	46.9 (45.2*)	40.0(45.2*)	20.0
34	DEFAULT	0.0	0.0	0.0	0.0
35	DEFAULT	0.0	0.0	0.0	0.0
36	SPEED 4	60	60.0	60.0	60
37	DEFAULT	0.0	0.0	0.0	0.0
* If rollers are rubber coated					

Seal Bar Maintenance and Replacement

WARNING: Wait until the heat sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.

The unit has three (3) heat sealing bars. (a-cross seal), (b-right seal), and (c-left seal). The optimum temperature and the dwell settings depend on the type of plastic film being used, the thickness of the film, and the bag construction. For instance, if the requirement is for boot plastic only at one end of the bed, this means there are four plies of plastic on one side, but only two plies on the other side. Furthermore, the Cross Seal has to seal four plies on one end, and only two on the other. Due to the variations such as that, the dwell times and/or the temperature are fine-tuned during the machine installation. After Installation if the packaging variables ever change, the dwell time in most cases is the only correction needed for a proper weld.



Temperature Settings

Standard temperature settings of the heat sealing bars are as follows:

Sealing Bar	Temperature ° F / ° C	Closing Time
Cross Seal No Boot	325 ° F / 162 ° C	170 a 200
Right edge No Boot	325 ° F / 162 ° C	170 a 200
Left edge No Boot	325 ° F / 162 ° C	170 a 200

The left seal thermo coupler is monitored by the # 27 module, the right seal is module # 35 and the cross seal is module # 22.

Seal power left, right, cross seal and manual seal are controlled by modules # 11 and # 12.

There are four major variables for obtaining a good weld.

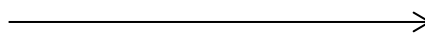
1. Temperature: The value is set via the control panel. The degrees are expressed in Fahrenheit. Try not to alter the temperature settings as much as possible. A variation of 5 degrees in Fahrenheit temperature will change the clarity of welded materials. Always adjust the dwell time first.

2. Time: The value is set via the control panel. Sealing time is expressed in 0.01 seconds, or 100 equals one second.

3. Pressure: A value that is set by the stroke of the air cylinders from the factory. Unless you are changing the seal rail system height, leave settings as they are.

4. Condition of seal bars: upper seal bars black coating is smooth with no cut or scraps and a dull finish. Lower seal bed smooth with not cuts and a shiny finish on tape.

Note: *The Machine is configured to operate with two sheets of 3 mill plastic from the factory. If the thickness changes, you should only have to adjust the dwell. More Heat and pressure can create expensive problems later.*

Explanation of chart written out below: 

(a) Temperature and Time Correct. The plastic appears melted with small bubbles and a connecting line between the bubbles. The solder is constant throughout.

(b) Excessive time or temperature. The melted plastic bubble appears irregularly, several of which are joined together and in some cases bundling between these portions.

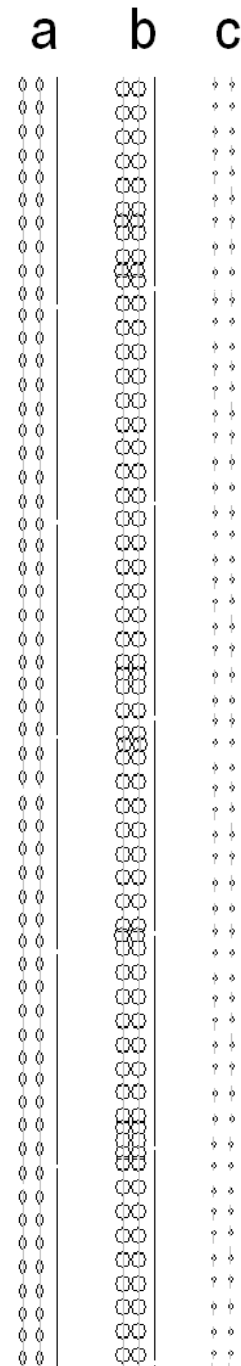
The weld is not constant throughout.

(c) Lack of time or temperature. The plastic melted with small bubbles appear regularly without union between these parts.

The weld looks constant without proper seal.

Cleaning seal bars: for best performance, seal bars should be kept clean, clean whenever necessary with a soft cloth dampened with WD-40. Be very careful not to scratch or disturb the coating on the upper heat seal bar as this will cause sticking and film buildup and poor seal quality.

Very Important Note: *If you are having issues with a complete seal, (for example the rear), check for air movement around the machine. A large fan overhead near the 1390 can cool the seal bar enough to make you think you need to add heat or pressure to correct the problem. This is not always the best solution. **Always be aware of your surroundings before changing any settings.***



Side Sealing Bars

WARNING: Wait until the heat sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.

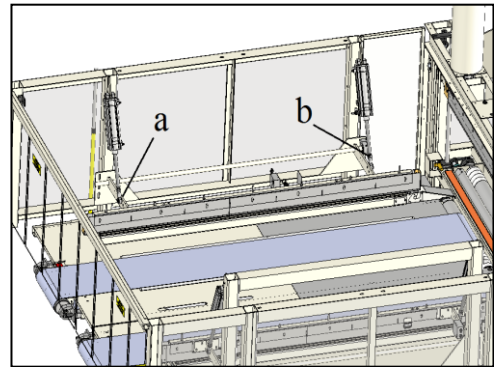
Refer to table on page **Error! Bookmark not defined.** for details

(A). - Welding is even and the depth of a weld's right.

The melted plastic appears with small bubbles and a connecting line between these bubbles. The weld is constant throughout.

(B). - Sealing bars are too deep

To set the depth of the shaft, loosen the nuts (a), (b) and rotate the cylinder shaft clockwise from top view on both cylinders which support the seal bars. Rotate the shaft ¼ turn at a time, and test the quality of the seal between each setting.



(C). - Heat sealing bars Lack depth.

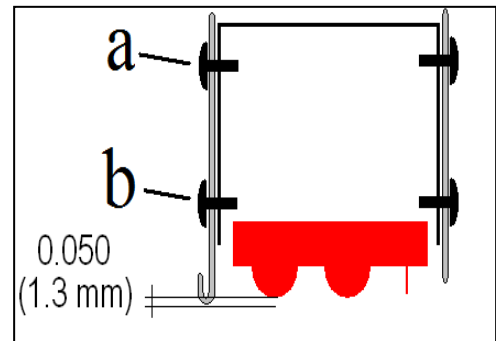
Adjust the height of the shaft, loosen the nuts (a), (b) and rotate cylinder shaft counterclockwise from top view on both cylinders which support the seal bars. Rotate the shaft ¼ turn at a time, and test the quality of the seal between each setting.

(D). - Heat sealing bar is not parallel with the non-stick tape lengthwise.

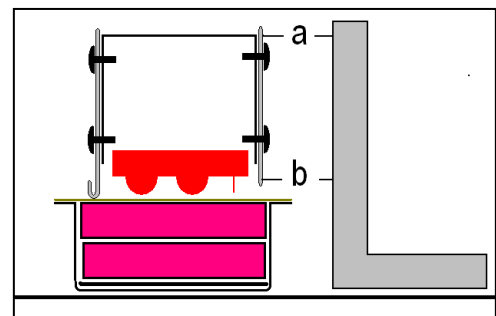
Adjust the parallelism between the heat seal bar and nonstick ribbon by loosening the nut (a) or (b) and rotate the corresponding cylinder rod. Rotate the shaft ¼ turn at a time, and test the quality of the seal between each setting.

(E). - Irregularity along the sealing

1. Make sure the sheet metal clamping the plastic film is at the correct height. The bar should be protruding to 0.050 inch (1.3mm) below the seal bars. To do this, loosen the screws (a) and (b) holding the pressure plate and lower it until the measurement is correct. Atlanta Attachment has a tool to facilitate this adjustment Part # 1390965 included in the kit of replacement parts.



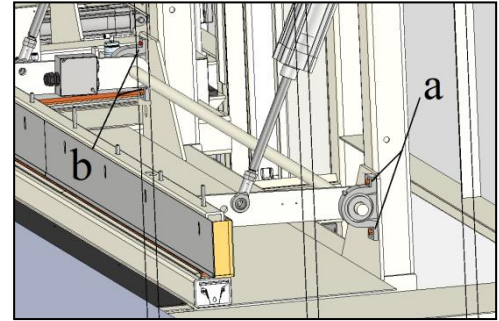
2. Verify that the sealing bar is parallel with reference to the non-stick tape. Rest the cooled seal bar on the non-stick tape and place a square on the table top next to seal bar and check the distance between the top of the heat baffle (a) and the bottom (b). You should have equal reference to the square. Make sure that the sheet metal is on the rubber and not the metal lip of the bottom tray. You should have equal reference to the square. If not, go to alignment on page 30.



Note: Upper bar should always come into contact with tape and silicone cushion. At no time should any part of the upper seal bar contact the metal of the lower bar assembly.

Alignment (continued)

Loosen the four screws (a) and (b) securing the two bearings and slide up or down to meet the proper angle. Check after each adjustment. It is very likely need to adjust the height of the bar.

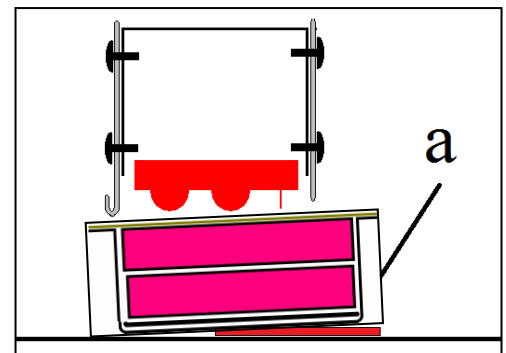


(F). - Random irregularities in the seals.

1. Check the non-stick tape on all three seal bars, tape should be smooth, clean, no air pockets and or crevices. Tape must be cleaned periodically and replaced as needed.
2. Inspect the silicone rubber backing under tape for cuts. If cut or damaged, replace silicone rubber cushion in that area as they are all glued together. After replacement follow the procedure for system realignment on page 33.
3. Check the upper sealing bars for damage, they should look black with a dull finish all along the bar. If any shinny areas are seen along the bar, it is damaged and needs replacement.

(G). - Irregularities constant seal.

1. Check the non-stick tape on all three seal bars, tape should be smooth, clean, no air pockets or crevices. Tape must be cleaned periodically and replaced as needed.
2. Inspect the silicone rubber backing under tape for cuts. If cut or damaged, replace silicone rubber cushion in that area as they are all glued together. After replacement follow the procedure for system realignment on page 33.
3. Check and see if shims under the support tray of non-stick tape are in place. Otherwise move them or insert new shims in that area.



4. Check the upper sealing bars for damage, they should look black with a dull finish all along the bar. If any shinny areas are seen along the bar, it is damaged and needs replacement.

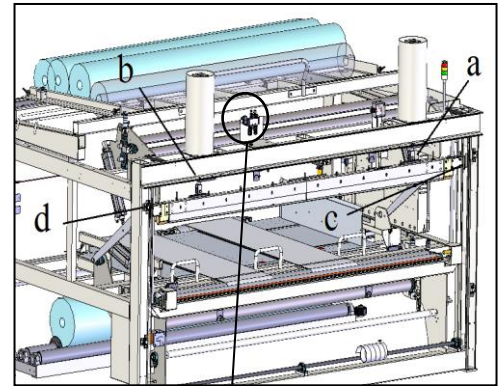
Note: Upper bar should always come into contact with tape and silicone cushion. At no time should any part of the upper seal bar contact the metal of the lower bar assembly.

Symptoms and adjustments of the cross seal Bar

(a), (b), (c), (f) and (g) in the previous graph are types of heat sealing problems that also apply to the cross seal bar with the following additions:

(D). Bar-Gradient

Position cross seal bar to the height as pictured until you see the four bolts (C) & (D) in the chain guard opening. Loosen these bolts with a 7/16 wrench as well as the 30mm nut above the clevis on the cylinder where pressure needs to be added. Rotate the cylinder shaft counter clockwise from top view ¼ turn only, then tap the cylinder cycle button (1/10 sec) to jog cylinders. Tighten the four chain bolts with a 7/16 wrench and test seal. Repeat if needed, otherwise tighten nut above clevis to complete adjustment.



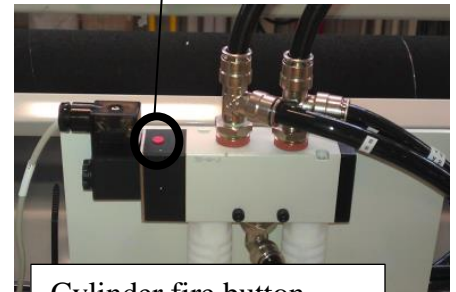
e. - Stamped Irregularities in crossbar seal

1 Check the non-stick tape on all three seal bars, tape should be smooth, clean, no air pockets and or crevices. Tape must be cleaned periodically and replaced as needed.

2. Inspect the silicone rubber backing under tape for cuts. If cut or damaged, replace silicone rubber cushion in that area as they are all glued together. After replacement follow the procedure for system realignment on page 33.

3. Check and see if shims under the support tray of non-stick tape are in place. Otherwise move them or insert new shims in that area.

4. Check the upper sealing bars for damage, they should look black with a dull finish all along the bar. If any shiny areas are seen along the bar, it is damaged and needs replacement.



Cylinder fire button

Replacement of Nonstick Tape

1. Make sure heat seal bars are in the up position.

2. Open the clamping system (a) peel back non-stick tape

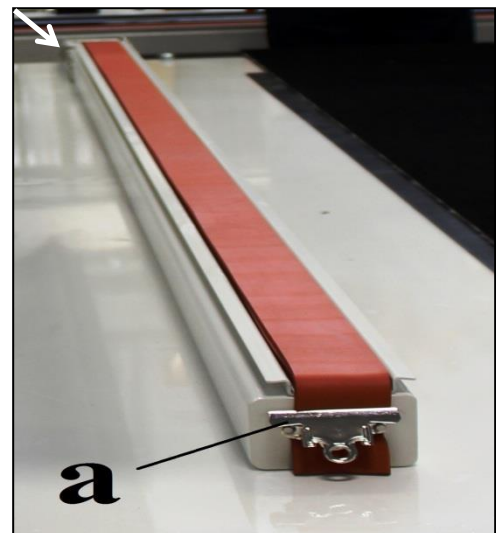
3. Inspect the silicone rubber backing under tape for cuts. If cut or damaged, replace silicone rubber cushion in that area as they are all glued together. After replacement follow the procedure for system realignment on page 33.

4. Pull out enough new tape from the roll located in front of raised rail to cover silicone padding.

5. Align the tape and adhere to the silicone rubber and metal flanges of support tray.

6. Cut the excess tape and mount into the front clamping system. (A)

Replacement
Tape here.



Cross Bar chain tension

Chains are responsible for parallel movement of the cross seal bar.

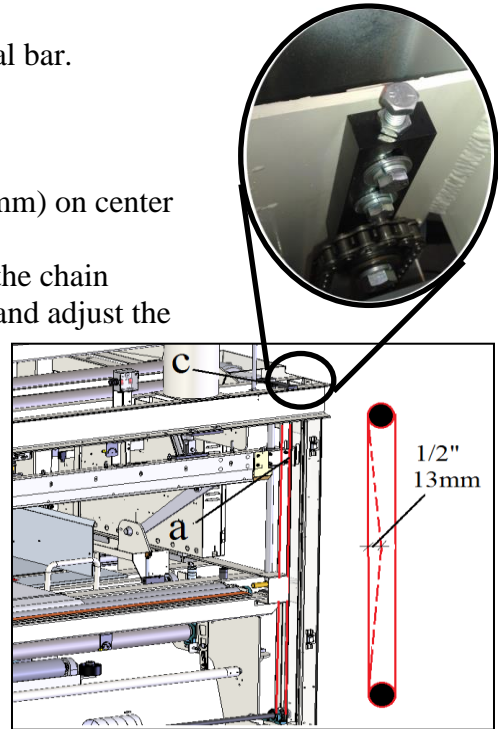
To check tension and adjust if needed:



The chain (a) displacement is approximately 0.5 inches (12 mm) on center if light pressure is applied to the chain.

The adjusting tensioners (c) are located at the upper ends of the chain system. Use a 9/16 wrench to loosen the two mounting bolts and adjust the tension bolt. Retighten the mounting bolts.

Note: Tension should be check every three months.



Replacing silicone rubber padding:

WARNING: Wait until the heat sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.

With seal bar in the up position remove non-stick tape. Next remove the damaged silicone padding completely. Clean glue off with mineral spirits. **(DO NOT LOOSEN ANY OF THE SCREWS BENEATH THE SILICONE PADDING AS THIS WILL DISRUPT THE SEAL BAR LOWER RAIL ALIGNMENT!)** Glue new padding to the rail. Secure PTFE tape and see shimming the seal bar on page **Error! Bookmark not defined.** after lower rubber replacement.



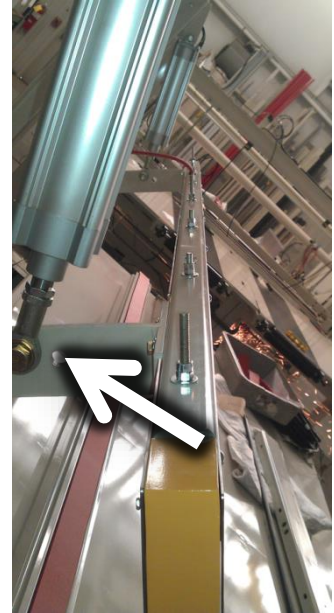
Adjusting the Seal bar Pressure

Note: For cross seal bar see: symptoms and adjustment of cross seal bar.
WARNING: *Wait until the heat sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.*

Loosen nut above clevis on each cylinder rod and rotate rod cylinder counter clockwise $\frac{3}{4}$ turn. Take a sample set of plastic layers used in production and perform a seal. What we are trying to determine is a sealing pressure point. The object is to get the heated seal bar sealing the plastic evenly with as little force as possible.

Note: We are only adjusting the cylinder rods, not shimming.

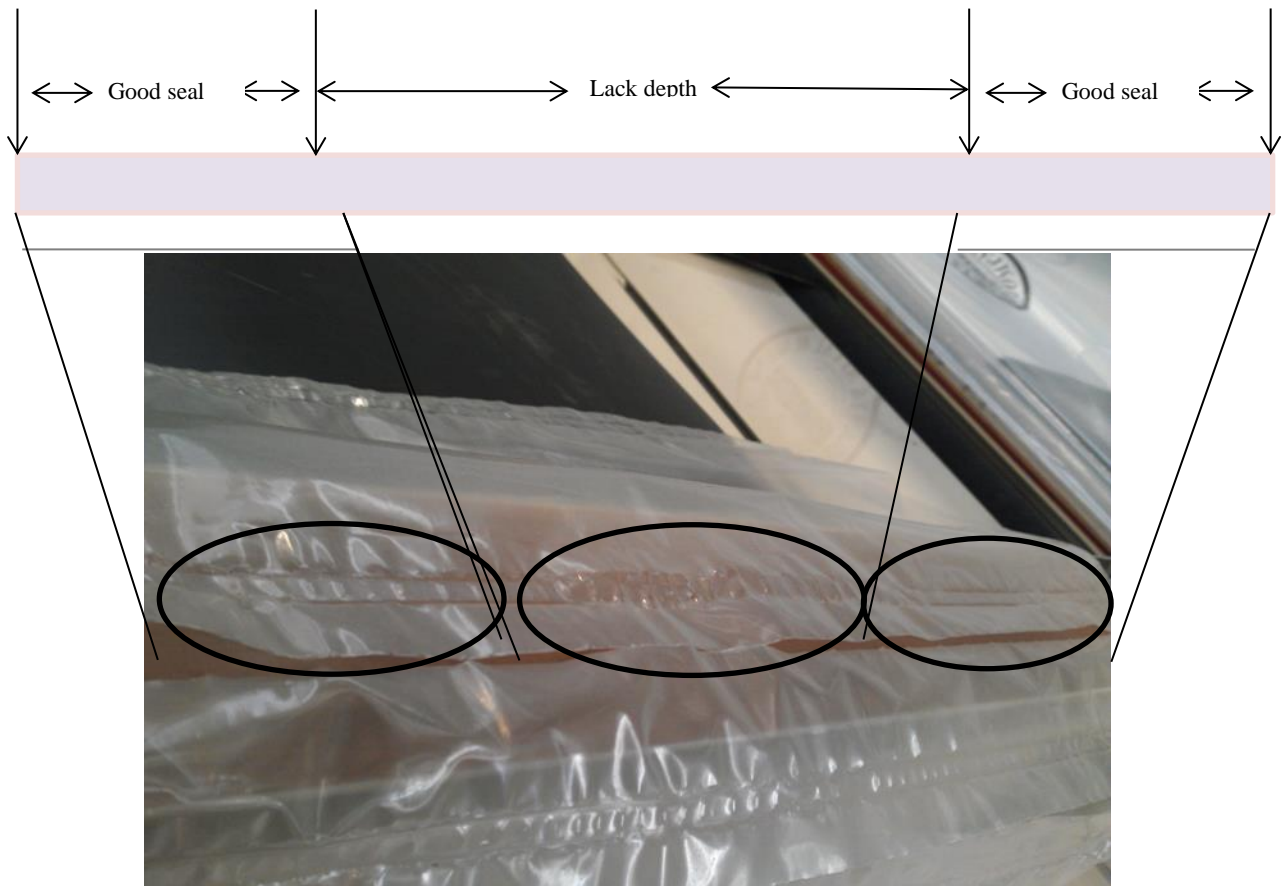
Once you have example A, try to decrease pressure by a $\frac{1}{2}$ turn on both cylinders and see if you get example B. If not, keep decreasing until you see example B. If so, then increase pressure $\frac{1}{2}$ turn and tighten the cylinder rod nuts and you are finished.



Example A



Example B

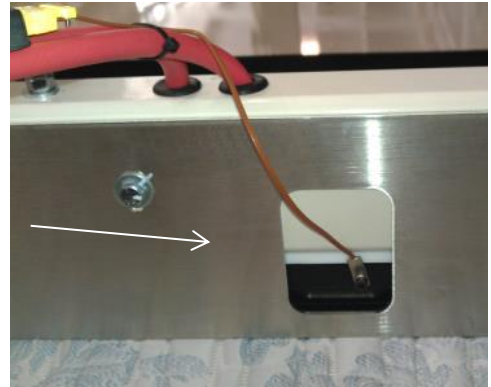


Upper Seal Bar Element Replacement

WARNING: Wait until the heat sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.

1) Turn Power supply off

2) Remove thermo coupling wire.



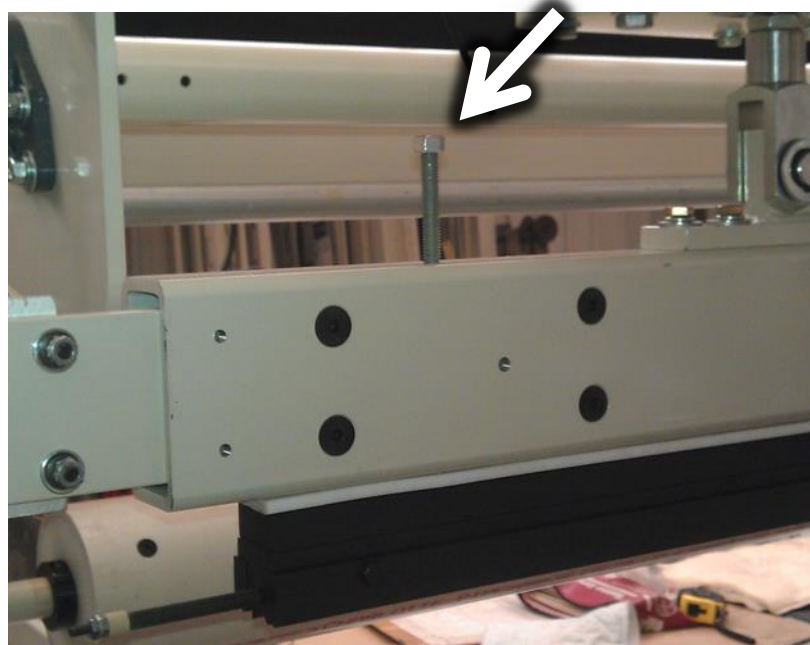
3) Remove protective end plates from seal bar



4) Disconnect wire from both ends of heating element.



- 5) On the three tallest studs remove the top nut and back out the bottom nut to the end of stud without removing.

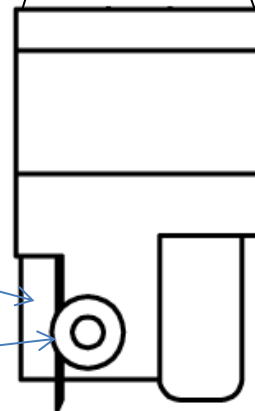
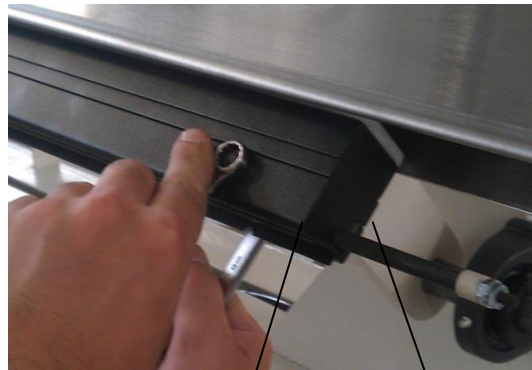


- 6) Remove all of the remaining nuts from shorter studs. This will allow the seal bar assembly to slide out pass stainless steel guards far enough for servicing.



Warning: It is imperative to lay out a large pad to protect parts being removed from this point on.

- 7) Using two closed end wrenches remove the nuts while leaving the bolts in place. **Be careful not to scratch any part of the coating on the seal bar assembly.** Note the order in which you remove the nuts because it is important that they are installed exactly in the same order.



- 8) Remove the Spacer bar (and Knife if applicable)

- 9) Remove damaged heating element.

10) On one end of the new heating element make a mark 3 ½” in from the tip with a sharpie. Starting with your mark begin inserting the heating element into the open slot of seal bar. Once in place, you should have 3 ½ “of extra heating element protruding from both ends of the seal bar.



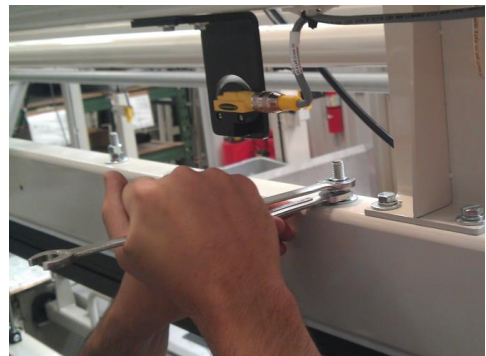
Reverse steps 1 thru 10 to complete replacement with special attention to steps 7, 6, 5, & 4.

On step (7) torque each bolt to 7 in. lb. torque only!

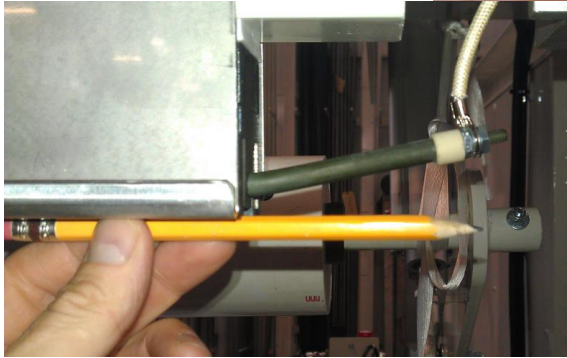
On step (6) & (5) Push seal bar assembly up with one hand as you tighten the first set of nuts with the other hand. After all of the nuts are finger tight; use a wrench to turn each nut ¼ to a ½ turn to finish compression of nylon gasket. (**WARNING DO NOT TIGHTEN PAST ½ TURN!**)



Install the second nut on each shaft and lock it to the bottom nut using two wrenches. Use caution in this procedure making sure the bottom nut does not move from its set point.



(4) Bend heat element up approximately 30 degrees.



After replacement is complete refer to Adjusting the Seal bar Pressure on page 33 for final adjustments.

Shimming the Seal Bar

Note: For cross seal bar see: symptoms and adjustment of cross seal bar; once adjustment is complete, move to #3 on this page 31.

Follow procedures for replacing Left and Right seal edge or heating element page.35.

After replacement, some very important steps are needed for the system to perform properly.

If you are inexperienced, It is always advisable to contact Atlanta Attachment service techs for detail procedures on setting up seal bar alignment, the next couple of steps are crucial to the machines performance.

- 1) Setup test plastic as seen on right

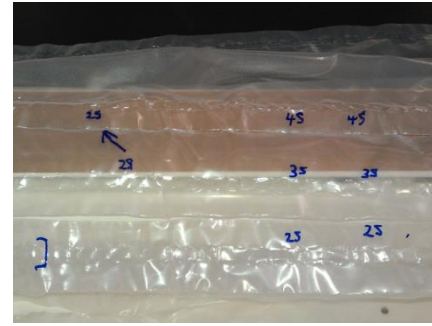
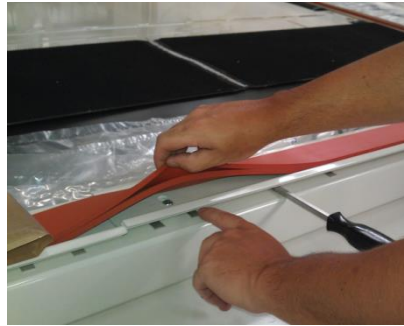


- 2) Adjusting the Seal bar Pressure

Somewhere between Example A and B on page 33 is a good starting point for a new setup before moving on to shimming. Always make this adjustment **before** shimming.

- 3) Shimming rail system.

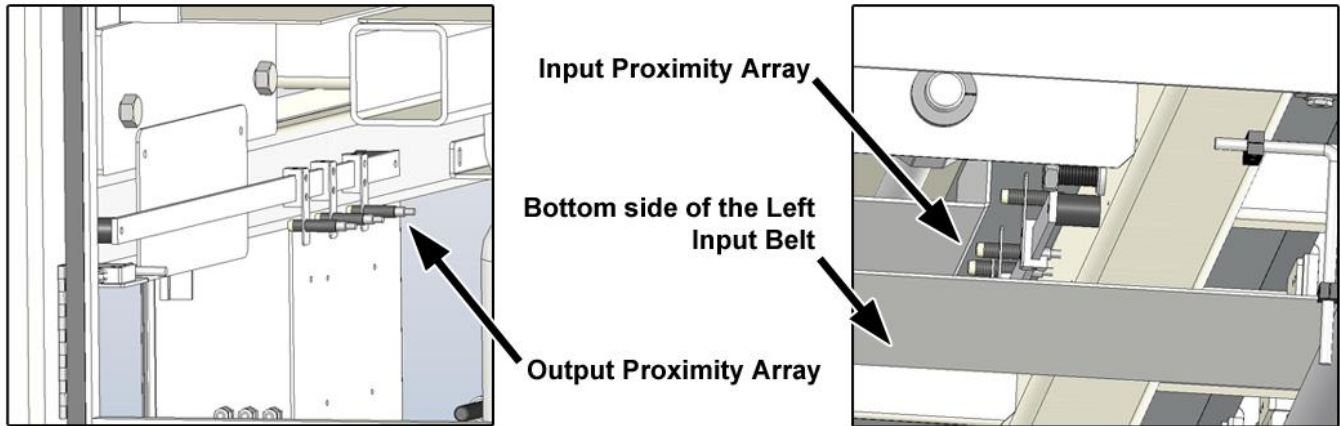
After test seal, shim the low points and record the value.



Keep repeating until you have a smooth seal. Then go back to Adjusting the Seal bar Pressure on page 33 and repeat this final adjustment to complete alignment of weld.

Mattress Size Adjustments

The 1390HCB machine is designed to automatically detect and adjust itself for one of the two basic bed lengths: 75” and 80”. To detect the bed length, the machine uses one proximity sensor which is mounted on a rectangular guide rail. The array is mounted on the right side of the Input frame, under the table, near the front of the machine (right illustration). The sensor detects the position of the (right) movable Input frame during the bed alignment and locating cycle.



Before this machine is shipped, it is adjusted and tested according to the customer bed specifications and should not need to be readjusted. If the parameters of the bed change after installation and it is necessary to readjust these arrays, it is very easy to do so. Simply loosen the screw that clamps the proximity sensor mounting block and move in the desired direction. If you want to be able to detect a smaller bed in the Input, move the sensor toward the center of the machine and vice versa. It works the same way if you want to stop the adjustable Output Seal bar frame.

Maintenance

Under normal operating circumstances, the 1390B machine does not require much maintenance. The following list outlines the normal machine maintenance that should be performed on periodic bases to keep the machine in a good working order:

Daily

Clean the three Seal bars at least once a day, preferably at the beginning of the first shift, before the seal bars begin to heat up. To clean the Seal bars, use a soft cloth and WD-40 as the solvent. Use extra caution and make sure Seal bars are not hot or heating up before cleaning. Also, use extra care not to scratch the Seal bar's anti-stick coating. If the coating surface is scratched to the bare metal, the plastic film may stick to it, which in turn may result in poor seal quality and /or machine down time.

Visually inspect PTFE tape (covering the lower seal bars) for any cuts and delaminating from the lower seal bar. If necessary, replace the tape.

During machine operation, listen for any unusual noises and watch for any uncommon machine behavior. For example: jerky cross seal bar up/down movement, squeaky belt drive, etc.

Clean the machine and remove any plastic film scraps or other debris. They may cause mechanism to jam and potentially fail.

Weekly

Check the main air supply filter for any accumulation of oil or debris. Empty the filter bowl before it is filled to the maximum level indicated on the side of the bowl.

Check the smoothness of the up/down movement of the Cross Seal Bar. If the bar chatters at all or does not move smooth, wipe the rods clean and apply a coat of sewing head oil to keep the rods lightly lubricated. This will improve the performance and extend the life of the bearing and keep the shafts for rusting. If the condition persists after application of the lubricant, check the tension and alignment of the two synchronizing chains. Also check the condition of the Cross Seal Guide rods for any unusual wear.

Monthly

Check the chain tension on all four motor drives. Adjust as needed.

Check the tension of the input and output belts. Adjust as needed.

Quarterly

Check the conveyor bearings and other pivot bearings and lubricate using PTFE based grease.

Check the condition of the Seal bar tape and the silicone rubber cushion below it for any through cuts particularly in the area where the hot knife cuts through the plastic. If the PTFE tape or cushion or both is cut or damaged, the whole setup must be replaced.

Bi-Annually

Replace the air supply filter element.

Lockout Procedure

Make sure all seal bar cylinders are in the desired position (up or down). It is necessary to observe the position of these cylinders. When the main air is turned off to the machine, the cylinders are pneumatically locked in the position they are at that moment.

Turn off the main air lockout valve and let the airlines and the air tank bleed-off completely.

Install a lockout padlock in the air lockout valve.

Turn off the main electrical switch and lock it out.

Wait until all seal bars cool off sufficiently before attempting to work near any of the seal bars.

Note: Do not lock seal bars in the down position if they are hot.

Troubleshooting

Machine does not power up when the Power ON button is pressed.

1. Check to make sure all four Emergency Stops are pulled out and operational.
2. Check for a short circuit. Turn off all breakers, and turn the machine back ON. If it comes ON, switch ON one breaker at a time.

The Input Conveyor belts turn in reverse upon machine startup before the bed is loaded on the input conveyor.

1. All three bed Alignment Eyes are covered (dark) upon machine startup. Check, and if necessary adjust the sensitivity screw. The Red led should blink 3 times /sec.
2. If sensitivity is ok but the problem persists, check the dark/light operate mode (white) screw, all three eyes should be set to light operate (turned clockwise).
3. If the eyes appear to be set correctly but the problem still exists, replace one eye at a time. Make sure to adjust as the new eye as described above.

The Input Conveyor belts turn in reverse once the bed is loaded and aligned.

1. None of the three size detecting proximity sensors were covered during the alignment phase. Adjust the proximity sensor in the input and reload the bed. Repeat this procedure until the problem is solved.

The Input aligns and positions the bed properly and does not continue.

The outfeed eye is full blocked (dark). The Red LED is not on. Adjust the eye sensitivity and make sure the Eye mode is set to Dark Operate (Counter-clockwise)

1. If problem persists, replace the eye (adjust as described)

The bed transfers to the Output area for sealing; the Cross Seal begins to go down, but goes back up before cross sealing.

1. The cross seal eye is too sensitive or adjusted too far toward the Input end of the machine. Adjust the pot on the amplifier to reduce the sensitivity some, but no less than 5 on the scale. If problem persists, realign the cross seal sensor.

The Side or Cross Seal is spotty in appearance.

1. Check the quality of the Teflon tape on the lower seal bar. Check the silicone rubber tape backing for cuts.
2. Adjust the Air Cylinder rod ends, out ¼ turn at a time, to lower the seal bar. Test the seal quality between every adjustment.

The seal is good in appearance but weak.

1. Adjust the seal bar Temperature, and/or dwell time (do not exceed 30).

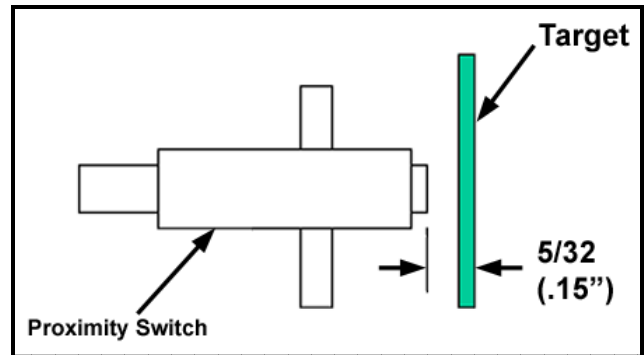
Machine continues to run even after the film (top or bottom) has run out.

1. Check to make sure that the Film run-out Eye for the corresponding film is set and working properly.

Sensor Adjustments

Proximity Switch

All proximity switches used on the 1390B machine have 8mm sensing range. The distance between the end of the sensor and the target flag should be set at about 5/32" for best performance.



Cross Seal Photo Detector

The amplifier sensitivity for the Cross Seal bar is located in the bottom-right corner of the main control box. It is factory set to the maximum setting of 10 (on the adjustment knob). It can be adjusted down if a false detection of the trailing edge of the mattress occurs often. The false detection usually results in an incomplete downward movement of the Cross Seal bar.

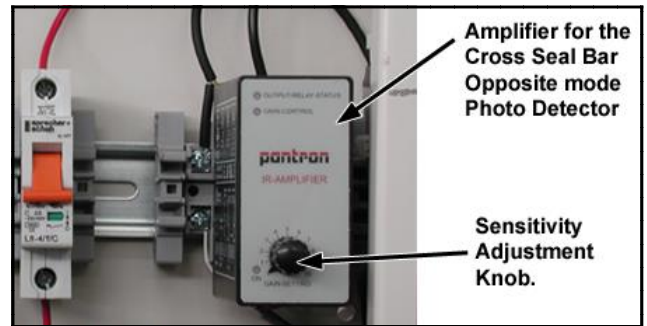
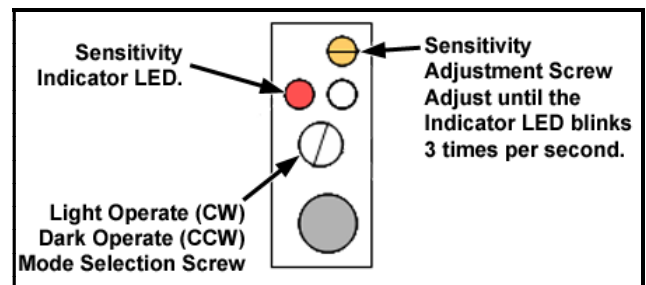


Photo Eye

All retro-reflective photo eyes on the 1390B machine are set to Light operated mode (except the "Custom Conveyor Full Eye" which is set to the dark operated mode).



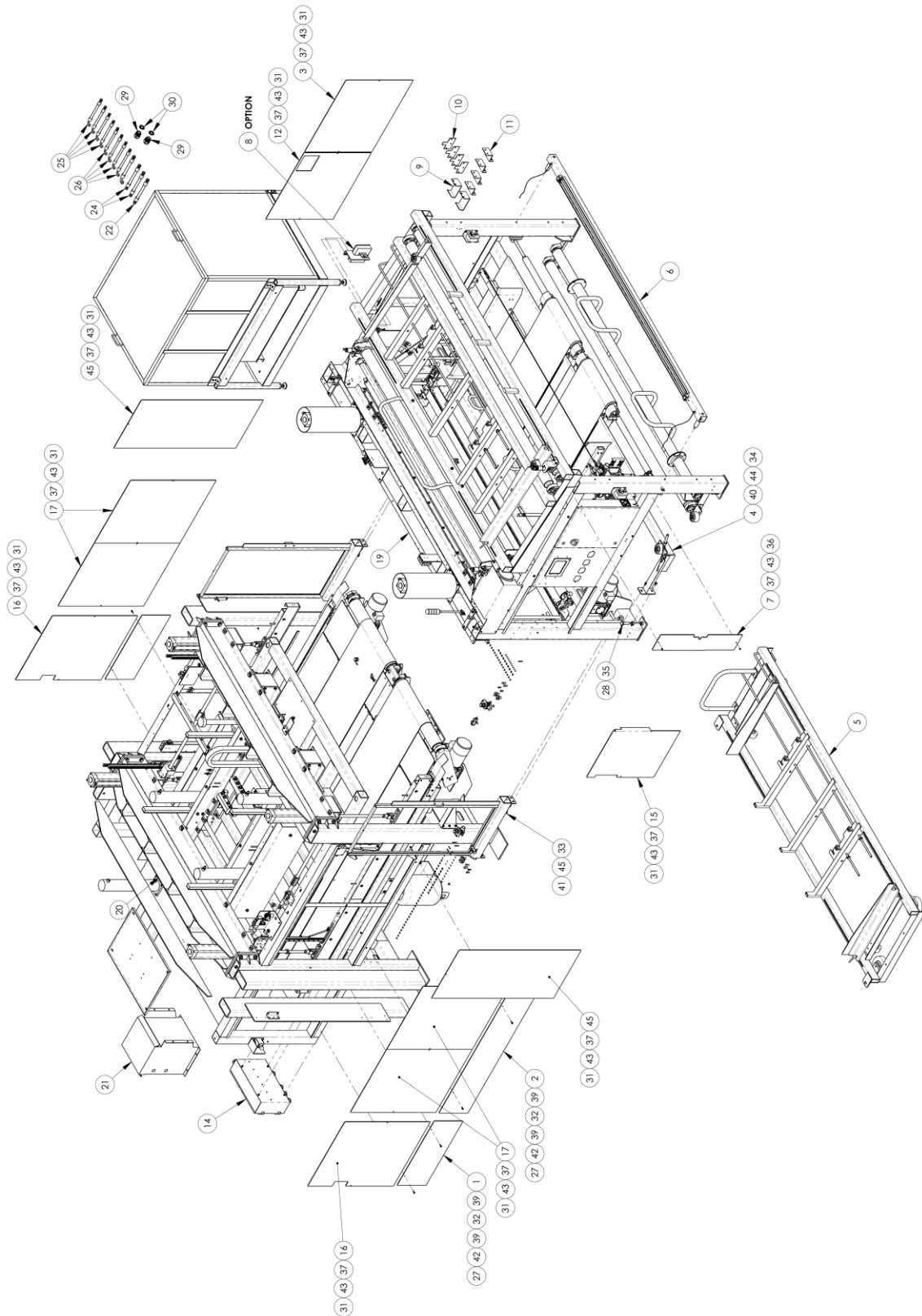
Assembly Drawings & Parts Lists

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PARTS DEPOT

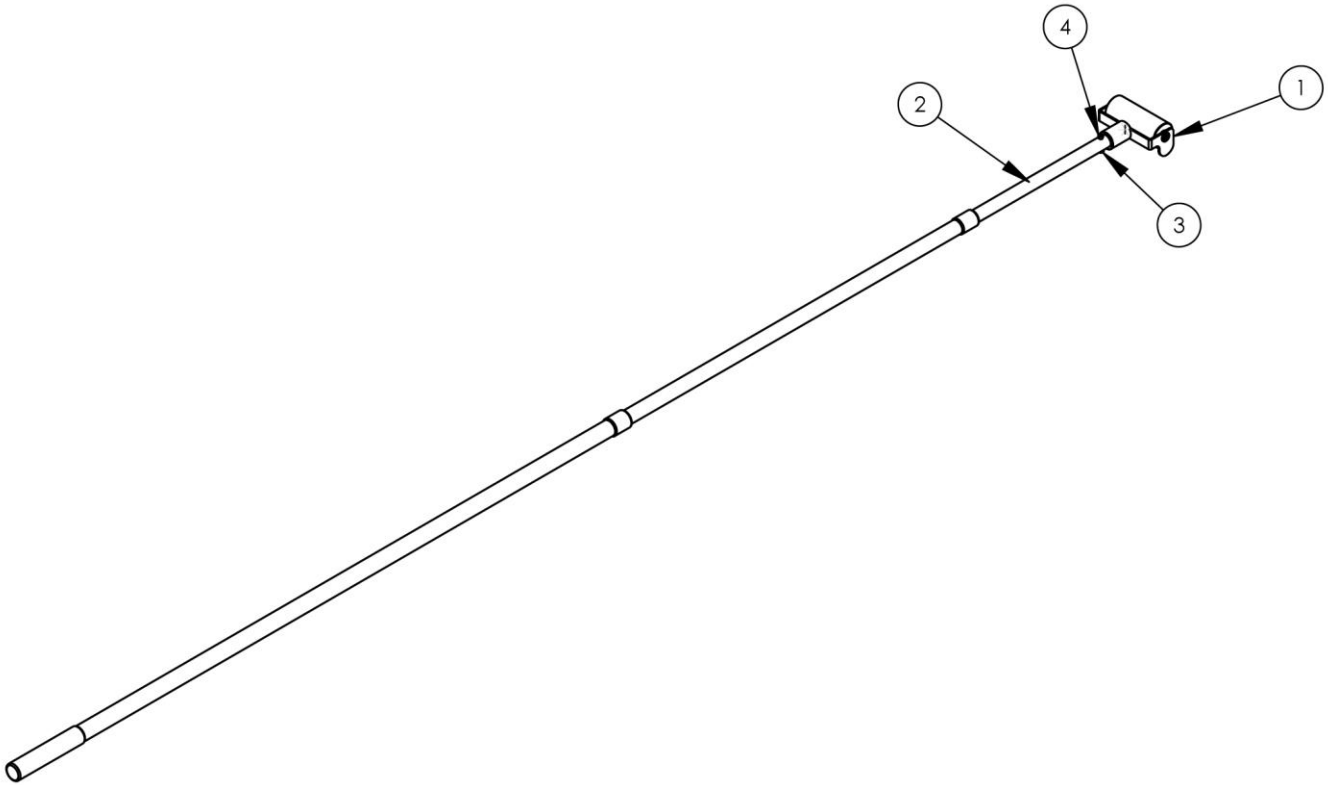
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11390HCB Auto Pack, Hyd Comp, Turner

AAC Drawing Number 9007178 Rev 3

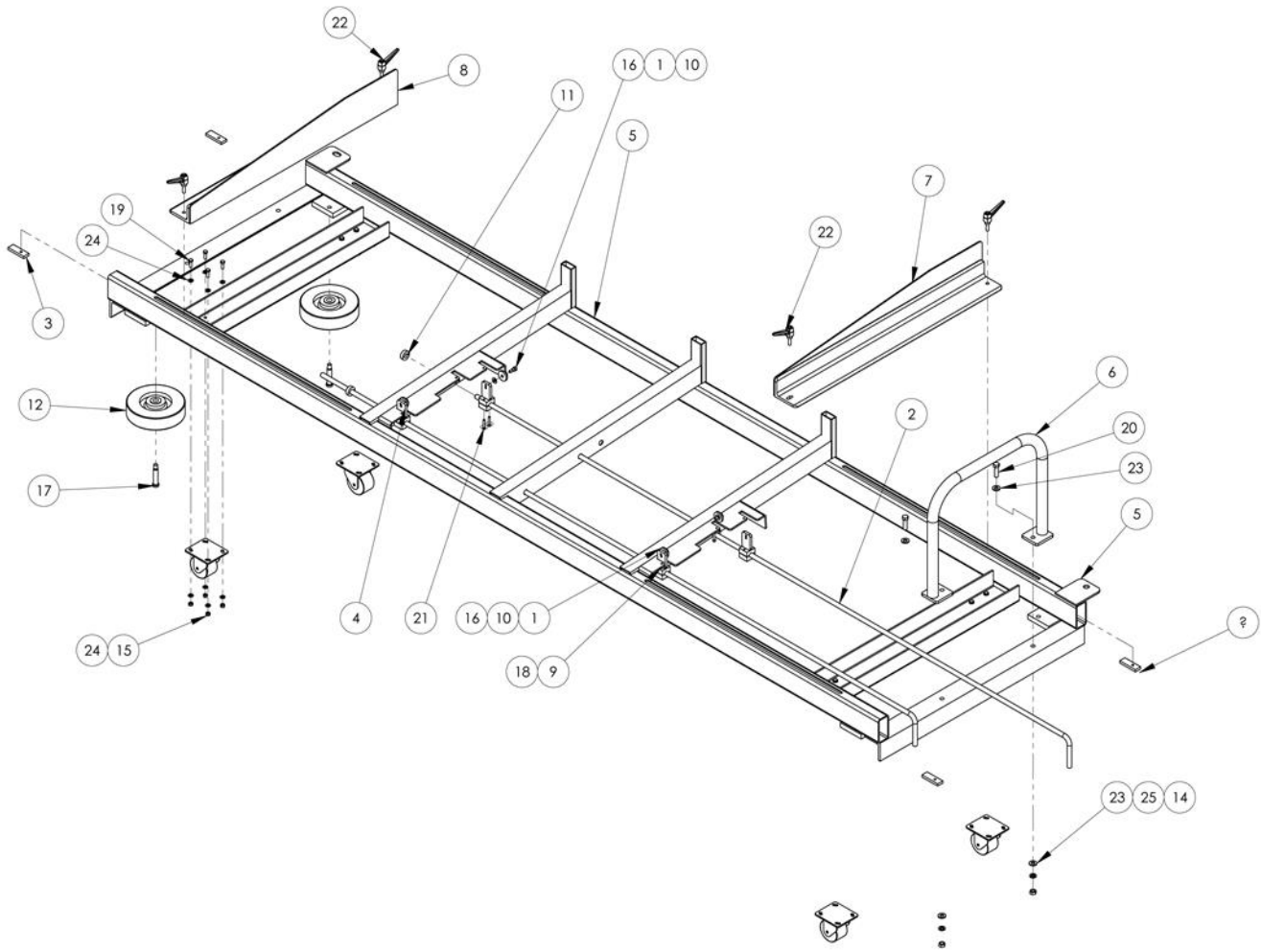
NO	QTY	PART #	DESCRIPTION
1	2	1386771	SIDE SEAL GUARD EXT,SHORT
2	1	1386772	SIDE SEAL GUARD, LONG
3	1	1390003	SIDEPANEL #3, LEXAN
4	1	1390457	MOUNT,LOWER CASTER
5	1	1390500	ROLL HOLDER FRAME, LOWER
6	1	1390683	FRONT SEAL BAR ASBLY
7	1	1391150	GUARD, LEFT FRONT-INFEED
8	1	1391436	REMOTE TOUCH SCREEN KIT
9	2	1394000	SHIPPING BRACKET 1
10	4	1394284	SHIPPING BRACKET 2
11	4	1394285	SHIPPING BRACKET 3
12	1	1394729	SIDEPANEL #4, LEXAN
13	1	1406240	HYDRAULIC PUMP ASSY
14	1	1406280	POWER CABINET, 480V
15	1	1406534	GUARD, LEXAN-INFEED LH
16	2	1406656	SIDE PANEL, REAR RIGHT
17	4	1406657	SIDE SEAL GUARD, LH & RH
45	2	1406658	GUARD,DOOR PANEL,LH & RH
19	1	1406759	INPUT CONVEYOR
20	1	1406760	EXIT ASSY W/ HYD COMP
21	1	EENMK015KD	TRANSFORMER,480-240
22	1	HH302101010208	HYD HOSE, 208", 10X10X5/8
23	1	HH302101010213	HYD HOSE, 213", 10X10X5/8
24	2	HH30210101024	HYD HOSE, 24", 10X10X5/8
25	4	HH3028080838	HYD HOSE, 38", 8X8X1/2
26	4	HH3028080844	HYD HOSE, 44", 8X8X1/2
27	8	NNH1/4-20	NUT,HEX,1/4-20
28	8	NNH7/8-9	7/8-9 HEX NUT
29	2	RBM4524	STRAIN RELIEF,1-1/4 NPT
30	2	RBM9144	LOCKNUT,NYLON,1-1/4"NPT
31	19	SSBC98048	10-32 X 3/4 BUTTON CAP SC
32	6	SSHC01064	1/4-20 X 1 HHCS
33	4	SSHC10064	5/16-18 X 1 HHCS
34	4	SSHC25064	3/8-16 X 1,HEX CAP
35	8	SSHC49192	7/8-9 X 3 HEX CAP
36	3	SSHC98032	10-32X1/2 HEX HD
37	23	WWF10	WASHER, FLAT, #10, COM
38	2	WWFE016	WASHER,FENDER,LARGE,1/4
39	12	WWFS1/4	WASHER,FLAT,SAE,1/4
40	4	WWFS3/8	WASHER,FLAT,SAE,3/8
41	4	WWFS5/16	WASHER,FLAT,SAE,5/16
42	8	WWL1/4	WASHER,LOCK, 1/4
43	22	WWL10	WASHER,LOCK,#10
44	4	WWL3/8	WASHER,LOCK, 3/8
45	4	WWL5/16	WASHER,LOCK, 5/16



1390170 Tape Roller Handle Assembly

AAC Drawing Number 1390170 Rev 0

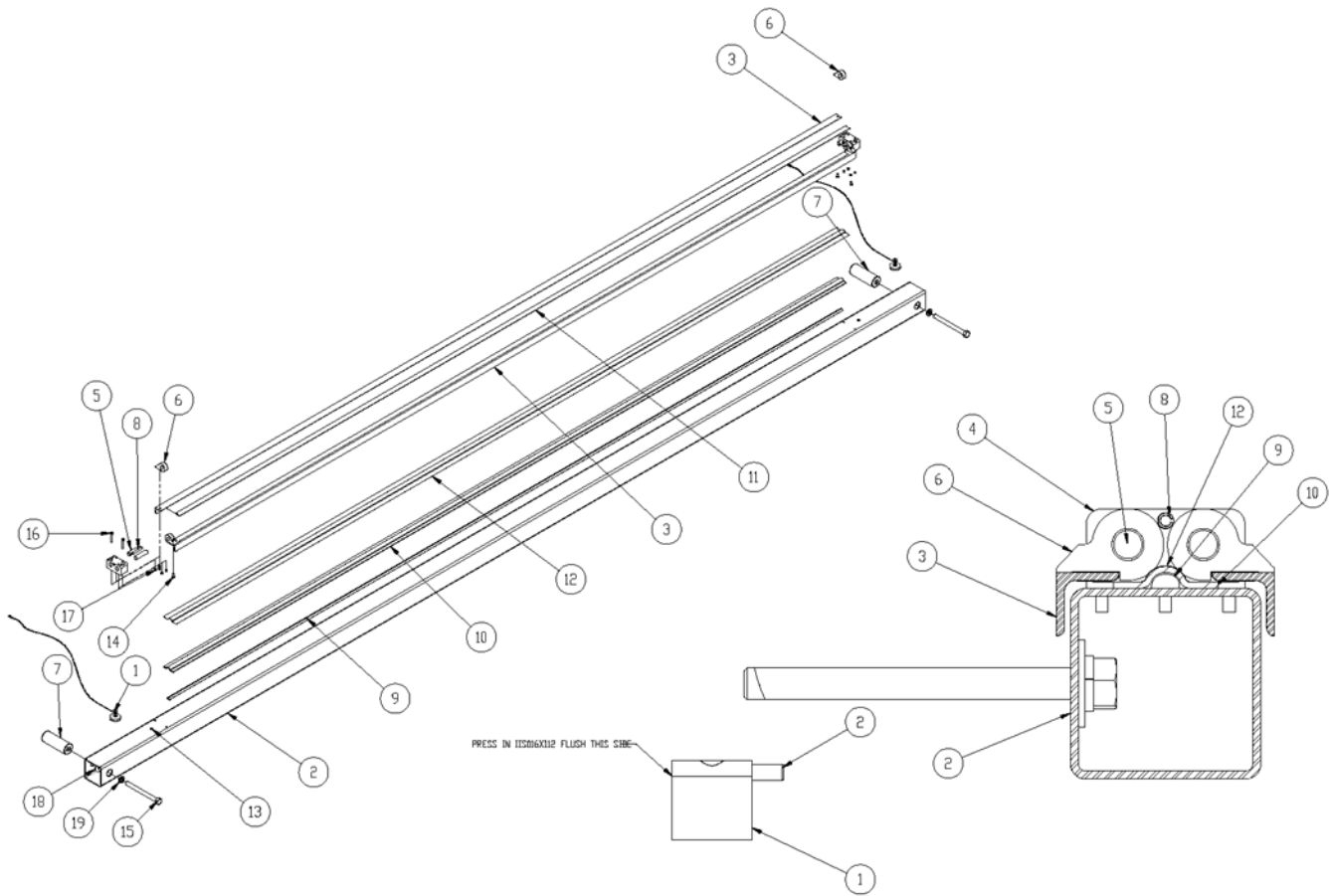
NO	QTY.	PART #	DESCRIPTION
1	1	1390520	ROLLER,TAPE REMOVING
2	1	MM78005T44	Telescoping Pole-6'-18'
3	1	NNH10-32	HEX-NUT 10-32 REG.
4	1	SSSC98072	10-32 X 1-1/8 SOC CAP



1390500 Lower Roll Holder Frame

AAC Drawing Number 1390500 Rev 5

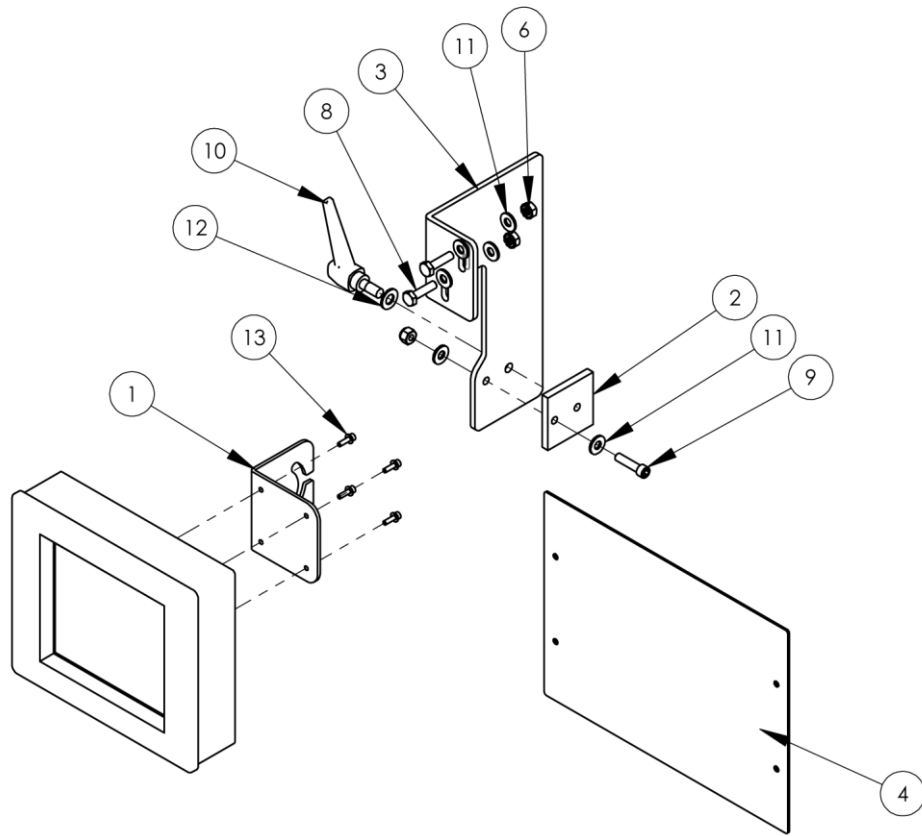
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	4	1390198	ROLL RELEASE DISK	14	2	NNH1/2-13	NUT,HEX,1/2-13
2	2	1390458	ROD, ROLL STOP	15	16	NNK5/16-18	KEP NUT, 5/16-18
3	4	1390459	NUT PLATE-SIDE ROLLER ADJ	16	4	SSAS024024	SHOULDER BOLT 3/8 X 3/8L
4	4	1390463	ROLL STOP, WELD'T	17	2	SSAS048160	SHOULDER BOLT 3/8 X 2.5L
5	1	1390508	FRAME WELDT- BOTTOM ROLLS	18	4	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
6	1	1390559	HANDLE ASSEMBLY	19	16	SSHHC10064	5/16-18 X 1 HHCS
7	1	1390565	RIGHT IDLER ROLLER, ROLL	20	2	SSHHC45112	1/2-13 X 1-3/4 HHCS, G8
8	1	1390566	LEFT IDLER ROLLER, ROLL	21	8	SSSC05080	SREW, SOCKET CAP 1/4-28X1-1/4
9	4	BB1L038	BEARING,BALL,.375B	22	4	TTH32430	HANDLE,THRD,3/8-16X1-1/4
10	4	BBTRA613	WASHER,THRUST,STL, .375B	23	4	WWFS1/2	WASHER,FLAT,SAE,1/2
11	2	CCCL10F	CLAMP COLLAR- 5/8 ID	24	32	WWFS5/16	WASHER,FLAT,SAE,5/16
12	2	MM082008	CASTER,PPP,1200LBS/WHEEL	25	2	WWL1/2	1/2 LOCK WASHER
13	4	MM16CA03201-S	CASTER,SWIVEL, 3.25" STEEL				



1390683 Front Seal Bar Assembly

AAC Drawing Number 1390683 Rev 1

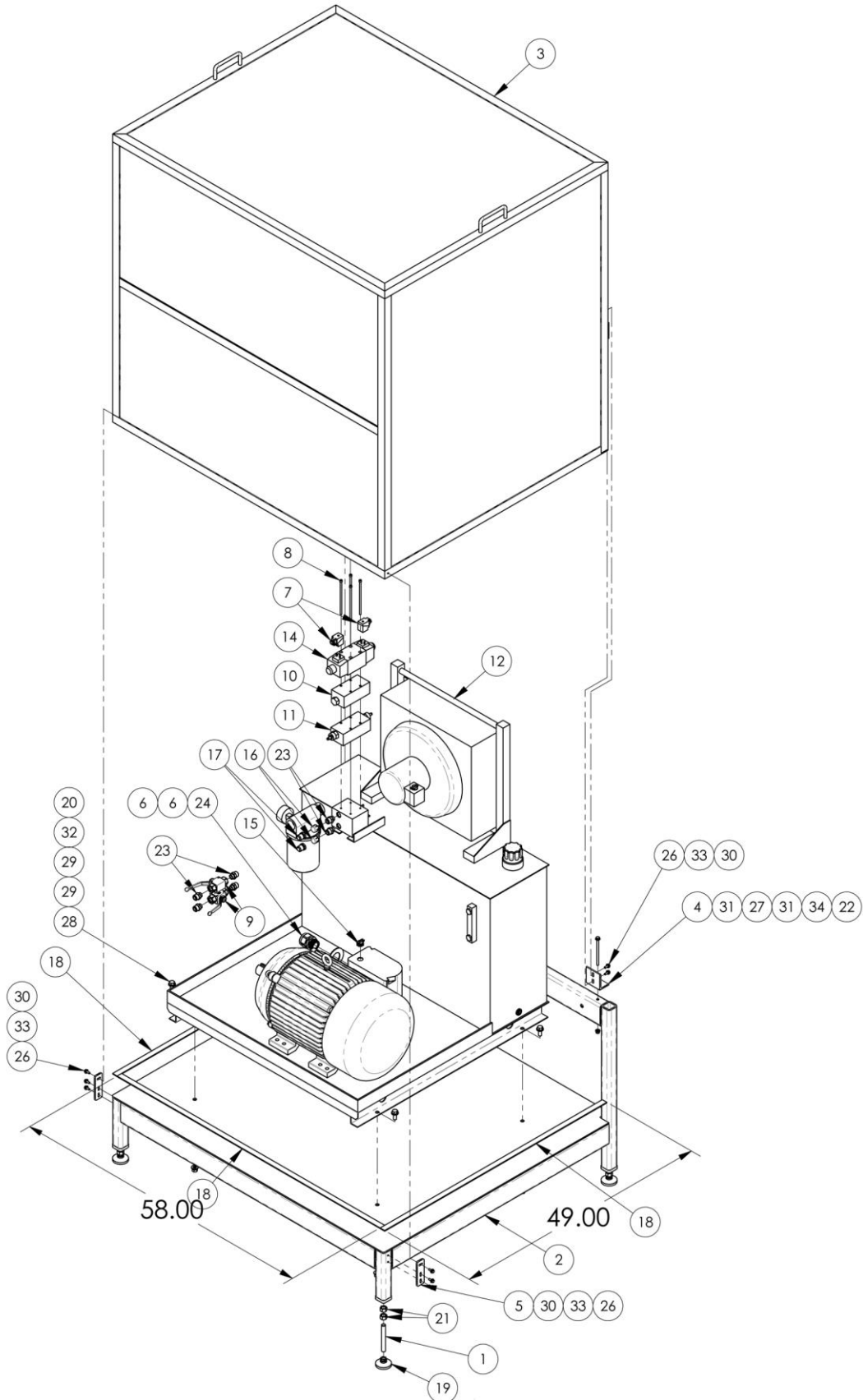
NO.	QTY	PART#	DESCRIPTION	NO.	QTY	PART#	DESCRIPTION
1	2	1390330	MAGNET, HAND	11	*20'	MM76495A27	TAPE, TEFLON
2	1	1390680	SUPPORT RAIL	12	*10'	MM76495A32	TAPE, TEFLON
3	2	1390700	GUIDE RAIL, HAND	13	2	SSBC98024	10-32 X 3/8
4	2	1390707	PIVOT BLOCK	14	4	SSFC98032	10-32 X 1/2 FLAT
5	4	1390708	PIVOT SHAFT	15	2	SSHC45352	1/2-13X5 HEX
6	4	1390709	PIVOT ARM, HAND	16	4	SSSC98080	10-32 X 1-1/4 SOC
7	2	1390733	SPACER, SEALER	17	8	SSSS01016	1/4-20 X 1/4
8	2	IIS016X112	ROLL PIN 1/8 DIA	18	2	WWF1/2	WASHER, FLAT, 1/2
9	*10'	MM1000A52	MOLDING, VINYL	19	2	WWL1/2	1/2 LOCK
10	*10'	MM5109K26	FOAM, SILICONE				



1391436 Remote Touch Screen Kit

AAC Drawing Number 1391436 Rev 1

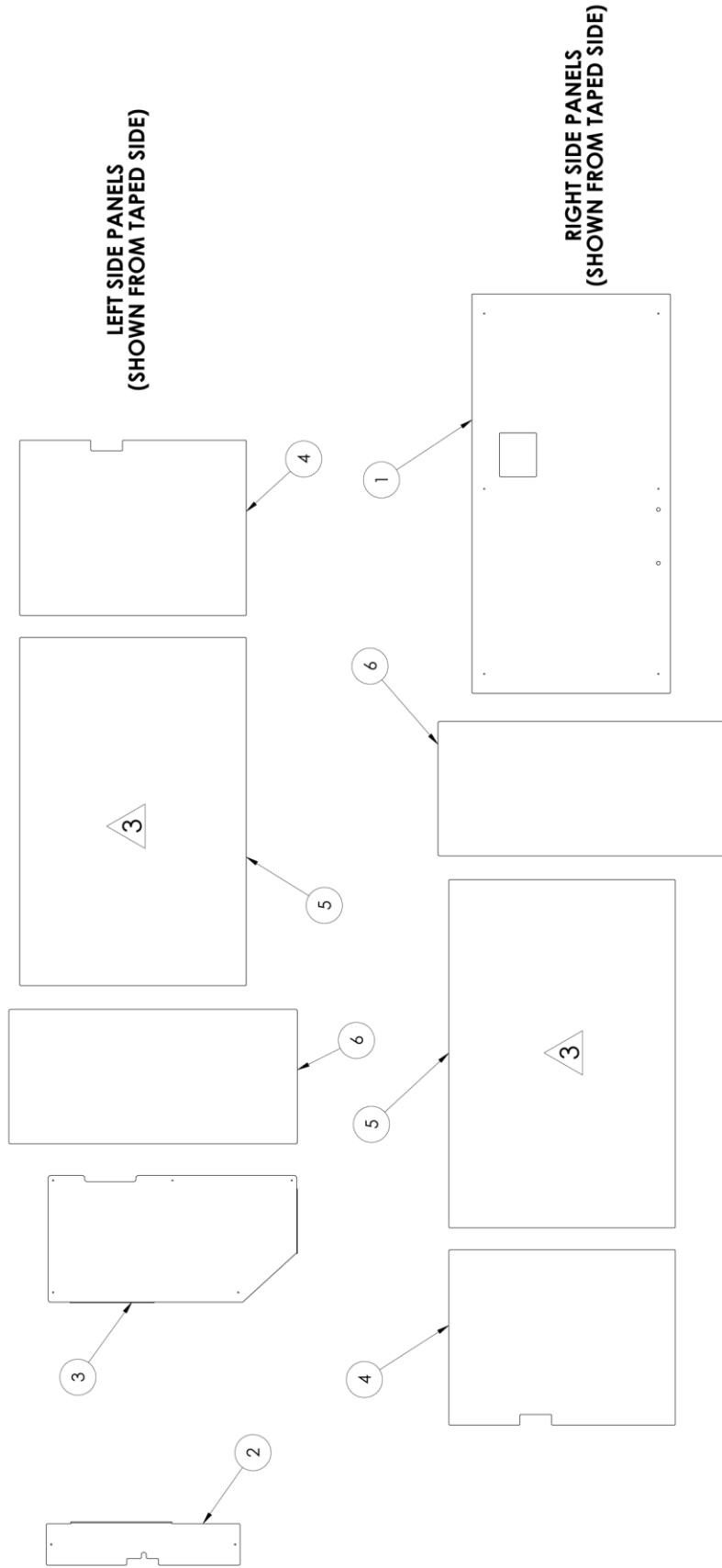
NO	QTY	PART #	DESCRIPTION
1	1	0411-3706	BOX SUPPORT
2	1	0411-3708	NUT PLATE, BOX MOUNT
3	1	1391594	MOUNT, TOUCH SCREEN
4	1	1396336	DOOR, LEFT, 4080-004
5	1	NNE1/4-20	NUT, ELASTIC LOCK, 1/4-20
6	2	NNK1/4-20	NUT, KEP, 1/4-20
7	1	NNK8-32	NUT, KEP, 8-32
8	2	SSHCO1064	1/4-20 X 1 HHCS
9	1	SSSC01064	1/4-20 X 1 SOC CAP
10	1	TTH32425	HANDLE, THRDDED, 5/16-
11	6	WWFS1/4	WASHER, FLAT, SAE, 1/4
12	1	WWFS5/16	WASHER, FLAT, SAE, 5/16
13	4	WWFS6	WASHER, FLAT, #6



1406240 Hydraulic Pump Assembly

AAC Drawing Number 1406240 Rev 0

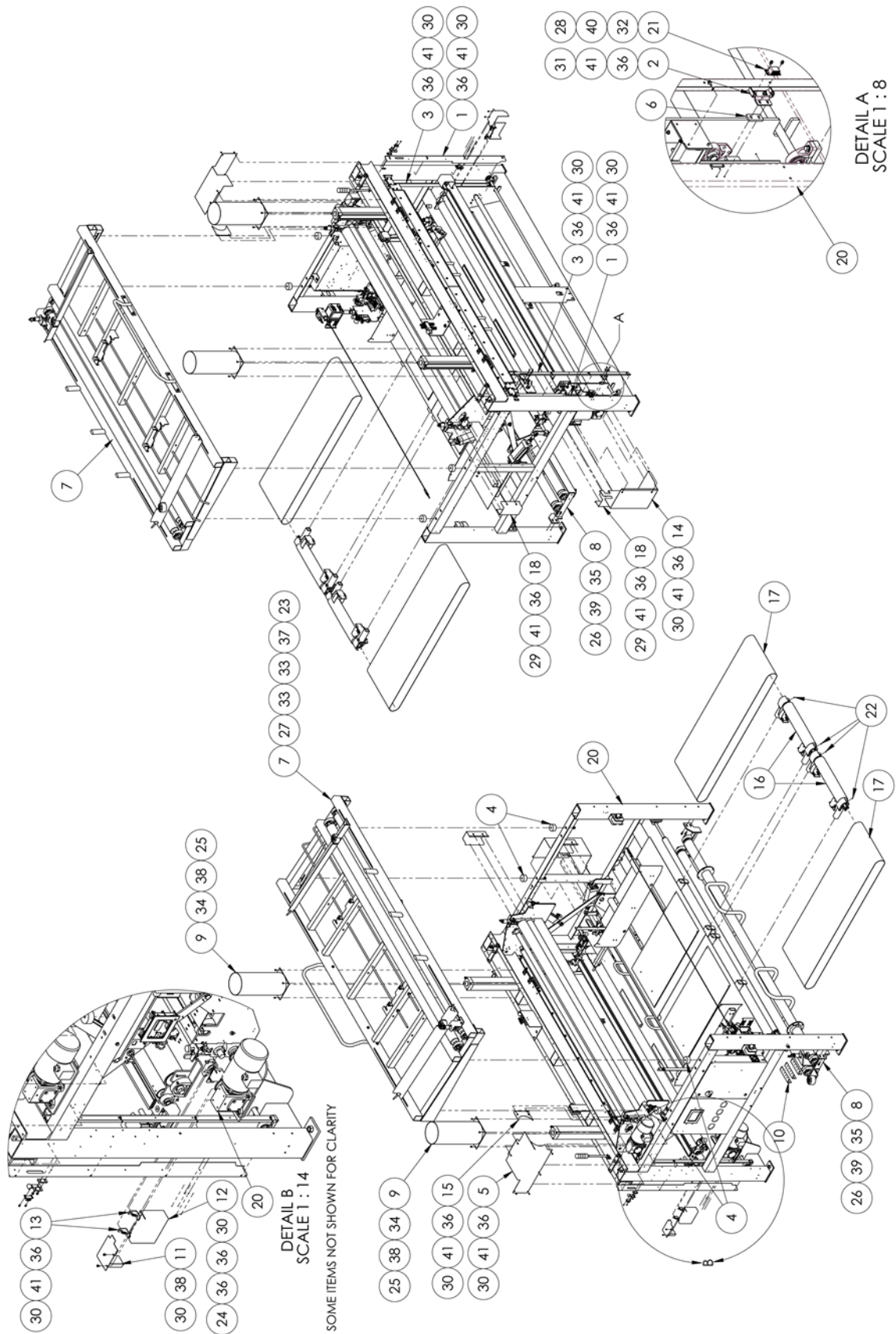
NO	QTY	PART #	DESCRIPTION
1	4	0411-1063	THREADED ROD
2	1	1406250	FRAME,PUMP,HYDRAULIC
3	1	1406255	GUARD,PUMP,HYDRAULIC
4	2	1406275	GUARD MOUNT ANGLE
5	2	1406276	GUARD MOUNT BRACKET
6	2	1406293	STRAIN RELIEF WASHER
7	2	FFSC18-0	SOLENOID CONNECTOR
8	1	HYBD05-625	BOLT KIT,HYD,VALVE STACK
9	2	HYBV450249	BALL VALVE, HYD, 7250 PSI
10	1	HYC05MSV	CHECK VALVE,HYD,CHECK
11	1	HYF05MSV	FLOW CONTROL,HYD, W/ CHK
12	1	HYMG18	HYD PUMP, 18 G/M, 25HP
13	10*	HYOT32	OIL,HYD,TELLUS 32, 5 GAL
14	1	HYVSD05-220V	SOLENOID VALVE,HYD BI DIR
15	2	K-235	CONNECTOR,ROMEX,1/2"
16	2	MM1277K29	PLASTIC CAP, 7/8-14
17	2	MM1277K41	PLASTIC PLUG, 7/8-14
18	156"	MM93745K55	FOAM,FIRM,BUNA-N,1/8X1
19	4	MML-2	LEVELING PAD, 5/8-11
20	4	NNH1/2-13	NUT,HEX,1/2-13
21	8	NNH5/8-11	NUT,HEX,5/8-11
22	2	NNH5/16-18	NUT,HEX, 5/16-18
23	6	PPP64001008	STR 7/8-14MJIC,3/4-16MORB
24	1	RBM4524	STRAIN RELIEF,1-1/4 NPT
25	1	RBM9144	LOCKNUT,NYLON,1-1/4"NPT
26	10	SSHC05048	1/4-28 X 3/4 HEX CAP
27	2	SSHC10320	5/16-18 X 5 HEX CAP SC
28	4	SSHC45080	1/2-13X1-1/4 HEX CAP
29	8	WWFS1/2	WASHER,FLAT,1/2, SAE
30	10	WWFS1/4	WASHER,FLAT,SAE,1/4
31	4	WWFS5/16	WASHER,FLAT,SAE,5/16
32	4	WWL1/2	1/2 LOCK WASHER
33	10	WWL1/4	WASHER,LOCK, 1/4
34	2	WWL5/16	WASHER,LOCK, 5/16



1406670 Lexan Guards W/Tape

AAC Drawing Number 1406670 Rev 1

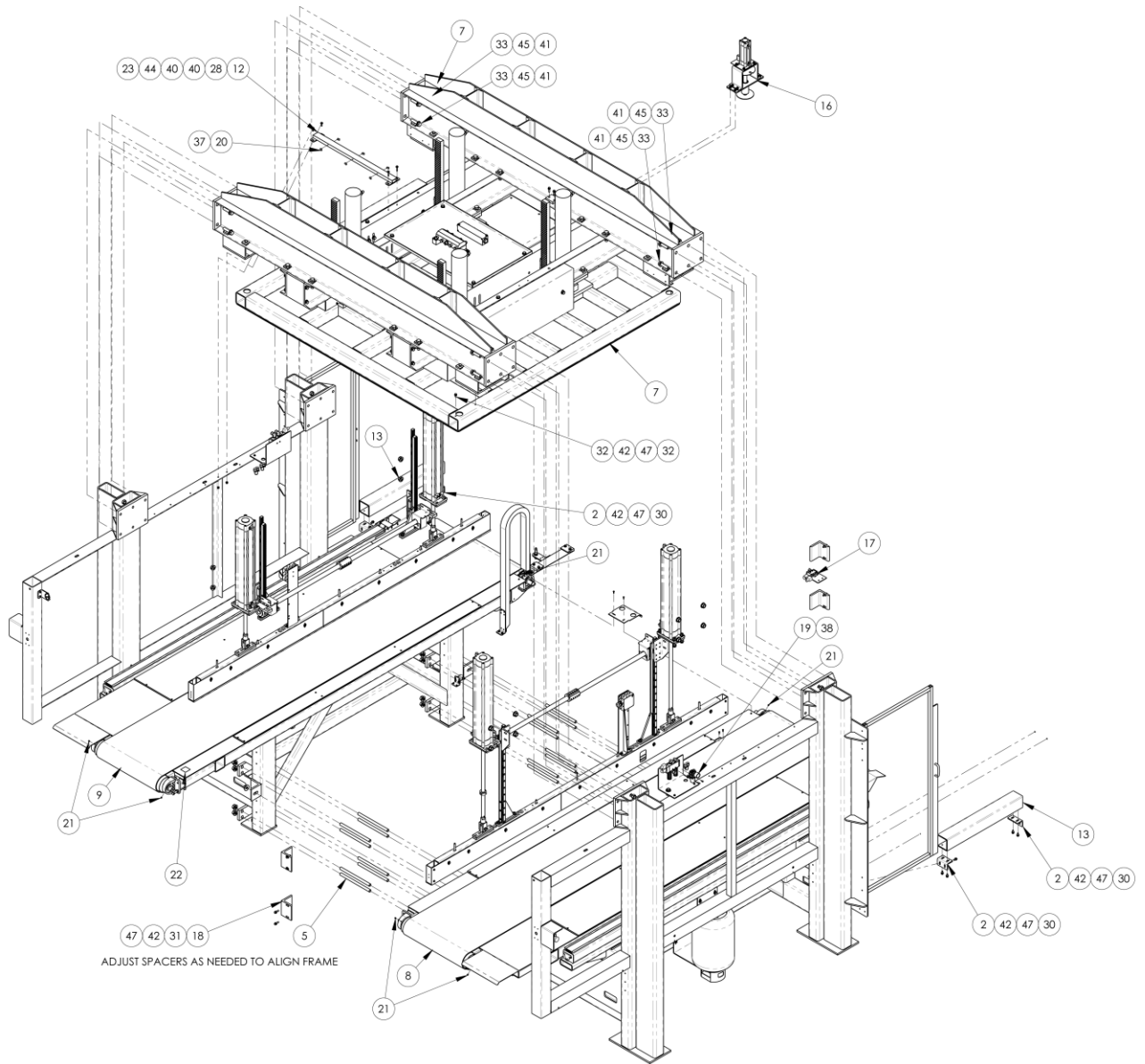
NO	QTY	PART #	DESCRIPTION
1	1	1390003	SIDEPANEL #3, LEXAN
2	1	1391150	GUARD, LEFT FRONT-INFEED
3	1	1406534	GUARD, LEXAN-INFEED LH
4	2	1406656	SIDE PANEL, REAR RIGHT
5	2	1406657	SIDE SEAL GUARD, LH & RH
6	2	1406658	GUARD,DOOR PANEL,LH & RH
7	1296"	ZZZSH-310	TAPE, DOUBLE SIDED

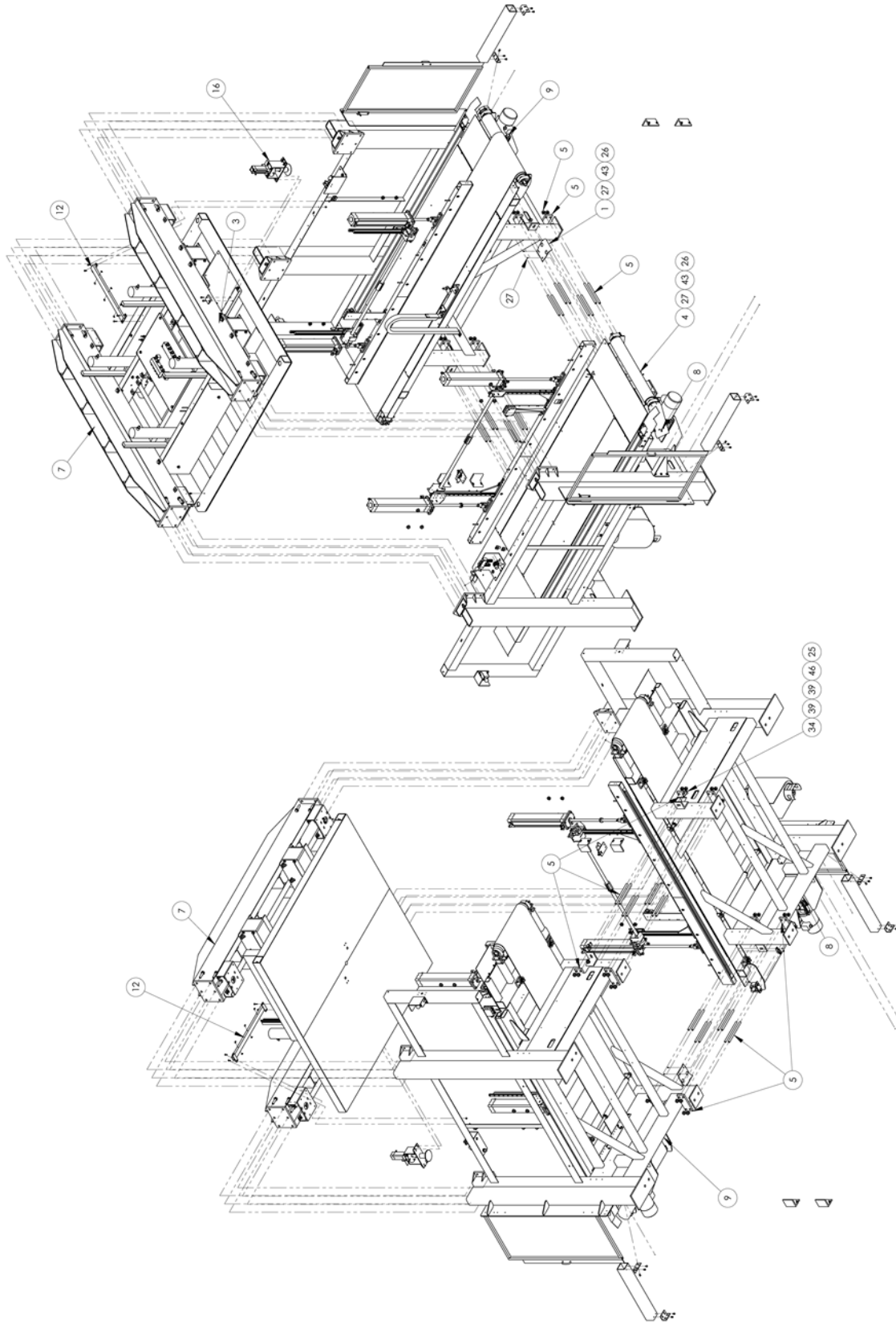


1406759 Input Conveyor

AAC Drawing Number 1406759 Rev 1

NO	QTY	PART #	DESCRIPTION
1	2	1390067	GUARD, CHAIN, SEAL-BAR, R
2	4	1390159	SPACER,LATCH,LEFT
3	2	1390394	GUARD, CHAIN, SEAL-BAR, R
4	4	1390617	TOP RACK SPACER
5	1	1390623	GUARD, CHAIN, UPR ROLLER
6	4	1390969	PLATE, SPACER, DOOR LATCH
7	1	1391054	ROLL HOLDER FRAME
8	1	1391056	LOWER ROLL FEED
9	2	1391091	GUARD, CYLINDER
10	3	1391176	MTG BRKT, SIX MODULE STAT
11	1	1391178	GUARD, CHAIN, LWR ROLLER
12	1	1391179	GUARD, LOWER FILM GEAR BO
13	2	1391180	MTG BRKT, LOWER FILM MOTO
14	1	1391382	GUARD, CHAIN, UPR ROLLER
15	1	1391435	GUARD, CHAIN, UPR ROLLER
16	2	1391446	ROLLER ASSY, 24"
17	2	1391499	BELT,CONVEYOR,FRONT,24"
18	2	1391873	GUARD, ROLLER BEARINGS
19	4	1394286	NUT PLATE
20	1	1406758	INPUT CONVEYOR ASSY. #4
21	4	MM1676A12	MAGNETIC CATCH
22	4	MM2421K31	GREASE FITTING, FLUSH-STYLE
23	5	NNH1/2-13	NUT,HEX,1/2-13
24	2	NNK10-32	KEP NUT, 10-32
25	8	SSHHC01048	1/4-20 X 3/4 HEX HEAD
26	4	SSHHC25080	3/8-16 X 1-1/4 HEX HEAD
27	5	SSHHC45192	1/2-13X3 HEX CAP
28	8	SSSC90024	#8-32 X 3/8 SOC CAP SC
29	8	SSSC98024	10-32 X 3/8 SOC CAP
30	36	SSSC98032	10-32X1/2, SOC CAP
31	8	SSSC98048	10-32 X 3/4 SOC CAP
32	8	WWF8	WASHER, FLAT, #8
33	10	WWF1/2	WASHER,FLAT,1/2, SAE
34	8	WWF1/4	WASHER,FLAT,SAE,1/4
35	4	WWF3/8	WASHER,FLAT,SAE,3/8
36	52	WWF10	WASHER, FLAT, #10, SAE
37	5	WWL1/2	1/2 LOCK WASHER
38	10	WWL1/4	WASHER,LOCK, 1/4
39	4	WWL3/8	WASHER,LOCK, 3/8
40	8	WWL8	WASHER,LOCK,#8
41	48	WWL10	WASHER,LOCK,#10

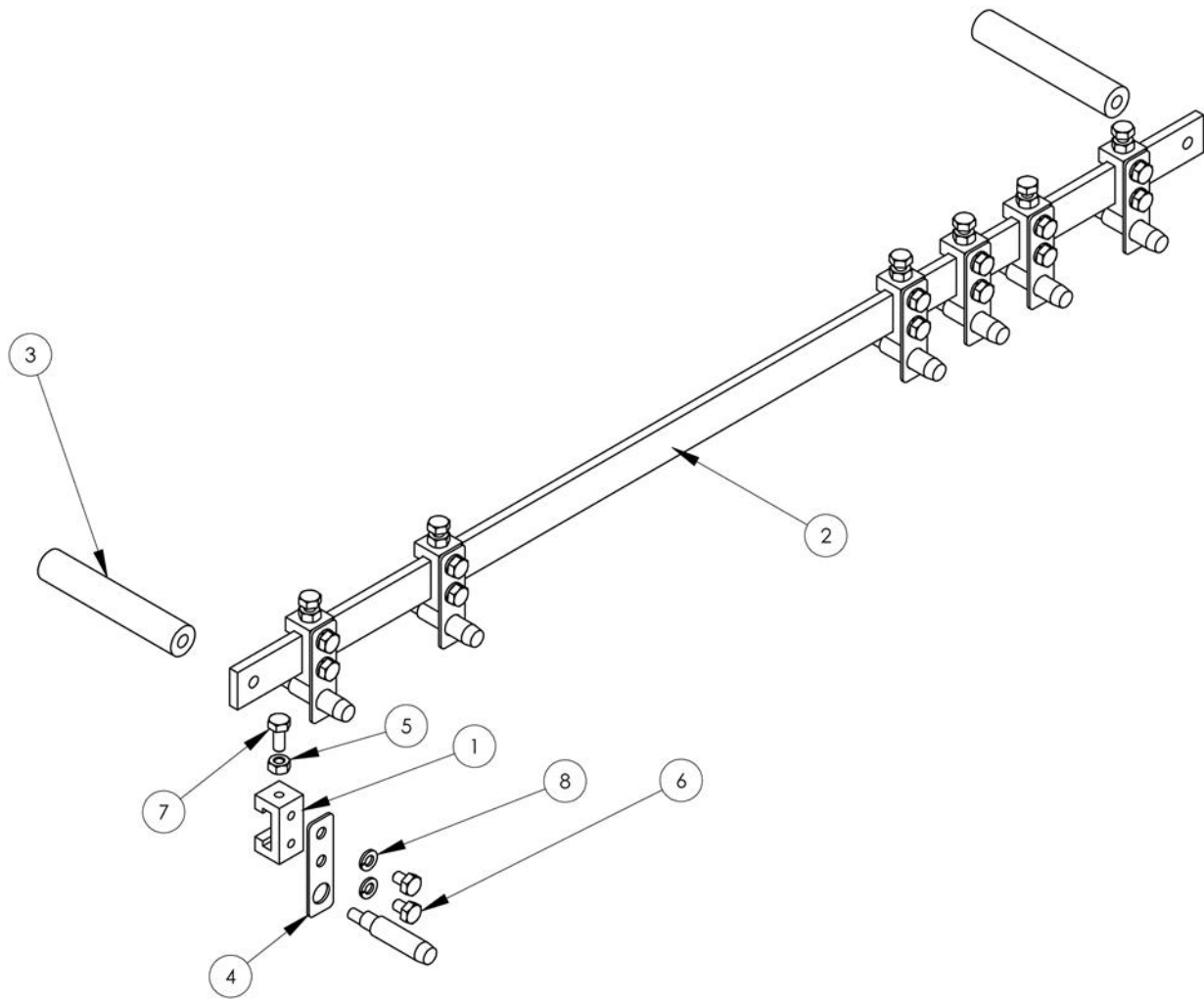




1406760 Exit Assembly W/ Hydraulic Compression

AAC Drawing Number 1406760 Rev 5

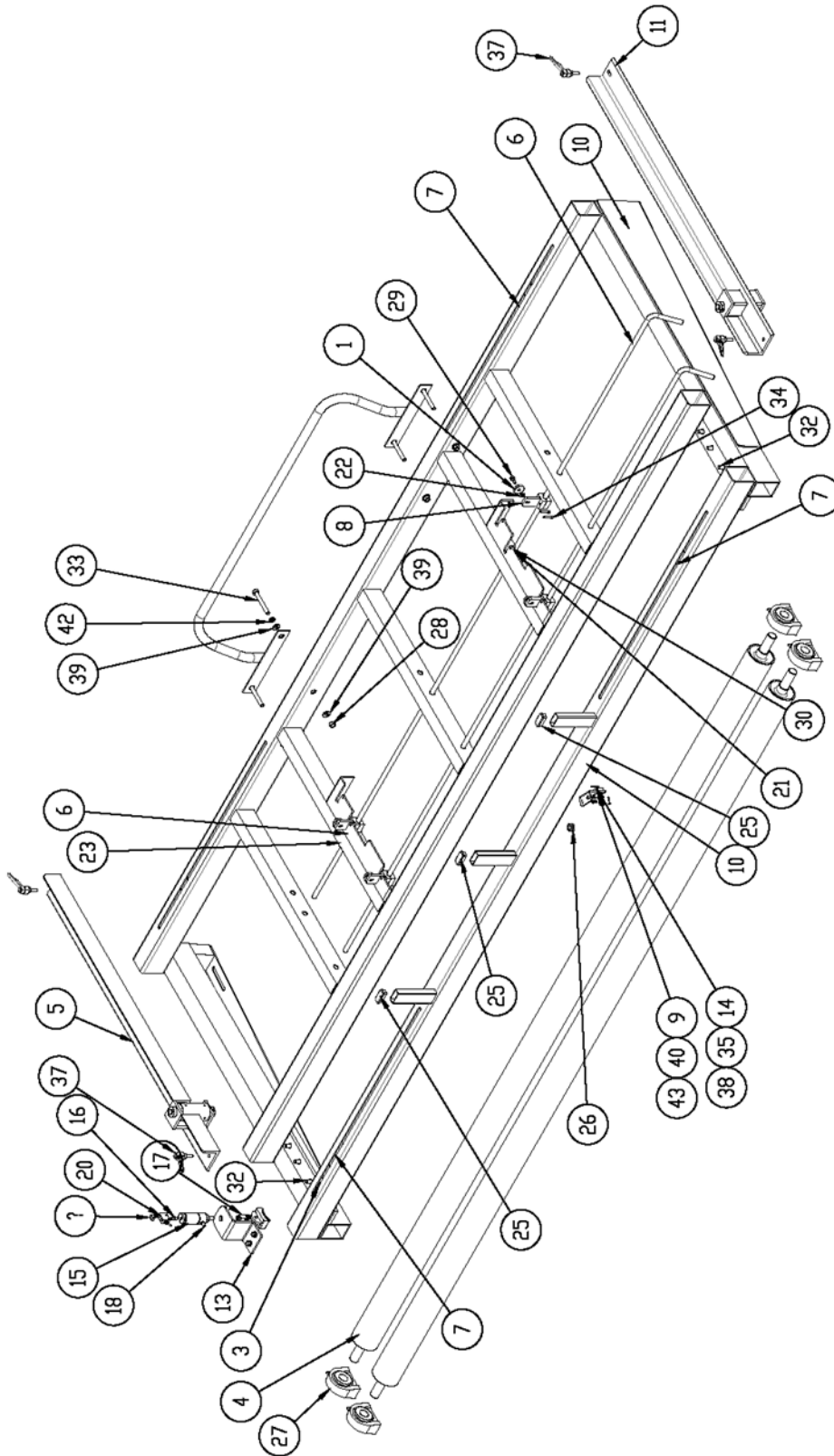
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	1390225	GUARD, COUPLING	27	4	SSFC98040	#10-32 X 5/8 FLAT ALLEN
2	4	1390384	PLATE, MOUNTING	28	2	SSHC01064	1/4-20 X 1 HHCS
3	1	1406260	UPPER STOP EYE ASSY	29	2	SSHC01096	1/4-20 X 1-1/2 HHCS
4	1	1406265	LOWER STOP EYE ASSY	30	10	SSHC10048	5/16-18 X 3/4 HHCS
5	4	1406297	OUTFEED FRAME CLAMP ASSY	31	8	SSHC10080	5/16-18 X 1-1/4 HHCS
6	1	1406550	PLATEN HEIGHT DETECT ASSY	32	2	SSHC20048	5/16-24 X 3/4 HEX CAP
7	1	1406570	HYD COMP, 120" SIDESEAL	33	24	SSHC34192	3/4-10 X 3 HEX CAP
8	1	1406580	SIDE SEALER 120", LEFT	34	2	SSHC41160	5/8-11X2-1/2 HEX CAP
9	1	1406590	SIDE SEALER 120", RIGHT	35	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
10	2	1406595	CYLINDER ASSY. SIDE SEAL	36	2	SSSC98032	10-32X1/2, SOC CAP
11	2	1406596	CYLINDER ASSY. SIDE SEAL	37	6	SSZH#10032	SCREW,SHT.METAL HEX 10
12	1	1406621	HYDRAULIC HOSE SUPPORT	38	2	SSZH#10048	SCREW,SHT.METAL HEX 10
13	2	1406623	TUBE,F,4X4X.25WX29L	39	4	WWF5/8	WASHER,FLAT,5/8
14	2	1406640	SIDE SEAL SYNC BAR ASSY	40	6	WWFS1/4	WASHER,FLAT,SAE,1/4
15	2	1406645	SIDE SEAL BAR ASSY, 110"	41	24	WWFS3/4	WASHER, .797ID X 1-1/2OD
16	1	1406715	MATRESS PIVOT ASSY	42	20	WWFS5/16	WASHER,FLAT,SAE,5/16
17	1	1406727	VALVE ASSY, PIVOT ASSY	43	6	WWFS10	WASHER, FLAT, #10, SAE
18	4	1406924	SPACER, FRAME, .50 THK	44	4	WWL1/4	WASHER,LOCK, 1/4
19	1	AA198-503B	REG,0-30 W/GAUGE& BRKT, R	45	24	WWL3/4	3/4 LOCK WASHER
20	6	AAF3/16	CLAMP, BLACK PLASTIC	46	2	WWL5/8	WASHER,LOCK 5/8
21	6	MM2421K31	GREASE FITTING, FLUSH-STYLE	47	20	WWL5/16	WASHER,LOCK, 5/16
22	1	MMT9945	TAPE,REFLECTIVE,2" WIDE	48	2	WWL10	WASHER,LOCK,#10
23	4	NNH1/4-20	NUT,HEX,1/4-20	49	2	WWSI4	WASHER,INT. TOOTH
24	24	NNH3/4-10	NUT,HEX,3/4-10	50	2	WWSQ044	WASHER,SQUARE STRUCTURAL
25	2	NNH5/8-11	NUT,HEX,5/8-11	51	16	WWF3/4	WASHER,FLAT,3/4
26	4	NNK10-32	KEP NUT, 10-32				



1391623 Infeed Sensor Assembly

AAC Drawing Number 1391623 Rev 0

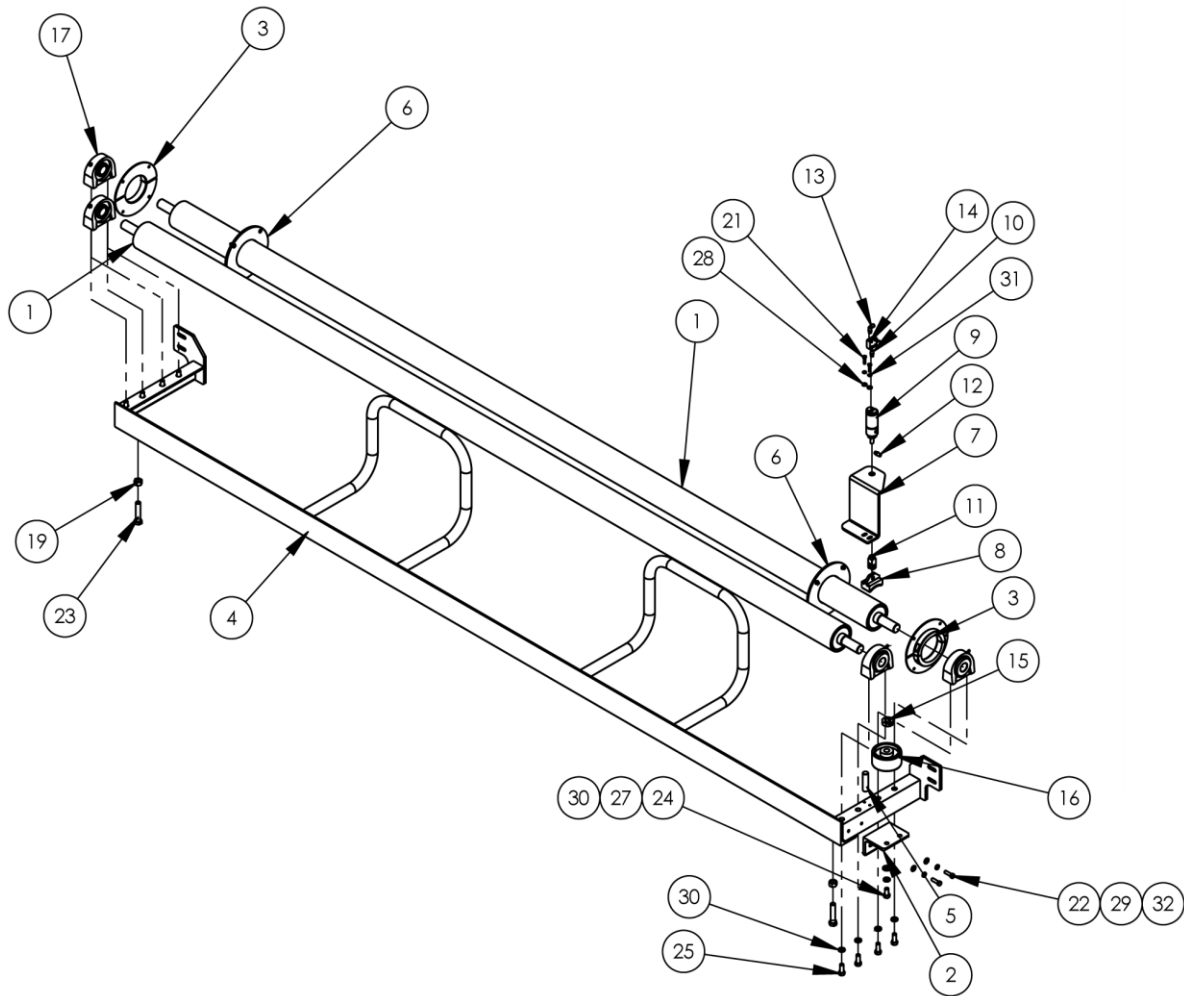
NO	QTY	PART	DESCRIPTION
1	7	1390410	BRACKET, SENSOR
2	1	1390495	BAR, SENSOR MOUNTING
3	2	1391624	SPACER, SIZE SENSOR RAIL
4	7	1391625	BRACKET, SENSOR
5	7	NNH3/8-16	1/4-20 HEX NUT
6	14	SSHCO1024	1/4-20 X 3/8 HEX HEAD
7	7	SSHCO1040	1/4-20 X 5/8 HEX HEAD
8	14	WWL1/4	1/4 LW



1391054 Roll Holder Frame

AAC Drawing Number 1391054 Rev 3

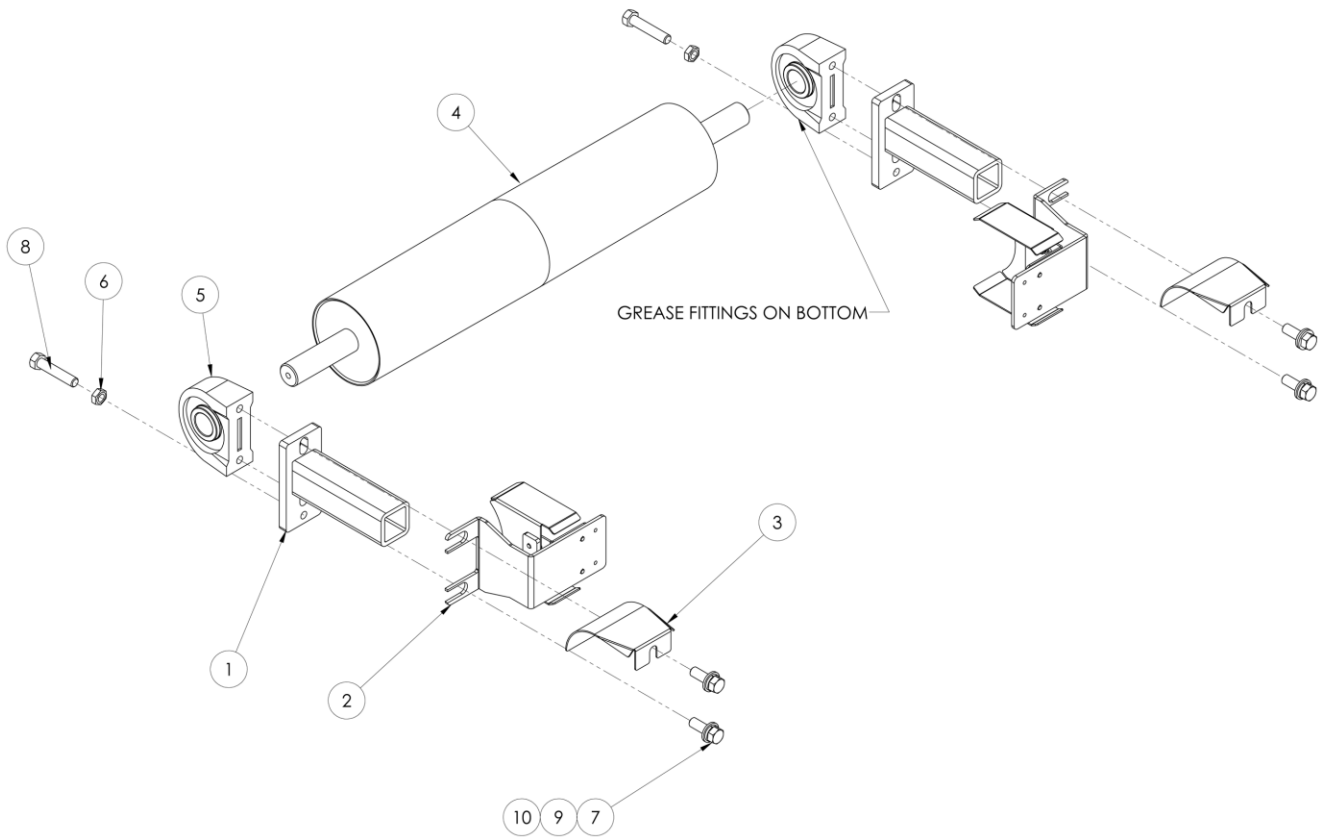
NO.	QTY	PART#	DESCRIPTION
1	4	1390198	ROLL RELEASE DISK
2	1	1390233	ROLL STOP TUBE
3	1	1390276	NUT PLATE-ROLL BRAKE MTG
4	2	1390405	SUPPORT ROLLER WELDT
5	1	1390412	SIDE ROLLER, ROLL HOLDER
6	2	1390458	ROD, ROLL STOP
7	4	1390459	NUT PLATE-SIDE ROLLER ADJ
8	4	1390463	ROLL STOP, WELD'T
9	1	1390468	BRACKET, EYE MOUNT,LH
10	1	1390470	FRAME WELDT- TOP ROLL
11	1	1390759	SIDE ROLLER, LONG
12	1	1391096	BRAKE BLOCK ASSY, 1390B
13	1	1391098	MTG. BRKT. ROLL BRAKE
14	1	1975-412A	PLATE,NUT,4-40,.95CTC
15	1	AAC171D	CYLINDER,AIR,DA,1-1/2 B,1 ST
16	1	AAF122A-A	1/8" NPT HEX CLOSE
17	1	AAFCT-15	CLEVIS,AIR CYL,7/16-20
18	1	AAFP18	MUFFLER,1/8 NPT, BRONZ
19	1	AAQME-5-8	QUICK MALE ELBOW
20	1	AAVMJTV-3	VALVE,TOGGLE
21	4	BB1L038	BEARING,BALL,.375B
22	4	BBTRA613	WASHER,THRUST,STL, .375B
23	2	CCCL10F	CLAMP COLLAR- 5/8 ID
24	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
25	3	MM132-1496	PLUG 1 X 2
26	2	MM9307K63	GROMMET,1/2ID,13/16 HOLE
27	4	MMGRPA207-20	1.25" BEARING, GRIP-IT
28	4	NNH1/2-13	NUT,HEX,1/2-13
29	4	SSAS024024	SHOULDER BOLT 3/8 X 3/8L
30	4	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
31	2	SSHC25064	3/8-16X1,HEX CAP
32	8	SSHC45096	1/2-13X1-1/2 HEX CAP
33	4	SSHC45256	1/2-13X4 HEX CAP
34	8	SSSC05080	"SCREW, SOCKET CAP 1/4-28 x 1-1/4
35	2	SSSC70064	4-40 X 1 SOCKET CAP
36	2	SSSC98032	10-32X1/2, SOC CAP
37	4	TTH32430	HANDLE,THRD,3/8-16X1-1/4
38	2	WWF4	WASHER, FLAT, #4
39	16	WWFS1/2	WASHER,FLAT,SAE,1/2
40	2	WWFS10	WASHER, FLAT, #10, SAE
41	2	WWFS3/8	WASHER,FLAT,SAE,3/8
42	12	WWL1/2	1/2 LOCK WASHER
43	2	WWL10	WASHER,LOCK,#10
44	2	WWL3/8	WASHER, LOCK, 3/8



1391056 Lower Roll Feed

AAC Drawing Number 1391056 Rev 2

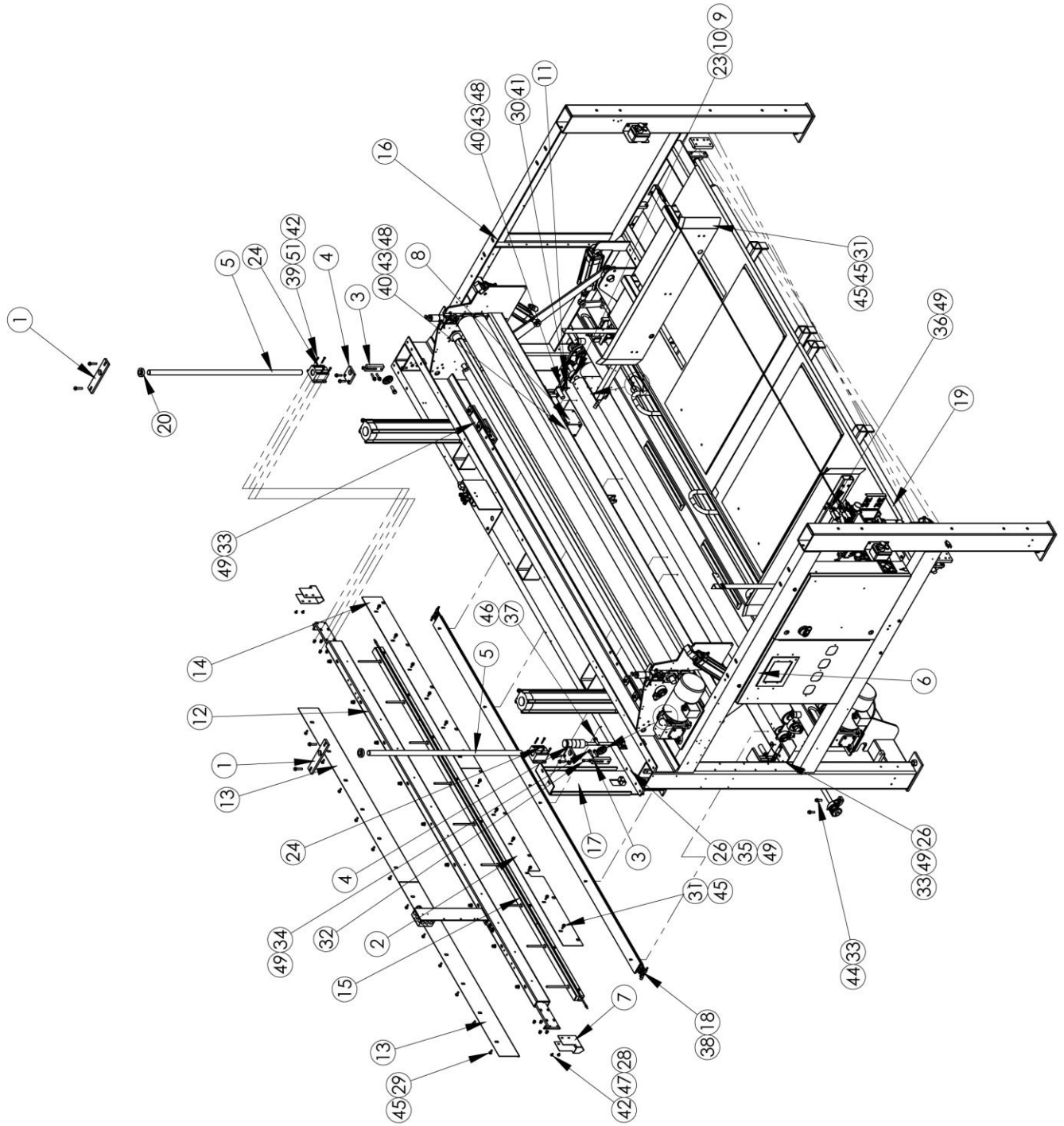
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	1390405	SUPPORT ROLLER WELDT	17	4	MMGRPA207-20	1.25" BEARING, GRIP-IT
2	1	1390804	BOTTOM ROLLER MTG BRKT FO	18	8	NNE10-32	NUT,ELASTIC LOCK
3	2	1390810	GUIDE PLATE ASSY, LOWER R	19	2	NNH5/8-11	NUT,HEX,5/8-11
4	1	1390811	LOWER ROLLER WELDMENT	20	8	SSFC98048	#10-32 X .75 SHCSF
5	1	1390812	AXEL, GLIDE WHEEL	21	2	SSHCO1064	1/4-20 X 1 HHCS
6	2	1390882	SIDE PLATE- BOTTOM ROLL	22	2	SSHC25080	3/8-16 X 1-1/4 HEX CAP
7	1	1391095	MTG. BRKT. BRAKE	23	2	SSHC41192F	5/8-11X4 HEX CAP FULL THD
8	1	1391096	BRAKE BLOCK ASSY, 1390B	24	1	SSHC45064	1/2-13X1 HEX CAP
9	1	AAC171D	CYLINDER,AIR,DA,1-1/2 B,1 ST	25	8	SSHC45080	1/2-13X1-1/4 HEX CAP
10	1	AAF122A-A	1/8" NPT HEX CLOSE	26	8	WWF10	WASHER, FLAT, #10, COM
11	1	AAFCT-15	CLEVIS,AIR CYL,7/16-20	27	1	WWFS1/2	WASHER,FLAT,SAE,1/2
12	1	AAFP18	MUFFLER,1/8 NPT, BRONZ	28	2	WWFS1/4	WASHER,FLAT,SAE,1/4
13	1	AAQME-5-8	QUICK MALE ELBOW	29	2	WWFS3/8	WASHER,FLAT,SAE,3/8
14	1	AAVMJTV-3	VALVE,TOGGLE	30	9	WWL1/2	1/2 LOCK WASHER
15	1	CCCL12F	CLAMP COLLAR- 3/4	31	2	WWL1/4	WASHER,LOCK,1/4
16	1	MM2419T31	WHEEL, 4"OD X 2"W X 3/4 B	32	2	WWL3/8	WASHER, LOCK, 3/8



1391446 Roller Assembly, 24"

AAC Drawing Number 1391446 Rev 2

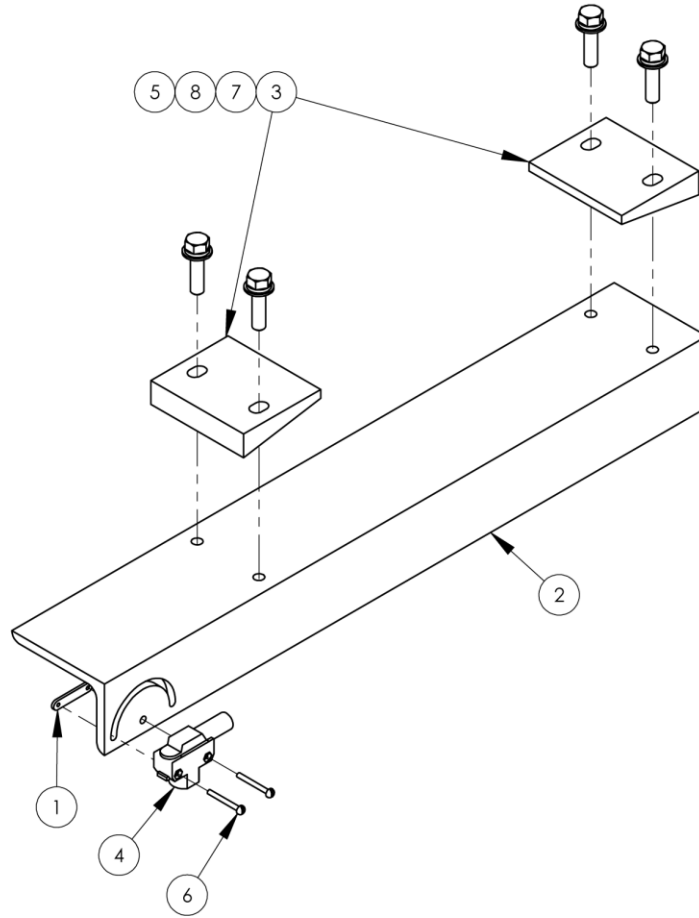
NO	QTY	PART #	DESCRIPTION
1	2	1390282	WELDMENT, BELT-TENSIONER
2	2	1390681	GUARD, ROLLER
3	2	1390859	COVER, PILLOWBLOCK
4	1	1391447	IDLER-ROLLER, 24" BELT
5	2	MMUCPA207-20	1.25" BEARING
6	2	NNJ1/2-13	1/2-13 JAM NUT
7	4	SSH45096	1/2-13 X 1-1/2 HEX HEAD
8	2	SSH45160F	1/2-13X2-1/2 HEX CAP
9	5	WWFS1/2	WASHER,FLAT,1/2, SAE
10	3	WWL1/2	1/2 LOCK WASHER



1406758 Input Conveyor Assembly #4

AAC Drawing Number 1406758 Rev 2

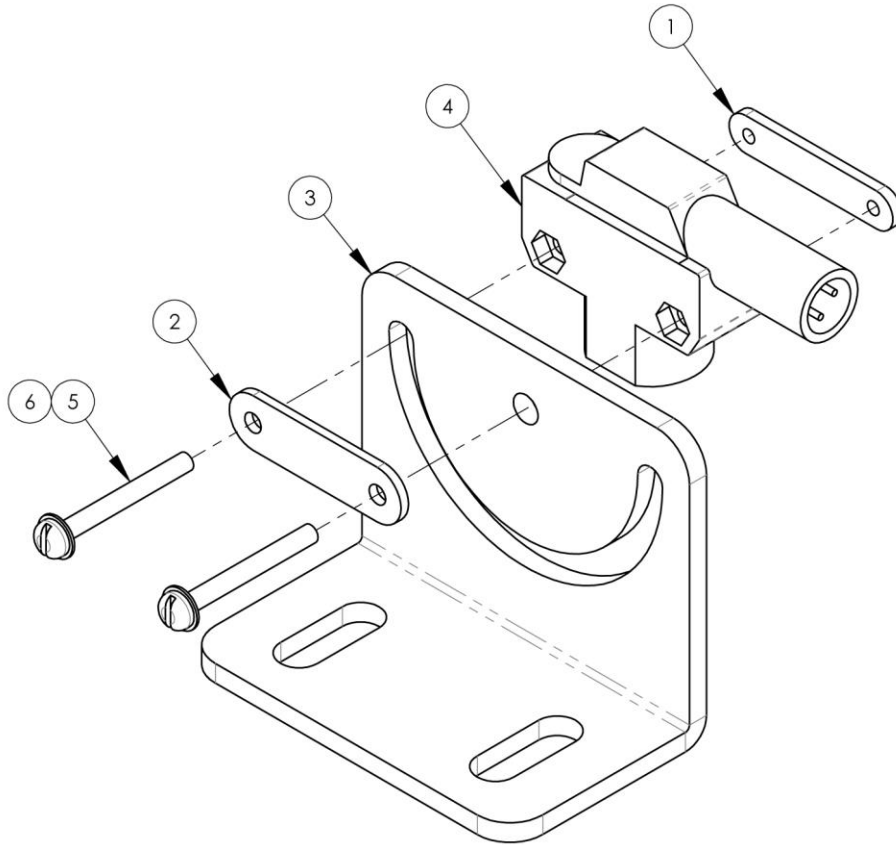
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	2	1390324	TOP BRACKET LINEAR SHAFT	27	2	NNJ3/8-16	3/8-16 JAM NUT
2	1	1390337	INPUT GUARD CROSS SEAL RT	28	4	SSBC01040	1/4-20 X 5/8 BUT HEAD
3	2	1390342	TOP CHAIN TENSIONER	29	12	SSBC10064	5/16-18 X 1 BUT HEAD
4	2	1390343	LOWER LINEAR BRKT CROSS	30	2	SSBC98048	#10-32 X 3/4 BUT HEAD
5	2	1390346	SHAFT,ROLLER	31	16	SSHC10064	5/16-18 X 1" HEX HEAD
6	1	1390484	SHAFT ASSY, IDLER SPKTS	32	2	SSHC25080	3/8-16 X 1-1/4 HEX HEAD
7	2	1390485	END PLATE, CROSS SEAL	33	18	SSHC25096	3/8-16 X 1-1/2 HEX HEAD
8	1	1390533	TAPE DISPENSER,CROSSBAR	34	4	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
9	1	1390535	TAPE ROLLER	35	4	SSHC25128	3/8-16 X 2 HEX HEAD
10	1	1390537	AXLE, TAPE ROLLER	36	2	SSHC25224	3/8-16 X 3-1/2 HEX HEAD
11	1	1390539	ROLLER,TAPE ALIGNMENT	37	2	SSHC45112	1/2-13 X 1-3/4 HEX HEAD
12	1	1390609	MOUNT, CROSS SEAL BAR	38	6	SSPS98032	#10-32 X 1/2 PAN HD SLOT
13	2	1390858	INPUT GUARD CROSS SEAL	39	8	SSSC05096F	1/4-28 X 1-1/2 SOC CAP FULL
14	1	1390967	INPUT GUARD CROSS SEAL LT	40	5	SSSC98032	#10-32 X 1/2 SOC CAP
15	1	1406519	SEAL BAR 120" ASSEMBLY	41	2	WWFE016	WASHER,FENDER,LARGE,1/4
16	1	1406757	INPUT CONVEYOR ASSY. #3	42	12	WWFS1/4	WASHER,FLAT,SAE,1/4
17	1	1406823	SUPPORT, CENTER CROSSBAR	43	5	WWFS10	WASHER, FLAT, #10, SAE
18	1	1406995	BLADDER KIT, 120" CROSS SEAL	44	36	WWFS3/8	WASHER,FLAT,SAE,3/8
19	1	1490345	IDLER ROLLER ASSY. FILM	45	32	WWFS5/16	WASHER,FLAT,SAE,5/16
20	2	CCCL20F	COLLAR,1 1/4" CLAMP TYPE	46	2	WWL1/2	1/2 LOCK WASHER
21	2	MM41E15	SPROCKET, 1/2 P, 15T	47	4	WWL1/4	WASHER,LOCK, 1/4
22	1	MM9307K63	GROMMET,1/2ID,13/16 HOLE	48	5	WWL10	WASHER,LOCK,#10
23	2	MM94807A029	PUSHNUT,ROUND,1/4 DIA	49	28	WWL3/8	WASHER,LOCK, 3/8
24	2	MMPB20M	LIN. PILLOW-BLOCK,MOD.	50	24	WWL5/16	WASHER,LOCK, 5/16
25	16	NNH1/4-28	NUT,HEX,1/4-28	51	8	WWS307-1	WASHER,SPRING,BELVEL
26	8	NNH3/8-16	3/8-16 HEX NUT				



1406260 Upper Stop Eye Assembly

AAC Drawing Number 1406260 Rev 0

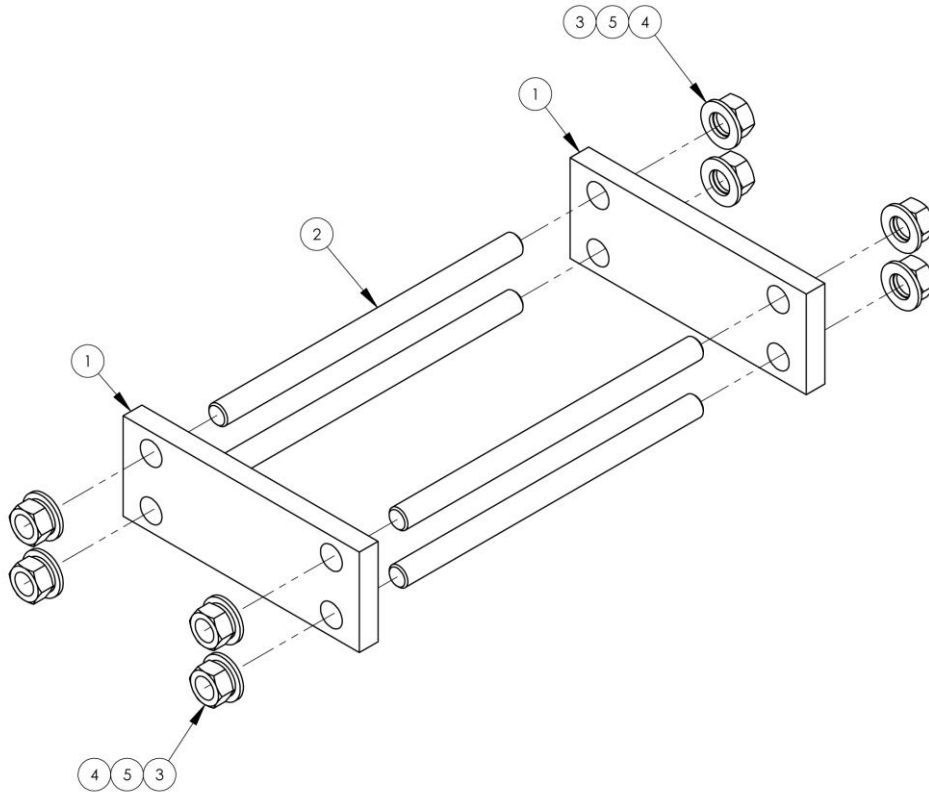
NO	QTY	PART #	DESCRIPTION
1	1	1975-412A	PLATE,NUT,4-40,.95CTC
2	1	1406259	UPPER STOP EYE MOUNT
3	2	1406261	CLAMPING WEDGE
4	1	FFQS186LEQ8	SENSOR,LASER EMITTER
5	4	SSHHC20080	5/16-24 X 1-1/4 HEX CAP
6	2	SSPS70064	4-40 X 1 PAN HD SLOTTED
7	4	WWFS5/16	WASHER,FLAT,SAE,5/16
8	4	WWL5/16	WASHER,LOCK, 5/16



1406265 Lower Stop Eye Assemblies

AAC Drawing Number 1406265 Rev 0

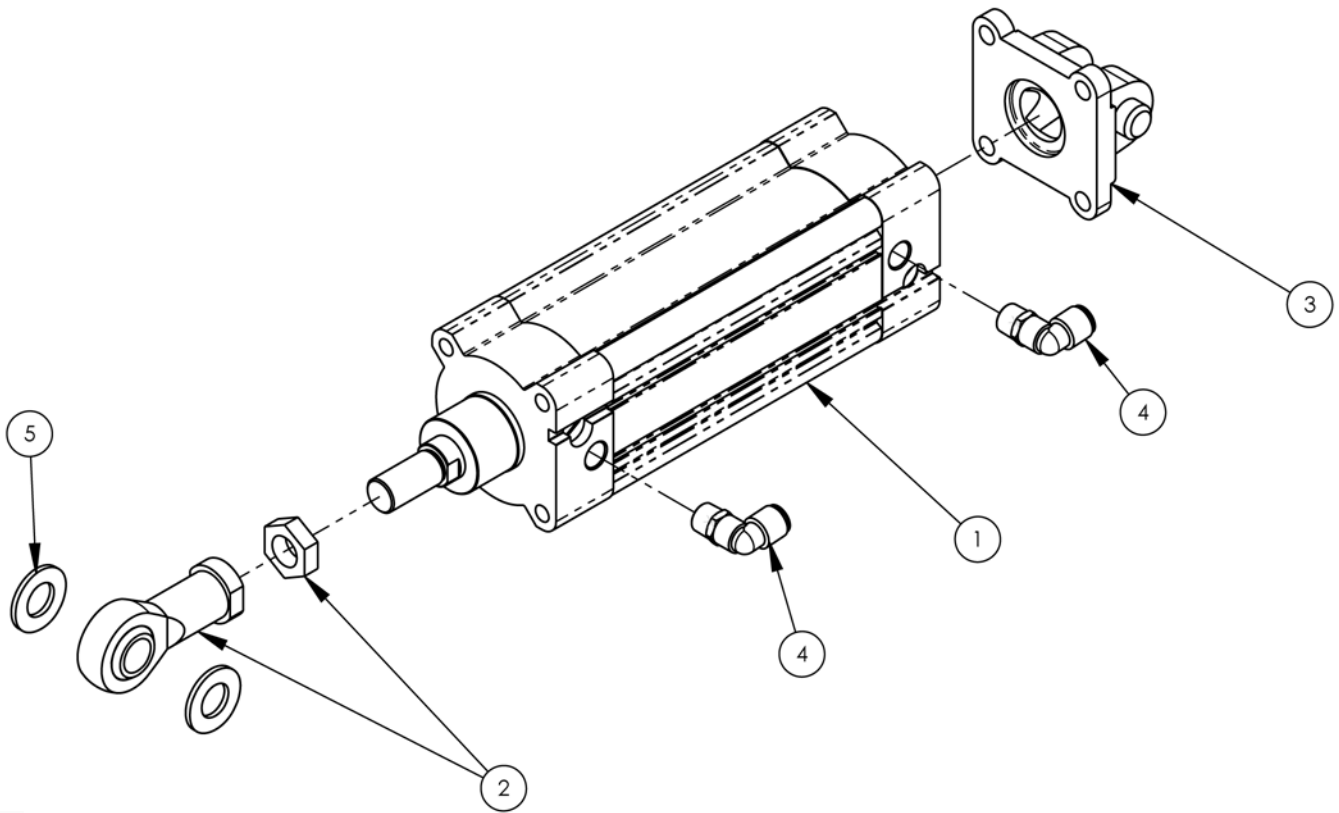
NO	QTY	PART #	DESCRIPTION
1	1	1975-412A	PLATE,NUT,4-40,.95CTC
2	1	1406262	WASHER PLATE, .95 CTC
3	1	1406396	BRACKET, EYE MOUNT,LH
4	1	FFQS18VN6RQ8	SENSOR,LASER RECEIVER,NPN
5	2	SSPS70064	4-40 X 1 PAN HD SLOTTED
6	2	WWSI4	WASHER,INT. TOOTH



1406297 Outfeed Frame Clamp Assembly

AAC Drawing Number 1406297 Rev 1

NO	QTY	PART #	DESCRIPTION
1	2	1406295	OUTFEED FRAME CLAMP BAR
2	4	MM90034A064	THREADED ROD, 3/4-10 X 12
3	8	NNH3/4-10	NUT, HEX, 3/4-10
4	8	WWFS3/4	WASHER, .797ID X 1-1/2OD
5	8	WWL3/4	3/4 LOCK WASHER



1391077 Gate Pivot Cylinder Assembly

AAC Drawing Number 1391077 Rev 1

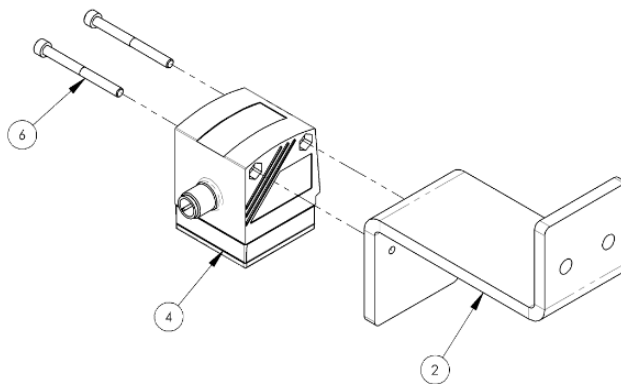
NO.	QTY	PART #	DESCRIPTION
1	1	AACDNCB80160PPV	CYLINDER,AIR,ISO,80X160
2	1	AAFSGSM20x15	ROD END, FEM-20MM X 1.5MM
3	1	AAFSNC80	REAR PIVOT
4	2	AAQME-3-3U	MALE ELBOW 3/8 OD TUBE,3/8UNIFIT
5	2	WWFS3/4	WASHER, .797ID X 1-1/2OD

1406550 Platen Height Detect Assembly

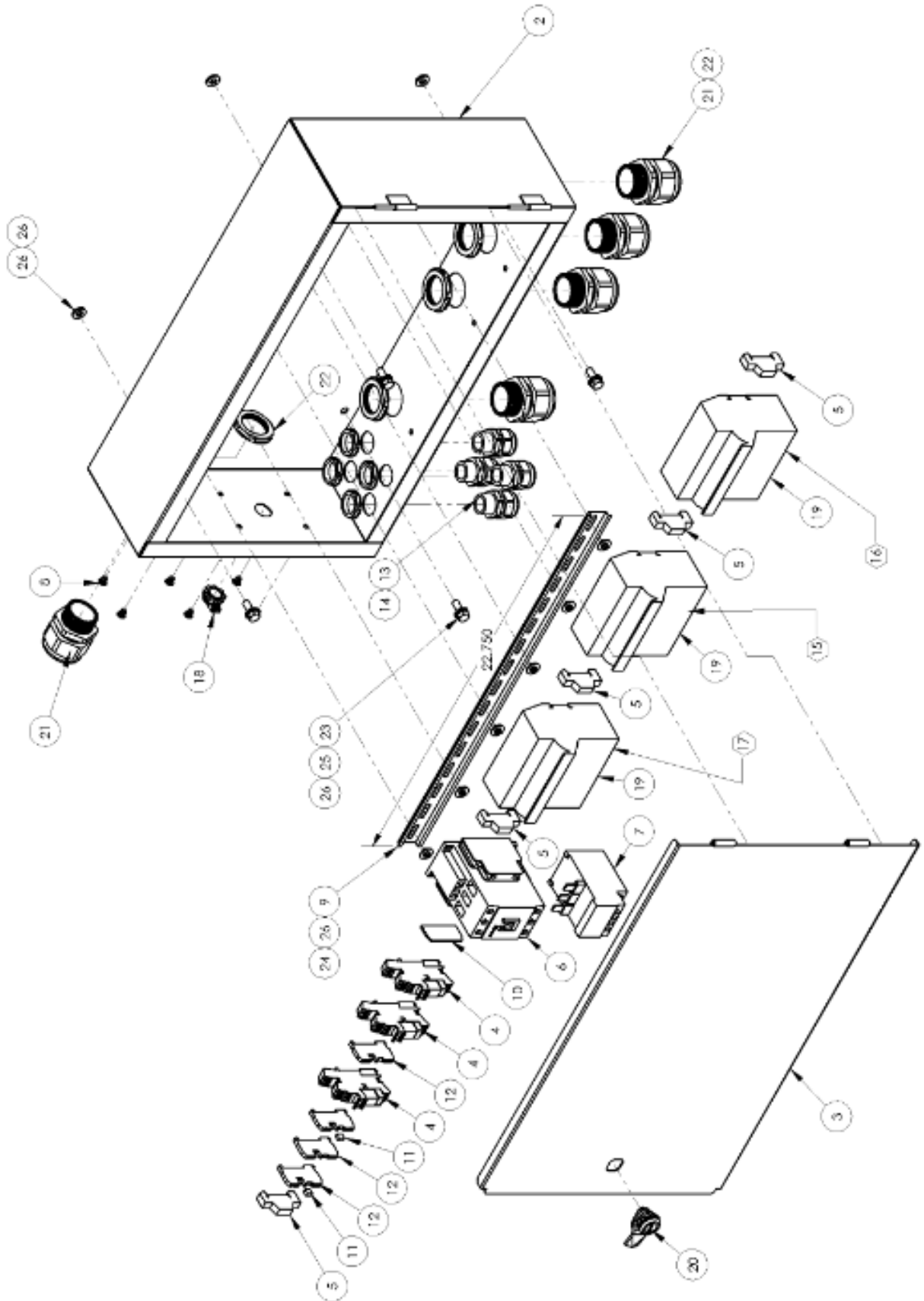
AAC Drawing Number 1406550 Rev 1

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1315062	BRACKET, BACKSTOP SENSOR
2	1	1315067	MOUNT, BACKSTOP SENSOR
3	2	1406261	CLAMPING WEDGE
4	1	1406546	PLATEN HEIGHT PROX MOUNT
5	2	1406547	CABLE TRACK SUPPORT BRKT
6	1	1406548	HEIGHT SENSOR MOUNT BRKT
7	1	FFT18FF25Q	EYE, FIXED FIELD, 1IN
8	1	FFUK1D-E9-OEM1	SENSOR, ULTRASONIC, ANALOG OUT 0-10V,
9	1	MM45021-37	DUCT, WIRE PLASTITRAK
10	4	SSFC01032	1/4-20 X 1/2 FLAT ALN CAP
11	2	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
12	6	SSHC01048	1/4-20 X 3/4 HEX CAP
13	4	SSHC20080	5/16-24 X 1-1/4 HEX CAP
14	2	SSSC98032	10-32X1/2, SOC CAP
15	6	WWFS1/4	WASHER, FLAT, SAE, 1/4
16	4	WWFS5/16	WASHER, FLAT, SAE, 5/16
17	2	WWFS10	WASHER, FLAT, #10, SAE
18	6	WWL1/4	WASHER, LOCK, 1/4
19	4	WWL5/16	WASHER, LOCK, 5/16
20	2	WWL10	WASHER, LOCK, #10

To replace ultrasonic sensor FFUK1D-E9-OEM1 with photoelectric sensor see kit # 1390KIT07 below.



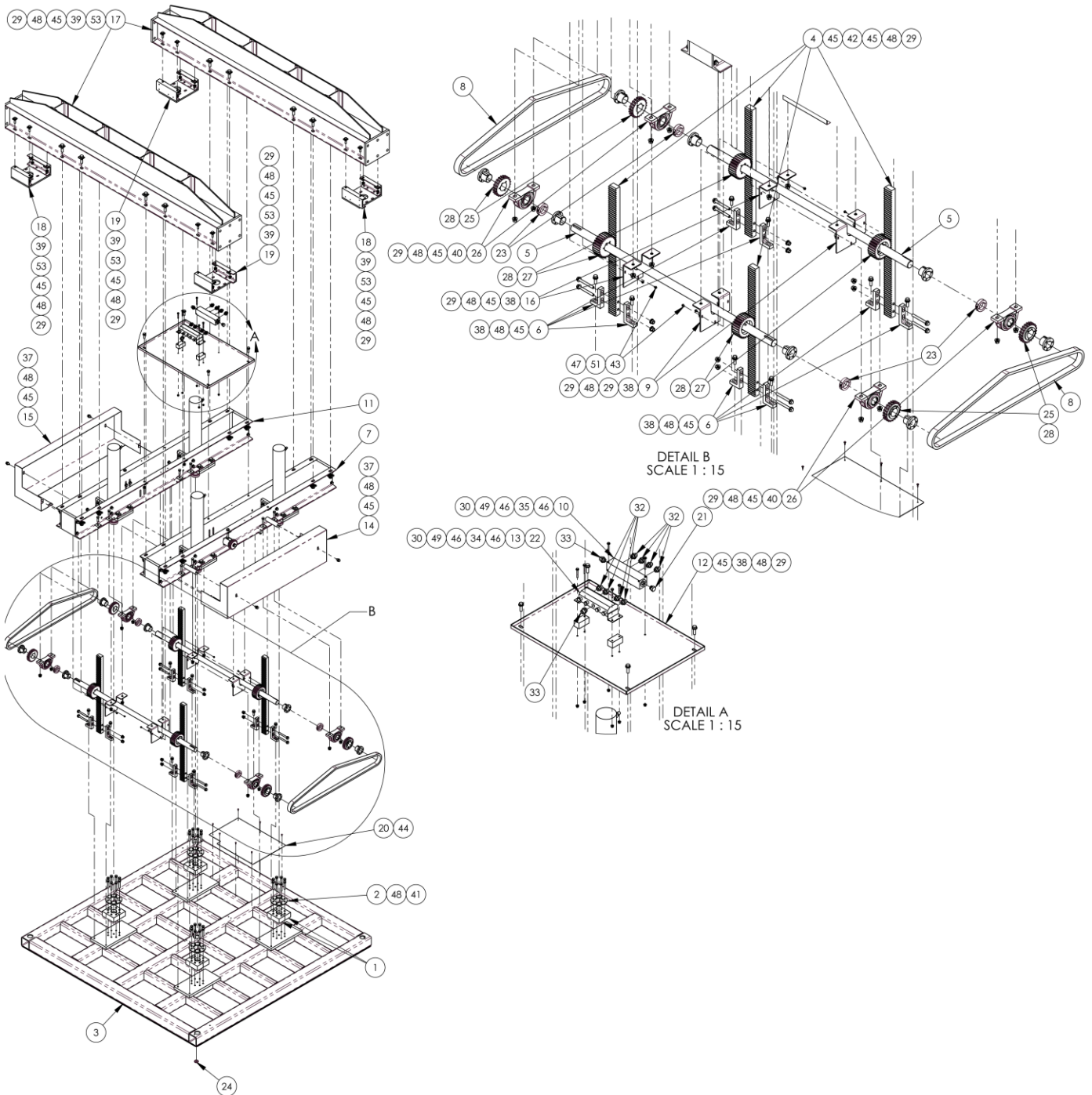
ITEM #	QTY.	PART #	DESCRIPTION
1	1*	4080112-160	CABLE ASSY, 12MM, ANALOG, 160"
2	1	14061314	HEIGHT SENSOR MOUNT BRKT
3	10*	EE6X753	CABLE TIE, 7.40, 50 LB
4	1	EEO1D102	PHOTOELECTRIC, PNP, 3.5M
5	1*	EEO1D102-INS1	SENSOR PROGRAMMING INSTRUCTIONS
6	2	SSSC90112	#8-32 X 1-3/4 SOC CAP SC



1406280 Power Cabinet, 480V

AAC Drawing Number 1406280 Rev 1

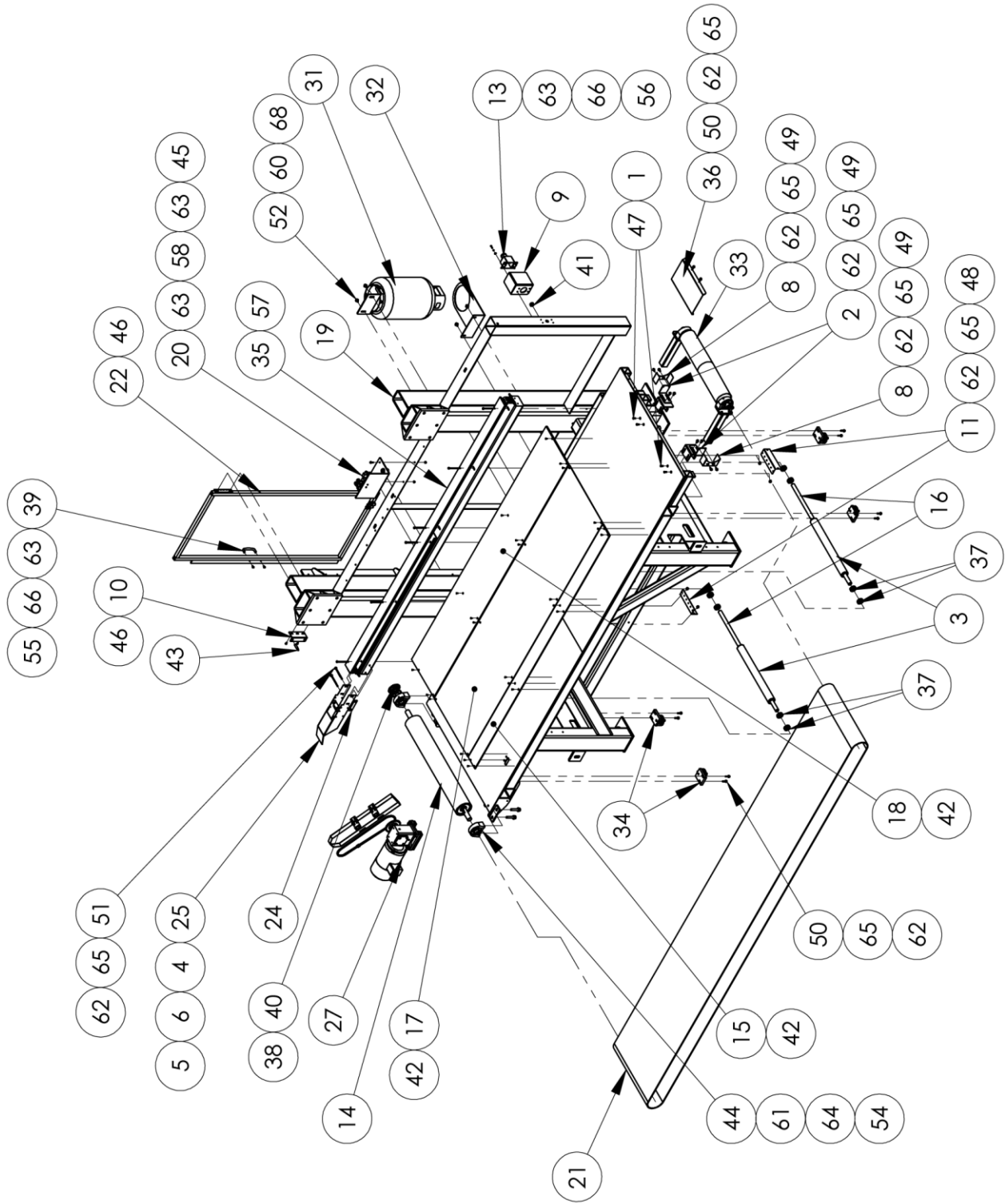
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1406280-WD	DIAGRAM, WIRING
2	1	1406282	PANEL, ELECTRICAL
3	1	1406285	DOOR, FRONT
4	3	EE788312	RELAY,24V,DPDT,WAGO
5	5	EECLIPFIX	ANCHOR,DIN RAIL
6	1	EEMC65A22AC	CONTACTOR,85A,220V AC
7	1	EEMT63L36A	RELAY,OVERLOAD,36A
8	6	EFPBMSH25C	MOUNT,CABLE TIE,NYLON
9	22.75"	EETS35X7.5A	DIN RAIL-AMERICAN
10	1	FF280-308	TERMBLK ENDPLATE,WAGO,280
11	2	FF280-402	JUMPER,WAGO,TOP,SNGL
12	4	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY
13	4	FF3460	STRAIN RELIEF,LIQ TIGHT, 3/4NPT
14	4	FF8465	NUT,LOCK, 3/4NPT,NYLON,BLK
15	3	FFAJT35	FUSE,35A,TIME DELAY
16	3	FFAJT45	FUSE,45A,TIME DELAY
17	3	FFAJT50	FUSE,50A,TIME DELAY
18	1	K-235	CONNECTOR,ROMEX,1/2"
19	3	MM1492FB3J60	FUSE HOLDERS 3 POLE
20	1	MMELH-1	LATCH, 1/4 TURN, SLOTTED
21	5	RBM4524	STRAIN RELIEF,1-1/4 NPT, .87-.1.26, BLK
22	5	RBM9144	LOCKNUT,NYLON,1-1/4"NPT
23	4	SSHC10056	5/16-18 X 7/8 HHCS
24	6	SSPP90020	SCREW,#8-32 X 5/16, PAN HD PHIL
25	4	WWL5/16	WASHER,LOCK, 5/16
26	18	WWFS5/16	WASHER,FLAT,SAE,5/16

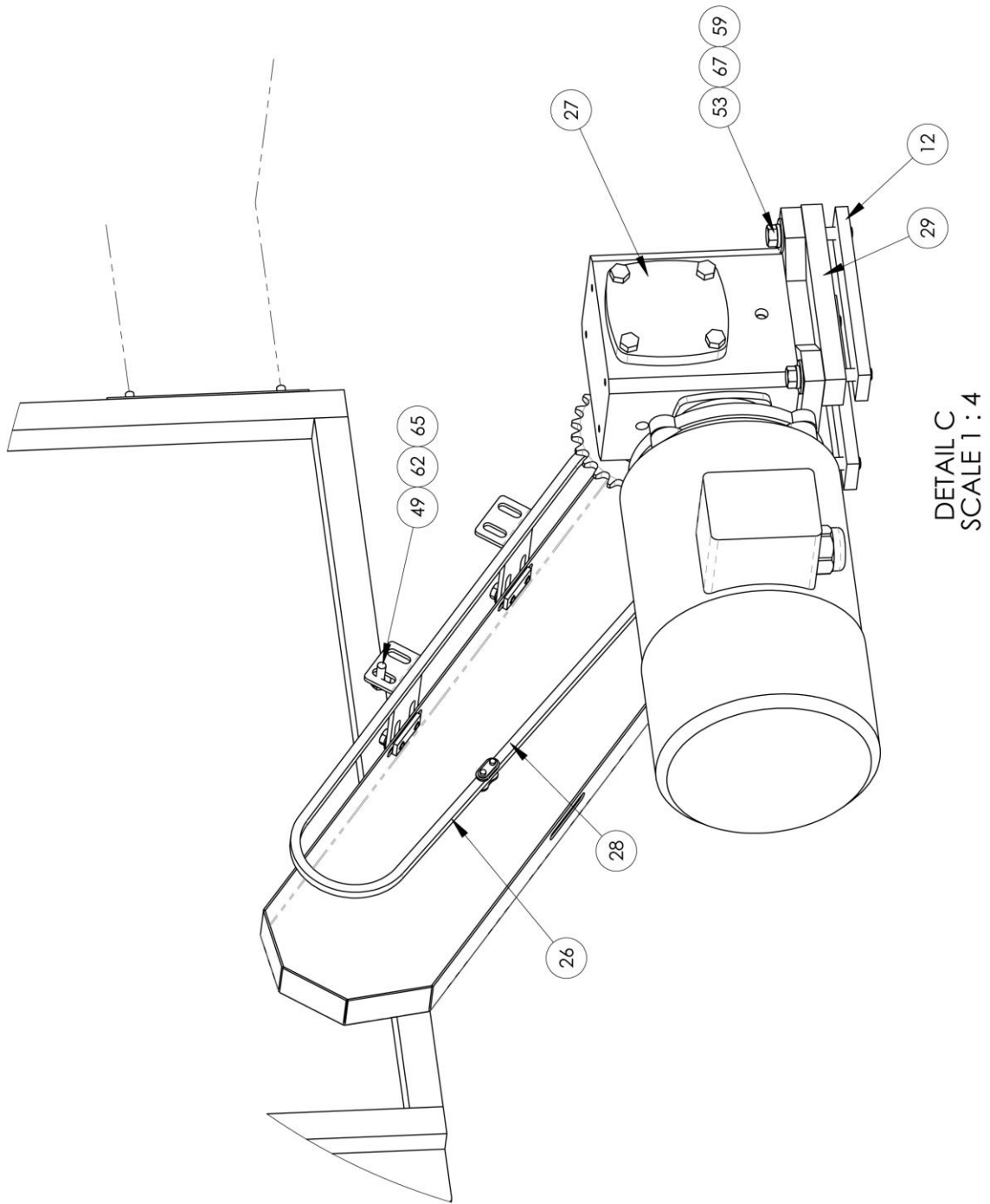


Hydraulic Compression, 120" Side Seal

AAC Drawing Number 1406570 Rev 4

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	8	1406141	SPLIT COUPLING	28	8	MMP1X1.75	BUSHING,SPLIT TAPER,1.75B
2	4	1406150	SPLIT COUPLING PLATE	29	44	NNH1/2-13	NUT,HEX,1/2-13
3	1	1406170	COMPRESSION PLATEN	30	6	NNH1/4-20	NUT,HEX,1/4-20
4	4	1406191	GEAR RACK,6DP,2"F,20 PA	31	16	NNH3/4-10	NUT,HEX,3/4-10
5	2	1406207	TRANSFER SHAFT	32	8	PPP64000810	STR 3/4-16MJIC,7/8-14MORB
6	8	1406208	GEAR RACK MOUNT	33	2	PPP64001010	STR 7/8-14MJIC,7/8-14MORB
7	1	1406210	PLATEN PRESS ASSY, LEFT	34	4	SSHC01144	HEX HEAD BOLTS
8	2	1406213	CHAIN, PLATEN TRANSFER	35	2	SSHC01192	HEX HEAD BOLTS, 1/4-20 X
9	2	1406217	SPROCKET GUARD	36	16	SSHC34176	3/4-10 X 2-3/4 HEX CAP
10	1	1406219	HYDRAULIC MANIFOLD	37	4	SSHC45064	1/2-13X1 HEX CAP
11	1	1406220	PLATEN PRESS ASSY, RIGHT	38	20	SSHC45112	1/2-13 X 1-3/4 HHCS, G8
12	1	1406223	MANIFOLD MOUNT PLATE	39	16	SSHC45128	1/2-13 X 2,HEX CAP
13	2	1406227	FLOW DIVIDER SPACER	40	8	SSHC45144	1/2-13X2 HEX CAP
14	1	1406520	PLATEN CHAIN GUARD, LEFT	41	32	SSHC45192	1/2-13X3 HEX CAP
15	1	1406525	PLATEN CHAIN GUARD, RIGHT	42	8	SSHC45288	1/2-13X4-1/2 HEX CAP
16	2	1406551	SPROCKET GUARD	43	6	SSHC98032	10-32X1/2 HEX HD
17	2	1406562	PLATEN SUPPORT BEAM	44	7	SSZH#10048	SCREW,SHT.METAL HEX 10
18	2	1406599	SIDE SEAL CYL/GEARBOX MNT	45	64	WWFS1/2	WASHER,FLAT,1/2, SAE
19	2	1406601	SIDE SEAL CYL/GEARBOX MNT	46	12	WWFS1/4	WASHER,FLAT,SAE,1/4
20	1	1406679	PLATE, ULTRASONIC TARGET	47	6	WWFS10	WASHER, FLAT, #10, SAE
21	1	HF50925K419	FITTING,HYD,PLUG	48	88	WWL1/2	1/2 LOCK WASHER
22	1	HYBEC-0FE	FLOW DIVIDER, HYD	49	6	WWL1/4	WASHER,LOCK, 1/4
23	4	MM6436K25	COLLAR,SPLIT,1.75ID,2PC	50	16	WWL3/4	3/4 LOCK WASHER
24	1	MM8087K16	PLUG,KNOCK-OUT,1"	51	6	WWL10	WASHER,LOCK,#10
25	4	MMD50P22	SPROCKET,22T,50P,TYPE 12	52	32	WWSQ096M	WASHER,SQUARE STRUCTURAL, MOD
26	4	MMGRP209-28	BEARING,PILLOW BLOCK,1.75	53	16	WWSQ08032SM	WASHER, SQ STRUCT., MOD
27	4	MMGYSS6P30	GEAR,SPUR,6P,30T,20PA				

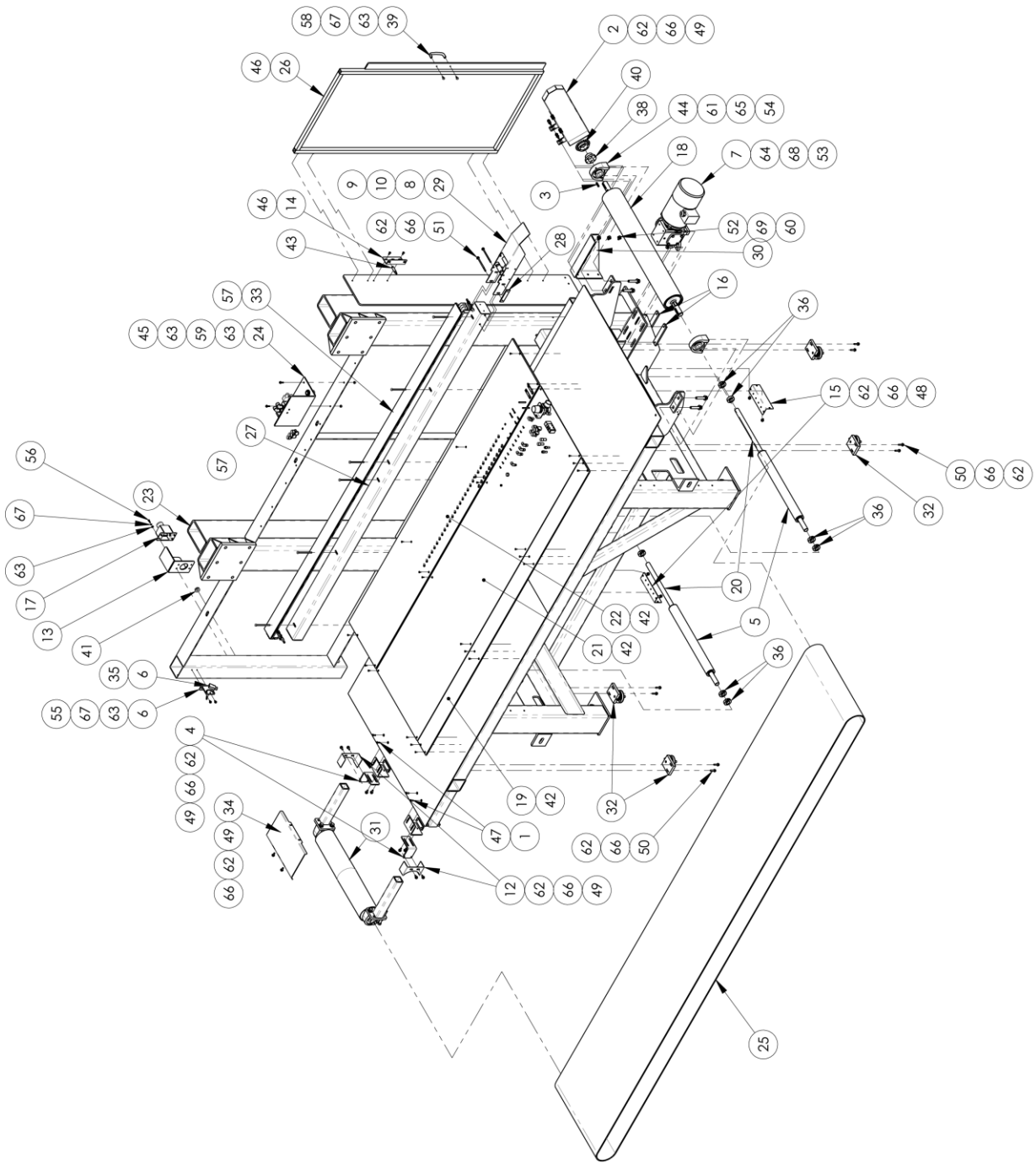




1406580 Side Sealer 120", Left

AAC Drawing Number 1406580 Rev 8

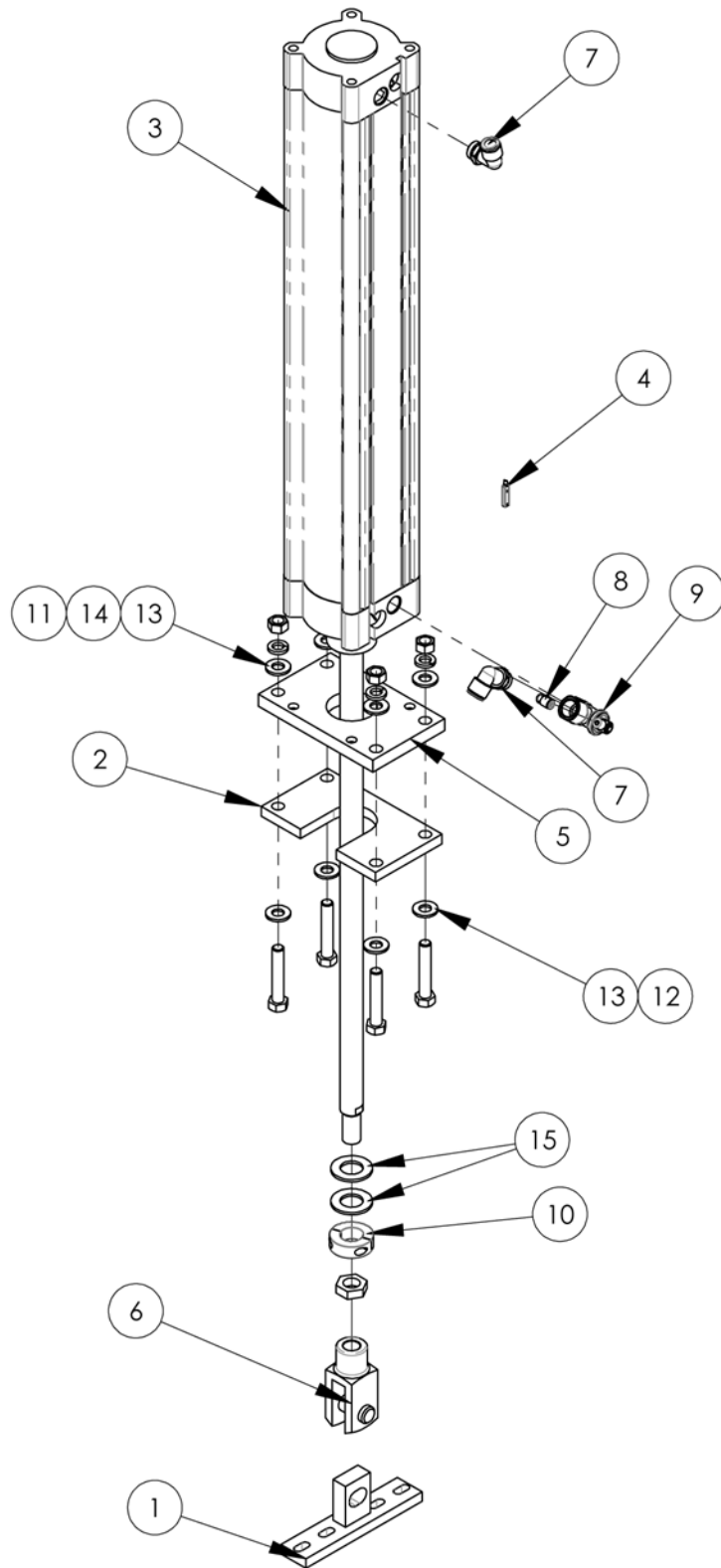
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	2	1349293	PLATE,NUT 1/4-20,2.50 CTC	35	1	1406895	BLADDER KIT, 110" SIDE SEAL, HCB
2	2	1390162	GUARD,BRACKET	36	1	1406899	EXIT TABLE EXTENSION
3	2	1390277	ASSY, ROLLER, SUPPORT	37	8	CCCL16F	COLLAR,1" CLAMP TYPE
4	1	1390512	TAPE ROLLER, UPPER	38	1	MM11/4SH	HUB, TAPERLOCK
5	1	1390513	AXLE, LIFT ROLLER	39	1	MM1897A24	HANDLE,DOOR,PULL,OVAL,5/8
6	1	1390522	HUB ROLLER, TAPE SUPPLY	40	1	MM40SH21H	SPROCKET, 1/2 P, 21T
7	2	1390607	GUARD,BRACKET	41	2	MM9307K63	GROMMET,1/2ID,13/16 HOLE
8	2	1390694	GUARD, REAR ROLLER	42	24	MM97530A027	MULTI GRIP RIVET 1/8"
9	1	1391034	E-STOP GUARD-LH	43	1	MMAM1-AN-4A	PROX SWITCH,10-30VDC,12MM
10	1	1391157	DOOR SENSOR MTG BRKT.	44	2	MMUCPA207-20	1.25" BEARING
11	2	1391176	MTG BRKT, SIX MODULE STAT	45	2	NNE10-32	NUT,ELASTIC LOCK
12	2	1391177	NUT PLATE, GEAR MOTOR MTG	46	6	SSBC01032	1/4-20 X 1/2 BUT CAP SC
13	1	1391189	STOP BUTTON BOX ASSY	47	4	SSFC01048	1/4-20 X 3/4 FLAT CAP
14	1	1406155	DRIVE-ROLLER REAR CONV.	48	4	SSHC01032	1/4-20 X 1/2 HHCS
15	1	1406160	PANEL, TOP UHMW, NARROW	49	12	SSHC01048	1/4-20 X 3/4 HEX CAP
16	2	1406162	SHAFT, BELT SUPPORT	50	10	SSHC01080	1/4-20 X 1-1/4 HHCS
17	1	1406163	PANEL, TOP UHMW, BELT	51	2	SSHC01288	SCREW,HEX CAP
18	1	1406165	PANEL, TOP UHMW, WIDE	52	7	SSHC10048	5/16-18 X 3/4 HHCS
19	1	1406565	WELMENT,EXIT FRAME,LEFT	53	4	SSHC25144	3/8-16X2-1/4 HEX CAP SC
20	1	1406573	VALVE ASSY, SIDE SEAL	54	4	SSHC45176	1/2-13X2-3/4 HEX CAP
21	1	1406598	BELT, OUTPUT CONVEYOR	55	2	SSHC98040	10-32X5/8 HEX HD
22	1	1406618	DOOR FRAME, LEFT	56	4	SSHC98048	SCREW, HEX CAP #10-32X.75
23	1	1406625	SIDE SEAL HEAT PAD RISER	57	6	SSPS01256	1/4-20 X 2-1/4 PAN HD SLOT
24	1	1406678	NUT PLATE,1/4-20 X 3" CTC	58	2	SSSC98056	10-32 X 7/8 SOC CAP
25	1	1406701	RAMP, BOTTOM SEAL RAIL	59	4	WWF3/8	WASHER,FLAT,3/8 OR 10MM
26	1	1406741	ROLLER CHAIN, #40X44"	60	7	WWF5/16	WASHER,FLAT,5/16
27	1	1406753	MOTOR/REDUCER ASSY	61	4	WWFS1/2	WASHER,FLAT,1/2, SAE
28	1	1406754	BRACKET,GUARD	62	28	WWFS1/4	WASHER,FLAT,SAE,1/4
29	2	1406813	5/8 SPACER	63	10	WWFS10	WASHER, FLAT, #10, SAE
30	1	1406827	STEP, LEFT SIDE	64	4	WWL1/2	1/2 LOCK WASHER
31	1	1406830	AIR TANK ASSY.	65	28	WWL1/4	WASHER,LOCK, 1/4
32	1	1406831	TOP PLATE, AIR TANK	66	6	WWL10	WASHER,LOCK,#10
33	1	1406845	IDLER ROLLER ASSY	67	4	WWL3/8	WASHER,LOCK, 3/8
34	4	1406847	BELT GUIDE PULLEY ASSY	68	7	WWL5/16	WASHER,LOCK, 5/16



1406590 Side Sealer 120" Right

AAC Drawing Number 1406590 Rev 5

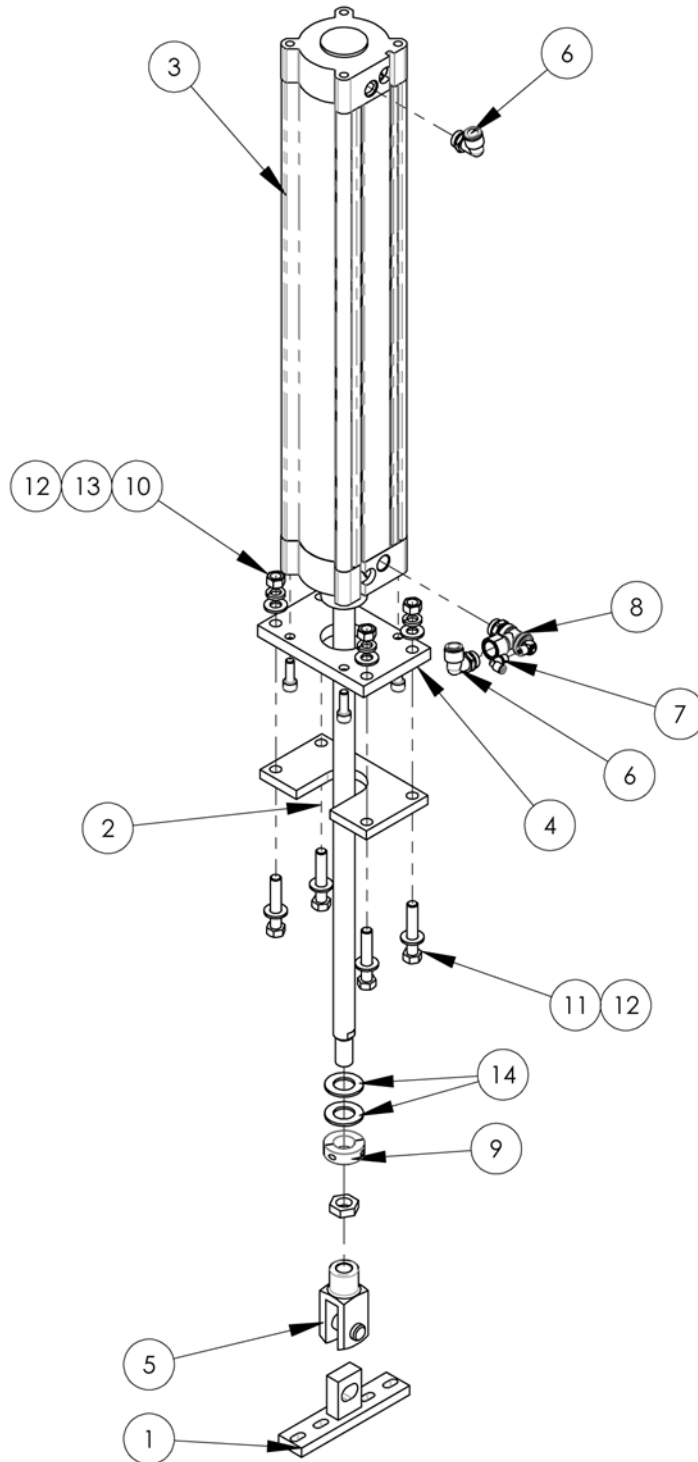
NO	QTY.	PART #	DESCRIPTION	NO	QTY.	PART #	DESCRIPTION
1	2	1349293	PLATE,NUT 1/4-20,2.50 CTC	36	8	CCCL16F	COLLAR,1" CLAMP TYPE
2	1	1390153	BRACKET, GUARD	37	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
3	1	1390160	KEY, 1/4 X 1.25L	38	1	MM11/4SH	HUB, TAPER LOCK
4	2	1390162	GUARD,BRACKET	39	1	MM1897A24	HANDLE,DOOR,PULL,OVAL,5/8
5	2	1390277	ASSY, ROLLER, SUPPORT	40	1	MM40SH21H	SPROCKET, 1/2 P, 21T
6	1	1390468	BRACKET, EYE MOUNT,LH	41	2	MM9307K63	GROMMET,1/2ID,13/16 HOLE
7	1	1390473	MOTOR/REDUCER ASSY	42	24	MM97530A027	MULTI GRIP RIVET 1/8"
8	1	1390512	TAPE ROLLER, UPPER	43	1	MMAM1-AN-4A	PROX SWITCH,10-30VDC,12MM
9	1	1390513	AXLE, LIFT ROLLER	44	2	MMUCPA 207-20	1.25" BEARING
10	1	1390522	HUB ROLLER, TAPE SUPPLY	45	2	NNE10-32	NUT,ELASTIC LOCK
11	2	1390607	GUARD,BRACKET	46	6	SSBC01032	1/4-20 X 1/2 BUT CAP SC
12	2	1390694	GUARD, REAR ROLLER	47	4	SSFC01048	1/4-20 X 3/4 FLAT CAP
13	1	1391046	E-STOP GUARD-RH	48	12	SSHC01032	1/4-20 X 1/2 HHCS
14	1	1391157	DOOR SENSOR MTG BRKT.	49	14	SSHC01048	1/4-20 X 3/4 HEX CAP
15	4	1391176	MTG BRKT, SIX MODULE STAT	50	8	SSHC01080	1/4-20 X 1-1/4 HHCS
16	2	1391177	NUT PLATE, GEAR MOTOR MTG	51	2	SSHC01288	SCREW,HEX CAP
17	1	1391189	STOP BUTTON BOX ASSY	52	3	SSHC10048	5/16-18 X 3/4 HHCS
18	1	1406155	DRIVE-ROLLER REAR CONV.	53	4	SSHC25096	3/8-16 X 1 1/2 HHCS
19	1	1406160	PANEL, TOP UHMW, NARROW	54	4	SSHC45176	1/2-13X2-3/4 HEX CAP
20	2	1406162	SHAFT, BELT SUPPORT	55	2	SSHC98032	10-32X1/2 HEX HD
21	1	1406163	PANEL, TOP UHMW, BELT	56	4	SSHC98040	10-32X5/8 HEX HD
22	1	1406165	PANEL, TOP UHMW, WIDE	57	6	SPPS01256	1/4-20 X 2-1/4 PAN HD SLOT
23	1	1406566	WELDMENT,EXIT FRAME,RIGHT	58	2	SPPS98040	10-32X5/8 PAN HD SLOT
24	1	1406573	VALVE ASSY, SIDE SEAL	59	2	SSSC98056	10-32 X 7/8 SOC CAP
25	1	1406598	BELT, OUTPUT CONVEYOR	60	3	WWF5/16	WASHER,FLAT,5/16
26	1	1406619	DOOR FRAME, RIGHT	61	4	WWF5/2	WASHER,FLAT,1/2, SAE
27	1	1406625	SIDE SEAL HEAT PAD RISER	62	36	WWF5/4	WASHER,FLAT,SAE,1/4
28	1	1406678	NUT PLATE,1/4-20 X3" CTC	63	13	WWF5/10	WASHER, FLAT, # 10, SAE
29	1	1406701	RAMP, BOTTOM SEAL RAIL	64	4	WWF5/8	WASHER,FLAT,SAE,3/8
30	1	1406827	STEP, LEFT SIDE	65	4	WWL1/2	1/2 LOCK WASHER
31	1	1406845	IDLER ROLLER ASSY	66	36	WWL1/4	WASHER,LOCK, 1/4
32	4	1406847	BELT GUIDE PULLEY ASSY	67	9	WWL10	WASHER,LOCK,#10
33	1	1406895	BLADDER KIT, 110" SIDE SEAL, HCB	68	4	WWL3/8	WASHER,LOCK, 3/8
34	1	1406899	EXIT TABLE EXTENSION	69	3	WWL5/16	WASHER,LOCK, 5/16
35	1	1975-412A	PLATE,NUT,4-40,.95CTC				



1406595 Cylinder Assembly Side Seal Front W/ Sensor

AAC Drawing Number 1406595 Rev 2

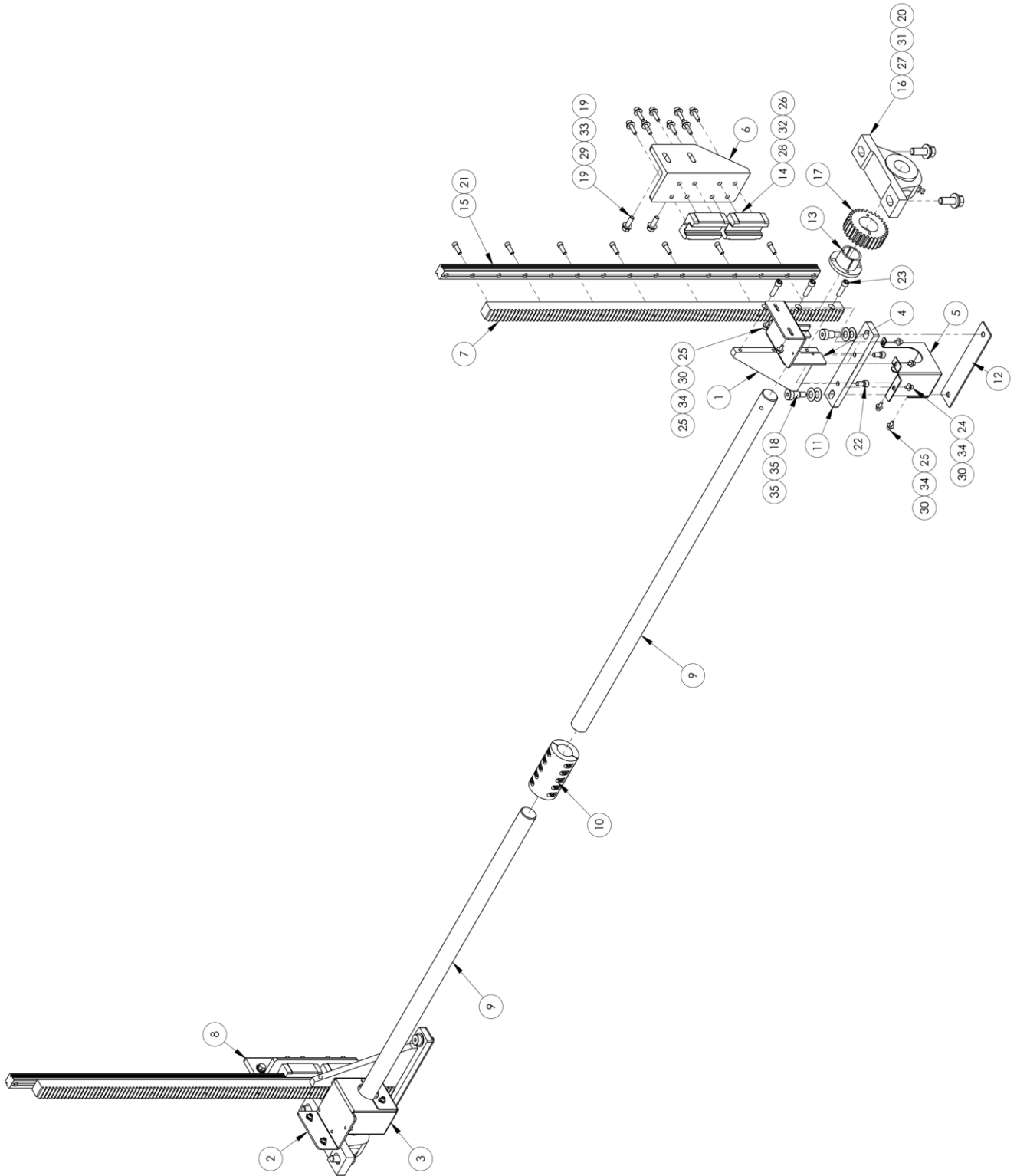
NO	QTY	PART #	DESCRIPTION
1	1	1391073	CROSS SEAL CYL. MNT
2	1	1406677	SPACER, MOUNTING PLT, - DNC
3	1	AACDNCB100610PP	CYLINDER, AIR, ISO, 100BX610S
4	AR*	AAESME8KLED24	SENSOR FOR FESTO DNCB CYL
5	1	AAFNC100	FLANGE, MOUNTING PLT, -
6	1	AAFSGM20X15	CLEVIS, ROD, M20 X 1.5
7	2	AAQME-2-2U	FITTING, 1/2T-1/2 UNIFIT
8	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
9	1	AAV78862121	VALVE, BLOCKING, R1/2
10	1	CCCLMSP25F	COLLAR, CLAMP, SPLIT, 25MM
11	4	NNH1/2-13	NUT, HEX, 1/2-13
12	4	SSHC45176	1/2-13X2-3/4 HEX CAP
13	8	WWFS1/2	WASHER, FLAT, 1/2, SAE
14	4	WWL1/2	1/2 LOCK WASHER
15	2	WWU25MM	WASHER, URETHANE, 25MM ID



1406596 Cylinder Assembly Side Seal Rear WO/Sensor

AAC Drawing Number 1406596 Rev 2

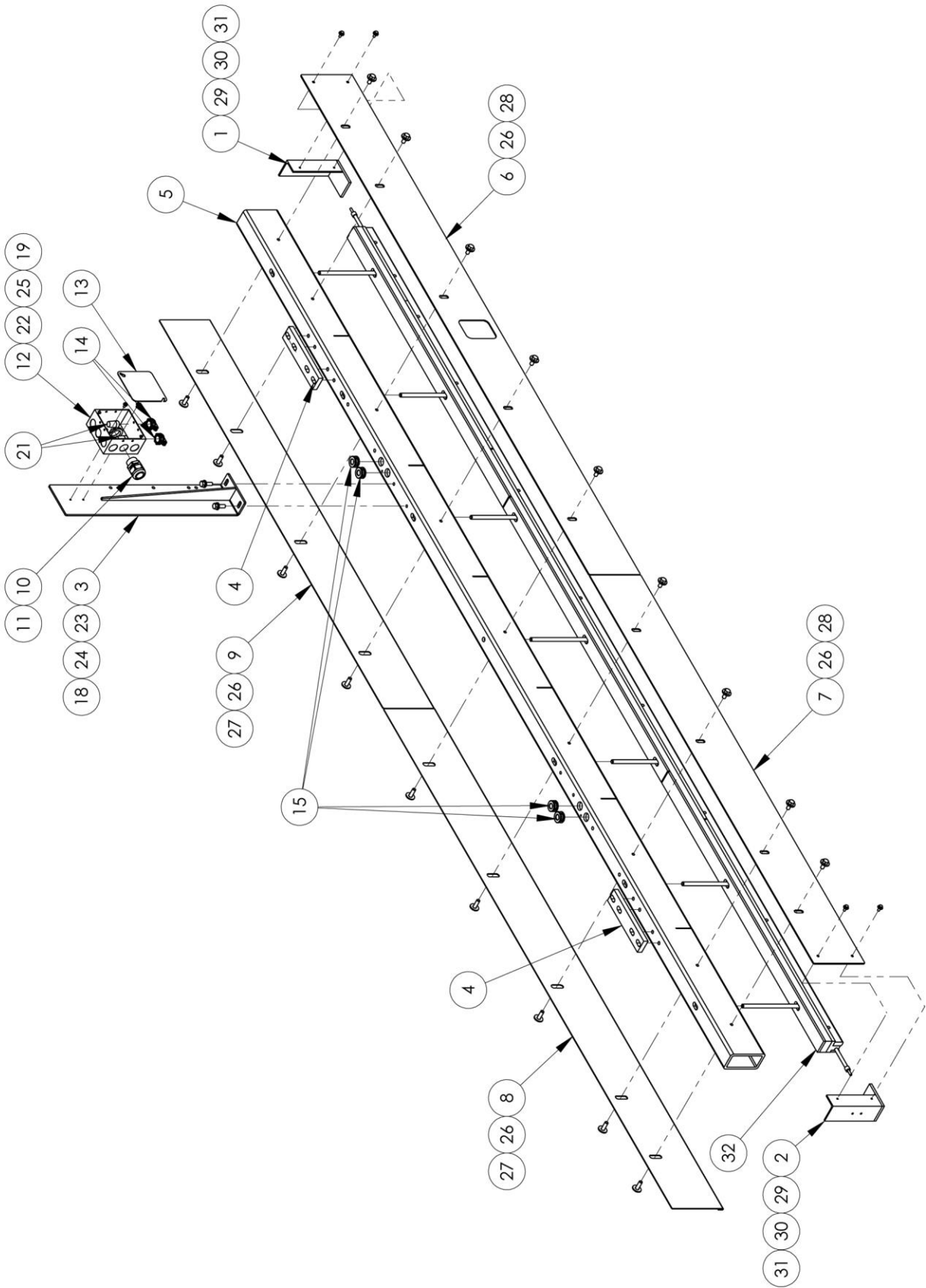
NO	QTY	PART #	DESCRIPTION
1	1	1391073	CROSS SEAL CYL. MNT
2	1	1406677	SPACER, MOUNTING PLT, - DNC
3	1	AACDNCB100610PP	CYLINDER, AIR, ISO, 100BX610S
4	1	AAFNC100	FLANGE, MOUNTING PLT, -
5	1	AAFSGM20X15	CLEVIS, ROD, M20 X 1.5
6	2	AAQME-2-2U	FITTING, 1/2T-1/2 UNIFIT
7	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
8	1	AAV78862121	VALVE, BLOCKING, R1/2
9	1	CCCLMSP25F	COLLAR, CLAMP, SPLIT, 25MM
10	4	NNH1/2-13	NUT, HEX, 1/2-13
11	4	SSHC45176	1/2-13X2-3/4 HEX CAP
12	8	WWFS1/2	WASHER, FLAT, 1/2, SAE
13	4	WWL1/2	1/2 LOCK WASHER
14	2	WWU25MM	WASHER, URETHANE, 25MM ID



1406640 Side Seal Sync Bar Assembly

AAC Drawing Number 1406640 Rev 3

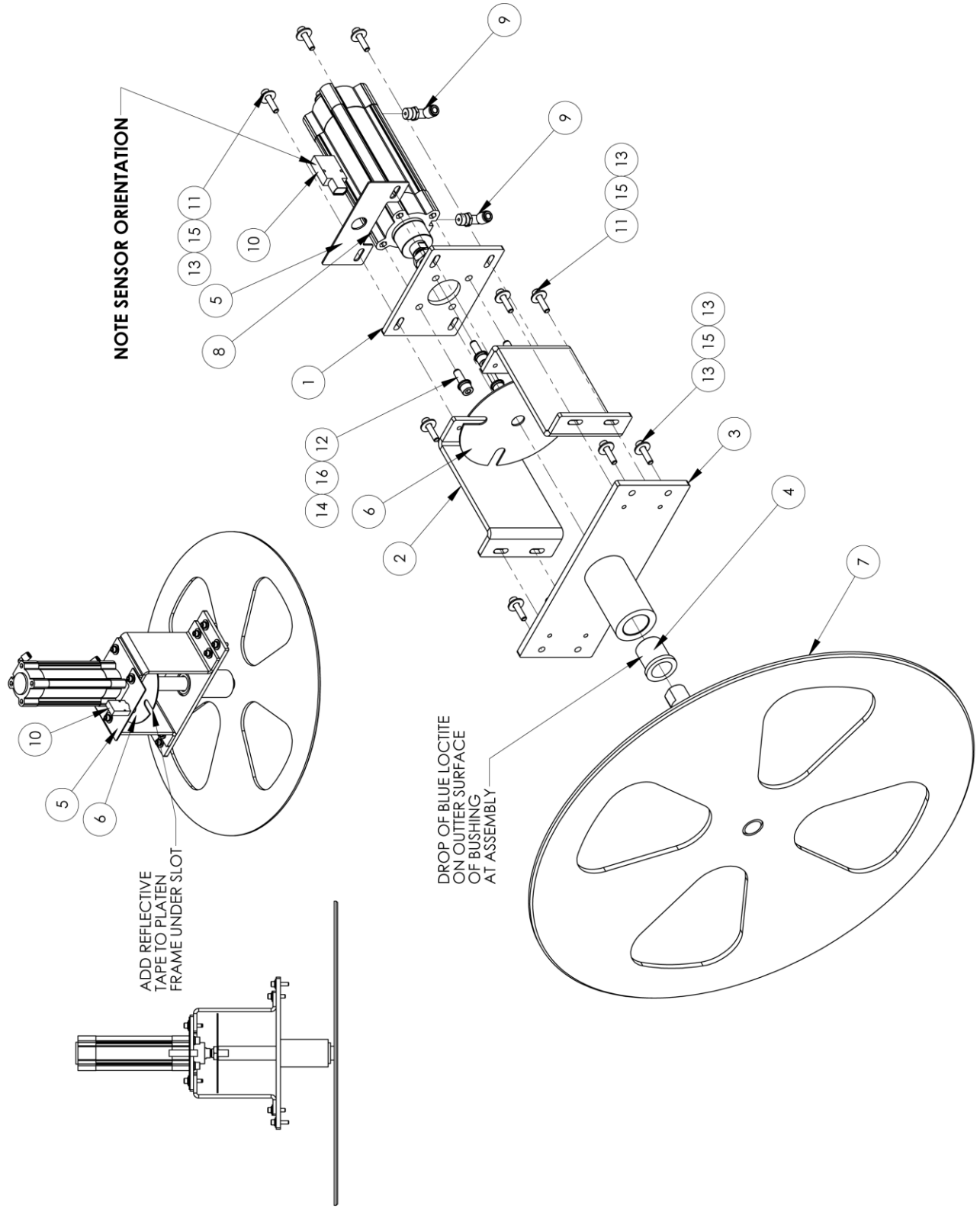
NO	QTY	PART #	DESCRIPTION
1	2	1390831	GUSSET, RACK MNT
2	1	1390864	GUARD BASE-COMPRESSION
3	1	1390865	GUARD, GEAR, COMPRESSION
4	1	1390872	GUARD BASE-COMPRESSION
5	1	1390873	GUARD, GEAR, COMPRESSION
6	1	1406574	MTG. BRKT, RAIL, RACK, LH
7	2	1406581	RACK, SIDE SEAL BAR SYNC
8	1	1406592	MTG. BRKT, RAIL, RACK, RH
9	2	1406661	SHAFT, JACK, 34.5" LG
10	1	1406676	COUPLING, 2 PC, 1.25" BORE
11	2	1406685	BASE PLATE, FLOATING MNT
12	2	1406712	SPACER PLATE, SIDE SEAL
13	2	MM114H	HUB, TAPERLOCK, H STYLE
14	4	MMAGH25CAN	LINEAR BEARING
15	2	MMAGR25860N	RAIL, LINEAR, AG SERIES
16	2	MMGRP207-20	BEARING, PILLOW BK, 1.25B
17	2	MMNSS10H30	GEAR, SPUR, 10P, 30T, 1"F, 14.5PA
18	4	SSAS032040	SCREW, ALLEN SHOULDER
19	4	SSHC10064	5/16-18 X 1 HHCS
20	4	SSHC45096	1/2-13X1-1/2 HEX CAP
21	14	SSSC01048	1/4-20 X 3/4" SOC CAP SC
22	4	SSSC10040	5/16-18 X 5/8 SOC CAP
23	6	SSSC10072	SOCKET CAP 5/16-18X1-1/8
24	6	SSSC98024	10-32 X 3/8 SOC CAP
25	8	SSSC98032	10-32X1/2, SOC CAP
26	16	SSSCM6X25	M6X25 SOC CAP SCREW
27	4	WWFS1/2	WASHER, FLAT, 1/2, SAE
28	16	WWFS1/4	WASHER, FLAT, SAE, 1/4
29	4	WWFS5/16	WASHER, FLAT, SAE, 5/16
30	14	WWFS10	WASHER, FLAT, #10, SAE
31	4	WWL1/2	1/2 LOCK WASHER
32	16	WWL1/4	WASHER, LOCK, 1/4
33	4	WWL5/16	WASHER, LOCK, 5/16
34	14	WWL10	WASHER, LOCK, #10
35	8	WWS9712K74	WASHER, SPRING



1406645 Side Seal Bar Assembly, 110"

AAC Drawing Number 1406645 Rev 0

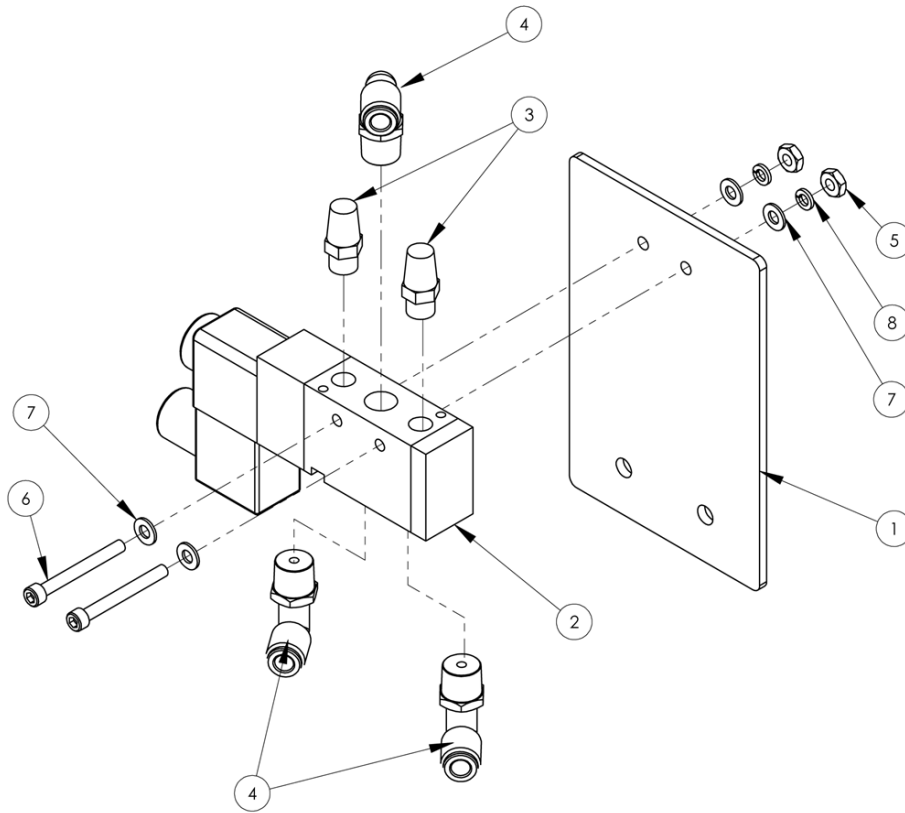
NO	QTY	PART #	DESCRIPTION
1	1	1390130	END PLATE,RIGHT
2	1	1390131	END PLATE,LEFT
3	1	1390354	BRACKET, J-BOX MOUNT
4	2	1406584	CYLINDER SPACER BLOCK
5	1	1406639	TUBE, SIDE SEAL, 114"
6	1	1406641	SIDE SEAL CLAMP GUARD,LRG
7	1	1406642	SIDE SEAL CLAMP GUARD,SML
8	1	1406643	SIDE SEAL CLAMP GUARD,LRG
9	1	1406644	SIDE SEAL CLAMP GUARD,SML
10	1	FF3234	STRAIN RELIEF,3/4NPT
11	1	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK
12	1	K-233	BOX,ELECTRICAL,SQUARE
13	1	K-234	COVER,4IN SQUARE
14	2	K-235	CONNECTOR,ROMEX,1/2"
15	4	MM9307K63	GROMMET,1/2ID,13/16 HOLE
16	1	NNH8-32	HEX-NUT 8-32 REG.
17	1	NNK8-32	KEP NUT, 8-32
18	2	SSHC10064	5/16-18 X 1 HHCS
19	2	SSPP90024	8-32X3/8 PAN PHLPS
20	1	SSPP90032	SCREW,8-32 PAN HD PHIL
21	2	TTMB70476	CONNECTOR,WIRE,EX LARGE
22	2	WWF8	WASHER, FLAT, #8
23	2	WWFS5/16	WASHER,FLAT,SAE,5/16
24	2	WWL5/16	WASHER,LOCK, 5/16
25	2	WWL8	WASHER,LOCK,#8
26	18	WWF5/16	WASHER,FLAT,5/16
27	9	SSBC10064	5/16-18 X 5/8 L
28	9	SSHC10048	5/16-18 X 3/4 HHCS
29	4	WWFS10	WASHER, FLAT, #10, SAE
30	4	WWL10	WASHER,LOCK,#10
31	4	SSHC95032	10-24 X .5, HEX CAP
32	1	1406635	SEAL BAR ASSY, 110"



1406715 Mattress Pivot Assembly

AAC Drawing Number 1406715 Rev 5

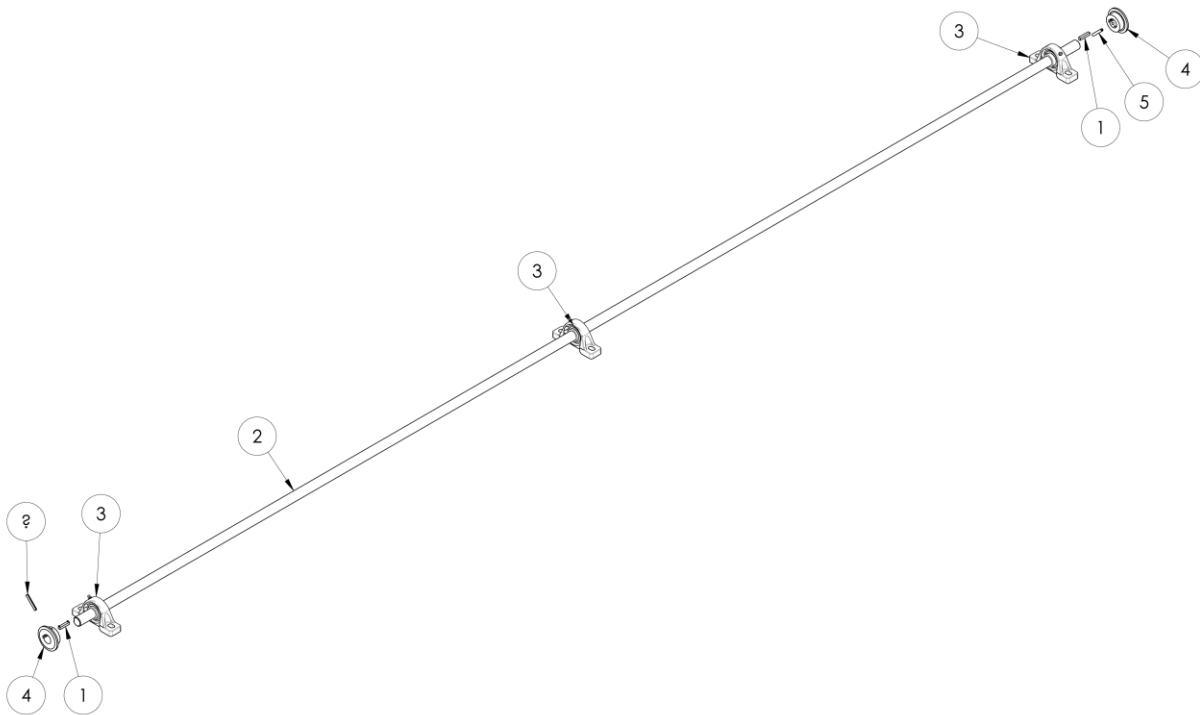
NO	QTY	PART #	DESCRIPTION
1	1	1406717	MOUNT. CYLINDER
2	1	1406719	BRACKET, CYLINDER OFFSET
3	1	1406720	MOUNT, PIVOT ASEMBLY
4	1	1406724	BEARING,BRONZE, MOD
5	1	1406837	EYE BKT, PIVOT ASSY
6	1	1406838	ENCODER DISC
7	1	1406890	PIVOT POST, WELDED
8	1	AACDNCB50100PPVA	CYLINDER,AIR,ISO,50BX100
9	2	AAQME-4-4U	ELBOW, MALE, 1/4X1/4NPT
10	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
11	12	SSSC01064	1/4-20 X 1 SOC CAP
12	4	SSSCM8X25	SCREW,SOC CAP,M8X25
13	12	WWF1/4	WASHER, FLAT, 1/4", COM
14	4	WWFM8	WASHER, FLAT, M8 I.D.
15	12	WWL1/4	WASHER,LOCK, 1/4
16	4	WWLM8	M8 LOCK WASHER



1406727 Valve Assembly, Pivot Assembly

AAC Drawing Number 1406727 Rev 0

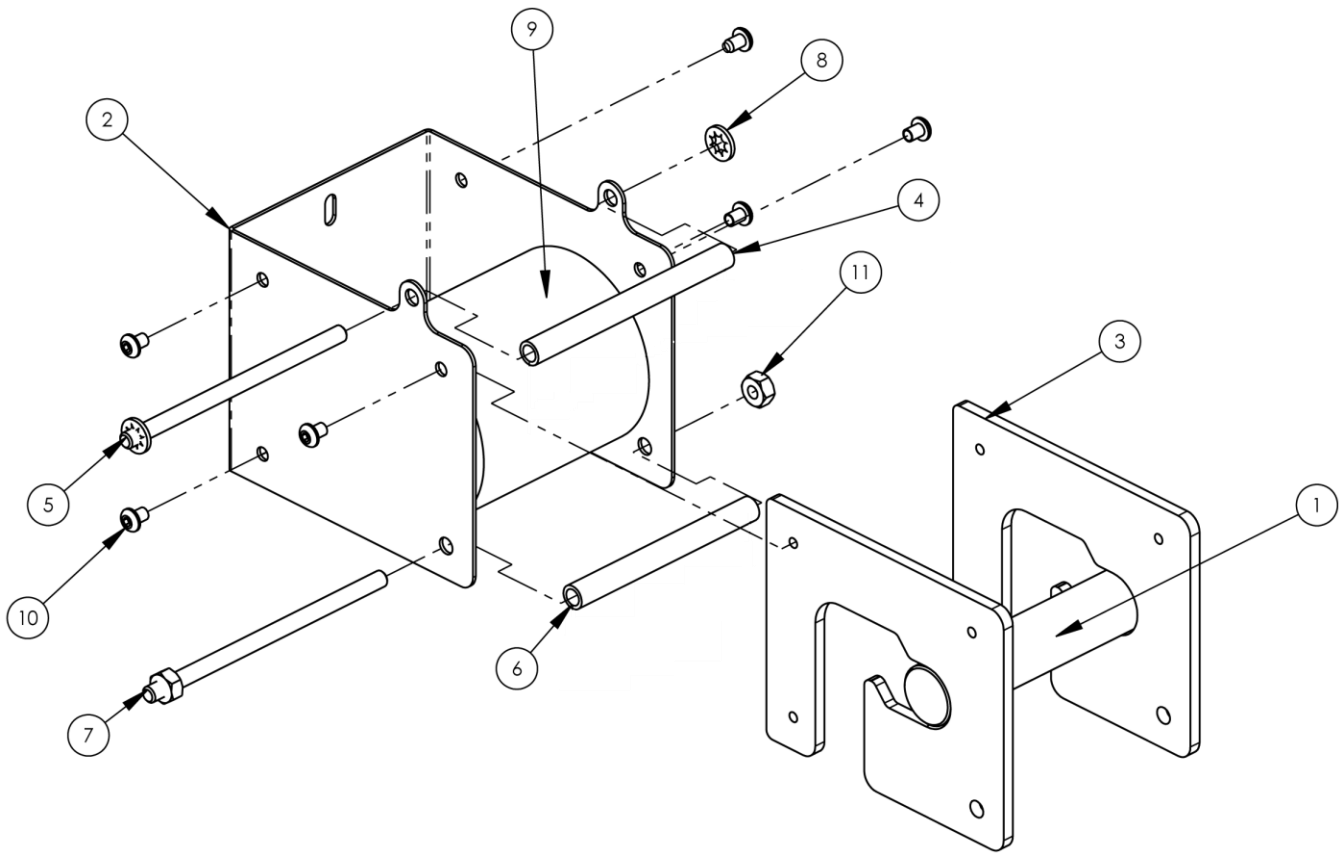
NO	QTY	PART #	DESCRIPTION
1	1	1390351	VALVE MTG PLATE
2	1	AAE4V21008	VALVE, 1/4" PORTED, 24VDC
3	2	AAFP18	MUFFLER, 1/8 NPT, BRONZ
4	3	AAQME-4-4	ELBOW, MALE, 1/4X1/4NPT
5	2	NNH8-32	HEX-NUT 8-32 REG.
6	2	SSSC90096	#8-32 X 1-1/2 SOC CAP SC
7	4	WWF8	WASHER, FLAT, #8
8	2	WWL8	WASHER, LOCK, #8



1390484 Drive Shaft Assembly

AAC Drawing Number 1390484 Rev 3

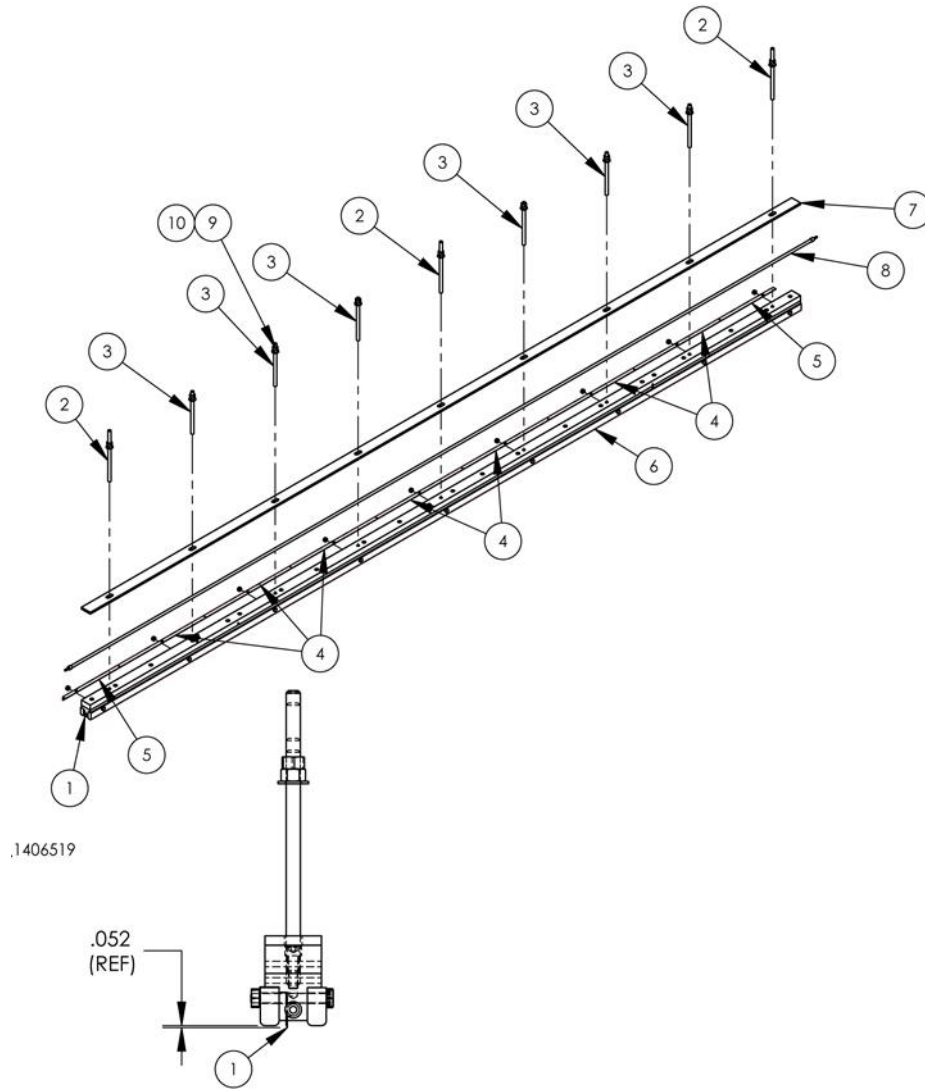
NO	QTY.	PART #	DESCRIPTION
1	2	1386645	MODIFIED SPROCKET
2	1	1390355	JACK SHAFT CROSS SEAL
3	2	1390997	KEY, 1/4 X 1.25L, W/STEP
4	2	11S016X112	ROLL PIN 1/8 DIA X 1 1/2 SS
5	3	MMUCP205-16	BEARING,PILLOW BLOCK,1"



1390533 Crossbar Tape Dispenser

AAC Drawing Number 1390533 Rev 1

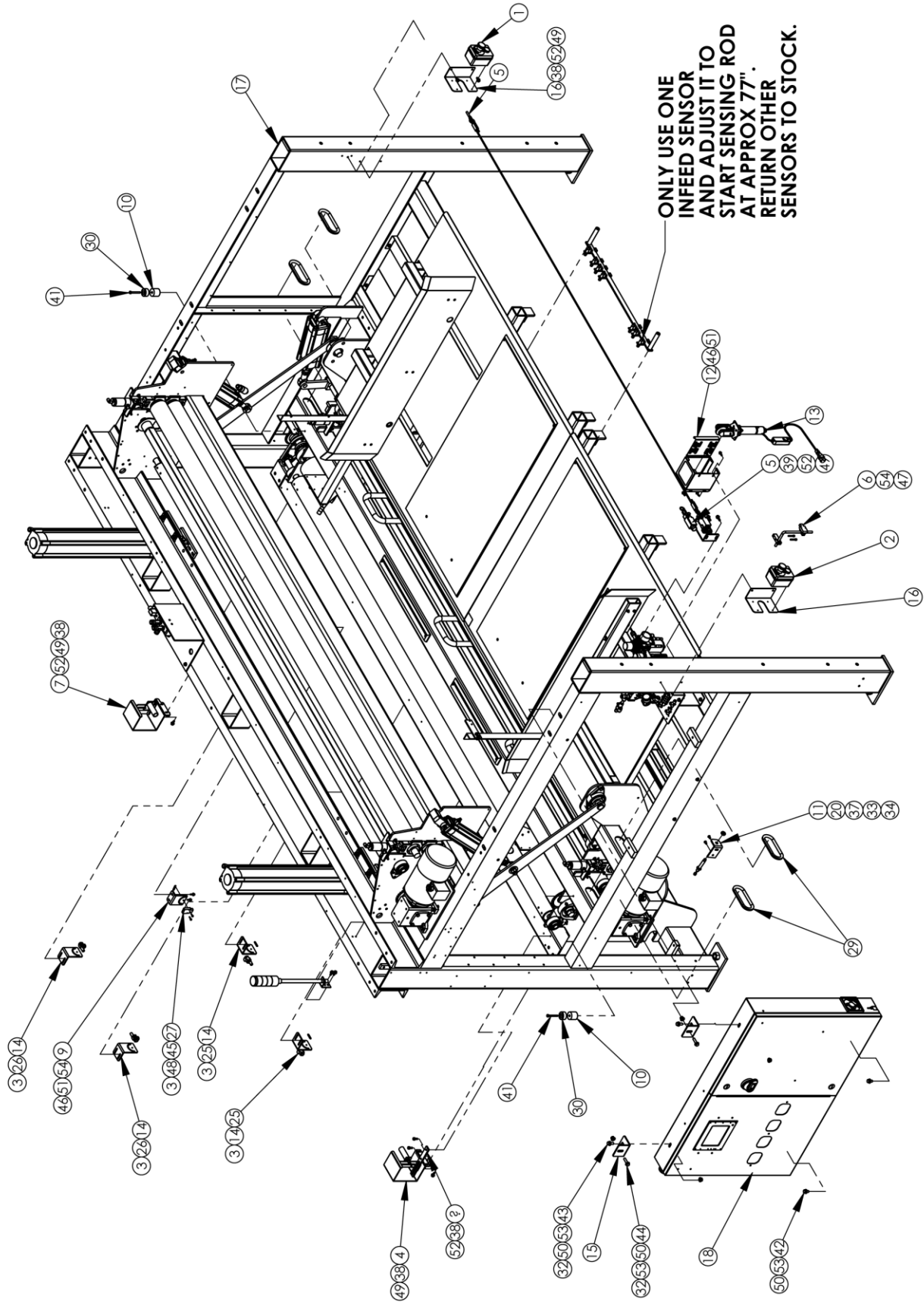
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1390522	HUB ROLLER, TAPE SUPPLY
2	1	1390532	DESPENSER BODY
3	2	1390534	TAPE HUB HOLDER
4	1	1390536	TAPE ROLLER
5	1	1390537	AXLE, TAPE ROLLER
6	1	1390561	SPACER, TAPE ROLLER
7	1	1390564	THREADED ROD
8	2	MM94807A029	PUSHNUT,ROUND,1/4 DIA
9	6	SSBC98016	10-32 X 1/4 BUTTON CAP SC
10	2	NNH1/4-20	NUT,HEX,1/4-20



1406519 Seal Bar 120" Assembly

AAC Drawing Number 1406519 Rev 1

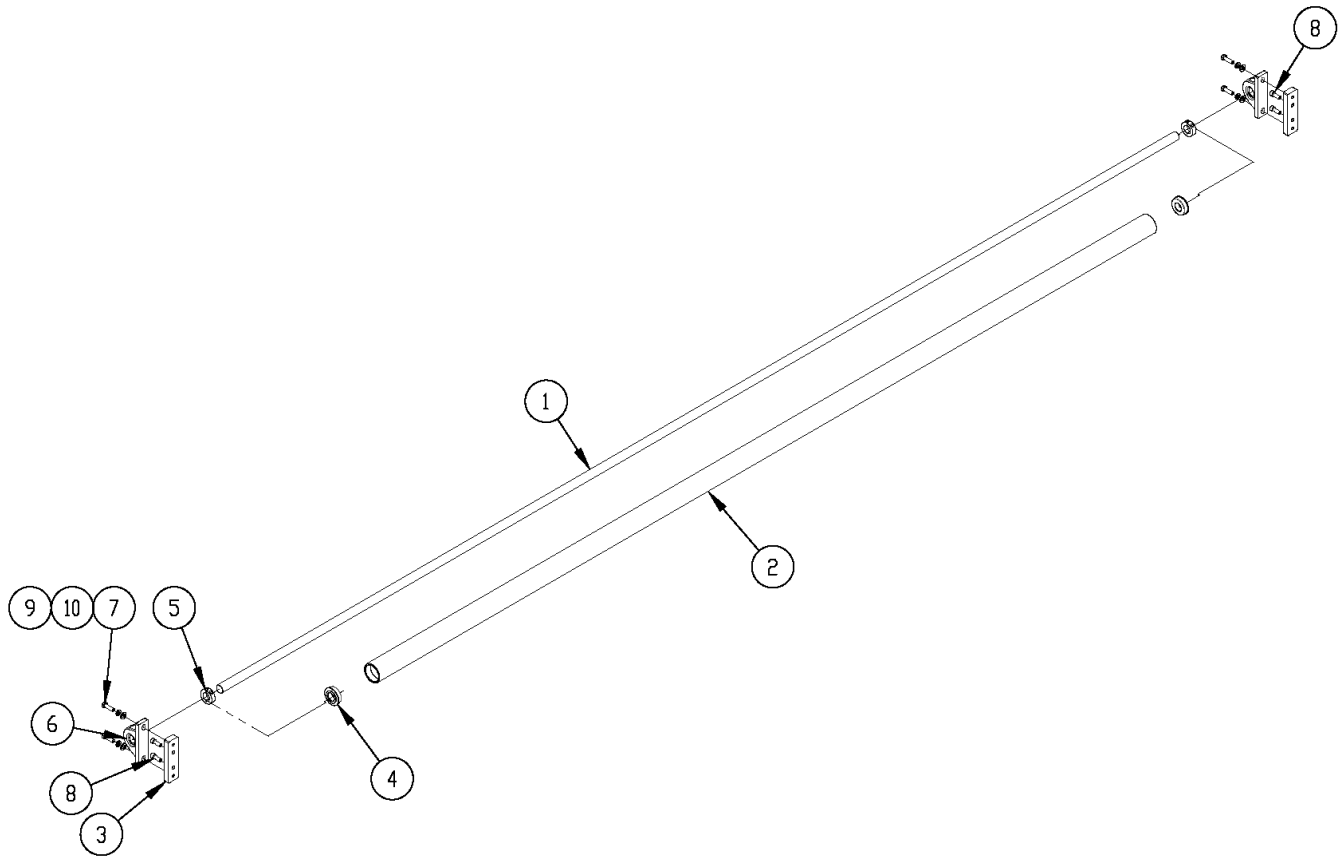
NO	QT	PART #	DESCRIPTION
1	1	1390333	CUT BLADE 120'
2	3	1390385	THREADED ROD, 7.5"
3	6	1390386	THREADED ROD, 6.25"
4	7	1391898	SHIM, .018, CROSS SEAL
5	2	1391899	SHIM, .018, CROSS SEAL
6	1	1406518	SEAL BAR 120' ASSEMBLY
7	1	1490508	STRIP, INSULATING
8	1	EERBN125A10A-4	HEAT ELEMENT, 125L, .315D
9	18	NNH3/8-16	NUT, HEX, 3/8-16
10	9	WWFS3/8	WASHER, FLAT, SAE, 3/8



1406757 Input Conveyor Assembly, #3

AAC Drawing Number 1406757 Rev 1

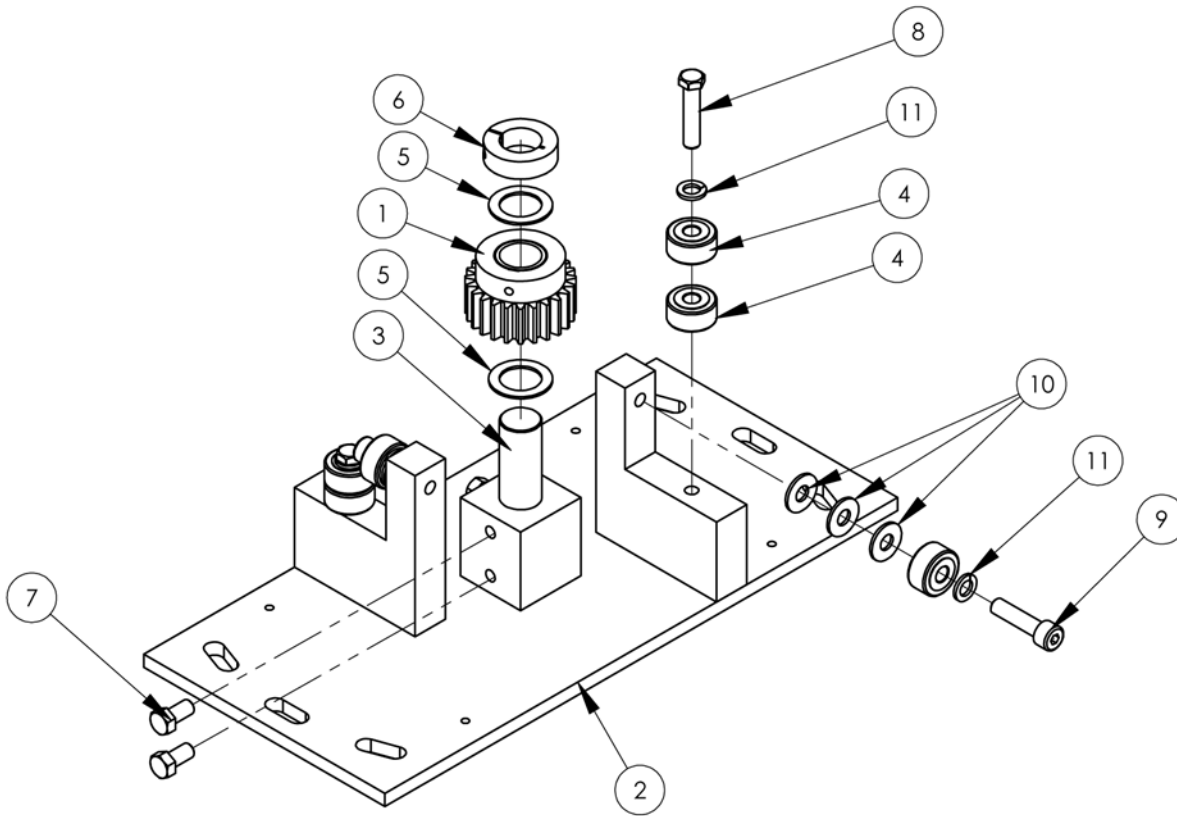
NO	QTY	PART#	DESCRIPTION	NO	QTY	PART#	DESCRIPTION
1	1	1278-6010F	START/E-STOP ASSY, W/22'	28	*50	MM5X521	RIVET,POP,1/8D.,313-.375
2	1	1278-6010G	START/E-STOP ASSY, W/4' CABLE	29	*6	MM8507K22	EDGE TRIM
3	5	1975-412A	PLATE,NUT,4-40,.95CTC	30	2	MM9540K28	BUMPER, 1-1/2 DIA, 70A
4	1	1390064	GUARD, SENSOR	31	*36	MMT9945	TAPE,REFLECTIVE,2" WIDE
5	1	1390366	E-STOP ASSY, CABLE PULL	32	4	NNH3/8-16	3/8-16 HEX NUT
6	1	1390443	SENSOR ASSEMBLY, FILM OUT	33	4	NNJ1/2-20	1/2-20 HEX JAM NUT
7	1	1390466	SENSOR ASSEMBLY, RIGHT	34	1	NNK1/4-20	KEP NUT, 1/4-20
8	1	1390467	SENSOR ASSEMBLY	35	*468	PPP40	CHAIN,#40 RIVET
9	1	1390468	BRACKET, EYE MOUNT,LH	36	*10	PPP40CL	LINK,CONNECTING,#40
10	2	1390478	SPACER, BUMPER	37	4	SSBC01032	1/4-20 X 1/2 BUTHEAD
11	2	1390703	BRKT, BUMPER, DANCER ARM	38	8	SSHC01048	1/4-20 X 3/4 HEX HEAD
12	1	1390713	HOLSTER ASSY, SEALER	39	2	SSHC01064	1/4-20 X 1 HEX HEAD
13	1	1390827	HAND SEALER ASSY 1390	40	2	SSHC01096	1/4-20 X 1-1/2 HEX HEAD
14	4	1390846	BRACKET, EYE MOUNT,LH	41	2	SSHC01144	1/4-20 X 2-1/4 HEX HEAD
15	2	1391136	TOP MTG BRKT, MAIN BOX	42	2	SSHC25048	3/8-16 X 3/4 HEX HEAD
16	2	1391142	MTG BRKT REMOTE CONTROL	43	2	SSHC25064	3/8-16 X 1 HEX HEAD
17	1	1391463	INPUT CONVEYOR ASSY. #2	44	2	SSHC25096	3/8-16 X 1-1/2 HEX HEAD
18	1	1406756	CONTROL BOX ASSY	45	2	SSSC70048	#4-40 X 3/4 SOC CAP
19	*50	AAF3/16	CLAMP, BLACK PLASTIC	46	6	SSSC98048	#10-32 X 3/4 SOC CAP
20	2	AAPR025IF2B	SHOCK 5/8 STK,1/2-20 THD	47	2	SSSC98080	#10-32 X 1-1/4 SOC CAP
21	*100	AAIP1/2	1/2" OD POLYURETHANE	48	2	WWF4	WASHER, FLAT #4
22	*300	AAIP3/8	3/8" OD POLYURETHANE	49	10	WWFS1/4	WASHER FLAT, 1/4
23	*150	AAIP4-1	1/4" OD POLYURETHANE	50	10	WWFS3/8	WASHER, FLAT, 3/8
24	*75	AAIP5/32	TUBING, 5/32 OD	51	6	WWFS10	WASHER, FLAT #10
25	2	FFQS18VN6RQ8	SENSOR,LASER RECEIVER,NPN	52	12	WWL1/4	1/4 LW
26	2	FFQS186LEQ8	SENSOR,LASER EMITTER	53	6	WWL3/8	3/8 LW
27	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	54	8	WWL10	#10 LW



1490345 Film Idler Roller Assembly

AAC Drawing Number 1490345 Rev 0

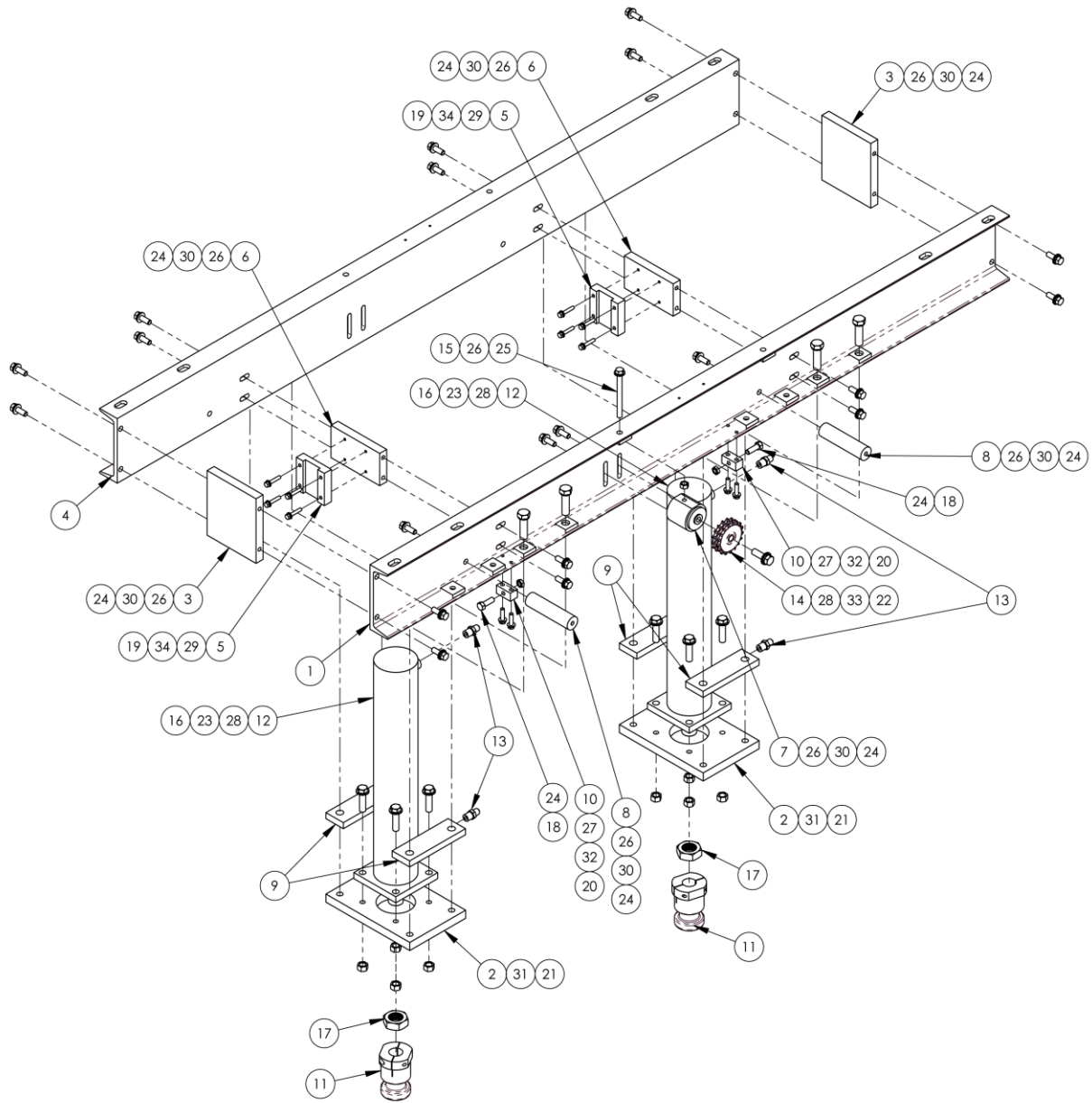
NO.	QTY	PART#	DESCRIPTION
1	1	1390446	TURN-AROUND ROD
2	1	1390464	TUBE, IDLER ROLLER
3	2	1490346	SPACER, PILLOW BLOCK
4	2	BBF-1000-4	BEARING, BALL, 1 1/4 B, UNGRD
5	2	CCCL16F	COLLAR, 1" CLAMP TYPE
6	2	MMVPLS-116	BEARING, PILLOW BLOCK 1.0B
7	4	SSHC25080	3/8-16 X 1-1/4 HEX CAP
8	4	SSSC25064	3/8-16X1 SOC CAP
9	4	WWFS3/8	WASHER, FLAT, SAE, 3/8
10	4	WWL3/8	WASHER, LOCK, 3/8



1391478 Idler Gear Assembly

AAC Drawing Number 1391478

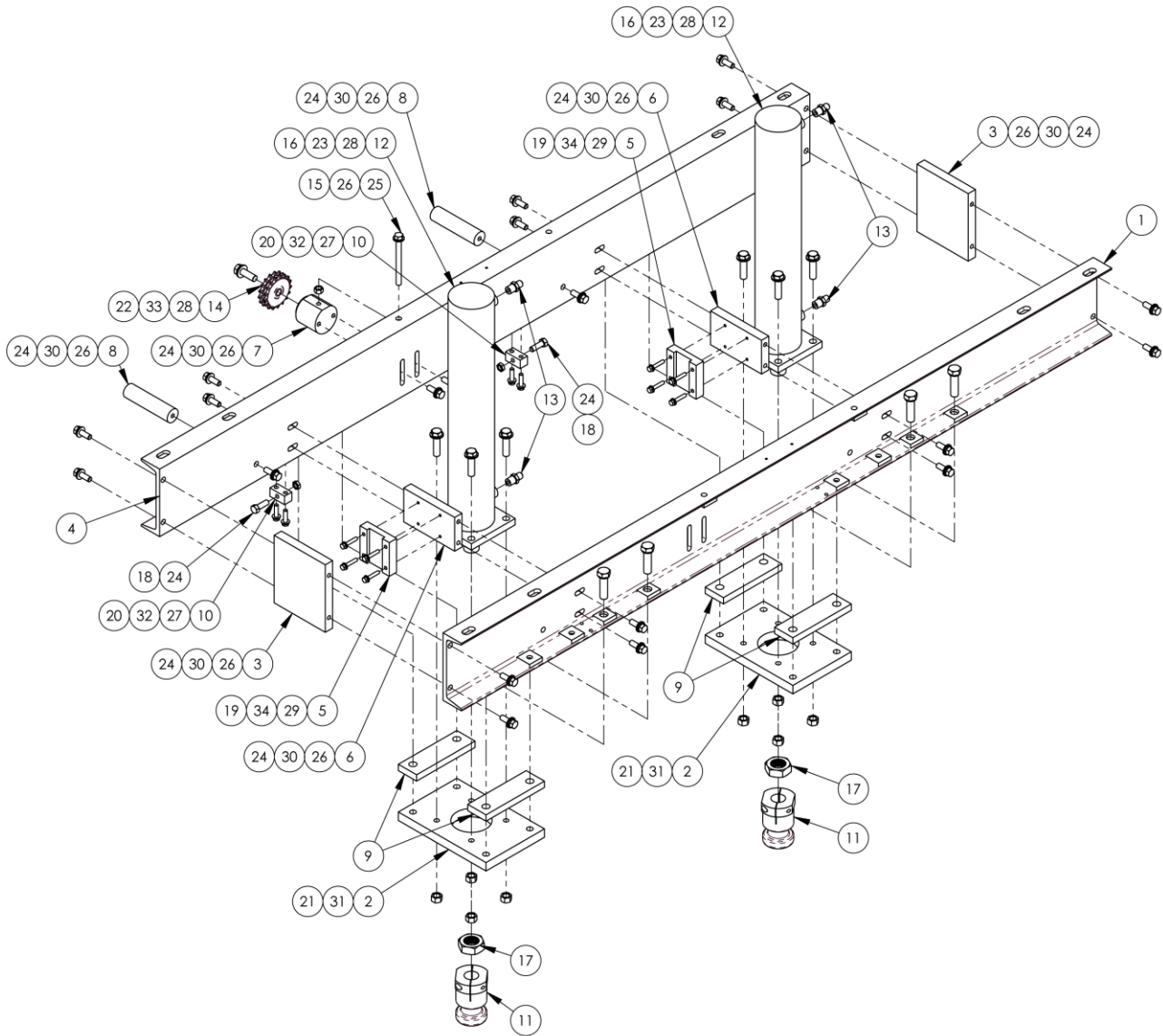
NO	QTY	PART #	DESCRIPTION
1	1	1391473	GEAR, 10F24,IDLER
2	1	1391477	IDLER GEAR MOUNT WELDMENT
3	1	1391479	SHAFT, IDLER GEAR, 1.0 OD
4	6	BBMCYR10SX	CAM FOLLOWER,10 ID,30 OD
5	2	BTT5906K412	BEARING,THRUST,1.0 ID
6	1	CCCL16F	COLLAR,1" CLAMP TYPE
7	4	SSHC25048	3/8-16X3/4,HEX CAP
8	2	SSHCM10X45	SCREW,HEX CAP M10X45
9	2	SSSCM10X40	CAP SCREW 10MM X 40MM
10	6	WWFM10	WASHER, FLAT, M10 I.D.
11	4	WWLM10	M10 LOCK WASHER



1406210 Platen Press Assembly, Left

AAC Drawing Number 1406210 Rev 5

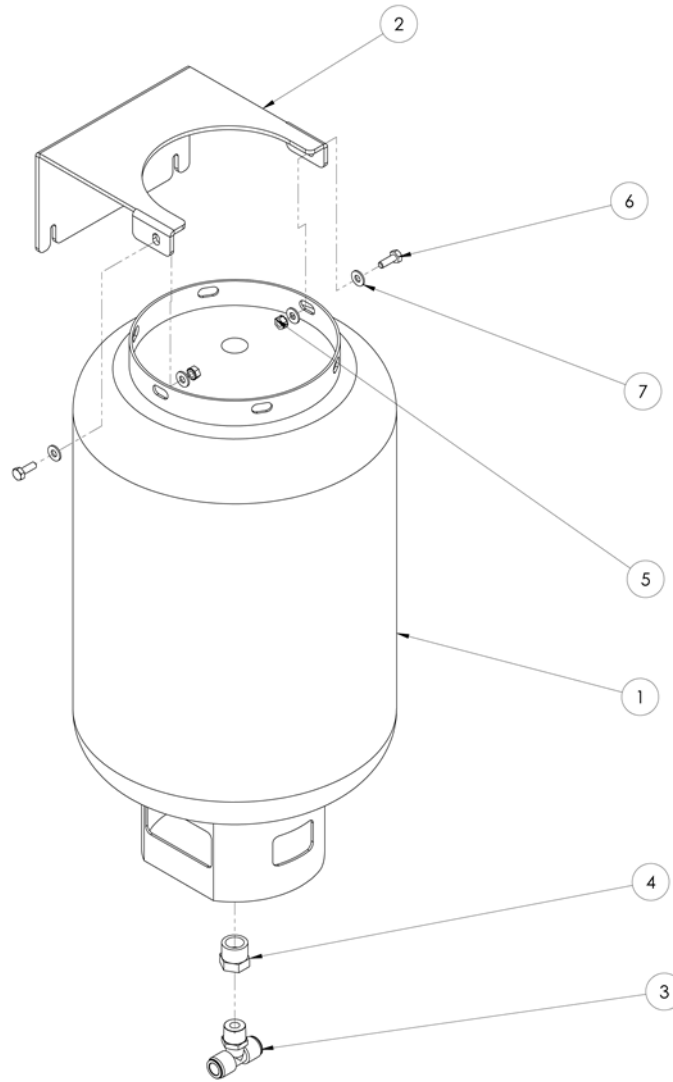
NO	QTY	PART #	DESCRIPTION
1	1	1406192	PLATEN CYL SUPPORT, LEFT
2	2	1406193	PLATEN CYL MOUNT PLATE
3	2	1406206	SUPPORT BEAM SPACER
4	1	1406209	PLATEN CYL SUPPORT, RIGHT
5	2	1406211	GEAR RACK GUIDE
6	2	1406212	GEAR RACK GUIDE MOUNT
7	1	1406214	CHAIN IDLER MOUNT
8	2	1406215	CHAIN GUARD SPACER
9	4	1406681	PLATEN CYL MOUNT SPACER
10	2	1406683	BLOCK, JACK SCREW
11	2	1406892	CYLINDER ROD END COUPLING, CLAMP
12	2	HC304020PP20	CYL, HYD, 4.0"B, 2.0"R, 20"S
13	4	HF05030808	STR 3/4-16ORB, 3/4-16JIC
14	1	MM6260K600	SPROCKET, IDLER, 17T, DBL
15	1	NNH1/2-13	NUT, HEX, 1/2-13
16	8	NNH5/8-11	NUT, HEX, 5/8-11
17	2	NNJ1-1/2-12	NUT, JAM, 1-1/2-12
18	2	NNJ1/2-13	1/2-13 JAM NUT
19	8	SSHC10112	SCREW, HEX, 5/16-18X1-3/4
20	4	SSHC25096	3/8-16 X 1 1/2 HHCS
21	8	SSHC34176	3/4-10 X 2-3/4 HEX CAP
22	1	SSHC41128	5/8-11 X 2 HEX CAP
23	8	SSHC41160F	5/8-11X2-1/2 HEX CAP
24	22	SSHC45096	1/2-13X1-1/2 HEX CAP
25	1	SSHC45352F	1/2-13X5 HEX CAP, FULL
26	21	WWFS1/2	WASHER, FLAT, 1/2, SAE
27	4	WWFS3/8	WASHER, FLAT, SAE, 3/8
28	9	WWFS5/8	WASHER, FLAT, 5/8, SAE
29	8	WWFS5/16	WASHER, FLAT, SAE, 5/16
30	20	WWL1/2	1/2 LOCK WASHER
31	8	WWL3/4	3/4 LOCK WASHER
32	4	WWL3/8	WASHER, LOCK, 3/8
33	1	WWL5/8	WASHER, LOCK 5/8
34	8	WWL5/16	WASHER, LOCK, 5/16



1406220 Platen Press Assembly, Right

AAC Drawing Number 1406220 Rev 5

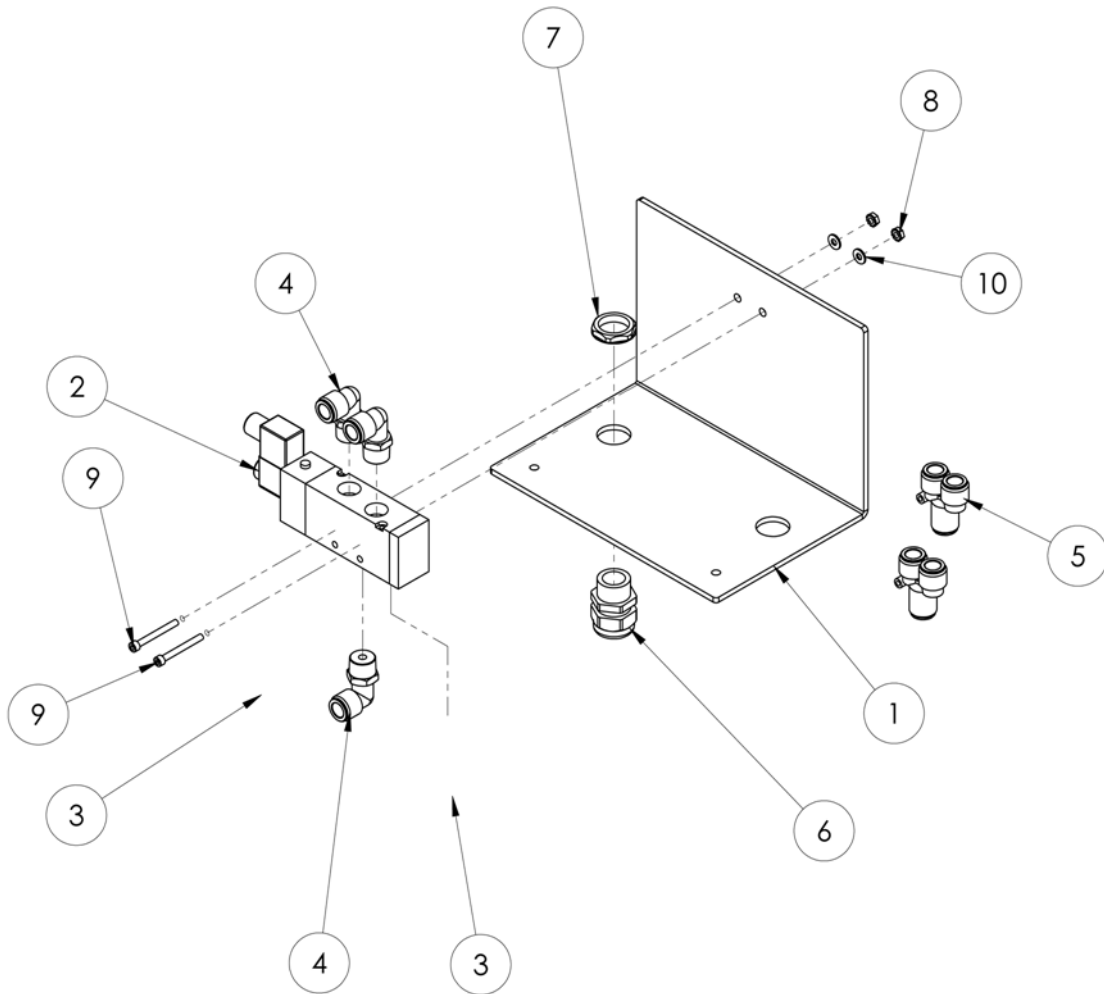
NO	QTY	PART #	DESCRIPTION
1	1	1406192	PLATEN CYL SUPPORT, LEFT
2	2	1406193	PLATEN CYL MOUNT PLATE
3	2	1406206	SUPPORT BEAM SPACER
4	1	1406209	PLATEN CYL SUPPORT, RIGHT
5	2	1406211	GEAR RACK GUIDE
6	2	1406212	GEAR RACK GUIDE MOUNT
7	1	1406214	CHAIN IDLER MOUNT
8	2	1406215	CHAIN GUARD SPACER
9	4	1406681	PLATEN CYL MOUNT SPACER
10	2	1406683	BLOCK, JACK SCREW
11	2	1406892	CYLINDER ROD END COUPLING,CLAMP
12	2	HC304020PP20	CYL,HYD,4.0"B,2.0"R,20"S
13	4	HF05030808	STR 3/4-16ORB,3/4-16JIC
14	1	MM6260K600	SPROCKET,IDLER,17T,DBL
15	1	NNH1/2-13	NUT,HEX,1/2-13
16	8	NNH5/8-11	NUT,HEX,5/8-11
17	2	NNJ1-1/2-12	NUT,JAM,1-1/2-12
18	2	NNJ1/2-13	1/2-13 JAM NUT
19	8	SSHHC10112	SCREW,HEX,5/16-18X1-3/4
20	4	SSHHC25096	3/8-16 X 1 1/2 HHCS
21	8	SSHHC34176	3/4-10 X 2-3/4 HEX CAP
22	1	SSHHC41128	5/8-11 X 2 HEX CAP
23	8	SSHHC41160F	5/8-11X2-1/2 HEX CAP
24	22	SSHHC45096	1/2-13X1-1/2 HEX CAP
25	1	SSHHC45352F	1/2-13X5 HEX CAP,FULL
26	21	WWFS1/2	WASHER,FLAT,1/2, SAE
27	4	WWFS3/8	WASHER,FLAT,SAE,3/8
28	9	WWFS5/8	WASHER,FLAT,5/8,SAE
29	8	WWFS5/16	WASHER,FLAT,SAE,5/16
30	20	WWL1/2	1/2 LOCK WASHER
31	8	WWL3/4	3/4 LOCK WASHER
32	4	WWL3/8	WASHER,LOCK, 3/8
33	1	WWL5/8	WASHER,LOCK 5/8
34	8	WWL5/16	WASHER,LOCK, 5/16



1391681 Air Tank Assembly

AAC Drawing Number 1391681 Rev 0

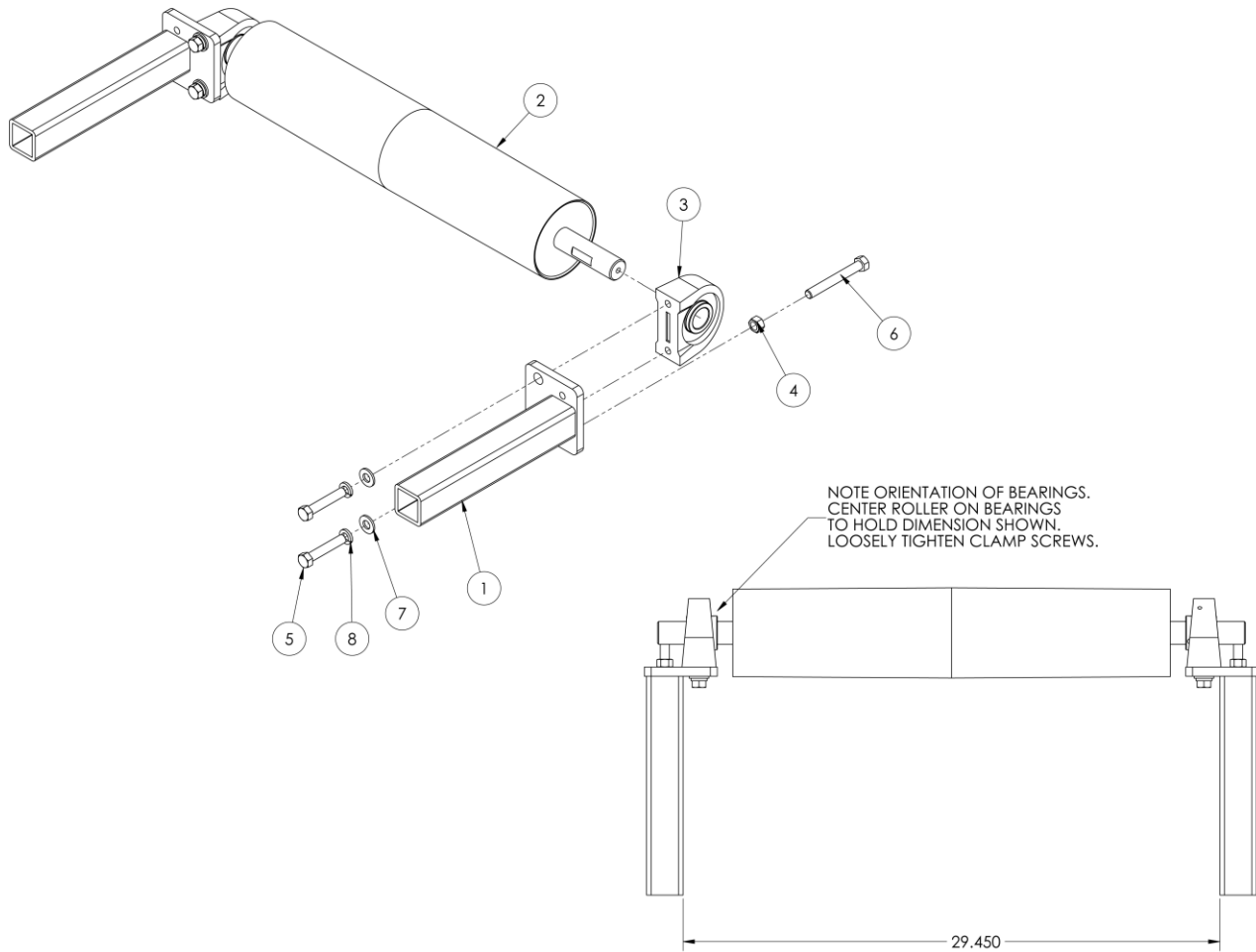
NO	QTY	PART #	DESCRIPTION
1	1	261007	AIR TANK ASSEMBLY
2	1	1391682	TOP PLATE, AIR TANK
3	1	AAQBT-2-2	QUICK BRANCH "T"
4	1	MM44605K24	HEX BUSHING, 3/4 X 1/2
5	2	NNK1/4-20	KEP NUT, 1/4-20
6	2	SSHCO1048	1/4-20 X 3/4 HEX HEAD
7	4	WWFS1/4	WASHER FLAT, 1/4



1406573 Valve Assembly, Side Seal

AAC Drawing Number 1406573 Rev 1

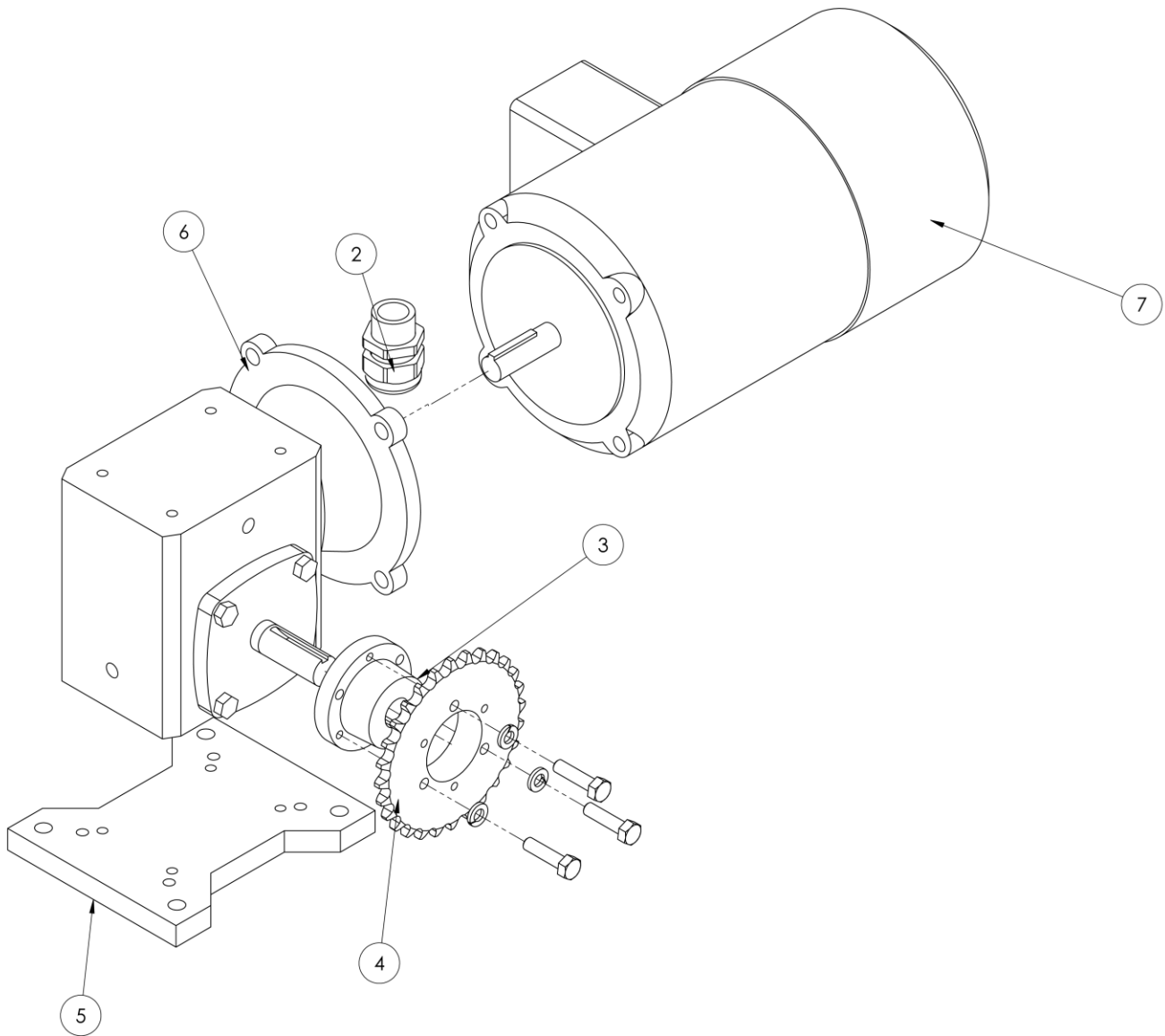
NO	QTY	PART #	DESCRIPTION
1	1	1406591	MOUNT, VALVE, JUNCTION BOX
2	1	AAE4V41015	VALVE, 1/2" PORTED, 24VDC
3	2	AAFAN400N04	MUFFLER, 1/2NPT, PLASTIC
4	3	AAQME-2-2S	FITTING, ELBOW, 1/2NPT, 1/2
5	2	AAQUY-2-2	QUICK UNION Y, 1/2X1/2
6	1	FF3234	STRAIN RELIEF, 3/4NPT
7	1	FF8465	NUT, LOCK, 3/4NPT, NYLON, BLK
8	2	NNK10-32	KEP NUT, 10-32
9	2	SSSC98112	SCR, SOC CAP 10-32 X 1-3/4
10	2	WWFS10	WASHER, FLAT, #10, SAE



1406675 Idler Roller Assembly

AAC Drawing Number 1406675 Rev 0

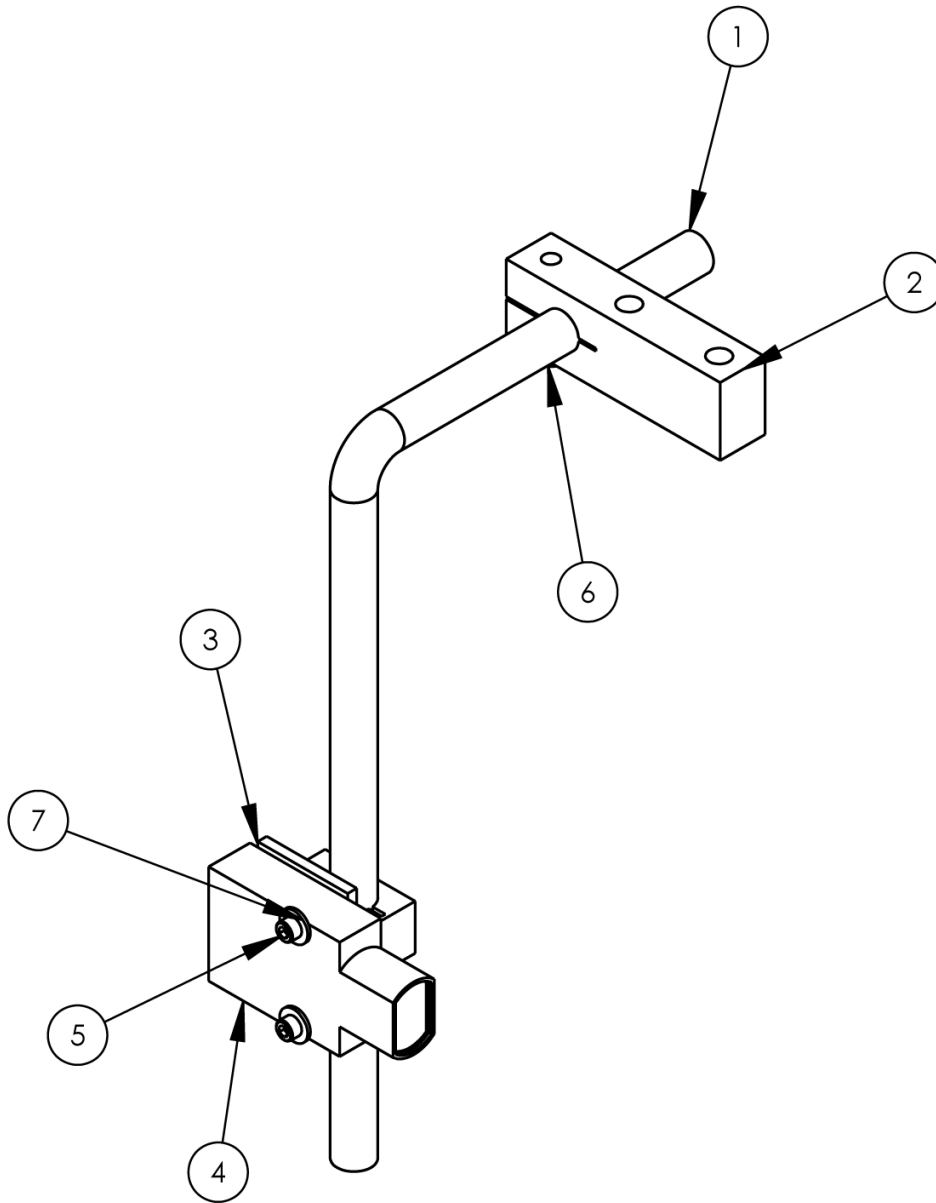
NO	QTY	PART #	DESCRIPTION
1	2	1390247	WELDMENT, BELT-TENSIONER
2	1	1391447	IDLER-ROLLER, 24" BELT
3	2	MMUCPA207-20	1.25" BEARING
4	2	NNH1/2-13	NUT, HEX, 1/2-13
5	4	SSH45176	1/2-13X2-3/4 HEX CAP
6	2	SSH45256F	1/2-13X4 FULL THD HEX CAP
7	4	WWFS1/2	WASHER, FLAT, 1/2, SAE
8	4	WWL1/2	1/2 LOCK WASHER



1406753 Motor/ Reducer Assembly

AAC Drawing Number 1406753 Rev 0

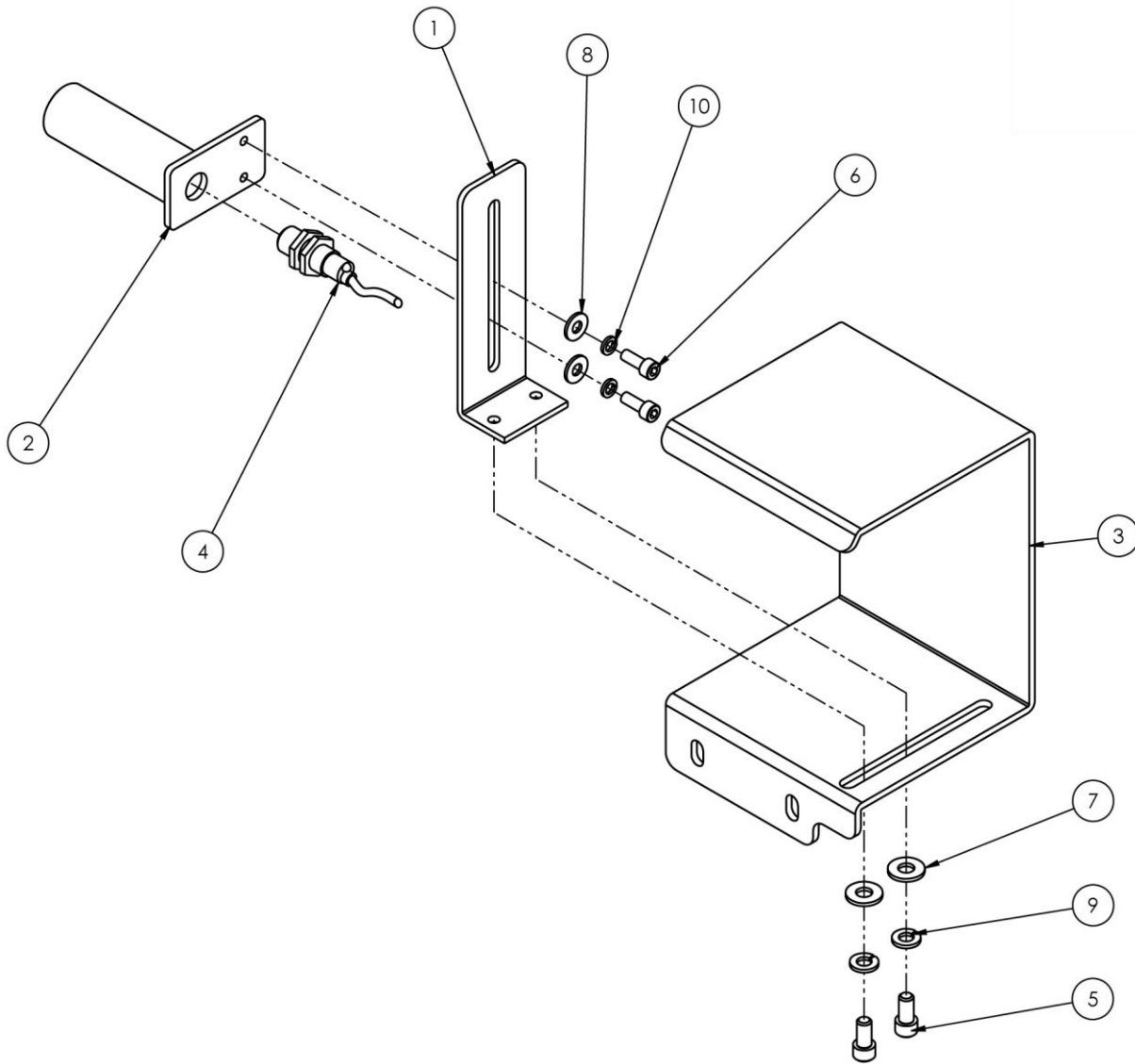
NO	QTY	PART #	DESCRIPTION
1	AR	51494	LUBRICANT,MOBIL SHC634
2	1	FF3460	STRAIN RELIEF,LIQ TIGHT
3	1	MM3/4SH	HUB, TAPERLOCK
4	1	MM40SH28H	SPROCKET, 1/2 P, 28T
5	1	MM56438	HORIZONTAL BASE,CI U
6	1	MMF71520B5J	SPEED REDUCER,WORM,
7	1	MMVM3542	3/4 1800 TEFC 208/460



1390443 Film Out Sensor Assembly

AAC Drawing Number 1390443 Rev 0

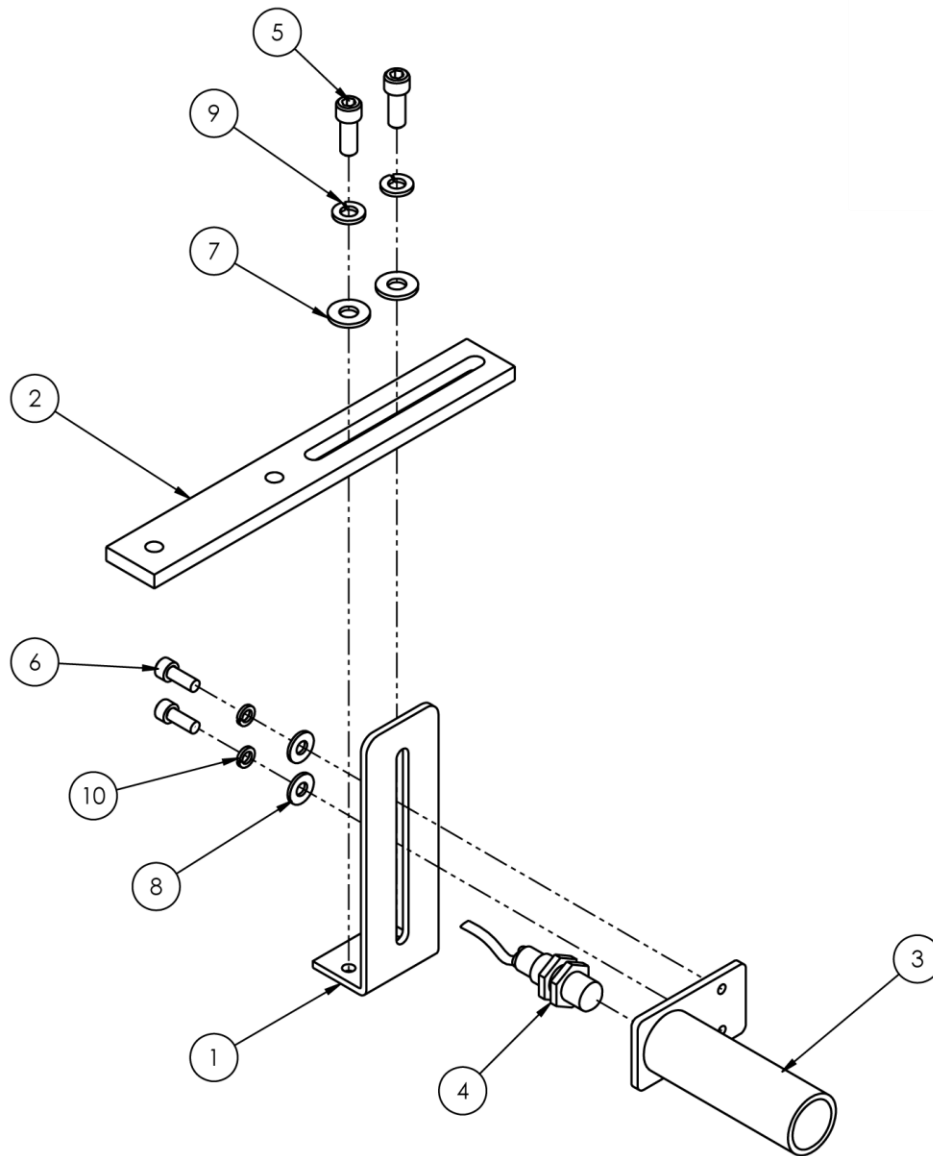
NO.	QTY	PART #	DESCRIPTION
1	1	1335-316	ROD, SS, "L", 3/8, 4.0 X
2	1	23080	BLOCK, CLAMP, EYE
3	1	23132A	HOLDER, EYE
4	1	FFSM312LVQ	EYE, ELECTRIC, 10-30VDC
5	2	SSSC70040	4-40 X 5/8, SCREW, SOCKET CAP
6	2	SSSC98040	10-32 X 5/8 SOC CAP
7	2	WWF4	WASHER, FLAT, #4



1390466 Right Sensor Assembly

AAC Drawing Number 1390466 Rev 0

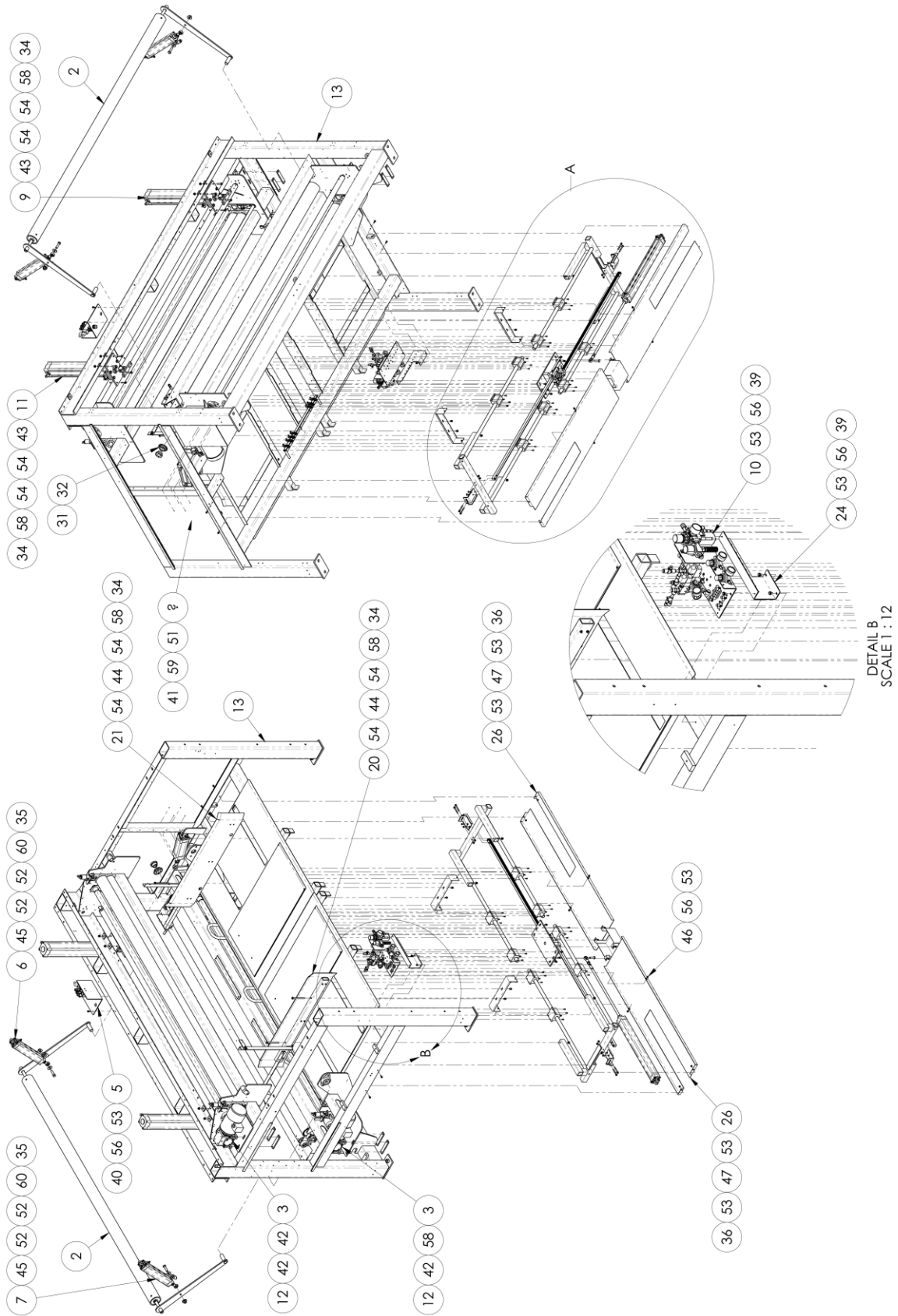
NO.	QTY	PART #	DESCRIPTION
1	1	1390063	BRKT,MNT,SENSOR
2	1	1390399	MOUNT, SENSOR
3	1	1390541	GUARD, SENSOR
4	1	EERM1215M	SENSOR, RECEIVER
5	2	SSSC01032	1/4-20X1/2 SOC CAP
6	2	SSSC98032	10-32X1/2, SOC CAP
7	2	WWFS1/4	WASHER,FLAT,SAE,1/4
8	2	WWFS10	WASHER, FLAT, #10, SAE
9	2	WWL1/4	WASHER,LOCK,1/4
10	2	WWL10	WASHER,LOCK,#10

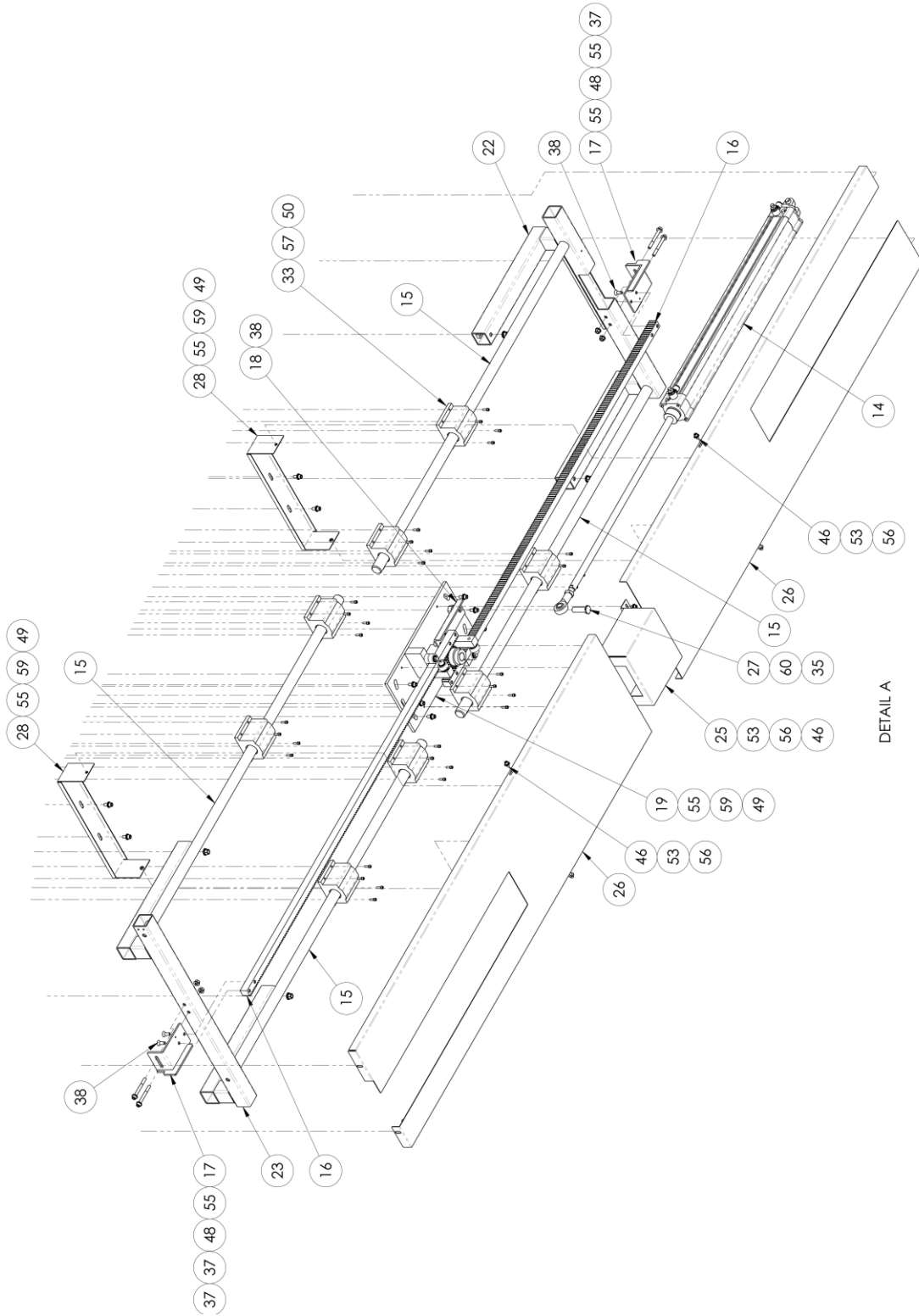


1390467 Sensor Assembly

AAC Drawing Number 1390467 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1390063	BRKT,MNT,SENSOR
2	1	1390395	BRACKET
3	1	1390399	MOUNT, SENSOR
4	1	EETM12HP15M	SENSOR, TRANSMITTER, HP
5	2	SSSC01040	1/4-20 X 5/8" SOC CAP SC
6	2	SSSC98032	10-32X1/2, SOC CAP
7	2	WWFS1/4	WASHER,FLAT,SAE,1/4
8	2	WWFS10	WASHER, FLAT, #10, SAE
9	2	WWL1/4	WASHER,LOCK,1/4
10	2	WWL10	WASHER,LOCK,#10

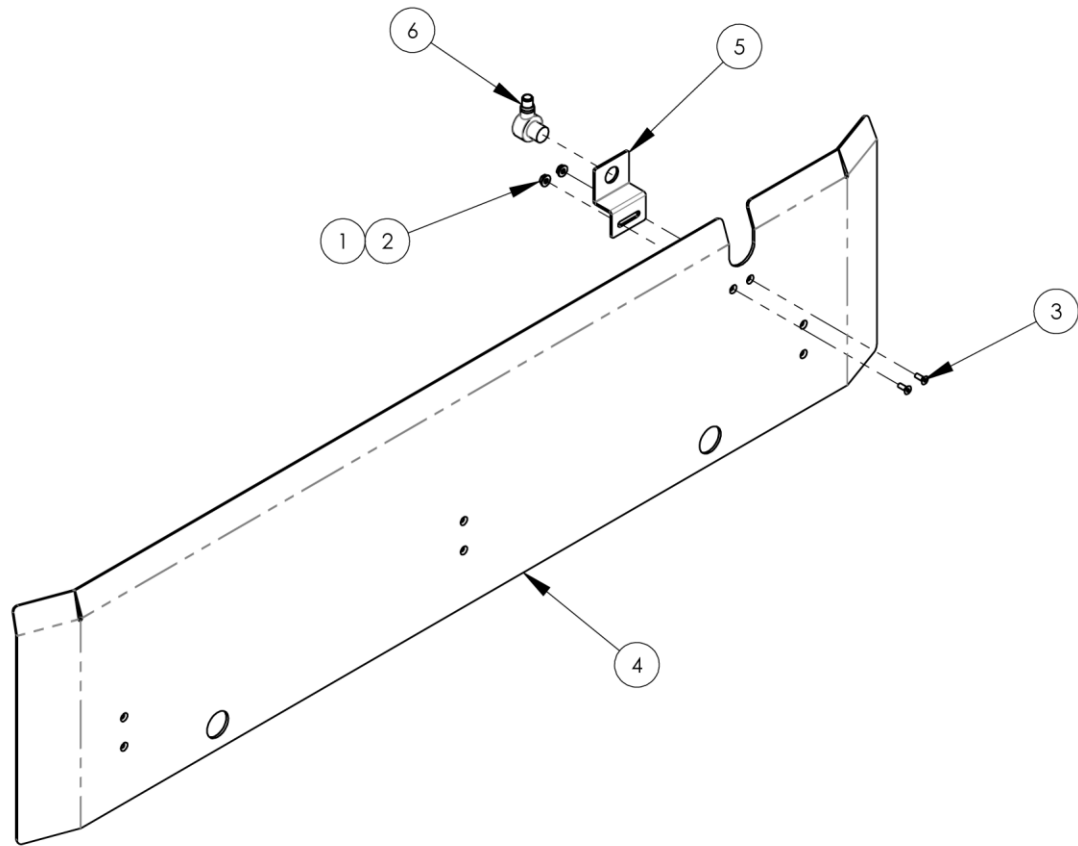




1391463 Input Conveyor Assembly #2

AAC Drawing Number 1391463 Rev 3

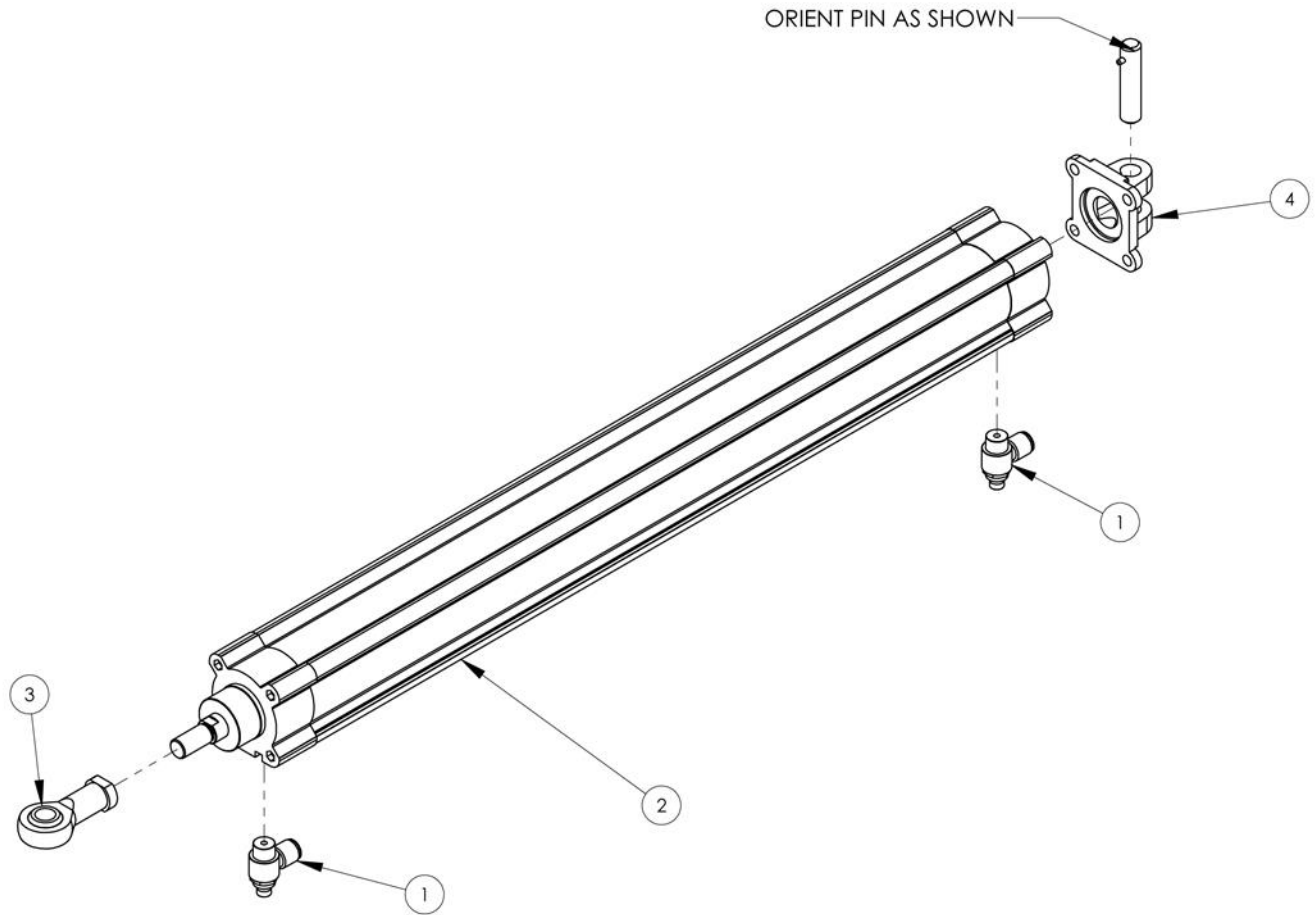
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	3	1390160	KEY, 1/4 X 1.25L	31	3	MM11/4SH	HUB, TAPERLOCK
2	1	1390297	PVC ROLLER ASM	32	3	MM40SH21H	SPROCKET, 1/2 P, 21T
3	2	1390473	MOTOR/REDUCER ASSY	33	8	MMP20	LIN.PILLOW-BLOCK,SEALIGN
4	1	1390979	MOTOR ASSEMBLY	34	12	NNH3/8-16	NUT,HEX,3/8-16
5	1	1391035	VALVE ASSY, CROSS SEAL	35	3	NNH5/8-11	NUT,HEX,5/8-11
6	1	1391062	CYL ASSY, LRG INFEED ROLL	36	4	NNK1/4-20	NUT,KEP,1/4-20
7	1	1391063	CYL ASSY, LRG INFEED ROLL	37	4	NNK5/16-18	NUT,KEP,5/16-18
8	2	1391068	ARM, PVC ROLLER	38	6	SSFC10056	5/16-18 X 7/8 FLAT HD CAP
9	1	1391071	CYLINDER ASSY. CROSS SEAL	39	4	SSHC01040	1/4-20 X 5/8 HHCS
10	1	1391104	VALVE BANK ASSEMBLY	40	2	SSHC01064	1/4-20 X 1 HHCS
11	1	1391145	CYLINDER ASSY. CROSS SEAL	41	4	SSHC10064	5/16-18 X 1 HHCS
12	4	1391177	NUT PLATE, GEAR MOTOR MTG	42	8	SSHC25096	3/8-16 X 1 1/2 HHCS
13	1	1391453	INPUT CONVEYOR ASSY #1	43	8	SSHC25128	3/8-16 X 2 HEX CAP
14	1	1391464	CYLINDER ASSY-INFEED SIDE	44	4	SSHC25352	3/8-16X5-1/2,HEX CAP
15	4	1391467	ROD,THOMSON,1-1/4OD	45	2	SSHC41160	5/8-11X2-1/2 HEX CAP
16	2	1391468	GEAR RACK, 10DP, 1" FACE	46	8	SSSC01032	1/4-20X1/2 SOC CAP
17	2	1391470	BRACKET, GEAR RACK PUSHER	47	4	SSSC01056	1/4-20 X 7/8 SOC CAP
18	1	1391472	BRACKET, GEAR RACK PULLER	48	4	SSSC10192	SCREW, SOCKET CAP
19	1	1391478	IDLER GEAR ASBLY	49	10	SSSC20048	5/16-24X3/4 SOC CAP
20	1	1391480	PUSHER ASBLY, LEFT	50	32	SSSC98040	10-32 X 5/8 SOC CAP
21	1	1391488	PUSHER ASBLY, RIGHT	51	4	WWF5/16	WASHER,FLAT,5/16
22	1	1391491	FRAME WELDMENT, PUSHER,LT	52	4	WWF5/8	WASHER,FLAT,5/8
23	1	1391492	FRAME WELDMENT, PUSHER,RT	53	22	WWFS1/4	WASHER,FLAT,SAE,1/4
24	1	1391493	BKT, MOUNT, SOL ASBLY	54	24	WWFS3/8	WASHER,FLAT,SAE,3/8
25	1	1391495	COVER, IDLER GEAR ASBLY	55	18	WWFS5/16	WASHER,FLAT,SAE,5/16
26	2	1391626	PAN, GREASE GUARD	56	14	WWL1/4	WASHER,LOCK, 1/4
27	1	1391695	MODIFIED 5/8-11 X 2 HHCS	57	32	WWL10	WASHER,LOCK,# 10
28	2	1391698	BRACKET, GUARD SUPPORT	58	20	WWL3/8	WASHER,LOCK, 3/8
29	1	1396850	MOTOR MOUNTING ANGLE	59	14	WWL5/16	WASHER,LOCK, 5/16
30	1	1396853	GUARD, CHAIN, INFEED MTR	60	3	WWL5/8	WASHER,LOCK 5/8



1406553 Left Pusher Plate Assembly

AAC Drawing Number 1406553 Rev 0

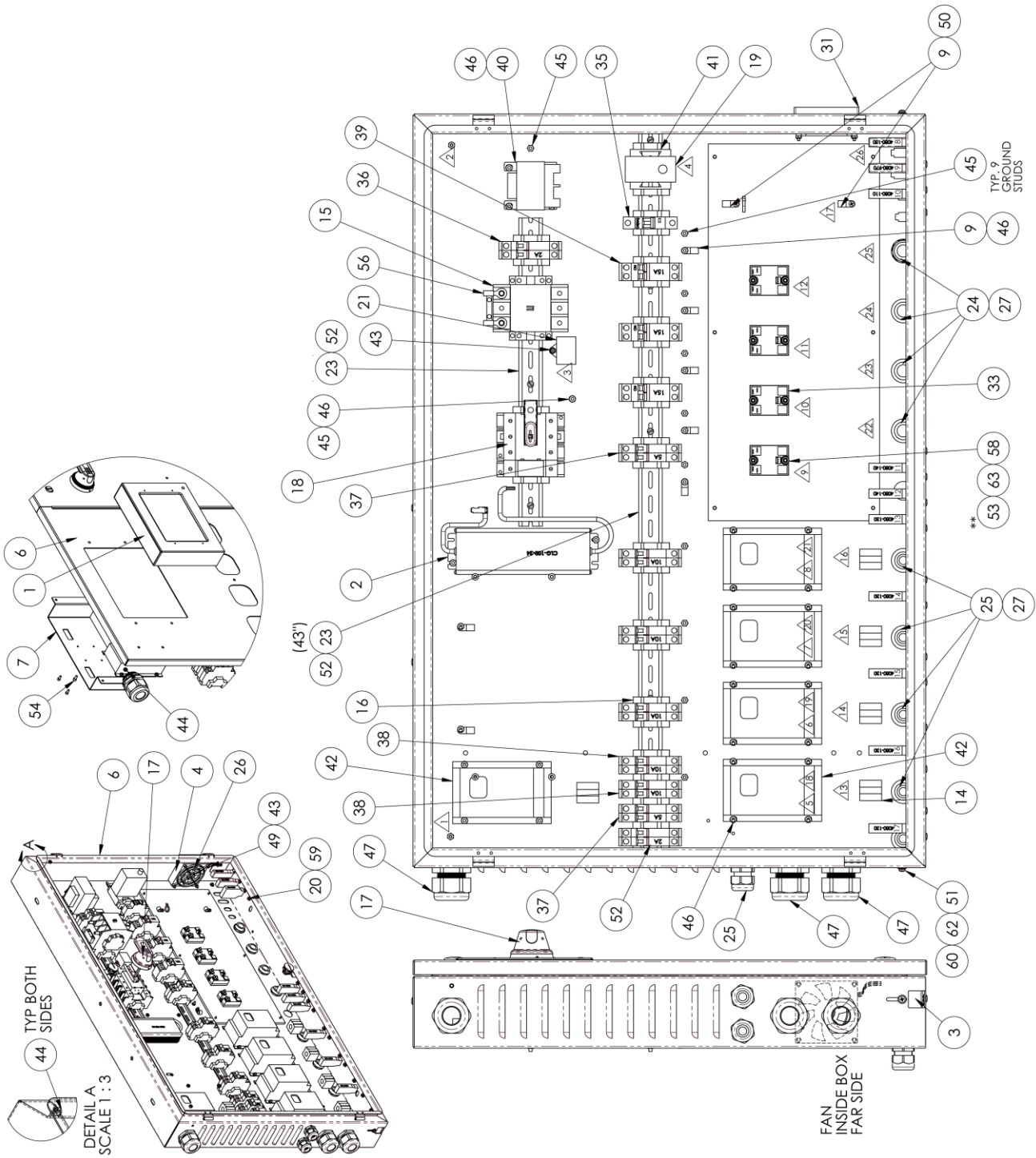
NO	QTY	PART #	DESCRIPTION
4	1	1406526	PLATE, PUSHER ASBLY
5	1	1406527	BRACKET, HEIGHT EYE
6	1	FFT18FF100Q	EYE, FIXED FIELD, 4IN
2	2	NNK10-32	KEP NUT, 10-32
3	2	SSFC98032	10-32 X 1/2 FLAT ALLEN
1	2	WWFS10	WASHER, FLAT, #10, SAE



1391464 Cylinder Assembly Infeed Side

AAC Drawing Number 1391464 Rev 0

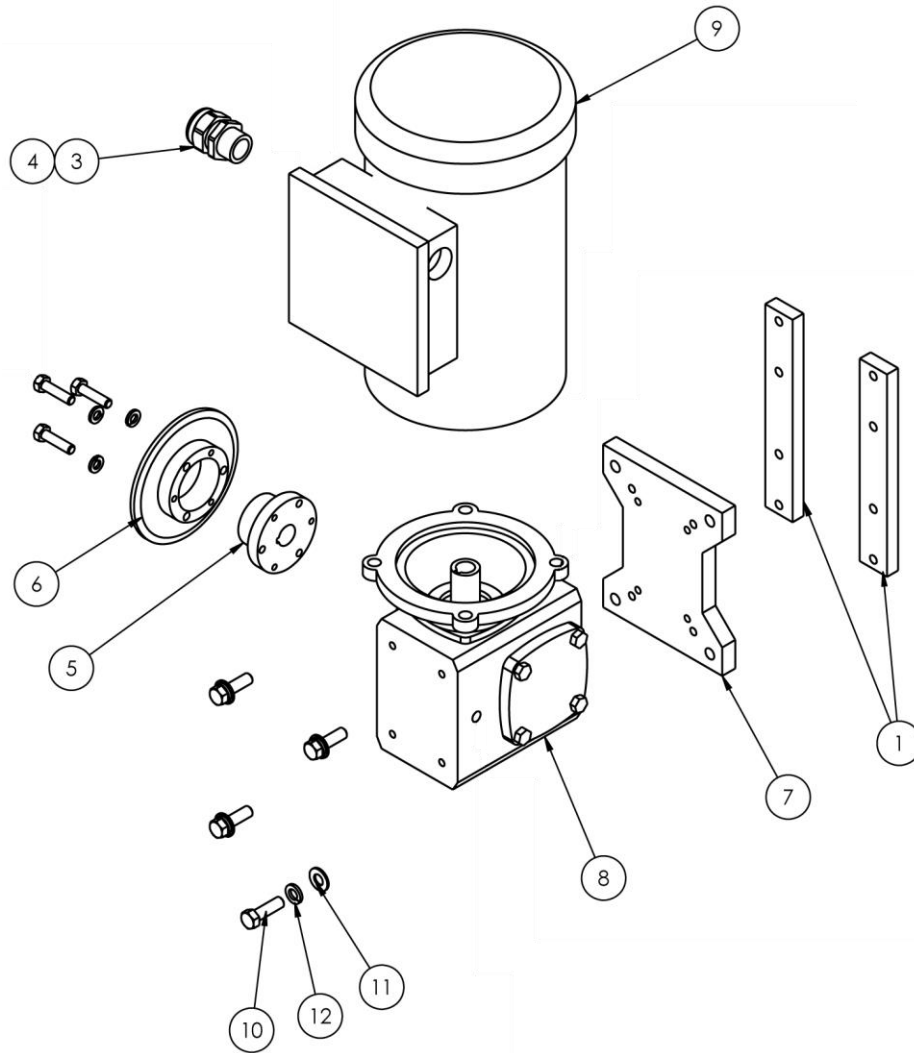
NO	QTY	PART #	DESCRIPTION
1	2	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8
2	1	AACDNCB63710PPV	CYLINDER,AIR,ISO,63BX380S
3	1	AAFSGSM16x15	BEARING,ROD END, FOR DNCB50
4	1	AAFSNC63	REAR PIVOT BRKT, 63MM BORE FESTO



1406756 Control Box Assembly

AAC Drawing Number 1406756 Rev 3

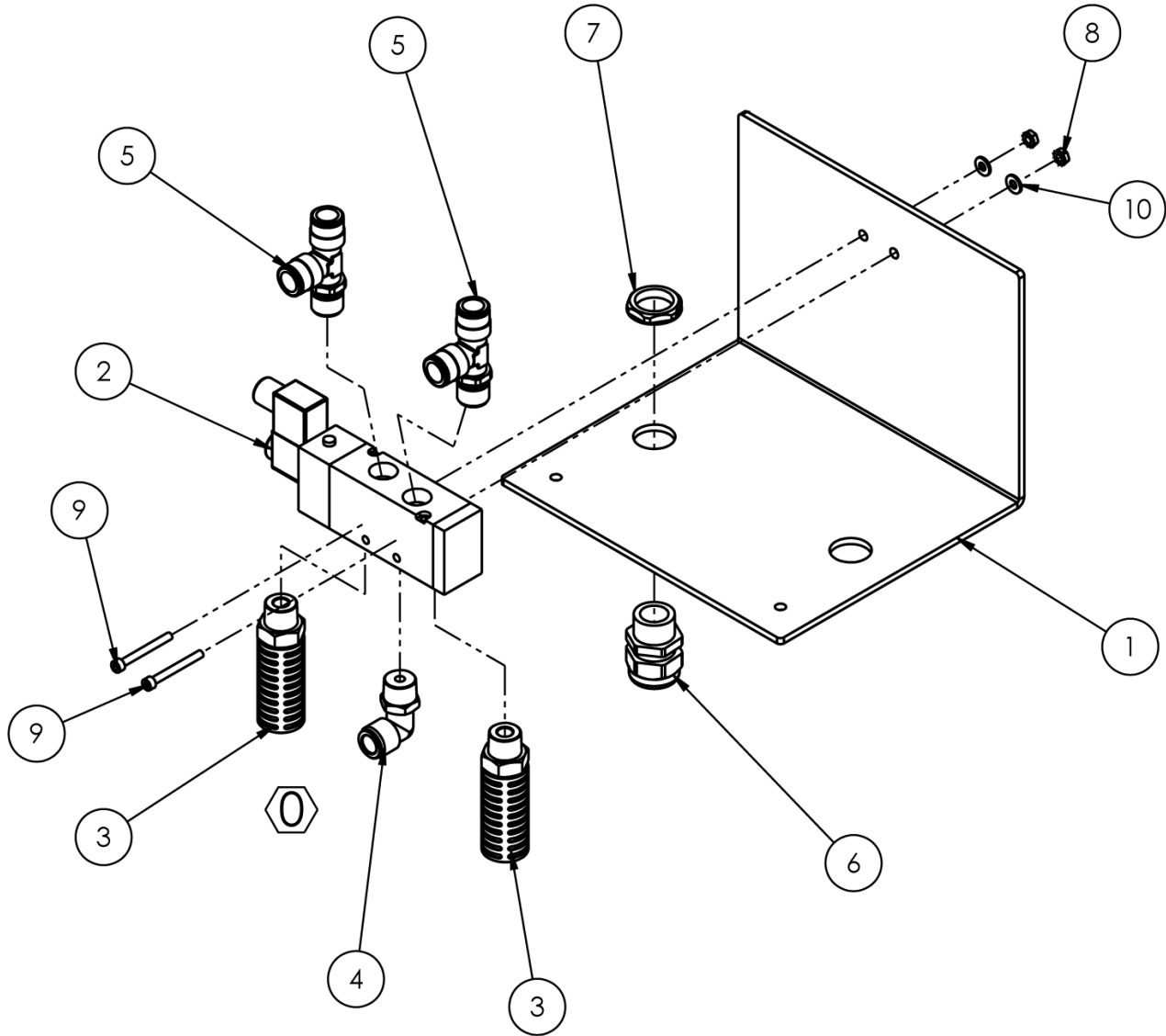
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	4080-004A	CONTROLLER,SBUS,8.4",VGA	33	4	FF84140210M1	RELAY,SSR,24VAC,25A
2	1	4080-990B	POWER SUPPLY, SBUS,	34	4	FFHSP1	THERMAL PAD
3	2	1391131	CLAMP, SERIAL BUS EXIT	35	1	FFL741C	CIRCUIT BREAKER,THERM-MAG
4	*AR	1391144	FAN - CONNECTOR ASSY	36	2	FFQL213DMKM02	CIRCUIT BREAKER,2A,2P
5	1	1391164	CABLE KIT	37	2	FFQL213DMKM05	CIRCUIT BREAKER,5A,2P
6	1	1391994	CONTROL BOX ASSM	38	5	FFQL213DMKM10	CIRCUIT BREAKER,10A,2P
7	1	1394922	MTG. PLATE, TOUCH SCREEN	39	3	FFQL213DMKM15	CIRCUIT BREAKER,15A,2P
8	1	1406749	ELECTRICAL KIT, 1390HCB	40	1	FFTX28/5A	TRANSFORMER,28V,4.6AMP
9	9	AAF3/8	CLAMP, BLACK PLASTIC	41	1	MM700HN126	RELAY BASE DIN RAIL MNT 11 PIN
10	20	EE6X752	TIE WRAP - Small.	42	5	MMSL208S	DRIVE, VAR, FREQ. .75HP, 1PH
11	*6'	EE9910-2	WIRE,STR,#10,PVC,RED	43	5	NNE6-32	NUT,ELASTIC LOCK,6-32
12	*6'	EE9910-10	WIRE,STR,#10,PVC,BLK	44	4	NNE8-32	NUT,ELASTIC LOCK, 8-32
13	*6'	EE9910-13	WIRE,STR,#10,PVC,BLU	45	20	NNH8-32	NUT,HEX, 8-32 REG.
14	5	EE64151B	FERRITE CORE,SPLIT,CABLE	46	34	NNK8-32	KEP NUT, 8-32
15	1	EECGC85A24	CONTACTOR,65A,24VAC	47	3	RBM4524	STRAIN RELIEF,1-1/4 NPT
16	29	EECLIPFIX	ANCHOR,DIN RAIL	48	3	RBM9144	LOCKNUT,NYLON,1-1/4"NPT
17	1	EEHR65	DISCONNECT HANDLE	49	4	SSFC80096	6-32 X 1-1/2 FT HD CAP
18	1	EEM60U3M	DISCONNECT ASSY, 3PH, 60A	50	2	SSPP90024	8-32X3/8 PAN PHLPS
19	1	EEN2424VDC	AMPLIFIER, PHOTOEYE,MANUAL	51	2	SSPP98024	# 10-32 X 3/8 PAN HD PHIL
20	23	EERPBM5H25C	MOUNT,CABLE TIE,NYLON	52	10	SSPS98024	# 10-32 X 3/8 LG. PAN HD SLOT
21	*AR	EERC601BUZ4	PROTECTOR, SURGE	53	11	SSSC90024	#8-32 X 3/8 SOC CAP SC
22	1	EESPA210-3.85	DISCONNECT SHAFT,MOD	54	1	SSSC98024	10-32 X 3/8 SOC CAP
23	*61"	EETS35X7.5A	DIN RAIL-AMERICAN	55	8	TT190020044	TERMINAL,FASTON,F
24	4	FF3234	STRAIN RELIEF,3/4NPT	56	2	TT190730242	TERMINAL,RING,5/16"STD
25	7	FF3460	STRAIN RELIEF,LIQ TIGHT	57	6	TTSRBS82908	TERMINAL,STAR RING,#8,14-18
26	1	FF08174	FAN GUARD, 92MM, METAL	58	*12	WWF8	WASHER, FLAT, #8
27	11	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK	59	23	WWFM6	6MM FLAT WASHER
28	*2'	FF8908-2	WIRE,STR,#8,PVC,RED	60	2	WWFS10	WASHER, FLAT # 10
29	*2'	FF8908-10	WIRE,STR,#8,PVC,BLK	61	4	WWL8	WASHER,LOCK,#8
30	*2'	FF8908-13	WIRE,STR,#8,PVC,BLU	62	2	WWL10	# 10 LW
31	1	FF09362F30	FAN FILTER ASSY, 92MM	63	8	WWSB8	WASHER,BELVEL,#8
32	*6"	FF31572787	WIRE,STR,#10,PVC,GRN/YEL				



1390482 Motor Assembly

AAC Drawing Number 1390482 Rev 4

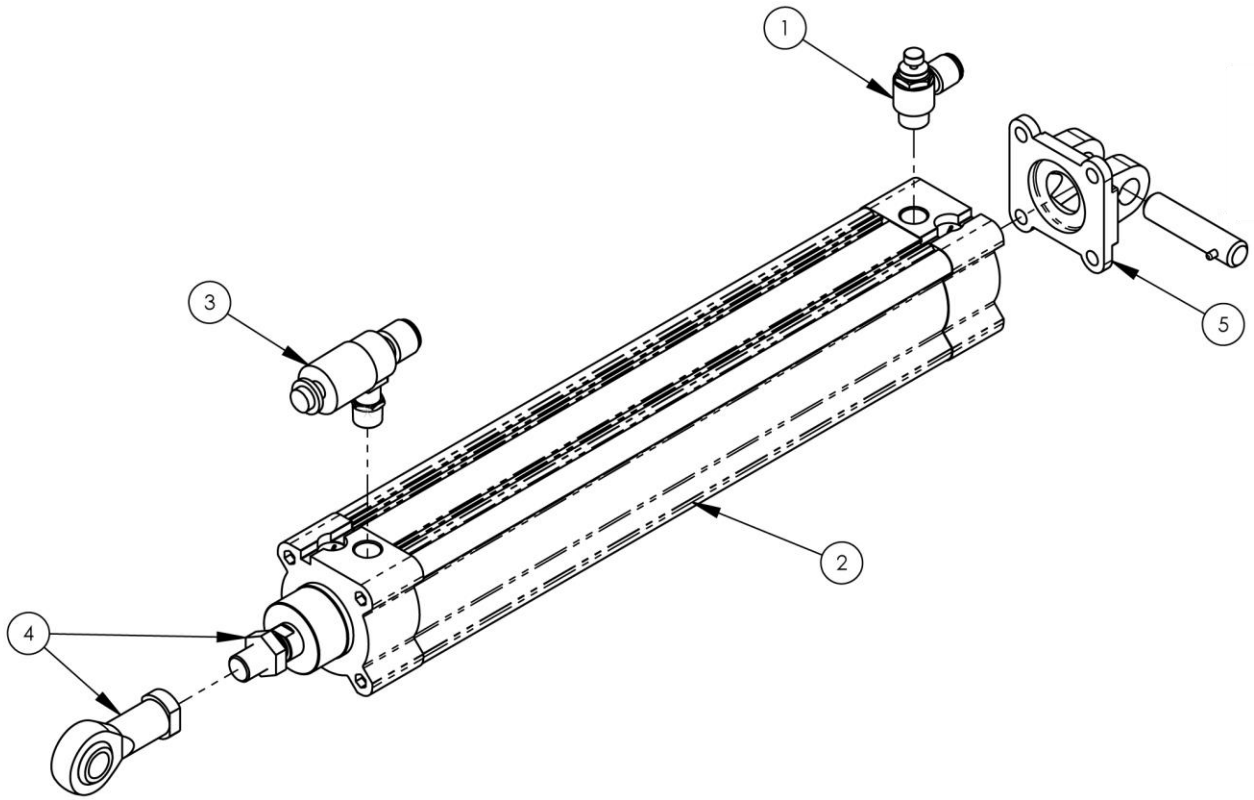
NO.	QTY	PART #	DESCRIPTION
1	2	1391381	PLATE, MOTOR ASSY ADAPTOR
2	.5 QT*	51494	LUBRICANT, MOBIL SHC634
3	1	FF3460	STRAIN RELIEF, LIQ TIGHT
4	1	FF8465	NUT, LOCK, 3/4NPT, NYLON, BLK
5	1	MM3/4SH	HUB, TAPERLOCK
6	1	MM40SH28H	SPROCKET, 1/2 P, 28T
7	1	MM56438	HORIZONTAL BASE, CI U
8	1	MMF71520B5J	SPEED REDUCER, WORM,
9	1	MMVM3542	MOTOR, 3PH, 3/4HP, 230/460V
10	4	SSH25080	3/8-16 X 1-1/4 HEX CAP
11	4	WWFS3/8	WASHER, FLAT, SAE, 3/8
12	4	WWL3/8	WASHER, LOCK, 3/8



1391035 Cross Seal Valve Assembly

AAC Drawing Number 1391035 Rev 1

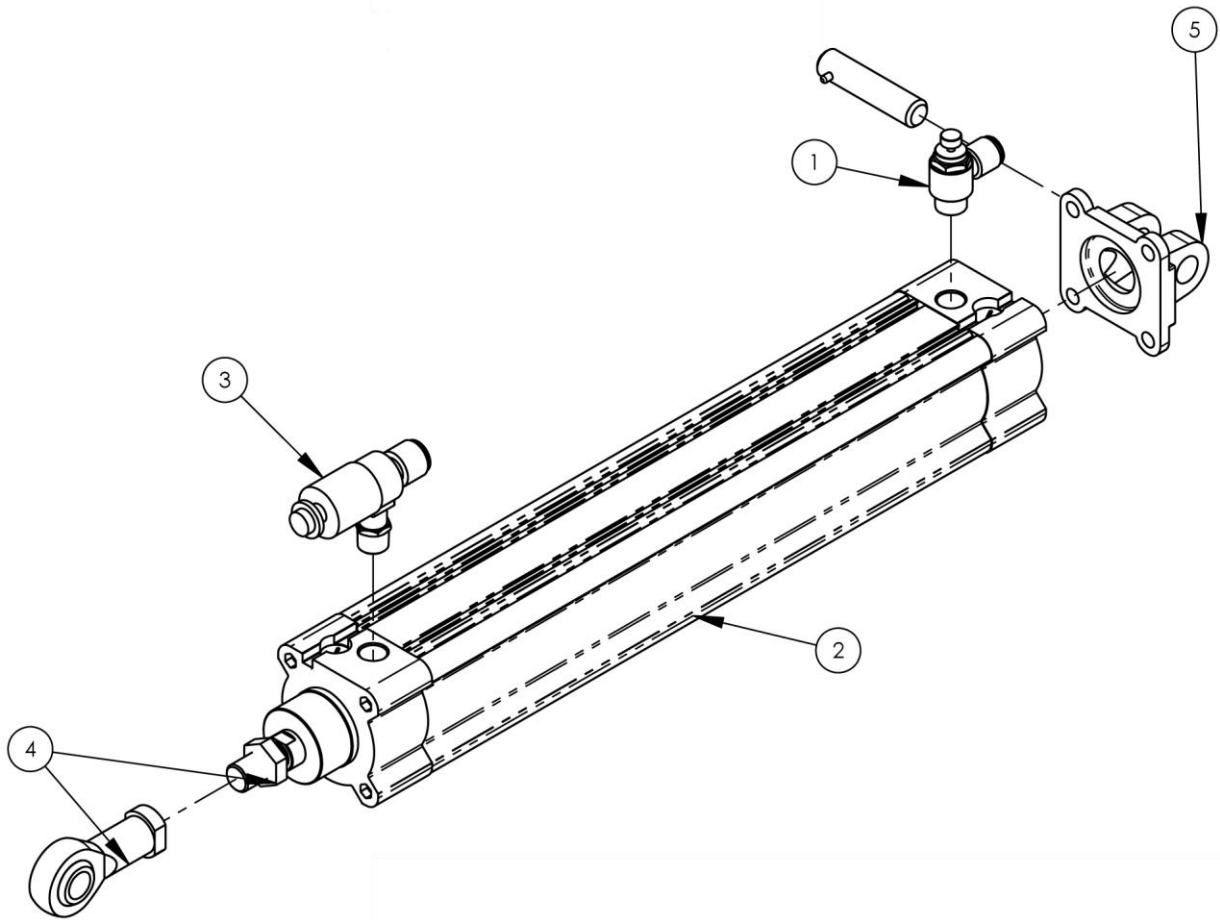
NO.	QTY	PART #	DESCRIPTION
1	1	1391086	MOUNT, VALVE, JUNCTION BOX
2	1	AAE4V41015	VALVE, 1/2" PORTED, 24VDC
3	2	AAFAN400N04	MUFFLER, 1/2NPT, PLASTIC
4	1	AAQME-2-2S	FITTING, ELBOW, 1/2NPT, 1/2
5	2	AAQMT-2-2S	TEE, 1/2NPT-1/2 TUBE
6	1	FF3234	STRAIN RELIEF, LIQ TIGHT
7	1	FF8465	NUT, LOCK, 3/4NPT, NYLON, BLK
8	2	NNK10-32	KEP NUT, 10-32
9	2	SSSC98112	SCR, SOC CAP 10-32 X 1-3/4
10	2	WWFS10	WASHER, FLAT, #10, SAE



1391062 Cylinder Assembly, Large Infeed Roll

AAC Drawing Number 1391062 Rev 0

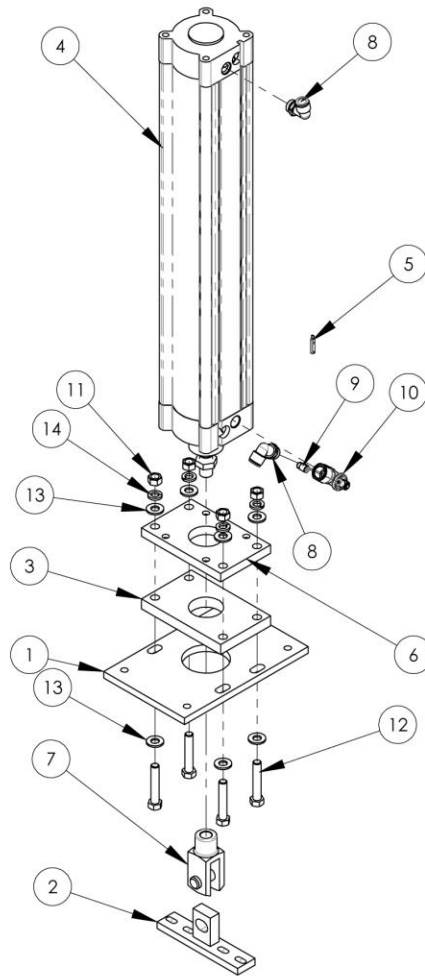
NO.	QTY	PART #	DESCRIPTION
1	1	AA1983201FU0311	FLOW CONTRL 3/8UNIFIT X3/8
2	1	AACDNCB63380PPV	CYLINDER,AIR,ISO,63BX380S
3	1	AAFASV510F3R	QUICK EXHAUST,3/8R,3/8T
4	1	AAFSGSM16x15	BEARING,ROD END, FOR DNCB50
5	1	AAFSNC63	REAR PIVOT BRKT, 63MM BORE FESTO



1391063 Cylinder Assembly, Large Infeed Roll

AAC Drawing Number 1391063 Rev 1

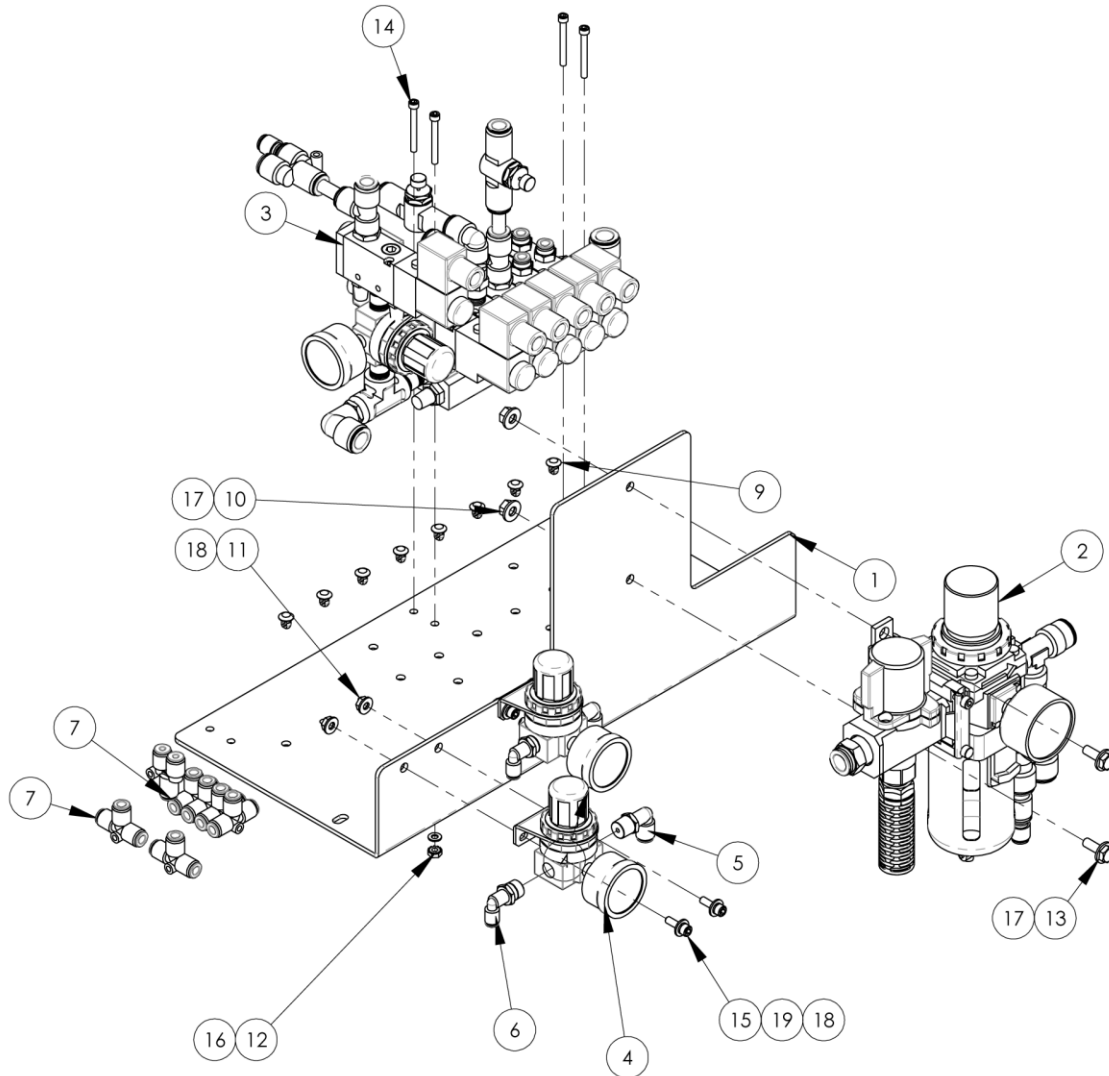
NO.	QTY	PART #	DESCRIPTION
1	1	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8
2	1	AACDNB63380PPV	CYLINDER,AIR,ISO,63BX380S
3	1	AAFASV510F3R	QUICK EXHAUST,3/8R,3/8T
4	1	AAFSGSM16x15	BEARING,ROD END, FOR DNCB50
5	1	AAFSNC63	REAR PIVOT BRKT, 63MM BORE FESTO



1391071 Cross Seal Cylinder Assembly

AAC Drawing Number 1391071 Rev 1

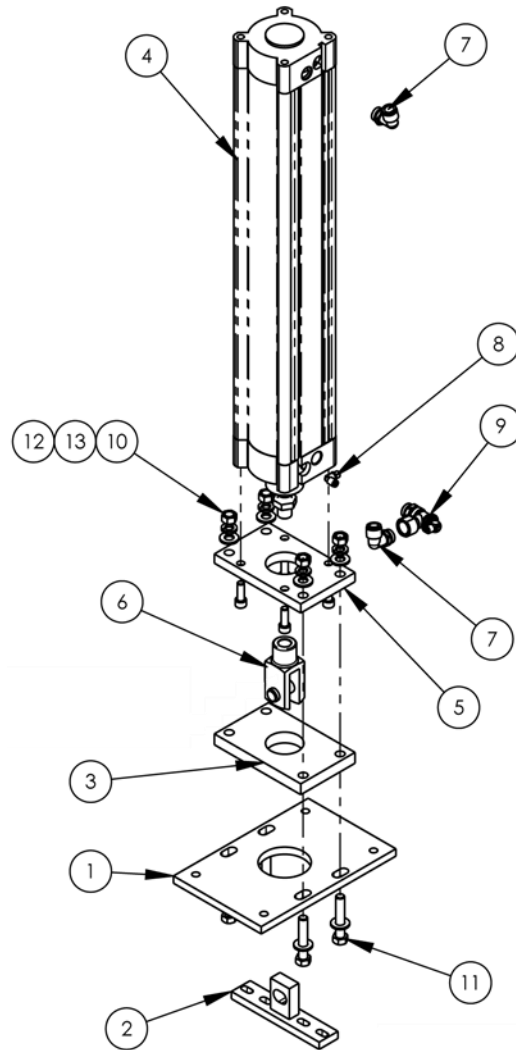
NO.	QTY	PART #	DESCRIPTION
1	1	1391072	CYLINDER MOUNT PLATE-END
2	1	1391073	CROSS SEAL CYL. MNT
3	1	1391075	SPACER, MOUNTING PLT, - DNC
4	1	AACDNCB100610PP	CYLINDER, AIR, ISO, 100BX610S
5	AR*	AAESME8KLED24	SENSOR FOR FESTO DNCB CYL
6	1	AAFNC100	FLANGE, MOUNTING PLT, - DNCB100610
7	1	AAFSGM20X15	CLEVIS, ROD, M20 X 1.5
8	2	AAQME-2-2U	FITTING, 1/2T-1/2 UNIFIT
9	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
10	1	AAV78862121	VALVE, BLOCKING, R1/2
11	4	NNH1/2-13	NUT, HEX, 1/2-13
12	4	SSHC45176	1/2-13X2-3/4 HEX CAP
13	8	WWFS1/2	WASHER, FLAT, SAE, 1/2
14	4	WWL1/2	1/2 LOCK WASHER



1391104 Valve Bank Assembly

AAC Drawing Number 1391104 Rev 2

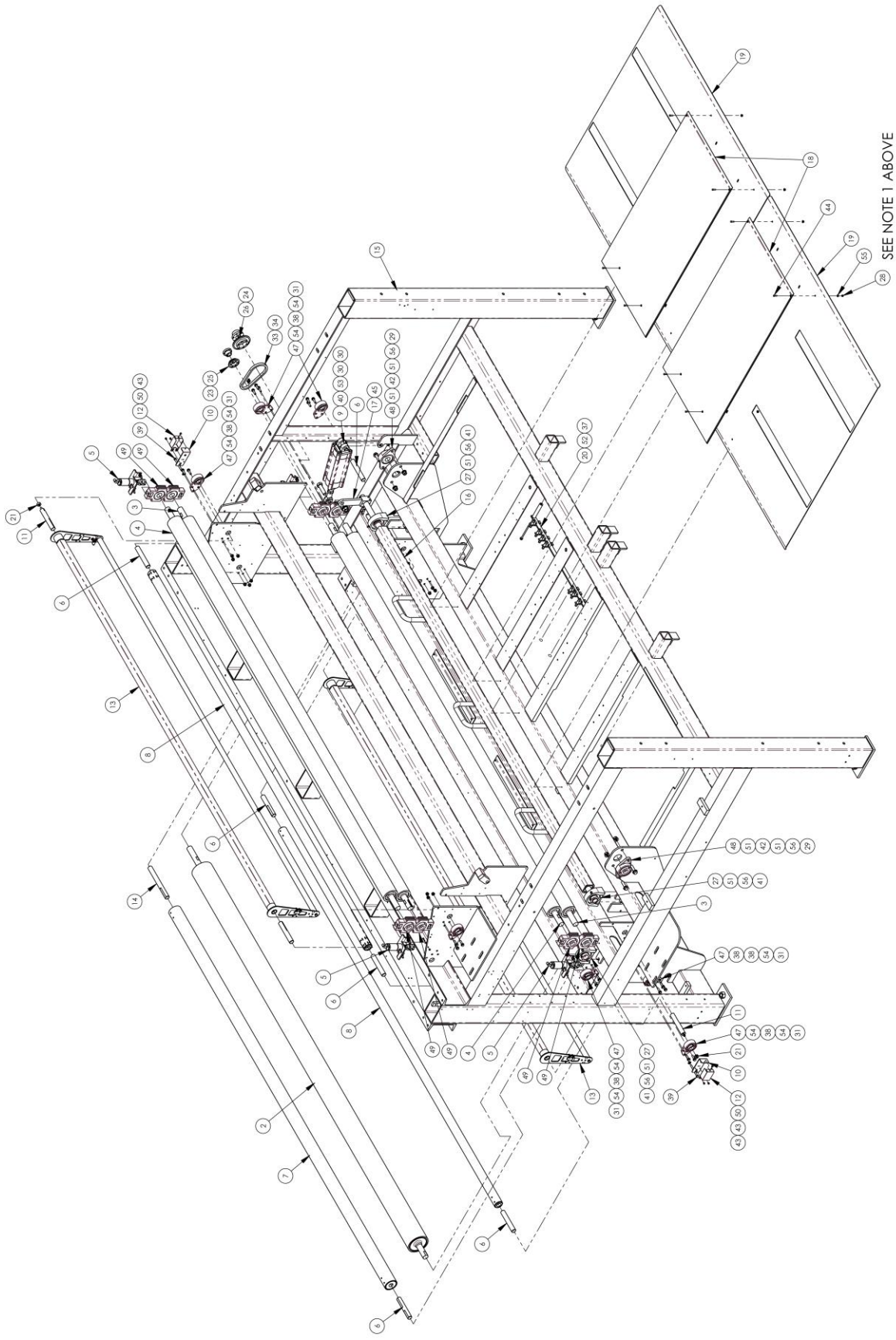
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1391105	PLATE, MOUNTING	11	4	NNK10-32	KEP NUT, 10-32
2	1	1391116	MAIN REGULATOR	12	4	NNK8-32	KEP NUT, 8-32
3	1	1391146	VALVE STACK ASSY	13	2	SSH01048	1/4-20 X 3/4 HEX CAP
4	2	AAMSR2000	REG,0-140 W/GAUGE&	14	4	SSSC90096	#8-32 X 1-1/2 SOC CAP SC
5	2	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT	15	4	SSSC95040	10-24 X1, SOC CAP
6	2	AAQME-5-4	ELBOW, MALE	16	4	WWF8	WASHER, FLAT, #8
7	6	AAQUT-4-4	QUICK UNION T 1/4X1/4	17	4	WWFS1/4	WASHER,FLAT,SAE,1/4
8	1	AAQUY-5-4	Y UNION, 5/32X1/4	18	8	WWFS10	WASHER, FLAT, #10, SAE
9	8	EEPBMH25	MOUNT,CABLE TIE,NYLON	19	4	WWL10	WASHER,LOCK,#10
10	2	NNK1/4-20	KEP NUT, 1/4-20				



1391145 Cross Seal Cylinder Assembly

AAC Drawing Number 1391145 Rev 1

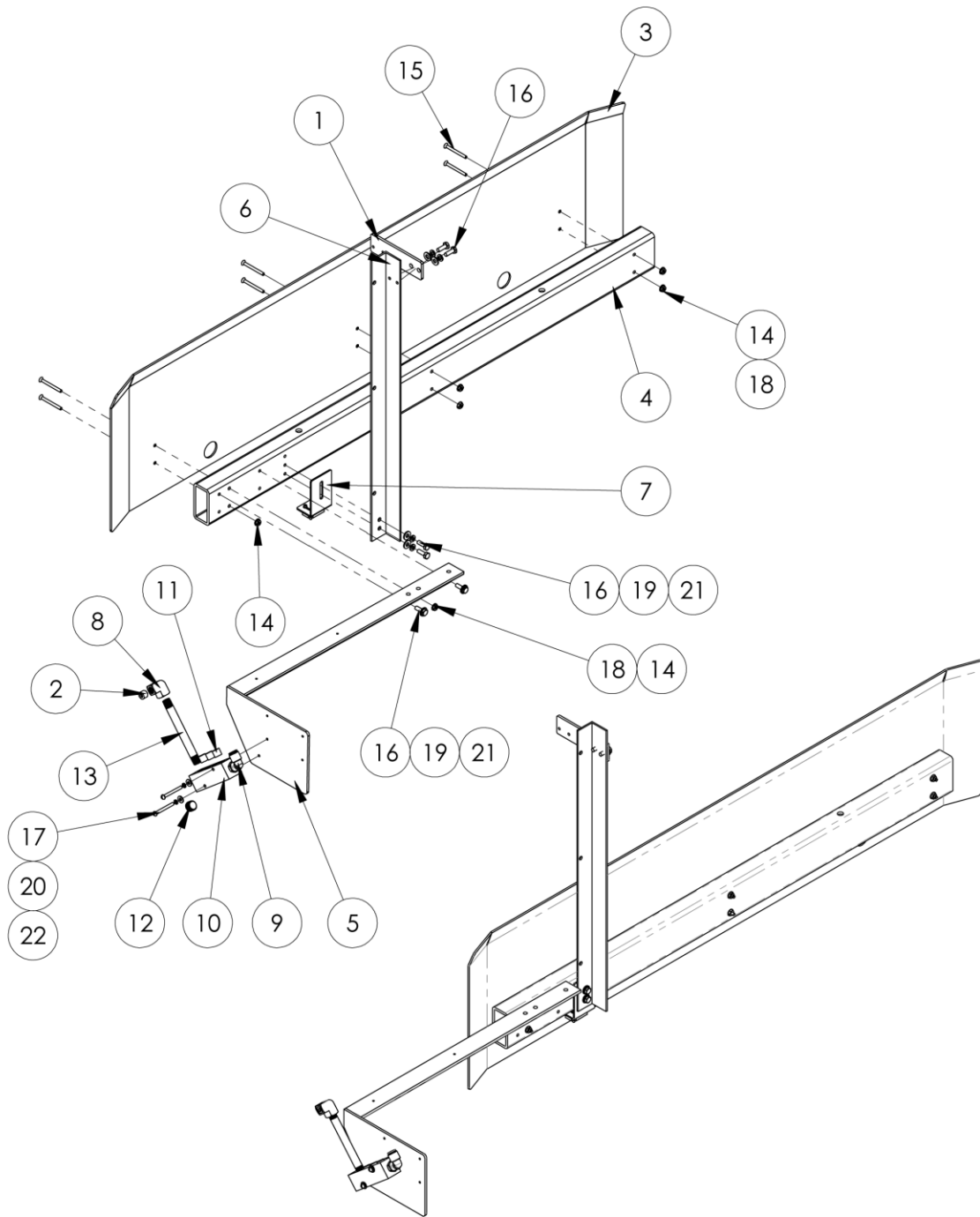
NO.	QTY	PART #	DESCRIPTION
1	1	1391072	CYLINDER MOUNT PLATE-END
2	1	1391073	CROSS SEAL CYL. MNT
3	1	1391075	SPACER, MOUNTING PLT,- DNC
4	1	AACDNCB100610PP	CYLINDER, AIR, ISO, 100BX610S
5	1	AAFNC100	FLANGE, MOUNTING PLT,- DNCB100610
6	1	AAFSGM20X15	CLEVIS, ROD, M20 X 1.5
7	2	AAQME-2-2U	FITTING, 1/2T-1/2 UNIFIT
8	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
9	1	AAV78862121	VALVE, BLOCKING, R1/2
10	4	NNH1/2-13	NUT, HEX, 1/2-13
11	4	SSH45176	1/2-13X2-3/4 HEX CAP
12	8	WWFS1/2	WASHER, FLAT, SAE, 1/2
13	4	WWL1/2	1/2 LOCK WASHER



1391453 Input Conveyor Assembly #1

AAC Drawing Number 1391453 Rev 3

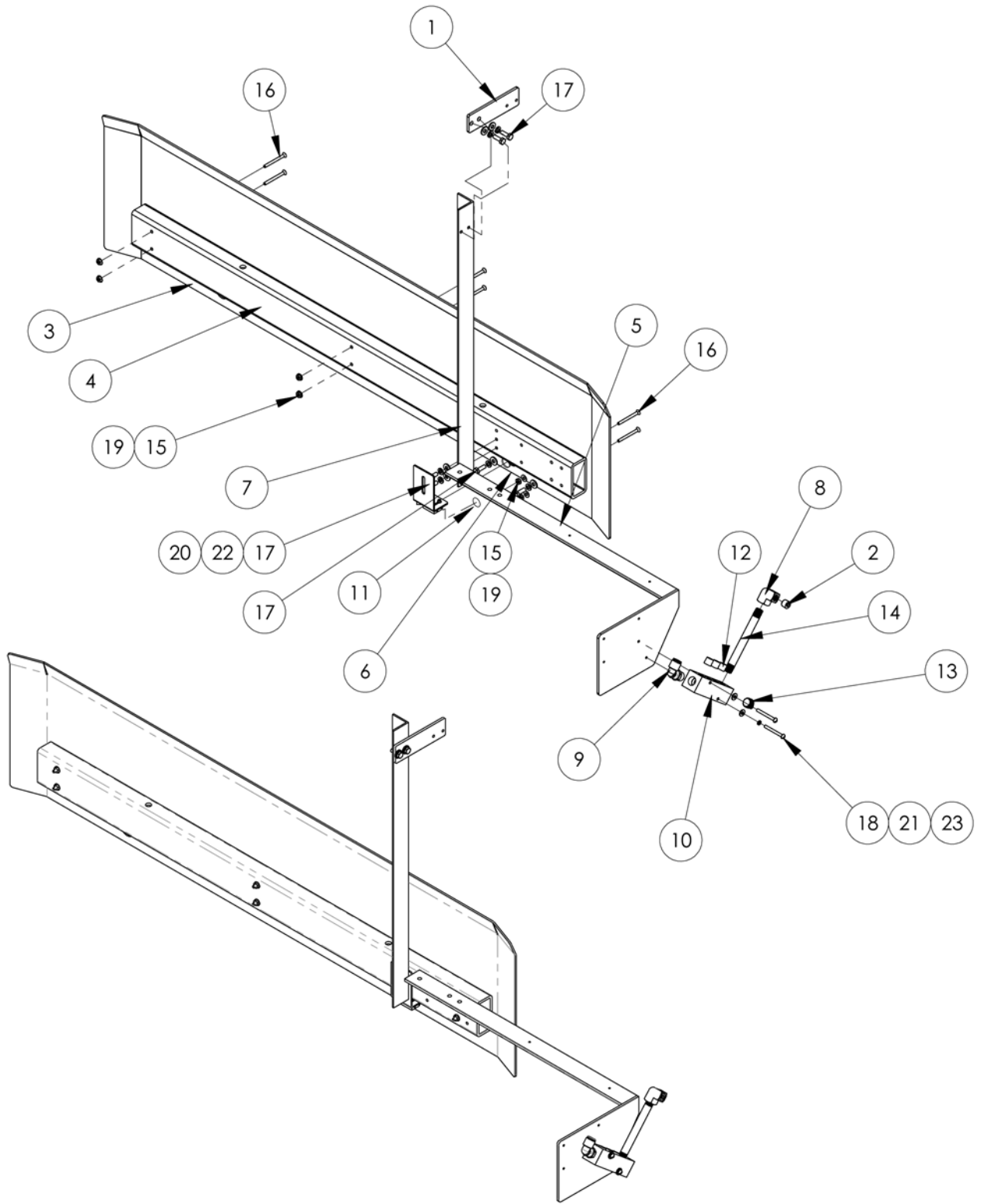
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	2	1390178	BELT SPACER-IN-FEED	31	30	NNK5/16-18	KEP NUT, 5/16-18
2	1	1390224	ROLLER, DRIVE ASSY	32	2	NNK8-32	NUT,KEP,8-32
3	2	1390360	ROLLER ASSY,4-1/4",DRIVE	33	1	PPP40	CHAIN,#40 RIVET
4	2	1390365	ROLLER ASSY,4-1/4",IDLER	34	1	PPP40CL	LINK,CONNECTING,#40
5	4	1390378	PINCH ROLLER AIR CLAMP	35	2	RRE9654K93	SPRING,EXT,.035X.28X6.0
6	7	1390491	SHAFT, STUD	36	4	SSFC98048	#10-32 X .75 SHCSF
7	1	1390698	ROLLER, IDLER, FILM	37	2	SSHC01320	SCREW,HEX CAP
8	2	1390699	WELDMENT, IDLER ROLLER	38	28	SSHC10080	5/16-18 X 1-1/4 HHCS
9	1	1391077	GATE PIVOT CYLINDER ASSY	39	2	SSHC10224F	5/16-18 X 3.5 HEX CAP
10	2	1391132	BRACKET, POT MNT.	40	1	SSHC34176	3/4-10 X 2-3/4 HEX CAP
11	2	1391133	SHAFT, DANCER BAR	41	8	SSHC45080	1/2-13X1-1/4 HEX CAP
12	2	1391147	COVER-POT, DANCER ARM	42	4	SSHC45128	1/2-13 X 2,HEX CAP
13	2	1391151	BAR,DANCER ASBLY	43	6	SSPP90024	8-32X3/8 PAN PHLPS
14	1	1391432	SHAFT, STUD, LONG	44	8	SSPS98048	#10-32X3/4 PAN HD SLTD
15	1	1391442	FRAME WELDMENT, INPUT	45	2	SSSC10080	5/16-18 X 1-1/4 SOC CAP
16	1	1391454	BAR, STOP.ASSM	46	2	SSSC90048	#8-32 X 3/4 SOC CAP SC
17	1	1391458	LEVER, STOP DRIVE	47	10	UUCFB205-16	BEARING, FLANGE, 3 BOLT
18	2	1391460	BELT SLIDE PLATE	48	2	UUCFL207-20	1.25" BEARING, FLANGE
19	2	1391461	PLATE, TOP	49	8	UUCT207-20	PEER207-TAKEUP-BEARING
20	1	1391623	SENSOR ASSM, INFEED	50	6	WWF8	WASHER, FLAT, #8
21	2	CCCL6F	CLAMP COLLAR- 3/8	51	20	WWFS1/2	WASHER,FLAT,1/2, SAE
22	1	K-3607T511	SASH CHAIN	52	2	WWFS1/4	WASHER,FLAT,SAE,1/4
23	1	MM1JA	HUB, TAPERLOCK,1 B	53	1	WWFS3/4	WASHER, .797ID X 1-1/2OD
24	1	MM11/4SH	HUB, TAPERLOCK	54	60	WWFS5/16	WASHER,FLAT,SAE,5/16
25	1	MM40JA15H	SPROCKET, 1/2 P, 15T	55	8	WWFS10	WASHER, FLAT, #10, SAE
26	1	MM40SH25H	SPROCKET, 1/2 P, 25T	56	8	WWL1/2	1/2 LOCK WASHER
27	4	MMUCPA207-20	1.25" BEARING	57	2	WWL1/4	WASHER,LOCK, 1/4
28	8	NNE10-32	NUT,ELASTIC LOCK	58	1	WWL3/4	3/4 LOCK WASHER
29	4	NNH1/2-13	NUT,HEX,1/2-13	59	6	WWL8	WASHER,LOCK,#8
30	1	NNH3/4-10	NUT,HEX,3/4-10	60	1	ZZZSH-310	TAPE, DOUBLE SIDED



1391480 Pusher Assembly, Left

AAC Drawing Number 1391480 Rev 1

NO	QTY	PART #	DESCRIPTION
1	1	1390194	BRACKET, SENSOR
2	1	1390350	PLUG, 1/4" PIPE, MOD
3	1	1391482	PLATE, PUSHER ASBLY
4	1	1391483	MOUNT, GUIDE TUBE
5	1	1391485	BRACKET, MANFOLD, LT
6	1	1391610	CABLE SUPPORT BRACKET
7	1	1406933	EYE/BKT ASSY, BLACK BORDERS
8	1	AAF1/4-BFF	90 DEG ELBOW, 1/4" NPT
9	1	AAQME-3-3S	FITTING, ELBOW, 3/8NPT, 3/8
10	1	AAVM4A	MANIFOLD, 3/8 X 1/4 (2) IN, (4) OUT
11	3	MM4554K12	PLUG, 1/4" PIPE
12	1	MM4638K513	PLUG, 3/8", HEX SOCKET
13	1	MM4830K137	NIPPLE, 1/4NPT X 5.0L
14	6	NNK10-32	KEP NUT, 10-32
15	6	SSFC98128	# 10-32 X 2 FLAT CAP
16	6	SSHCO1048	1/4-20 X 3/4 HEX CAP
17	2	SSRS98112	SCREW, RND HD SLOTTED
18	6	WWF10	WASHER, FLAT, # 10, COM
19	6	WWFS1/4	WASHER, FLAT, SAE, 1/4
20	2	WWFS10	WASHER, FLAT, # 10, SAE
21	6	WWL1/4	WASHER, LOCK, 1/4
22	2	WWL10	WASHER, LOCK, # 10

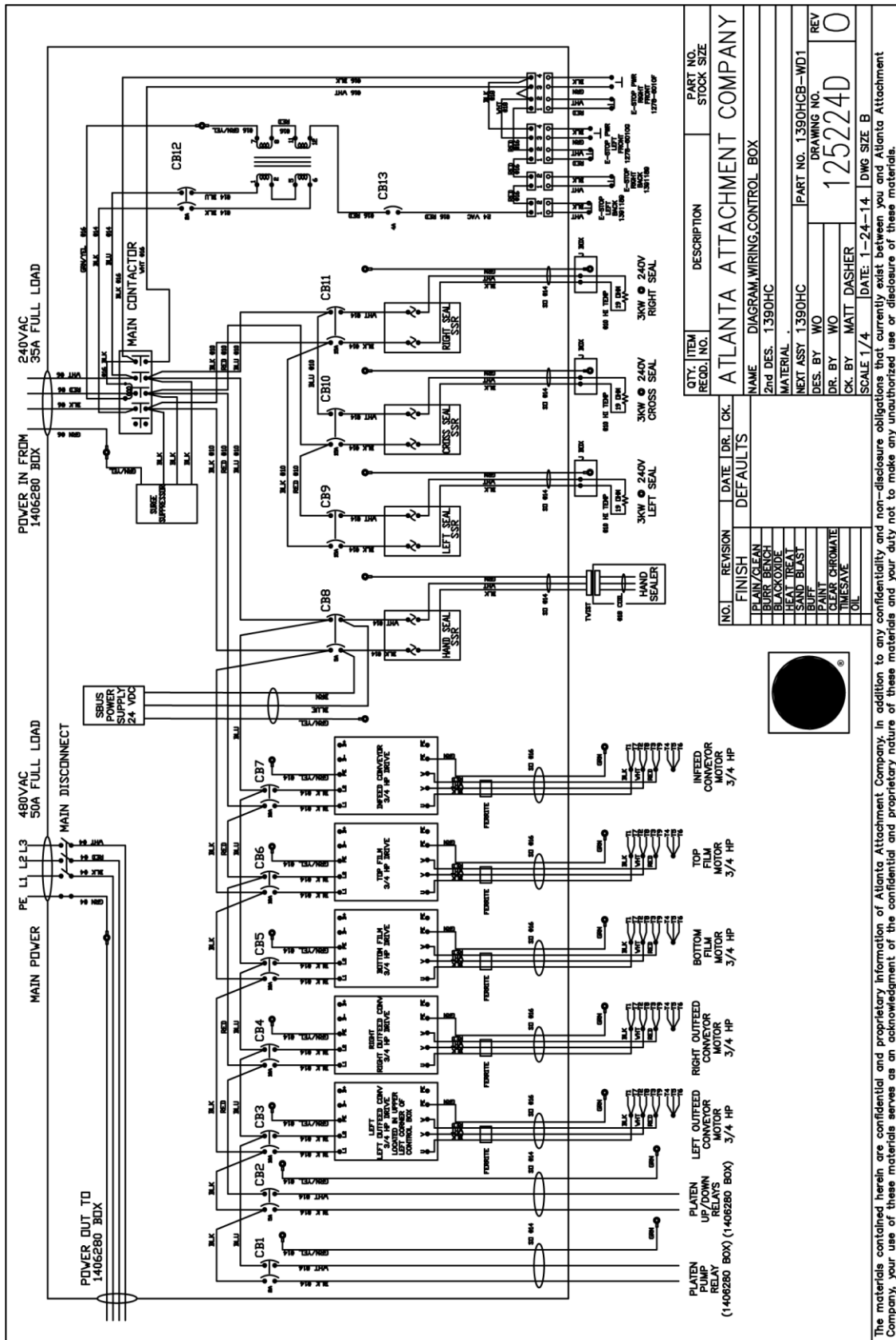


1391488 Pusher Assembly, Right

AAC Drawing Number 1391488 Rev 1

NO	QTY	PART #	DESCRIPTION
1	1	1390194	BRACKET, SENSOR
2	1	1390350	PLUG,1/4" PIPE, MOD
3	1	1391482	PLATE, PUSHER ASBLY
4	1	1391483	MOUNT, GUIDE TUBE
5	1	1391487	BRACKET, MANFOLD,RT
6	1	1391601	BRACKET, PUSHER EYE MOUNT
7	1	1391610	CABLE SUPPORT BRACKET
8	1	AAF1/4-BFF	90 DEG ELBOW, 1/4" NPT
9	1	AAQME-3-3S	FITTING,ELBOW,3/8NPT,3/8
10	1	AAVM4A	MANIFOLD, 3/8 X 1/4(2) IN, (4) OUT
11	1	FFT18FF25Q	EYE,FIXED FIELD, 1IN
12	3	MM4554K12	PLUG, 1/4" PIPE
13	1	MM4638K513	PLUG,3/8",HEX SOCKET
14	1	MM4830K137	NIPPLE,1/4NPT X 5.0L
15	6	NNK10-32	KEP NUT, 10-32
16	6	SSFC98128	#10-32 X 2 FLAT CAP
17	6	SSHCO1048	1/4-20 X 3/4 HEX CAP
18	2	SSRS98112	SCREW,RND HD SLOTTED
19	6	WWF10	WASHER, FLAT, #10, COM
20	6	WWFS1/4	WASHER,FLAT,SAE,1/4
21	2	WWFS10	WASHER, FLAT, #10, SAE
22	6	WWL1/4	WASHER,LOCK, 1/4
23	2	WWL10	WASHER,LOCK,#10
24	1	1406933	EYE/BKT ASSY, BLACK BORDERS

1390HCB-WD1 Wiring Diagram, Control Box



QTY.	ITEM RECD.	DESCRIPTION	PART NO.	STOCK SIZE
		ATLANTA ATTACHMENT COMPANY		
		NAME: DIAGRAM WIRING CONTROL BOX		
		2nd DES. 1390HC		
		MATERIAL: NEXT ASSY 1390HC		
		DES. BY: WO		
		DR. BY: WO		
		CK. BY: MATT DASHER		
		SCALE: 1/4		
		DATE: 1-24-14		
		DWG SIZE: B		
		PART NO. 1390HCB-WD1		
		DRAWING NO. 125224D		
		REV O		

NO.	REVISION	DATE	DR.	CK.
	DEFAULTS			
	FINISH			
	PLAIN/CLEAN			
	BURR/BENCH			
	BLACK OXIDE			
	HEAT TREAT			
	SAND BLAST			
	PAINT			
	CLEAR CHROMATE			
	TIMESAVE			
	OIL			

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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