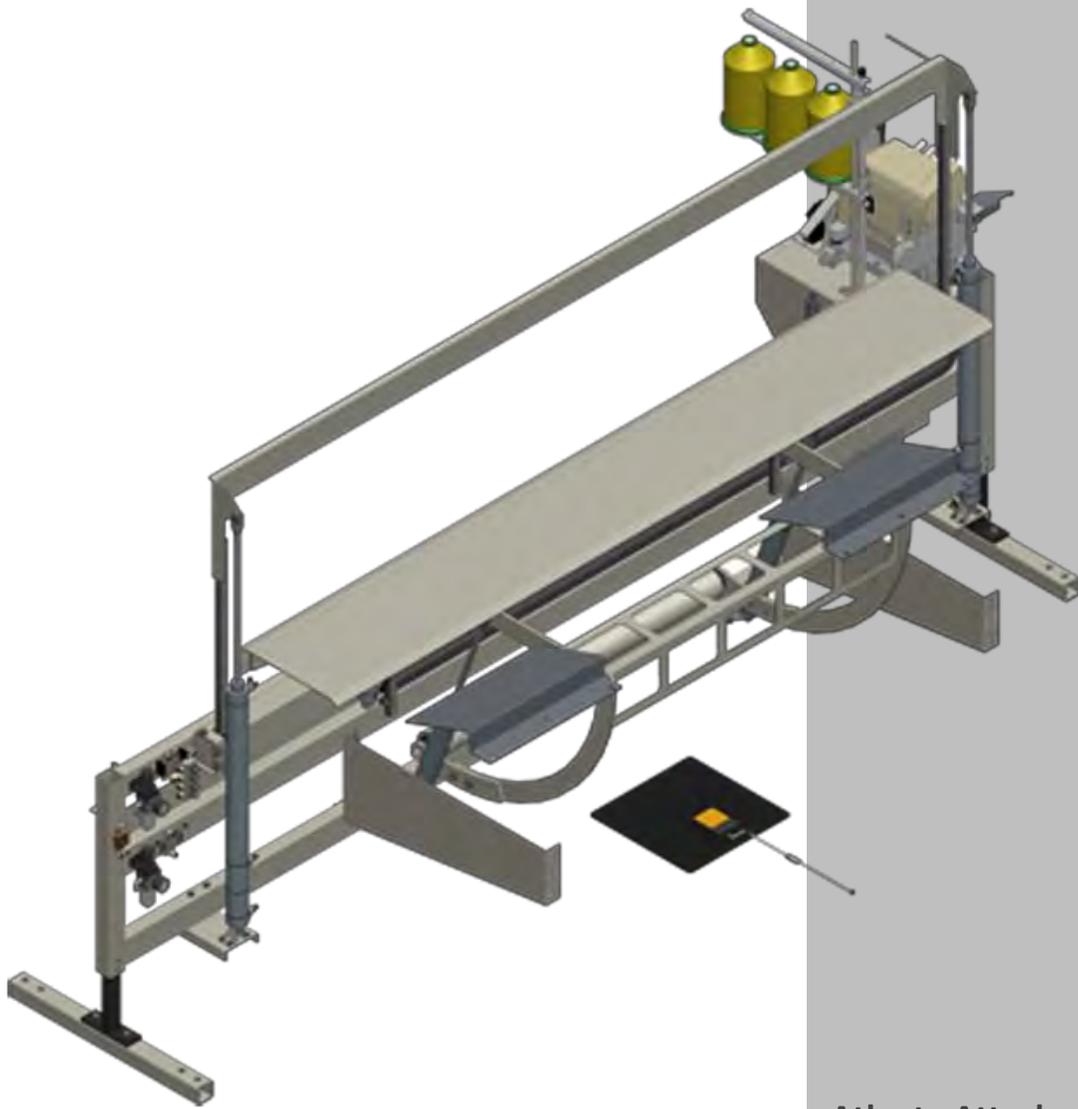




Model **1458250**

Revision 1.7 Updated Aug 5, 2016

# Technical Manual & Parts Lists



**Atlanta Attachment Company**

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# ATLANTA ATTACHMENT COMPANY, INC.

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<b>IMPORTANT</b>
<b>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.</b>

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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 1458250 Sock Closer 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.

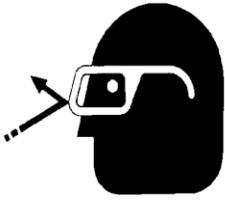
## Signs on the Machine

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.**

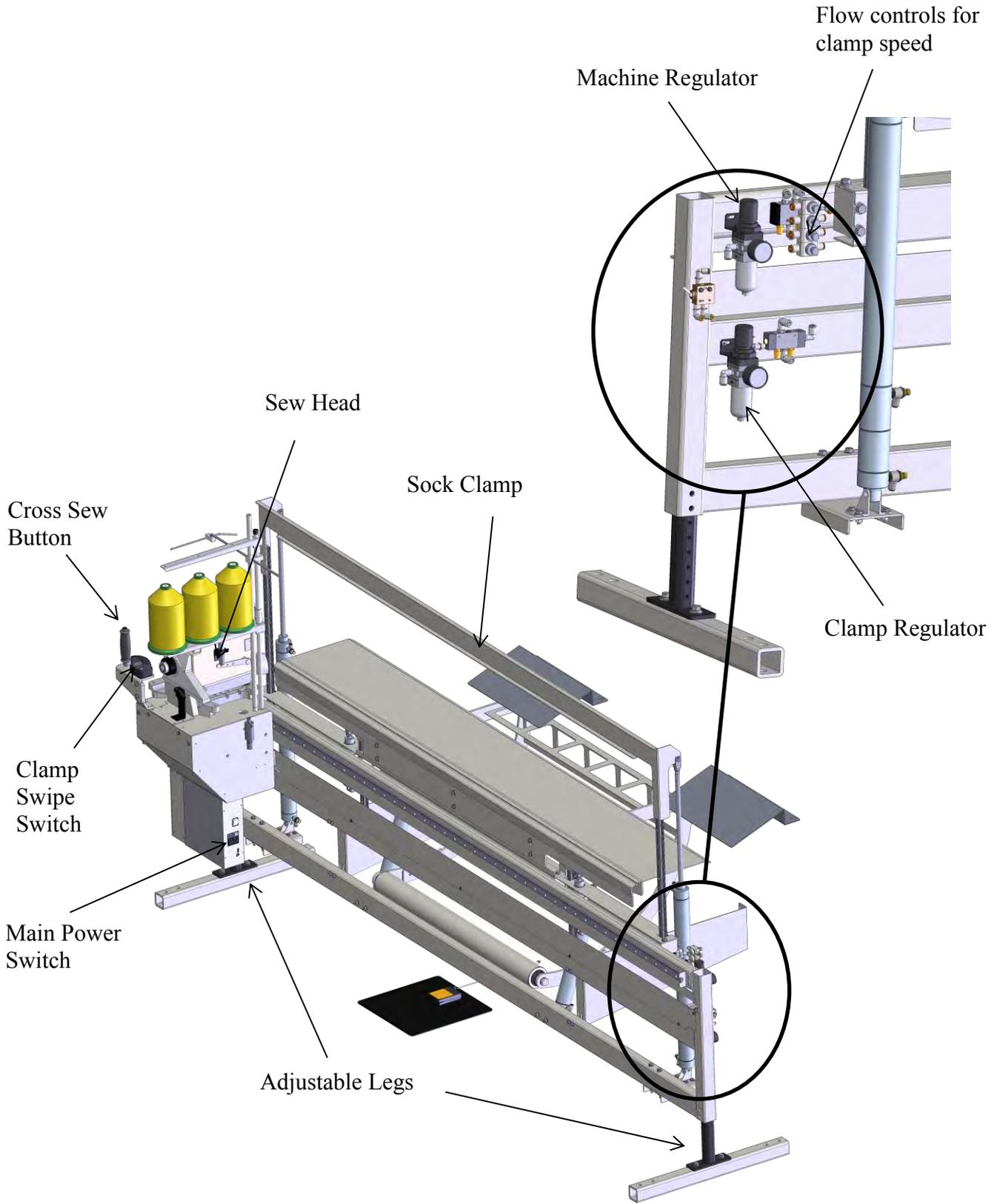
**Operate the equipment only as stated in this manual. Incorrect use could cause damage to the equipment or personal injury.**

**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



## Machine Specifications

Sewing head Pressure:	60 psi. min.
Clamp Pressure:	Adjustable 0-18 psi. clamp @ 80 psi. machine pressure
Max Height:	12"
Max Width:	84"
Voltage Requirements:	220-208VAC single phase rated to 10 amps

## Operation



**NOTE:** *Tables and conveyors shown in pictures are for illustration purposes only and are not included with the 1458250.*



**Warning:** *Do not turn machine off while sewing head is out of home position (far right side) as this will cause the clamps to open and may damage the sew head.*

This machine sews the seam along the bottom edge of the mattress. It should be set up so that the surface of the lower clamp is 2" lower than surface of the mattress support table or conveyor. This allows for a slight drooping of the mattress when conveying through the open clamps.

The purpose of this machine is to close the end of a sock which has been wrapped over a mattress by either a machine or manually. Settings on this machine are preset to the customer's specification before shipping. Adjustments should only be made by trained personnel.

When the machine is ready to load, the support roller and upper clamp are "up" and the lower clamp is "down" The sewing head must be all the way to the right end of the frame or the clamps will not activate. Feed the mattress over the support roller, through the clamp opening, and on to a support table or conveyor behind the clamp.

Align the end of the mattress with the back edge of the top clamp. The Mattress should be on the opposite side of sewing operation. Pull any excess sock through the clamp opening.



Touch the clamp swipe switch, the support roller retracts, the bottom clamp rises to support the end of the mattress and the top clamp closes to a position with a 2" gap between the top clamp and the bottom clamp. Even out the material by pulling all across the clamp. While holding the material taught, step on the foot switch to completely close the clamps.



**Note:** *Clamp pressure is set low enough that once clamps are closed you would be able to still lift the upper clamp by hand. Also, the closing speed of the clamp is set slow to reduce the risk of injury.*



If it is necessary to re-open the clamps to the 2" position, simply touch the wipe switch two times quickly.

To sew the seam: (Clamps must be closed)  
Grasp the sew handle with your right hand, slide the sewing head until the edge of the material is under the presser foot. Press the sew button with your thumb, and gently pull the sewing head along the edge of the clamp. Gently pull the trimmed material away from the trimming knife with your left hand, being careful not to stretch it. Continue to sew along the edge of the material at an even speed.



Make sure the scrap material falls down the shoot and moves out of the way to get a consistent sew. The sew head has only one speed. The speed at which you pull the sew head will determine stitch quality. Use a smooth and even motion while sewing the sock. Too fast and you will run off the sock, too slow and the seam will bunch the material up and possibly break the needle. Make sure to match your pulling speed with the sewing head speed.



Once you have sewn past the end of the sock you will notice a loose chain stitch. Press the sew button while pushing the sew head slightly backwards and it will suck the chain stitch into the trimmer and cut it off.



Return the sew head back to the start position, touch the clamp swipe switch, and the clamps open and the support roller will extend.



Operation complete.



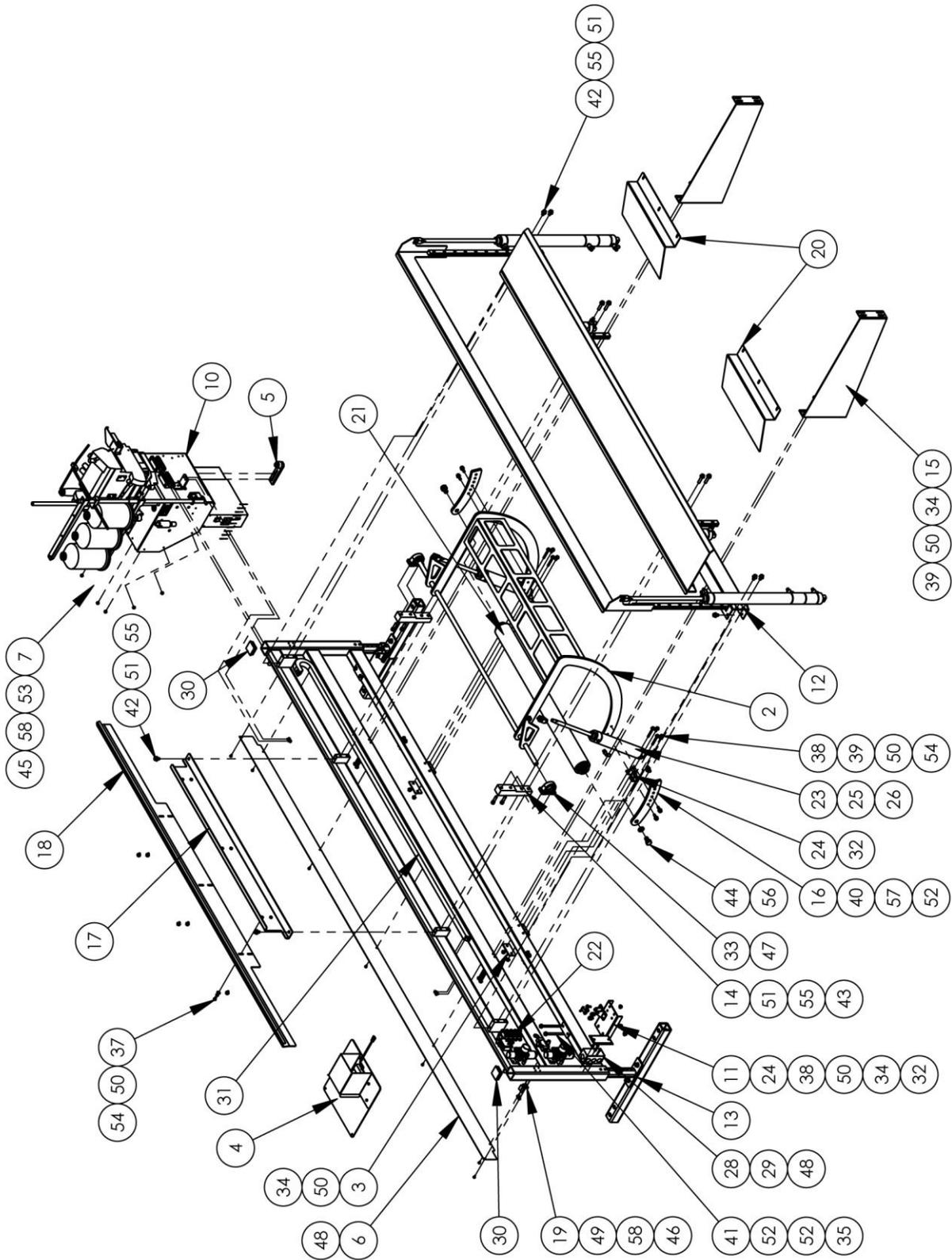


## Assembly Drawings & Parts Lists

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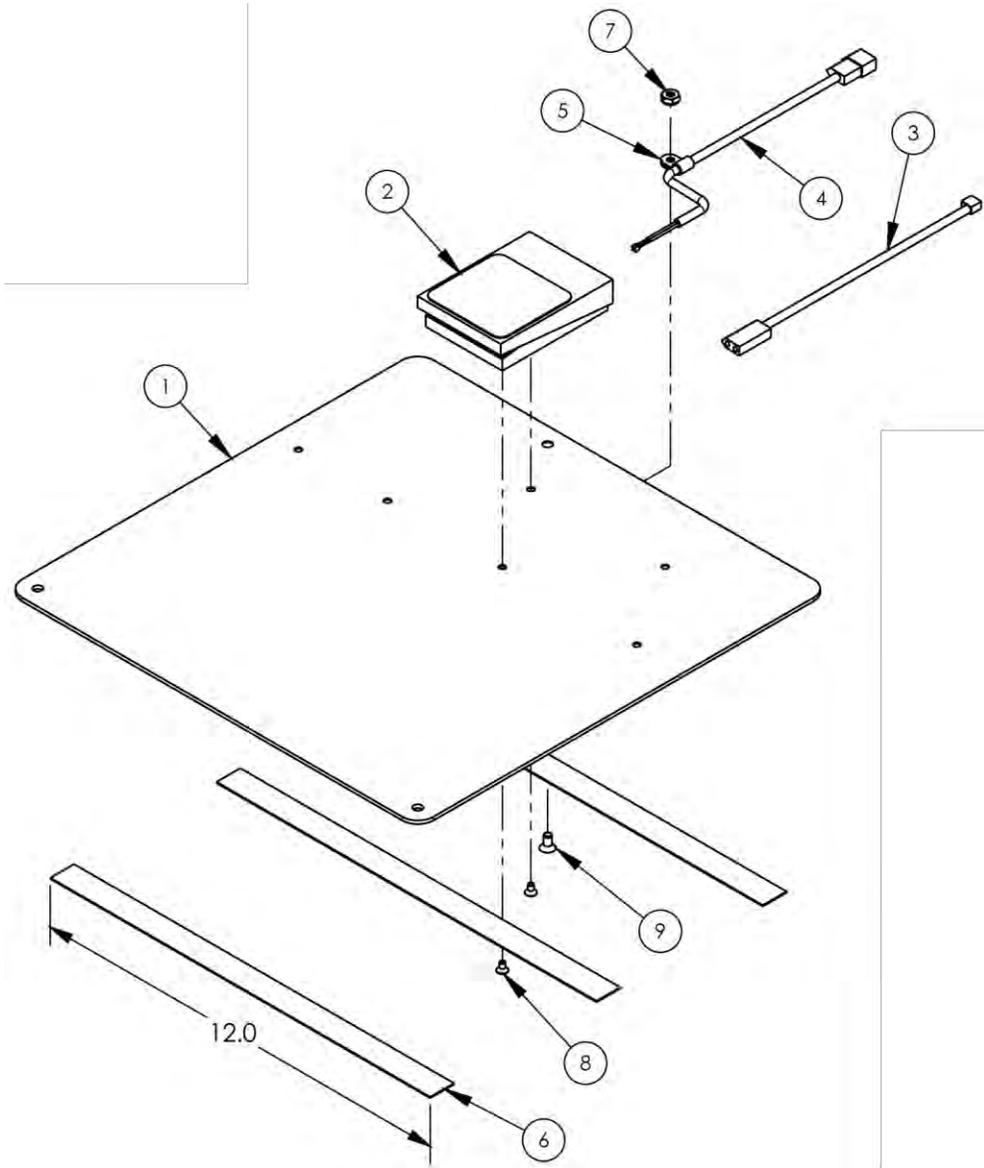
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# 1458250 Sock Closer

AAC Drawing Number 1458250 Rev 7

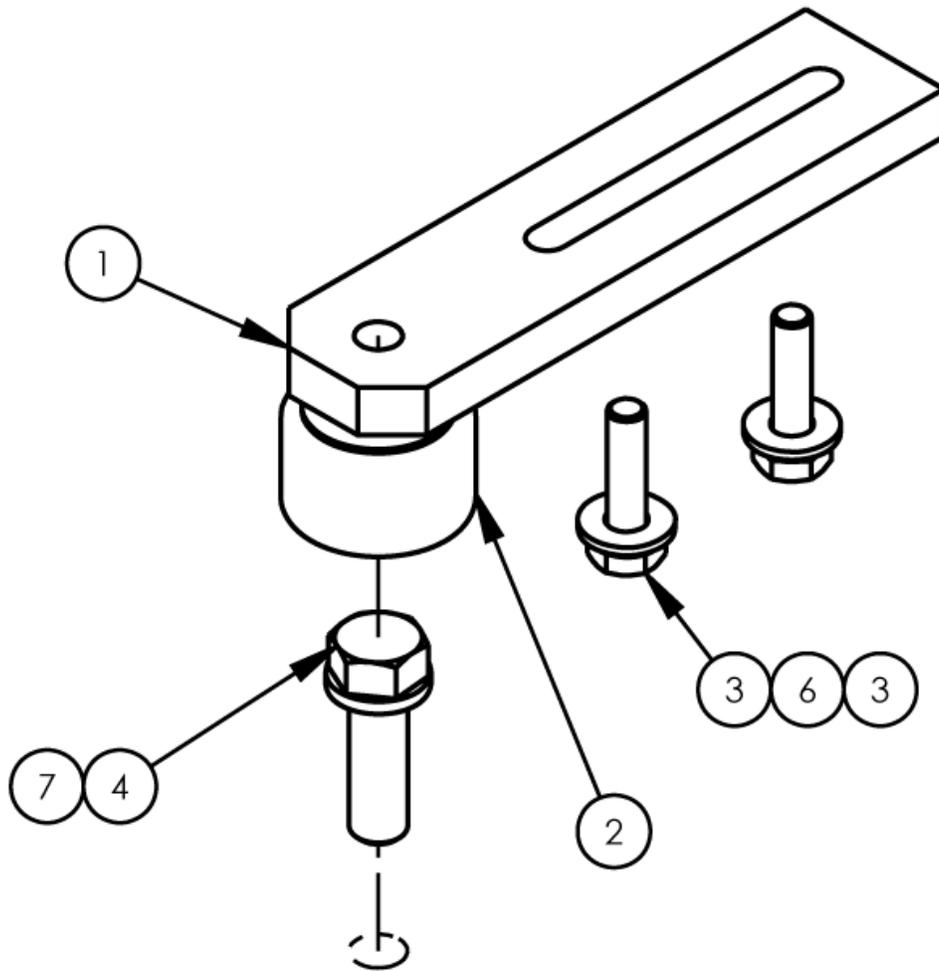
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	211-203P	HI FLEX FOOT SW CABLE	30	2	MM132-2X2A	END CAP, SQUARE, BLACK
2	1	1458110	ROLL HOLDER WELDMENT	31	1	MM55835K933	DUCT,WIRE PLASTITRAK
3	4	1458119	WASHER PLATE	32	4	MM97245A679	CLEVIS PIN W/COTTER PIN
4	1	1458131	FOOT PEDAL ASSY W/GUARD	33	2	MMUCA204-12	BEARING,PILLOW BLOCK,..75B
5	1	1458210	ROLLER,GUIDE SUPPORT,ASSY	34	20	NNK1/4-20	NUT,HEX,KEP,1/4-20,W/LOCK
6	1	1458213	SHIELD,LOWER	35	4	NNK5/16-18	NUT,KEP,5/16-18
7	1	1458223	COVER,SEWING MOUNT,FRONT	36	4	SSBC98032	10-32 X 1/2 BUTTON CAP SC
8	AR	1458250-PD	PNEUMATICS DIAGRAM	37	6	SSHC01032	1/4-20 X 1/2 HHCS
9	AR	1458250-WD	WIRING DIAGRAM	38	12	SSHC01048	1/4-20 X 3/4 HEX CAP
10	1	1458251	SEWING HEAD STAND ASSY	39	12	SSHC01144	HEX HEAD BOLTS
11	2	1458259	CYLINDER BRACKET	40	4	SSHC10064	5/16-18 X 1 HHCS
12	1	1458260	CLOSER CLAMP ASSY	41	4	SSHC10256	5/16-18 X 4.0 HEX CAP
13	1	1458270	BASE,CLOSER, ASSY	42	8	SSHC25048	3/8-16X3/4,HEX CAP
14	2	1458278	PILLOW BLOCK MOUNT	43	4	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
15	2	1458282	SUPPORT,CLOSER FRAME	44	2	SSHC41064	5/8-11 X 1 HEX CAP SCREW
16	2	1458284	ROLLER SUPPORT EXT.	45	8	SSHC98024	10-32 X 3/8 HEX CAP
17	1	1458285	BRACKET, CLAMP GUARD	46	2	SSHC98032	10-32X1/2 HEX HD
18	1	1458286	CLAMP GUARD	47	4	SSSC25088	3/8-16X1-3/8 SOC CAP
19	1	1458304	STOP,LIMIT SWITCH	48	11	SSZH#10032	SCREW,SHT.METAL HEX 10
20	2	1458305	GUIDE,MATTRESS,FLIP TABLE	49	6	WWF10	WASHER, FLAT, #10, COM
21	1	1490031	ROLLER ASSEMBLY, W/BEARINGS	50	50	WWFS1/4	WASHER,FLAT,SAE,1/4
22	4	AA3000F-07	FLOW CONTROL,INLINE,1/4"	51	12	WWFS3/8	WASHER,FLAT,SAE,3/8
23	2	AACM3110DXP	CYLINDER,AIR,DA W/MAGNET	52	12	WWFS5/16	WASHER,FLAT,SAE,5/16
24	4	AAFD229	PIVOT BRAK	53	8	WWFS10	WASHER, FLAT, #10, SAE
25	2	AAFD2313	CLEVIS, AIR CYLINDER	54	14	WWL1/4	WASHER,LOCK, 1/4
26	4	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT	55	12	WWL3/8	WASHER, LOCK, 3/8
27	15'	EE02041603	CABLE,3X16AWG,HI-FLEX	56	2	WWL5/8	5/8 LOCK WASHER
28	1	K-230	BOX,METAL, 2X4X2	57	4	WWL5/16	WASHER, LOCK, 5/16
29	1	K-231	COVER, 2X4	58	14	WWL10	WASHER,LOCK,#10



## 1335M-116 Foot Pedal Assembly

AAC Drawing Number 9003047 Rev 2

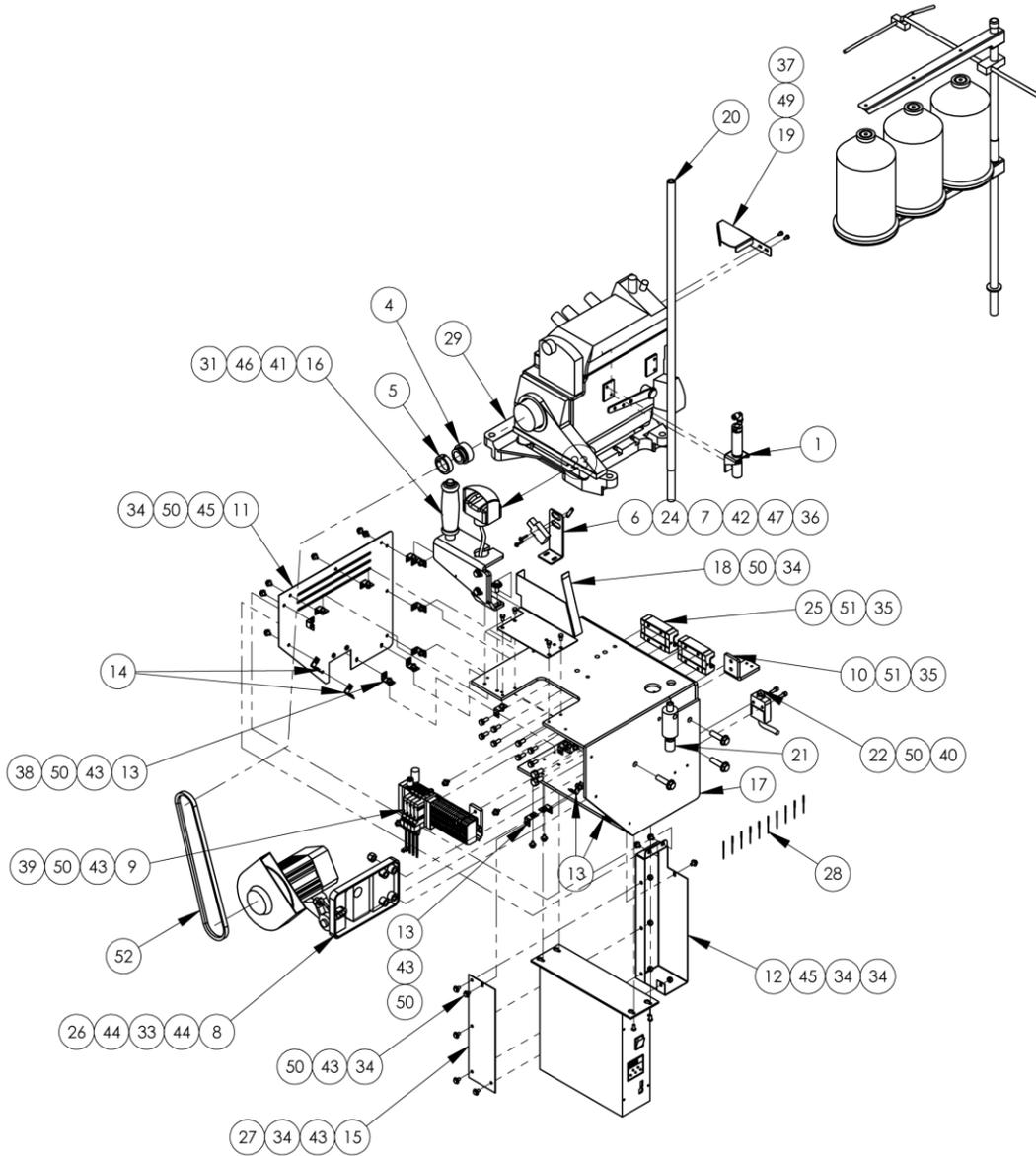
NO.	QTY	PART #	DESCRIPTION
1	1	1278-5281	PLATE, FOOT PEDAL
2	1	1278-6161	FOOT SWITCH MODIFICATION
3	1	211-203B	CABLE,3P SBus - 2P MOLEX
4	1	211-203N	CABLE,2P FAST-2P MOLEX
5	1	AAF3/16	CLAMP, BLACK PLASTIC
6	3 FT	MM6970T64	3/4" WIDE ABRASIVE
7	1	NNK10-32	KEP NUT, 10-32
8	2	SSFC80016	SCR,FLAT HD,CAP,6-32 X 1/4
9	1	SSFC98024	#10-32 X .375 FLAT CAP



## 1458210 Guide Support Roller Assembly

AAC Drawing Number 1458210 Rev 0

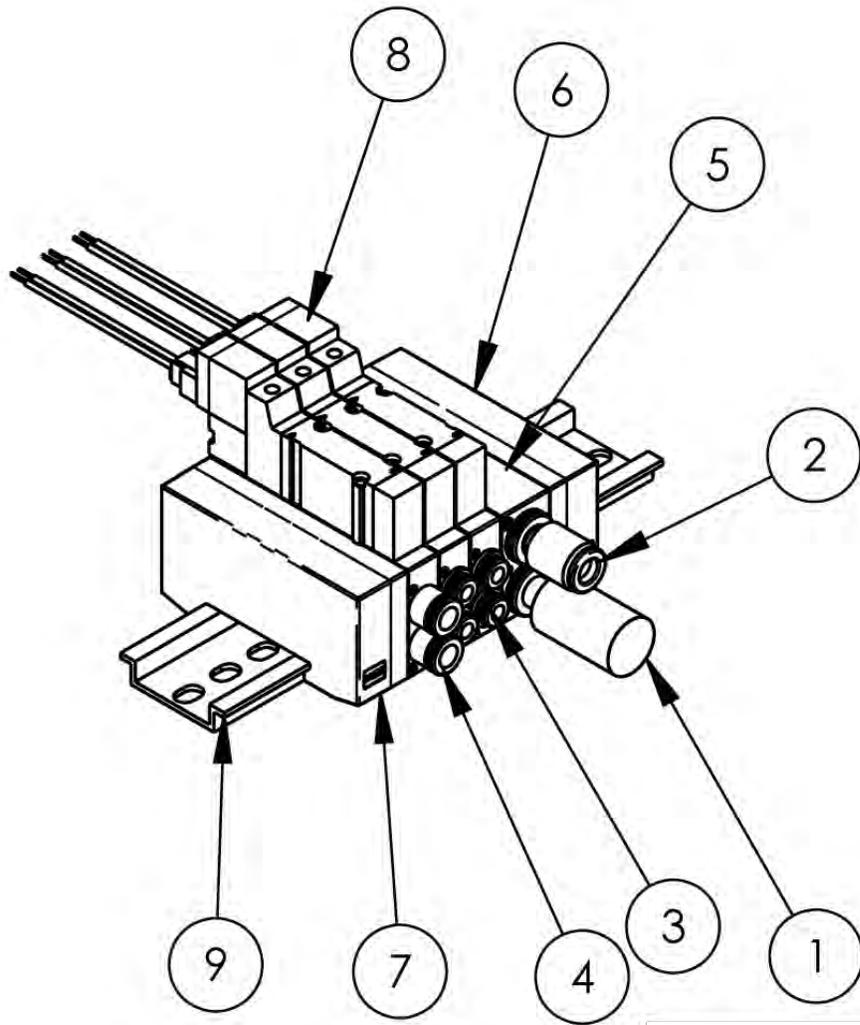
NO.	QTY	PART #	DESCRIPTION
1	1	13453313	MOUNT, CARRIAGE GUIDE, LO
2	1	MMCYR114S	FOLLOWER, CAM
3	2	SSHCO1064	1/4-20 X 1 HHCS
4	1	SSHCO25080	3/8-16 X 1-1/4 HEX CAP
5	2	WWFS1/4	WASHER, FLAT, SAE, 1/4
6	2	WWL1/4	WASHER, LOCK, 1/4
7	1	WWL3/8	WASHER, LOCK, 3/8



# 1458251 Sewing Head Stand Assembly

AAC Drawing Number 1458251 Rev 3

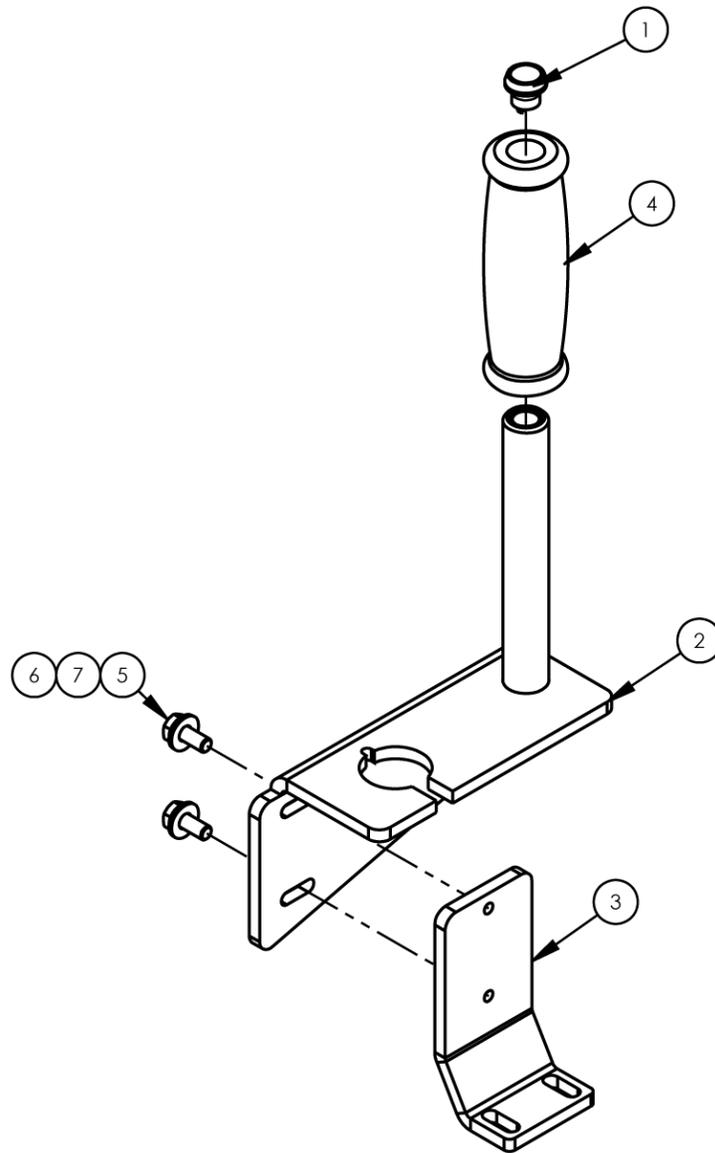
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	112G24	FOOTLIFT,PNEUMATIC	27	4	NNE10-32	NUT,ELASTIC LOCK
2	1	0211-701H	CABLE,I/O,EFGA	28	10	SNB27100/16GB	NEEDLE,B27X100
3	1	0211-702C	CABLE,POS.SENSOR,3',EFGA	29	1	SPEGEXT5104KS	SEW HEAD,CYL ARM, TOP FEED
4	1	311-128	HUB, HANDWHEEL, TAPE MOUN	30	4	SSBC98024	10-32 X 3/8 BUTTON CAP SC
5	1	311-129	SLEEVE TAPE MOUNT ADJUST	31	2	SSHC01048GR8	1/4-20 X 3/4 HEX CAP
6	1	1278-6689B	BRACKET, EYE MOUNT	32	2	SSHC10048	5/16-18 X 3/4 HHCS
7	1	1975-412A	PLATE,NUT,4-40,.95CTC	33	3	SSHC25096	3/8-16 X 1 1/2 HHCS
8	1	4059-DC1500	MOTOR,DC WITH CONTROLLER	34	25	SSHC98024	10-32 X 3/8 HEX CAP
9	1	1458146	SOLENOID, DIN RAIL ASSY	35	8	SSHCM6X16	SCREW, HEX M6X16
10	1	1458211	MOUNT, PLASTITRAK	36	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
11	1	1458222	GUARD,SIDE,PANEL	37	2	SSPSM4X8	M4-0.70X8
12	1	1458224	GUARD,EFGA, WIRE,BOX	38	15	SSSC98024	10-32 X 3/8 SOC CAP
13	15	1458225	CLIP, GUARD HARD MOUNT	39	2	SSSC98032	10-32X1/2, SOC CAP
14	3	1458226	CLIP, GUARD PANEL ASSY	40	2	SSSC98040	10-32 X 5/8 SOC CAP
15	1	1458227	GUARD,WIRE,PANEL	41	2	WWF1/4	WASHER, FLAT, 1/4", COM
16	1	1458230	HANDLE,SEW CONTROL	42	2	WWF4	WASHER, FLAT, #4
17	1	1458252	MOUNT,SEWING HEAD	43	25	WWF10	WASHER, FLAT, #10, COM
18	1	1458254	GUARD,BELT,UPPER	44	4	WWFS3/8	WASHER,FLAT,SAE,3/8
19	1	1458255	CLOTH PLATE EXTENSION	45	13	WWFS10	WASHER, FLAT, #10, SAE
20	1	4300056	POLE, THREAD STAND	46	2	WWL1/4	WASHER,LOCK, 1/4
21	1	AAVTBV200	CHAIN VACUUM WASTE UNIT	47	2	WWL4	WASHER,LOCK,#4
22	1	EE2W815	LIMIT SWITCH,MINIATURE	48	2	WWL5/16	WASHER,LOCK, 5/16
23	1	FFOTBVN6	SWITCH,OPTO-TOUCH	49	2	WWL8	WASHER,LOCK,#8
24	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	50	40	WWL10	WASHER,LOCK,#10
25	2	MMAGH25CAN	LINEAR BEARING	51	8	WWLM6	WASHER,LOCK,M6
26	3	NNE3/8-16	NUT, ELASTIC 3/8-16	52	1	ZX3829	V-BELT,3/8 X 27"



## AAE3200-3 Solenoid Assembly

AAC Drawing Number 9000088 Rev 1

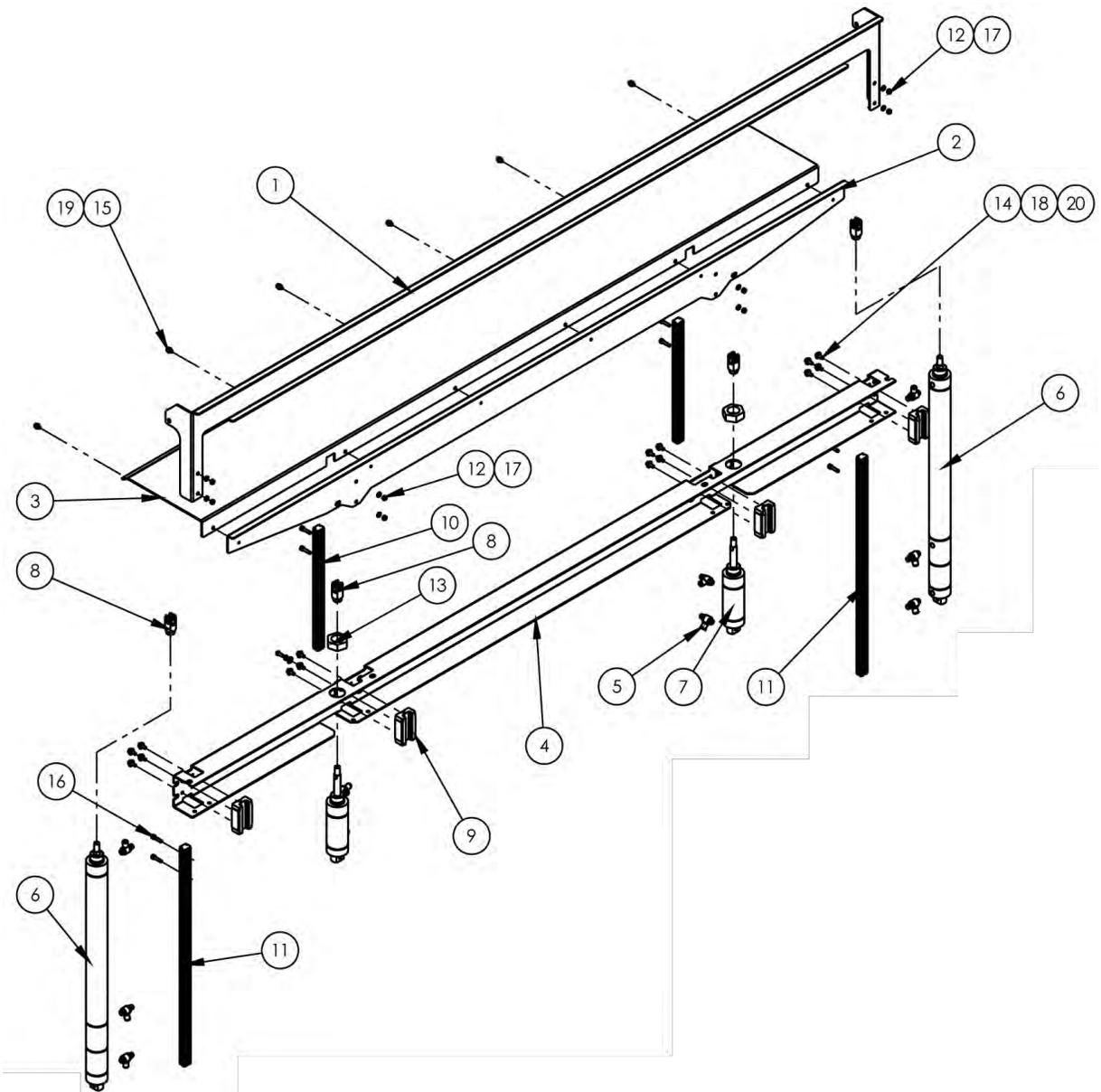
NO.	QTY	PART #	DESCRIPTION
1	1	AN203-KM8	SILENCER,EXH PORT
2	1	KQ2R07-09	FITTING,REDUCING
3	2	SX3000-50-1A-N3	BLOCK ASSY,5/32
4	1	SX3000-50-1A-N7	BLOCK ASSY,1/4
5	1	SX3000-51-15A	SUP/EXH BLOCK
6	1	SX3000-52-1A	END CAP,LEFT
7	1	SX3000-53-1A	END CAP,RIGHT
8	3	SY3140-5LZ	SOLENOID VALVE
9	1	VZ1000-11-1-9	DIN RAIL



## 1458230 Sew Control Handle

AAC Drawing Number 1458230 Rev 0

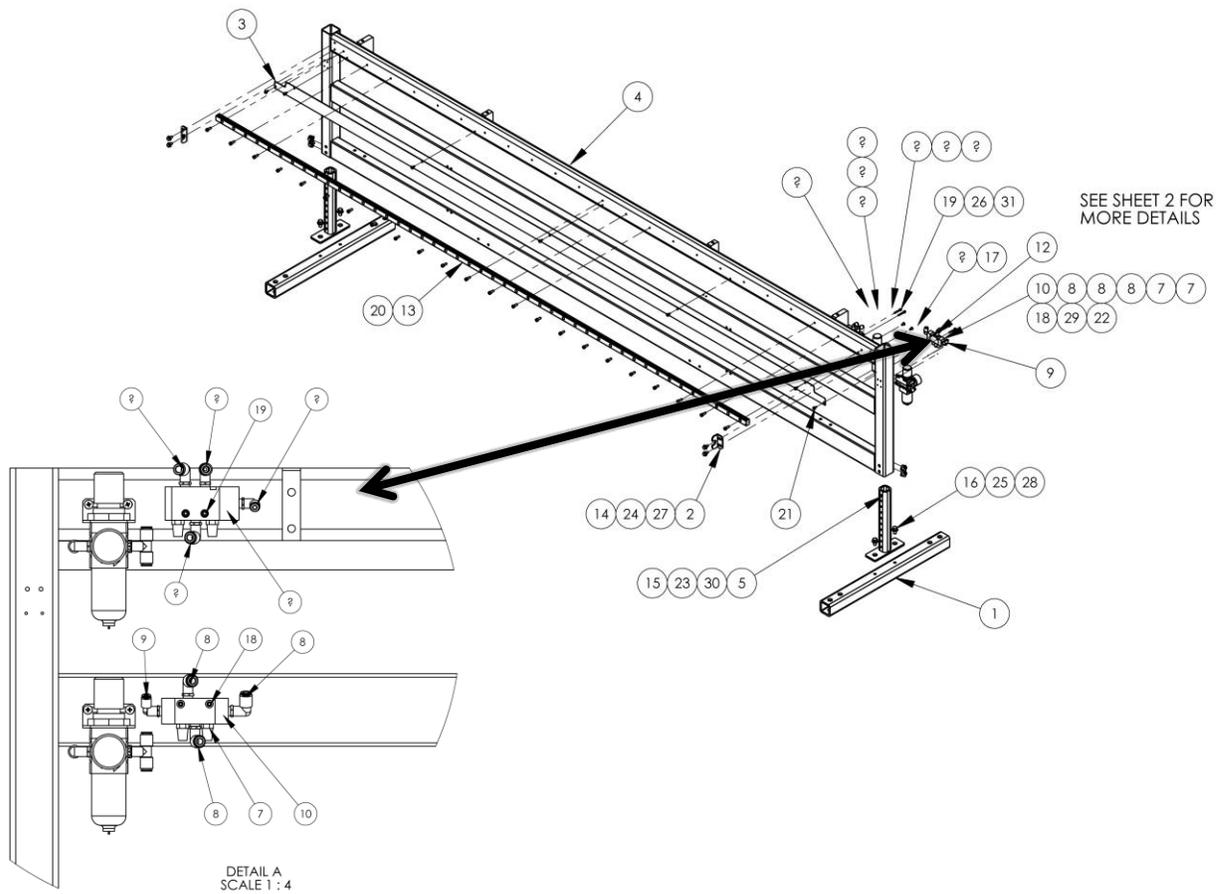
NO.	QTY	PART #	DESCRIPTION
1	1	0211-705U	CABLE, TREADLE H.S ASSY
2	1	1458232	HANDLE BRKT
3	1	4600227	BRKT, HEAD ENGAGE
4	1	MMGP-105	GRIP HANDLE-FOAM 3/4 ID
5	2	SSH01040	1/4-20 X 5/8 HHCS
6	2	WWFS1/4	WASHER, FLAT, SAE, 1/4
7	2	WWL1/4	WASHER, LOCK, 1/4



## 1458260 Closer Clamp Assembly

AAC Drawing Number 1458260 Rev 1

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1458256	UPPER CLAMP BAR	11	2	MMAGR25650N	RAIL,MODIFIED
2	1	1458257	LOWER CLAMP BAR	12	8	NNEM6-1.0	NUT, LOCK M6-1.0
3	1	1458258	LOWER CLAMP BAR EXTENSION	13	2	NNJ1-1/4-12	NUT-HEX JAM 1-1/4-12
4	1	1458272	GUIDE RAIL MOUNT	14	16	SSHCM6X16	SCREW, HEX M6X16
5	10	AA198RA404U	FLOW CONTROL,1/4PTX1/4	15	6	SSSC01024	1/4-20 X 3/8 SOC CAP SC
6	2	AAC312-14DXPB	CYLINDER,AIR,2" BORE	16	8	SSSCM6X25	M6X25 SOC CAP SCREW
7	2	AAC312DXP	AIR CYLINDER 2" B X 2" S	17	8	WWFM6	WASHER, FLAT, M6, SAE
8	4	AAFD2313	CLEVIS, AIR CYLINDER	18	16	WWFS1/4	WASHER,FLAT,SAE,1/4
9	4	MMAGH25CAN	LINEAR BEARING	19	6	WWL1/4	WASHER,LOCK,1/4
10	2	MMAGR25360N	RAIL,LINEAR,AG SERIES	20	16	WWLM6	M6 LOCK WASHER

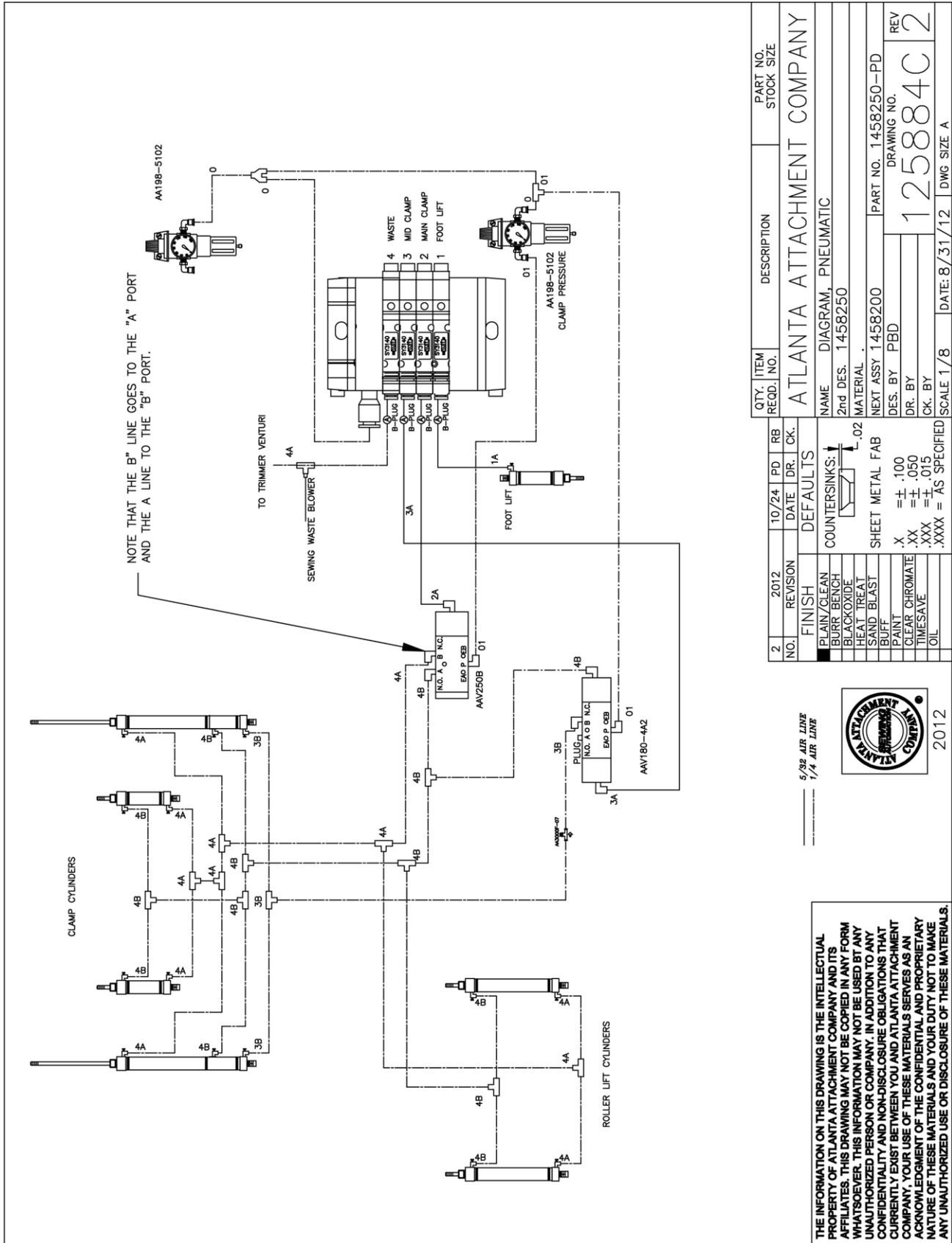


## 1458270 Closer Base Assembly

AAC Drawing Number 1458270 Rev 1

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	2	1458105	SHIPPING BRACKET	17	4	SSPP98024	10-32 X 3/8 PAN HD PHILIP
2	2	1458212	STOP,BEARING	18	2	SSSC70080	4-40 X 1-1/4 SOCKET CAP
3	1	1458235	SHIELD,UPPER	19	2	SSSC80080	6-32 X 1-1/4 SOC CAP SC
4	1	1458271	FRAME,CLOSER	20	23	SSSCM6X16	M6 X 16, SOC CAP
5	2	1458320	WELDMENT, FOOT	21	7	SSZS93032	SCREW, SHT.METAL 10 ZIP
6	2	AA198-5102	REGULATOR W/GAUGE & NUT	22	2	WWF4	WASHER, FLAT, #4
7	4	AAFP18	MUFFLER, 1/8 NPT, BRONZ	23	4	WWF5/16	WASHER,FLAT,5/16
8	6	AAQME-4-8	QUICK MALL ELBOW, 1/4 T	24	5	WWF5/16	WASHER,FLAT,SAE,1/4
9	2	AAQME-5-8	QUICK MALE ELBOW	25	4	WWF3/8	WASHER,FLAT,SAE,3/8
10	1	AAV180-4A2	PILOT VALVE	26	2	WWF6	WASHER, FLAT, #6
11	1	AAV250B	VALVE, PILOT, 1/4" NPT	27	4	WWL1/4	WASHER,LOCK,1/4
12	1	MM4554K11	PLUG, 1/8" PIPE	28	4	WWL3/8	WASHER,LOCK, 3/8
13	1	MMAGR252700N	RAIL,LINEAR, AG 2700MM	29	2	WWL4	WASHER,LOCK,#4
14	4	SSHC01040	1/4-20 X 5/8 HHCS	30	4	WWL5/16	WASHER,LOCK, 5/16
15	4	SSHC10040	5/16-18 X 5/8 HHCS	31	2	WWL6	WASHER,LOCK,#6
16	4	SSHC35048	3/8-24 X .75 HEX CAP				

# 1458250-PD Pneumatic Diagram



QTY.	ITEM RECD.	NO.	DESCRIPTION	PART NO.	STOCK SIZE
2	2012	10/24	PD	RB	
FINISH					
PLAIN/CLEAN					
BURR BENCH					
BLACKOXIDE					
HEAT TREAT					
SAND BLAST					
PAINT					
BUFF					
CLEAR CHROMATE					
TIMESAVE					
OIL					
COUNTERSINKS:					
L.02					
SHEET METAL FAB					
X = ± .100					
.XX = ± .050					
.XXX = ± .015					
.XXXX = AS SPECIFIED					
SCALE 1/8					
DATE: 8/31/12					
DWG SIZE A					
REV					
DRAWING NO.					
125884C					
REV 2					

NO.	REVISION	DATE	DR.	CHK.
2	2012	10/24	PD	RB

5/32 AIR LINE  
1/4 AIR LINE

2012

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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 implicada 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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