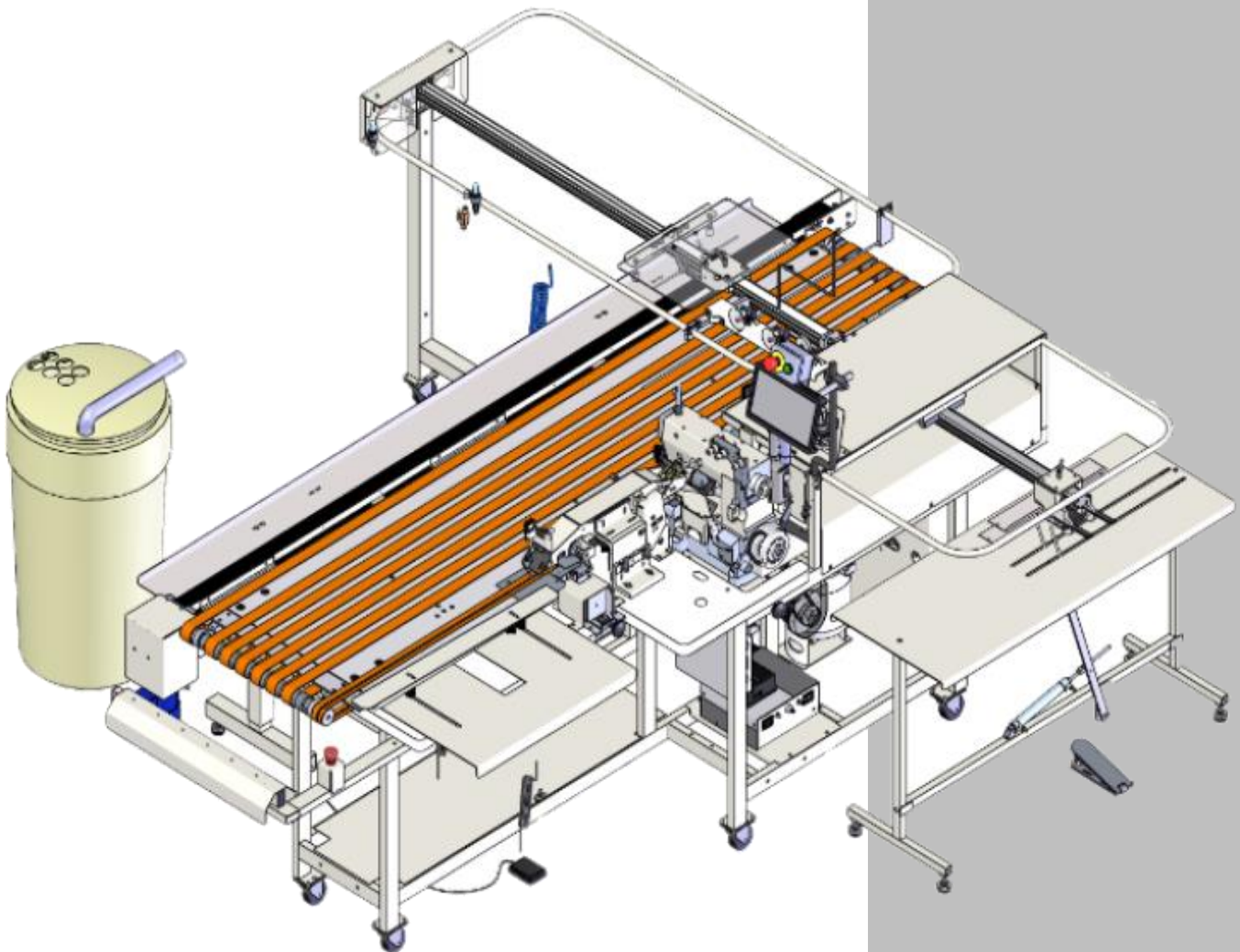




Model **213-ESG**
Gateway Controls

Rev 2. Created June 25, 2024(wr)

Parts Manual



Atlanta Attachment Company

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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 211ESE Hemmer 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 Parts Material comprises:
- Safety information
- Electrical and Pneumatic diagrams

And may also include.

- A list of recommended spare parts

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.

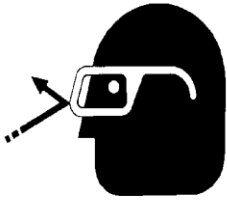
Signs on the Machine

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

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

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

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

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

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

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

Description

The Atlanta Attachment Company's high-speed automatic Two Needle cover stitch hemming workstation is a combination unit for sleeves, pockets and bodies complete with stacking capabilities for all.

The 2213ES is a versatile unit for hemming sleeves, pockets, and small bodies. It is available with picker stacker, return conveyor and fold in half stacker.

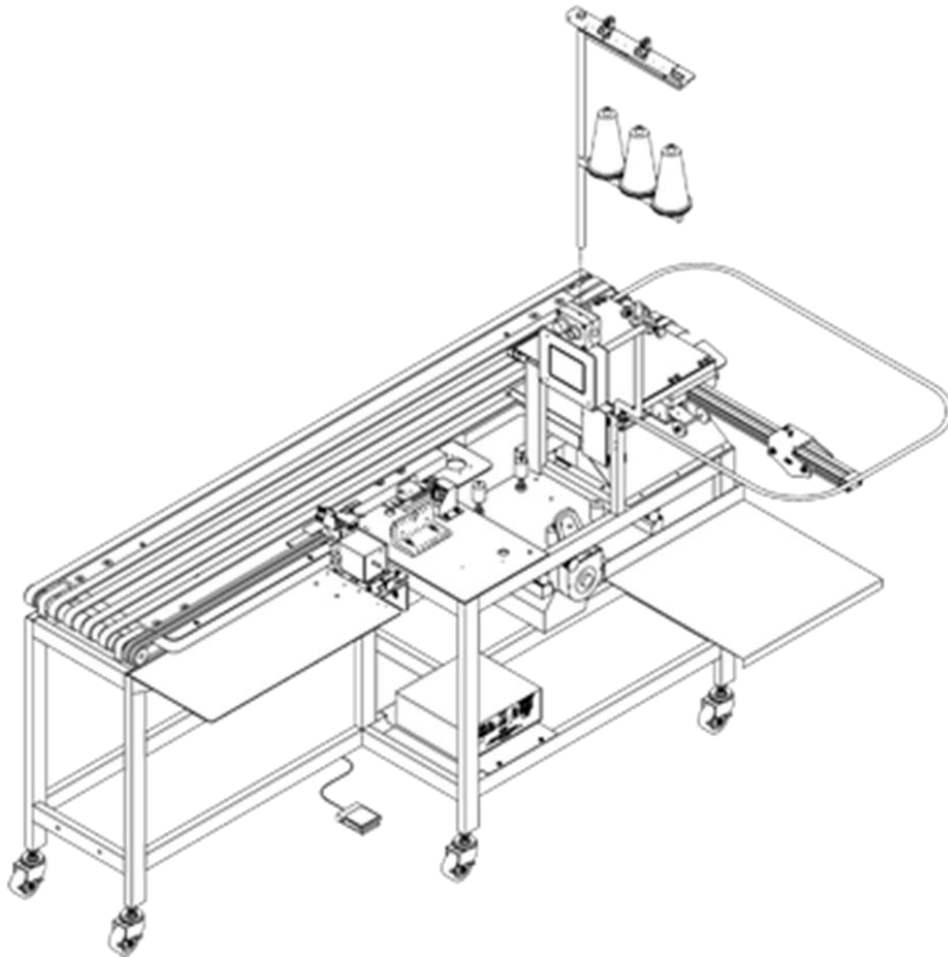
The modular design of AAC's Two Needle Hemmer allows the flexibility of picking the combination of components to design a custom system best suited to the need.

Description: An electronically controlled workstation consisting of a conveyORIZED downturn hemming apparatus with two needle bottom cover stitch sewing head, electronic motor, automatic edge trim and cut part.

Operation: The operator places parts to an edge guide and initiates sewing. The unit will continue sewing as long as parts are placed on the conveyor within a specific distance. The sew cycle will stop, if the operator fails to position the next part, thereby reducing thread waste. Average production on sleeves is 350 - 400 dozen pair per 8-hour day.

CAUTION:

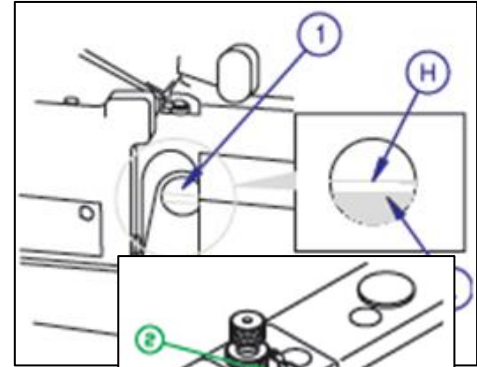
There are cloth and thread trimming knives on this piece of equipment. These knives cut automatically. **DO NOT** put fingers or hands in or around these knives. All adjustments made to the Sewing machine head or knives should be made with power "OFF".



Sewing Head Maintenance

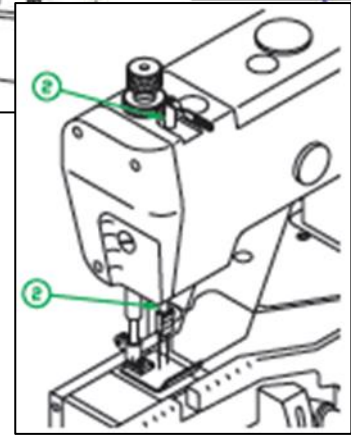
1. Oil Level

Always keep enough oil in the machine so that the oil level is between two lines H and L of oil gauge (item 1).



2. Manual Oiling

Before starting machine for the first time, or if the machine is idle for more than a couple of weeks, manually lubricate needle bar (item 2).



3. Oil Change

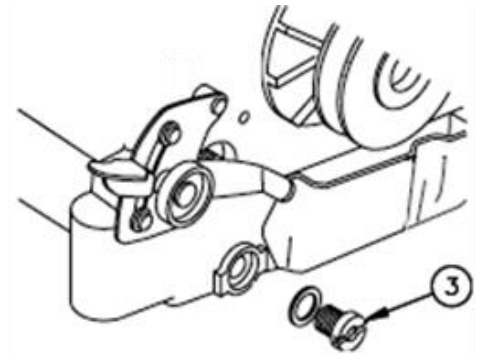
Change oil after the first month in operation. After that, change oil every 6 months.

Note:

Be sure to change oil because dirty oil can cause excess wear on moving parts and shortens the life of the machine.

4. To Drain Oil

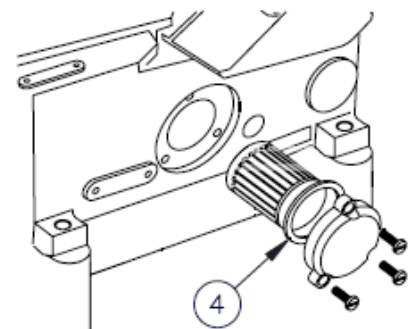
Take out drain plug (item 3) and drain oil from here.



5. Checking and Replacing Oil Filter

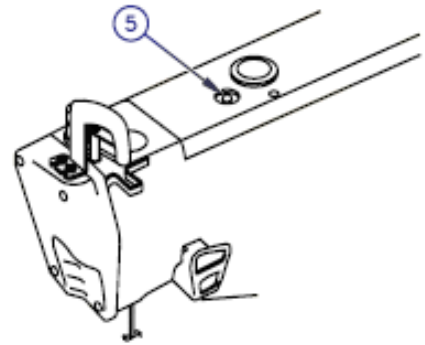
If oil filter (item 4) is clogged, normal lubrication cannot occur.

Check and clean it every 6 months at the time of the regular oil change.



Note:

If oil jet in window (item 5) is abnormally restricted or weak, or oil contains bubbles, check and clean oil filter or if necessary, replace it with new oil filter.



Preventative Maintenance Schedule

1. Daily Maintenance:

- A. Check v-belt tightness.
- B. Check oil level – always keep level between lines H and L of oil gauge.
- C. Clean filter on waste containers. Dump if necessary.
- D. Clean thread buildup from top conveyor, puller roller and lower conveyor.
- E. Use low-pressure air blower gun to clean sewing head and tabletop.
- F. Wipe off lens of electric eyes with soft cloth.
- G. Drain water trap on air regulators.
- H. Blow off motor to insure proper cooling.

2. Weekly Maintenance:

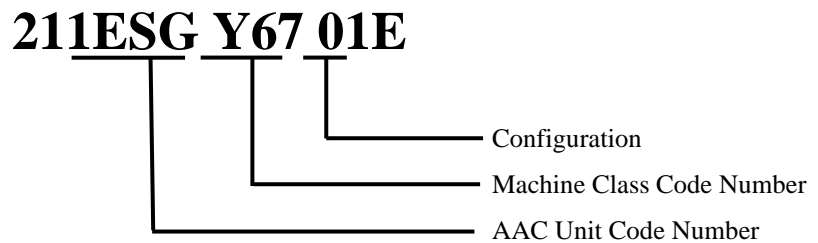
- A. Use low-pressure air blower gun to clean inside of sewing head, remove throat plate to gain access.
- B. Check sharpness of edge trimming and thread chopping knives; sharpen as needed to maintain keen edge.
- C. Check level of thread lubricant reservoirs; fill with silicone oil as necessary (if required for thread type used).
- D. Check belt tensions on top conveyor, adjust if necessary.
- E. Check gear belt tensions on lower conveyor and puller drive, adjust if necessary.
- F. Check all mechanical assemblies, tighten loosen components if found.
- G. Check all air cylinders for correct activation speeds, adjust flow controls if necessary.
- H. Check reflective tape for wear and replace as needed.

3. Monthly Maintenance:

- A. Oil and filter change intervals should occur at 30 days or 200 service hours after installation and then every 6 months or 1200 service hours. If you run the unit on 24-hour shifts, factor in the hours in operation and change accordingly.
- B. See Oil Change Instructions in Sewing Head Manual provided by Yamato, Pegasus, etc.
- C. If machine is idle for more than a couple of weeks, manually lubricate needle bar before operating.
- D. Remove and clean the top conveyor assembly.
- E. Remove and clean chain puller assembly.
- F. Replace or sharpen chain cutter blades. (311-2005 and 311-2006)
- G. Check filter elements in all air regulators with bowls, replace if necessary.

Configuration

The Atlanta Attachment's Units Numbers are formed in the following manner.



Sewing Machine Codes

G67	PEGASUS 5.6mm
R67	IMOLDI 4.5mm
R68	RIMOLDI 6.00mm
S67	SINGER 5.6mm
Y66	YAMATO 4.8mm
Y64	YAMATO 5.6mm
Y67	YAMATO VC2700-156M 5.6 mm
Y68	YAMATO 6.4mm

4.8 gauge = Part Number 2213ESG6609E

5.6 gauge = Part Number 2213ESG6702E

6.4 gauge = Part Number 2213ESG6810E

Assembly Drawings & Parts Lists

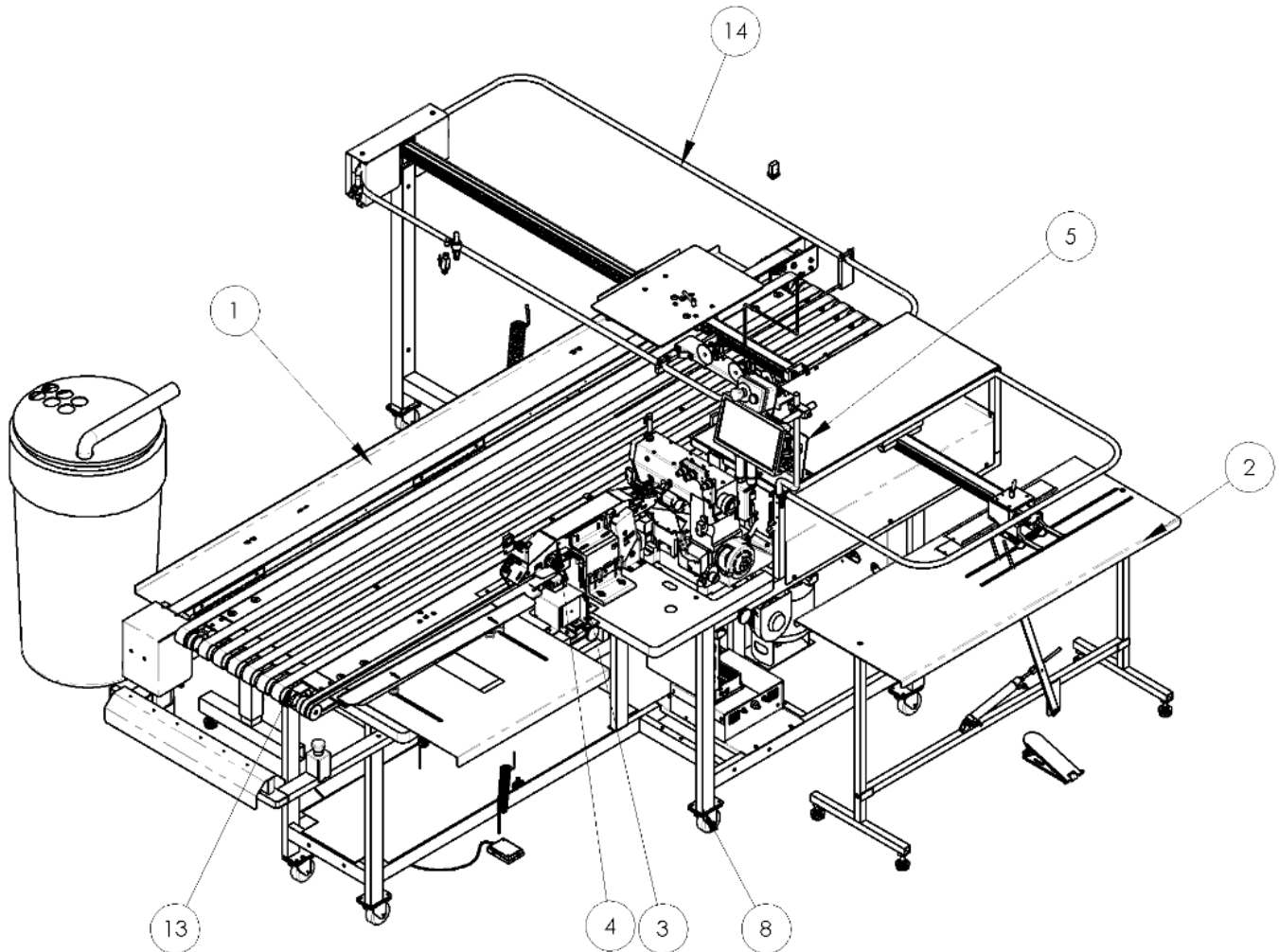
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One-Stop Shopping
For Expendable Replacement Parts for AAC & Other Bedding Equipment Suppliers
Toll Free: **1-866-885-5100**
www.atlantapartsdepot.com • sales@atlantapartsdepot.com

2213ESGXXE Auto Hemmer, With Gateway & Efka

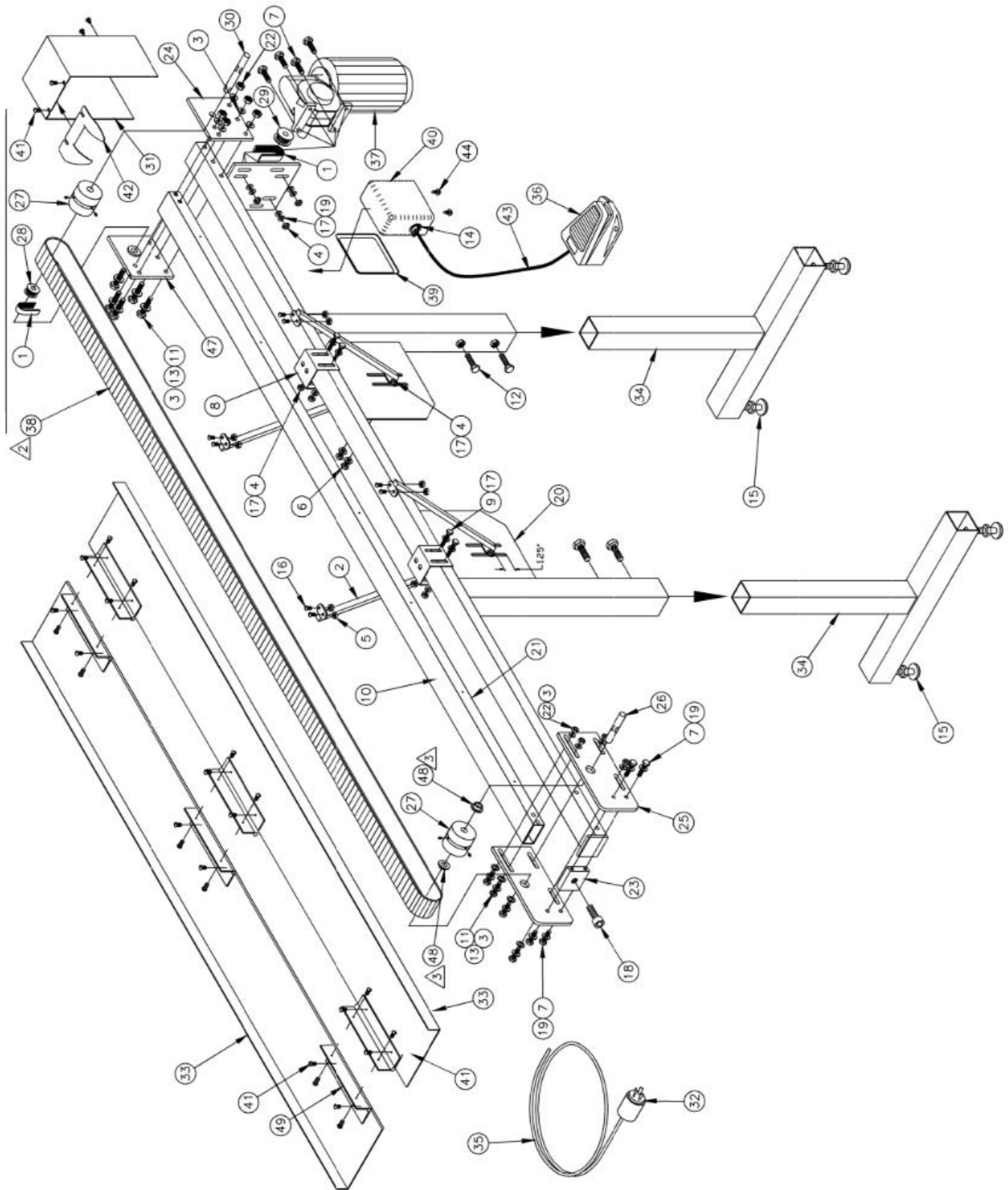
AAC Drawing Number 9007440 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	013-G6605B	CONVEYOR, FREE STANDING
2	1	211-162	INDEXING TABLE
3	1	211-G6606G	HEMMING FOLDER ASSEMBLY W/AIR
4	1	211-G6607F	TOP CONVEYOR, 2 BELTS
5	1	2213020	PANEL GAUGE, FOOT ONLY
6	1	213ES-PD	PNEUMATIC DIAGRAM
7	1	213-SWD1	DIAGRAM, WIRING, SBUS EFKA
8	1	213E-200E	FRAME AND TABLE ASSY EFKA
9	1	211-3R	HEMMER SEWING HEAD SBUS, PEG 5.6
10	1	211-3T	HEMMER SEWING HEAD SBUS, PEG 6.4
11	1	211-3V	HEMMER SEWING HEAD SBUS, PEG 4.8
12	1	311-011	STACKER, PICK AND STACK
13	1	311-017A	LOWER CONVEYOR ASSY
14	1	311-018	STACKER ASSEMBLY
15	1	2213005	LASER ALIGNMENT MODULE, LINE

013-G6605B Conveyor, Free Standing

AAC Drawing Number 190500C Rev 29

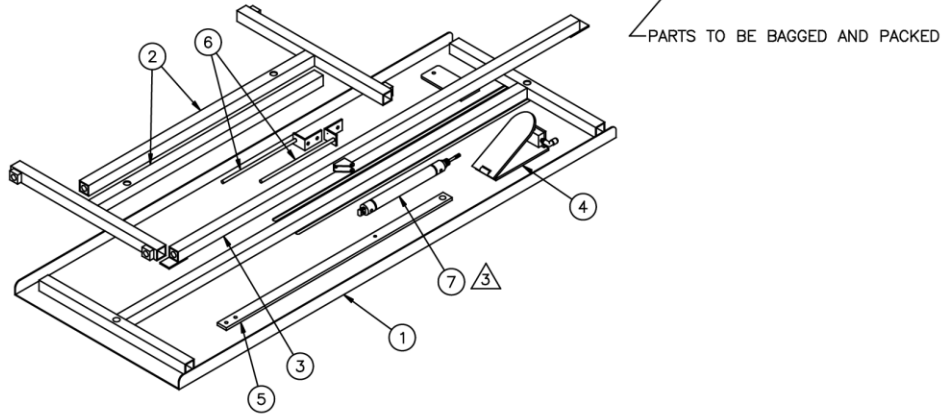
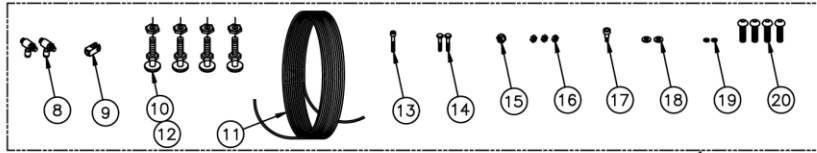


013-G6605B parts list

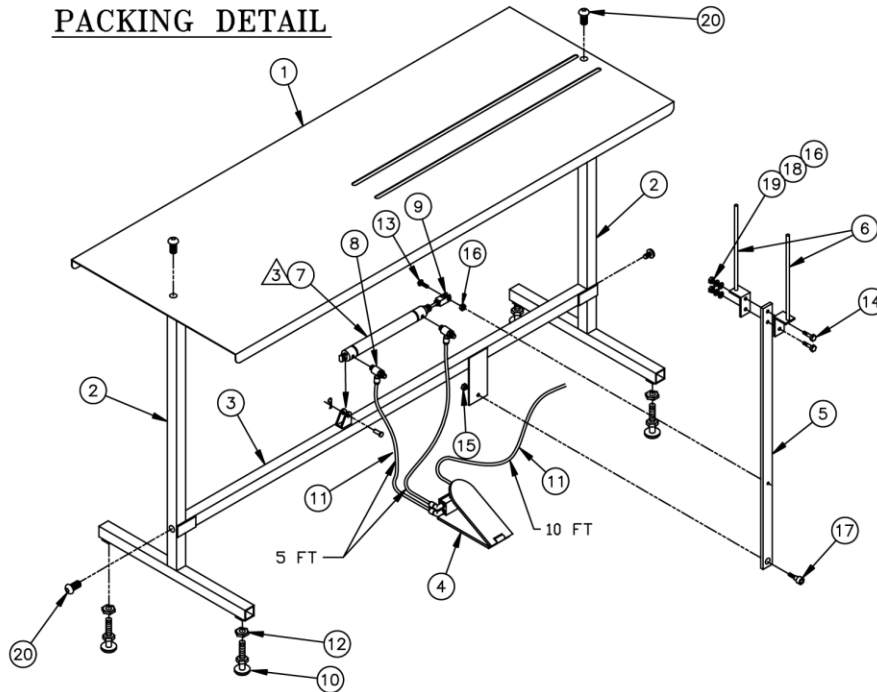
QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
4	15	RUBBER FEET	MMFB4444
2	14	ROMAX CONNECTOR	K-235
9	13	5/16 LOCK WASHER	WWL5/16
4	12	SCREW, HEX CAP 1/2-13 X 1	SSHC45064
9	11	SCREW, HEX CAP 5/16-18 X 3 (GRADE 5)	SSHC10192
108	10	TEFLON TAPE	MM130-10A
4	9	SCREW, HEX CAP 1/4-20 X 3	SSHC01192
2	8	U BRACKET	013-078
8	7	SCREW, HEX CAP 1/4-20 X 1	SSHC01064
4	6	SCREW, HEX CAP 1/4-20 X 3/4	SSHC01048
8	5	10-32 KEP NUT	NNK10-32
12	4	1/4-20 KEP NUT	NNK1/4-20
18	3	5/16 WASHER	WWF5/16
4	2	DROP LEAF SUPPORT	MM1756A3
1	1	GEAR BELT	GG150L050
1	29	PULLEY, GEAR 12TH	013-033A
1	28	PULLEY, MOD, 12TH	211-057
2	27	ROLLER, ALUM	013-031
1	26	AXLE, STACKER IDLER	013-030
2	25	PLATE, END SLOTTED	013-029
1	24	PLATE MOTOR MOUNT	013-028R
1	23	ADJUSTOR BELT TENSION	013-027
9	22	5/16 NUT	NNH5/16-18
1	21	TUBE, BELT SUPPORT	013-025
1	20	WELDMENT TOP TUBE	013-084
8	19	1/4 LOCK WASHER	WWL1/4
1	18	SCREW, SOCKET SET 3/8 X 1 3/4	SSSC25112
20	17	1/4 SAE WASHER	WWFS1/4
8	16	SCREW, TRUSS SLOTTED 10-32 X 5/8	SSTS98040

211-162 Indexing Table

AAC Drawing Number 191010B Rev 4



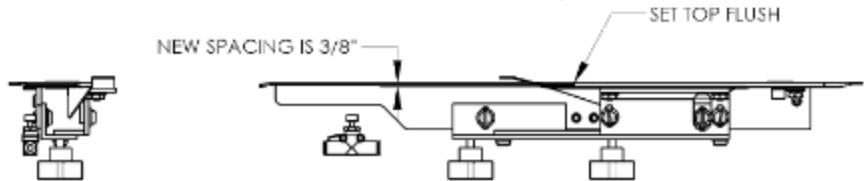
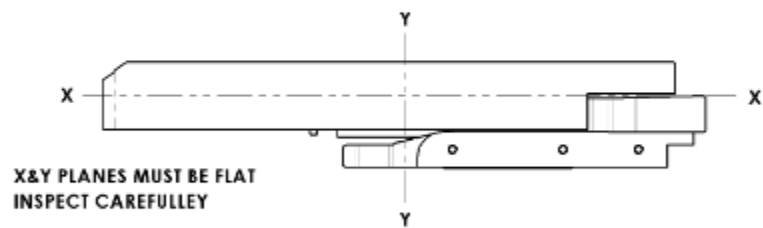
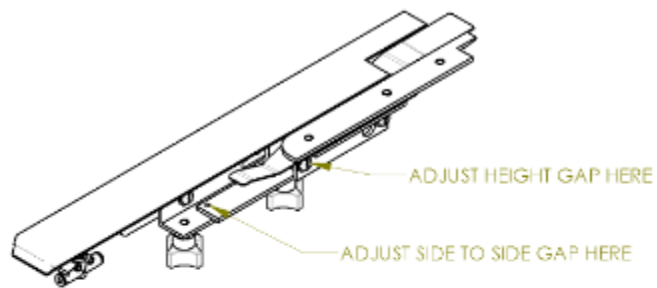
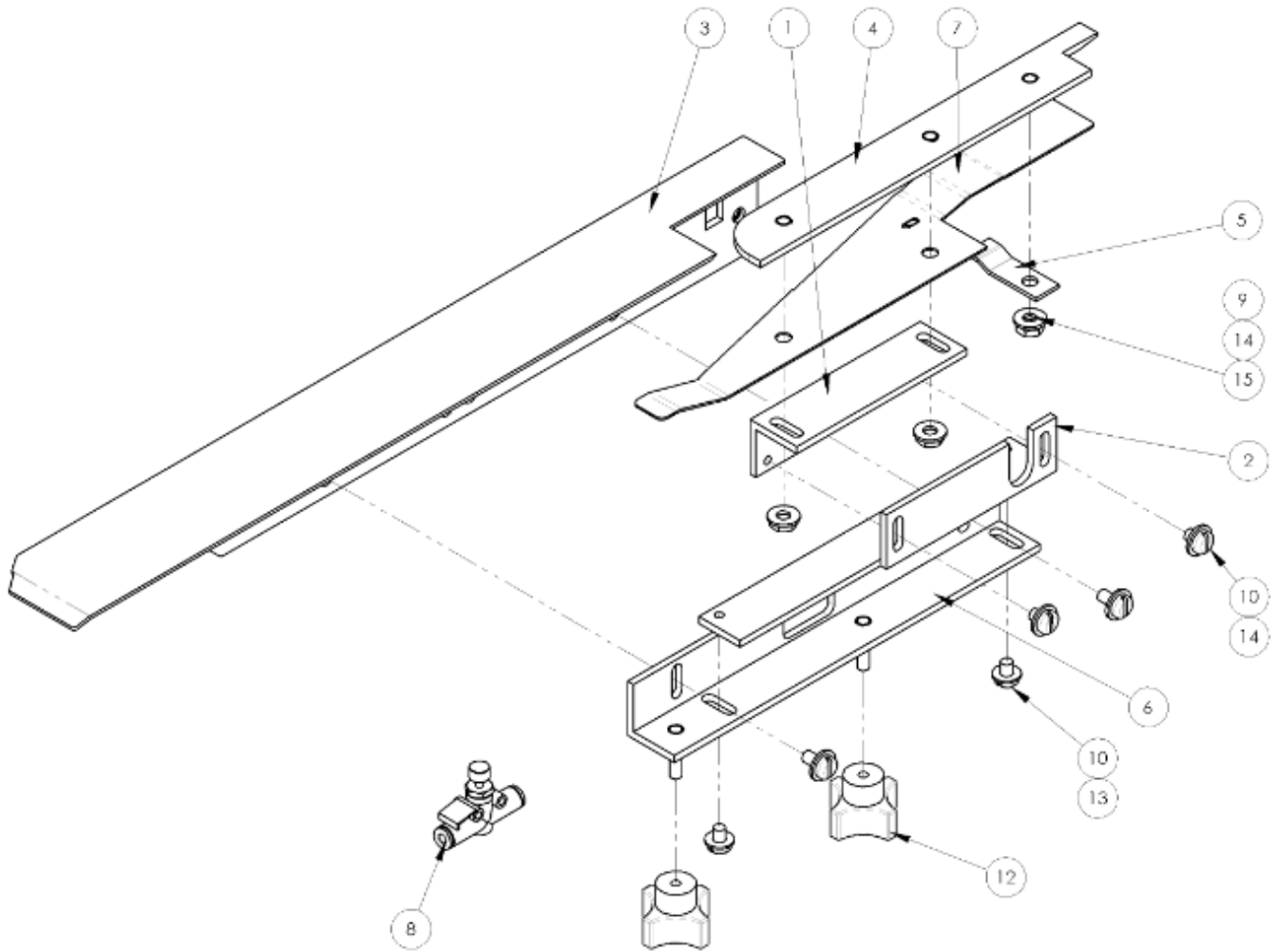
PACKING DETAIL



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-162-1	Table Top Weldment	11	20'	AATP5/32	5/32 Air Line
2	2	211-162B8	Leg Weldment	12	4	NNH1/2-13	Hex Nut
3	1	211-162B7	Stand Weldment	13	1	SSSC01096	Scr,So Cp 1/4-20x1-1/2
4	1	AA192-10DA	Foot Switch	14	2	SSHC01080	Scr,Hx Cp 1/4-20x1-1/2
5	1	016-049	Pivot Bundle Indexer	15	1	NNE5/16-18	Elastic Nut
6	2	211-162A	Fork	16	3	NNH1/4-20	Nut
7	1	AAC6DP-6	Air Cylinder	17	1	SSAS024024	Scr,Al Sh 3/8x3/8
8	2	AA198RA508	Flow Control	18	2	WWF1/4	Flat Washer
9	1	AAFCT-11	Humphrey Clevis	19	2	WWL1/4	Lock Washer
10	4	MMFB4444	Rubber Feet	20	4	SSBC45096	Scr,Butt Cp 1/2-13x1 1/2

211-G6606G Hemming Folder Assembly

AAC Drawing Number 9007395 Rev 0

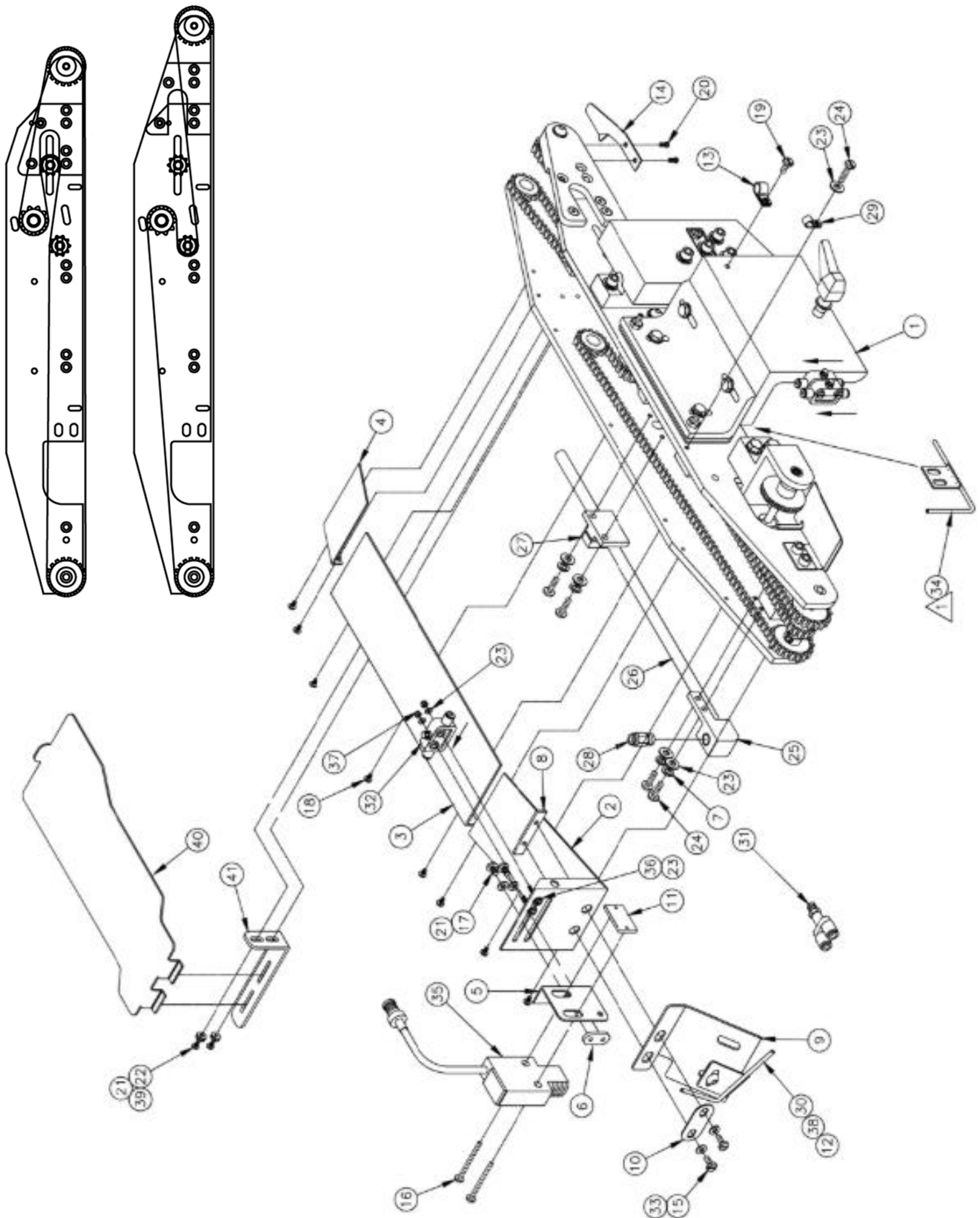


211-G6606G parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	010-022A	BRACKET, FOLDER MOUNT
2	1	010-022B	BRACKET, FOLDER MOUNT
3	1	011-011	FOLDER, EDGE GUIDE
4	1	011-013A	EDGE GUIDE, RIGHT
5	1	011-060	SUPPORT, LOWER FOLDER
6	1	211-093	BASE, FOLDER MOUNT BRKT
7	1	2213017	TONGUE, FOLDER WITH AIR
8	1	AA2001F-03	FLOW CONTROL,IN-LINE,5/32
9	3	NNH10-24	HEX-NUT 10-24 REG.
10	4	SSPS95016	#10-24 X 1/4 PAN HD SLTD
11	2	SSPS95024	#10-24 X 3/8 PAN HD SLTD
12	2	TTCL1BPPK1	KNOB,PLASTIC, #10-24
13	2	WWB10S	WASHER,BRASS,10,SMALL
14	7	WWFS10	WASHER, FLAT #10
15	1	WWL10	WASHER,LOCK,#10

211-G6607F Top Conveyor, 2 Belt

AAC Drawing Number 192134C Rev 2

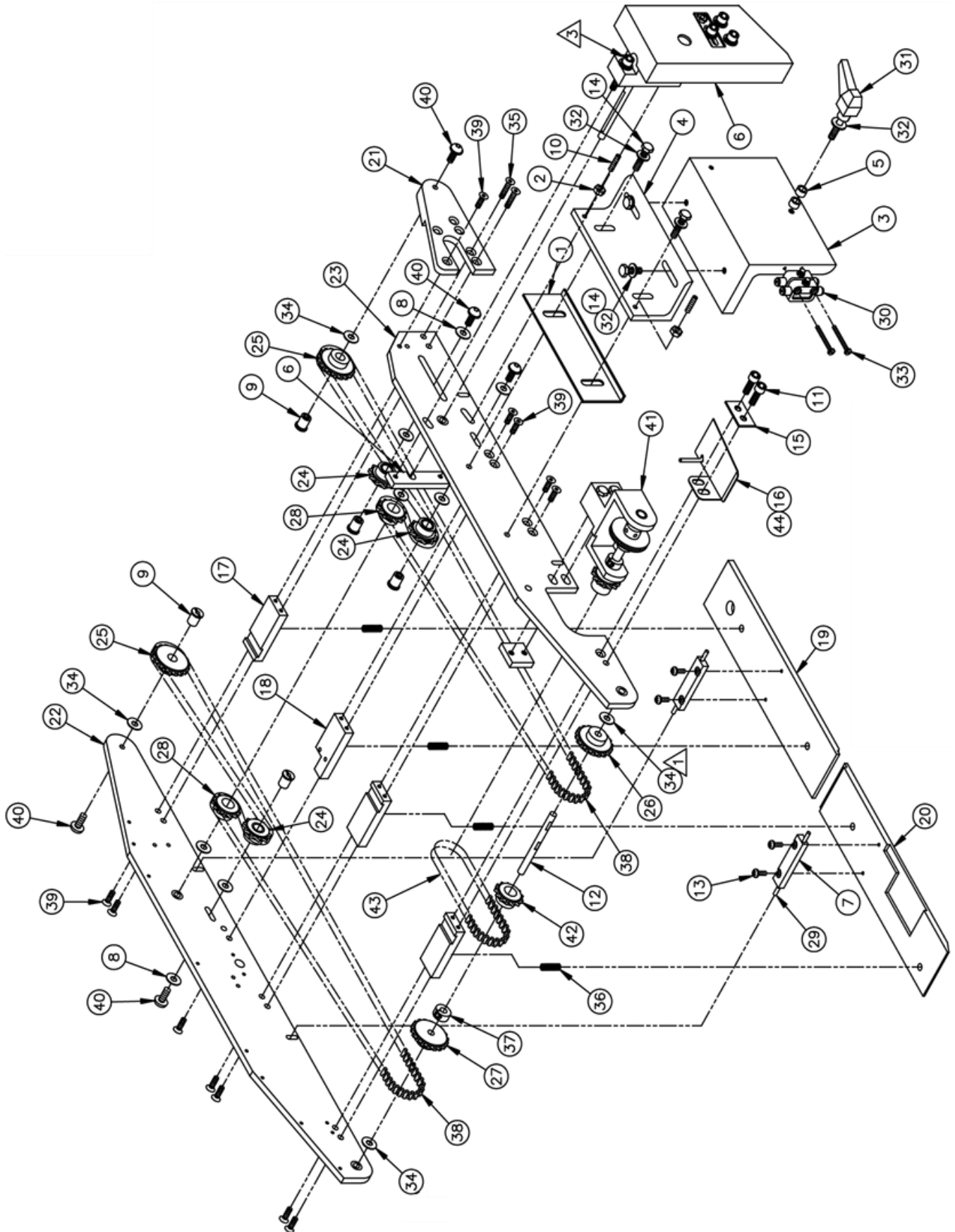


211-G6607F parts list

QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	20	SCREW, BUTTON CAP 6-32 x 1/2	SSBC80032
1	19	SCREW, PAN SLOTTED 10-32 x 1/2	SSPS98032
8	18	SCREW, TRUSS PHILLIPS 6/32 x 1/4	SSTP80016
2	17	SCREW, PAN SLOTTED 8-32 x 3/8	SSPS90024
2	16	SCREW, ROUND SLOTTED 4-40 x 3/4	SSRS70048
2	15	SCREW, PAN SLOTTED 10-32 x 3/8	SSPS98024
1	14	FOLD HOLDER	211-023
1	13	CLAMP, PLASTIC	AAF1/4
1	12	ELASTIC NUT	NEE1/4-20
1	11	NUT PLATE	1975-412A
1	10	WASHER PLATE	WW25DW
1	9	AIR JET MOUNT	311-091
1	8	NUT PLATE	F201-113
4	7	WASHER, LOCK	WWL6
1	6	NUT PLATE	211-064
1	5	BRACKET, ELECTRIC EYE	011-048
1	4	MOUNT, FRONT ELEC EYE	211-138
1	3	COVER, TOP CONVEYOR	011-046A
1	2	MOUNT, ELECTRIC EYE	211-020
1	1	TOP CONVEYOR, GENERIC	211-171
QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	39	LOCK WASHER	WWL8
1	38	SCREW, BUTTON CAP 1/4-20 x 1/2	SSBC01032
2	37	ELASTIC NUT	NEE6-32
2	36	SCREW, PAN HD SLOTTED 6-32 x 1/4	SSPS80064
1	35	EYE, ELECTRIC	FFSM312LVQ
0	34	TUBE, UNCURLER	211-178
2	33	WASHER, FLAT	WWF10
1	32	FLOW CONTROL	AA2000F-03
1	31	QUICK MALE "Y"	AAQY-5-5
1	30	TUBE, UNCURLER	211-174
1	29	CLAMP, PLASTIC	AAF1/8
1	28	QUICK MALE CONNECT	AAQMC-5-8
1	27	UNCURLER CLAMP BLK	2112-603
1	26	UNCURLER TUBE	2112-601
1	25	UNCURLER SUPPORT BLK	2112-602
5	24	SCREW, PAN PHILLIPS 6-32 x 1/2	SSPP80032
9	23	WASHER, FLAT, SAE	WWFS6
2	22	SCREW, PAN HD SLOTTED 8-32 x 1/2	SSPS90032
4	21	WASHER, FLAT	WWF8

211-171 Top Conveyor Internal Components

AAC Drawing Number 191359C Rev 5

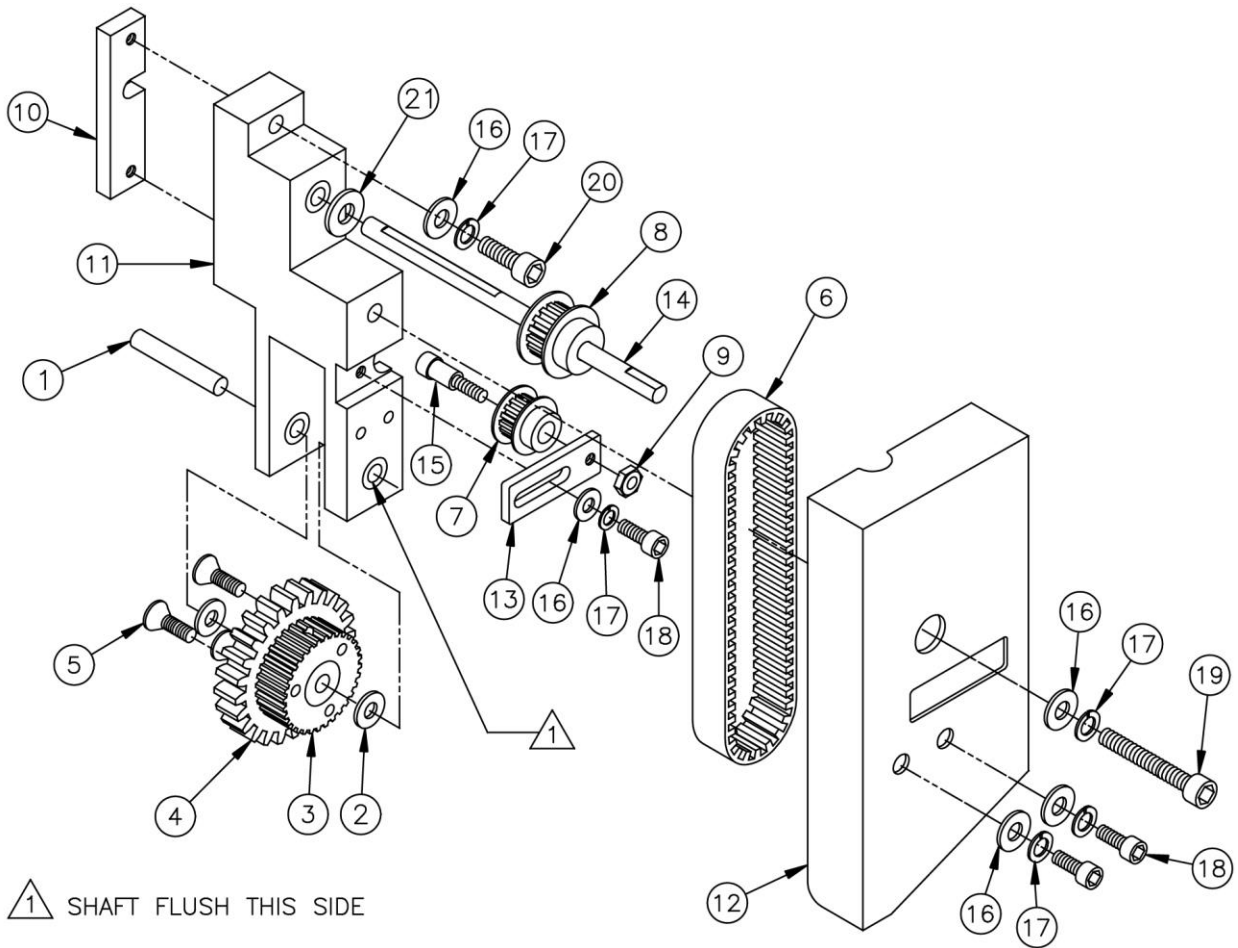


211-171 parts list

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	011-050	Bracket, Adjustment	23	1	211-003	Plate, Right Side
2	2	NNH10-32	Nut, Hex	24	3	211-049	Sprocket, Idler, 10T
3	1	011-052	Top Conv Mount	25	2	011-037	Sprocket, Idler, 18T
4	1	011-051	Brkt, Top Conv Mount	26	1	011-039	Sprocket, Drive, 18T
5	2	011-049	Spacer	27	1	011-040	Sprocket, Idler, 18T
6	1	311-002	Main Drive	28	2	MM66A-13	Sprocket, Drive, 13T
7	2	211-008	Pin Plate	29	4	IIS008x048	Spring Pin
8	3	WWFS10	Washer, Flat, SAE	30	2	AA2000F-03	Flow Control
9	5	011-041	Stud, Idler Sprocket	31	1	TTH32416	Threaded Handle
10	2	SSSS98048H	Scr, So St 10-32x3/4	32	5	WWF1/4	Washer, Flat
11	2	SSSC98048	Scr, So Cp 10-32x3/4	33	2	SSPS80096	Scr, Pn SI 6-32x1 1/2
12	1	211-005	Axle, Front Drive	34	9	BBTRA411	Thrust Washer
13	4	SSPP80024	Scr, Pn Ph 6-32x3/8	35	2	SSFC98048	Scr, Fl Cp 10-32x3/4
14	4	SSHC01056	Scr, Hx Cp 1/4-20x7/8	36	4	RRLC024C10	Spring
15	1	WWP032	Washer Plate	37	1	CCCL4F	Clamp Collar
16	1	011-154	Material Edge Uncurler	38	2	MM25CCF210	Chain, 52.5 L
17	3	011-032A	Spacer	39	12	SSFC98032	Scr, Fl Cp 10-32x1/2
18	1	011-032B	Spacer, Notched	40	5	SSBC98048	Scr, But Cp 10-32x3/4
19	1	211-007	Plate, Belt Pressure	41	1	311-001A	Feed Wheel Assy
20	1	211-006	Plate, Belt Pressure	42	1	MM66A-10	Sprocket, 10T
21	1	211-004	Nose Piece	43	1	MM25CCF040	Chain, 10.0 Long
22	1	211-002	Plate, Left Side	44	0.85	AA TP5/32	Airline, 5/32

311-002 Top Conveyor, Main Drive

AAC Drawing Number 190255B Rev 7

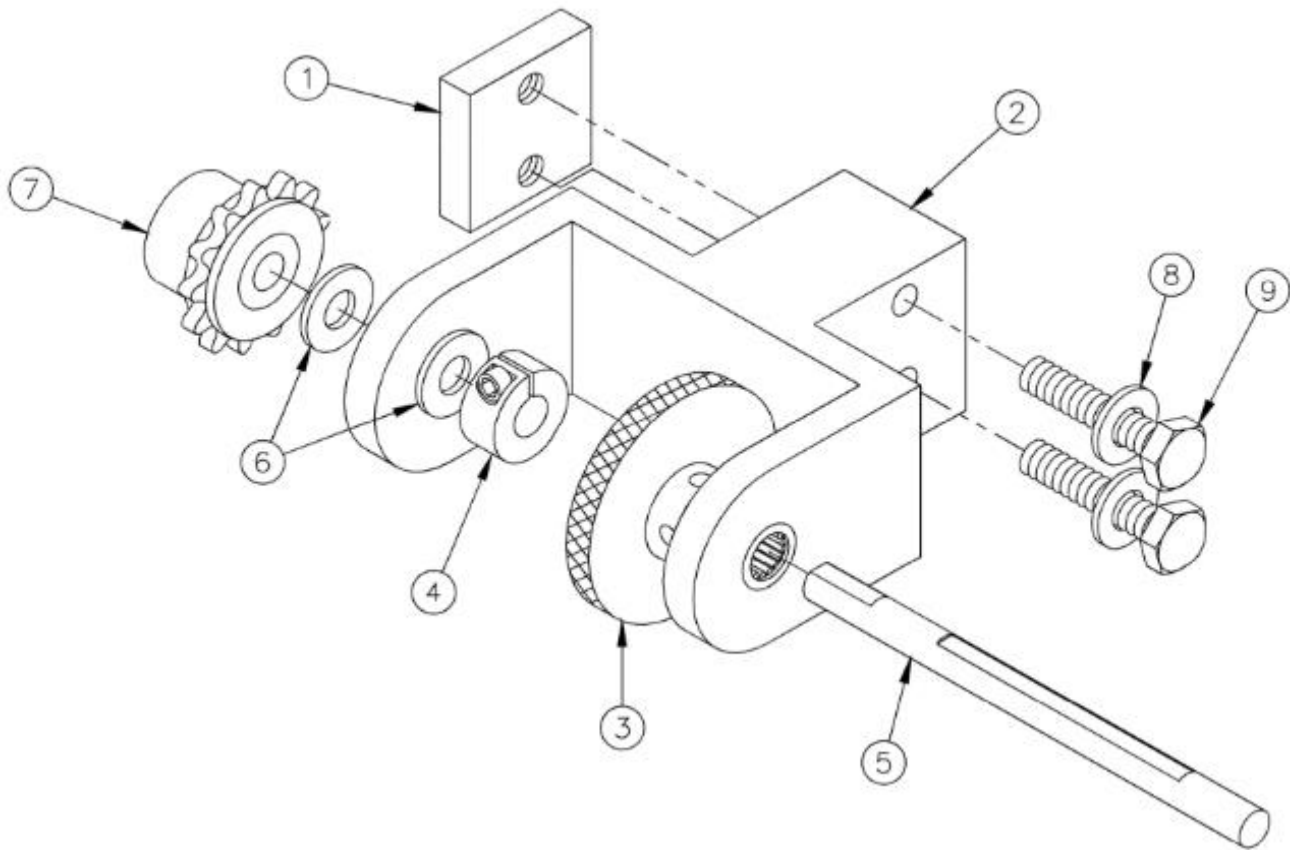


△ 1 SHAFT FLUSH THIS SIDE

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	IID016X112	Dowel Pin	12	1	211-075	Belt Guard
2	2	BBTT601	Thrust Bearing	13	1	211-077	Tensioner
3	1	211-014	Pulley, Top Conveyor	14	1	211-076	Shaft Top Drive
4	1	211-013	Gear, Top Conveyor	15	1	SSAS016048	Scr,Al Sh 1/4x2/4,10-24
5	3	SSFC98040	Scr,Fl Al Cp 10-32x5/8	16	5	WWFS10	Washer
6	1	GG120XL037	Gear Belt	17	5	WWL10	Lock Washer
7	1	211-078	Pulley, 10 Teeth	18	3	SSSC98032	Scr,So Cp 10-32x1/2
8	1	PP22XLB037	Pulley, 22 Teeth	19	1	SSSC98192	Scr,So Cp 10-32x3
9	1	NNH10-24	10-24 Hex Nut	20	1	SSSC98080	Scr,So Cp 10-32x1 1/4
10	1	211-016	Nut Plate	21	1	BBTRA411	Thrust Washer
11	1	211-074	Pivot, Top Conv Drive				

311-001A Feed Wheel Assembly

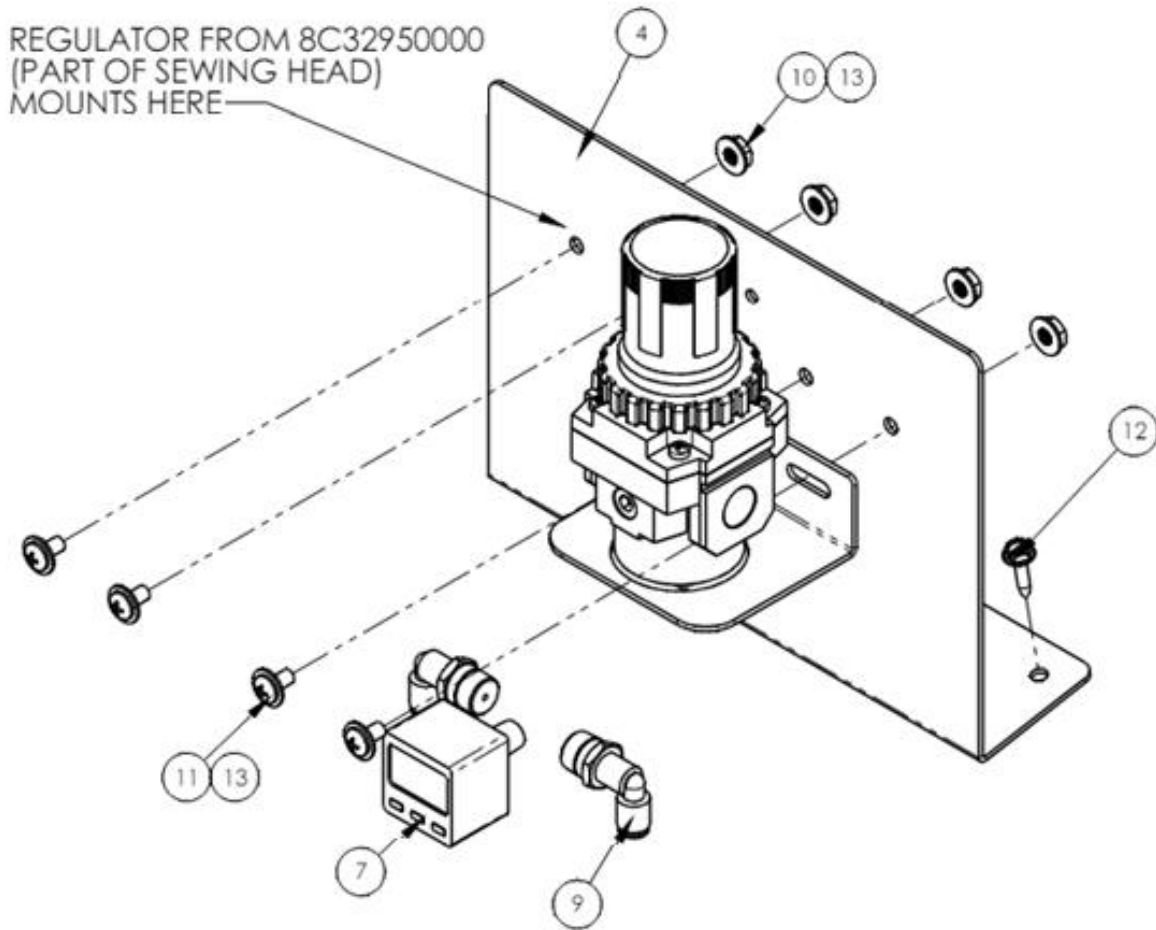
AAC Drawing Number



QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	9	SCREW, HEX CAP 1/4-20 X 1 1/2	SSHCO1096
2	8	WASHER, FLAT, SAE, 1/4	WWFS1/4
1	7	SPROCKET DRIVE 10 T	MM66A-10
2	6	BEARING, BRONZE	BBTT601
1	5	SHAFT, FEED WHEEL	011-042
1	4	COLLAR, CLAMP, 1/4	CCCL4F
1	3	FEED WHEEL	010-015
1	2	MOUNT. FEED WHEEL	011-033
1	1	NUT PLATE, 1/4-20	011-036

2213020 Panel Gauge, Foot Lift Only

AAC Drawing Number 2213020 Rev 2



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	0411-071	BRKT,REGULATOR
2	1	213ES-PD	PNEUMATIC DIAGRAM
3	1	213-SWD1	DIAGRAM, WIRING, SBUS EFKA
4	1	2213021	GAUGE PANEL,
5	2	4080-4326	CABLE, DIGITAL PRESS. GAUGE
6	1	4080-4327	CABLE, DUAL ELECT REG.
7	1	AA198-ISE30A	DIGITAL PRESSURE GAUGE
8	1	AA198-RP3	REGULATOR,PRECISION AIR
9	2	AAQME-5-4	ELBOW, MALE 5/32X1/4NPT
10	4	NNK10-32	KEP NUT, 10-32
11	4	SSPP98024	10-32 X 3/8 PAN HD PHILIP
12	2	SSZH#10048	SCREW,SHT.METAL HEX 10
13	8	WWF10	WASHER, FLAT, #10, COM

Sewing Head Details

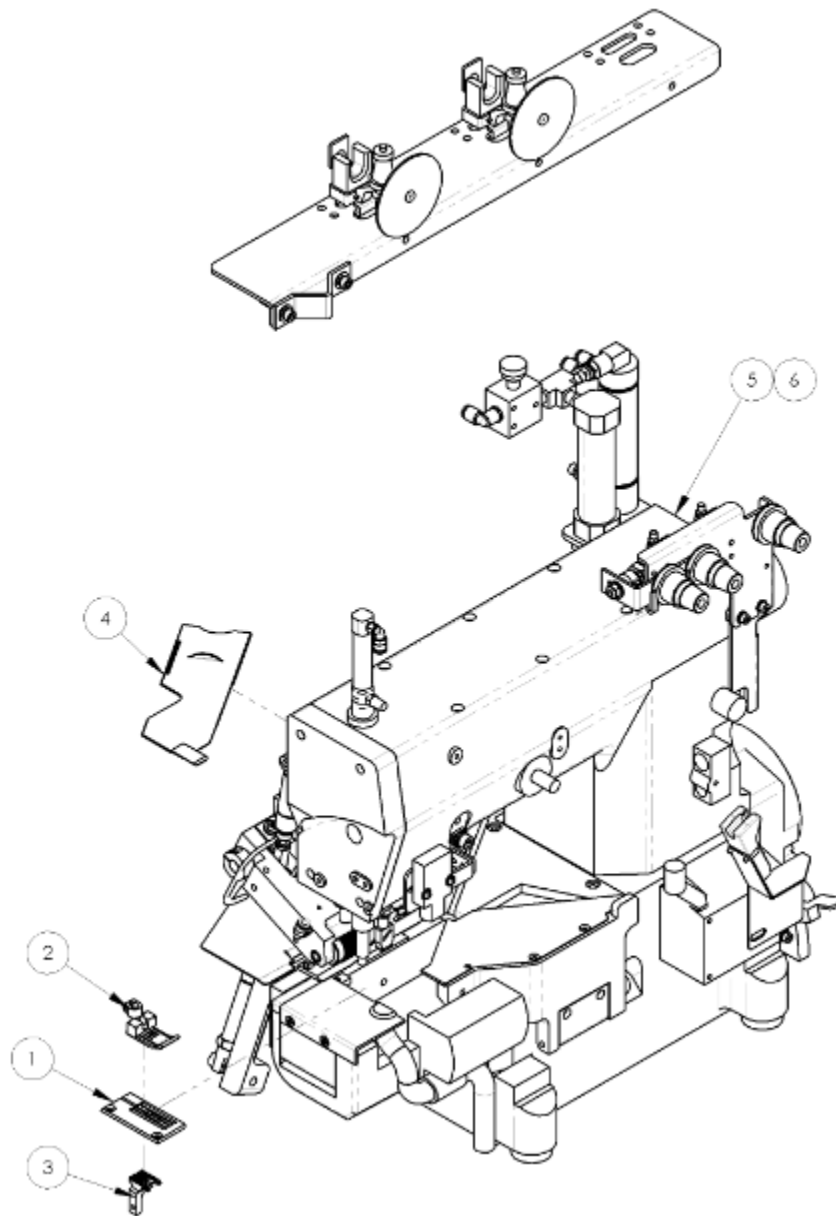
for 2213ES Two Needle Hemmer

Gauge Parts

211P48	Gauge Set for Pegasus 4.8mm	
257016B48M		Needle Plate, 3N, Pegasus 4.8mm
257301A48M		Modified Foot , Pegasus 4.8mm
25724216FM		Feed Dog Modified, Pegasus 4.8mm
211P56	Gauge Set for Pegasus 5.6mm	
257018B56M		Needle Plate, Pegasus 5.6mm
257301A56M		Modified Foot , Pegasus 5.6mm
25724316FM		Feed Dog Modified, Pegasus 5.6mm, 6.4mm
211P64	Gauge Set for Pegasus 6.4mm	
257018B64M		Needle Plate, Pegasus 6.4mm
257301A64M		Modified Foot , Pegasus 6.4mm
25724316FM		Feed Dog Modified, Pegasus 6.4mm
211R453	Gauge Set for Rimoldi 4.5mm,3 ROW FEED	
302066010M		Needle Plate, Rimoldi 4.5mm,3 Row Feed
302078313M		Modified Foot , Rimoldi 4.5mm, 3 Row Feed
311262000M		Feed Dog Modified, Rimoldi 4.5mm, 6.0mm
211R454	Gauge Set for Rimoldi 4.5mm,4 ROW FEED	
302705010M		Needle Plate, Rimoldi 4.5mm,4 Row Feed
302078313M		Modified Foot , Rimoldi 4.5mm, 3 Row Feed
311262000M		Feed Dog Modified, Rimoldi 4.5mm, 6.0mm
211R60	Gauge Set for Rimoldi 6.0mm	
302406410M		Needle Plate, Rimoldi 6.0mm
300581313M		Modified Foot , Rimoldi 6.0mm
311262000M		Feed Dog Modified, Rimoldi 4.5mm, 6.0mm
211Y48	Gauge Set for Yamato 4.8mm	
0094800M		Needle Plate, Yamato 4.8mm
3107050M		Modified Foot, Yamato 4.8mm
3109001M		Feed Dog Modified, Yamato 4.8mm, 5.6mm
211Y56	Gauge Set for Yamato 5.6mm	
0094801M		Needle Plate, Yamato 5.6mm
0064041		M Modified Foot, Yamato 5.6mm
3109001M		Feed Dog Modified, Yamato 4.8mm, 5.6mm
211Y64	Gauge Set for Yamato 6.4mm	
0094802M		Needle Plate, Yamato 6.4mm
0064042M		Modified Foot, Yamato 6.4mm
3109003M		Feed Dog Modified, Yamato 6.4mm

211-3R Sewing Head Assembly, Pegasus 5.6mm, Model : 2213ESG6702E

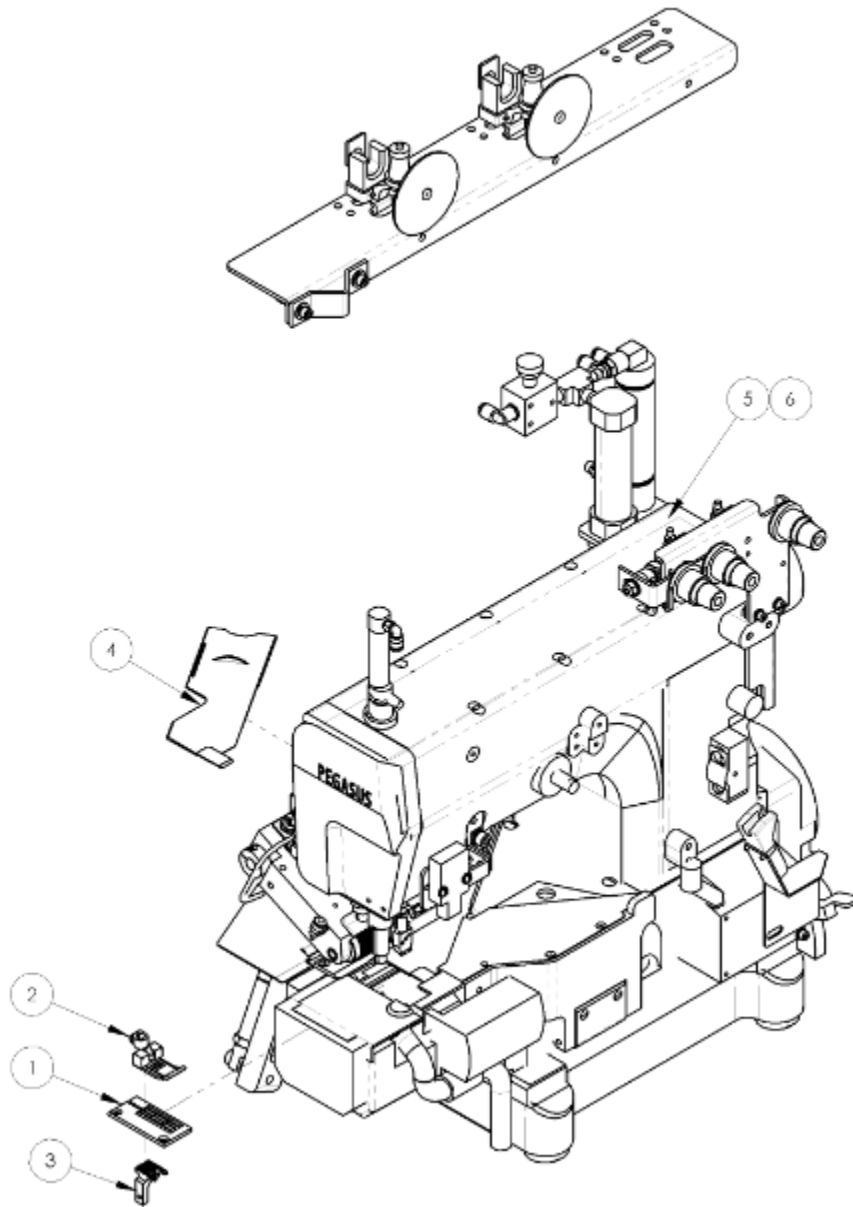
AAC Drawing Number



ITEM #	QTY.	PART #	DESCRIPTION
1	1	257018B56M	NEEDLE PLATE, MODIFIED 5.6 GA
2	1	257301A56M	FOOT, MODIFIED, PEGASUS, 5.6 GA
3	1	25724316FM	FEED DOG, MODIFIED, 5.6
4	1	211-067	COVER, LOOPER TOP
5	1	2213050	SEWING HEAD ASSEMBLY FOR 211, PEGASUS
6	1	SW&G66408C	SEWING HEAD, 3N, 5.6 GA 2N SLEEVE HEMMER

211-3T Sewing Head Assembly, Pegasus 6.4mm, Model:2213ESG6810E

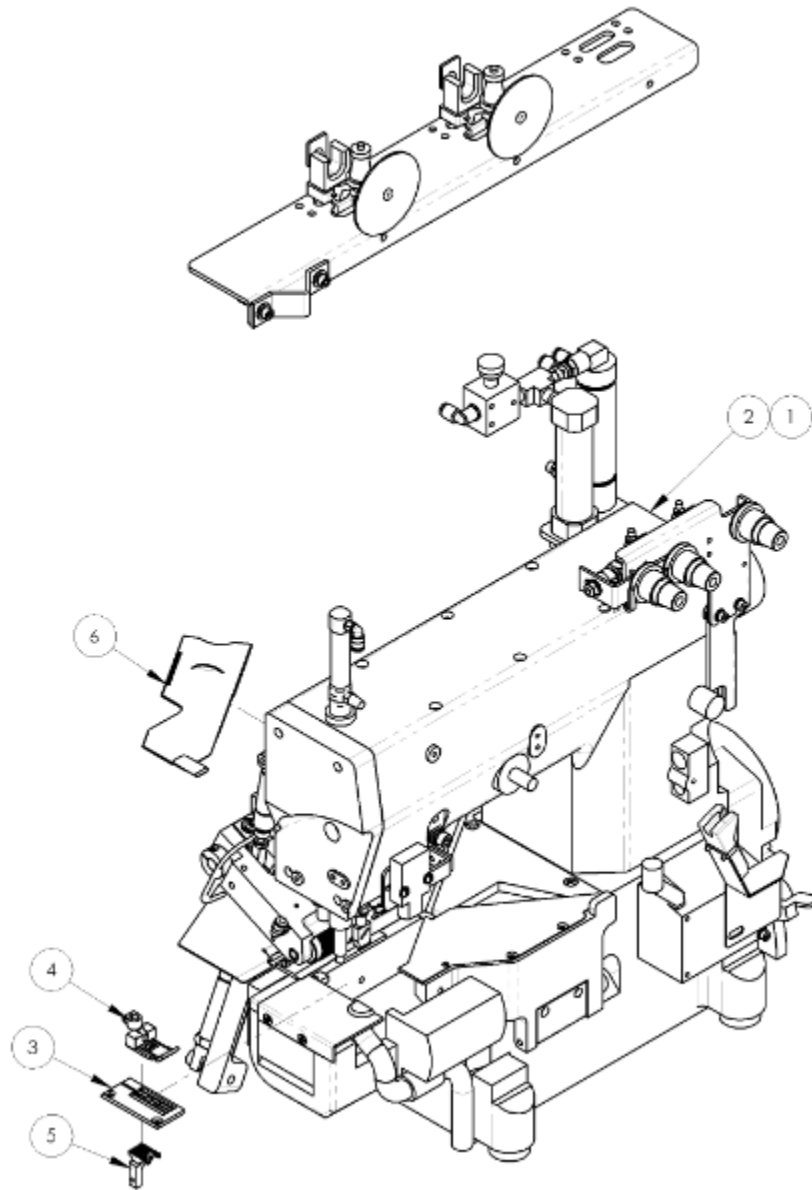
AAC Drawing Number



ITEM #	QTY.	PART #	DESCRIPTION
1	1	257018B64M	NEEDLE PLATE, MOD. PEG 6.4 GA
2	1	257301A64M	FOOT, MODIFIED, PEGASUS, 6.4 GA
3	1	25724316FM	FEED DOG, MODIFIED, 6.4
4	1	211-067	COVER, LOOPER TOP
5	1	2213050	SEWING HEAD ASSEMBLY FOR 211, PEGASUS
6	1	SW&G66408B	SEWING HEAD, 3N, 6.4 GA 2N SLEEVE HEMMER

211-3V Sewing Head Assembly, Pegasus 4.8mm, Model 2213ESG6609E

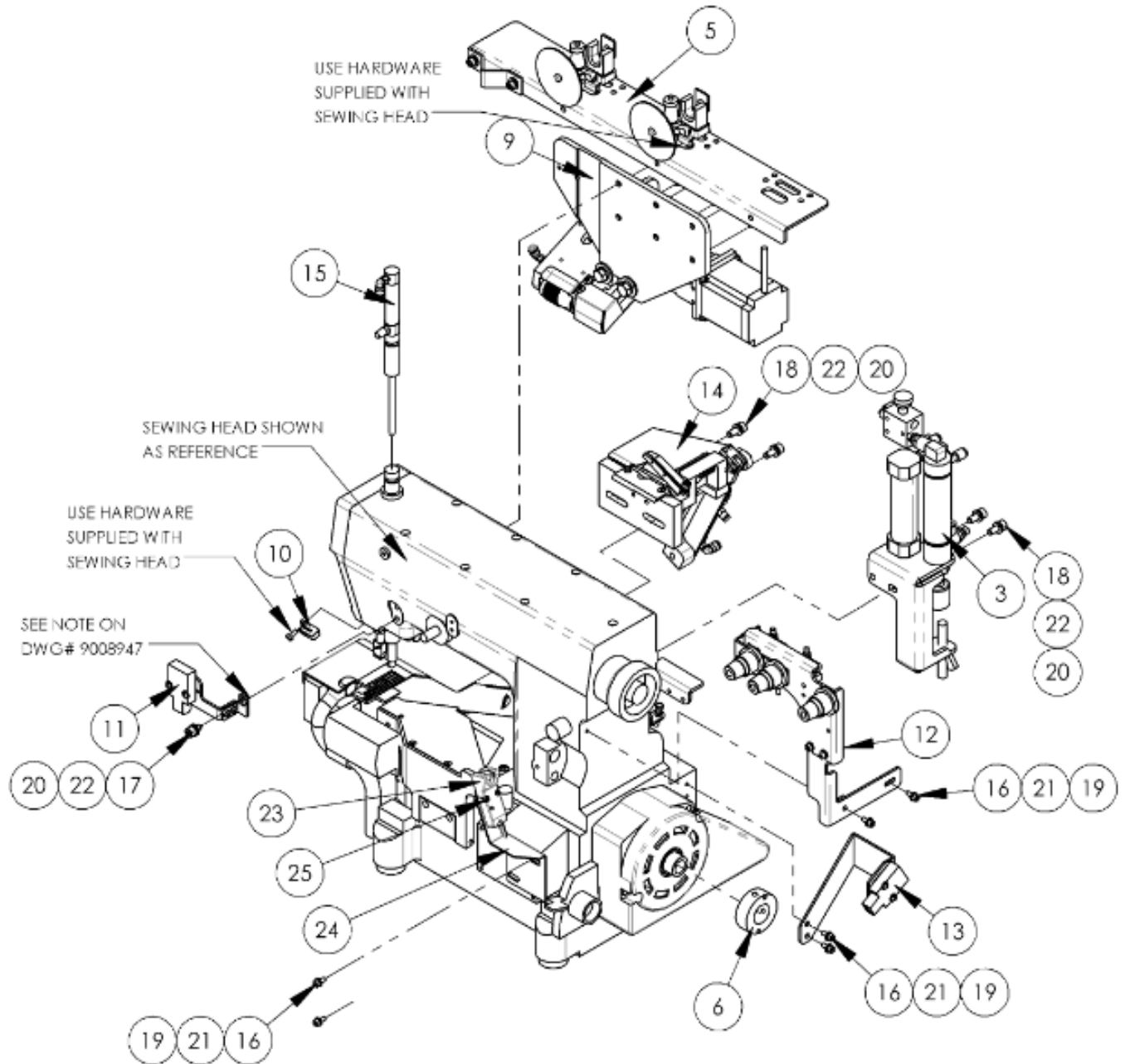
AAC Drawing Number



ITEM #	QTY.	PART #	DESCRIPTION
1	1	SW&G66408A	SEWING HEAD, 3N, 4.8 GA 2N SLEEVE HEMMER
2	1	2213050	SEWING HEAD ASSEMBLY FOR 211, PEGASUS
3	1	257016B48M	NEEDLE PLATE, MODIFIED, PEGASUS 4.8 GA
4	1	257301A48M	FOOT, MODIFIED, PEGASUS, 4.8 GA
5	1	25724216FM	FEED DOG, MODIFIED, 4.8
6	1	211-067	COVER, LOOPER TOP

2213050 Sewing Head Assembly, Pegasus

AAC Drawing Number 2213050 Rev 0

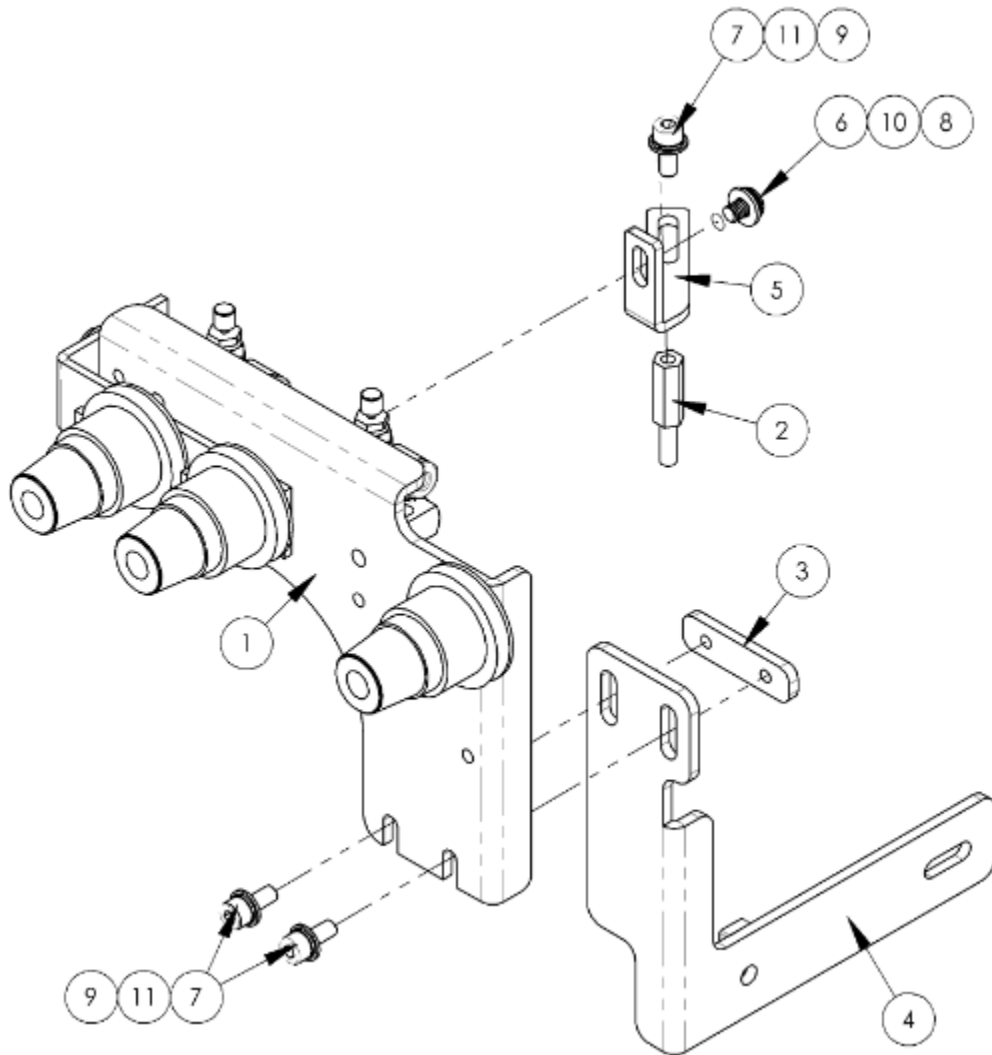


2213050 parts list

ITEM #	QTY.	PART #	DESCRIPTION
1	1	010-072	COVER, LOOPER, MODIFIED
2	1	011-061	LOOPER EYELET
3	1	011-G6612A	FOOTLIFT ASSY, PEGASUS
4	1*	0211-702A*	CABLE, POS1, SENSOR, 6' EFKA DC1500, FF5M312LVQ*
5	1	0411-069E	THREAD BREAK ASSY, PEGASUS
6	1	1278-6364	DISC, TAPE MOUNTING
7	2*	206338*	RUBBER CUSHION F/PEGASUS*
8	1	211-067	COVER, LOOPER TOP
9	1	211-075B	COVER, MAIN DR.2N HEMR. TOP CONVEYOR
10	1	211-114	THREAD GUIDE ASSEMBLY
11	1	211-153B	ELECTRIC EYE ASSY 2, PEGASUS
12	1	3101760D	THREAD HANDLING ASSY, PEGASUS
13	1	311-120B	ELECTRIC EYE ASSY, PEGASUS
14	1	311-2000G	CHAIN TRIMMER, PEGASUS
15	1	8C32950000	FOOT PRESSURE ASSY , PNEUMATIC
16	6	SSSCM4X10	SCREW,SOC CAP,M4-0.7X8
17	1	SSSCM6X10	M6X10 SOC CAP SCREW
18	4	SSSCM6X15	M6X15 SOC CAP SCREW
19	6	WWFM4	WASHER, FLAT, M4
20	5	WWFM6	WASHER, FLAT, M6, SAE
21	6	WWLM4S	M4 LOCK WASHER,S/S
22	5	WWLM6	WASHER,LOCK,M6
23	1	4003-16730	
24	1	40-233E	BRKT, LOOPER THREAD SENSOR SW&G66408C
25	2	SSPS70032	4-40 X 1/2 PAN HD SLOTTED

310176D Thread Handling Assembly, Pegasus

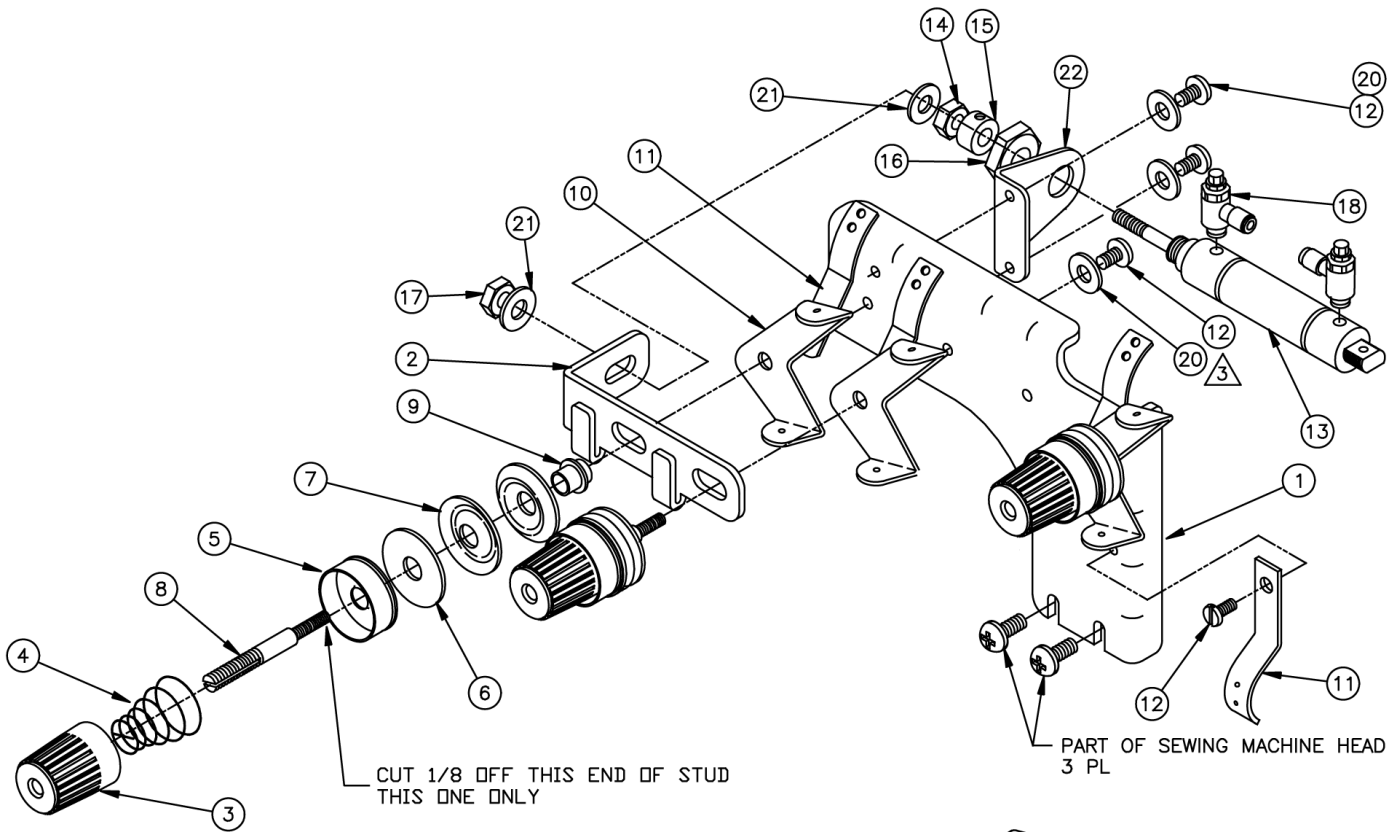
AAC Drawing Number 9008944 Rev 0



ITEM #	QTY.	PART #	DESCRIPTION
1	1	3101760	THREAD TENSION ASSY
2	1	3101760C	POST, ATTACHMENT
3	1	311-126B	NUT PLATE, TENSION MOUNT, PEGASUS
4	1	311-126C	BRKT, TENSION MOUNT, PEGASUS
5	1	311-126E	BRKT, TENSION MOUNT, TOP, PEGASUS
6	1	SSBC90016	8-32 X 1/4 BUTTON CAP
7	3	SSSCM4X10	SCREW,SOC CAP,M4-0.7X8
8	1	WWF8	WASHER, FLAT, #8
9	3	WWFM4S	WASHER, FLAT, M4,SS
10	1	WWL8	WASHER,LOCK,#8
11	3	WWLM4S	M4 LOCK WASHER,S/S

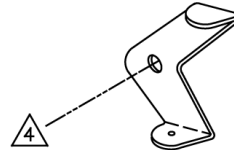
3101760 Thread Handling Assembly

AAC Drawing Number 290600C Rev 8



NOTES:

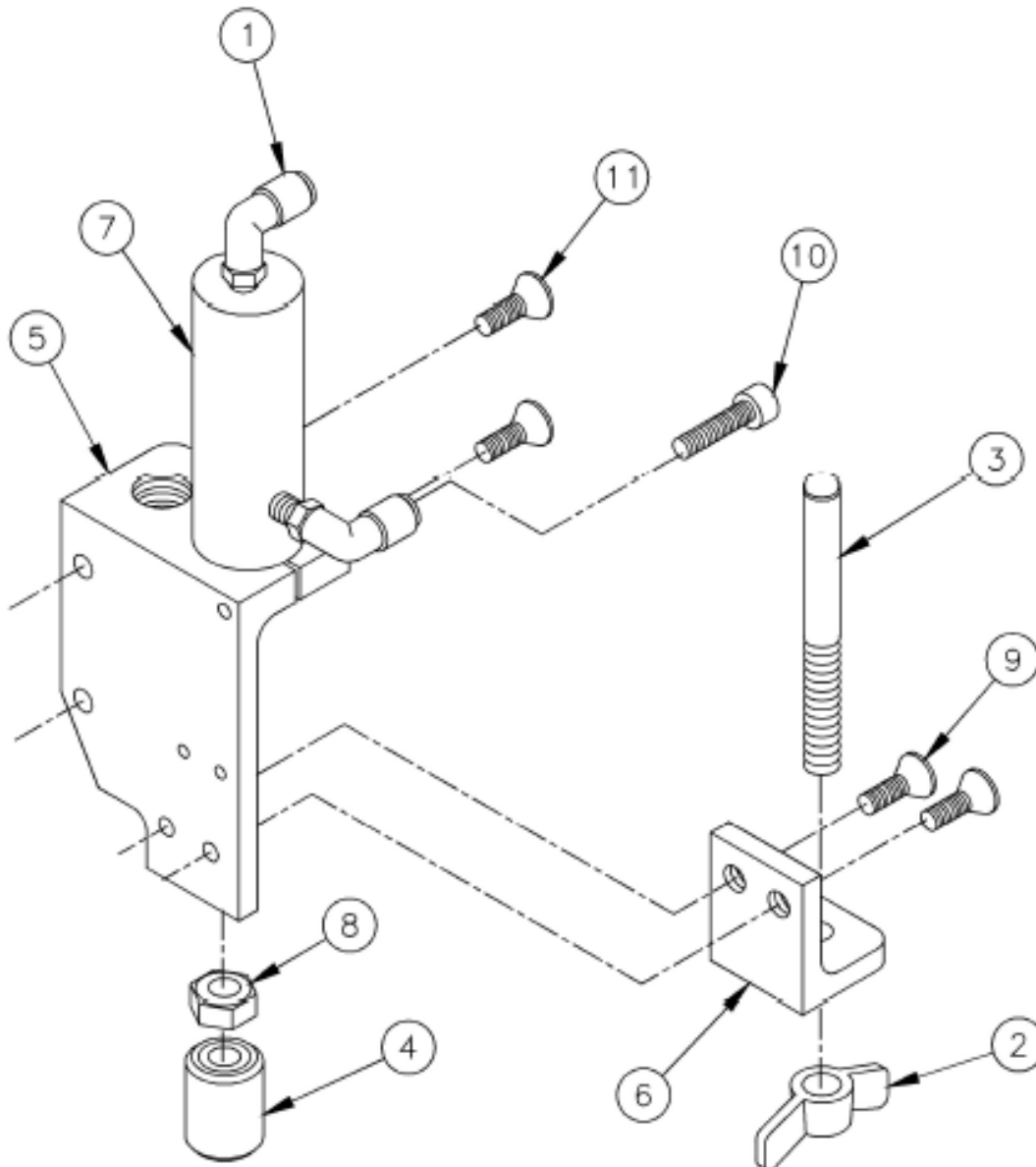
- 1. * DENOTE PARTS SUPPLIED WITH MACHINE.
- ② GRIND THIS STUD FLUSH WITH BACK OF ITEM 1.
- ③ ATTACHES KIT TO MOUNT BRKT ON SEWING HEAD ASSY.
- ④ REUSE LEFT OVER TENSION GUIDE FOR LOOPER THREAD GUIDING.



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	3101760A	Bracket, Main	12	4	SSPS90016	Scr,Pn SI 8-32x1/4
2	1	3101760B	Bracket, Tension	13	1	1975-213	Air Cylinder
*3	3	0093863	Tension Cap	14	1	NNH10-32	Hex Nut
*4	3	0090847	Spring, Tension	15	1	CCCL3F	Collar, Set
*5	3	0090071	Tension Retainer	16	1	NNJ7/16-20	Jam Nut
*6	3	00177	Felt Washer	17	1	NNE10-32	Elastic Nut
*7	6	0031111	Tension Disc	18	2	AA198RA510	Flow Control
*8	3	290029	Tension Post	*19	1	0093556	Looper Thread Eyelet
*9	3	0090812	Tension Ferrule	20	3	WWF8	Flat Washer
*10	3	0090856	Tension Eyelet	21	2	WWF10	Flat Washer
*11	4	0090807	Thread Guide	22	1	AAFF-8	Foot Bracket

011-G6612A Foot Lift Assembly, Pegasus W664

AAC Drawing Number 9008942 Rev 2

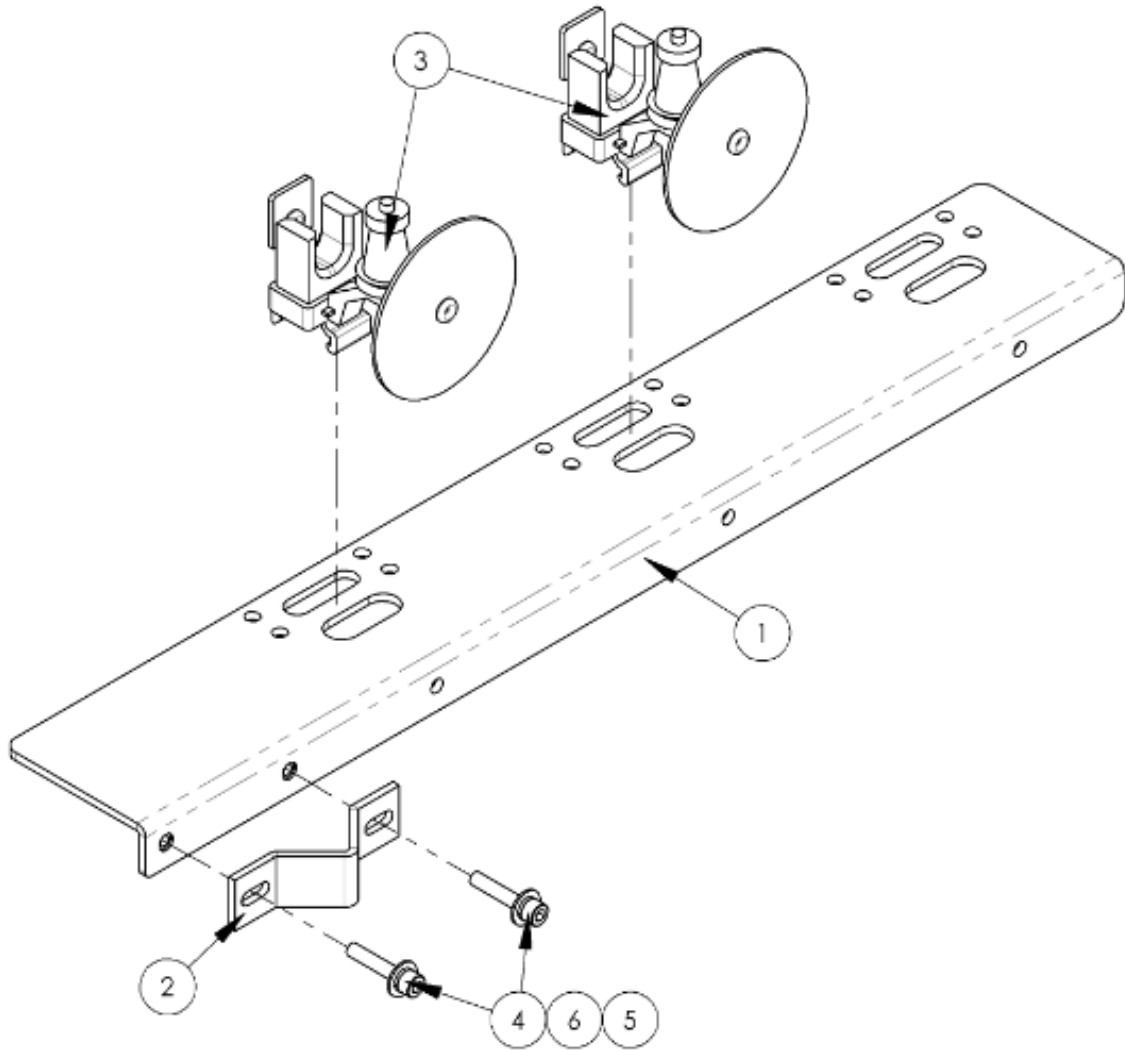


QTY. REOD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	11	SCREW, FLAT ALLEN CAP 6MM X 16MM	SSFCM6X16
1	10	SCREW, SOCKET, SET 10-32 X 1 1/4	SSSC98080
2	9	SCREW, FLAT ALLEN CAP 1/4-20 X 1/2	SSFC01032
1	8	JAM NUT	NNJ5/16-24
1	7	CYLINDER	AAC6D-1
1	6	MOUNT FOOTLIFT LIMIT	010-075A

QTY. REOD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	6	MOUNT FOOTLIFT LIMIT	010-075A
1	5	MOUNT FOOTLIFT CYLINDER	010-074A
1	4	BUMPER	+1200A
1	3	SCREW POST	SSSC35192M
1	2	WING, NUT	NNW3/8-24
2	1	QUICK MALE ELBOW	AAQME-5-8

0411-069E Thread Break Assembly

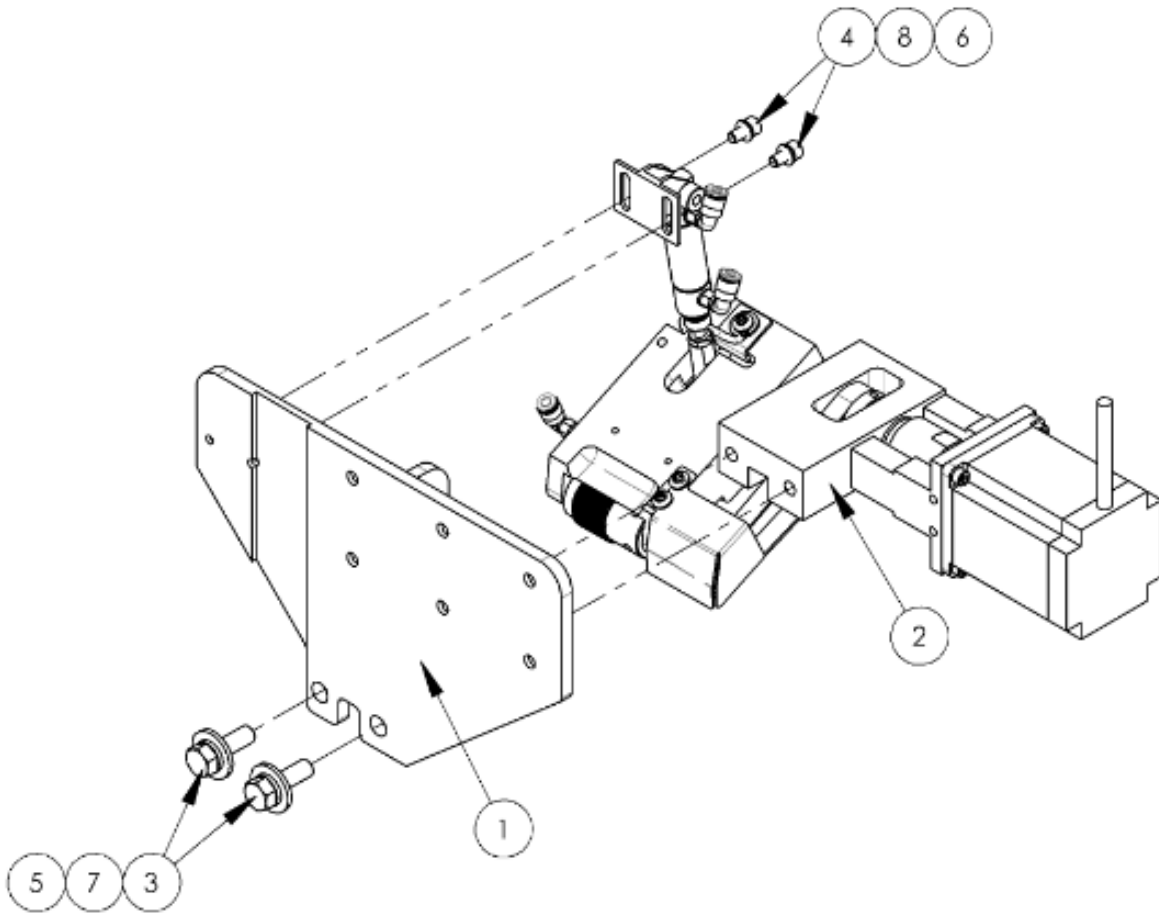
AAC Drawing Number 9008960 Rev 0



ITEM #	QTY.	PART #	DESCRIPTION
1	1	0411-069C	BRKT, THREAD BREAK DETECT
2	1	0411-070	CLAMP, SENSOR BRACKET
3	2	4003-IS3WT2	SENSOR, THREAD BREAK
4	2	SSSC98064	10-32 X 1 SOC CAP
5	2	WWF10	WASHER, FLAT, #10, COM
6	2	WWL10	WASHER, LOCK, #10

211-075B Chain Puller Main Assembly

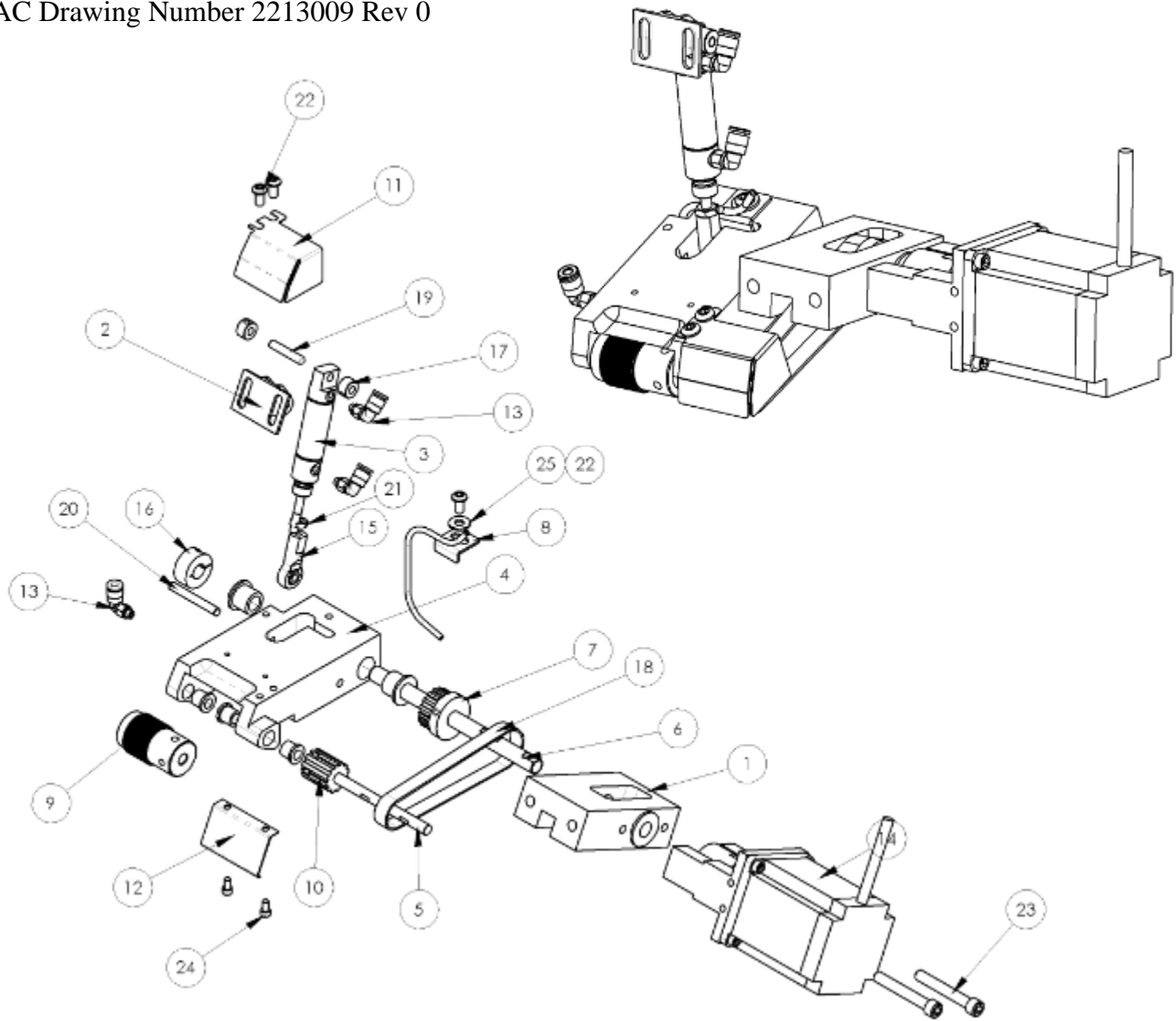
AAC Drawing Number 9008946 Rev 0



ITEM #	QTY.	PART #	DESCRIPTION
1	1	011-075	PLATE, PULLER SASSYMNT
2	1	2213009	CHAIN PULLER ASSY
3	2	SSH10064	5/16-18 X 1 HHCS
4	2	SSSC98024	10-32 X 3/8 SOC CAP
5	2	WWF5/16	WASHER,FLAT,5/16
6	2	WWF8	WASHER, FLAT, #8
7	2	WWL5/16	WASHER,LOCK, 5/16
8	2	WWL8	WASHER,LOCK,#8

2213009 Chain Puller Assembly

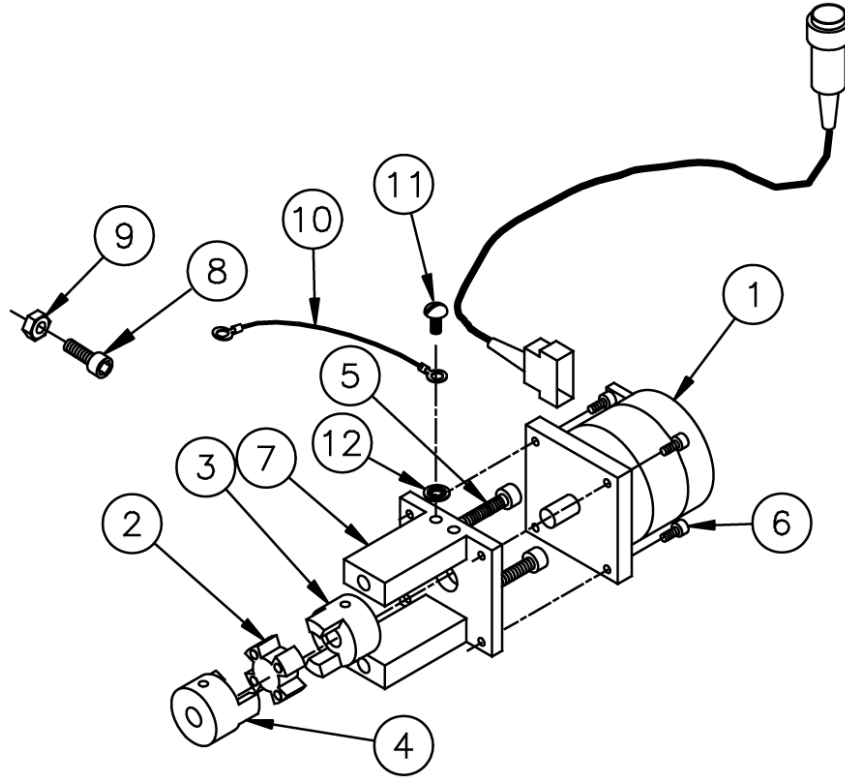
AAC Drawing Number 2213009 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION	ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	011-069B	MOUNT, STEPPING MOTOR	14	1	AP-22E-105	DRIVE MOTOR ASSY, 2A
2	1	011-070	PLATE,CYLINDER MOUNT	15	1	BBAW-3Z	BRG,ROD END,F, 10-32
3	1	1975-213	CYLINDER, AIR, DA, 9/16B, 1/2S	16	1	CCCL6F	CLAMP COLLAR- 3/8
4	1	311-3001C	ARM, PULLER PIVOT	17	2	CCSC33/16	COLLAR,SET,3/16"
5	1	311-3002B	AXLE, LOWER, CHAIN PULLER	18	1	GG100XL037	BELT,GEAR,1/5P,3/8W
6	1	311-3003A	AXLE, UPPER, CHAIN PULLER	19	1	IID012X064	DOWEL PIN,3/16 X 1
7	1	311-3004A	PULLEY,GEAR,1/5 PITCH,16T	20	1	IID012X096	DOWEL PIN,3/16 X 1-1/2
8	1	311-3009	MOUNT HEM BLOW DOWN TUBE	21	1	NNH10-32	HEX-NUT 10-32 REG.
9	1	311-3010B	ROLLER, NARROW CHAIN PULLER	22	3	SSBC98024	10-32 X 3/8 BUTTON CAP SC
10	1	311-3011	PULLEY,1/5 PITCH, 12 TOOT	23	2	SSSC01112	1/4-20 X 1-3/4 SOC CAP
11	1	311-3012	GUARD, BELT CHAIN PULLER	24	2	SSSC80016	6-32 X 1/4 SOC CAP SC
12	1	311-3013	GUARD, CUTTER	25	1	WWFS10	WASHER, FLAT, #10, SAE
13	3	AAQME-5-10	AIR ELBOW, 10-32 X 5/32				

AP-22E-105 Drive Motor Assembly

AAC Drawing Number 190170B Rev 3

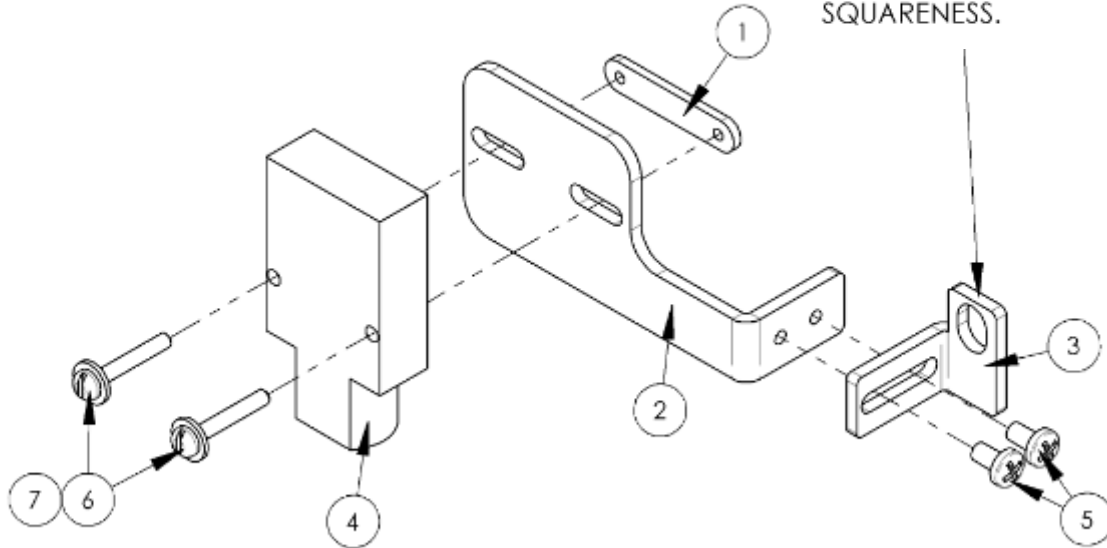


NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	AP-22E-103	Step Motor	7	1	AP-22E-101	Bracket. Motor Adaptor
2	1	MML050	Spider	8	1	SSSC90048	Scr, Socket Cap, 8-32x3/4
3	1	MML050-250	Coupling Body	9	1	NNH8-32	#8 Nut
4	1	MML050-375	Coupling Body	10	1	28128A	Ground Strap
5	2	SSSC01128	Scr, Socket Cap, 1/4-20x2	11	1	SSPS98016	Scr, Pan Head, 10-32 x 1/4
6	4	SSSC90032	Scr, Socket Cap, 8-32x1/2	12	1	WWSI10	Internal Star Washer

211-153B Electric Eye Assembly

AAC Drawing Number 9008947 Rev 0

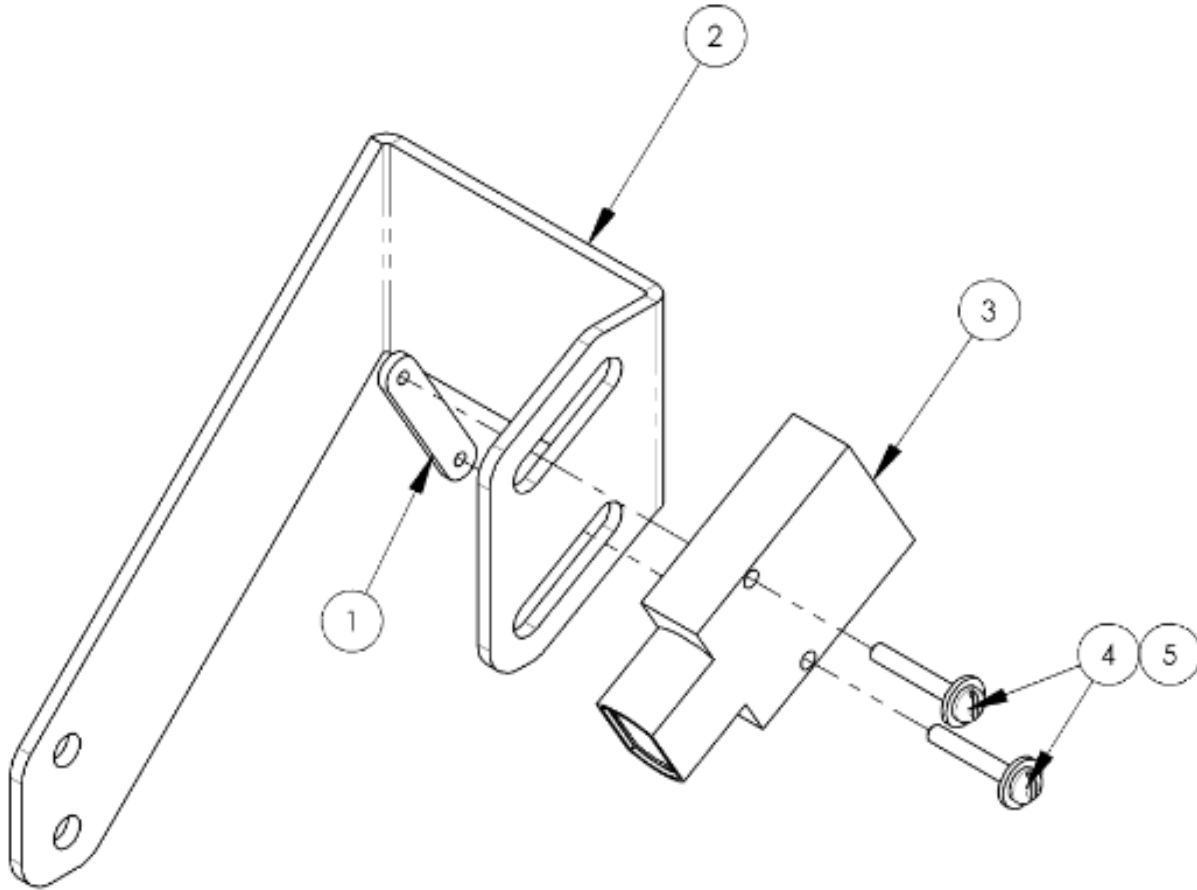
NOTE:
 - THIS ASSEMBLY IS INSTALLED ON TOP OF THE FIXTURE PROVIDED WITH THE SEWING HEAD.
 - THE EDGE THE LEADER POINTS RESTS AGAINST THE FIXTURE FOR SQUARENESS.



ITEM #	QTY.	PART #	DESCRIPTION
1	1	1975-412A	PLATE,NUT,4-40,.95CTC
2	1	211-153	EYE MOUNT, FRONT
3	1	211-154A	EYE BRACKET, REAR
4	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
5	2	SSPP80016	#6-32X1/4 PAN PHILLIPS
6	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
7	2	WWF4	WASHER, FLAT, #4

311-120B Electric Eye Assembly

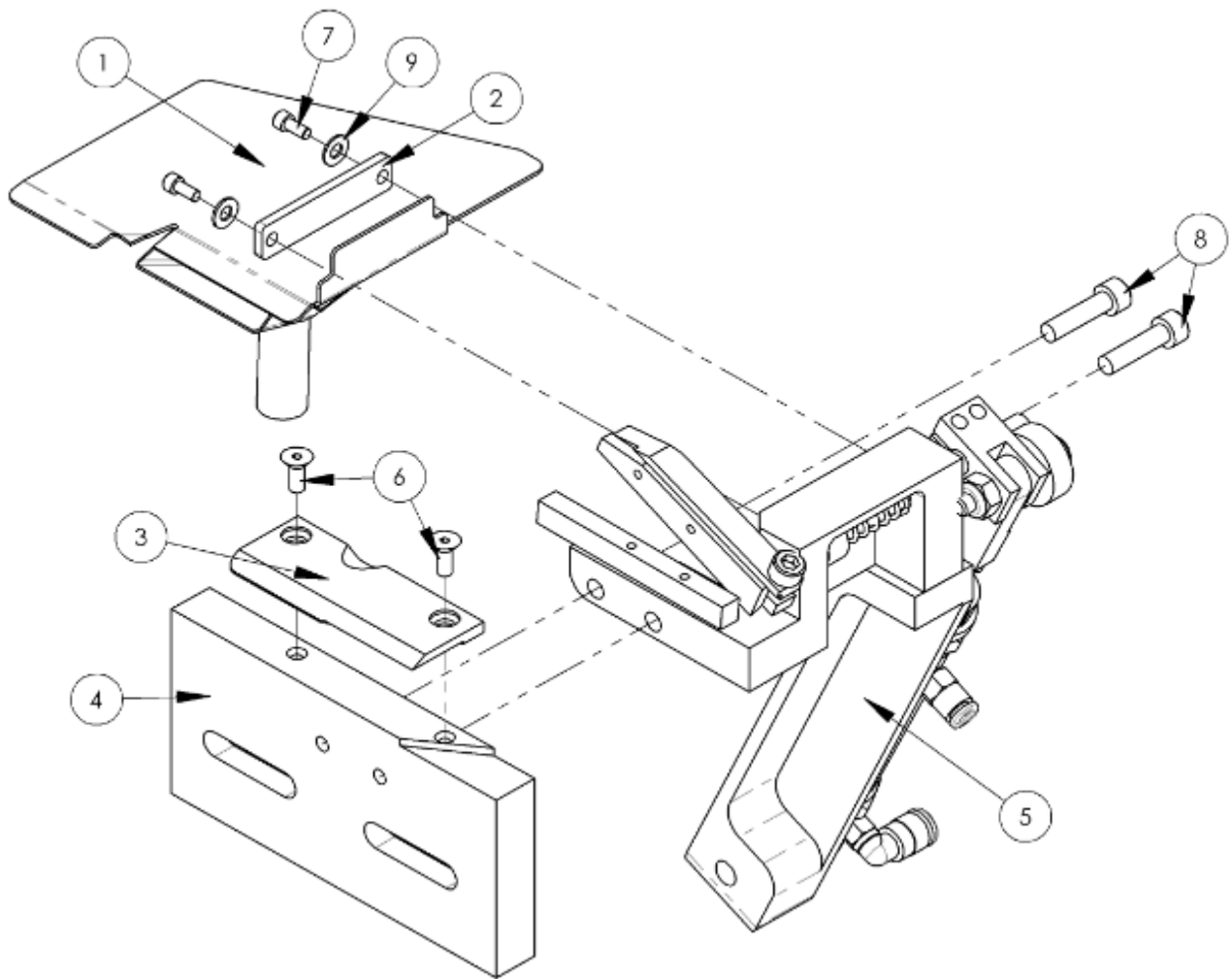
AAC Drawing Number 9008943 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1975-412A	PLATE,NUT,4-40,.95CTC
2	1	311-120A	POSITION SENSOR MOUNT BRACKET, PEGASUS
3	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
4	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
5	2	WWF4	WASHER, FLAT, #4

311-2000G Chain Trimmer, Pegasus W664

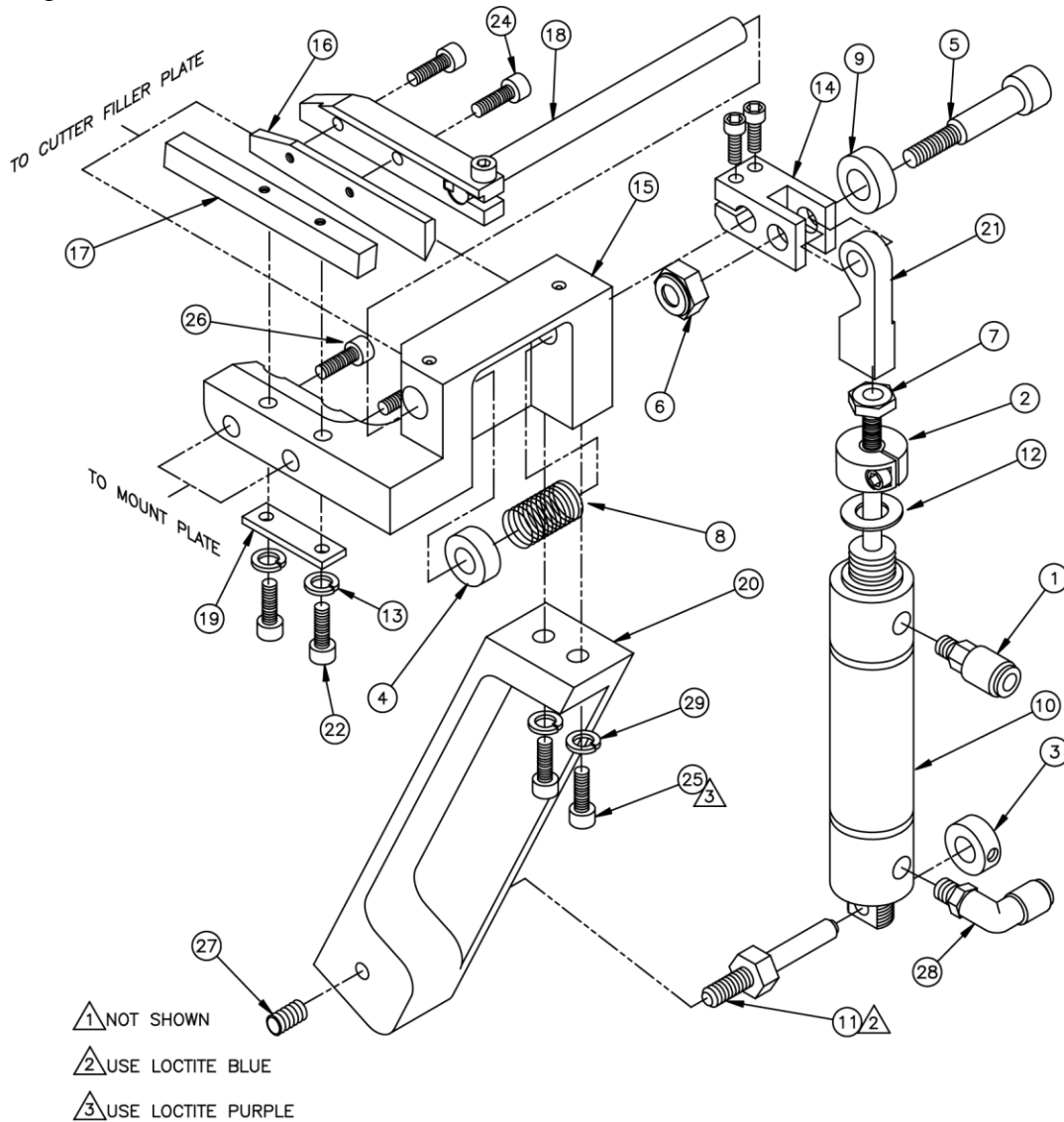
AAC Drawing Number 9008945 Rev 0



ITEM #	QTY.	PART #	DESCRIPTION
1	1	0411-1055	PLATE ASSY, VACUUM CHAIN TRIMMER ASSY
2	1	311-20016	PLATE,WASHER
3	1	311-2002A	PRESSURE PLATE
4	1	311-2009I	CHAIN, CUTTER MOUNT, PEGASUS
5	1	311-2017	THREAD TRIMMER ASSEMBLY
6	2	SSFC80024	6-32 X 3/8 FLAT CAP
7	2	SSSC70016	4-40 X 1/4 SOCKET CAP
8	2	SSSC98048	10-32 X 3/4 SOC CAP
9	2	WWB6S	WASHER, FLAT, 5/32", BRAS

311-2017 Thread Trimmer Assembly

AAC Drawing Number 191337C Rev 13

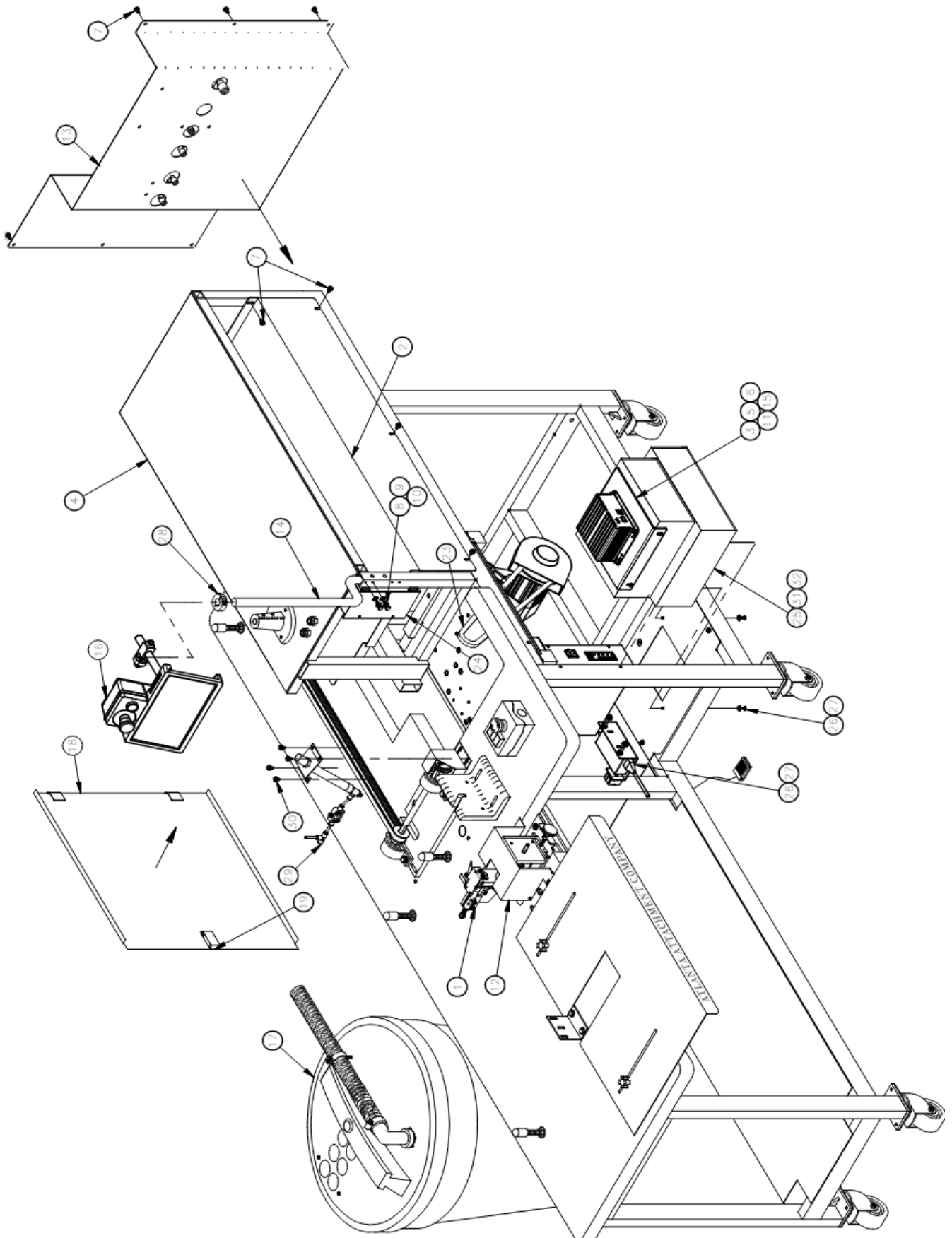


NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	AAQMC-5-10	Quick Male Conn	16	1	311-2005	Cutter Blade, Mov
2	1	CCCL3F	Collar, Clamp 3/16	17	1	311-2006	Blade, Stationary
3	1	CCSC33/16	Collar, Set 3/16	18	1	311-2007	Upper Cutter Holder
4	1	CCSC41/4	Collar, Set 1/4	19	4	0411-120	Washer Plate
5	1	SSM4633	Scr,Al Sh 1/4x3/4	20	1	311-2013	Mount, Cylinder
6	1	NNE10-32	Elastic Nut	21	1	1975-408	Drive Link
7	1	NNH10-32	Hex Nut	22	2	SSSC70048	Scr,So Cp 4-40x3/4
8	1	RRLC045E10	Spring	23	1	311-2018	Adjustment Instructions
9	1	WWFF1/4	Felt Washer	24	2	SSSC70012	Scr,So Cp 4-40x3/16
10	1	1975-213B	Cylinder, Air	25	2	SSSC98048	Scr,So Cp 10-32x3/4
11	1	1976-048D	Stud, Cyl Mount	26	2	SSSC98040	Scr,So Cp 10-32x5/8
12	1	273-4-503	Leather Washer	27	1	SSSS10016	Scr,So Set 5/16-18x1/4
13	2	WWL4	Lock Washer	28	1	AAQME-5-10	Quick Male Elbow
14	1	311-2003	Clevis	29	2	WWL10	Lock Washer
15	1	311-2004	Cutter, Body				

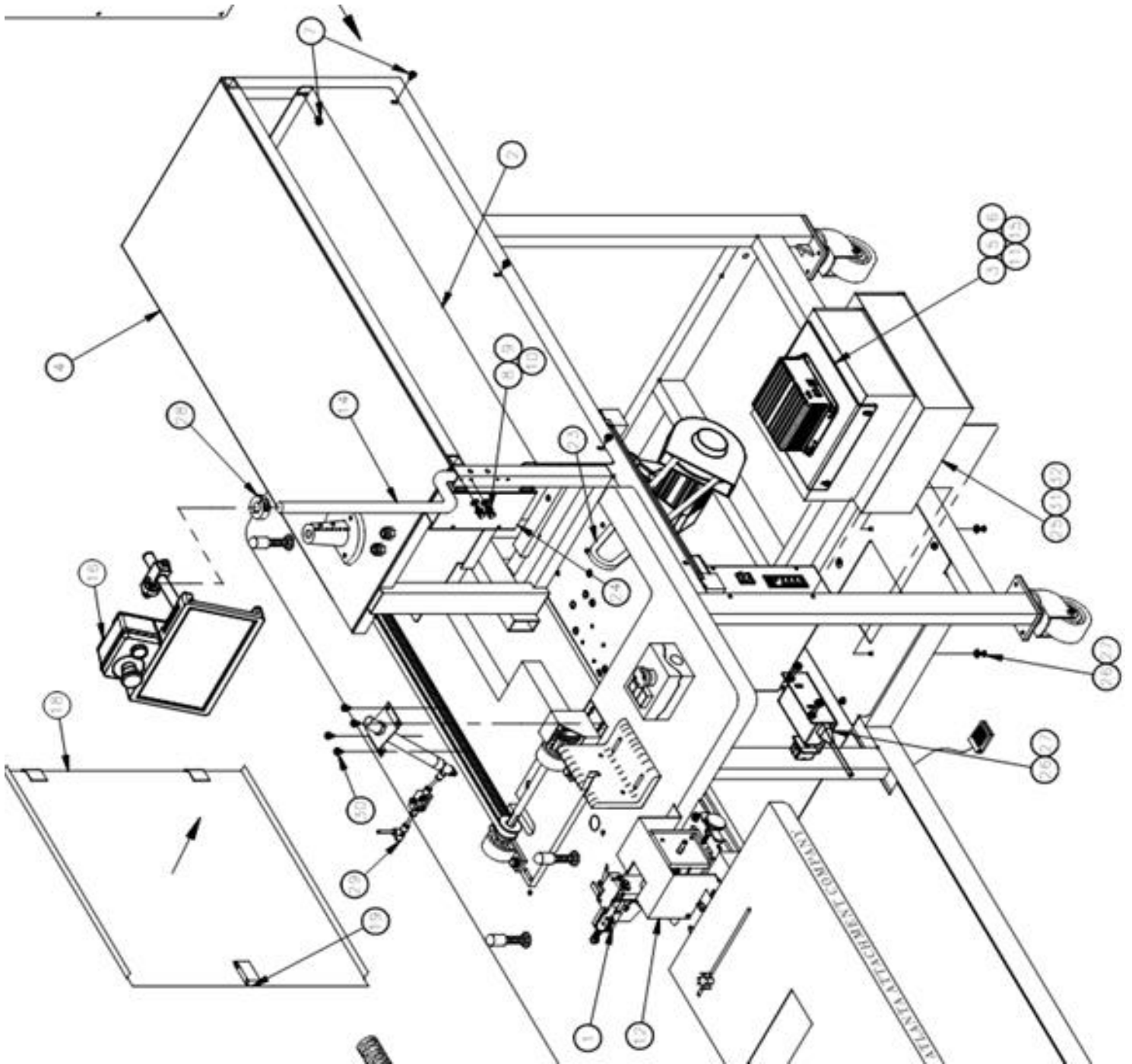
Workstation Details

213E-200F Frame and Table Assembly, Efka

AAC Drawing Number 192184E Rev 0



Enlarged Center View

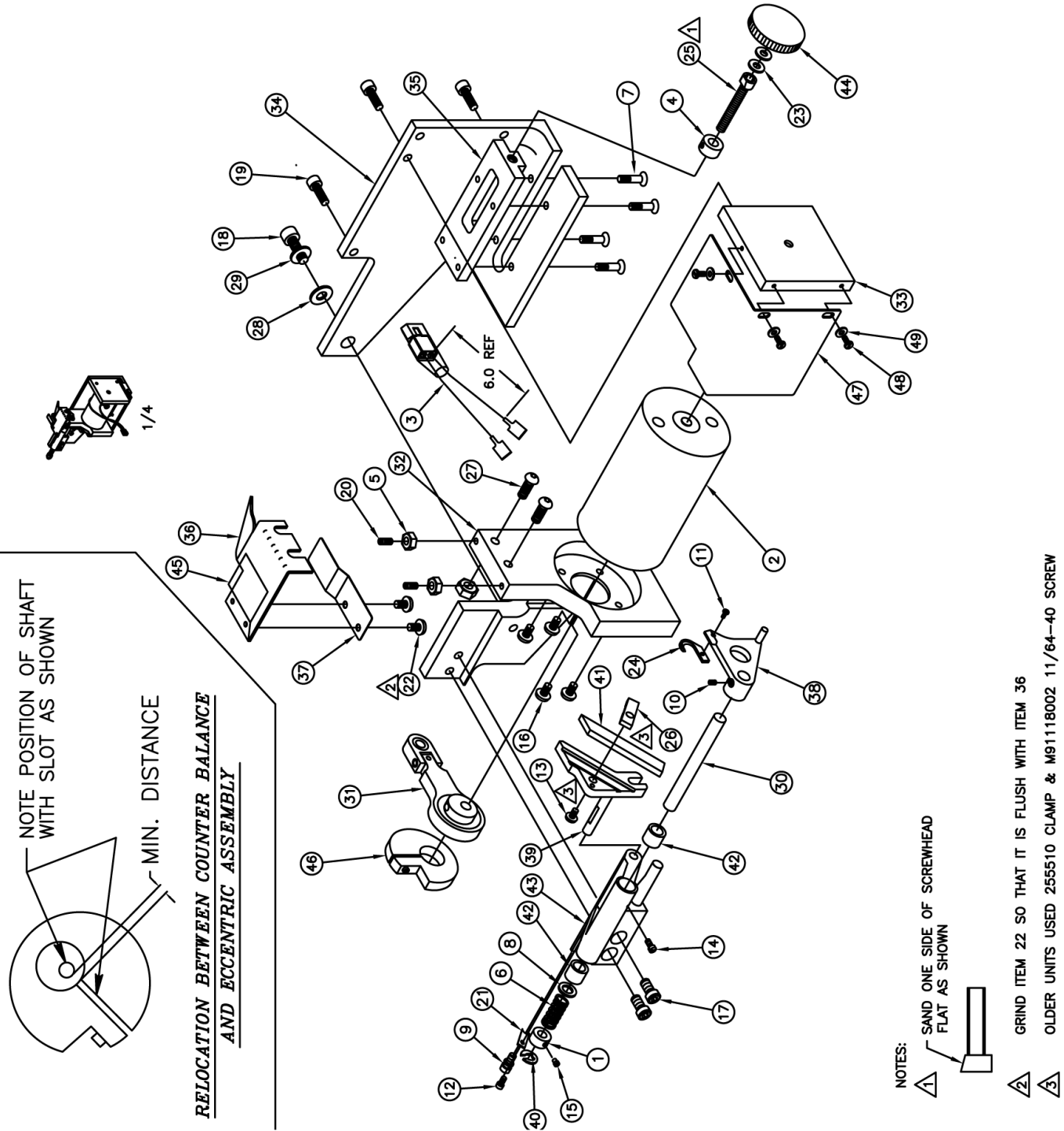


213E-200F parts list

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE	QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	.	CABLE POST, 23140A, LONG EFGCABLE, PA DC1500, 6%	0211-702E	1	19	SLIDE LATCH	MM40450010
1	.	LABEL, CONNECT V BELT	26276F	1	18	DOOR, ELEC BOX	010-122
1	.	LABEL, 220 VOLTS	26276D	1	17	WASTE CAN	0411-1300
1	.	LABEL, REG & PANEL	26237ALAB	1	16	MOUNT, TOUCH SCREEN	4082006
1	.	ACCROLUBE GREASE	ZZZSR-109	2	15	SCREW, PAN, 6-32X3/8	SSPP80024
AR	.	WIRING DIAGRAM	213-SWD1	1	14	ROD, CONT BOX SUP.	211-126-2
AR	.	PNEUMATIC DIAGRAM	213-SPD	1	13	REGULATOR ASSEMBLY	314-Y6607
1	32	BOX TOP W/STAND-OFF	AP-28-803C	1	12	COVER, TRIMMER MOTOR	211-098
1	31	CONTROL BOX, STEPPER	AP-28-620B	1	11	PC GATEWAY	EEJBC375CG
4	30	SCREW, HEX SHEET METAL #10X1	SSZH#10064	2	10	1/4 LOCK WASHER	WWL1/4
1	29	HEAD LIFT SUB ASSEMBLY	011-086	2	9	1/4 WASHER	WWF1/4
1	28	COLLAR, CLAMP, 3/4	CCCL12F	2	8	SCREW, HEX, CAP 1/4-20 X 3/4	SSHCO1048
4	27	WASHER, FLAT, 8	WWF8	13	7	SCREW, SHEET METAL 10-16 X 1/2 (SELF DRILL)	SSZS93032
4	26	SCREW, PAN HEAD SLOTTED 8-32 X 1/2	SSPS90032	4	6	KEP NUT, 10-32	NNK10-32
1	25	CONTROL BOX, STEPPER	AP-28-800W	2	5	WASHER, FLAT, 6	WWFS6
1	24	COVER, WIRE CONDUIT	011-084	1	4	TABLE ASSEMBLY	213E-201F
1	23	V BELT	ZX3840	1	3	PC MOUNT PLATE	4082013
0	22	THREAD STAND	011-136	1	2	COVER PLATE	311-020
0	21	THREAD STAND	011-149	1	1	EDGE TRIMMER	211-121A

211-121A Edge Trimmer Assembly, SBUS

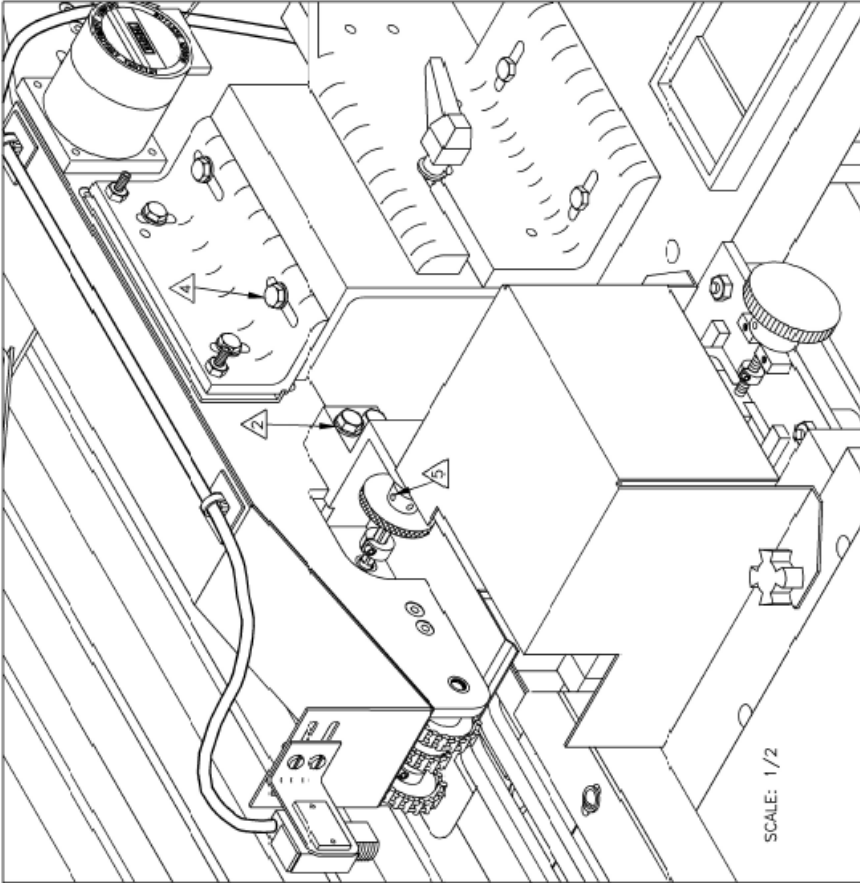
AAC Drawing Number 192051C Rev 6



211-121A parts list

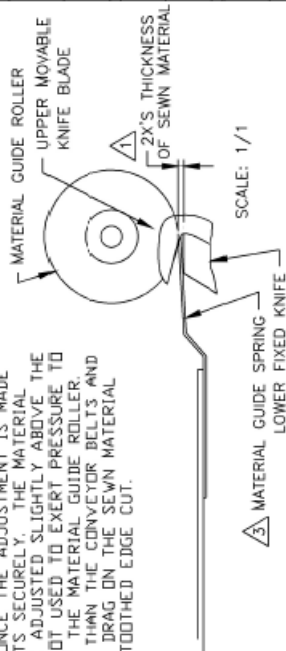
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	CC192024	COLLAR	26	1	255510-PEG	CLAMP
2	1	EEMS221005C	MOTOR	27	2	SSBC01032	SCREW, BUTTON CAP 1/4-20 X 1/2
3	1	211-172	CABLE	28	1	WWFS1/4	SAE WASHER
4	1	CCSC41/4	1/4 SET COLLAR	29	1	WWL1/4	LOCK WASHER
5	2	NNH8-32	HEX NUT	30	1	255508-2	SHAFT
6	1	RR306105	SPRING	31	1	010-027	ECCENTRIC ASSY
7	4	SSFC90032	SCREW, FLAT ALLEN CAP 8-32 X 1/2	32	1	010-029A1	DC MOTOR MOUNT
8	1	SSM207045	WASHER	33	1	010-029B1	DC MOTOR MOUNT
9	1	SSM255513	SCREW 11/64-40 X 7/32	34	1	010-031	MOUNT, MOTOR
10	1	SSM4547	SCREW, SOCKET SET M6 X .75 X 5	35	1	010-032	BLOCK, MOTOR ADJ.
11	1	SSM5109	SCREW 1/8-44 X 13/64	36	1	010-036A	PLATE,CUTTER GUARD
12	1	SSM7010	SCREW M3 X .5 X 6mm	37	1	010-042	PLATE,SPRING,CUTTER
13	1	SSSCM5X10	SCREW M5 X 10 SOC CAP	38	1	255507-91	HOLDER, UPPER CUTTER
14	1	SSM7036	SCREW M4 X .7 X 6mm	39	1	255509	HOLDER, LOWER CUTTER
15	1	SSM22570	SCREW, FILLISTER, 182-40 X 3/16	40	1	202522	RING
16	4	SSPS80032	SCREW, PAN HD SLOTTED 6-32 X 1/2	41	1	204351	CUTTER, LOWER
17	2	SSSC01040	SCREW, SOCKET CAP 1/4-20 X 5/8	42	2	240099	NEEDLE BEARING
18	1	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1	43	1	255506	BRACKET, CUTTER
19	4	SSSC95040	SCREW, SOCKET CAP 10-24 X 5/8	44	1	TTK32315	TORQUE KNOB
20	2	SSSS90032	SCREW, SOCKET SET 8-32 X 1/2	45	1	MMFELT	1 X 1.25 FELT PAD
21	1	255511-PEG	GUIDE	46	1	010-037A	COUNTER BALANCE
22	2	SST585008	SCREW, TRUSS SLOTTED 6-40 X 1/8	47	1	211-137	COVER
23	2	SST585008	5/32 BRASS WASHER	48	3	SSPS80024	SCREW, PAN SLOTTED 6-32 X 3/8
24	1	306394	CUTTER, UPPER	49	3	WWFS6	WASHER, FLAT, SAE
25	1	SSSC05128F	SCREW, SOCKET CAP 1/4-28 X 2	50	0	010-042A	PLATE,SPRING,CUTTER

011-INST1 Material Adjustment

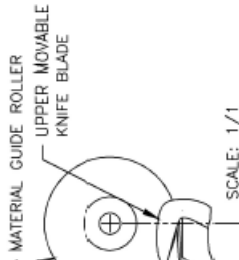


THE MATERIAL GUIDE ROLLER SHOULD BE ADJUSTED IN THREE DIMENSIONS:

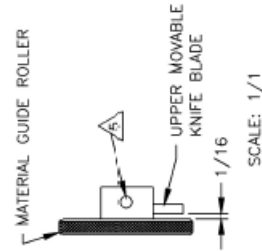
1. THE MATERIAL GUIDE ROLLER SHOULD BE LOCATED VERTICALLY AT A HEIGHT OF 2X'S THE THICKNESS OF THE SEWN MATERIAL ABOVE THE LOWER FIXED KNIFE. THIS IS ACCOMPLISHED BY LOOSENING THE TWO 1/4"-20 BOLTS Δ ATTACHING THE MATERIAL GUIDE ROLLER SUPPORT BLOCK TO THE FRAME OF THE UPPER CONVEYOR CASE SHOULD BE TAKEN TO KEEP THE SUPPORT BLOCK MOVED TO THE RIGHT AT IT IS ALSO USED TO TENSION THE DRIVE BELT. ONCE THE ADJUSTMENT IS MADE TIGHTEN THE TWO 1/4"-20 BOLTS SECURELY. THE MATERIAL GUIDE SPRING Δ SHOULD BE ADJUSTED SLIGHTLY ABOVE THE LOWER FIXED KNIFE. IT IS NOT USED TO EXERT PRESSURE TO HOLD THE MATERIAL AGAINST THE MATERIAL GUIDE ROLLER. THE ROLLER MOVES SLOWER THAN THE CONVEYOR BELTS AND ANY PRESSURE WILL CREATE DRAG ON THE SEWN MATERIAL CAUSING A RAGGED OR SAW-TOOTHED EDGE CUT.



2. THE MATERIAL GUIDE ROLLER SHOULD BE ADJUSTED ALONG THE SEWING PLANE SO AS TO BE CENTERED AT THE RIGHT 1/3 OF THE CUTTING EDGE OF THE UPPER MOVABLE KNIFE BLADE. THIS IS ACCOMPLISHED BY LOOSENING THE TWO 1/4"-20 BOLTS Δ LOCATED IN THE SLOTTED HOLES OF THE UPPER CONVEYOR MOUNTING BRACKET. AFTER LOCATING THE MATERIAL GUIDE ROLLER PROPERLY, TIGHTEN THE TWO 1/4"-20 BOLTS SECURELY.



3. THE MATERIAL GUIDE ROLLER SHOULD BE ADJUSTED ALONG THE DRIVE SHAFT TO LEAVE 1/16" CLEARANCE BETWEEN THE ROLLER AND THE UPPER MOVABLE KNIFE BLADE. THIS IS ACCOMPLISHED BY LOOSENING THE SET SCREWS Δ IN THE MATERIAL GUIDE ROLLER AND MOVING THE ROLLER ALONG THE SHAFT UNTIL THE DESIRED 1/16" CLEARANCE IS REACHED. TIGHTEN THE SET SCREWS



NOTE: THIS ADJUSTMENT WILL HAVE TO BE REPEATED EVERY TIME THE MATERIAL TRIMMING KNIFE IS ADJUSTED FOR THE AMOUNT OF TRIM OFF.

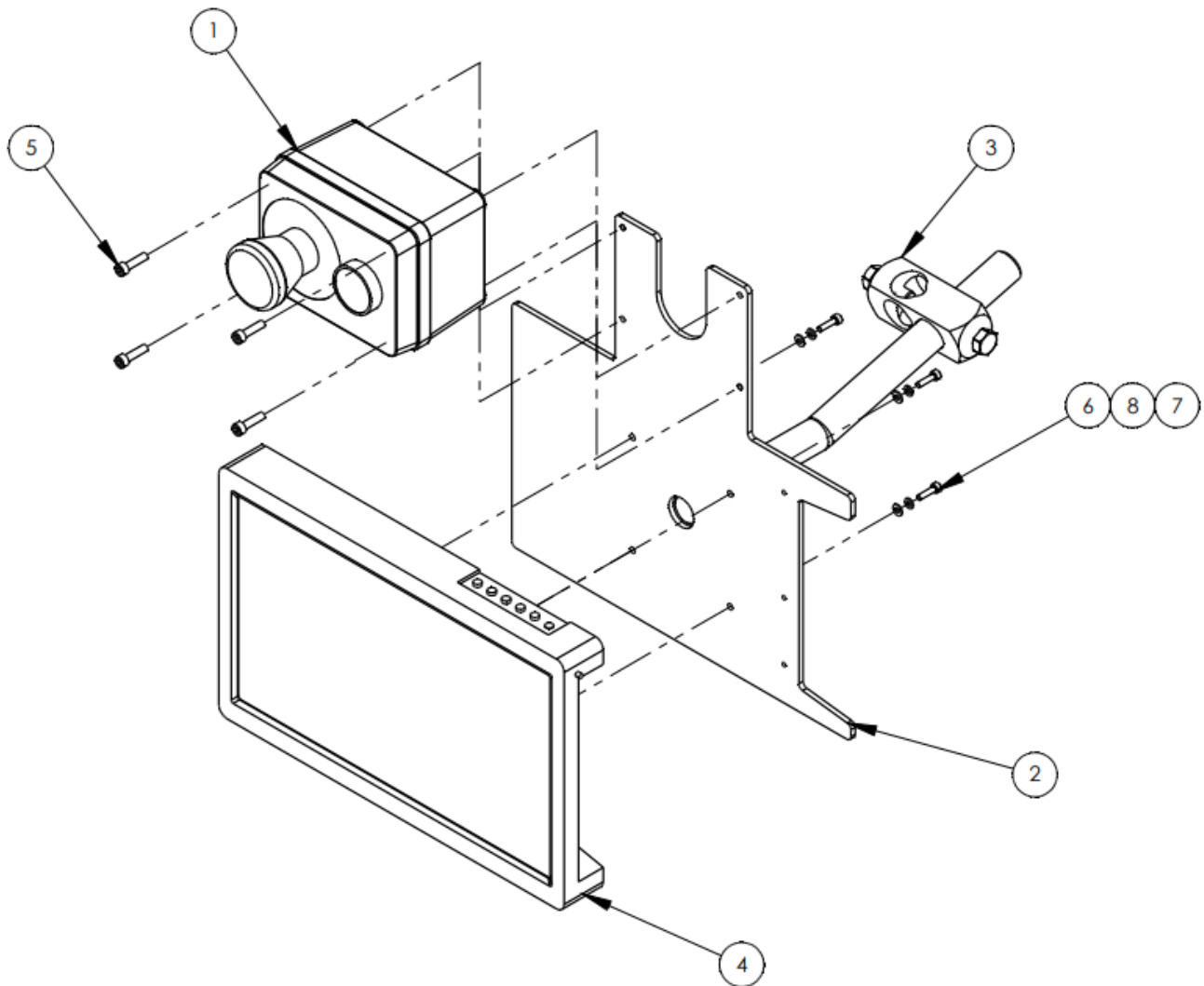
		ATLANTA ATTACHMENT COMPANY DRAWING NO. 290035C REV. 0	
2nd DES. MATERIAL ADJ. GUIDE ROLLER		DRAWING NO. 290035C REV. 0	
PART NO. 011-INST1		QTY. ITEM RECD. NO.	
NAME: ADJUSTMENT-MATERIAL 2nd DES. GUIDE ROLLER, 011-06607		DESCRIPTION: ATLANTA ATTACHMENT COMPANY	
MATERIAL NOTED		PART NO. STOCK SIZE	
ASSEMBLY 011-06607		NAME: ADJUSTMENT-MATERIAL	
DR. BY DAVID BRAUNER		PART NO. 011-INST1	
CK. BY DANNY MURPHY		DRAWING NO. 290035C REV. 0	
SCALE 1/2 DATE: 12/1/93 MACH. C.		DATE: 12/1/93	
FINISH		COUNTERSINKS: .02	
DECIMAL TOLERANCE:		.X = ±.010	
.XX = ±.005		.XXX = ±.002	
.XXXX = ±.0005		FRACTIONS = 1/64	



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4082006 HMI Touch Screen Assembly

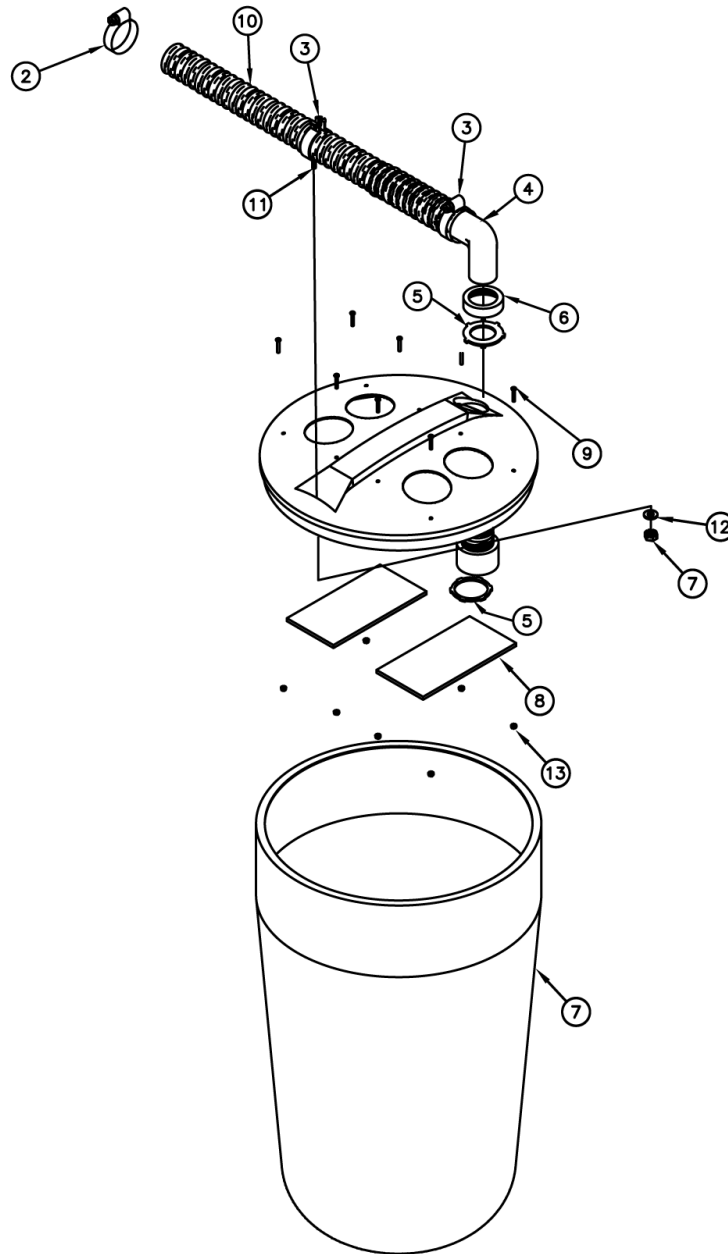
AAC Drawing Number 4082006 Rev 0



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1278 6010	START/STOP BUTTON ASSY
2	1	13311126	MOUNT, 10" TOUCH SCREEN,
3	1	28201	CROSS BLOCK, 3/4 X 3/4
4	1	4082105	TOUCHSCREEN, 10",SUB ASSEMBLY
5	4	SSSC90040	8-32 X 5/8 SOC CAP SC
6	4	SSSCM3X12	M3-0.5X12 ,SOCKET CAP
7	4	WWFM3	FLAT WASHER, M3
8	4	WWLM3	WASHER, LOCK, M3

0411-1300 Waste Container Assembly

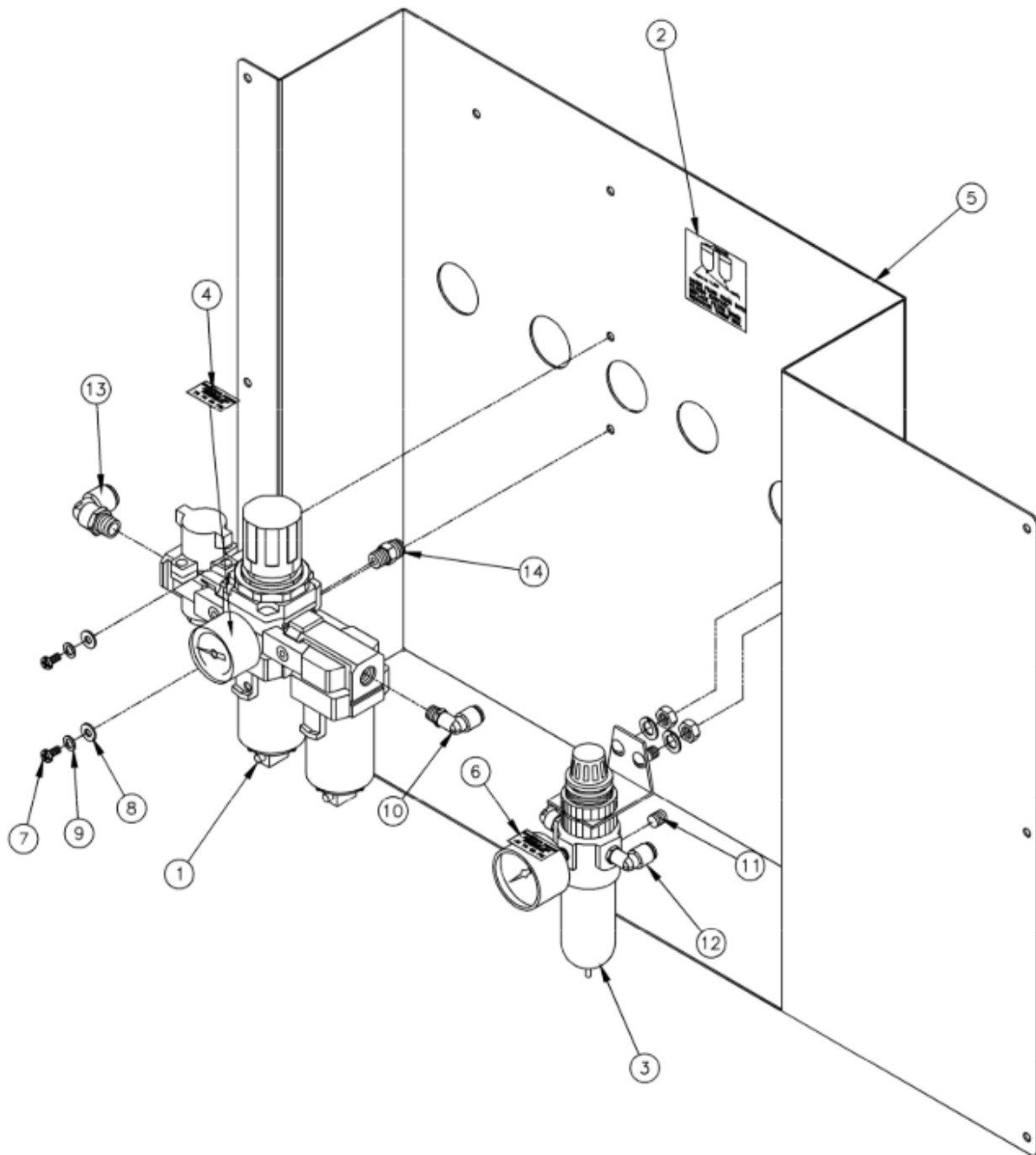
AAC Drawing Number 191225C Rev 10



NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	MMTC32GTAN	CONTAINER, WASTE	8	2	26285A	FILTER, WASTE SYS
2	2	MM5415K16	HOSE CLAMP	9	8	SSPS90064	SCREW, PAN HD SLOTTED 8-32 X 1
3	1	MM16300	TUBE CLAMP	10	6'	MMFH150	FLEX HOSE
4	1	MMRPL150	PLAIN ELBOW	11	1	SSHCO1032	SCREW, HEX CAP 1/4-20 X 1/2
5	2	MMTC32GLN	1 1/2 CONDUIT LOCK NUT	12	1	WWF1/4	WASHER, FLAT
6	1	MMTC32GR	REDUCER	13	8	NNK8-32	8-32 KEP NUT
7	1	NNK1/4-20	NUT	14			

314-Y6607 Regulator Assembly

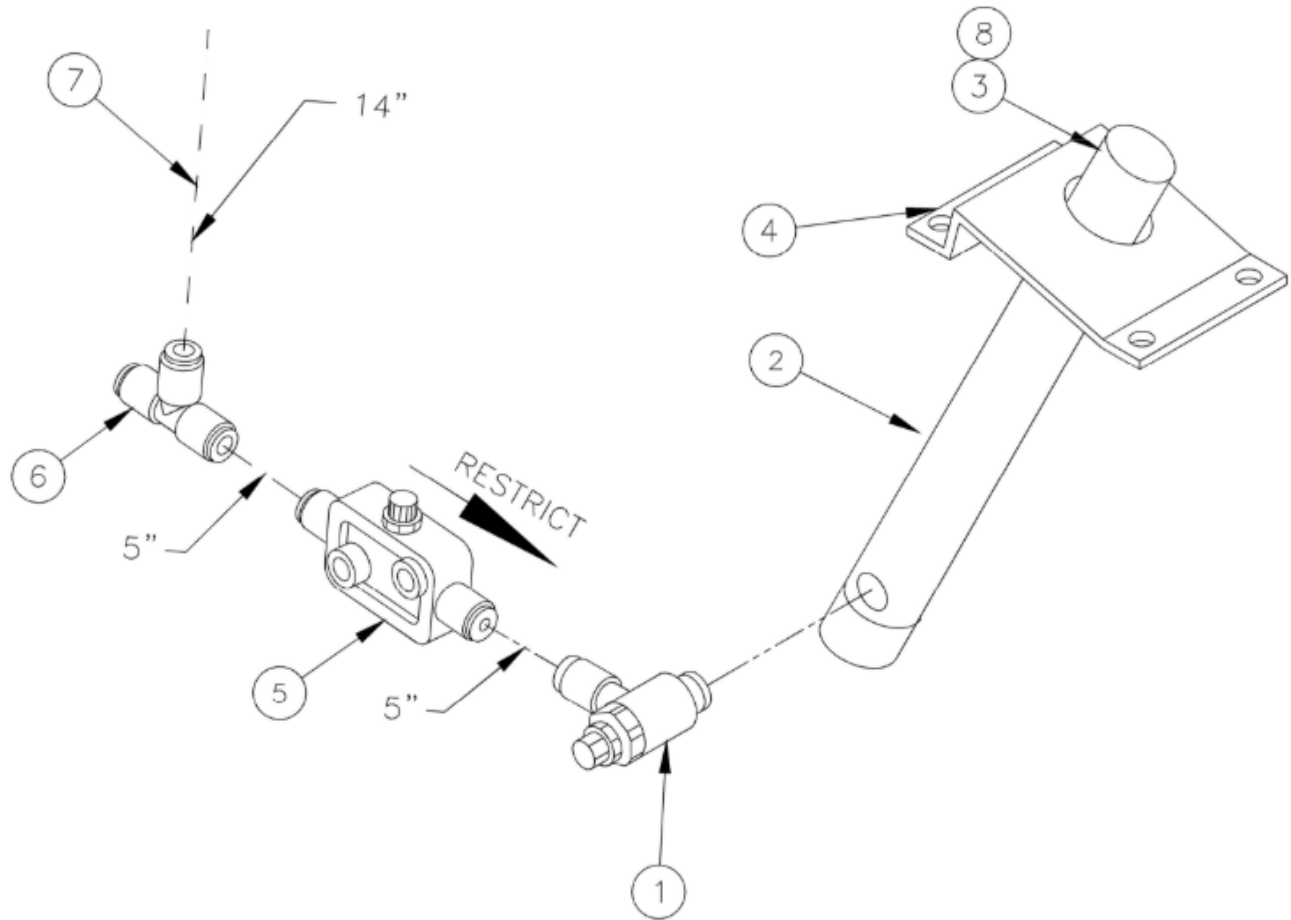
AAC Drawing Number 191076C Rev 4



QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE	QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	15	ADAPTER,PRESSURE GAUGE	AA198-5110A	2	8	NO. 10 WASHER	WWFS10
1	14	QUICK MALE CONNECTOR	AAQMC-4-4	2	7	SCREW, PAN PHILLIPS 10-32 x 1/2	SSPP98032
1	13	QUICK MALE ELBOW	AAQME-3-4	1	6	LABEL 40 PSI	013-124
REF	12	QUICK MALE ELBOW	AAQME-4-8	1	5	FILTER PANEL	013-105
1	11	1/8 PIPE PLUG	MM4554K11	1	4	LABEL 70-80 PSI	013-124
1	10	QUICK MALE ELBOW	AAQME-4-4	1	3	REGULATOR	AA198-5
2	9	NO. 10 LOCK WASHER	WWL10	1	2	LABEL	26237ALAB1
				1	1	AIR REGULATOR W/FILTER	AA198-5110

011-086 Head Lift Assembly

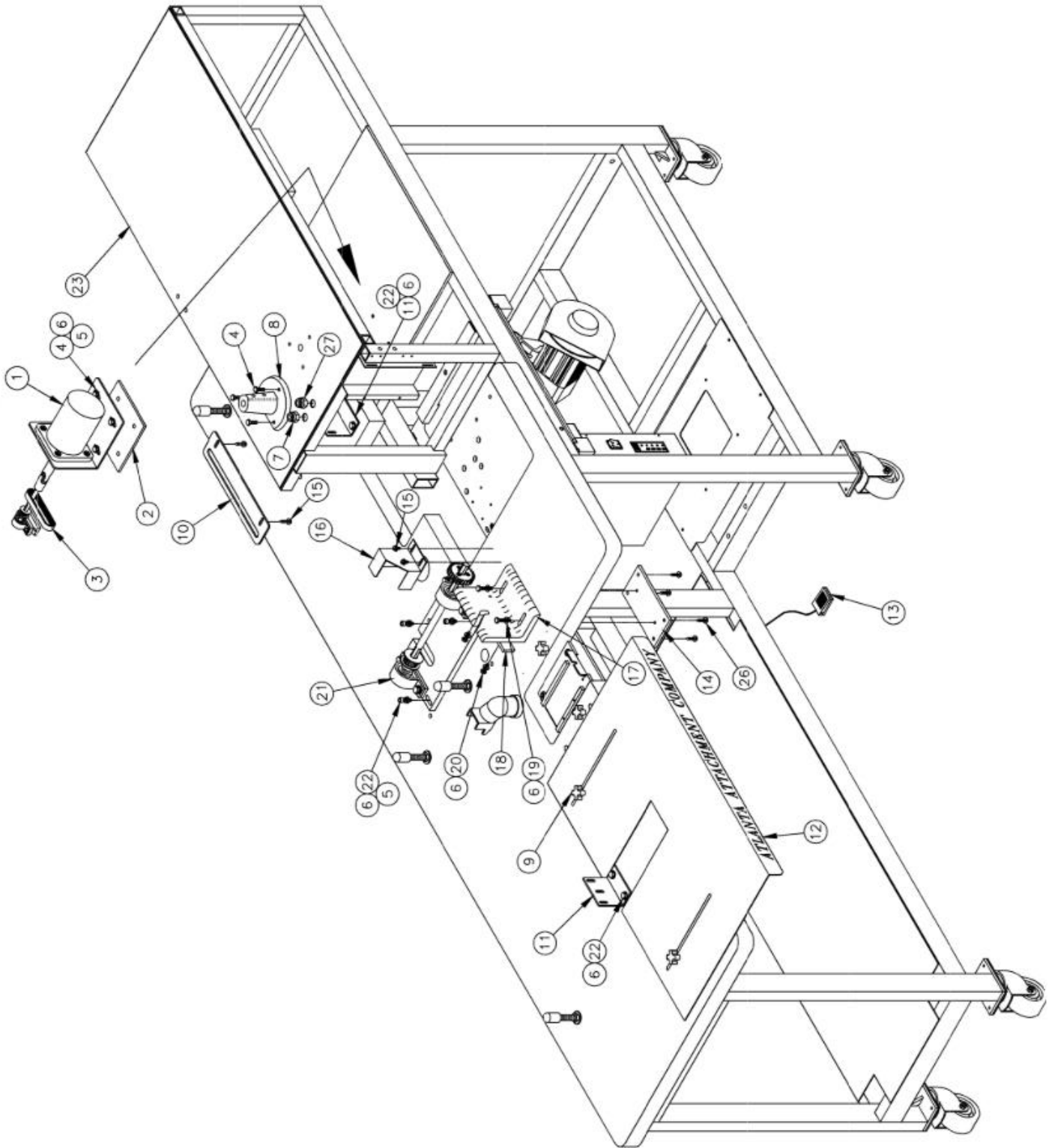
AAC Drawing Number 190473A Rev 4



QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	8	JAM NUT	NNJ5/16-18
2'	7	5/32" AIRLINE	AATP5/32
1	6	UNION T	AAQUT-5-5
1	5	IN LINE FLOW CONTROL	AA2000F-03
1	4	MOUNT BRKT	O10-096A
1	3	BUMPER	1535E-181
1	2	AIR CYLINDER	AAC6DP-4
1	1	FLOW CONTROL	AA198RA508

213E-201F Table Sub-Assembly

AAC Drawing Number 192185D Rev 0

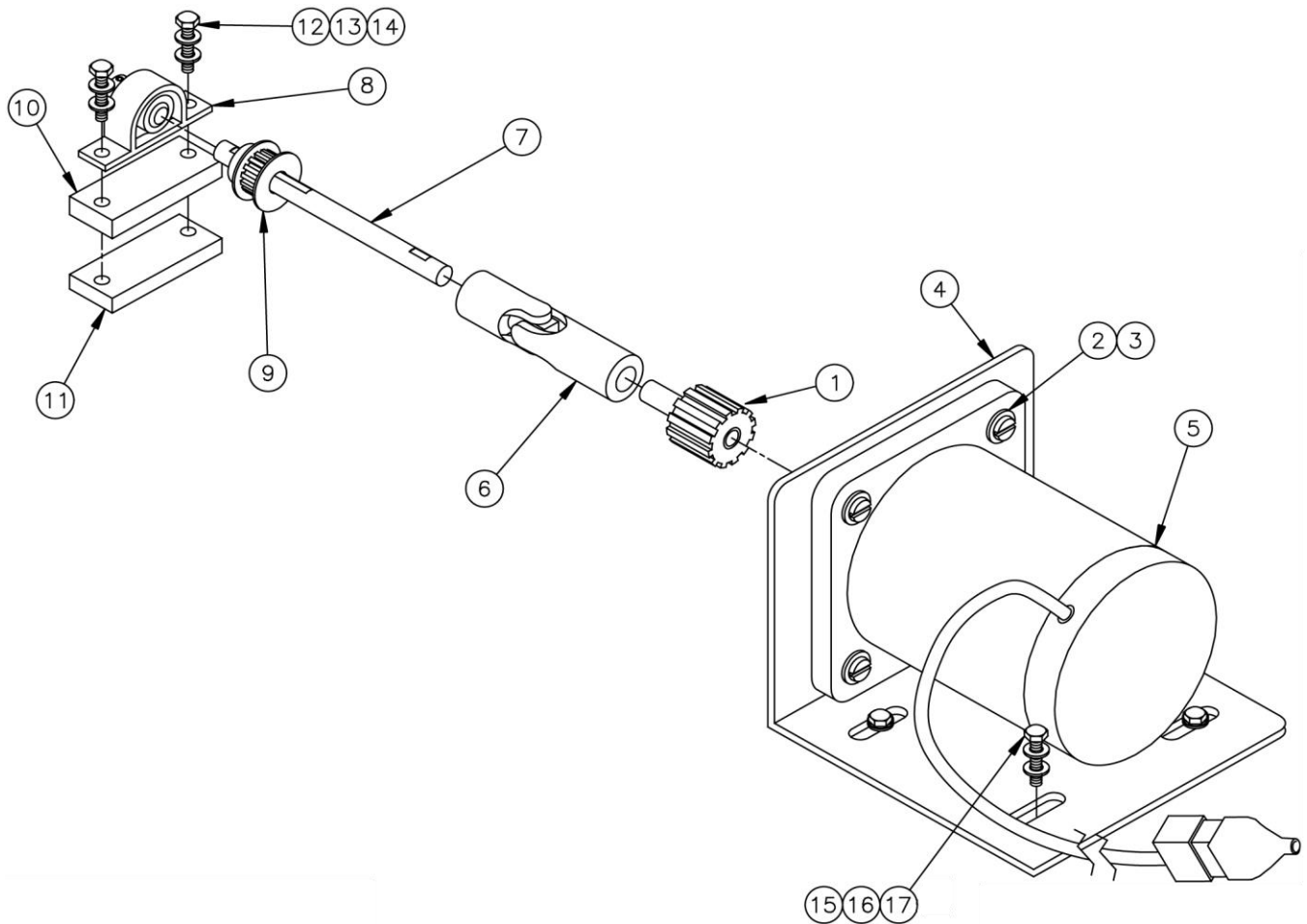


213-201F parts list

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
5'	28	AIRLINE	AATP5/8
1	27	BULKHEAD UNION	AAQBU-3-3
4	26	SCREW, HEX SHEET METAL NO. 10 X 1 1/2	SSZH#10096
AR	25	WIRING DIAGRAM	213FS-WD
AR	24	PNEUMATIC DIAGRAM	213ES-PD
1	23	BOTTOM SIDE ASSY	213E-202F
7	22	SCREW, HEX CAP 1/4-20 X 2	SSHC01128
1	21	TRANSFER DRV ASSY	211-034
2	20	SCREW, HEX CAP 1/4-20 X 7/8	SSHC01056
2	19	SCREW, HEX CAP 1/4-20 X 2 1/2	SSHC01160
1	18	SHIM, CONV MNT	011-054
1	17	TOP CONVEYOR MNT	211-029
1	16	TOP COVER, CONV DRV	211-030
4	15	SCREW, HEX SHEET METAL NO. 10 X 1.0	SSZH#10064
1	14	CONVEYOR MOUNT	011-129
1	13	SWITCH, FOOT ASSY	0411-1903
1	12	BUNDLE SHELF	010-089
2	11	HINGE BRACKET	010-058
1	10	EYE MOUNT	311-008K
4	9	PLASTIC KNOB	TTCL1BPPK1
0	8	BASE STAND	265157
		BASE STAND	AP-1721
1	7	BULKHEAD UNION	AAQBU-4-4
15	6	1/4 SAE WASHER	WWFS1/4
7	5	1/4 LOCK WASHER	WWL1/4
7	4	SCREW, HEX CAP 1/4-20 X 5/8	SSHC01040
1	3	GEAR BELT	GG600L050
1	2	MOTOR SPACER	211-053
1	1	DRIVE MOTOR	211-G6602

211-G6602 Drive Train Assembly

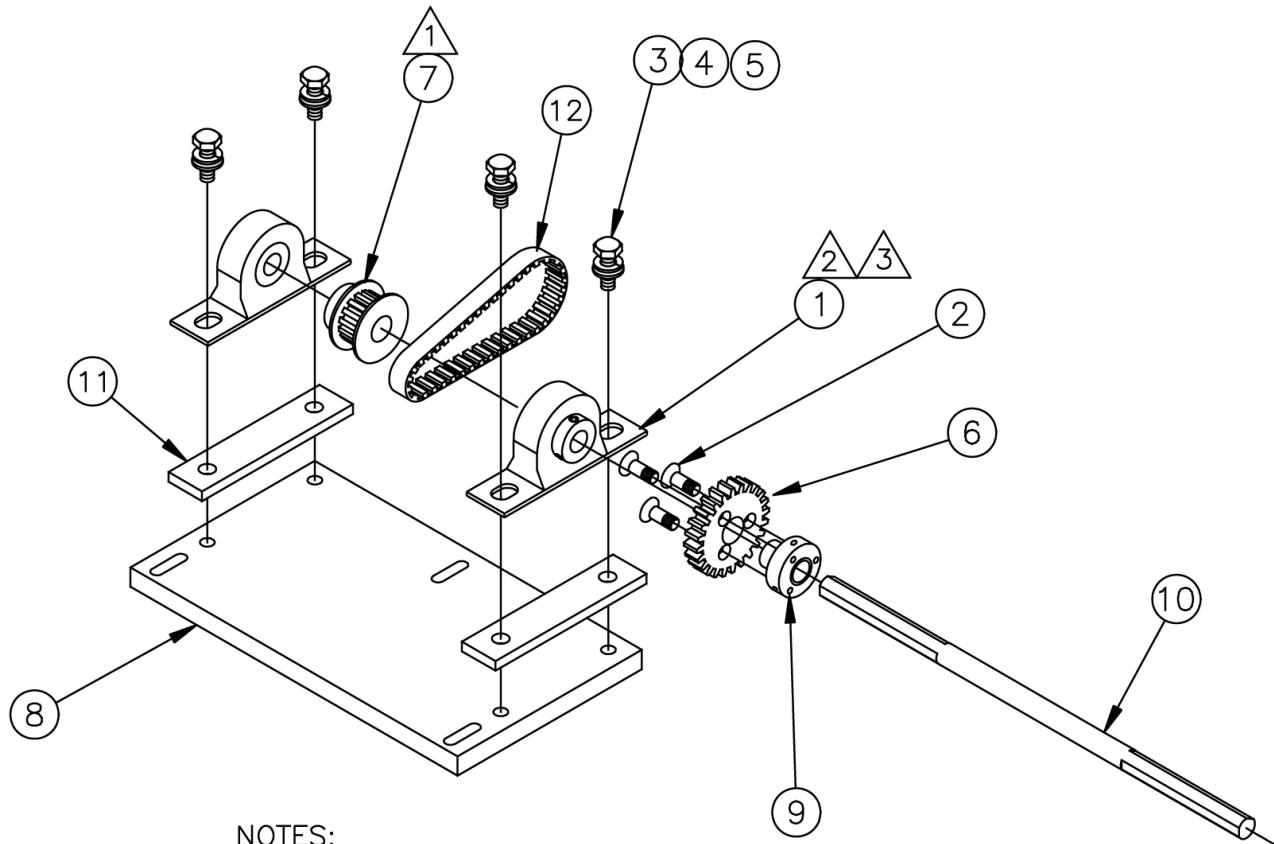
AAC Drawing Number 190182B Rev 5



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-025	Gear Pulley	11	1	211-069	Nut PI
2	4	SSPS98032	Scr,Pan Slt'd 10-32x1/2	12	2	SSH010144	Scr,Hx Cp 5/16-18x2-1/4
3	4	WWSI10	#10 Int Lock Washer	13	2	WWF5/16	Washer
4	1	011-018	Bracket, Motor	14	2	WWL5/16	Lock Washer
5	1	011-020	Stepper Motor	15	4	WWF1/4	Washer
6	1	A-2010U	1/2 Bore U-Joint	16	4	WWL1/4	Lock Washer
7	1	211-026	Shaft	17	AR	SSH01048	Hex Cap Screw
8	1	MM2X897	1/2 Pillow Block		AR	SSH01056	Hex Cap Screw
9	1	211-045	Gear		AR	SSH01064	Hex Cap Screw
10	1	211-051	Spacer, P. Block				

211-034 Transfer Drive Assembly

AAC Drawing Number 290131B Rev 8



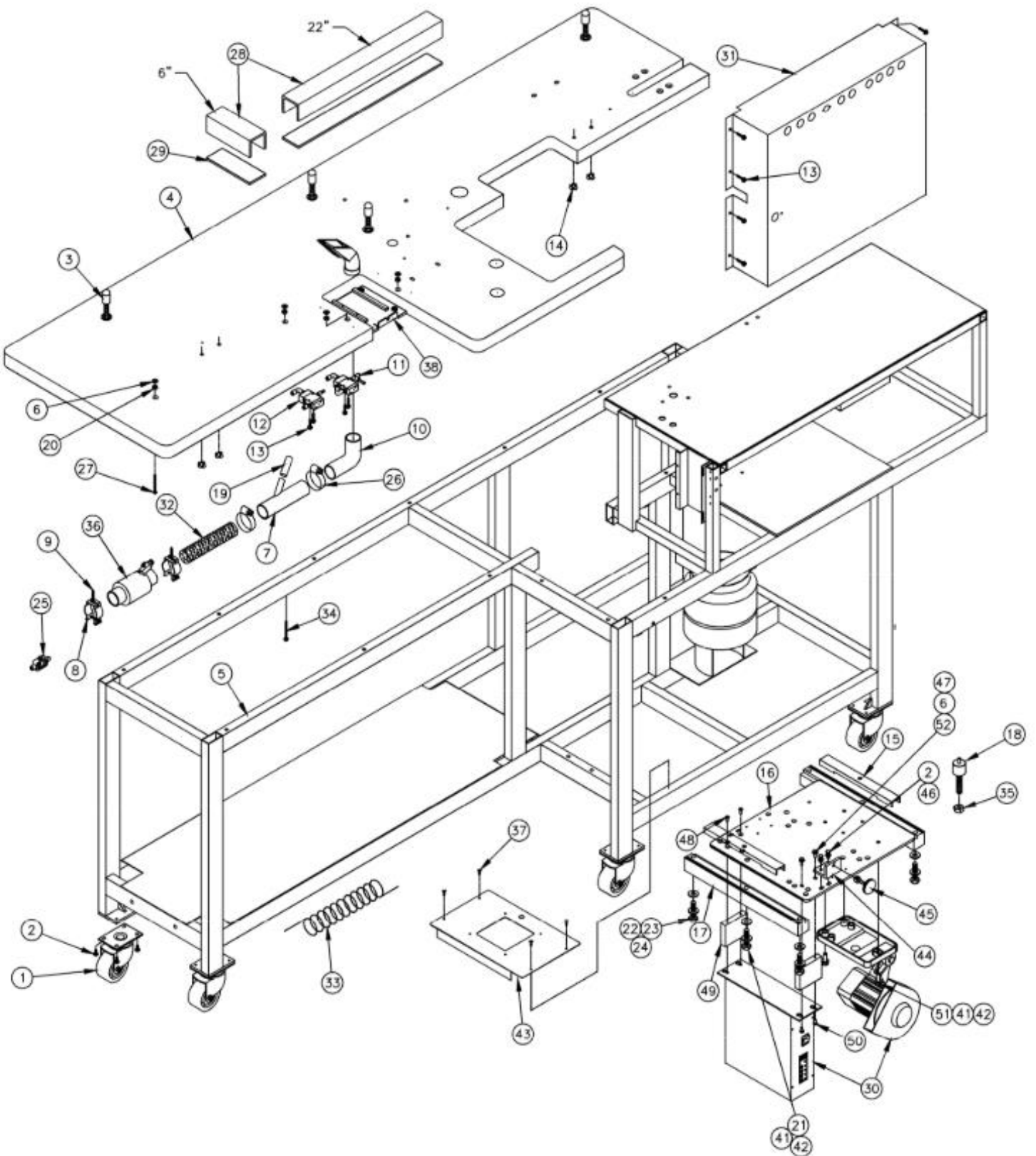
NOTES:

- △ 1 LEAVE SET SCREWS LOOSE ON SHAFT UNTIL BELT INSTALLED.
- △ 2 ASSEMBLE WITH SET SCREW FLANGE TO OUTSIDE, OPPOSITE EACH OTHER.
- △ 3 ADJUST PILLOW BLOCKS AWAY FROM SLOT ON BRACKET.

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	MM2X897	1/2 Pillow Blocks	7	1	211-057	Pulley, Mod
2	3	SSFC90048	Scr, Fl Al Cp 8-32X3/4	8	1	211-028	Pl Top Conv Dr
3	4	SSHC20048	Scr, Hx Cp 5/16-24X3/4	9	1	211-047	Gear Adaptor
4	4	WWF5/16	Washer, 5/16 USS	10	1	211-048	Rod, Top Conv Dr
5	4	WWL5/16	5/16 Lock Washer	11	2	211-051	Spacer, Pillow
6	1	211-013	Gear Top Conv Dr	12	1	GG540L050	Gear Belt

213-202F Table Sub-Assembly

AAC Drawing Number 192164D Rev 0

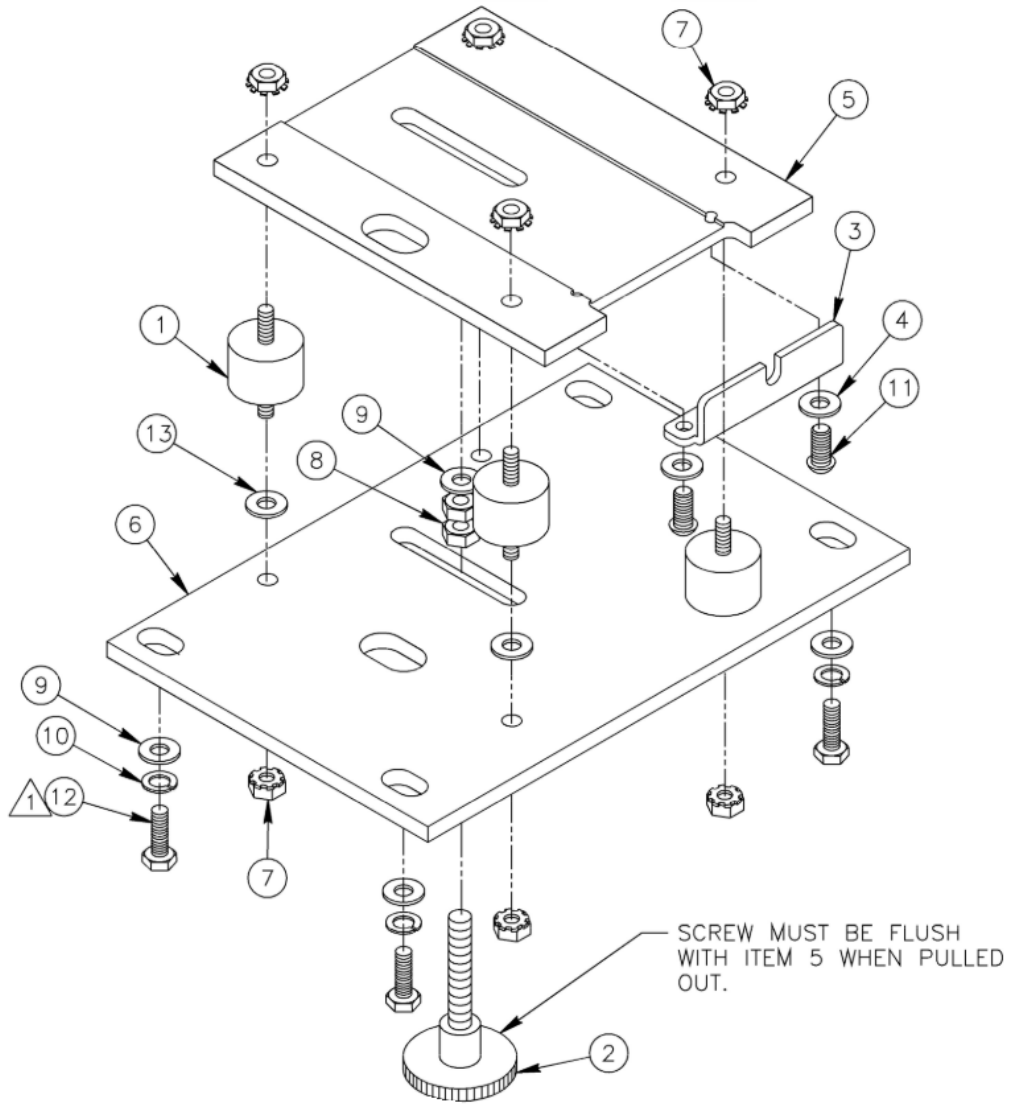


213-202F parts list

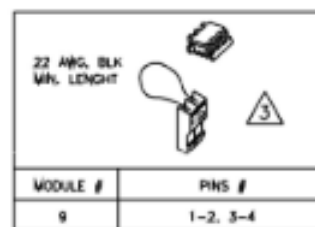
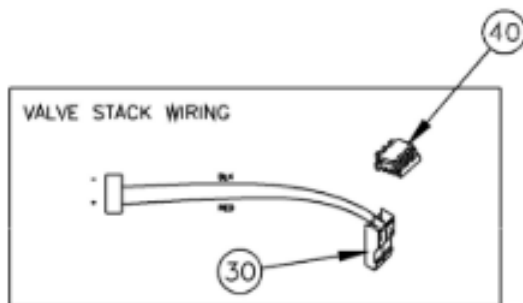
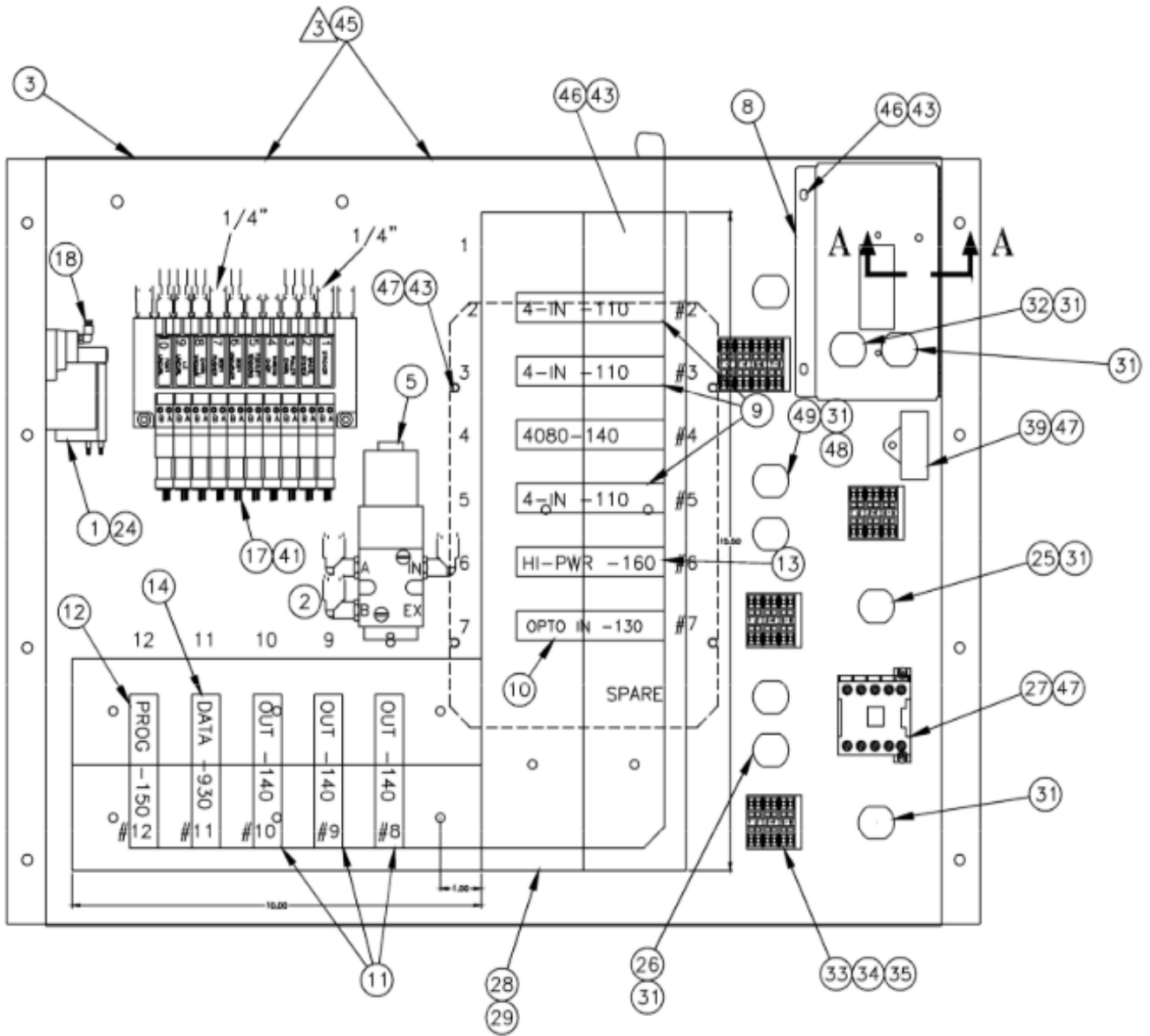
QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE	QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	52	SCR,HEX CAP,10-32X5/8	SSHC98040	2	26	HOSE CLAMP	MM5415K16
4	51	SCR,HEX CAP,5/16-18X1	SSHC10064	1	25	IN-LINE FLOW CONT	AA2000F-03
4	50	SCR,PAN HD,10-32X3/8	SSPS98024	4	24	3/8 LOCK WASHER	WWL3/8
2	49	SPACER, EFKA BOX	0411-3928	4	23	3/8 FLAT WASHER	WWF3/8
2	48	SCR,FLAT HD,10-32X1/2	SSFC98032	4	22	SCREW, HEX CAP 3/8-16 X 2 1/2	SSHC25160
2	47	LOCKWASHER,#10	WWL10	2	21	SCREW, HEX CAP 5/16-18 X 2	SSHC10128
2	46	WASHER, LOCK, 1/4	WWL1/4	4	20	HEX NUT	NNH10-24
2	45	TORQUE KNOB ASSEMBLY	011-117	1	19	ADAPTOR, TUBE	211-132A
2	44	ANGLE BLOCK	011-100	4	18	POST, ISOLATOR	211-124A
1	43	MNT,CONTROL BOX	211-208	2	17	HEAD/MOTOR SLIDE RAIL	011-098
5	42	WASHER, FLAT, 5/16	WWL5/16	1	16	MOTOR HD MT PLATE	013-091
5	41	WASHER, LOCK, 5/16	WWF5/16	2	15	CLAMP BRACKET	011-099
AR	40	WIRING DIAGRAM	213FS-WD	4	14	1/4-20 WOOD INSERT	TTIW1/4-20
0	39	PNEUMATIC DIAGRAM	213ES-PD	12	13	SCREW, HEX SHEET METAL #10 X 1/2	SSZH#10032
1	38	EDGE TRIMMER MOUNT	211-195	1	12	PILOT VALVE ASSEMBLY	26284
4	37	SCREW, SHEET METAL 10-16 X 1/2, SELF DRILL	SSZS93032	1	11	PILOT VALVE ASSEMBLY	26239
1	36	WASTE VENTURI ASSY.	0411-1057	1	10	FUNNEL	MM16314G1
8	35	1/2-20 JAM NUT	NNJ1/2-20	2	9	SCREW, HEX SHEET METAL #10 X 3/4	SSZH#10048
12	34	SCREW, HEX SHEET METAL NO. 10 X 2	SSZH#10128	2	8	TUBE CLAMP	MM16300
2	33	COIL HOSE	AAVBG35B	1	7	1.5 X 1 Y	MMYSB1.5X1
1'	32	FLEX HOSE	MMFH150	6	6	SAE FLAT WASHER	WWFS10
1	31	ELECTRONIC ASSEMBLY	213-203F	1	5	FRAME WELDMENT	311-007
1	30	MOTOR,EFKA DC1500	4059-DC1500	1	4	MAIN TABLE	311-010
1'	29	CONDUIT COVER	EEDC2X2	4	3	LOWER CONV BUMPER	011-111
1'	28	WIRING CONDUIT	EEDF2X2	17	2	SCREW, HEX CAP 1/4-20 X 1/2	SSHC01032
4	27	SCREW, PAN HD SLOTTED 10-24 X 2	SSPS95128	5	1	3" RUBBER CASTER	MM427-3RB

211-195 Edge Trimmer Mount Assembly

AAC Drawing Number 191053B Rev 1

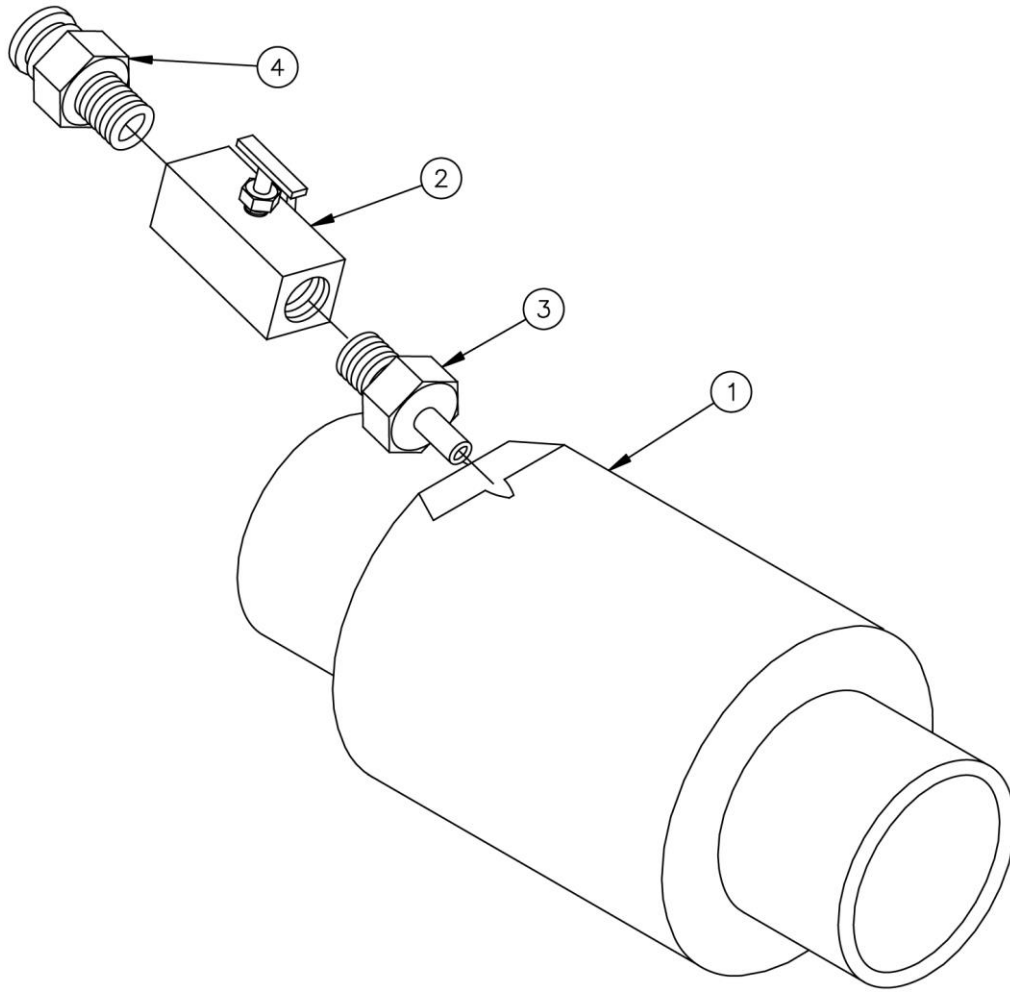


QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
4	13	WASHER,SAE,1/4	WWFS1/4
4	12	SCREW, HEX CAP 5/16-18 X 1 1/4	SSHHC10080
2	11	SCREW, BUTTON CAP 10-32 X 3/8	SSBC98024
4	10	5/16 LOCK WASHER	WWL5/16
5	9	WASHER SAE 5/16	WWFS5/16
2	8	NUT, JAM 5/16-18	NNJ5/16-18
8	7	NUT, KEP, 1/4-20	NNK1/4-20
1	6	PLATE, MOTOR SUPPORT	010-040
1	5	PLATE, MOTOR MOUNTING	010-039A
2	4	SAE FLAT WASHER	WWFS10
1	3	BRACKET, SCREW	211-160
1	2	TORQUE KNOB-STUD 5/16-18 X 2	TTK32309
4	1	MOUNT, VIBRATION, MOTOR	MMB6002



211-203F parts list

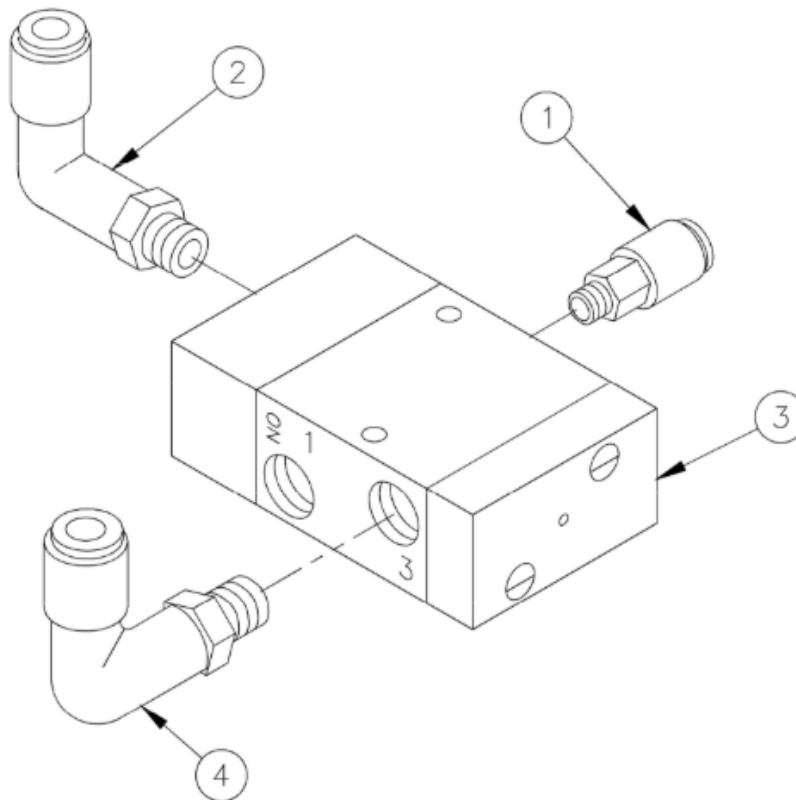
QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE	QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
8'	25	CABLE, 3 COND.	EE16-3C2406	4'	49	CABLE	FF19510
2	24	SCREW, PAN HD SLOTTED 8-32 x 1 1/4	SSPS90080	2	48	RECEPTACLE	EET8966
1'	23	AIRLINE, 5/32	AATP5/32	7	47	SCREW, PAN HD SLOTTED 8-32 x 3/8	SSPS90024
1'	22	AIRLINE, 1/4	AATP4-1	14	46	SCREW, PAN HD SLOTTED 8-32 x 1/4	SSPS90016
2	21	UNION Y, QUICK	AAQUY-4-4	1'	45	DOOR TRIM - BLACK	MM100-1/8
1	20	UNION T, QUICK	AAQUT-4-4	2	44	NUT, 8-32 KEEP	NNK8-32
1	19	REDUCER, QUICK	AAQPR-5-4	18	43	WASHER, FLAT	WWF8
1	18	ELBOW, QUICK	AAQME-5-10	2	42	TERMINAL RING	TTSRBS82908
1	17	SOLENOID ASSEMBLY	AAE411-10	2	41	SCREW, SOCKET CAP 4-40X 3/8	SSSC70024
1	16	POWER SUPPLY	4080-990R	10	40	COVER, STRAIN RELIEF	FFSC10002
	15			1	39	MODULE, TVS	FFRAV781BW
1	14	MODULE, DATA	4080-930	2'	38	WIRE, 16 GA	FF3077-7
1	13	MODULE, SINGLE OUT	4080-160	2'	37	WIRE, 16 GA	FF3077-6
1	12	MODULE, PROGRAM	4080-150	2	36	WIRE, 16 GA	FF3077-28
4	11	MODULE, QUAD OUT	4080-140	4	35	TERMINAL, END	FF264-371
1	10	MODULE, OPTO ISO	4080-130	3	34	TERMINAL BLOCK	FF264-347
3	9	MODULE, QUAD IN	4080-110	10	33	TERMINAL BLOCK	FF264-341
1	8	DISCONNECT, AC	40-320	20'	32	CABLE, 3 COND.	FF19510
AR	7	DIAGRAM, WIRING	213FS-WD	7	31	STRAIN RELIEF	FF1724
AR	6	DIAGRAM, PNEU.	213ES-PD	10	30	CONNECTOR, 2 PIN	FF100F2202
1	5	VALVE, AIR, SOL	AAE711C24D	4.4'	29	DUCT, WIRE	EEDF2X2
1	4	CABLE PACKAGE	213-204F	4.4'	28	COVER, WIRE DUCT	EEDC2X2
1	3	PANEL, ELECTRICAL	211-204	1	27	CONTACTOR, MINI	EECA491024
3	2	QUICK MALE ELBOW	AAQME-4-8	2	26	CORD, POWER	EE17518
1	1	SWITCH, LOW AIR	AAVF51FM1B	8'	25	CABLE, 3 COND.	EE16-3C2406



NO.	QTY	PART #	DESCRIPTION
1	1	211142	Waste Venturi
2	1	AAF2304-2	Needle Valve
3	1	AAF10684	Brass Fitting
4	1	AAQMC-4-8	Quick Male Connect

26284 Pilot Valve Sub-Assembly

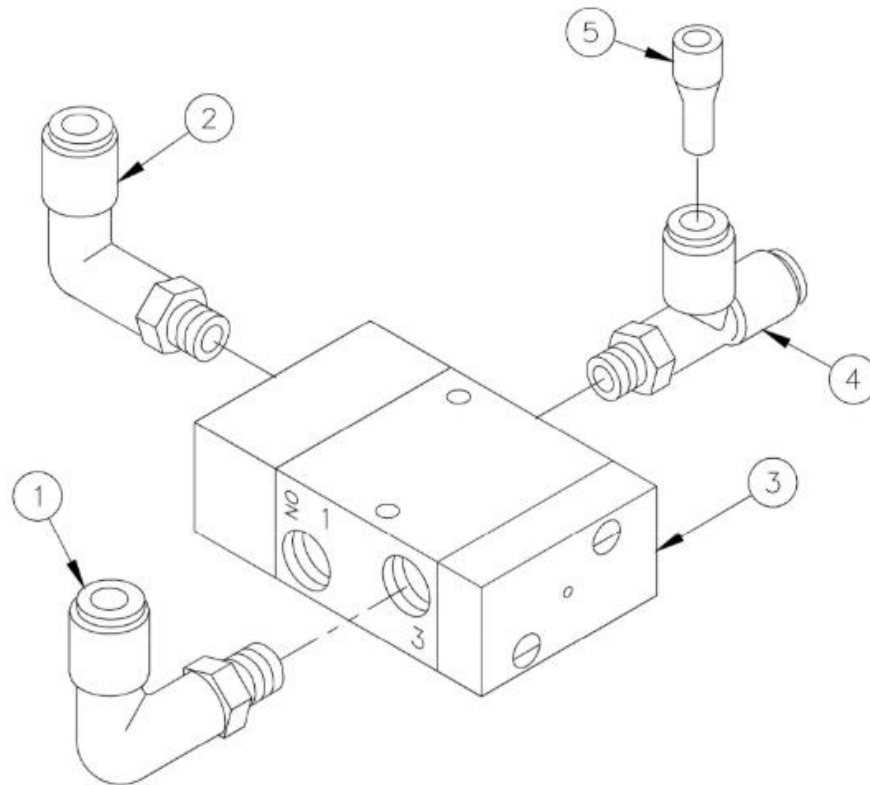
AAC Drawing Number 260634A Rev 4



QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	5	PLUG	MM4554K11
1	4	QUICK MALE EL	AAQME-4-8
1	3	PILOT VALVE	AAV125B
1	2	QUICK MALE EL	AAQME-5-8
1	1	QUICK MALE CONNECT	AAQMC-4-8

26239 Pilot Valve Sub-Assembly

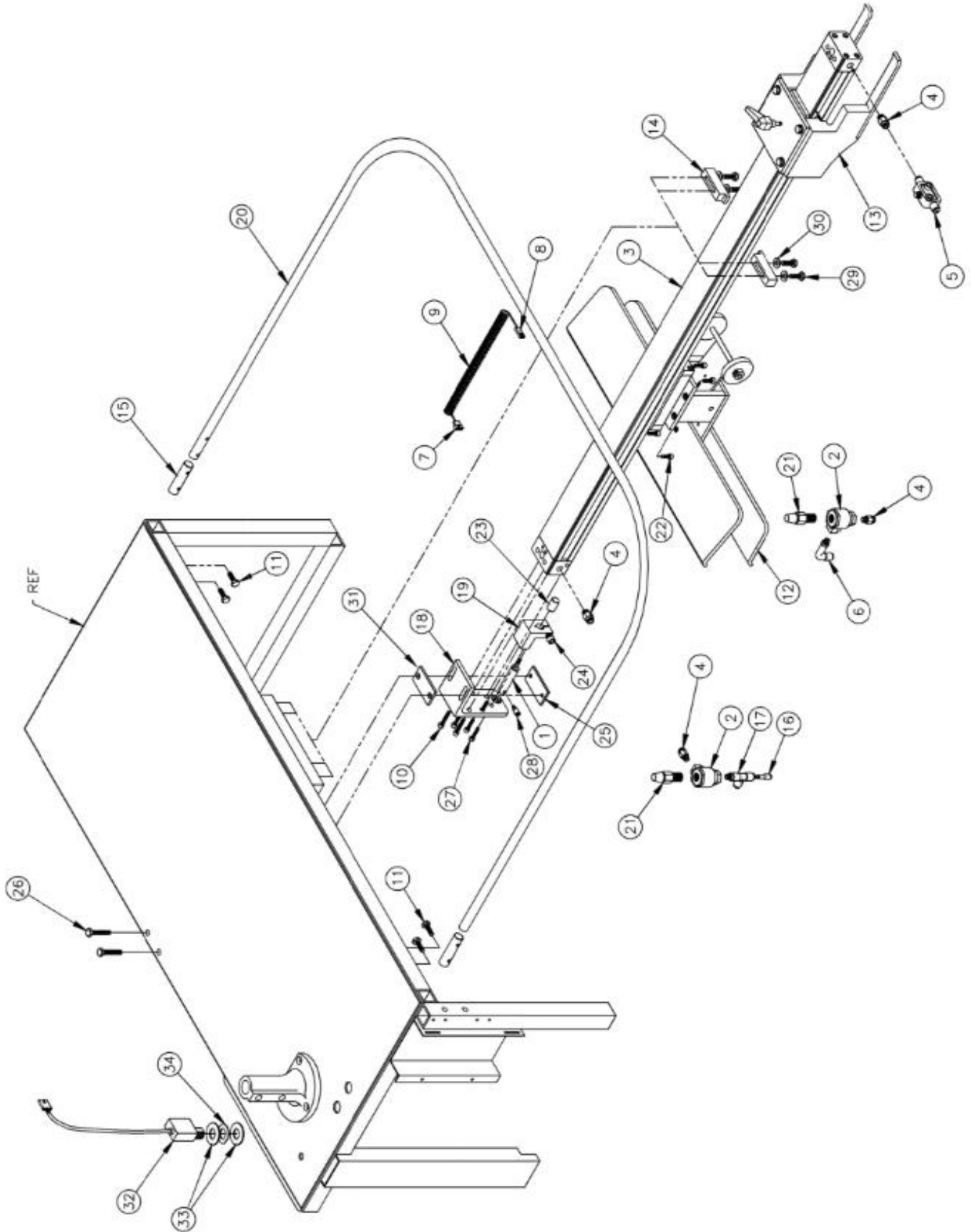
AAC Drawing Number 260573A Rev 5



QTY. REGD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	6	PLUG	MM4554K11
1	5	REDUCER	AAQPR-5-4
1	4	QUICK MALE T	AAQMT-4-8
1	3	PILOT VALVE	AAV125B
1	2	QUICK MALE EL	AAQME-5-8
1	1	QUICK MALE EL	AAQME-4-8

311-011 Stacker, Pick and Stack

AAC Drawing Number 191895C Rev 8



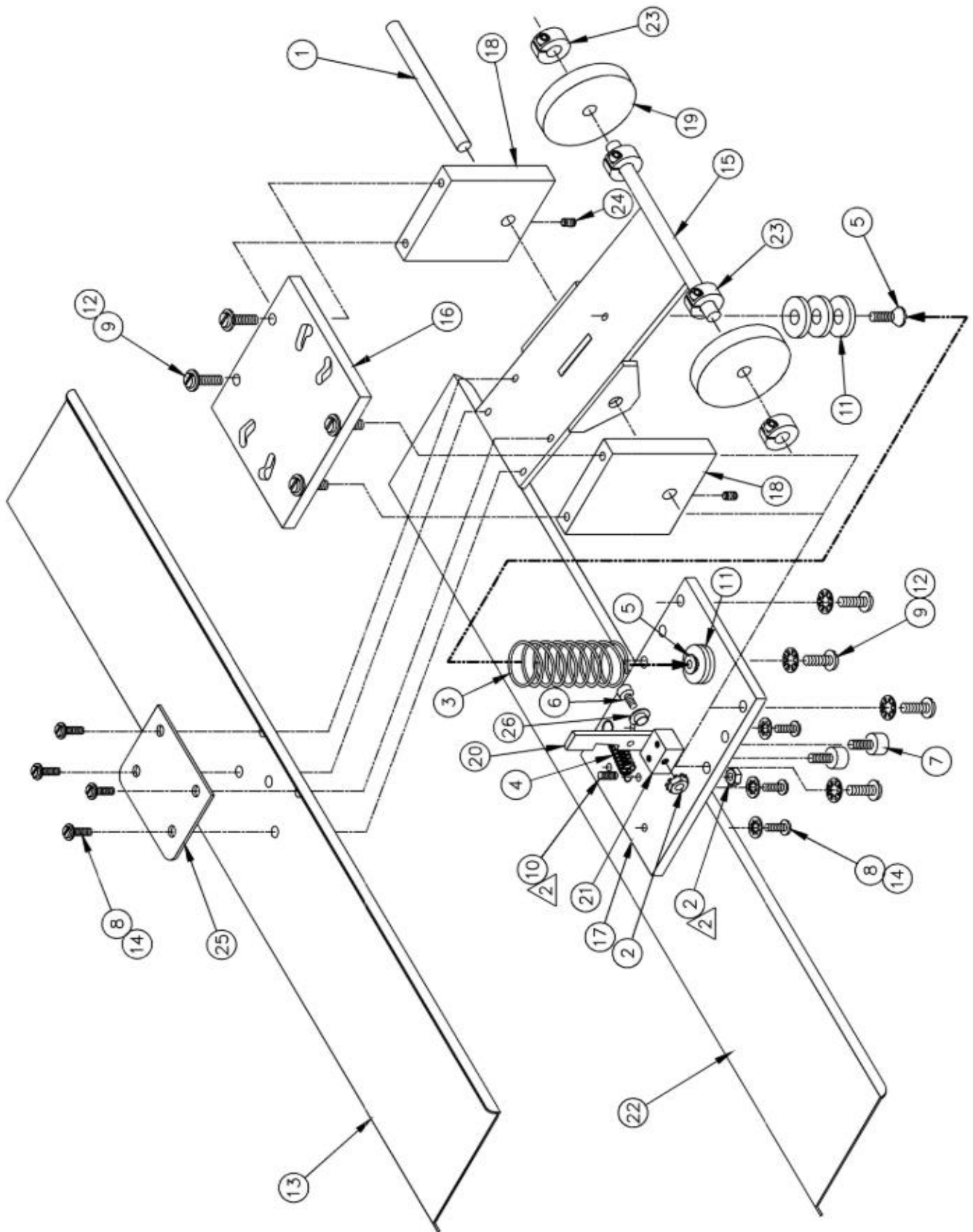
311-011 parts list

QTY. REOD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	17	MALE RUN TEE	AAQMT-4-8
1	16	PLUG IN REDUCER	AAQPR-5-4
2	15	ROD 5/8 OD	029-017
2	14	MOUNT, AIR CYL, REAR	016-034A
1	13	CLAMP OPENER ASSY	016-023
1	12	CLAMP, MATERIAL, ASSY	016-014A
4	11	SCREW, HEX CAP 1/4-20 x 3/4	SSHC01048
4	10	SCREW, METRIC, SOCKET CAP M5 x 6 x 40	SSM5X.8X40
1	9	CABLE, COILED, 3 CON	029-016
1	8	2 PIN MALE CONN.	FF59F1802
1	7	2 PIN FEMALE CONN.	FF31F1033
1	6	QUICK MALE ELBOW	AAQME-4-8
1	5	FLOW CONTROL	AA3000F-07
4	4	QUICK MALE CONNECTOR	AAQMC-4-8
1	3	CYLINDER, AIR	AACSRM032
2	2	EXHAUST VALVE	AAVSQE1
1	1	AIR CYLINDER	AAC3PS-1/2

QTY. REOD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	34	WASHER, SPRING	WWSW3/4
2	33	SHIM	MM3088A434
1	32	EYE, ELECTRIC	FFSM312LVQ
1	31	SPACER	311-013A
4	30	1/4 WASHER	WWFS1/4
4	29	SCREW, HEX CAP 1/4-20 x 1	SSHC01064
1	28	QUICK MALE CONNECT	AAQMC-5-10
2	27	SCREW, SOCKET CAP 10-32 x 1/2	SSSC98032
2	26	SCREW, HEX CAP 1/4-20 x 2	SSHC01128
1	25	NUT PLATE	311-013
1	24	SCREW, SOCKET, SET 8-32 x 3/4	SSSC90048
1	23	BUMPER	311-011B
4	22	SCREW, SOCKET, CAP 10-24 x 5/8	SSSC95040
2	21	MUFFLER	MMU002A
1	20	GUARD, STACKER	311-059
1	19	CYL MOUNT	311-011A
1	18	BRACKET, PUSHER CYL.	311-011C

016-014A Material Clamp Assembly

AAC Drawing Number 190681C Rev 13

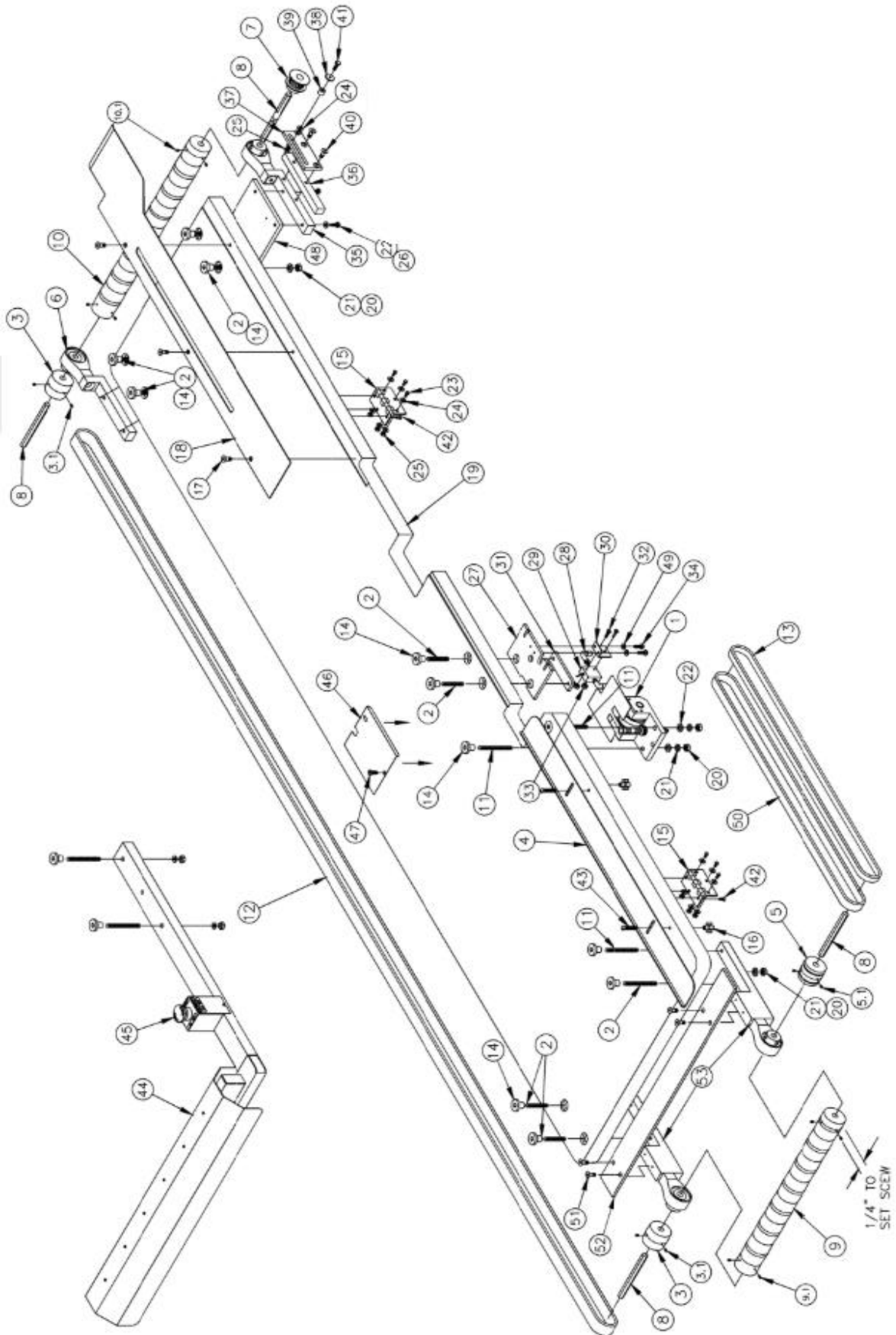


016-014A parts list

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	26	BUSHING, 016-020B	016-020B1
1	25	STIFFNER	016-022A
2	24	SCREW, SOCKET SET 1/4-20 x 1/4	SSSP01016
4	23	1/4" CLAMP COLLAR	CCCL4F
1	22	CLAMP JAW	016-022B
1	21	MOUNT, TRIP LEVER	016-021
1	20	LEVER, TRIP	016-020B
2	19	WHEEL, CLAMP OPENER	013-040
2	18	SUPPORT, SIDE	016-018
1	17	BKT,BOTTOM CLAMP JAW	016-017
1	16	BASE PLATE, CLAMP JAW	016-016
1	15	BRACKET, CLAMP ASSY	016-015
8	14	WASHER, INT TEETH, #8	WWSI8
1	13	CLAMP JAW	016-022C
8	12	WASHER, INT TEETH,#10	WWSI10
6	11	1/4 SAE FLAT WASHER	WWFS1/4
1	10	ROD, THREADED	A-2206A
8	9	SCREW, PAN HEAD SLOTTED 10-32 x 1/2	SSPS98032
8	8	SCREW, BUTTON CAP 8-32 x 1/4	SSBC90016
2	7	SCREW, SOCKET CAP 6-32 x 3/8	SSSC80024
1	6	SCREW, SOCKET CAP 10-32 x 7/8	SSSC98056
2	5	SCREW, FLAT CAP ALLEN 8-32 x 3/8	SSFC90024
1	4	SPRING,.024X.19X.94	RRLE024B-6
1	3	SPRING,.055X.72X2	RRLC055J-7
2	2	NUT, KEP 10-32	NNK10-32
1	1	DOWEL PIN, 1/4 X 3"	IID016X192

311-017A Lower Conveyor

AAC Drawing Number

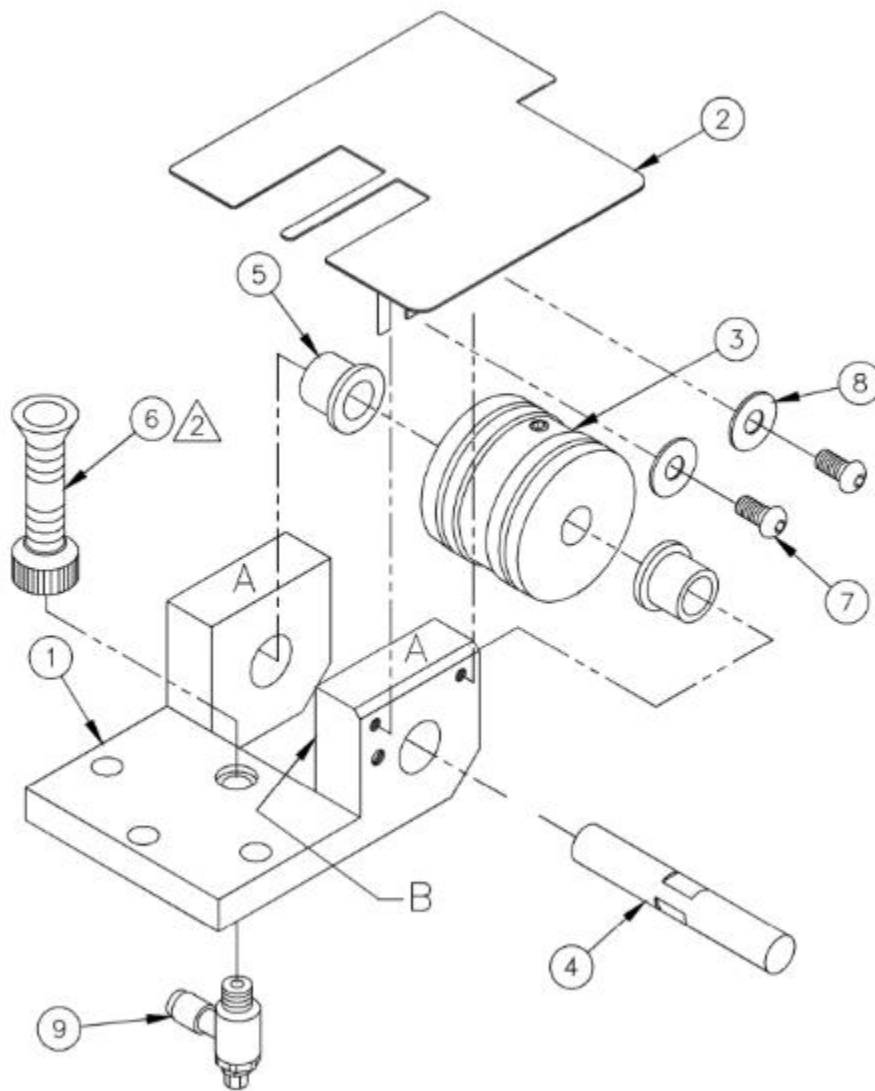


311-017A parts list

QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	53	ROD END BRACKET	010-145C
1	52	TABLE EXTENSION	213-011
4	51	SCREW, FLAT ALLAN 10-32 x 1/2	SSFC98032
1	50	BELT, URETH., .75W	213-007B
2	49	WASHER, FLAT, SAE	WWFS10
1	48	CONV SUPP PLATE	311-051A
1	47	SCREW, WOOD FLAT PHILLIPS NO. 6 x 1 1/4	SSWFP06080
1	46	PLATE, FRONT KNIFE	311-046
1	45	EMER STOP BOTTON	311-036
1	44	MATERIAL ARM	311-029
2	43	SCREW, TRUSS SLOTTED 10-24 x 2 1/2	SSTS95160
6	42	SCREW, FLAT ALLAN 1/4-20 x 1 1/2	SSFC01096
1	41	SCREW, HEX CAP 1/4-20 x 1 1/4	SSHC01080
2	40	SCREW, FLAT ALLEN CAP 1/4-20 x 1 1/4	SSFC01080
1	39	CAM FOLLOWER	A-2014-7
1	38	LARGE FENDER WASHER	WWFE016
1	37	TENSIONER, CONV. DRIVE	011-004
1	36	SPACER	211-056
1	35	ROD END BRACKET	010-146
2	34	SCREW, PAN HEAD SLOTTED 10-32 x 1/4	SSPS98016
2	33	KEP W/ RET LOCK	NNK8-32
2	32	SCREW, PAN HD. SLOTTED 8-32 x 3/4	SSPS90048
1	31	NUT PL. FOLDER MT.	211-038
1	30	BRACKET SWITCH HOLDER	211-037
1	29	VALVE	AAVMJTV-3
2	28	QUICK MALE ELBOW	AAQME-5-8
1	27	FOLDER MOUNT PLATE	211-036
2	26	SCREW, HEX CAP 5/16-18 x 1	SSHC10064
7	25	1/4-20 KEP NUT	NNK1/4-20
15	24	1/4 FLAT WASHER	WWFS1/4
6	23	SCREW, HEX CAP 1/4-20 x 1/2	SSHC01032
4	22	5/16 FLAT WASHER	WWFS5/16
5	21	5/16 LOCK WASHER	WWL5/16
5	20	5/16-18 HEX NUT	NNH5/16-18
1	19	TABLE TOP	311-009B
1	18	SLEEVE SUPPORT PLATE	311-014A
3	17	SCREW, FLAT CAP 10-32 x 1 1/2	SSFC98096
2	16	PLASTIC KNOB	TTCL1BPPK1
1	15	3X3 HINGE PAIR	MM741-3
12	14	RECESSED NUT	NNM103
1	13	URETHANE BELT	213-007
8	12	URETHANE BELT	213-006
3	11	THREADED ROD 2.5L	K-102-21
4	10.1	SCREW, SOCKET SET 1/4-20 x 1/2	SSSS01032
1	10	ROLLER 18.62L	013-006
4	9.1	SCREW, SOCKET SET 1/4-20 x 1/2	SSSS01032
1	9	ROLLER 17.63L	013-007
4	8	SHAFT FLATTED	010-052
1	7	GEAR PULLEY	211-055
1	6	ROD END BRACKET	010-145
2	5.1	SCREW, SOCKET SET 1/4-20 x 1/2	SSSS01032
1	5	ROLLER, ALUM	010-049
1	4	FRONT EDGE GUIDE	311-044
4	3.1	SCREW, SOCKET SET 1/4-20 x 3/8	SSSS01024
2	3	ROLLER	23055
9	2	THREADED ROD	350254
1	1	BELT IDLER ASM	010-047

010-047 Belt Idler Assembly

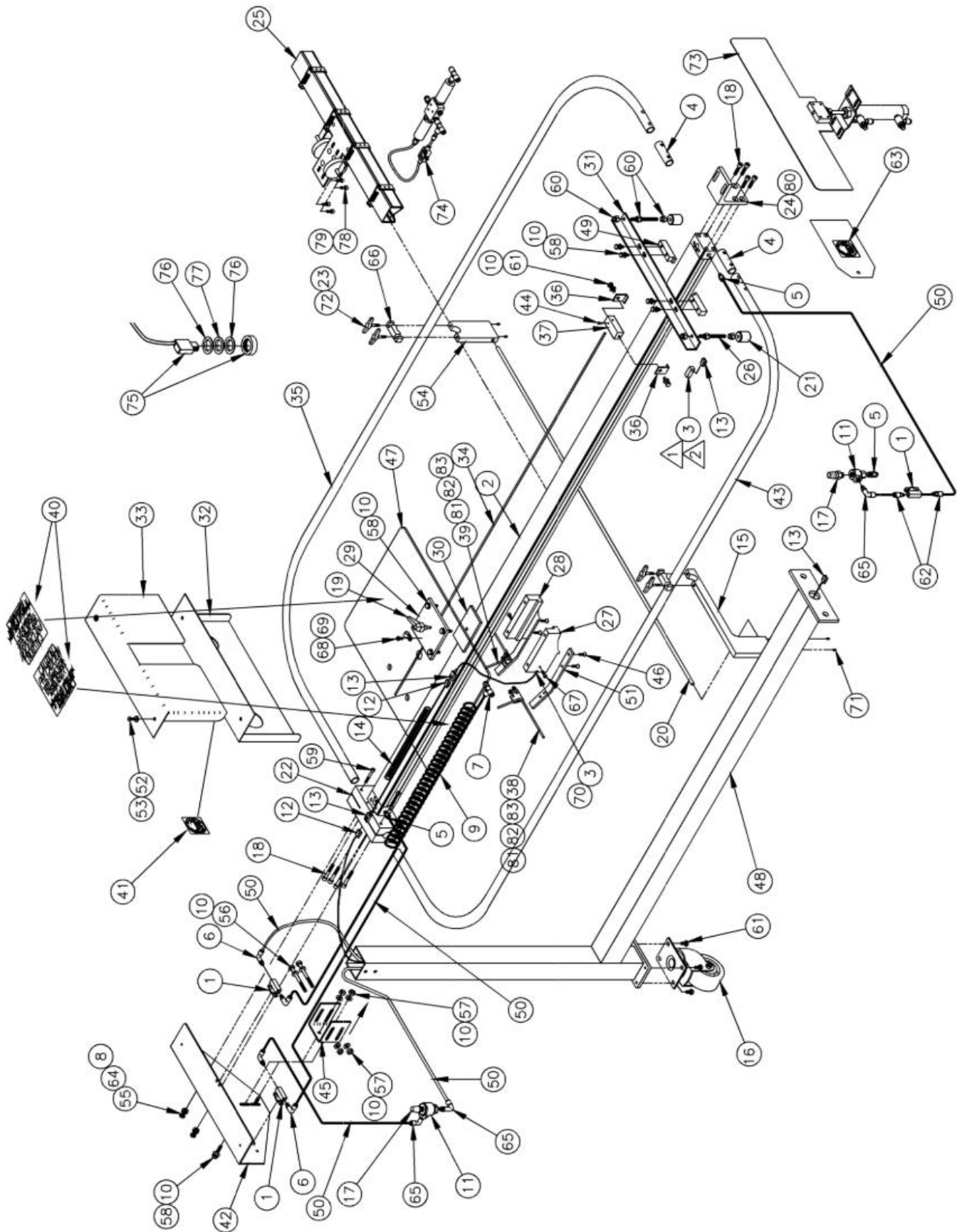
AAC Drawing Number 290014B Rev 11



QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	9	REV AIR FLOW 5/32X10-32	AA198RR510
2	8	WASHER, FLAT, SAE 10	WWFS10
2	7	SCREW, BUTTON CAP 10-32 X 3/8	SSBC98024
1	6	SOFFIE AIR JET	AAF01
2	5	BEARING, BRONZE	UUFF609-01
1	4	SHAFT, FLATTED	010-047B
1	3	ROLLER, ALUMINIUM	010-047C
1	2	PLATE, STRIPPER BELT	211-109C
1	1	ROLLER YOKE, IDLER	010-047D

311-018 Stacker Assembly

AAC Drawing Number 190902C Rev 12



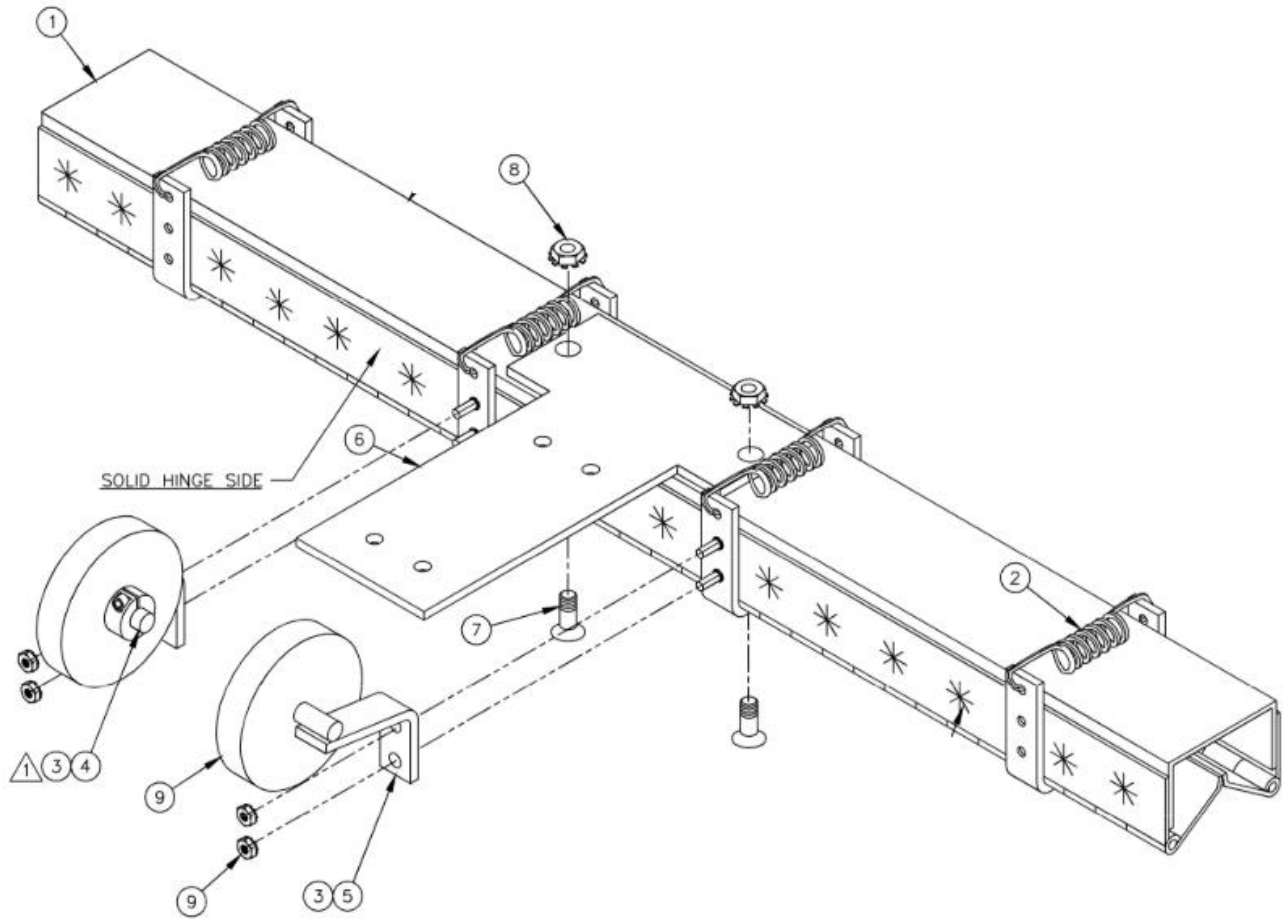
311-018 parts list

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
4	83	WASHER, LOCK, 6	WWL6
4	82	WASHER, FLAT, SAE, 6	WWFS6
4	81	SCREW, SOCKET, CAP 6-32 x 1/2	SSSC80032
AR	80	BRKT, CYL MOUNT	311-033
4	79	LOCK WASHER	WWLM5
4	78	SCREW, METRIC SOCKET, CAP M5 x .8 x 10	SSSCM5X.8X10
1	77	SPRING WASHER	WWSW3/4
2	76	SHIM	MM3088A434
1	75	ELECTRIC EYE	FFSM312LVQ
1	74	STACKER BLOW-DOWN	013-123
1	73	PUSHER ASSEMBLY	013-G6606
4	72	SCREW, SOCKET, CAP 1/4-20 x 1	SSSC01064
4	71	SCREW, SOCKET SET 6-32 x 1/4	SSSS01016
1	70	SCREW, TRUSS SLOTTED 6-32 x 1/4	SSTS80016
1	69	CLAMP, PLASTIC	AAF1/4
1	68	SCREW, PAN SLOTTED 10-23 x 1/2	SSPS98032
2	67	SCREW, SOCKET, CAP 6-32 x 3/4	SSSC80048
2	66	TOP, ROD MOUNT	013-113
3	65	QUICK MALE ELB	AAQME-4-8
2	64	LOCK WASHER	WWL5/16
1	63	STACKER SPEED LAB.	013-126
2	62	QUICK MALE CONNECTOR	AAQMC-4-4
6	61	SCREW, HEX CAP 1/4-20 x 3/8	SSHCO1024
6	60	NUT, JAM 5/16-24	NNJ5/16-24
4	59	SCREW, SOCKET CAP 1/4-20 x 1 1/2	SSSC01096
10	58	SCREW, HEX CAP 1/4-20 x 3/4	SSHCO1048
4	57	NUT, HEX, 1/4-20	NNH1/4-20
2	56	SCREW, SOCKET, HEX 1/4-20 x 3	SSHCO1192
2	55	WASHER, FLAT, 5/16	WWF5/16
1	54	ROD MOUNT	013-112
2	53	WASHER, FLAT, NO. 10	WWF10
2	52	SCREW, PAN HEAD SLOTTED 10-32 x 3/4	SSPS98048
2	51	RAMP, OPENER, STACKER	311-018E
5'	50	AIRLINE	AATP4-1
2	49	MOUNT, AIR CYLINDER, REAR	016-034
1	48	WELDMENT, STACKER FRAME	311-032
1	47	GUARD, PICK & STACK	013-089
4	46	SCREW, FLAT CAP 10-24 x 1/2	SSFC95032
1	45	U BRACKET	013-078
1	44	SCREW, SOCKET CAP 6-32 x 3/8	SSSC80024
1	43	GUARD, STACKER FRONT	311-038

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	42	BRACKET, FRONT CYL MOUNT	013-064
1	41	AIR JET LABEL	013-126A
2	40	HANDS-OFF LABEL	111-LAB2
1	39	BLOWER ASSY, RIGHT SLEEVE	013-061
1	38	BLOWER ASSY, LEFT SLEEVE	013-060
1	37	MOUNT, WIRE GUIDE	013-059
2	36	CLAMP, WIRE GUIDE MOUNT	013-058
1	35	GUARD, STACKER REAR	311-037
1	34	ROD, SST, 1/8 DIA X 43" LONG	013-055
1	33	COVER, STACKER, INSIDE	013-054A
1	32	COVER, CYLINDER MNT BRKT	013-054
1	31	BEAM CLAMP STABILIZER	311-018B
1	30	PLATE, CLAMP OPENER	013-048
1	29	PLATE, TOP, OPENER	013-047
1	28	BRACKET, OPENER, LEFT	013-046
1	27	BRACKET, OPENER, RIGHT	013-045
2	26	THREADED STUD	013-043
1	25	MATERIAL CLAMP	311-018D
1	24	BRKT, CYL MOUNT 2/STACK	311-018A
4	23	WING KNOB	SSW#1/4
1	22	BKT, REAR CYLINDER MOUNT	013-018
2	21	BUMPER	11200A
1	20	ROD	013-114
1	19	1/4-20 THREADED HANDLES	TTH32415
8	18	SCREW, METRIC SOCKET, CAP M5 x 8 x 40	SSM5X.8X40
2	17	PAPER MUFFLER	MMU002A
1	16	CASTER RUBBER	MM427-3RB
1	15	ROD MOUNT, LONG	013-111
1	14	CABLE, COILED, 3 CON	029-016
4	13	2 PIN MALE CONNECTOR	FF59F1802
2	12	2 PIN FEMALE CONNECTOR	FF31F1033
2	11	QUICK EXHAUST VALVE	AAVSQE1
18	10	1/4 WASHER	WWF1/4
1	9	COIL HOSE	AAVBG35A
2	8	SCREW, HEX CAP 5/16-18 x 3/4	SSHCO10048
1	7	QUICK UNION TEE	AAQUT-4-4
4	6	QUICK MALE ELBOW	AAQME-4-4
3	5	QUICK MALE CONNECTOR	AAQMC-4-8
2	4	ROD, 5/8 OD TAPPED	029-017
2	3	REED SWITCH ASBLY	016-067
1	2	CYLINDER, AIR, RODLESS	AACSRLM060
3	1	NEEDLE VALVE	AA6805

311-018D Material Clamp

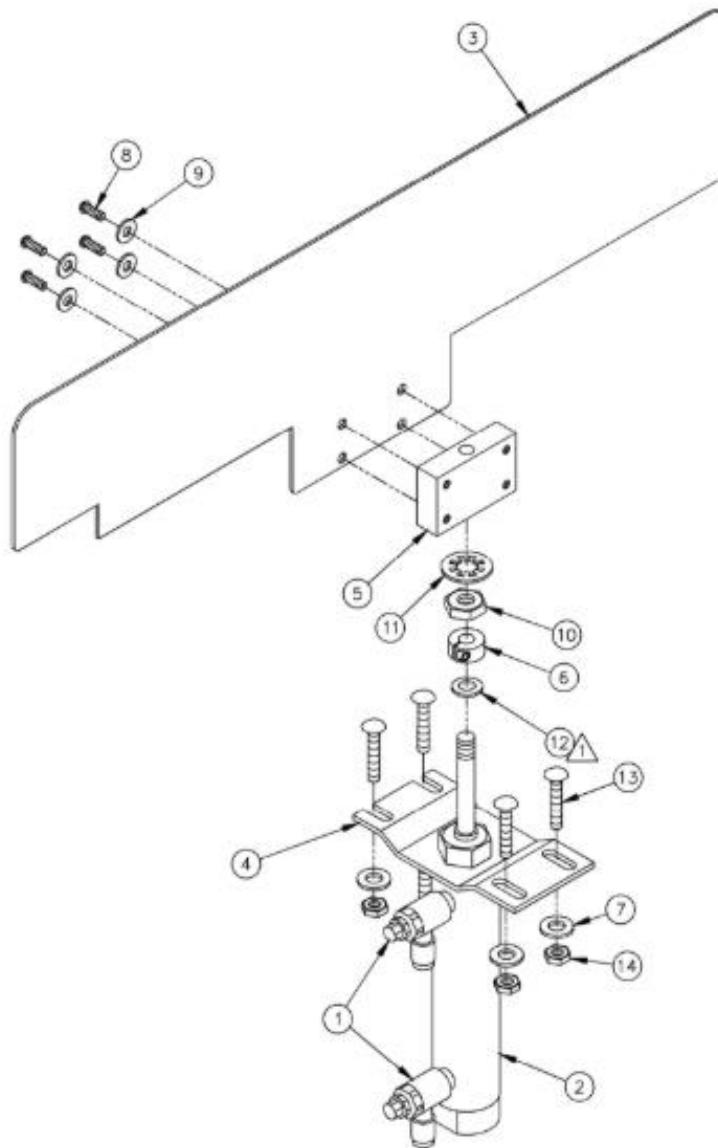
AAC Drawing Number



QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	9	ROLLER, 2"	013-040
6	8	NUT, KEP 10-32	NNK10-32
2	7	SCREW, FLAT CAP ALLEN 10-32 X 1/4	SSFC98016
1	6	PLATE, CLAMP MOUNT	311-018C
1	5	OPENER BRKT ASSY LFT	013-062
1	4	OPENER BRKT ASSY RT	013-063
2	3	1/4 CLAMP COLLAR	CCCL4F
4	2	SPRING	RRLE020B-7
1	1	WELDMENT	311-018DA

013-G6606 Pusher Assembly

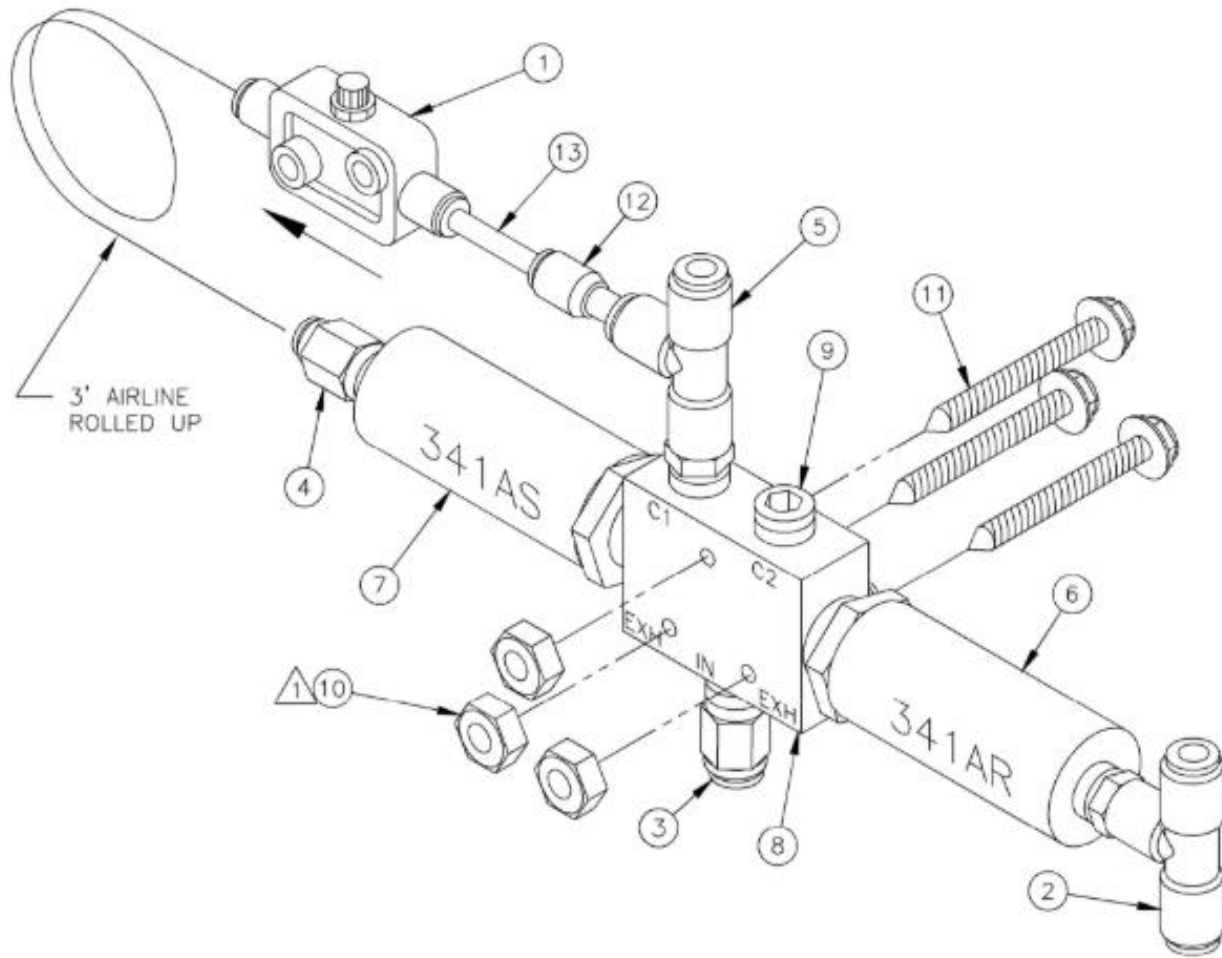
AAC Drawing Number



QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
4	14	1/4-20 KEP NUT	NNK1/4-20
4	13	CARRIAGE BOLT 1/4-20 X 2 1/2	SSBK01160
1	12	1/4 LEATHER WASHER	273-4-503
1	11	INT TOOTH WASHER	WWSI5/16
1	10	NUT JAM 5/16-24	NNJ5/16-24
4	9	NO. 10 WASHER	WWFS10
4	8	SCREW, BUTTON CAP 10-32 X 1/4	SSBC98016
4	7	WASHER 1/4	WWFS1/4
1	6	CLAMP COLLAR	CCCL5F
1	5	MOUNT, PUSHER BLADE	013-021
1	4	MOUNT, PUSHER CYL.	013-020
1	3	BLADE, PUSHER	013-019
1	2	AIR CYLINDER	AAC6DP-3B
2	1	FLOW CONTROL	AA198RA408

013-123 Stacker Blow-Down

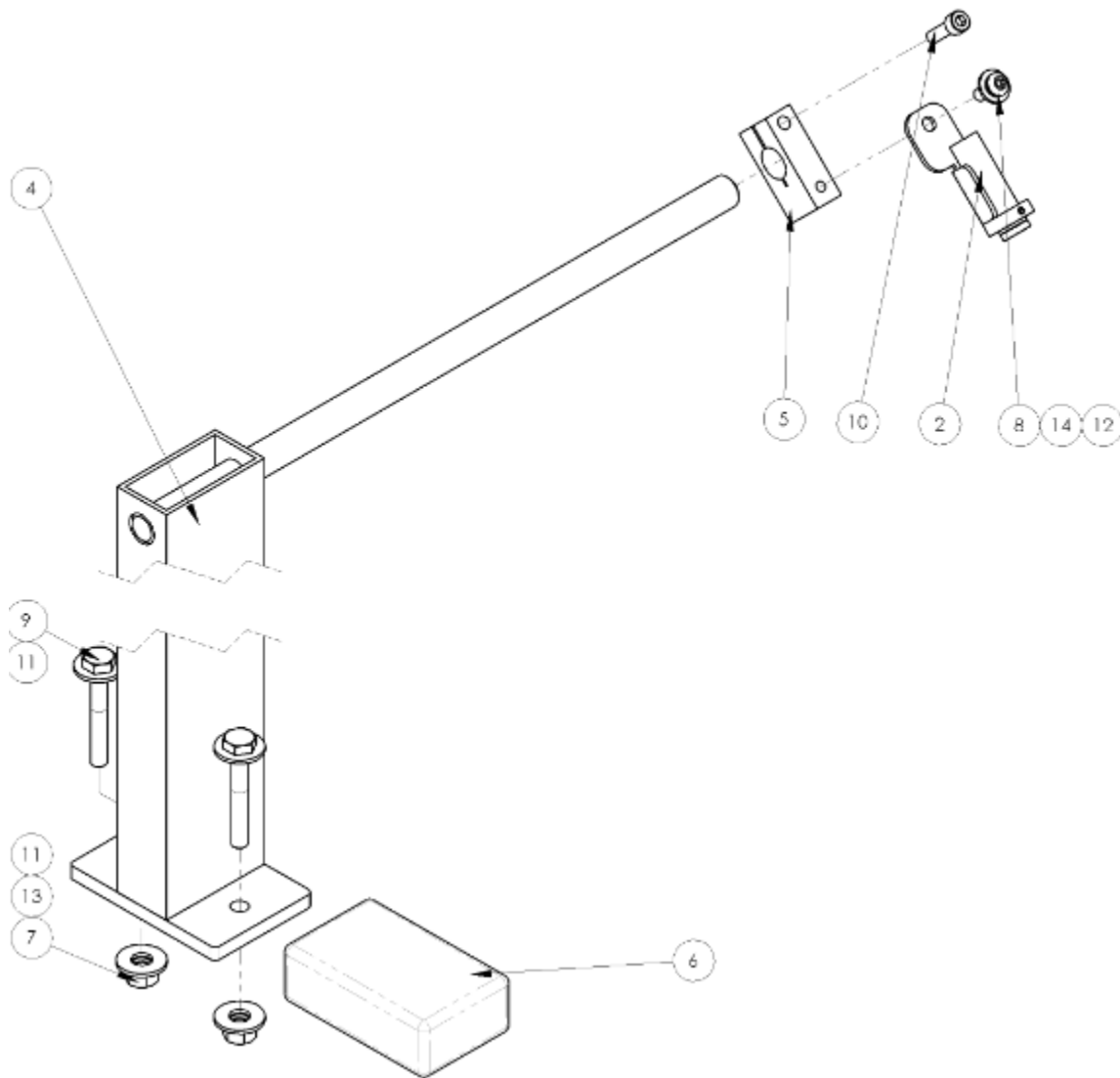
AAC Drawing Number



QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
3.25'	13	AIRLINE	AATP5/32
1	12	QUICK REDUCER	AAQPR-5-4
3	11	SCREW, HEX SHEET METAL #6 X 1 1/2	SSZH#6096
3	10	1/4-20 HEX NUT	NNH1/4-20
1	9	1/8" PIPE PLUG	MM4554K11
1	8	HUMPHREY VALVE	AAV41-PP
1	7	1/8" PILOT VALVE	AAV341AS08
1	6	1/8" PILOT VALVE	AAV341AR08
1	5	QUICK MALE RUN T	AAQMT-4-8
1	4	QUICK MALE CONN.	AAQMC-5-8
1	3	QUICK MALE CONN.	AAQMC-4-8
1	2	QUICK BRANCH T	AAQBT-4-8
1	1	FLOW CONTROL	AA2000F-03

2213005 Laser Alignment Module

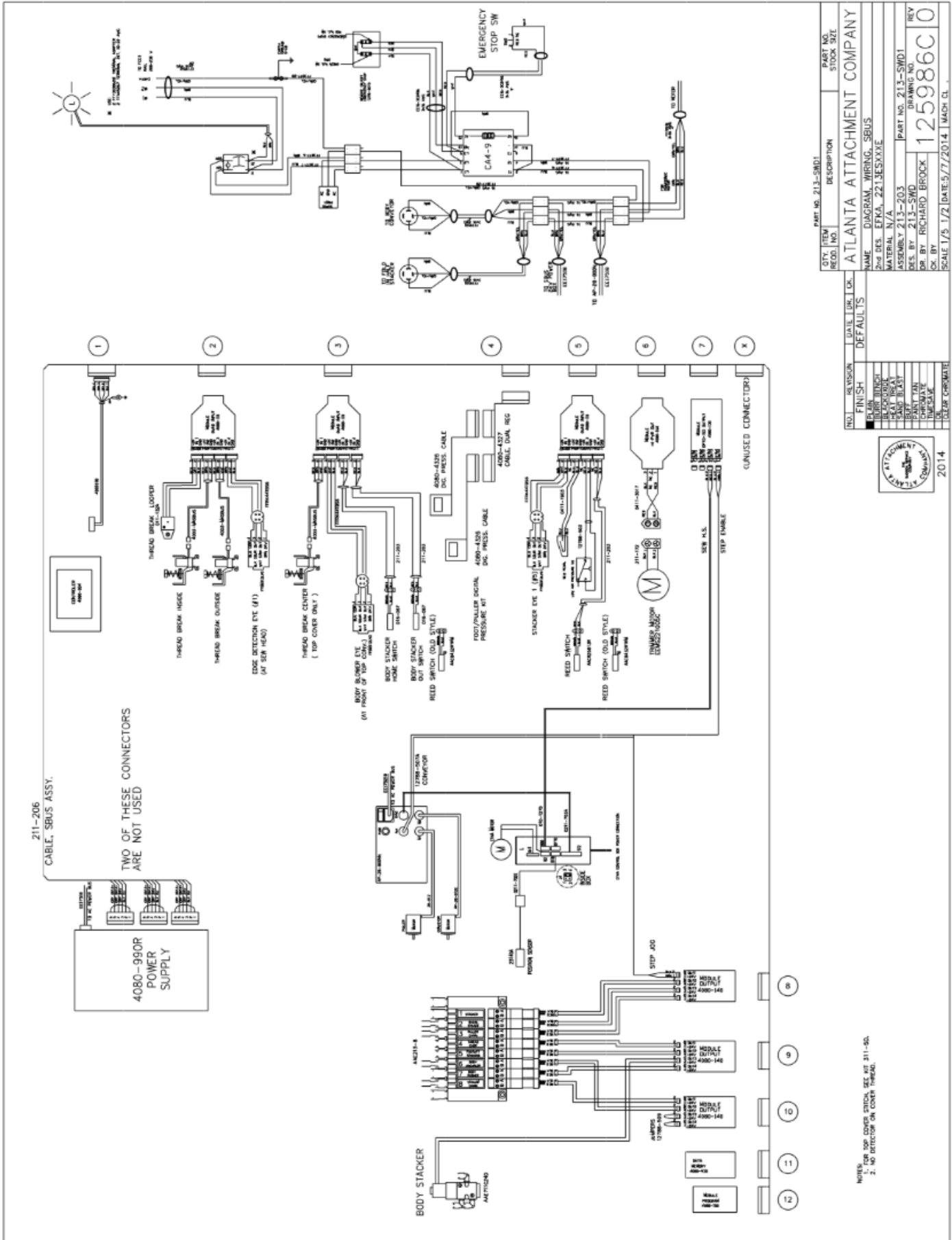
AAC Drawing Number



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	211-203R	CABLE, EXT 12', 2PM TO 2PF MOLEX
2	1	1320931C	LASER,LINE,MOD.
3	1	1395137	COLLAR, SET, THIN, .46 ID
4	1	2213008	WELDMENT, LASER ALIGNMENT
5	1	3304031	HOLDER, LASER
6	1	EEDTS050240Um	POWER SUPPLY, 5VDC, 2.4A MODIFIED
7	2	NNH1/4-20	NUT,HEX,1/4-20
8	1	SSBC98032	10-32 X 1/2 BUTTON CAP SC
9	2	SSHCO1112	1/4-20 X 1-3/4 HHCS
10	1	SSSC98040	10-32 X 5/8 SOC CAP
11	4	WWF1/4	WASHER, FLAT, 1/4", COM
12	1	WWFS10	WASHER, FLAT, #10, SAE
13	2	WWL1/4	WASHER,LOCK, 1/4
14	1	WWL10	WASHER,LOCK,#10

Pneumatic and Electrical Details

213-SWD1 Wiring Diagram



CITY, ITEM	DESCRIPTION	PART NO.	STOCK SIZE
REC'D. NO.			
ATLANTA ATTACHMENT COMPANY			
NAME	DIAGRAM, WIRING, SBU5		
2nd DES.	EPKA, 2213ESXXXE		
MATERIAL	N/A	PART NO. 213-SWD1	DRAWING NO.
ASSEMBLY	213-203		
DES. BY	RICHARD BROCK		REV
CHK. BY			125986C 0
SCALE	1/5, 1/2	DATE: 5/7/2014	MACH. CL.

NO.	REVISION	DATE	BY	OR.
1	FINISH			DEFAULTS
2	REVISION			
3	REVISION			
4	REVISION			
5	REVISION			
6	REVISION			
7	REVISION			
8	REVISION			
9	REVISION			
10	REVISION			
11	REVISION			
12	REVISION			

NOTES:
 1. FOR TOP COVER SWITCH, SEE KIT 311-50.
 2. NO DETECTOR ON COVER THREAD.

Notes

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 a la 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 neumática-cas.
- Desgaste normal de piezas como correas, anillos de goma, cuchillas, agujas, etc.
- Ajustes de la máquina en relación con 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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