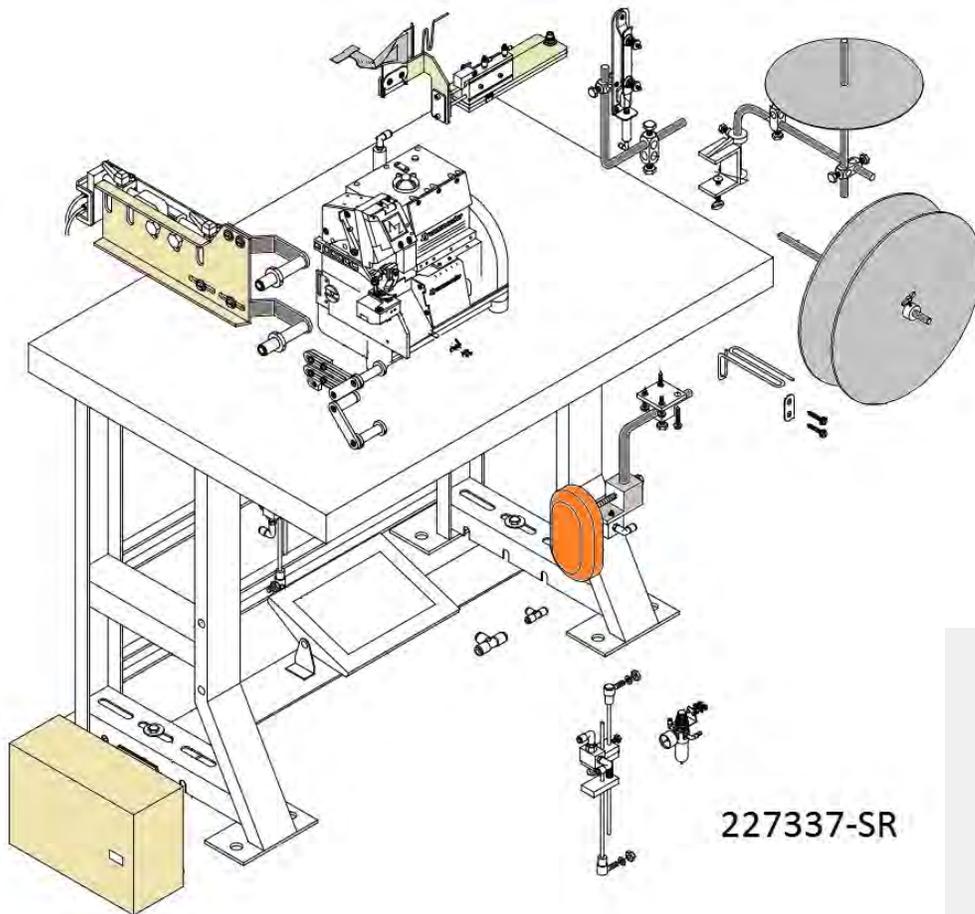




Model **273-37**

Revision 1.0 Updated Dec 12, 2016

Technical Manual & Parts Lists



227337-SR

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 1330 Border Zipper Workstation 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.

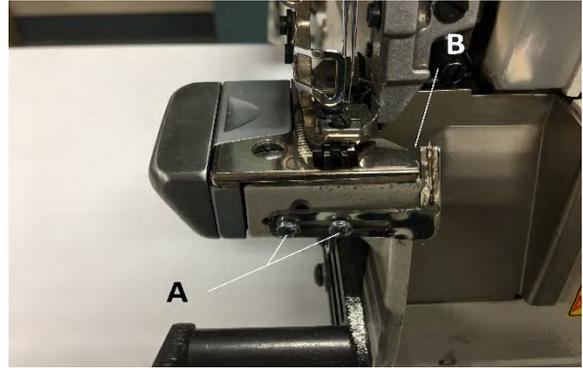
- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS operate equipment in daylight or with adequate working lights.
- Follow daily and weekly checklists, making sure hoses are tightly secured and bolts are tightened.
- ALWAYS watch and avoid holes or deep depressions.
- ALWAYS 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.

Installation

Folder

1.- Install needle finger.

It needs to be as close as possible to the throat plate (B).
Mount it using 2 screw A

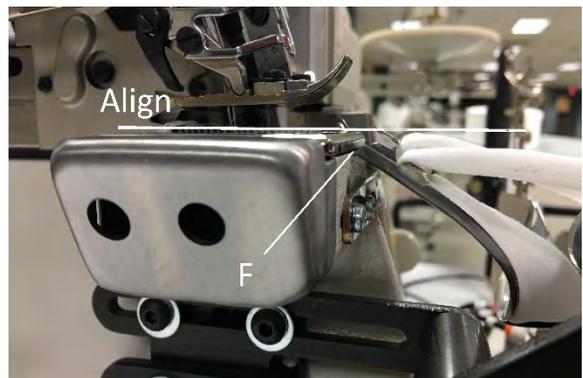


2. – Initial position of Folder bracket.

With the block C in the down position and the cylinder retracted, the left side of the folder needs to be aligned with the right side of the throat plate (D),



The front part of the folder should be close as possible (F) and parallel with the throat plate and the height should be just below the throat plate (G)

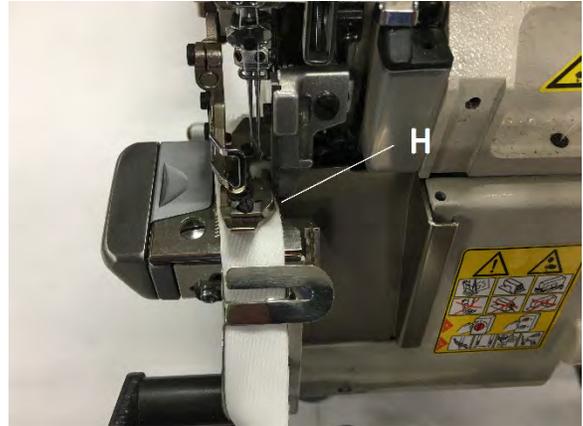


Use the 2 screws (E) on the cylinder bracket and the 2 screws (G) get the adjustment.



3. - Fine adjustment of folder position.

With the cylinder extended, the right side of the tape needs to be barely cut by the side-trimming knife. (H)



4. - Tape Roll Holder and tape tensioning

Align the roll holder (I) with the tape tensioner (J) and folder (K) to make a smooth transition from the tape roll to the folder. Try to keep the three components set the same height.



5. - Collar Dispenser

Use the same rod of the tape holder to support the collar roll.(L) Install the tensioning wire (M) in an easy spot for the operator to access.



Rollers

1. – Front Rollers

- a.- Install roller mount bracket using screws (N)
- b.- Loosen screws (O) and (P) and set upper roller (R) as close as possible to the folder keeping the 20 degrees angle in relation to the throat plate as show on picture,.

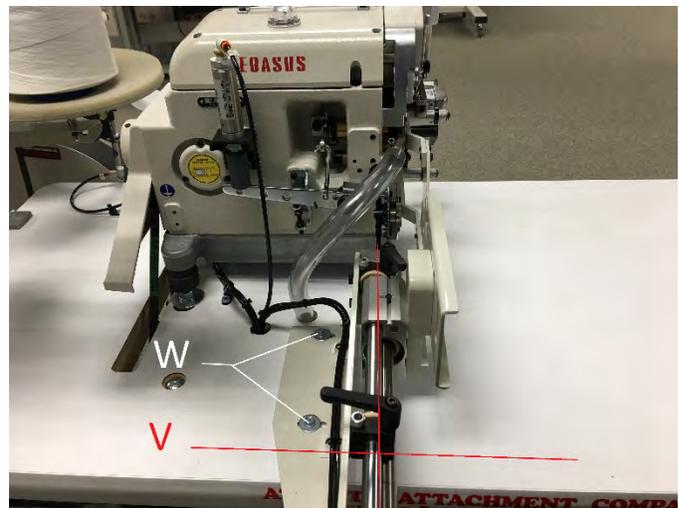


- c.- Adjust Position of lower roller
Loosen screws (T) and (U); adjust position of lower roller (S) according to the picture



2. – Back Rollers

- a.- The cylinder shaft needs to be perpendicular to the table. (V) Do not tighten screws (W) before front and side adjustment



b.- Front adjustment

With the assembly at the maximum forward position, level the upper roller with the throat plate by loosening both holding screws (Z). Set the lower roller (X) as close as possible to the front rollers without touching it; use adjusting screws (Y)



c.- Side adjustment

Set the lower roller assembly as close as possible to the machine without touching it



Install control box, treadle rod assembly and air regulator
Make sure to allow space for control box access and airline connections. Install Templex vacuum kit if its apply



Install knee switch and connect the airlines to the components according to the pneumatic diagram.



Operation

1.- Sequence

a.- Material loading and initial sewing.

The operator heels the treadle to raise the presser foot — load the circular collar over the rollers and under the foot — load the shirt over the rollers and under the foot. A touch of the knee switch shifts the folder to the left and expands the rollers bringing the tape in line with the presser foot.

The operator removes the tape from the pinching needle and locates it under the presser foot. The seams starts on the left shoulder seam inserting the tape

Folder is located on the left position. The back roller is open tensioning the collar and shirt.

Operator drops the foot and sews

b.- Setting the Tape.

Approximately 1" from the right shoulder seam the folder is shifted to the right by activating the knee switch; continuing the sewing will allow the tape to be cut by the edge-trimming knife this produces a neat rounded finish on the tape. The tape may be retracted at any point in the cycle. Rollers stay opened

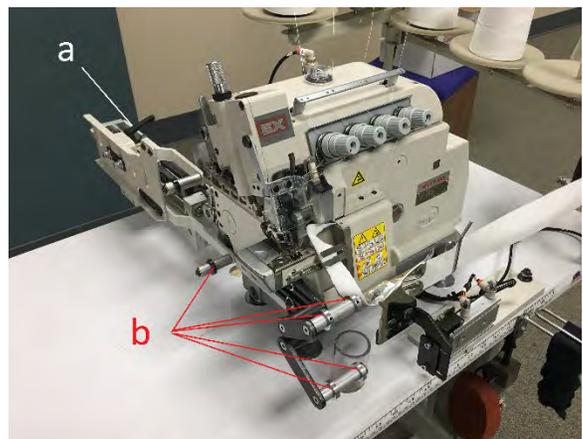
c.- End of seam.

After finishing the seam, the operator activates the knees switch. The tape folder stay to the right away from the machine, the rollers collapse releasing the collar.

2.- Collar Size Adjustment

The size of the collar is adjusted by moving the stop block (a) on the cylinder. The position of the collar is adjusted by moving the collars ring (b) located on all the rollers

Note: The 273-37S operates the same as the 273-37 except the rollers, while adjustable for size, do not expand or retract pneumatically.



Final Seam product view



3.- Threading the machine

1. - Extend the folder
2. - Raise the cylinder block (A)
3. - Retract the folder



- 4.- Swing the folder bracket out
- 5.- Open the access door



4.- Air pressure

A regulator is located inside the pneumatic control box. Recommended air pressure is 60 Lbs. It controls the general pressure and the expansion of the rolls.



Parts List

1	32	COLLAR TAPE FOLDER	273-374
2	31	1/4-20 HEX NUT	NNH1/4-20
2	30	1/4 LOCKWASHER	WWL1/4
2	29	1/4-20 X 3/8 SS SCREW	SSHC01064
AR	28	PNEUMATIC DIAGRAM	27337PDS
1	27	QUICK UNION T	AAQUT-5-5
1	26	WASHER PLATE	WW25DW1
2	25	SAE FLAT WASHER	WWFS10
2	24	10-32 X 3/8 SS SCREW	SSPS8024
5	23	1/4 AIRLINE	AA1P4-1
4	22	5/32 AIRLINE	AA1P5/32
1	21	ROD CONNECTOR	A-U
2	20	12 IN. STAT DISK	785-A9-12
1	19	UNIV BIND REEL	780-U-1024
1	18	ROD, 12 IN.	780-101
1	17	KNEE SWITCH	AA192-6-1
1	16	NEEDLE BRACKET	273-37-02
1	15	THROAT PLATE	273-37-01
1	14	ROLLER ASSY, REAR	1279CS-R
1	13	FOLDER MNT ASSY	1279CS-F
1	12	ROLLER ASSY, FRNT	1279CS-F
1	11	GUIDE WIRE	1279-188
1	10	FOLDER MOUNT	1279-172
1	9	CONT BOX	27337CB
1	8	TENSION ASSY	1000PR
1	7	PUSH TYPE FOOTLIFT	11259
2	6	BRASS WASHER	WWB6S
1	5	WASHER PLATE	WW25DW
2	4	SCREEN SHEET METAL	SSSZH#10064
2	3	SCREEN PLATE SLOTTED	SSPSM3X5
2	2	SCREEN WASHER HEAD	SSM223S
1	1	QUICK UNION T	AAQUT-4-4

QTY	ITEM	DESCRIPTION
1	1	1
1	2	2
1	3	3
1	4	4
1	5	5
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1	7	7
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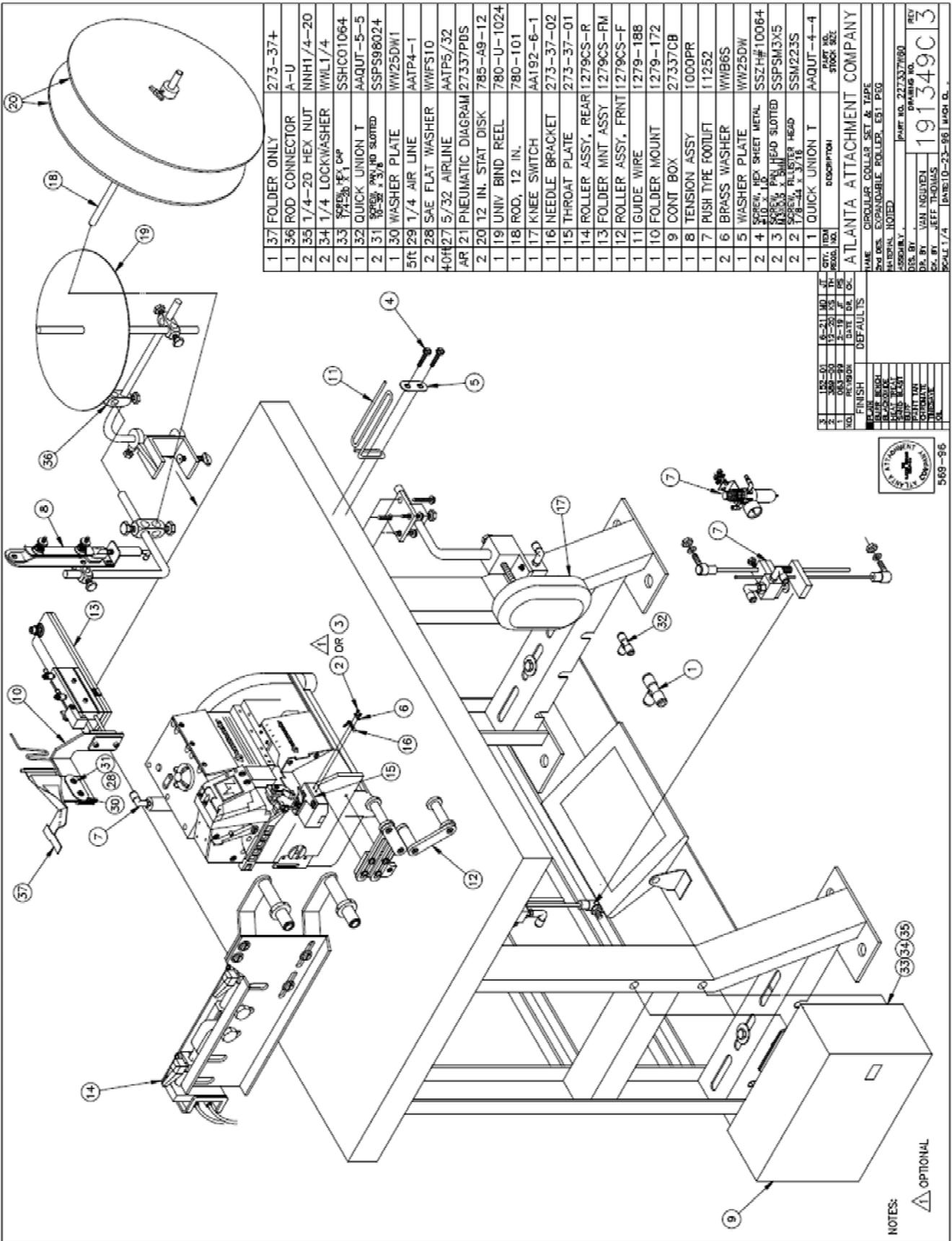
ATLANTA ATTACHMENT COMPANY

NAME: CIRCULAR COLLAR SET & TAPE
 QTY DES: EXPANDABLE ROLLER, 8403, YAM
 MATERIAL: NOTED
 ASSEMBLY:
 DES. BY: MARCIA DILLON
 CK. BY: JEFF THOMAS
 PART NO. 273371025
 DRAWING NO. 191326C
 REV. 5
 SCALE: 1/4" = 1" (REV'D-23-98) (REV'D)

524-96

NOTES:
 1. OPTIONAL
 2. NOT SHOWN

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1	37 FOLDER ONLY	273-374
1	36 ROD CONNECTOR	A-U
2	35 1/4-20 HEX NUT	NNH1/4-20
2	34 1/4 LOCKWASHER	WML1/4
2	33 5/16" x 1" CAP	SSHCO1064
1	32 QUICK UNION T	AAQT-5-5
2	31 3/8" DIA HO SLOTTED	SSPS98024
1	30 WASHER PLATE	WW25DW1
5ft	29 1/4 AIR LINE	AATP4-1
2	28 SAE FLAT WASHER	WWFS10
40ft	27 5/32 AIRLINE	AATPS/32
AR	21 PNEUMATIC DIAGRAM	27337PDS
2	20 12 IN. STAT DISK	785-A9-12
1	19 UNIV BIND REEL	780-U-1024
1	18 ROD, 12 IN.	780-101
1	17 KNEE SWITCH	AA192-6-1
1	16 NEEDLE BRACKET	273-37-02
1	15 THROAT PLATE	273-37-01
1	14 ROLLER ASSY, REAR	1279CS-R
1	13 FOLDER MNT ASSY	1279CS-PM
1	12 ROLLER ASSY, FRNT	1279CS-F
1	11 GUIDE WIRE	1279-188
1	10 FOLDER MOUNT	1279-172
1	9 CONT BOX	27337CB
1	8 TENSION ASSY	1000PR
1	7 PUSH TYPE FOOT/FT	11252
2	6 BRASS WASHER	WWB6S
1	5 WASHER PLATE	WW25DW
2	4 SCREW, HEX SHEET METAL	SSZH#10064
2	3 SCREW, PAN HEAD SLOTTED	SSPSM3X5
2	2 SCREW, ROLLER HEAD	SSM223S
1	1 QUICK UNION T	AAQT-4-4
1	1 CONT BOX	27337CB
1	1 TENSION ASSY	1000PR
1	1 PUSH TYPE FOOT/FT	11252
2	1 BRASS WASHER	WWB6S
1	1 WASHER PLATE	WW25DW
2	1 SCREW, HEX SHEET METAL	SSZH#10064
2	1 SCREW, PAN HEAD SLOTTED	SSPSM3X5
2	1 SCREW, ROLLER HEAD	SSM223S
1	1 QUICK UNION T	AAQT-4-4

3	125-01	6-21	100	100
2	100-01	15-20	100	100
1	050-01	5-19	100	100
NO	REGION	DATE	DR	DC
FINISH				
REWORK				
BLACKENING				
POLISH				
TEXT				
DR				
CHK				
CMT				
DATE				
BY				



NOTES:
 OPTIONAL

ATLANTA ATTACHMENT COMPANY
 NAME: CIRCULAR COLLAR SET & TAPE
 3rd DES: EXPANDABLE ROLLER, EST. P60
 MATERIAL: NOTED
 ASS'Y: PART NO. 227337060
 DES. BY: VAN NGUYEN
 CHK. BY: JEFF THOMAS
 SCALE: 1/4
 DRAWING NO. 191349C3
 REV 3
 DATE: 10-23-96
 WDR: DL

1	44	FOLDER ONLY	273-37+
2	43	1/4-20 HEX NUT	NNH1/4-20
2	42	1/4 LOCKWASHER	WWL1/4
2	41	1/2" X 1" CAP	SSHCO1064
1	40	ROD	1279-71

1	39	HANDLE, THREADED	TH32415
1	38	SHORT BLOCK	1279-25
1	37	5/8" X 1" X 3/4" HEX CAP	SSHCO10048
2	36	FLAT WASHER	WWF8

5	35	FLAT WASHER	WWF5/16
4	34	NUT 5/16-18	NNUS/16-18
2	33	5/16 X 1/2 SET COLLAR	1279-29
2	32	1/2 X 3/4 SET COLLAR	1279-30
2	31	1/2 X 7/8 SET COLLAR	1279-31
1	30	ROD THREADED	1279-28
2	29	2.5" ROLLER	1279-20
1	28	PARTS BAG FOR 1279	1279-PB1
1	27	BASE CASTING ASSM.	1279-03
AP	26	PNEUMATIC DIAGRAM	27337PDS
30RT	25	BLACK NYLON AIRLINE	AATP5/32
SFT	24	BLACK NYLON AIRLINE	AATP4-1
1	23	WASHER PLATE	WW25DW1
4	22	1/2" X 3/4" PH ROD SLOTTED	SSPS80024
1	21	FOLDER MOUNT	1279-172A
4	20	NO. 10 WASHER	WWFS10
2	19	1/2" X 1" FLUSTR HEAD	SSM22569B
1	18	NEEDLE BRACKET	273-37-04
1	17	PARTS FOR 273-34	273-34U70
1	16	PNEUMATIC COINT ASSY	27337CB
1	15	CIRCULAR NECK DEVICE	1279CS-R
1	14	PNEUMATIC FOOTLIFT	11295
4	13	1/2" X 3/4" PH ROD SLOTTED	SSZTH10064
1	12	1/2" X 3/4" PH ROD	SSM#1/4
1	11	FOLDER MOUNT ASBLY	1279CS-FM
1	10	UNIV BIND REEL	780-U-1024
1	9	1/2" X 1" FLUSTR. CAP	SSSC01032
4	8	SOLATOR W/PINS	51295B
1	7	COVER PLATE	F273-34-11
3	6	SAE FLAT WASHER	WWFS1/4
1	5	SUPPORT	F273-34-23
1	4	OFFSET ROD	F273-34-22
1	3	QUICK UNION TEE	AADUT-4-4
1	2	TENSION ASSEMBLY	1000PR
1	1	KNEE SWITCH	AA192-6-1

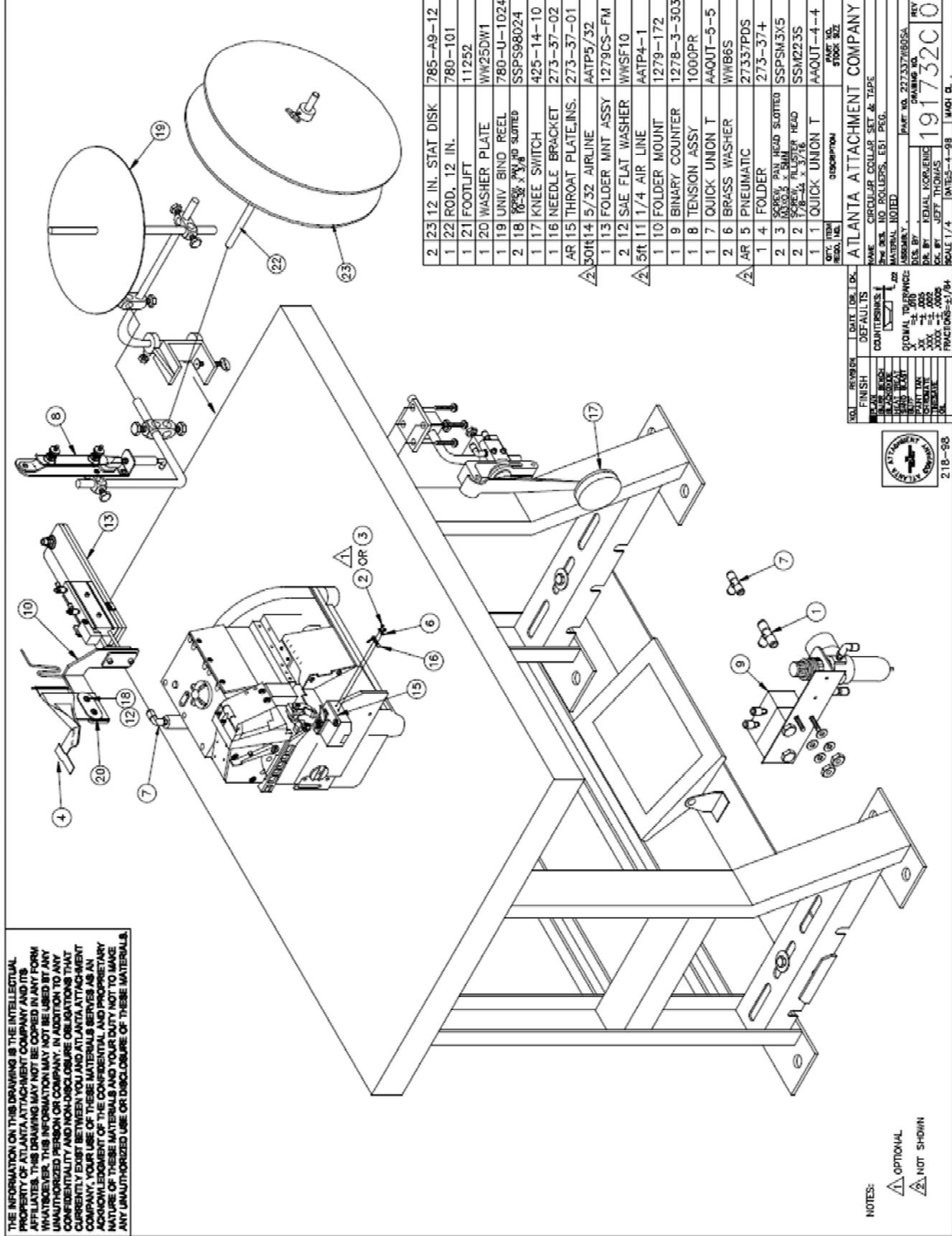
9	12	1/2" X 3/4" PH ROD	SSZTH10064
3	6	SAE FLAT WASHER	WWFS1/4
1	5	SUPPORT	F273-34-23
1	4	OFFSET ROD	F273-34-22
1	3	QUICK UNION TEE	AADUT-4-4
1	2	TENSION ASSEMBLY	1000PR
1	1	KNEE SWITCH	AA192-6-1

NO.	FINISH	DEFAULTS
1	BLACK	
2	BRASS	
3	STAINLESS	
4	ALUMINUM	
5	PHENOLIC	
6	NYLON	
7	BRASS	
8	STAINLESS	
9	ALUMINUM	

NOTES:
 (1) OPTIONAL
 (2) NOT SHOWN

ITEM 28 CONTAINS THE FOLLOWING ITEMS:
 (1) CHIP DEFLECTOR 1279-32
 (4) SLOTTED FLUSTR HEAD SCREW, 183-32 X 1-1/2
 (4) SLOTTED FLUSTR HEAD SCREW, 183-32 X 7/8
 (1) FLUSTR HEAD SCREW, 183 X 1 1/32

ATLANTA ATTACHMENT COMPANY
 NAME: CIRCULAR COLLAR SET & TAPE
 PART NO. 22337J70
 REV 191544C6
 DES. BY: VAN NGUYEN
 DRWING NO. 191544C6
 CK. BY: JEFF THOMAS
 DATE: 04-24-97
 WORK. G.



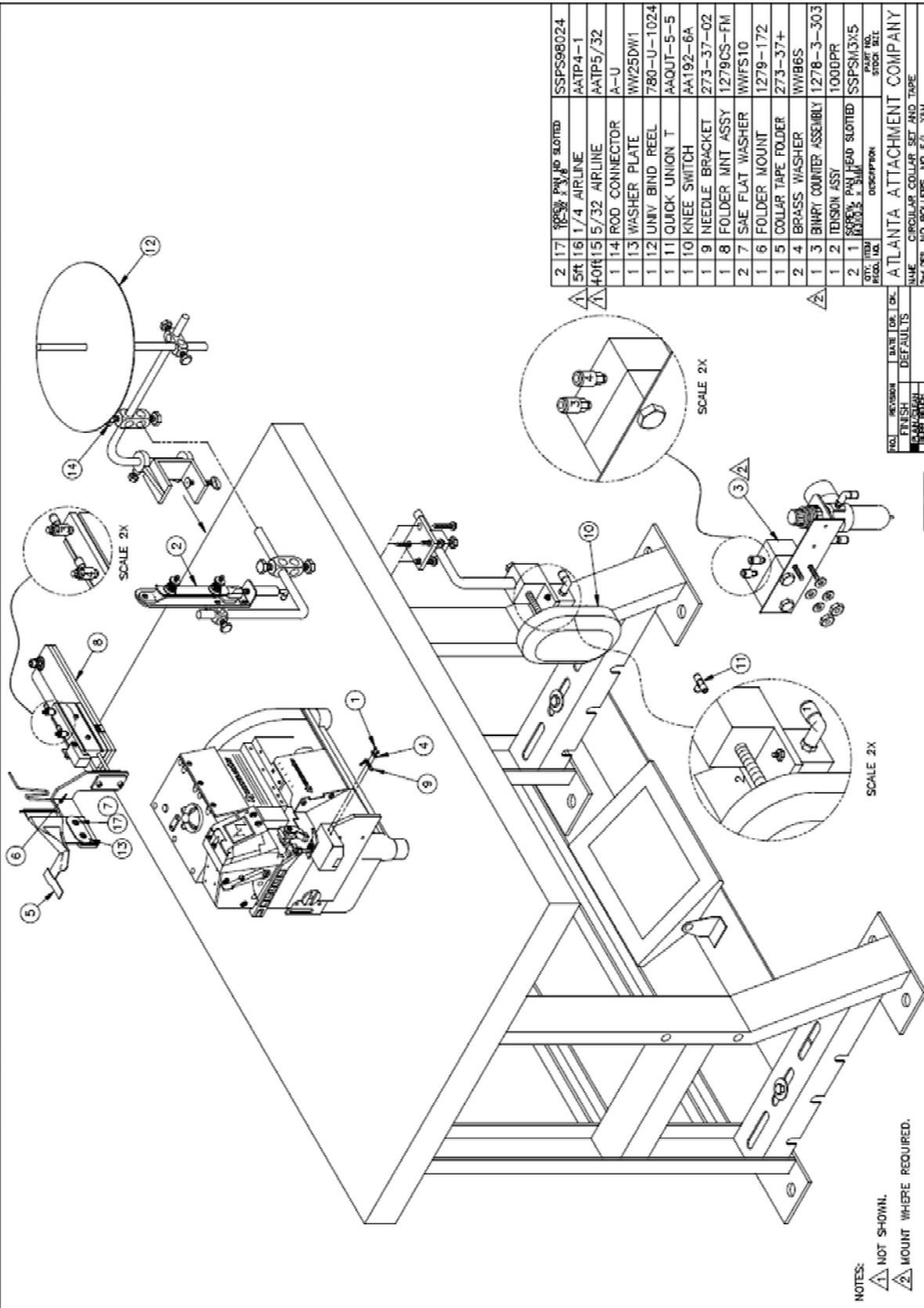
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2	23	12 IN. STAT DISK	785-A9-12
1	22	ROD, 12 IN.	780-101
1	21	FOOTLIFT	11252
1	20	WASHER PLATE	WM25DW1
1	19	UNIV BIND REEL	780-U-1024
2	18	1 1/2" DIA PAN HEAD SLOTTED	SSPS98024
1	17	KNEE SWITCH	425-14-10
1	16	NEEDLE BRACKET	273-37-02
AR	15	THROAT PLATE,INS.	273-37-01
2	14	5/32 AIRLINE	AATP5/32
1	13	FOLDER MNT ASSY	1279CS-FM
2	12	SAE FLAT WASHER	WMSFT10
2	11	1 1/4 AIR LINE	AATP4-1
1	10	FOLDER MOUNT	1279-172
1	9	BINARY COUNTER	1278-3-303
1	8	TENSION ASSY	1000PR
1	7	QUICK UNION T	AAQUT-5-5
2	6	BRASS WASHER	WMB6S
AR	5	PNEUMATIC	27337PDS
1	4	FOLDER	273-374
2	3	SCREW PAN HEAD SLOTTED	SSPSM3X5
2	2	SCREW FLUSTER HEAD	SSM223S
1	1	QUICK UNION T	AAQUT-4-4
QTY	ITEM	DESCRIPTION	PART NO.
	REQD.		STOCK REQ.

QTY	ITEM	DESCRIPTION	PART NO.
	REQD.		STOCK REQ.
ATLANTA ATTACHMENT COMPANY			
NAME CIRCULAR COLLAR SET & TAPE			
PAC. DESK. NO. ROLLERS, EST. PEG.			
MATERIAL NOTED			
DRAWN BY KENAL KORBING			
CHECKED BY JEFF THOMAS			
SCALE 1/4" = 1"			
DATE 10-1-88			
REV 191732C10			



NOTES:
 △ OPTIONAL
 ▽ NOT SHOWN



NOTES:
 1 NOT SHOWN.
 2 MOUNT WHERE REQUIRED.

2	17	100% PLY UP SLOTTED	SSPS98024
5	16	1/4 AIRLINE	AATP4-1
4	15	5/32 AIRLINE	AATP5/32
1	14	ROD CONNECTOR	A-U
1	13	WASHER PLATE	WW25DW1
1	12	UNIV BIND REEL	780-U-1024
1	11	QUICK UNION T	AAQUT-5-5
1	10	KNEE SWITCH	AA192-6A
1	9	NEEDLE BRACKET	273-37-02
1	8	FOLDER MNT ASSY	1279CS-FM
2	7	SAE FLAT WASHER	WWFS10
1	6	FOLDER MOUNT	1279-172
1	5	COLLAR TAPE FOLDER	273-37+
2	4	BRASS WASHER	WWB6S
1	3	BINARY COUNTER ASSEMBLY	1278-3-303
2	2	TENSION ASSY	100DPR
2	1	SCREW, PAN HEAD SLOTTED	SSPSM3X5
			SSPSM3X5
			SSPSM3X5

DATE	BY	CHKD	DESCRIPTION
			ATLANTA ATTACHMENT COMPANY
			CIRCULAR COLLAR SET AND TAPE
			NO ROLLERS, NO F/L, YAM
			MATERIAL NOTED
			REV
			1925630
			DESIGNED BY
			JEFF THOMAS
			DR. BY
			REV
			1925630
			SCALE 1/4" = 1" (10:1)
			1000000-2-97
			1000000-2-97
			1000000-2-97

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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	2	1279-36	ROD, STRAIGHT, 5P.
2	2	1279-80	COLLAR, FRONT ROLLER
3	1	1279-82B1	REAR ROLLER BRACKET
4	1	1279-82D	PLATE, WASHER 1.5 CENTER
5	1	1279-82E	WASHER PLATE, 7/32, 3PL.
6	1	1279-164	CYLINDER MOUNT BRACKET
7	2	1279-171A	CLAMP, TOP
8	2	1279-171B	CLAMP, CYLINDER STOP
9	1	1279-177	FLOW CONTROL GAUDD
10	1	1279-181	BRKT, TABLE MOUNT
11	1	1279-182	TOP REAR ROLLER BRKT
12	1	1279-183	BRKT, BOTTOM
13*	1	1279-148	LABEL SCALE
14	2	1297-20	ROLLER
15	2	A419BRAS10	FLOW CONTROL S/32X10-32
16	1	A4CNCY25-8	CYLINDER, RODNESS
17	2	S8BC98024	10-32 X 3/8 BUTTON CAP SC
18	4	S8BC98032	10-32 X 1/2 BUTTON CAP SC
19	2	S8FC98032	10-32 X 1/2 FLAT ALLEN CAP
20	2	S55C01048	1/4-20 X 3/4" SOC CAP SC
21	4	S55C01064	1/4-20 X 1 SOC CAP
22	2	S55C05032	1/4-28 X 1/2 SOC CAP
23	2	S55C05048	1/4-28 X 3/4 SOC CAP
24	4	S55C98056	10-32 X 7/8 SOC CAP
25	2	S32H10064	3 SCREW SHT METAL HEX 10
26	2	WMB105	WASHER BRASS, 10, SMALL
27	2	WVFF1/4	WASHER FLAT FELT, 5/16 X 1/3
28	2	WVFS1/4	WASHER FLAT, SAE, 1/4
29	2	WVFS10	WASHER, FLAT, #10, SAE
30	2	WVLI1/4	WASHER LOCK, 1/4
31	4	WVSI10	WASHER INTERNAL TOOTH, 10

PART NOT SHOWN

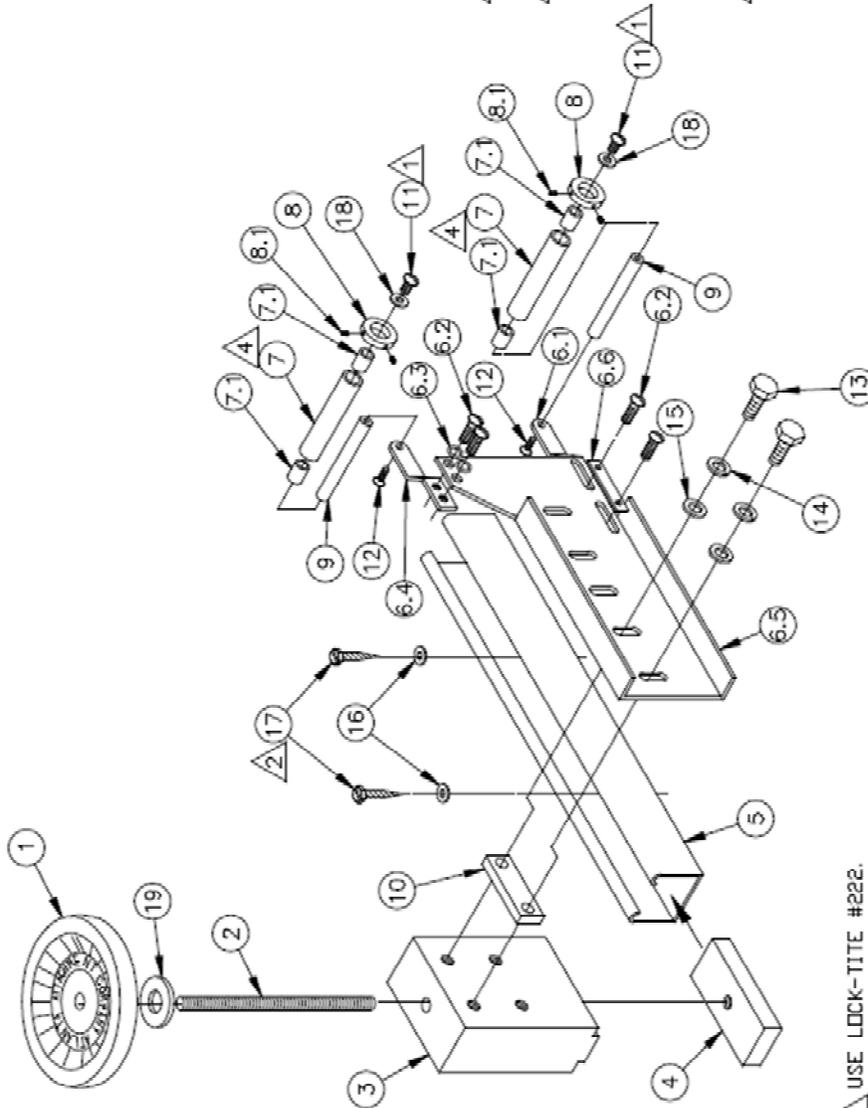
1920008

FINISH		DEFAULTS		ATLANTA ATTACHMENT COMPANY	
1	204	132	48	NAME	GEAR ROLLER ASST
2	200	174	16	2ND USE	
3	200	174	16	WEIGHT	POUNDS
4	200	174	16	WEIGHT	POUNDS
5	200	174	16	WEIGHT	POUNDS
6	200	174	16	WEIGHT	POUNDS
7	200	174	16	WEIGHT	POUNDS
8	200	174	16	WEIGHT	POUNDS
9	200	174	16	WEIGHT	POUNDS
10	200	174	16	WEIGHT	POUNDS
11	200	174	16	WEIGHT	POUNDS
12	200	174	16	WEIGHT	POUNDS
13	200	174	16	WEIGHT	POUNDS
14	200	174	16	WEIGHT	POUNDS
15	200	174	16	WEIGHT	POUNDS
16	200	174	16	WEIGHT	POUNDS
17	200	174	16	WEIGHT	POUNDS
18	200	174	16	WEIGHT	POUNDS
19	200	174	16	WEIGHT	POUNDS
20	200	174	16	WEIGHT	POUNDS
21	200	174	16	WEIGHT	POUNDS
22	200	174	16	WEIGHT	POUNDS
23	200	174	16	WEIGHT	POUNDS
24	200	174	16	WEIGHT	POUNDS
25	200	174	16	WEIGHT	POUNDS
26	200	174	16	WEIGHT	POUNDS
27	200	174	16	WEIGHT	POUNDS
28	200	174	16	WEIGHT	POUNDS
29	200	174	16	WEIGHT	POUNDS
30	200	174	16	WEIGHT	POUNDS
31	200	174	16	WEIGHT	POUNDS

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SCALE: 1:4 DATE: 10/16/2000 DWG: 1279CS-R1

REV 2



NOTES:

- 1 USE LOCK-TITE #222.
- 2 SCREWS TO TABLE TOP.
- 3 THIS ASSEMBLY IS BROKEN DOWN INTO SUB-ASSEMBLIES AND PART USING DECIMAL NUMBERS. ALL POINT NO'S COME WITH THE PARENT NO. OF THE PART. EXAMPLE (6) IS PART OF THE SUB-ASSEMBLY (6).
- 4 USE ACCULUBE BEFORE INSTALLING ROLLER

QTY.	ITEM	DESCRIPTION	PART NO.	STOCK SIZE
1	19	FLAT WASHER	WWFS/16	
2	18	FLAT WASHER	WWFB	
2	17	SCREW, HEX SH METAL	SSZH#10096	
2	16	10 FLAT WASHER	WWF10	
2	15	5/16 SAE FLAT WASHER	WWFS5/16	
2	14	5/16 LOCK WASHER	WWL5/16	
2	13	SCREW, HEX CAP	SSHC10064	
2	12	SCREW, FLAT ALLEN CAP	SSFC98032	
2	11	SCREW, PAN SLOTTED	SSPS98024	
1	10	SPACER	1279-96	
2	9	ROD, STRAIGHT, SP JEW R	1279-36	
4	8.1	SCREW, SOCKET SET	SSSS80008	
2	8	FRONT ROLLER COLLAR	1279-80	
4	7.1	BEARING	UUAA306-07	
2	7	2.5 IN. ROLLER	1279-20	
1	6.6	PLATE	1279-82E	
1	6.5	BRACKET	1279-82B	
1	6.4	BRACKET	1279-82C	
2	6.3	FLAT WASHER	WWFS10	
4	6.2	SCREW, PAN SLOTTED	SSPS98024	
1	6.1	BRACKET	1279-82A	
1	6	REAR ROLLER BRKT ASSY	1279-82	
1	5	REAR ROLLER TRACK	1279-85	
1	4	SLIDE LOCK	350-12005	
1	3	REAR ROLLER BLOCK	1279-83	
1	2	5/16-18 x 5 1/2 ROD	350-12540	
1	1	MACHINED HANDWHEEL	3501*1M	

ATLANTA ATTACHMENT COMPANY

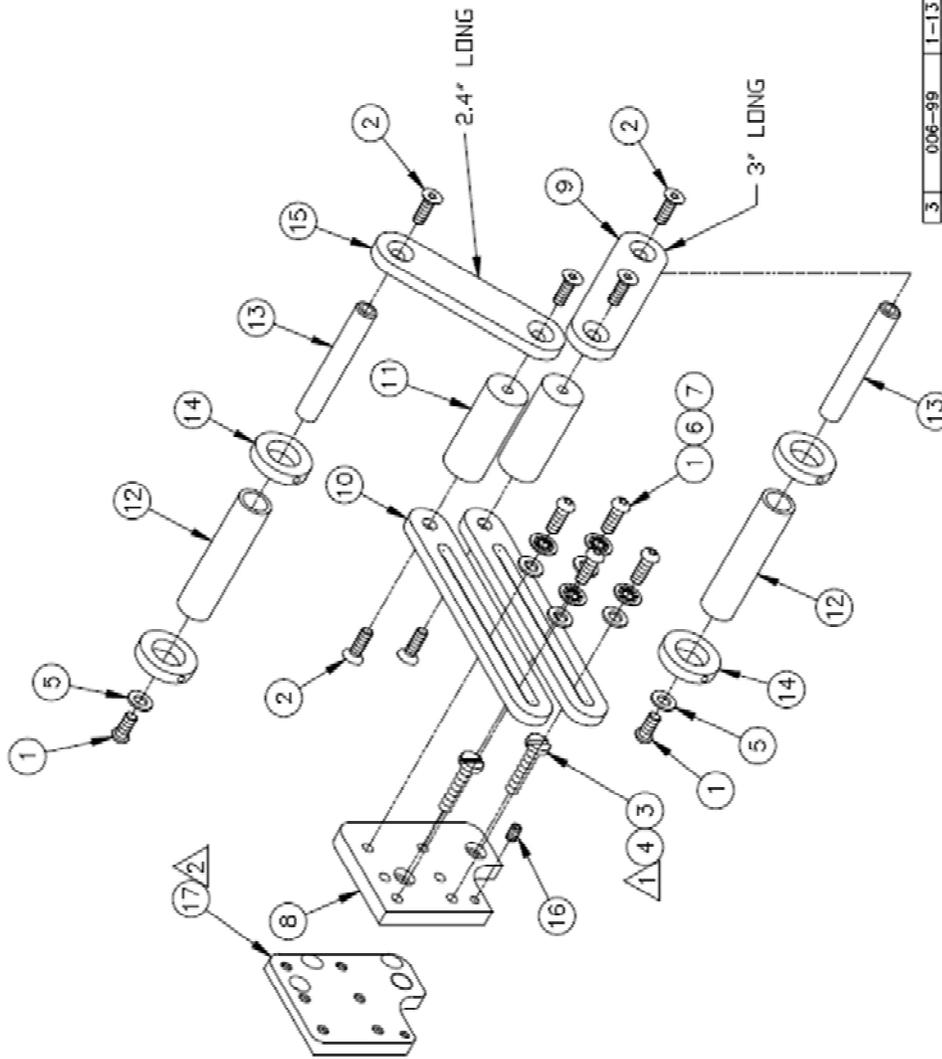
NAME	ROLLER ASSY., REAR
2nd DES.	FOR -1279W6025
MATERIAL	NOTED
ASSEMBLY	-1279W6025
PART NO.	1279W-002
DES. BY	JEFF THOMAS
DR. BY	DANNY MURPHY
CK. BY	
DATE	05/22/91
SCALE	1/5
DRAWING NO.	190132B
REV	4

NO.	REVISION	DATE	DR.	OK.	FINISH	TOLERANCE
4		3-4-97	MD	JT	PLAIN	
3		3-06-97	VN	JT	BURR BENCH	SURFACE ✓
2		1-79-96	DM	DM	BLACKOXIDE	DECIMALS
1		0-20-93	AH	DM	HEAT TREAT	.X = ± .010
					SAND BLAST	.XX = ± .005
					BLUFF	.XXX = ± .002
					PART TAN	.XXXX = ± .0005
					CHROMATE	FRACTIONS=1/64
					THRESAVE	



156-91

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3	006-99	1-13	VN	JT
2	290-97	8-29	VN	JT
1	341-96	6-28	AH	JT
NO.	REVISION	DATE	DR.	QC.
FINISH				
PLAIN				
BURR BENCH				
BLACK OXIDE				
HEAT TREAT				
SAND BLAST				
BURF				
PART TEN				
CHROMATE				
TIMESAVE				
OIL				

1	17	FR ROLLER MNT PLATE	1279-224
1	16	SCREW, SOCKET, SET NYLON 8-32 x 3/8	SSSP90024
1	15	ROLL SUPPORT BRKT	1279-174A
4	14	FRONT ROLLER COLLAR	1279-80
2	13	ROD, STRAIGHT	1279-362.1
2	12	ROLLER	1279-202.1
2	11	ROL BRACKET SPACER	1279-176
2	10	ROL ADJUST BRACKET	1279-175
1	9	ROL SUPPORT BRACKET	1279-174
1	8	FR ROLLER MNT PLATE	1279-173
4	7	#10 INT TOOTH WASHER	WWFS10
4	6	#10 SAE FLAT WASHER	WWFS10
2	5	#10 BRASS WASHER	WWB10S
2	4	SCREW, PAN HEAD SLOTTED M4X0.7 x 20mm	SSPSM4X20
2	3	SCREW, FILLISTER HEAD 11/64-40 x 3/4	SSM50267
6	2	SCREW, FLAT ALLEN CAP 10-32 x 1/2	SSFC98032
6	1	SCREW, BUTTON CAP 10-32 x 1/2	SSBC98032
QTY.	ITEM	DESCRIPTION	PART NO.
REQD.	NO.		STOCK SIZE

NOTES:

1 MOUNTS TO SEWING HEAD.
USE ITEM 3 OR 4 AS
REQUIRED.

2 REPLACE ITEM 8 WITH ITEM 17 FOR PEGASUS, JUKI HEAD.



216-96

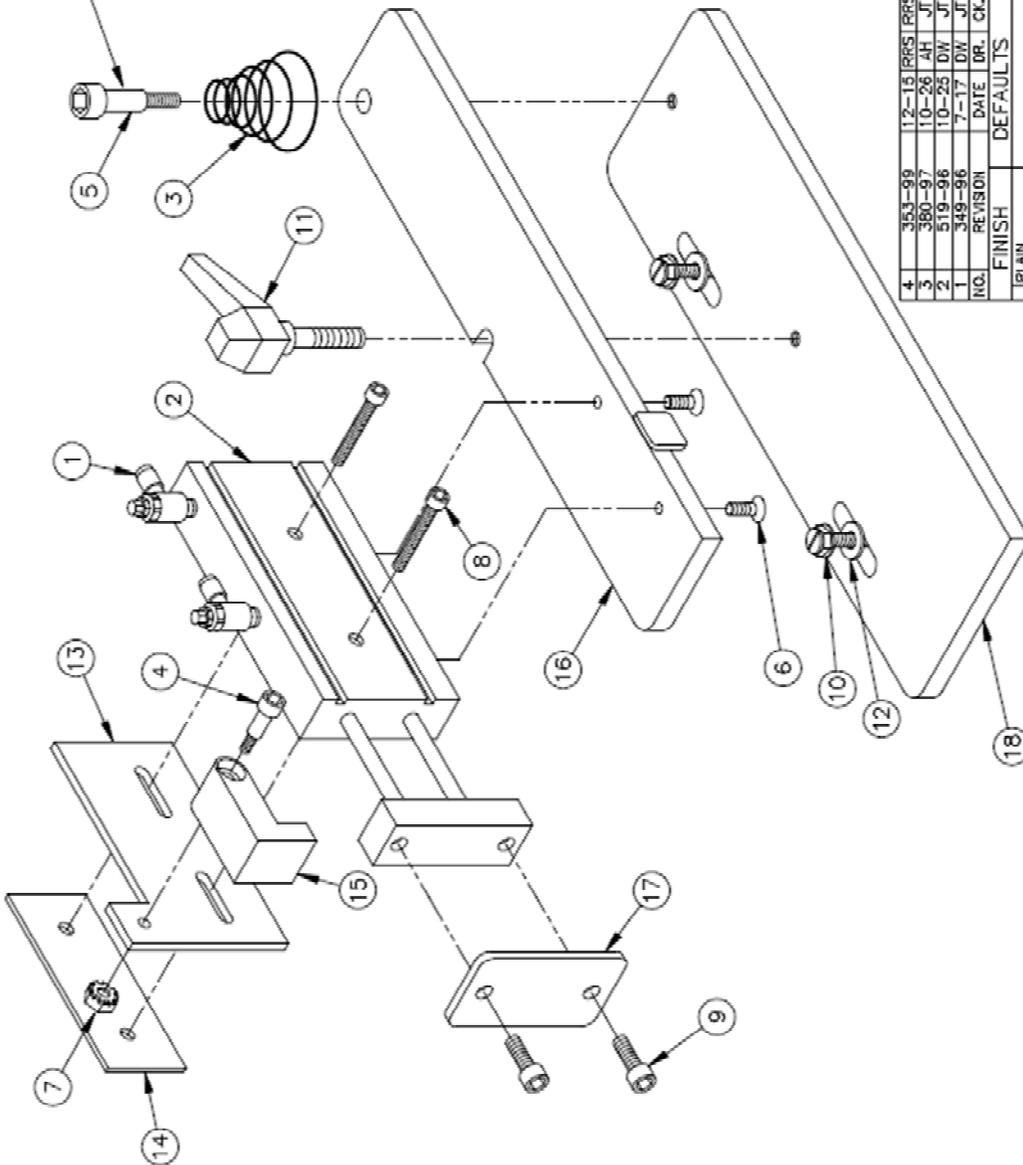
ATLANTA ATTACHMENT COMPANY

NAME: ROLLER ASSEMBLY, FRONT
2nd DES. - 27337, 504-E51 PEG
MATERIAL NOTED
ASSEMBLY - 1279CS
DES. BY: WGO
DR. BY: JEFF THOMAS
OK. BY: ALAN HUTCHINS
PART NO. 1279CS-F
DRAWING NO. 190343B3
REV. 3

SCALE 1/2 DATE: 4-30-96 MACH CL. 504-E51 PEG
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GRIND SCREW FLUSH WITH BOTTOM



1	18	MOUNT PLATE	1279-186
1	17	WASHER PLATE	1279-185
1	16	CYLINDER MOUNT	1279-184
1	15	CYLINDER STOP	1279-180
1	14	CYL STOP NUT	1279-179
1	13	CYLINDER STOP BRKT	1279-178
2	12	NO. 10 WASHER	WWFS10
1	11	THREADED HANDLE	TTH32410
2	10	SCREW, HEX SHEET METAL	SSZH#10064
2	9	SCREW, SOCKET CAP	SSSCM4X16
2	8	SCREW, SOCKET CAP	SSSC70048
1	7	8-32 KEP NUT	NNK8-32
2	6	SCREW, FLAT CAP	SSFC3MX10M
1	5	SCREW, ALLEN SHOULDER	SSAS016040
1	4	SCREW, ALLEN SHOULDER	SSAS012032
1	3	BEEHIVE SPRING	RRBEEHIVEH
1	2	AIR CYLINDER	AACXSM1030
2	1	FLOW CONTROL	AA198RA510

ATLANTA ATTACHMENT COMPANY	
NAME	FOLDER MOUNT ASSEMBLY
2nd DES.	227337, 504-E51 PEG
MATERIAL NOTED:	
ASSEMBLY:	
DES. BY	ALAN HUTCHINS
DR. BY	ALAN HUTCHINS
CK. BY	JEFF THOMAS
SCALE	1/1 1/2 DATE: 4-3-96
PART NO.	1279CS-FM
DRAWING NO.	190362B
REV	4
MACH CL.	

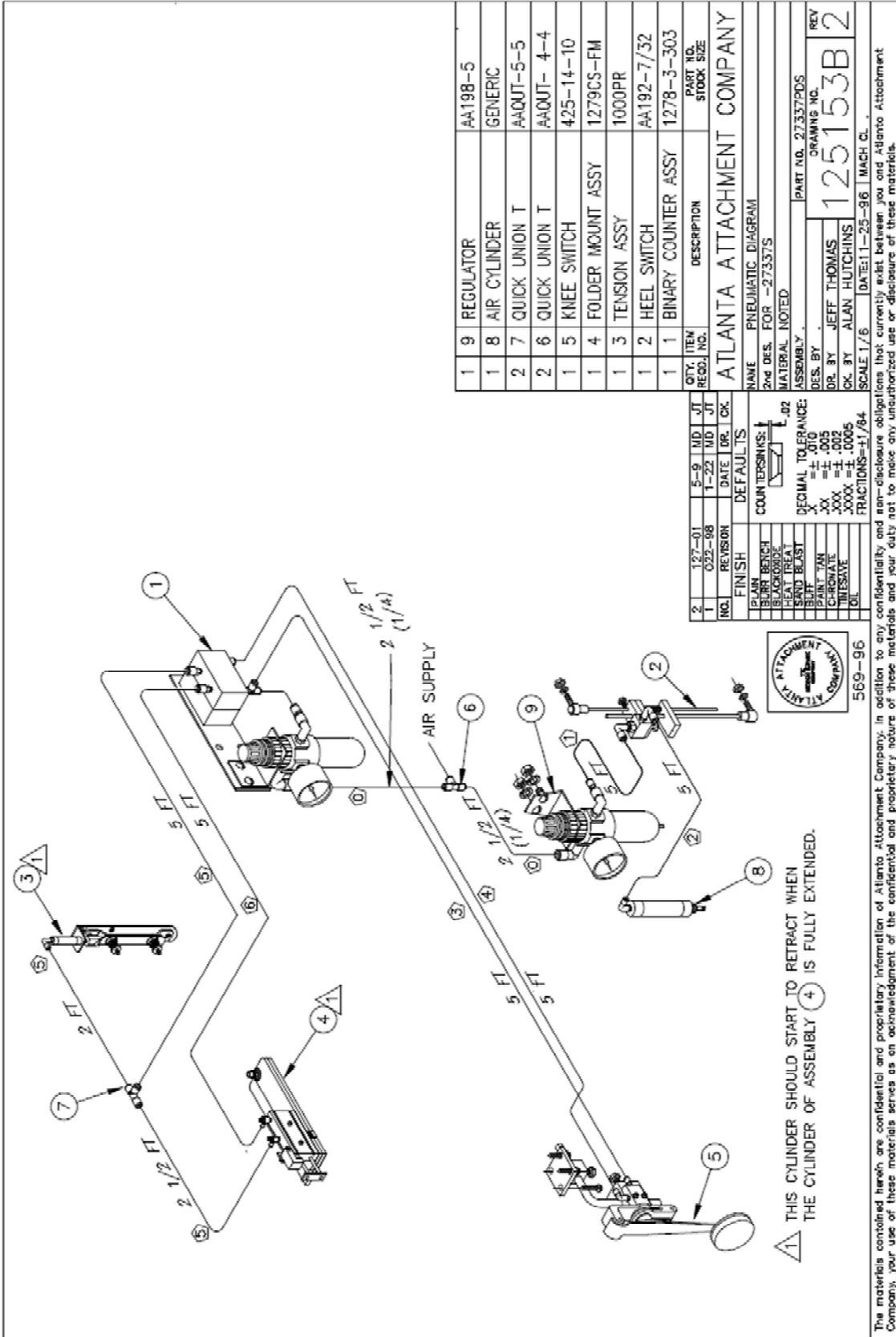
4	353-99	12-13	RRS	RRS
3	380-97	10-26	AH	JT
2	519-96	10-25	DW	JT
1	349-96	7-17	LDW	JT
NOL	REVISION	DATE	DR.	CK.
FINISH				
PLAIN				
BLURB BENCH				
BLACK OXIDE				
HEAT TREAT				
SAND BLAST				
PAINT TAN				
CHROMATE				
TINNESATE				
OIL				



171-96

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Pneumatic Diagram



QTY.	ITEM	RECD. NO.	DESCRIPTION	PART NO.	STOCK SIZE
1	9		REGULATOR	AA198-5	
1	8		AIR CYLINDER	GENERIC	
2	7		QUICK UNION T	AAQUT-5-5	
2	6		QUICK UNION T	AAQUT-4-4	
1	5		KNEE SWITCH	425-14-10	
1	4		FOLDER MOUNT ASSY	1279CS-FM	
1	3		TENSION ASSY	1000PR	
1	2		HEEL SWITCH	AA192-7/32	
1	1		BINARY COUNTER ASSY	1278-3-303	

NO.	REVISION	DATE	DR.	CHK.
2		127-01	5-9	JMD
1		022-98	1-22	JMD

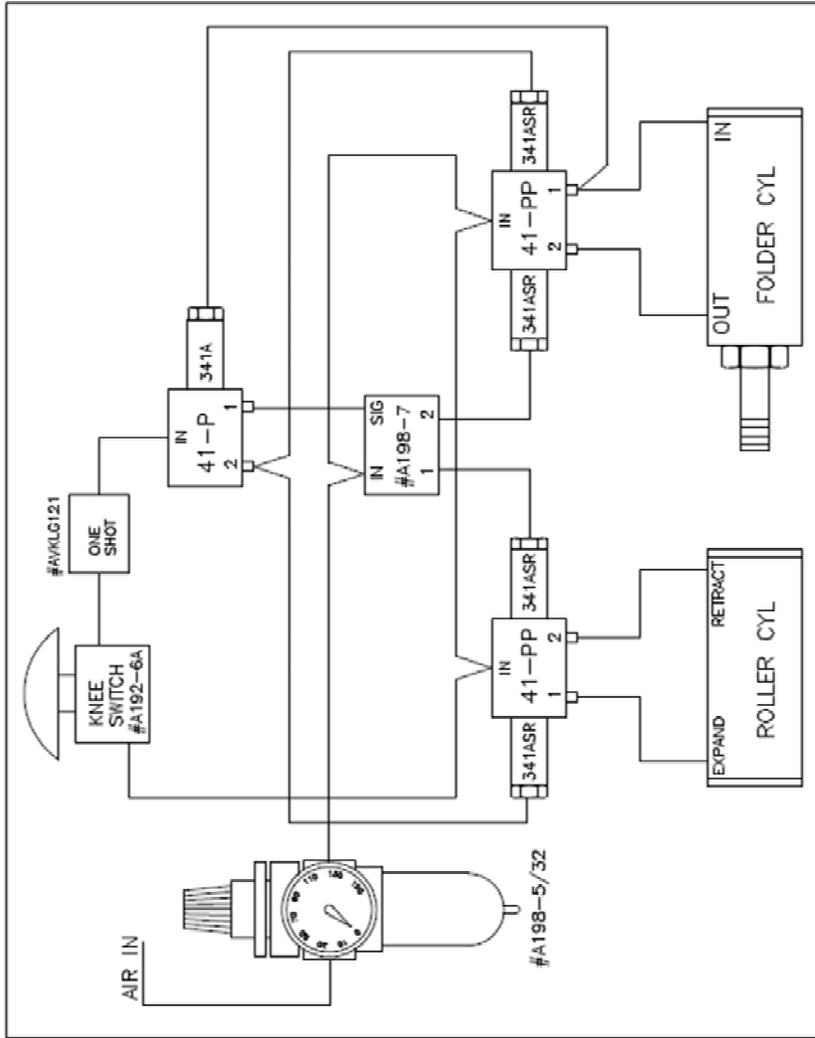
FINISH	DEFAULTS
PLAIN	COUNTERSINKS: .02
BURR BENCH	DEGMAL TOLERANCE:
BLAFOURDE	XX = ± .010
HEAT TREAT	XX = ± .005
SHOT BLAST	XX = ± .003
PAINT TAN	XXXX = ± .0005
CHROME	FRACTIONS=1/64
THRESHAVE	
OIL	

ATLANTA ATTACHMENT COMPANY

NAME: PNEUMATIC DIAGRAM
 2nd DES. FOR: -27337S
 MATERIAL: NOTED
 ASSEMBLY: PART NO. 27337PDS
 DES. BY: JEFF THOMAS
 DR. BY: ALAN HUTCHINS
 CK. BY: ALAN HUTCHINS
 SCALE: 1/6 | DATE: 11-23-96 | MACH. CL. 2

569-96

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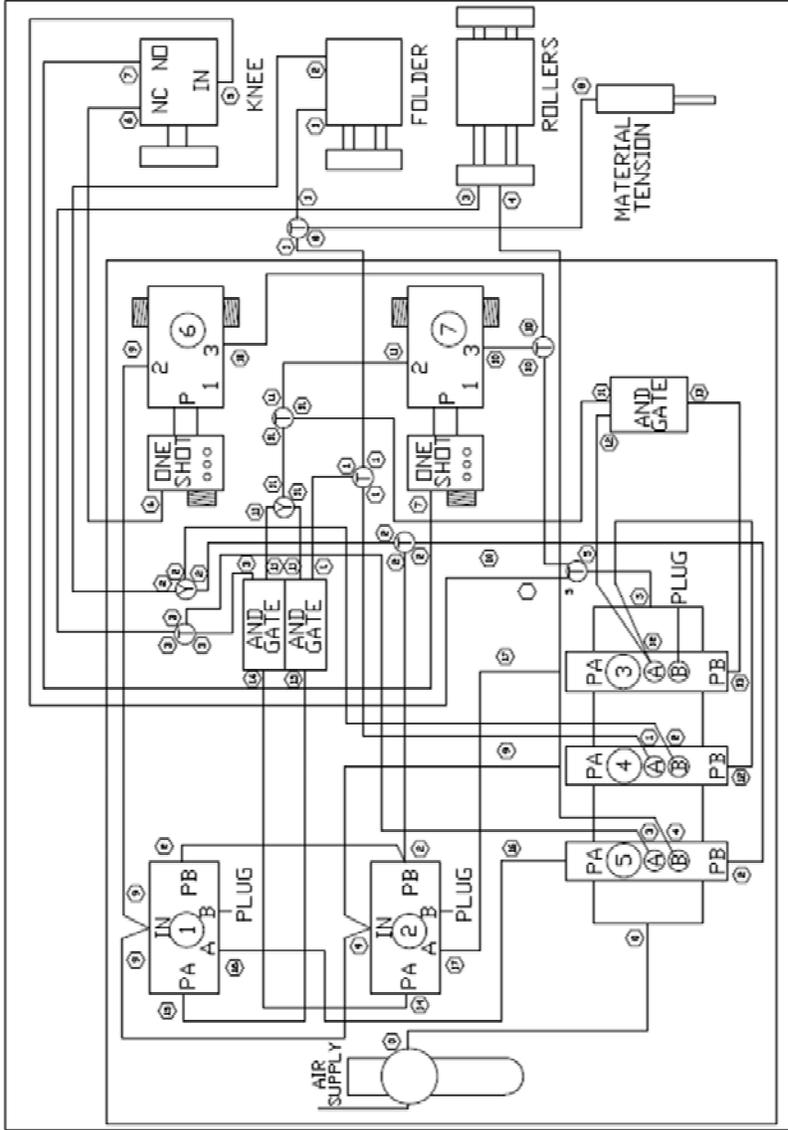
TO SCALE 1/1

NO.	REVISION	DATE	DR.	CK.	QTY.	ITEM	DESCRIPTION	PART NO.	STOCK SIZE
FINISH					ATLANTA ATTACHMENT COMPANY				
PLAIN					NAME PNEUMATIC DIAGRAM				
BLURR BENCH					2nd DES. FOR -27337				
BLACKOXIDE					MATERIAL TAN ADHESIVE				
HEAT TREAT					PART NO. 27337PD1				
SAND BLAST					DRAWING NO. 125271A				
BUFF					ASSEMBLY .				
PAINT TAN					DES. BY ALAN HUTCHINS				
CHROMATE					DR. BY ALAN HUTCHINS				
TIMESAVE					CK. BY JEFF THOMAS				
OIL					SCALE 1/1 DATE: 1-11-96 MACH CL .				
DECIMAL TOLERANCE:					PART NO. 27337PD1				
.X = ± .010					DRAWING NO. 125271A				
.XX = ± .005					REV				
.XXX = ± .002					REV				
.XXXX = ± .0005					REV				
FRACTIONS=±1/64					REV				



021-96

PLOT TO SCALE



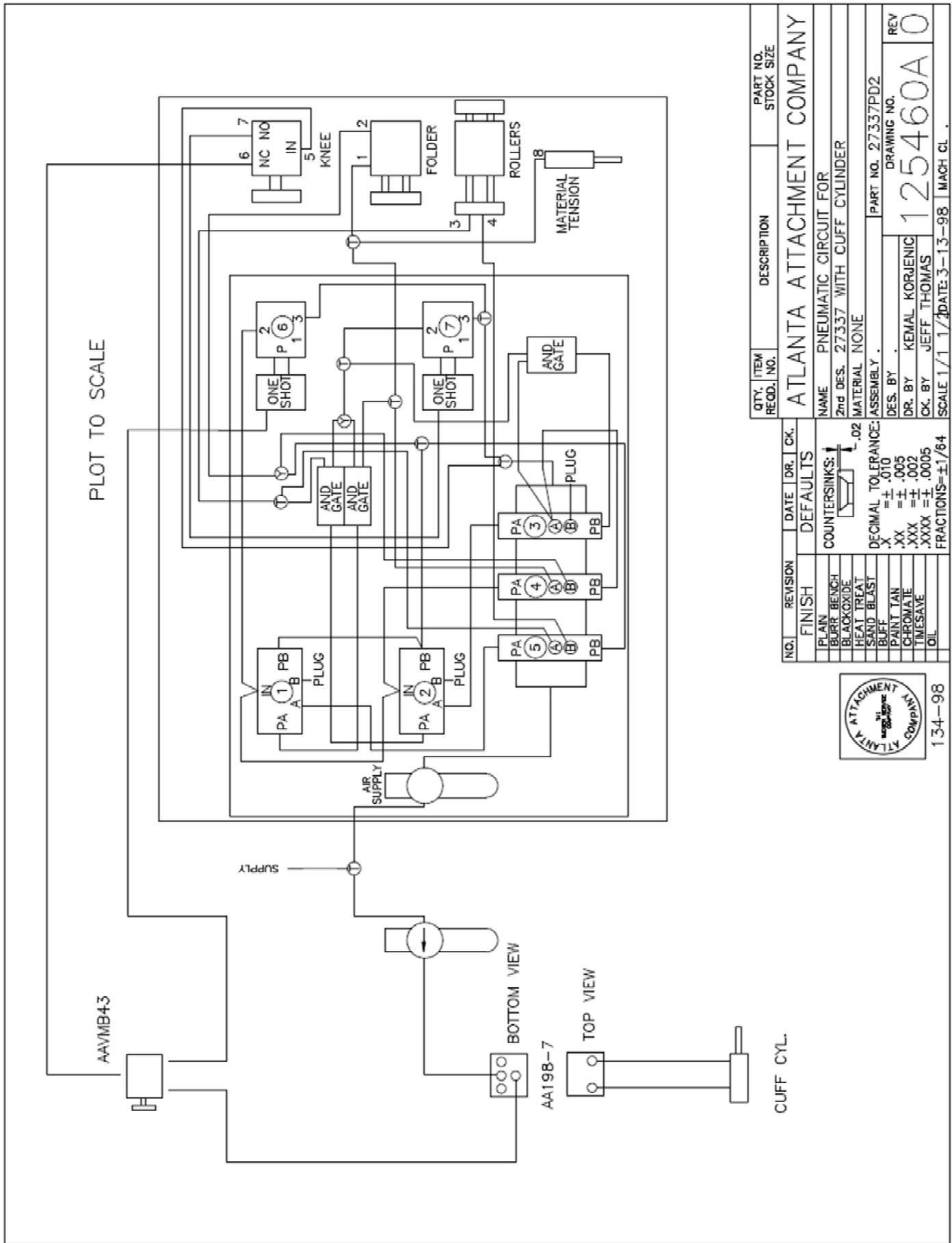
6	294-00	9-25	JT	TH
5	080-98	2-11	KK	JT
4	576-96	11-22	VN	JT
3	507-96	10-21	MD	JT
2	074-96	2-12	DW	JT
1	064-96	2-2	AH	JT

QTY.	ITEM	DESCRIPTION	PART NO.
REQD.	NO.		STOCK SIZE
ATLANTA ATTACHMENT COMPANY			
NAME		COLLAR SET AND TAPE PNEUMATIC CIRCUIT	
2nd DES.		MATERIAL NONE	
ASSEMBLY		PART NO. 27337P1	
DES. BY		RON SEGARS	
DR. BY		JEFF THOMAS	
CK. BY		SCALE 3/4	
DATE		1-22-96	
DR. CK.		MACH CL.	

FINISH		DEFAULTS	
PLAIN	BENCH	COUNTERSINKS:	1.02
BLACKOXIDE	HEAT TREAT	DECIMAL TOLERANCE:	.XX = ±.010
SAND BLAST	PAINT TAN	.XXX = ±.002	.XXXX = ±.0005
CHROMIATE	TIMESAVE	FRACTIONS=	±1/64
OIL			



044-96

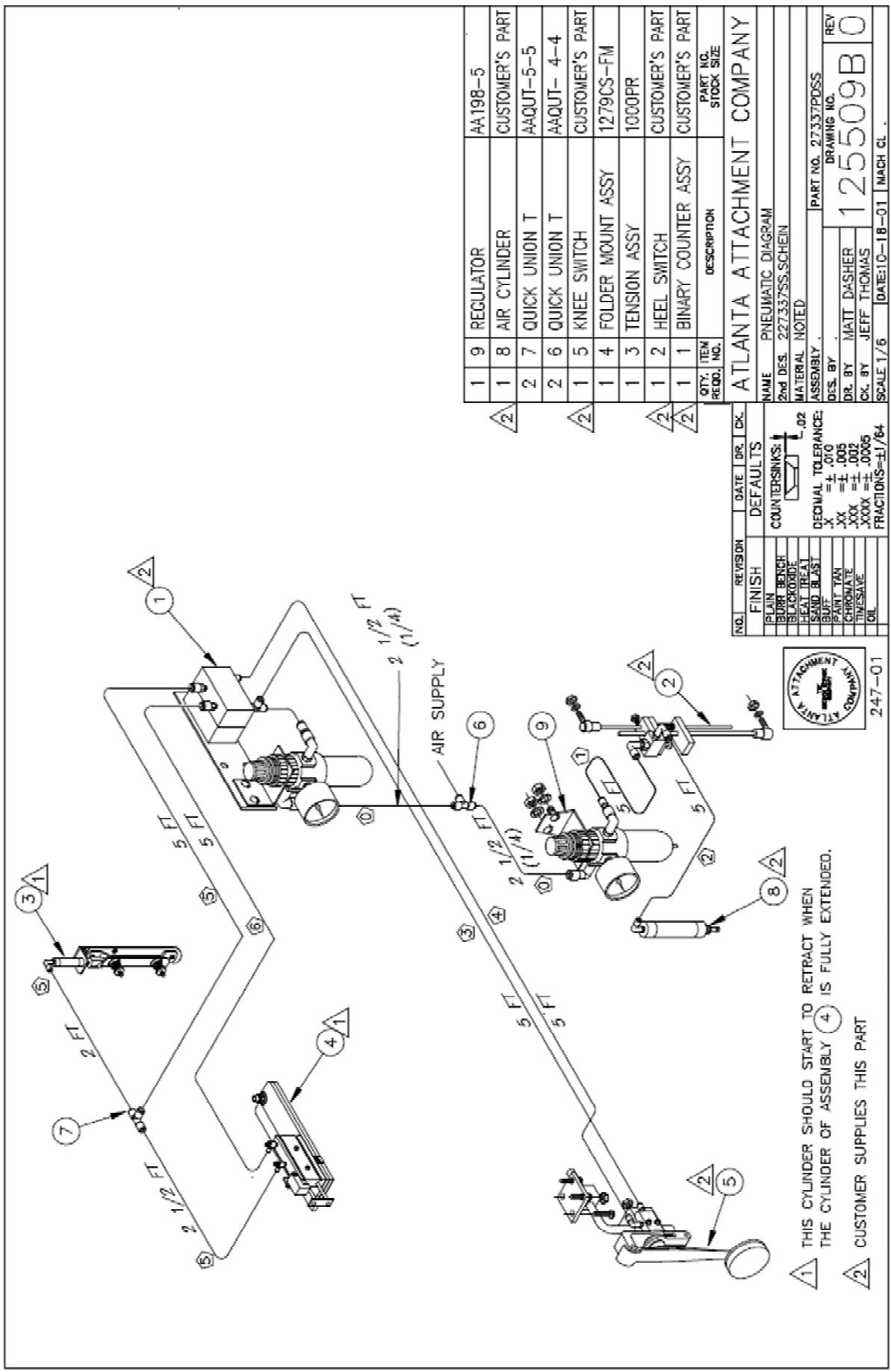


QTY.	ITEM	DESCRIPTION	PART NO.
REC'D.	NO.		STOCK SIZE
ATLANTA ATTACHMENT COMPANY			
NAME PNEUMATIC CIRCUIT FOR			
2nd DES. 27337 WITH CUFF CYLINDER			
ASSEMBLY MATERIAL NONE			
PART NO. 27337PD2			
DRAWING NO.			
125460A			
REV			
DES. BY KEMAL KORJENIC			
DR. BY JEFF THOMAS			
OK. BY			
SCALE 1/1 1/2 DATE 3-13-98 MACH CL.			

NO.	REVISION	DATE	DR.	CK.
DEFAULTS				
COUNTERSINKS: $\frac{1}{16}$.02				
DECIMAL TOLERANCE:				
.X = ± .010				
.XX = ± .005				
.XXX = ± .002				
.XXXX = ± .0005				
FRACTIONS = ± 1/64				



134-98



QTY.	ITEM	DESCRIPTION	PART NO.	STOCK SIZE
1	9	REGULATOR	AA198-5	
1	8	AIR CYLINDER	CUSTOMER'S PART	
2	7	QUICK UNION T	AAQUT-5-5	
2	6	QUICK UNION T	AAQUT-4-4	
1	5	KNEE SWITCH	CUSTOMER'S PART	
1	4	FOLDER MOUNT ASSY	1279CS-FM	
1	3	TENSION ASSY	1000PR	
1	2	HEEL SWITCH	CUSTOMER'S PART	
1	1	BINARY COUNTER ASSY	CUSTOMER'S PART	

NO.	REVISION	DATE	DR.	DC.

FINISH	DEFAULTS
PLAIN BENCH	
BLACKOXYDE	
HEAT TREAT	
SAND BLAST	
BLUF	
PART TAN	
CHROMATE	
THINSEAL	
OIL	

COUNTERSINKS: $\begin{matrix} \text{---} \\ \text{---} \end{matrix}$.02

DECIMAL TOLERANCE:
 X = ± .010
 XX = ± .005
 XXX = ± .003
 XXXX = ± .0005
 FRACTIONS = 1/64

NAME: PNEUMATIC DIAGRAM
 2nd DES. 227337SS-SCHNEIN
 MATERIAL NOTED
 ASSEMBLY

ATLANTA ATTACHMENT COMPANY

SCALE 1/6 DATE 10-18-01 MACH CL.

DR. BY: MATT DASHER
 CK. BY: JEFF THOMAS

PART NO. 27337POSS
 DRAWING NO. 125509B
 REV. 0



247-01

- 1 THIS CYLINDER SHOULD START TO RETRACT WHEN THE CYLINDER OF ASSEMBLY 4 IS FULLY EXTENDED.
- 2 CUSTOMER SUPPLIES THIS PART

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



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Printed in the USA