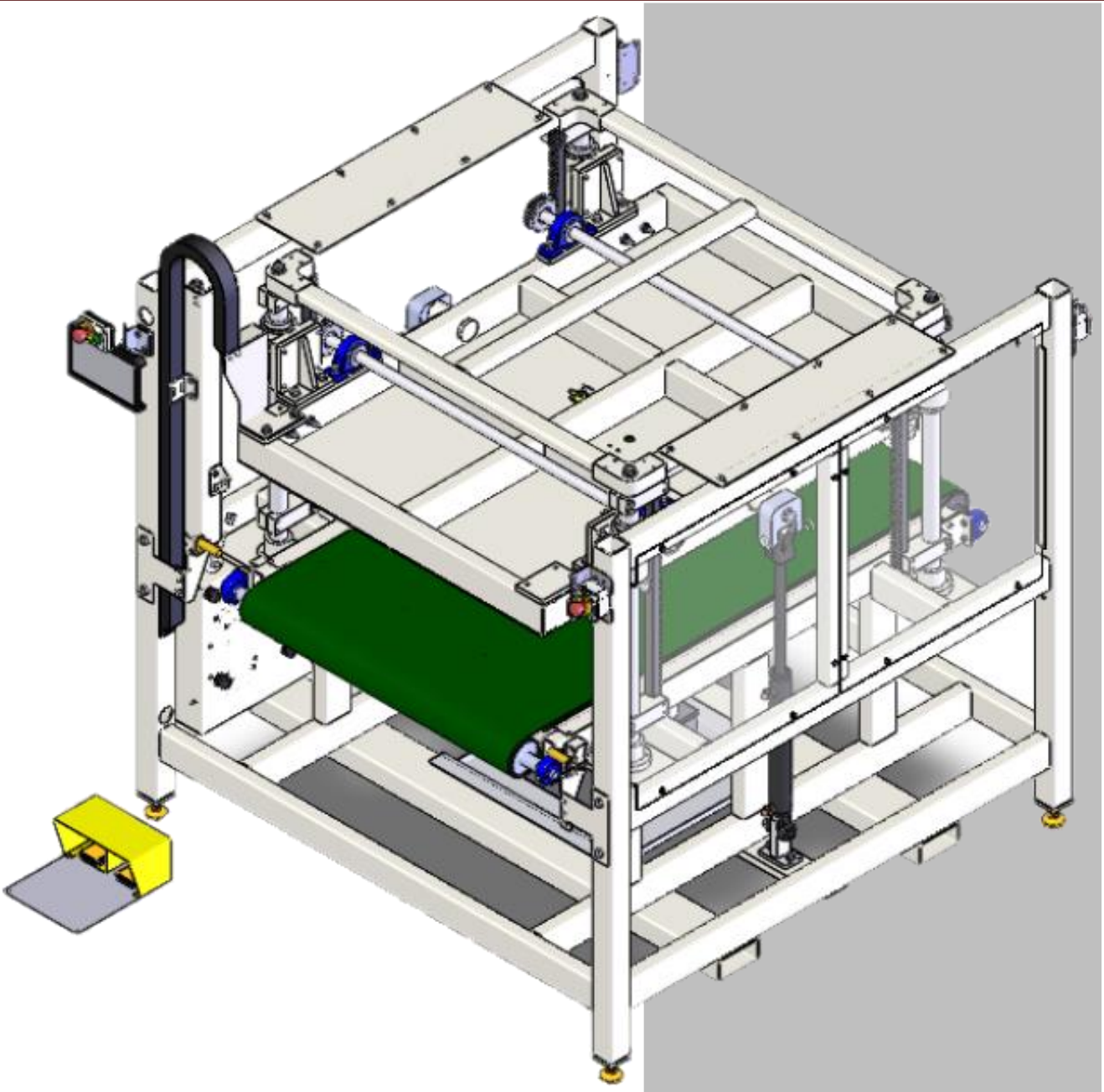
ATLANTA ATTACHMENT COMPANY
SEWING AUTOMATION

Model **1406CA**

Rev 0 Created Aug 21, 2023(wr)

INSTRUCTION & PARTS LIST



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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.

Table of Contents

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 your machine and describes the dangers inherent in machinery. Some of these dangers are obvious, while others are less evident.

Mandatory Information

All persons working on the machine should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only work on the machine 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
- Serial Bus Control system Operator instructions
- 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 pneumatic 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.

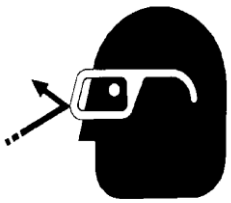
Signs on the Machine

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 set-up 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 us and/or your transport insurer without delay. 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.

Machine Installation

This equipment must be installed by an Atlanta Attachment Co. technician, or by a properly trained and authorized technician/mechanic. Atlanta Attachment Co. reserves the right to void any machine warranty if the machine is installed by anyone other than a qualified person as stated above

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.

Connection, Reconnection

Energy feed and discharge lines must be routed so that they do not run through the operator's working area, are not compressed, crushed or buckled, are not subjected to tensile stresses and cannot rub against anything. This is particularly important in the case of pneumatic, hydraulic and electricity lines or hoses. Always take the machine movements into account when routing such lines.

Electrical Connection

The machine shall only be connected to the factory power supply by a qualified electrician who is familiar with the local regulations. Before switching on the master switch, check that all fasteners are secure.

Pneumatic Connection

Only use dry filtered compressed air. Ensure that the air pressure always remains within the range specified, otherwise malfunctions may occur.

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

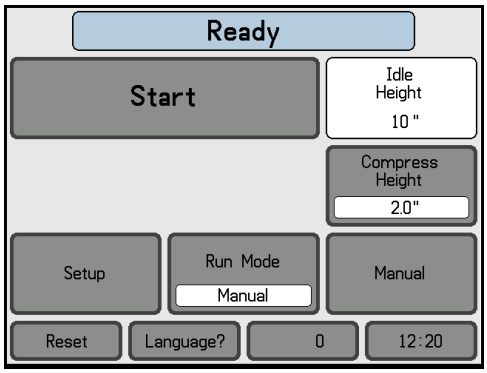
The end user has sole responsibility to enforce the use of safety procedures and guards on the machine. Any other safety devices or procedures due to local regulations should be should be retrofitted in accordance to these regulations and/or the EC Directive on the safety of machines.

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

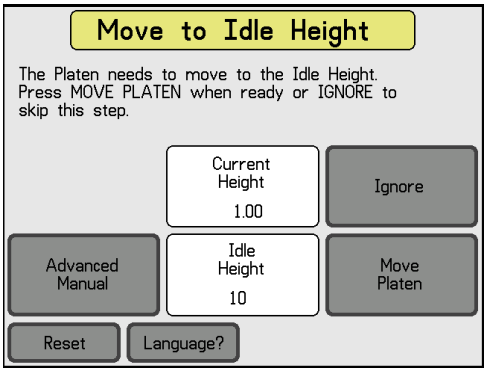
Operation

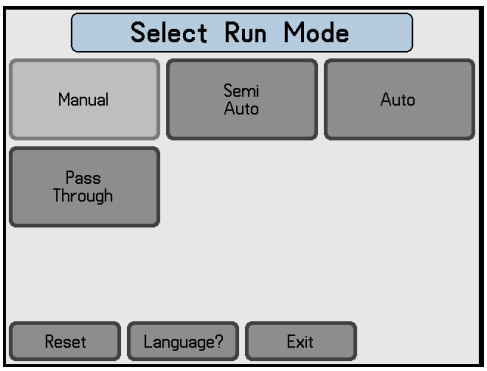
Touch Screen Details

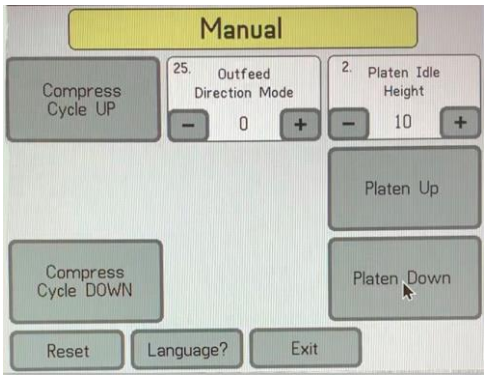
Main Ready Screen

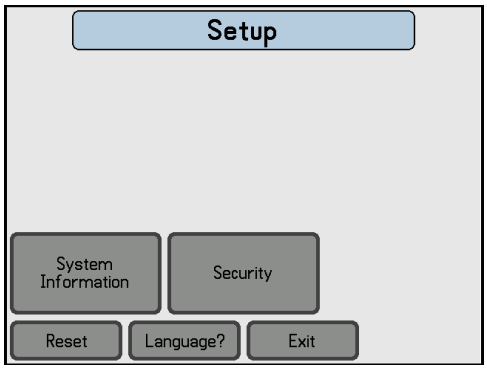


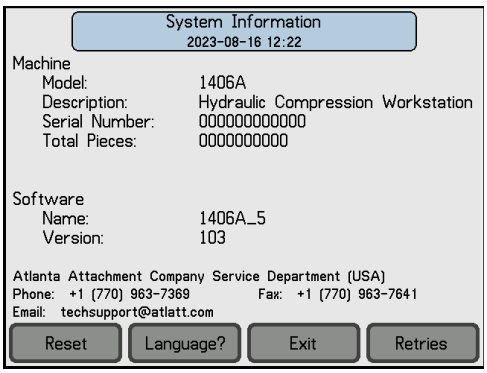
Operator Level Screens

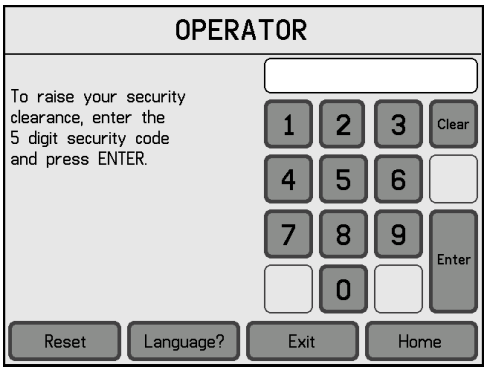












Returns to Ready screen

Language, press to select available Language

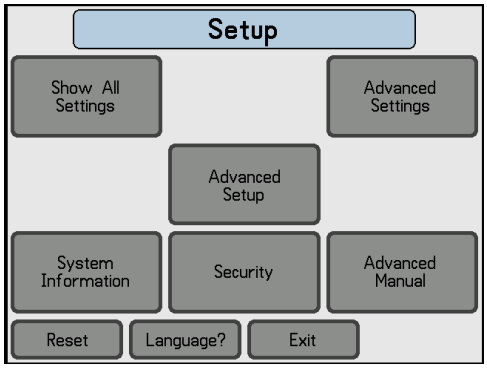
Reset or reboot of program

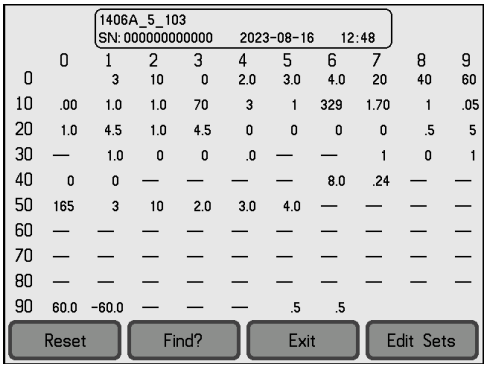
Exit – returns to previous page

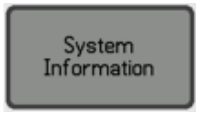
Piece Counter, press to access reset function

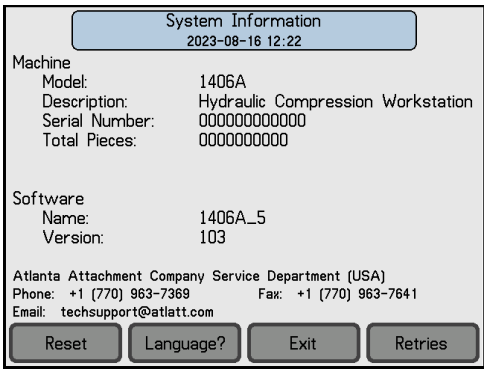
Clock, press to set time

Mechanic or Higher Security Level Screens

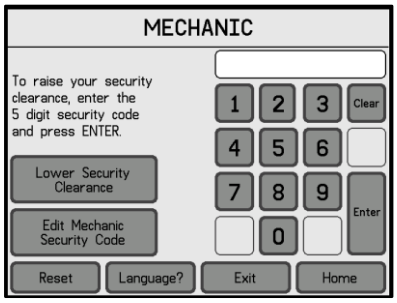


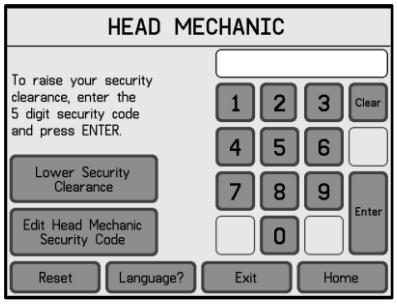


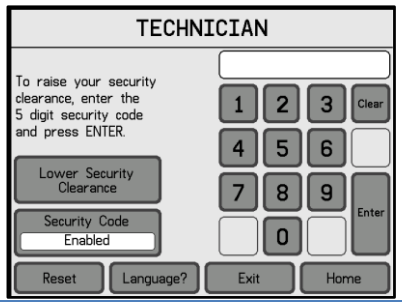


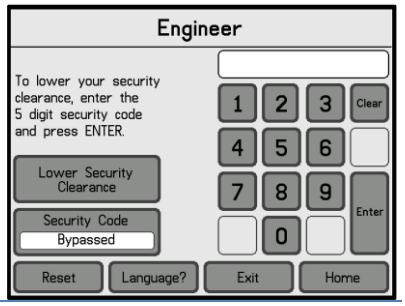


Enter code to increase level

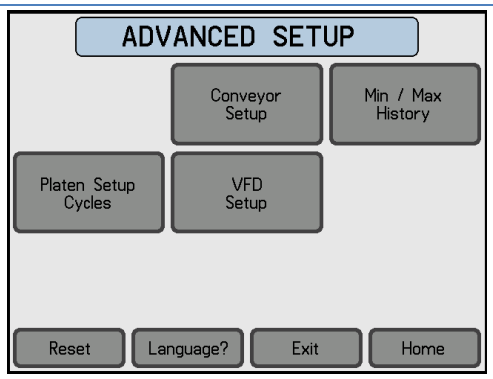


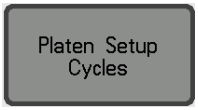




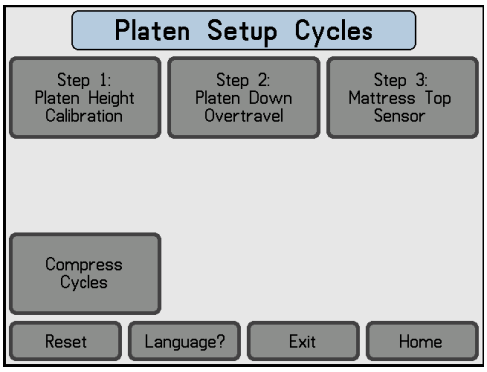


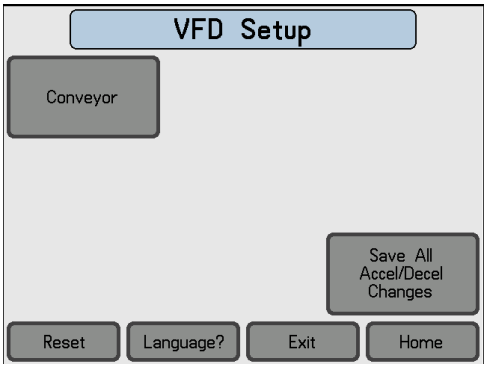

Advanced
Setup


ADVANCED SETUP
Conveyor Setup
Min / Max History
Platen Setup Cycles
VFD Setup
Reset
Language?
Exit
Home


Platen Setup
Cycles

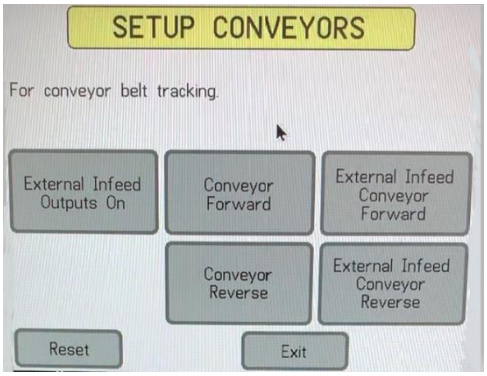

VFD
Setup

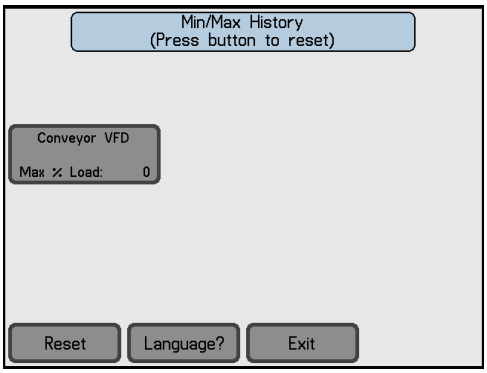

Platen Setup Cycles
Step 1: Platen Height Calibration
Step 2: Platen Down Overtravel
Step 3: Mattress Top Sensor
Compress Cycles
Reset
Language?
Exit
Home


VFD Setup
Conveyor
Save All Accel/Decel Changes
Reset
Language?
Exit
Home

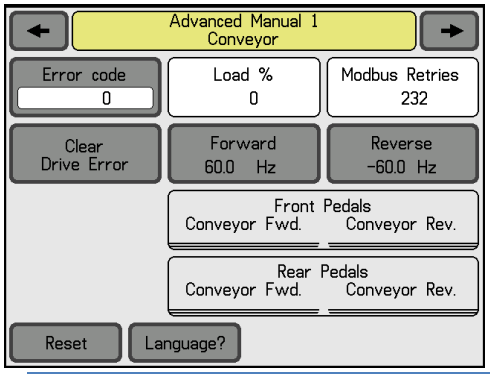

Conveyor
Setup

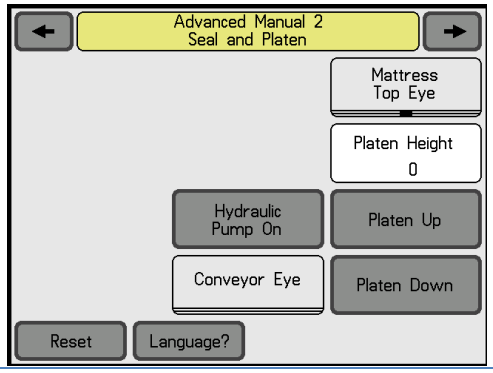

Min / Max
History

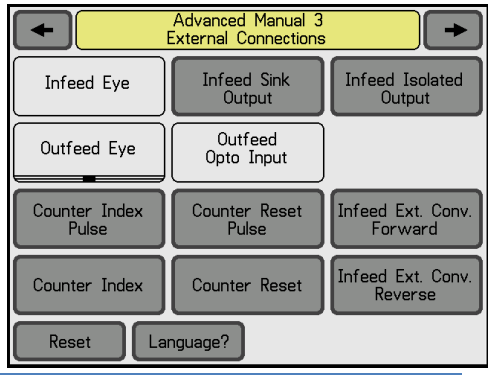

SETUP CONVEYORS
For conveyor belt tracking.
External Infeed Outputs On
Conveyor Forward
External Infeed Conveyor Forward
Conveyor Reverse
External Infeed Conveyor Reverse
Reset
Exit


Min/Max History
(Press button to reset)
Conveyor VFD
Max % Load: 0
Reset
Language?
Exit

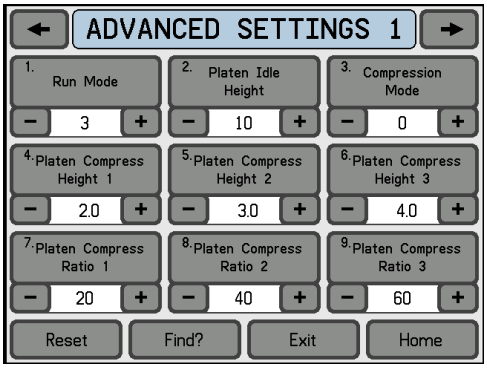

Advanced
Manual

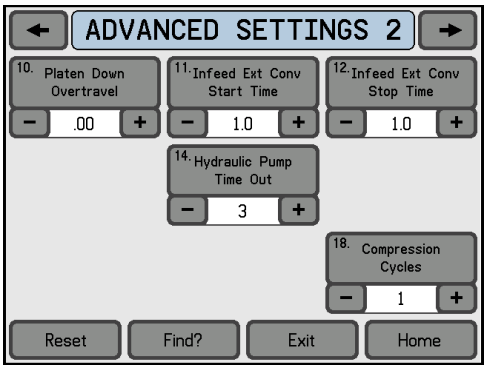

Advanced Manual 1
Conveyor
Error code
0
Load %
0
Modbus Retries
232
Clear Drive Error
Forward
60.0 Hz
Reverse
-60.0 Hz
Front Pedals
Conveyor Fwd.
Conveyor Rev.
Rear Pedals
Conveyor Fwd.
Conveyor Rev.
Reset
Language?

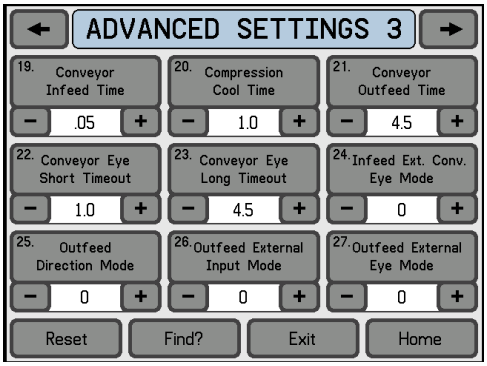

Advanced Manual 2
Seal and Platen
Mattress Top Eye
Platen Height
0
Hydraulic Pump On
Platen Up
Conveyor Eye
Platen Down
Reset
Language?

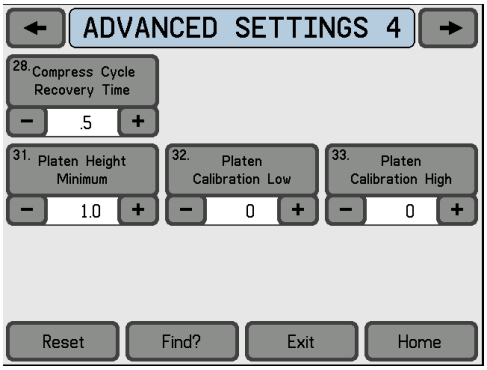

Advanced Manual 3
External Connections
Infeed Eye
Infeed Sink Output
Infeed Isolated Output
Outfeed Eye
Outfeed Opto Input
Counter Index Pulse
Counter Reset Pulse
Infeed Ext. Conv. Forward
Counter Index
Counter Reset
Infeed Ext. Conv. Reverse
Reset
Language?


Advanced
Settings


ADVANCED SETTINGS 1
1. Run Mode
3
2. Platen Idle Height
10
3. Compression Mode
0
4. Platen Compress Height 1
2.0
5. Platen Compress Height 2
3.0
6. Platen Compress Height 3
4.0
7. Platen Compress Ratio 1
20
8. Platen Compress Ratio 2
40
9. Platen Compress Ratio 3
60
Reset
Find?
Exit
Home


ADVANCED SETTINGS 2
10. Platen Down Overtravel
.00
11. Infeed Ext Conv Start Time
1.0
12. Infeed Ext Conv Stop Time
1.0
14. Hydraulic Pump Time Out
3
18. Compression Cycles
1
Reset
Find?
Exit
Home


ADVANCED SETTINGS 3
19. Conveyor Infeed Time
.05
20. Compression Cool Time
1.0
21. Conveyor Outfeed Time
4.5
22. Conveyor Eye Short Timeout
1.0
23. Conveyor Eye Long Timeout
4.5
24. Infeed Ext. Conv. Eye Mode
0
25. Outfeed Direction Mode
0
26. Outfeed External Input Mode
0
27. Outfeed External Eye Mode
0
Reset
Find?
Exit
Home


ADVANCED SETTINGS 4
28. Compress Cycle Recovery Time
.5
31. Platen Height Minimum
1.0
32. Platen Calibration Low
0
33. Platen Calibration High
0
Reset
Find?
Exit
Home

Assembly Drawings & Parts Lists

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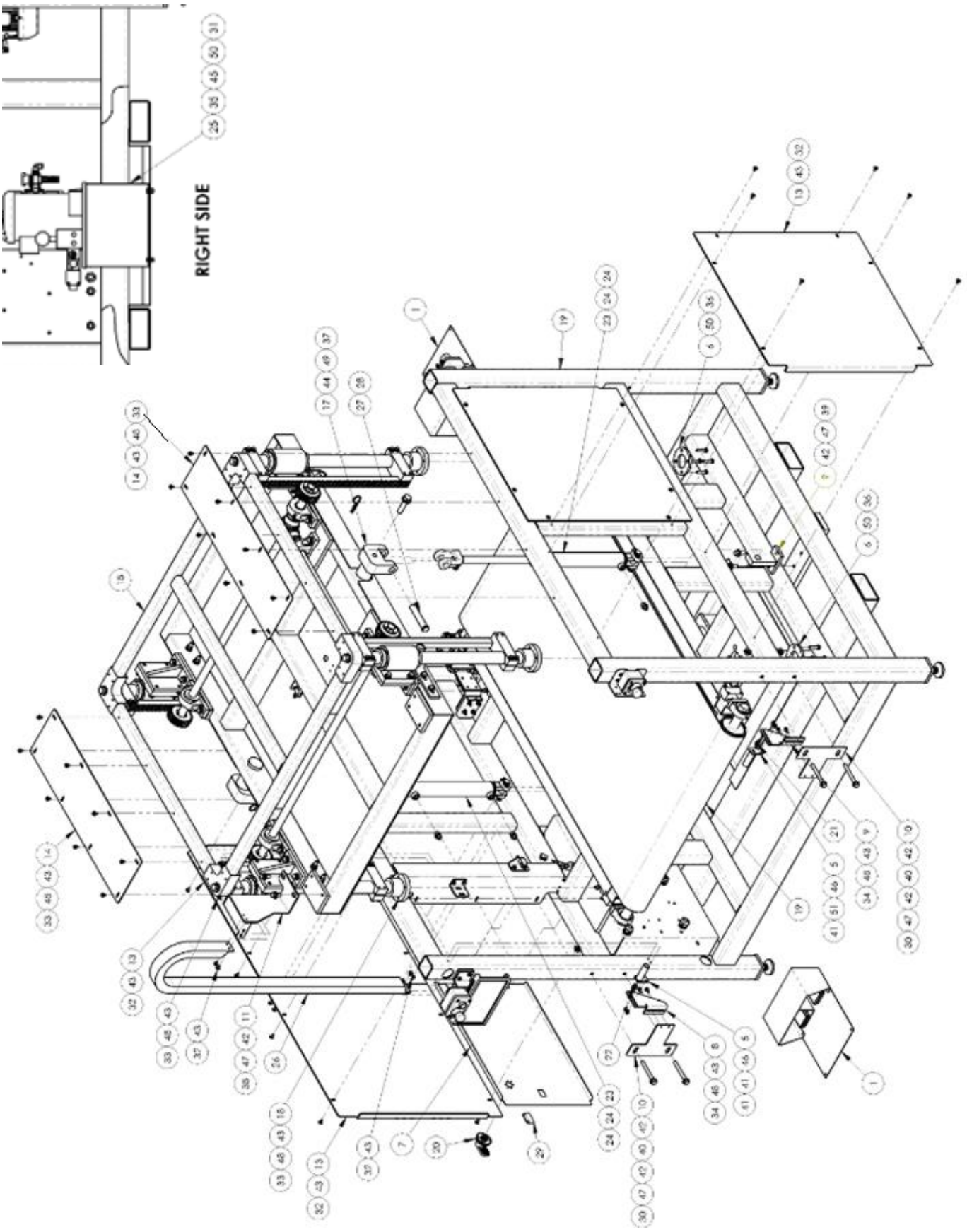
11406CA MATT COMPRESSION WORKSTATION, 45 x 64

AAC Drawing Number 9008890 Rev 1



11406CA parts list

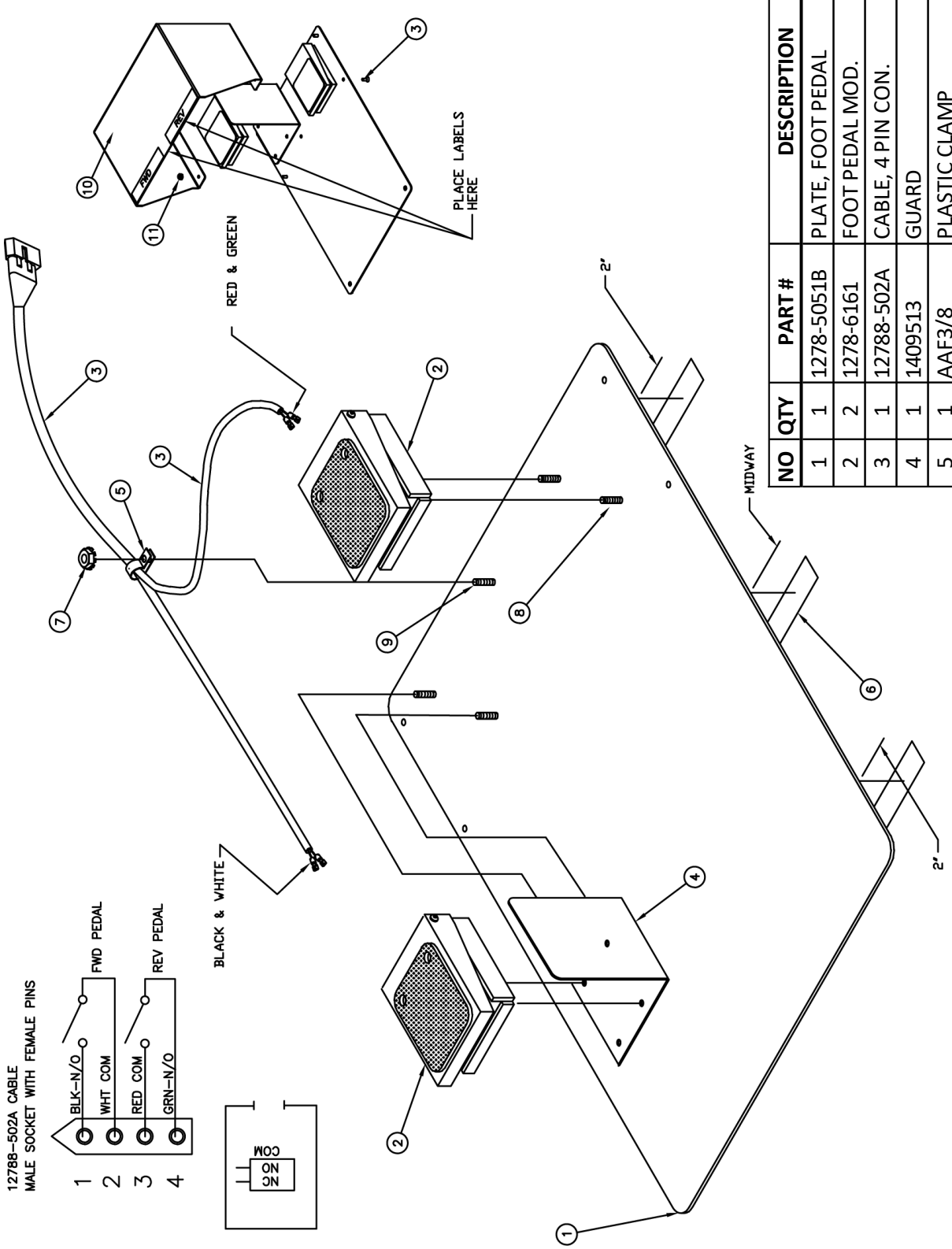
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1278-6160G	FOOT SWITCH ASSY 11458
2	*1	1406A-WD1	DIAGRAM, WIRING, PWR, SAFETY
3	*1	1406C-HD	DIAGRAM, HYDRAULIC
4	*1	1406C-PD	DIAGRAM,PNEUMATIC
5	2	1390399	MOUNT, SENSOR
6	4	1406028	PLATE, WASHER
7	1	1406066	DOOR, CONT. BOX
8	1	1406124	BRKT,EYE,CROSS SEAL,LEFT
9	1	1406126	BRKT,EYE,CROSS SEAL,RIGHT
10	2	1406797	PLATE,MTG,SENSOR
11	1	1406809	BRKT, COMPRESSION HEIGHT
12	2	1406991	MOUNT,LOWER HYD CYL
13	4	14061103	GUARD, LEXAN
14	2	14061104	PLATE,UPPER,BRACE
15	1	14061105	COMPRESSION ENCODER ASSY
16	*1	14061134	HYD,POWER PACKAGE
17	2	14061168	CYL ROD END MOUNT
18	1	14061205	PLATTEN ASSEMBLY
19	1	14061225	MAIN CONSOLE ASSY
20	1	EEHR65	DISCONNECT HANDLE
21	1	EERM1215M	SENSOR, RECEIVER
22	1	EETM12HP15M	SENSOR, TRANSMITTER, HP
23	2	HC287007	CYLINDER, HYD, 2"B, 14"STK
24	4	HF64000608	FITTING,HYD,STR,O-RING
25	1	HYMG2A	HYD PUMP,2GAL/MIN,2HP,3PH
26	1	MM45021-37	DUCT,WIRE PLASTITRAK

ITEM	QTY	PART NUMBER	DESCRIPTION
27	2	MM98306A682	PIN, CLEVIS, 1" X 5"
28	2	MM98335A094	PIN,COTTER,HAIR, .178DIA
29	1	MM40450010	FASTENER,SLIDE LOCK
30	4	NNH1/2-13	NUT,HEX,1/2-13
31	4	NNH3/8-16	NUT,HEX,3/8-16
32	28	SSBC01040	1/4-20 X 3/4 BUT CAP SC
33	21	SSHC01040	1/4-20 X 5/8 HHCS
34	4	SSHC01048	1/4-20 X 3/4 HEX CAP
35	4	SSHC25048	3/8-16X3/4,HEX CAP
36	16	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
37	2	SSHC34192	3/4-10 X 3 HEX CAP
38	2	SSHC45080	1/2-13X1-1/4 HEX CAP
39	4	SSHC45096	1/2-13X1-1/2 HEX CAP
40	4	SSHC45288	1/2-13X4-1/2 HEX CAP
41	4	SSSC98032	10-32X1/2, SOC CAP
42	14	WWFS1/2	WASHER,FLAT,1/2, SAE
43	53	WWFS1/4	WASHER,FLAT,SAE,1/4
44	2	WWFS3/4	WASHER, .797ID X 1-1/2OD
45	4	WWFS3/8	WASHER,FLAT,SAE,3/8
46	4	WWFS10	WASHER, FLAT, #10, SAE
47	10	WWL1/2	1/2 LOCK WASHER
48	25	WWL1/4	WASHER,LOCK, 1/4
49	2	WWL3/4	3/4 LOCK WASHER
50	20	WWL3/8	WASHER,LOCK, 3/8
51	4	WWL10	WASHER,LOCK,#10

Technical Manual & Part List

1278-6160G FOOT SWITCH ASSEMBLY, 11458

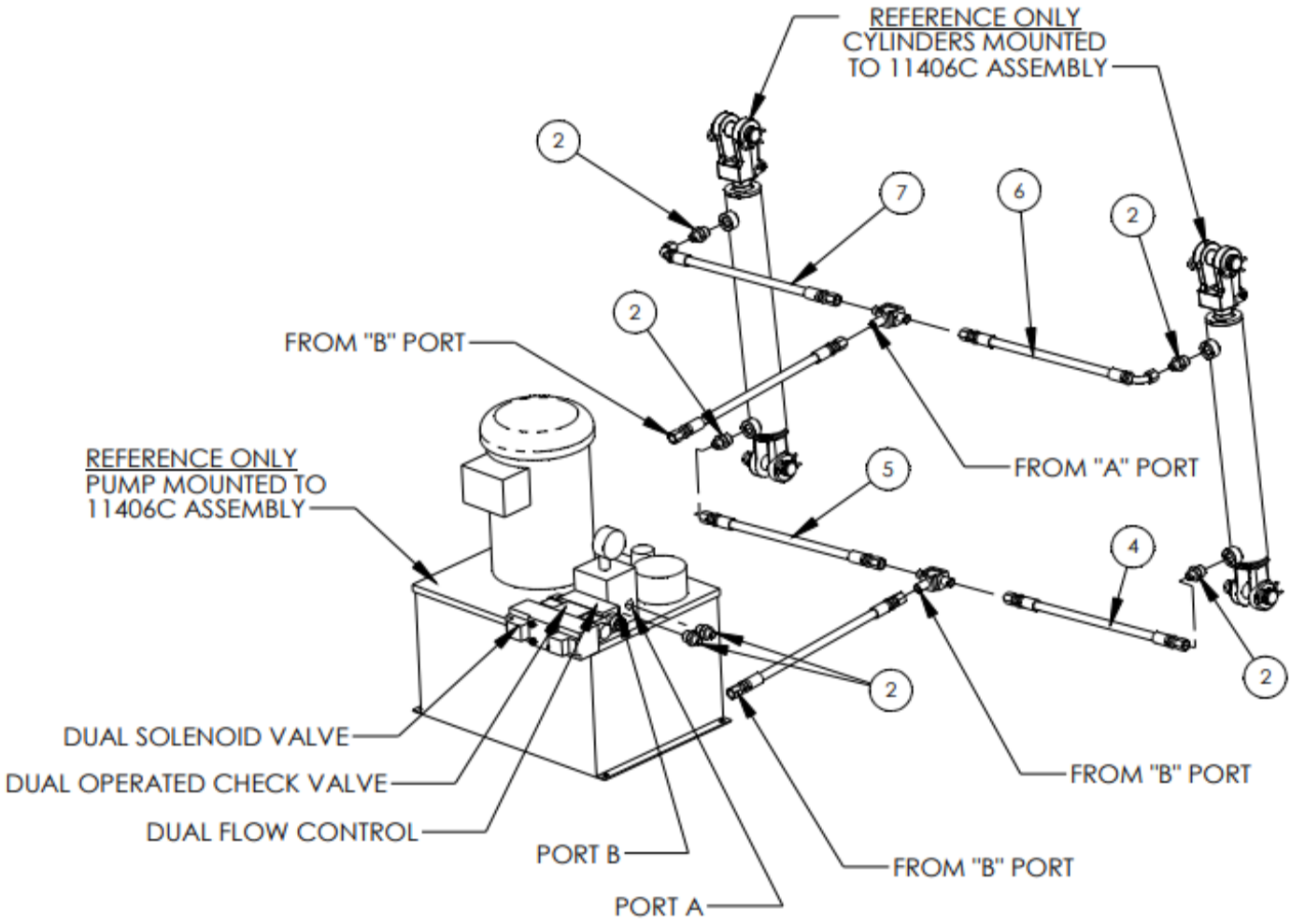
AAC Drawing Number 192819B Rev 1



NO	QTY	PART #	DESCRIPTION
1	1	1278-5051B	PLATE, FOOT PEDAL
2	2	1278-6161	FOOT PEDAL MOD.
3	1	12788-502A	CABLE, 4 PIN CON.
4	1	1409513	GUARD
5	1	AAF3/8	PLASTIC CLAMP
6	3FT	MM6970T64	3/4" ABRASIVE TAPE
7	1	NNK6-32	KEP NUT
8	4	SSFC80016	SCREW, FLAT ALLEN 6-32 X 1/4
9	5	SSFC80024	SCREW, FLAT ALLEN 6-32 X 3/8
10	1	1409512	GUARD
11	4	NNE6-32	LOCK NUT

14061134 HYDRAULIC POWER PACKAGE

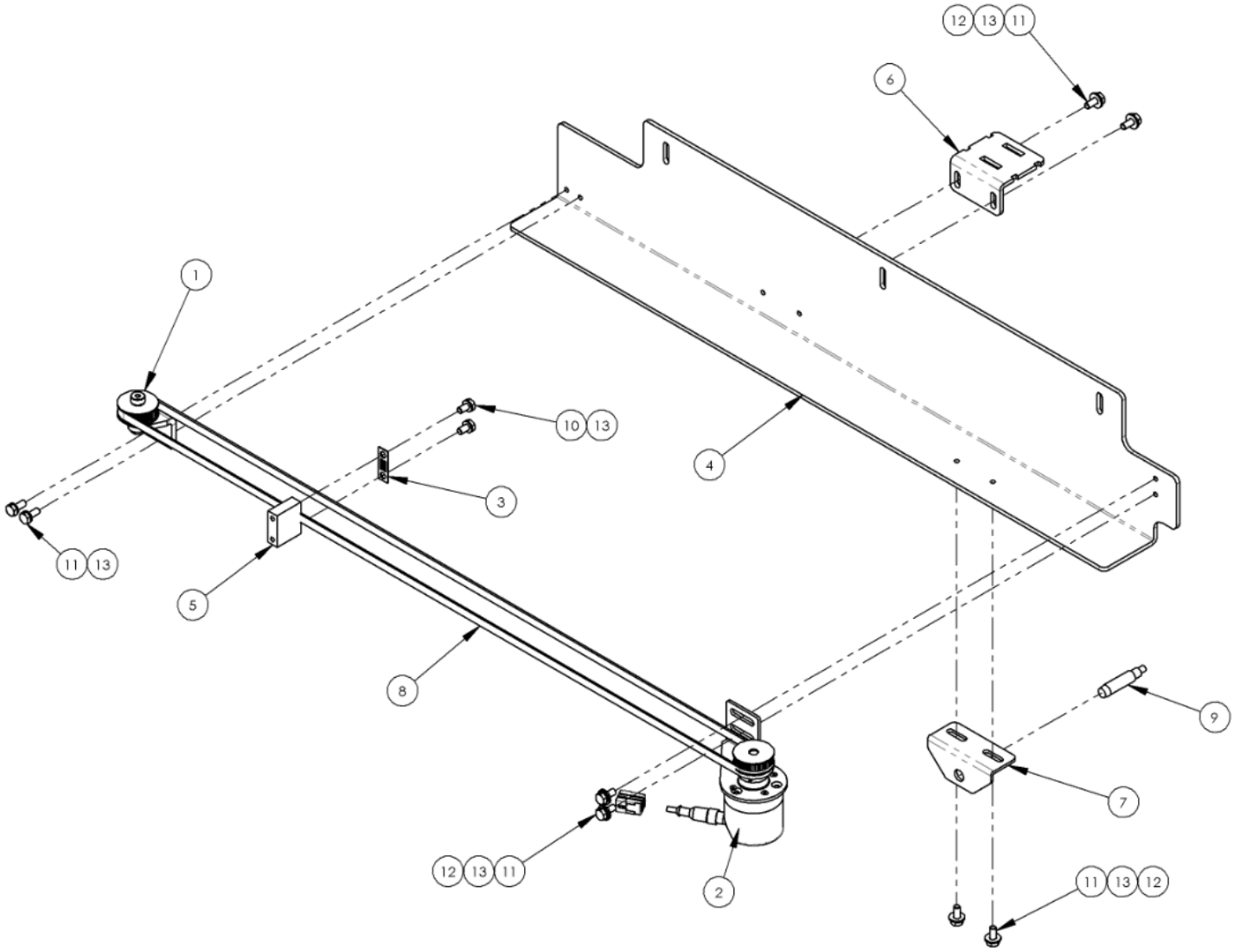
AAC Drawing Number 14061134 Rev 0



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	2	HF033T0606	TEE, 9/16-18 M-JIC, #6
2	6	HF64000608	FITTING,HYD,STR,O-RING
3	2	HH42246612	HYD HOSE, 12", 6SX6SX1/4
4	1	HH42246633	HYD HOSE, 33", 6SX6SX1/4
5	1	HH42246639	HYD HOSE, 39", 6SX6SX1/4
6	1	HH4224669042	HYD HOSE, 42", 6SX6-90X1/4
7	1	HH4224669050	HYD HOSE, 50", 6SX6-90X1/4

14061105 COMPRESSION ENCORDER ASSEMBLY

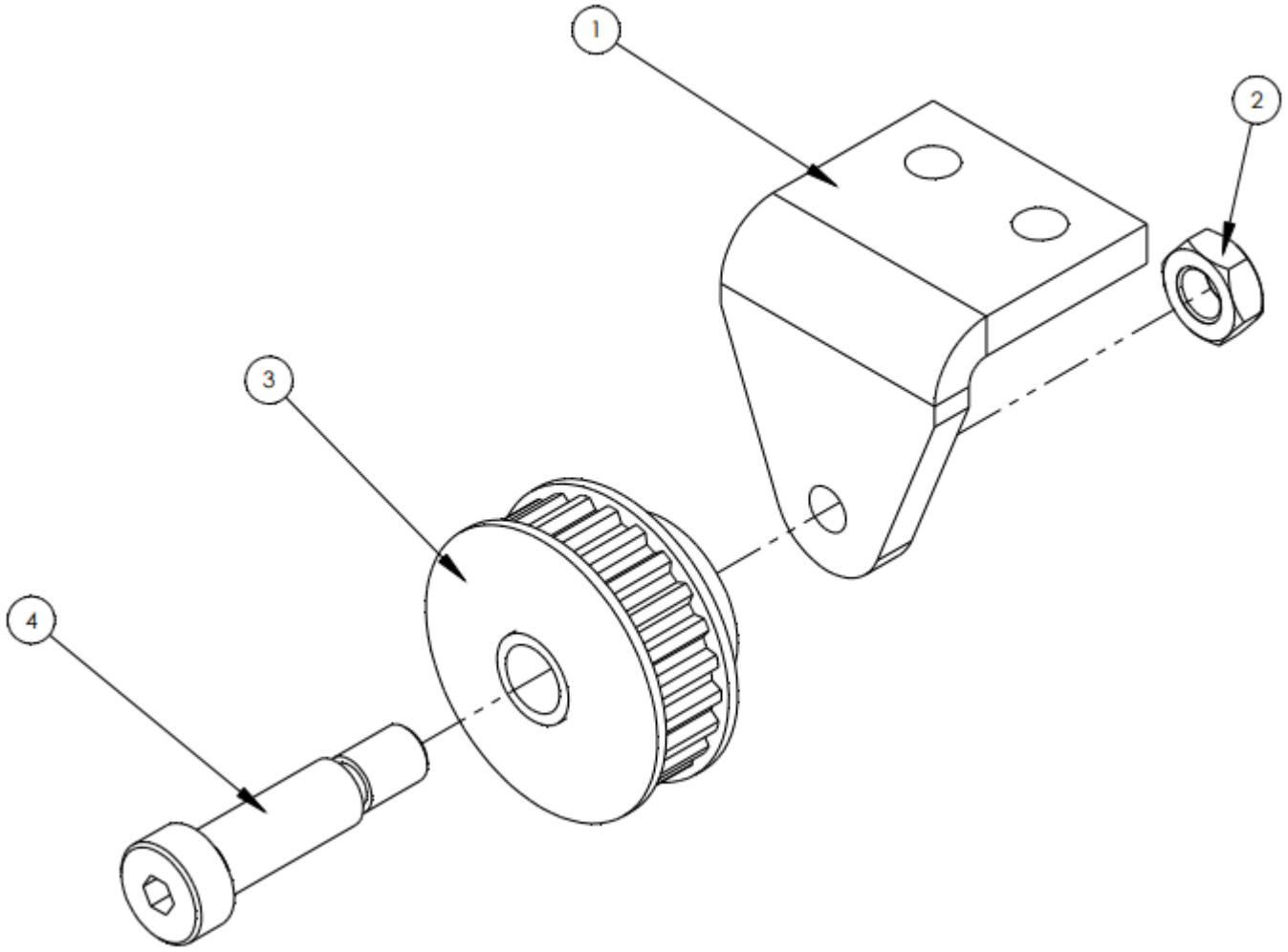
AAC Drawing Number 14061105 Rev 0



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1306600	PULLEY,IDLER,ASSEMBLY
2	1	1306601	POSITIONING ENCODER ASSY
3	1	1306603	PLATE,BELT RETAINER
4	1	14061106	MOUNT,COMPRESSION ENCODER
5	1	1406121	BLOCK, ENCODER BELT
6	1	1406122	SUPPORT, CABLE TRACK
7	1	1406135	BRACKET, PROX MOUNT
8	1	GG730XL037	BELT,GEAR,1/5P,3/8W,365T
9	1	MMAM1-AN-4A	PROX SWITCH,10-30VDC,12MM
10	2	SSHC01032	1/4-20 X 1/2 HHCS
11	8	SSHC01040	1/4-20 X 5/8 HHCS
12	6	WWFS1/4	WASHER,FLAT,SAE,1/4
13	10	WWL1/4	WASHER,LOCK, 1/4

1306600 IDLER PULLEY ASSEMBLY

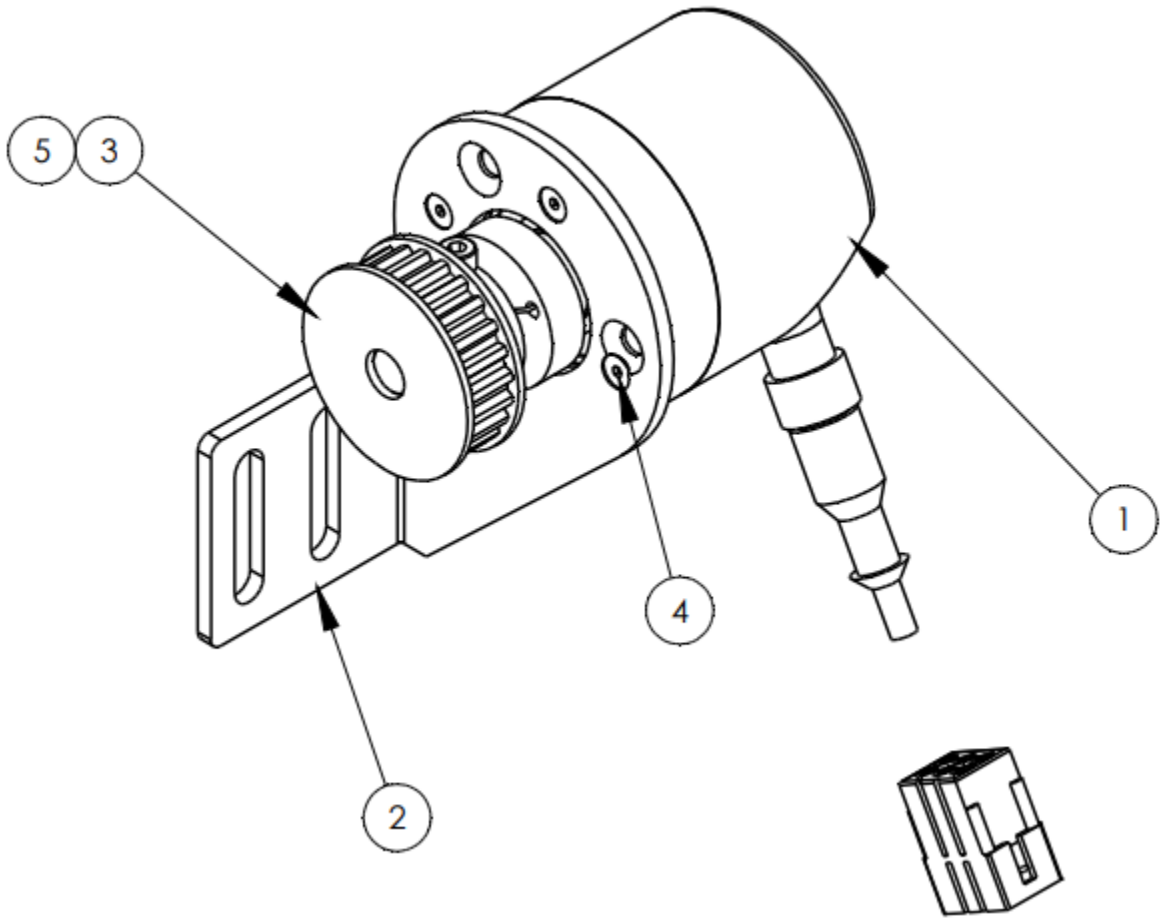
AAC Drawing Number 1306600 Rev 0



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1306599	BRACKET,IDLER PULLEY
2	1	NNJ5/16-18	NUT,JAM,5/16-18
3	1	PP24XLB037M3	PULLEY,GEAR,1/5PITCH,IDLE
4	1	SSAS024064	SHULDER BOLT 3/8 X .1.00L

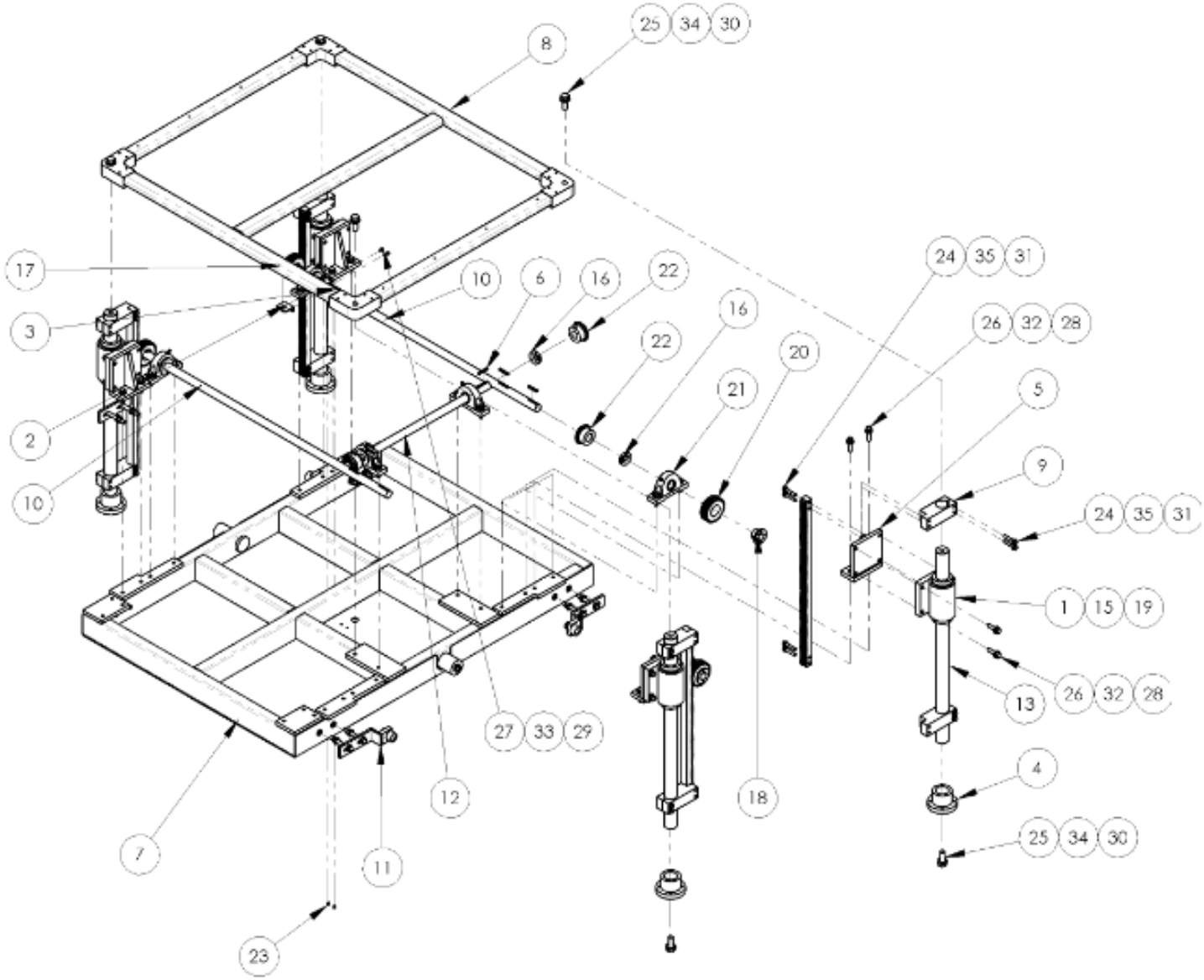
1306601 POSITIONING ENCORDER ASSEMBLY

AAC Drawing Number 1306601 Rev 2



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1953-405A	ENCODER, W/PLUG, 1953, 1306
2	1	1306598	BRACKET,ENCODER MOUNT
3	1	PP24XLB37M1	PULLEY, GEAR,1/5 PITCH
4	4	SSFCM3X10	M3-0.50X10, SCEW FLAT ALL
5	2	SSSCM4X10	SCREW,SOC CAP,M4-0.7X8

14061205 PLATTEN ASSEMBLY

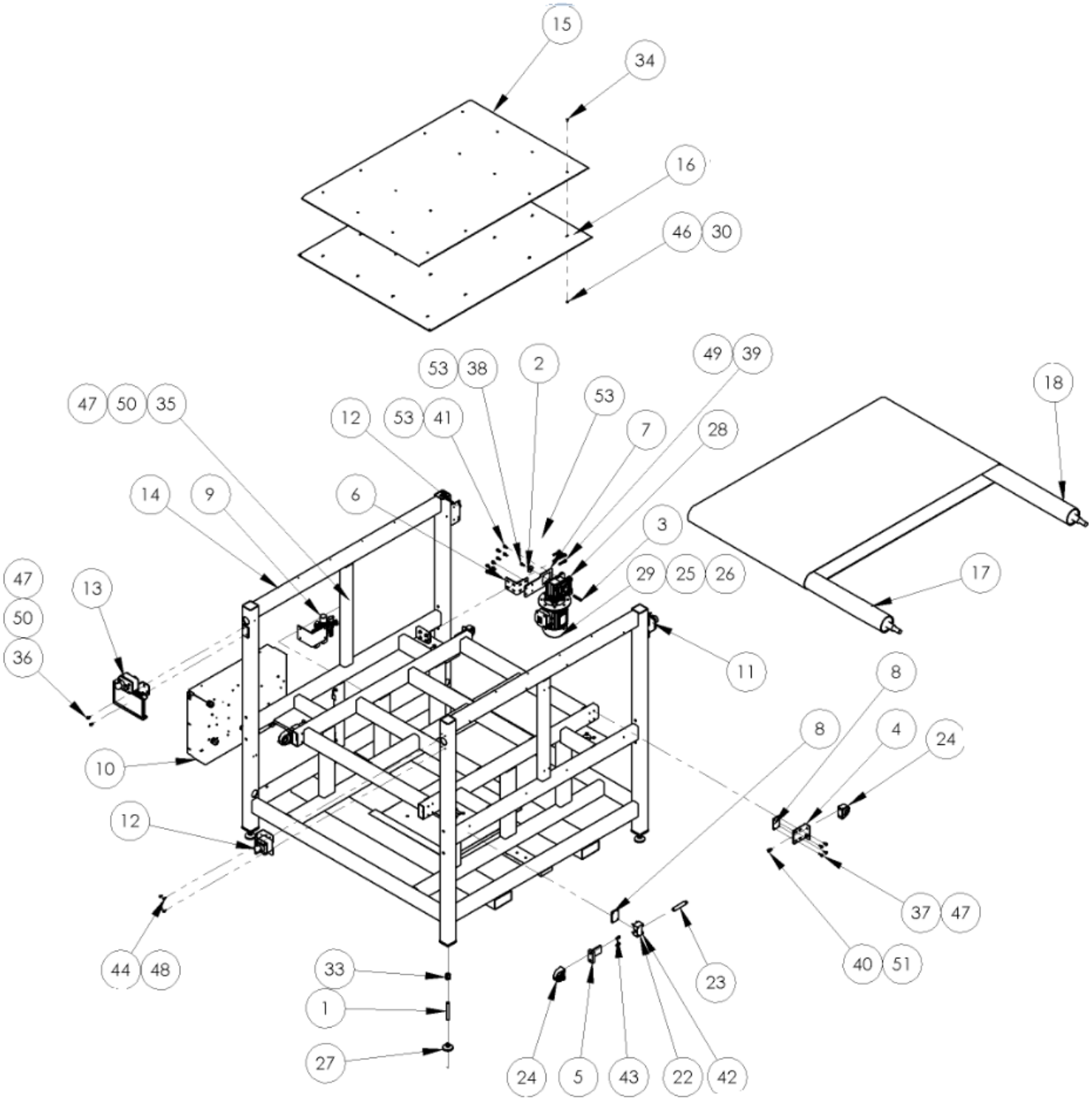


ITEM	QTY.	PART NUMBER	DESCRIPTION
1	4	1306320	MOUNT, BEARING,WELDMENT
2	1	1315062	BRACKET, BACKSTOP SENSOR
3	1	1315067	MOUNT, BACKSTOP SENSOR
4	4	1406027	MOUNT,COMPRESSION,BASE
5	4	1406039	MOUNT, PLATTEN
6	8	14061142	PARALLEL KEY
7	1	14061215	COMPRESSION PLATTEN, WELDMNT
8	1	14061220	FRAME, SUPPORT, UPPER
9	8	1406130	BLOCK,MTG,GEAR RACK
10	2	1406959	SHAFT, CROSS
11	4	1406976	FOLLOWER, RACK BACKUP
12	1	1406978	SHAFT, SIDE
13	4	1406993	RAIL, LINEAR, ROUND,2"
14	4	1406994	GEAR, RACK, 8DP 1.25 X 1.25 X 30.7L
15	4	BBIP32GW	2.0"ID, 3.0"OD, DW LINEAR BALL
16	4	CCSP20FK	COLLAR,CLAMP,1-1/4 BORE
17	1	FFT18FF25Q	EYE,FIXED FIELD, 1IN
18	4	MM114H	HUB, TAPERLOCK, H STYLE

ITEM	QTY.	PART NUMBER	DESCRIPTION
19	8	MM91665A630	SPRING,RETAINING,EXT,3"
20	4	MMGNSS8H30	GEAR, SPUR, 8P, 30T, 14.5PA
21	6	MMGRP207-20	BEARING, PILLOW BK, 1.25B
22	4	MMGYSM8F24X125	GEAR,MITER,8P,24TH
23	2	SSFC98024	#10-32 X .375 FLAT CAP
24	32	SSHC25144	3/8-16X2-1/4 HEX CAP SC
25	8	SSHC34128	3/4-10 X 2 HEX CAP
26	36	SSHC45128	1/2-13 X 2,HEX CAP
27	2	SSSC98032	10-32X1/2, SOC CAP
28	36	WWFS1/2	WASHER,FLAT,1/2, SAE
29	2	WWFS10	WASHER, FLAT, #10, SAE
30	8	WWFS3/4	WASHER, .797ID X 1-1/2OD
31	32	WWFS3/8	WASHER,FLAT,SAE,3/8
32	36	WWL1/2	1/2 LOCK WASHER
33	2	WWL10	WASHER,LOCK,#10
34	8	WWL3/4	3/4 LOCK WASHER
35	32	WWL3/8	WASHER,LOCK, 3/8

14061225 MAIN CONSOLE ASSEMBLY

AAC Drawing Number 14061225 Rev 0

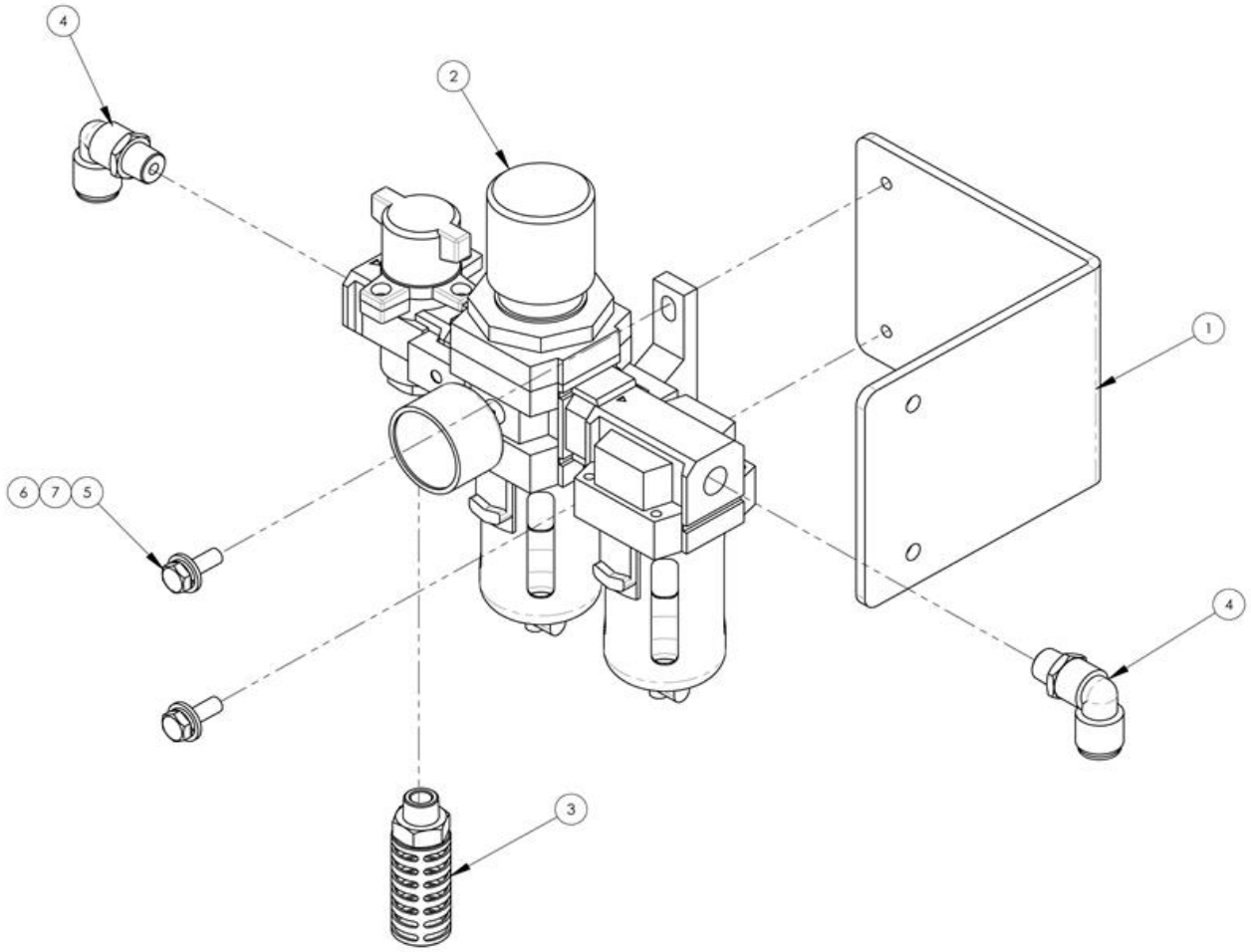


14061225 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	4	0411-1063	ROD, THREADED, 5/8-11 X 5
2	1	1306005	RETAINER,SHAFT,GEARBOX
3	1	1393369	KEY, GEARMOTOR
4	2	1406005	BRACKET,MTG,BEARING
5	2	1406053	MOUNT, BEARING,SLIDE
6	1	1406103	MOTOR MOUNT BKT
7	1	1406106	MOTOR MOUNT PLATE
8	4	14061143	PLATE, NUT, 1/4-20 (4), 5/16X1.5X2.5
9	1	1406116	REGULATOR ASSY
10	1	14061170	CONTROL ASSEMBLY
11	1	14061177	BUTTON BOX, E-STOP, REVERSIBLE
12	2	14061177	BUTTON BOX, E-STOP, REVERSIBLE
13	1	14061181	TOUCH SCREEN ASSY
14	1	14061210	MAIN FRAME
15	1	1406969	BELT,SUPPORT,WEAR PLATE
16	1	1406971	TOP PLATE
17	1	1406972	ROLLER,DRIVEN,CONVEYOR
18	1	1406974	ROLLER,DRIVE,CONVEYOR
19	1	1406975	BELT,URETHANE,142"LONG
20	1	1406A-WD1	DIAGRAM, WIRING, PWR, SAFETY
21	1	1406A-WD2	DIAGRAM, WIRING, SBUS
22	2	1458033	BLOCK, BELT TENSION
23	2	1458034	SCREW, BELT TENSION
24	4	BBTB-16T	BEARING,PBLOCK,SKWEZ, 1.0
25	1	FF3231	STRAIN RELIEF, LIQ TIGHT
26	1	FF8463	NUT,LOCK, 1/2NPT,NYLON,BLK
27	4	MML-2	LEVELING PAD, 5/8-11
28	1	MMRV5015D80	GEARBOX,WORM,RV50,15:1
29	1	MMYS801455	MOTOR,.55KW,IEC,B5,D80
30	16	NNE8-32	NUT,ELASTIC LOCK, 8-32
31	16	NNH1/4-20	NUT,HEX,1/4-20
32	4	NNH5/16-18	NUT,HEX, 5/16-18
33	8	NNH5/8-11	NUT,HEX,5/8-11
34	16	SSFC90040	8-32 x 2 FLAT ALLEN
35	8	SSHC01040	1/4-20 X 5/8 HHCS
36	2	SSHC01048	1/4-20 X 3/4 HEX CAP
37	8	SSHC01056	1/4-20 X 7/8 HEX CAP
38	5	SSHC10048	5/16-18 X 3/4 HHCS
39	4	SSHC10128	SCREW, HEX, 5/16-18 X 2 HHCS
40	4	SSHC25048	3/8-16X3/4,HEX CAP
41	4	SSHCM8X20	SCREW,HEX CAP
42	8	SSSC01112	1/4-20 X 1-3/4 SOC CAP
43	4	SSSC25048	3/8-16X3/4 SOC CAP
44	12	SSSC98040	10-32 X 5/8 SOC CAP
45	4	SSZS93032	SCREW, SHT.METAL 10 ZIP
46	16	WWF8	WASHER, FLAT, #8
47	18	WWFS1/4	WASHER,FLAT,SAE,1/4
48	12	WWFS10	WASHER, FLAT, #10, SAE
49	12	WWFS5/16	WASHER,FLAT,SAE,5/16
50	26	WWL1/4	WASHER,LOCK, 1/4
51	4	WWL3/8	WASHER,LOCK, 3/8
53	13	WWL5/16	WASHER,LOCK, 5/16
53	840"	ZZZSH-310	DOUBLE SIDED TAPE

1406116 REGULATOR ASSEMBLY

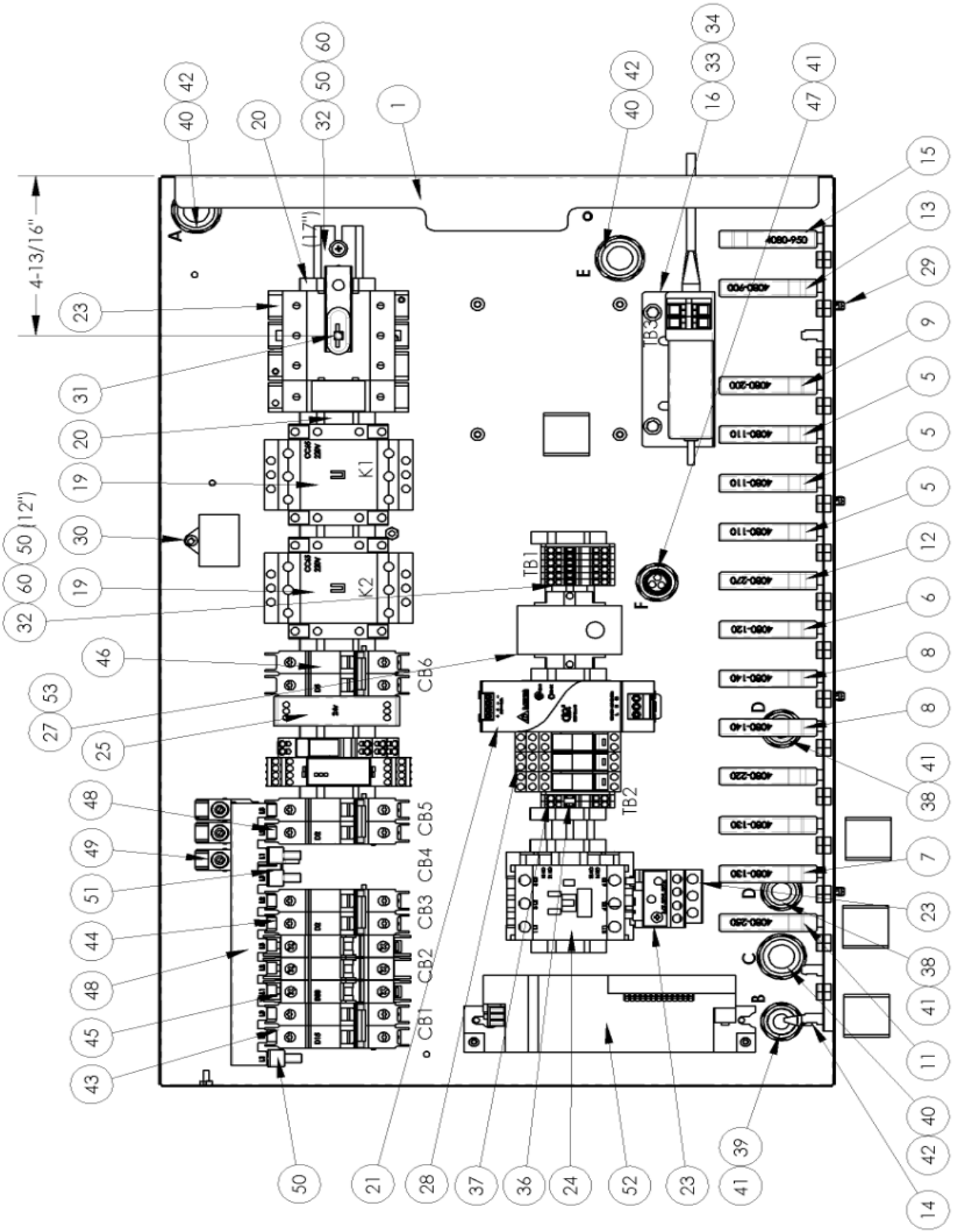
AAC Drawing Number 1406116 Rev 0



NO	QTY	PART #	DESCRIPTION
1	1	1406114	MOUNT, REGULATOR
2	1	AA198-5110	FILTER/REGULATOR/LOCKOUT
3	1	AAFNAN200-02	MUFFLER,1/8 NPT
4	2	AAQME-3-4	MALE ELBOW 3/8OD TUBE
5	2	SSHC01048	1/4-20 X 3/4 HEX CAP
6	2	WWFS1/4	WASHER,FLAT,SAE,1/4
7	2	WWL1/4	WASHER,LOCK, 1/4

14061170 CONTROL ASSEMBLY

AAC Drawing Number 14061170 Rev 0



14061170 Parts List

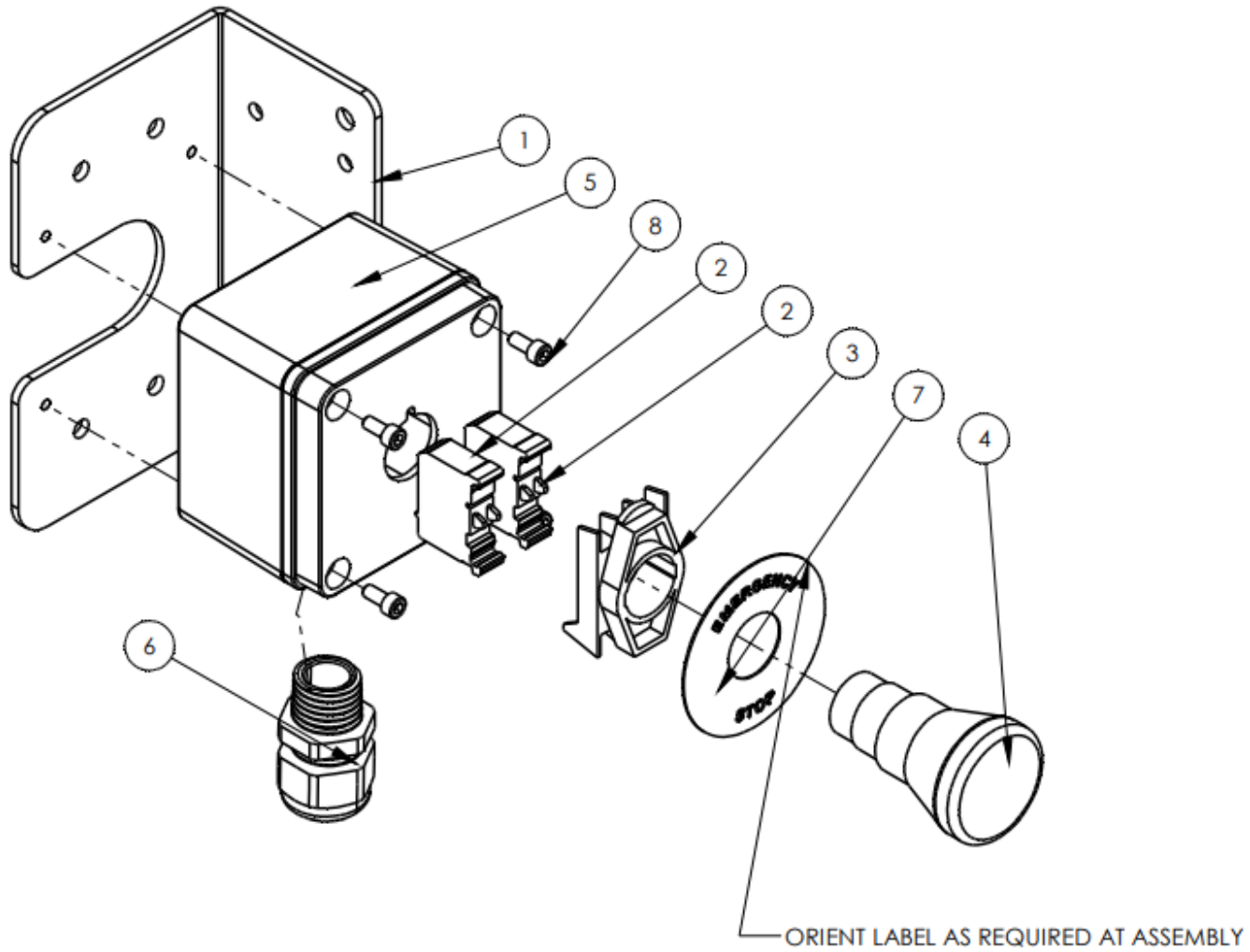
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	14061173	CONTROL PANEL
2	1	14061175	SBUS ASSEMBLY, 1406A
3	1	1406A-CAB1	CABLE PACKAGE, 1406A
4	1	1406A-CAB2	CABLE KIT
5	3	4080-110	MODULE,QUAD INPUT
6	1	4080-120	MODULE,SBUS, DUAL OPTO-ISO, INPT
7	2	4080-130	MODULE,QUAD OPTO-ISO
8	2	4080-140	MODULE,QUAD OUTPUT
9	1	4080-200	MODULE,AIR PRESSURE
10	1	4080-220	MODULE,DUAL ANALOG
11	1	4080-250	MODULE,THERMOCOUPLE
12	1	4080-270	MODULE,MODBUS
13	1	4080-900	SBUS MODULE, USB GATEWAY, INTERFACE
14	1	4080-940	MODULE,TERMINATOR
15	1	4080-950	MODULE,POWER
16	1	4082004	PC POWER BLOCK BRACKET
17	4	EE64151B	FERRITE CORE,SPLIT,CABLE
18	1	EE788304	RELAY,24V,SPDT,WAGO
19	2	EECGC85A220	CONTACTOR,65A,220VAC
20	11	EECLIPFIX	ANCHOR,DIN RAIL
21	1	EEDRP24V100W	POWER SUP,SW,24V 3.8A, DIN
22	1	EELG5925-24	RELAY,SAFETY, 2 CHAN, 24V
23	1	EEM60U3M	DISCONNECT, 3PH, 60A, UL98
24	1	EEMC32A22	CONTACTOR,IEC,230VAC
25	1	EEMDR2024	POWER SUP,SWITCHER,24V,1.0A,DIN
23	1	EEMT32S32A	RELAY,OVERLOAD,22A-32A
27	1	EEN2424VDC	AMPLIFIER, PHOTOEYE,MANUAL
28	3	EEP18524DC	RELAY, INTERFACE 24VDC, 1
29	6	EEPBMSH25C	MOUNT,CABLE TIE,NYLON
30	1	EERCM601BUZ4	PROTECTOR, SURGE

ITEM	QTY.	PART NUMBER	DESCRIPTION
31	1	EESPA210-3.95	DISCONNECT SHAFT,MOD
32	29"	EETS35X7.5A	DIN RAIL-AMERICAN
33	2	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
34	1	FF264-371	TERMBLK,WAGO,TOP,END
35	2	FF280-308	TERMBLK ENDPLATE,WAGO,280
36	1	FF280-402	JUMPER,WAGO,TOP,SNGL
37	8	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY
38	2	FF3200	STRAIN RELIEF,1/2NPT
39	1	FF3231	STRAIN RELIEF, LIQ TIGHT
40	3	FF3234	STRAIN RELIEF,3/4NPT
41	4	FF8463	NUT,LOCK, 1/2NPT,NYLON,BLK
42	3	FF8465	NUT,LOCK, 3/4NPT,NYLON,BLK
43	1	FFFAZD152NA	BREAKER,2P,15A,UL489,240VT-MAG
44	2	FFFAZD22NA	BREAKER,2P, 2A,UL489,240VT-MAG
45	1	FFFAZD303NA	BREAKER,3P,30A,UL489,240VT-MAG,
46	1	FFFAZD52NA	BREAKER,2P,5A,UL489,
47	1	FFM3200GAH-	STRAIN RELIEF, 1/2NPT, 3 HOLE, BLK
48	1	FFM9XUP312	BREAKER,ACC,UL489,COMB,18MM,
49	3	FFM9XUPC04	BREAKER,ACC,UL489,COMB,18MM,
50	1	FFM9XUTC15	BREAKER,ACC,UL489,COMB,18MM,
51	1	FFM9XUTC15	BREAKER,ACC,UL489,COMB,18MM,
52	1	MM700HN126	RELAY BASE DIN RAIL MNT 11 PIN
53	5	NNH8-32	NUT,HEX, 8-32 REG.
54	2	SSHC98032	10-32X1/2 HEX HD
55	1	SSPP90024	8-32X3/8 PAN PHLPS
50	7	SSPP98024	10-32 X 3/8 PAN HD PHILIP
57	3	WWF10	WASHER, FLAT, #10, COM
58	5	WWF8	WASHER, FLAT, #8
59	6	WWFS10	WASHER, FLAT, #10, SAE
60	2	WWL10	WASHER,LOCK,#10

Technical Manual & Part List

14061177 E-STOP ASSEMLBY

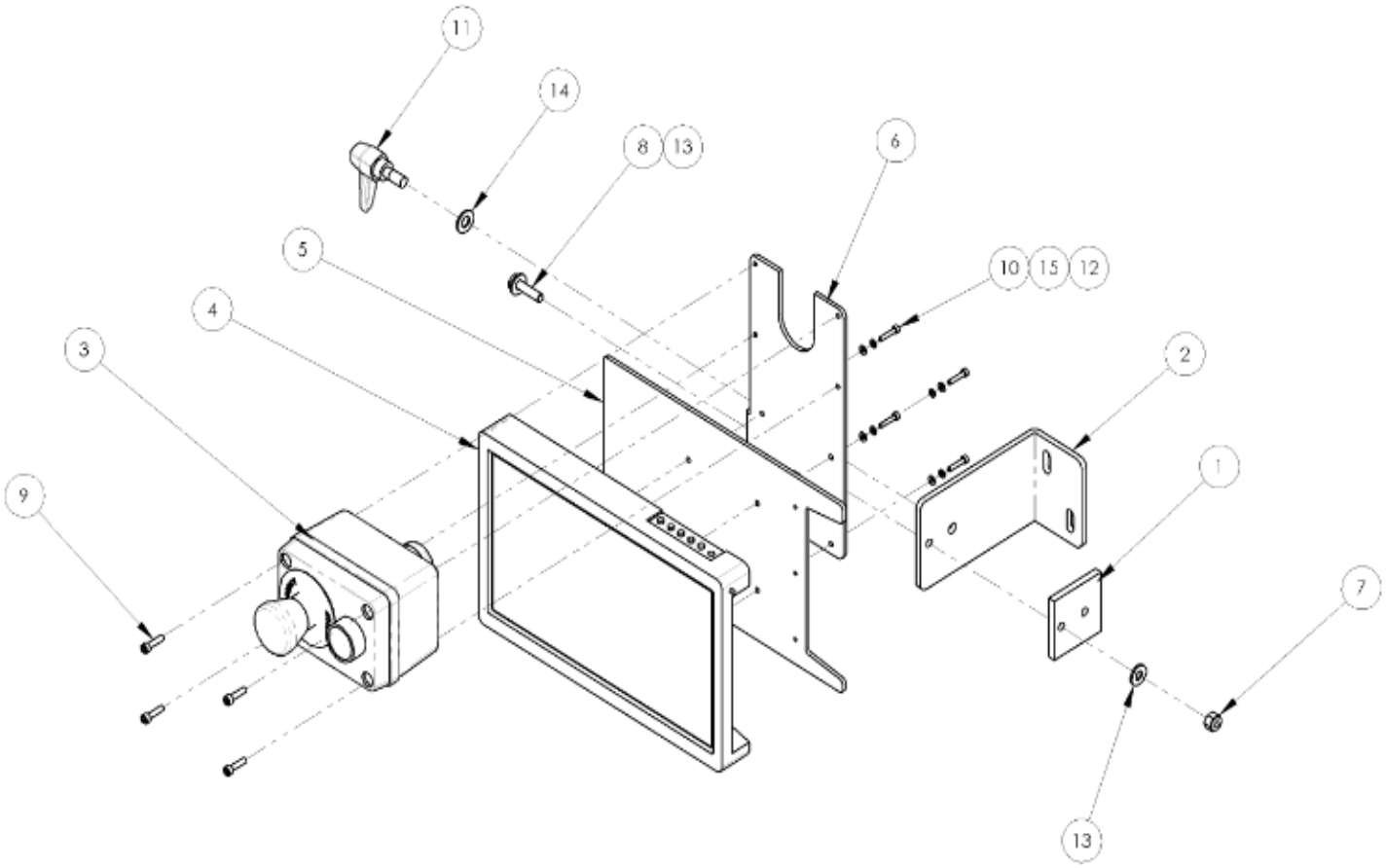
AAC Drawing Number 14061177 Rev



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	14061178	MTG BRKT REMOTE CONTROL
2	2	EE3Q01	CNTK BLOCK, N.C. (RED) SPNG TERM
3	1	EEA3L	LATCH,PUSH BUTTON
4	1	EEPMTS44	E-STOP BUTTON, TWIST REL.
5	1	EEPTS25302M1	BOX, 80X80X60MM, ONE BUTTON 7/8,
6	1	FFM3200GAH-SM	STRAIN RELIEF, 1/2NPT, 3 HOLE, BLK
7	1	MM800E15YE112	E-STOP LEGEND PLATE
8	4	SSSC90024	8-32 X 3/8 SOC CAP SC

14061181 TOUCH SCREEN ASSEMBLY

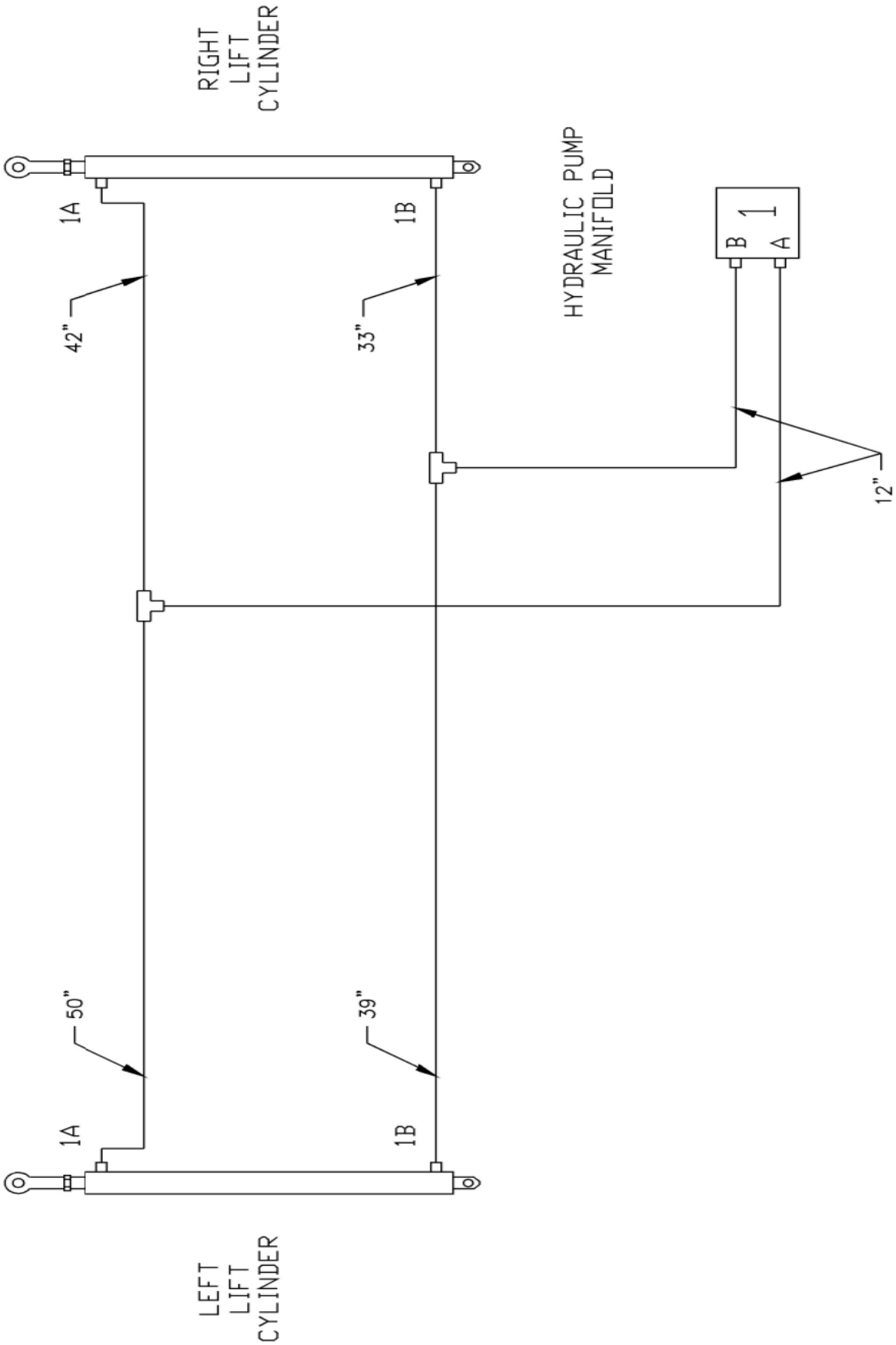
AAC Drawing Number 14061181 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	0411-3708	NUT PLATE,BOX MOUNT
2	1	1406059	MOUNT, TOUCH SCREEN
3	1	14061179	BUTTON BOX, E-STOP/START
4	1	4082105	TOUCHSCREEN. 10", SUB ASSEMBLY
5	1	4082105B	HMI BACKING PLATE, EEE10TSM
6	1	4300574	MOUNT, HMI, PC DISPLAY
7	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
8	1	SSHC01064	1/4-20 X 1 HHCS
9	4	SSSC90040	8-32 X 5/8 SOC CAP SC
10	4	SSSCM3X16	M3-0.5X16 ,SOCKET CAP
11	1	TTH32425	HANDLE,THRDED,5/16-18X3/4
12	4	WWFM3	FLAT WASHER, M3
13	2	WWFS1/4	WASHER,FLAT,SAE,1/4
14	1	WWFS5/16	WASHER,FLAT,SAE,5/16
15	4	WWLM3	WASHER, LOCK, M3

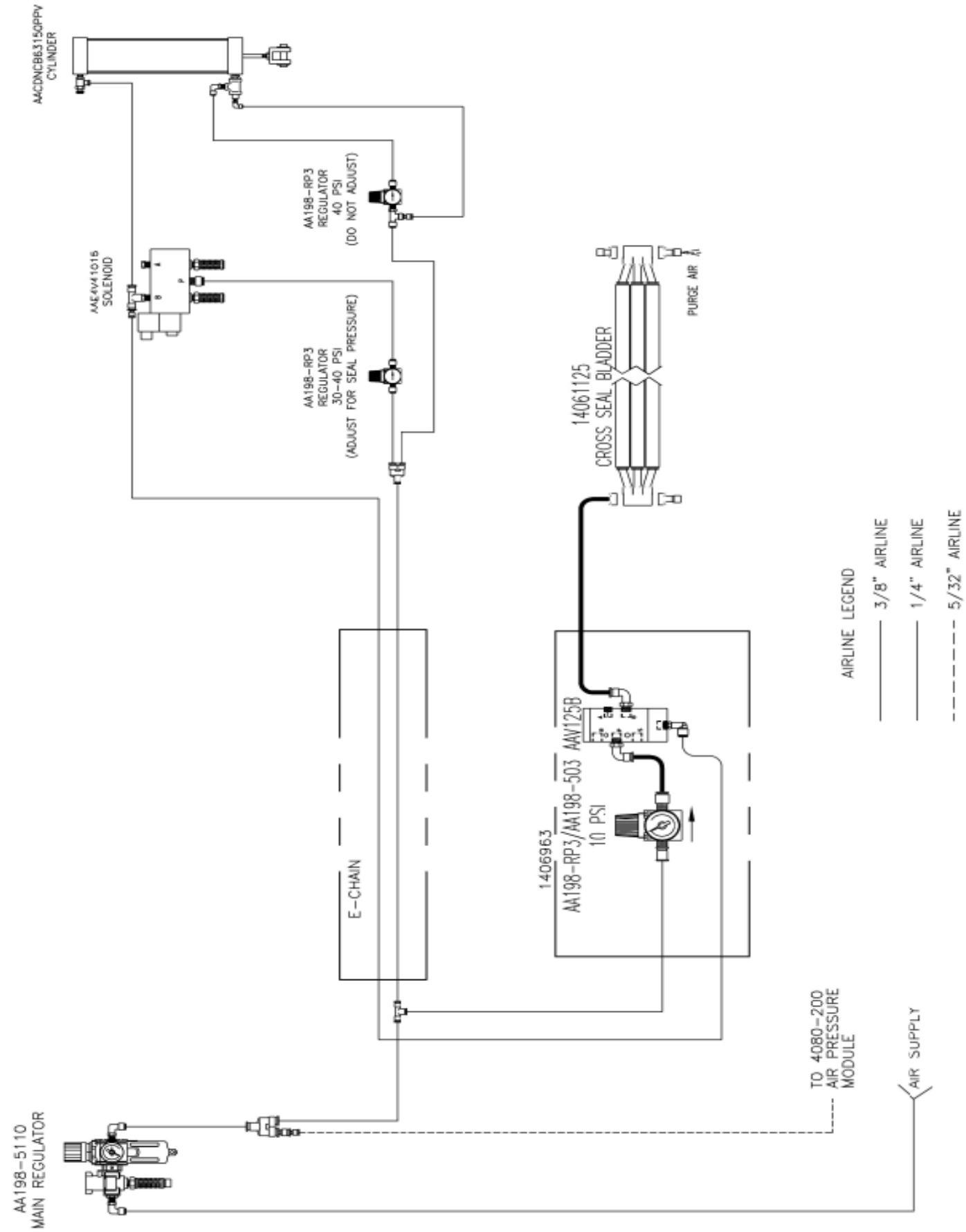
1406C-HD Hydraulic diagram

AAC Drawing Number 125595D Rev 0



1406C-PD Pneumatic Diagram

AAC Drawing Number 125593D Rev 0



1406A-WD1 Wiring Diagram, Power

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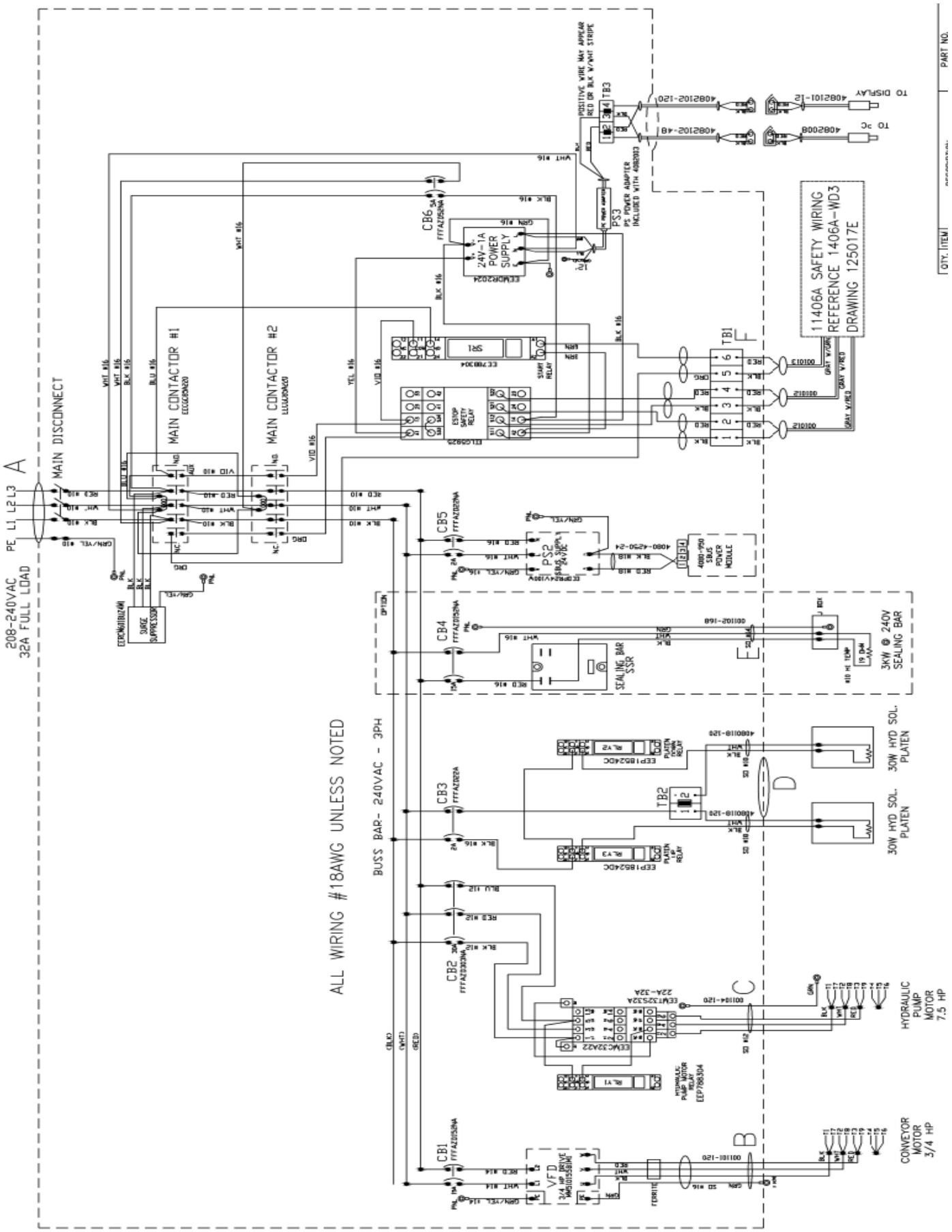

1406A-WD2 Wiring Diagram, Serial Bus

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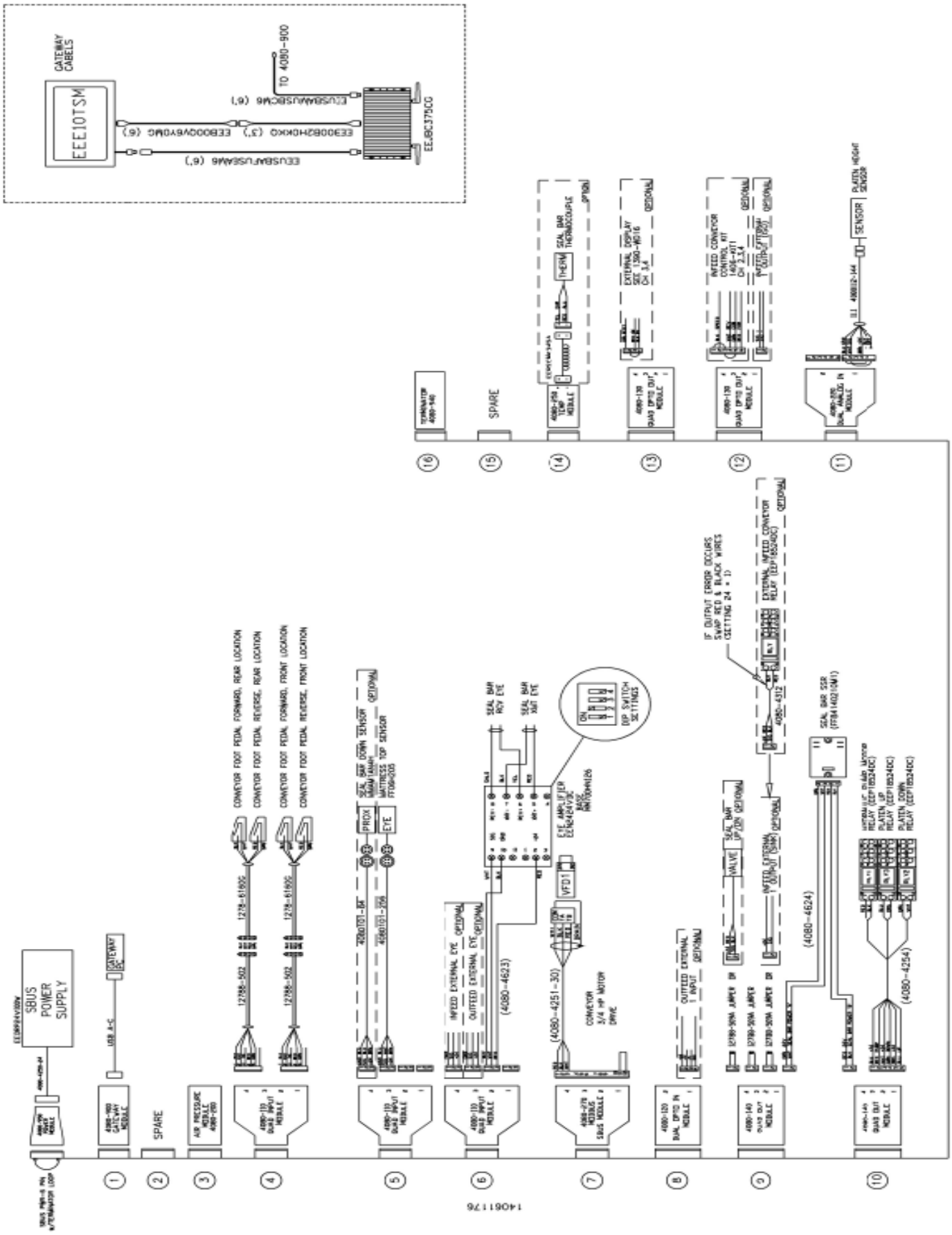

1406A-WD3 Wiring Diagram, Safety

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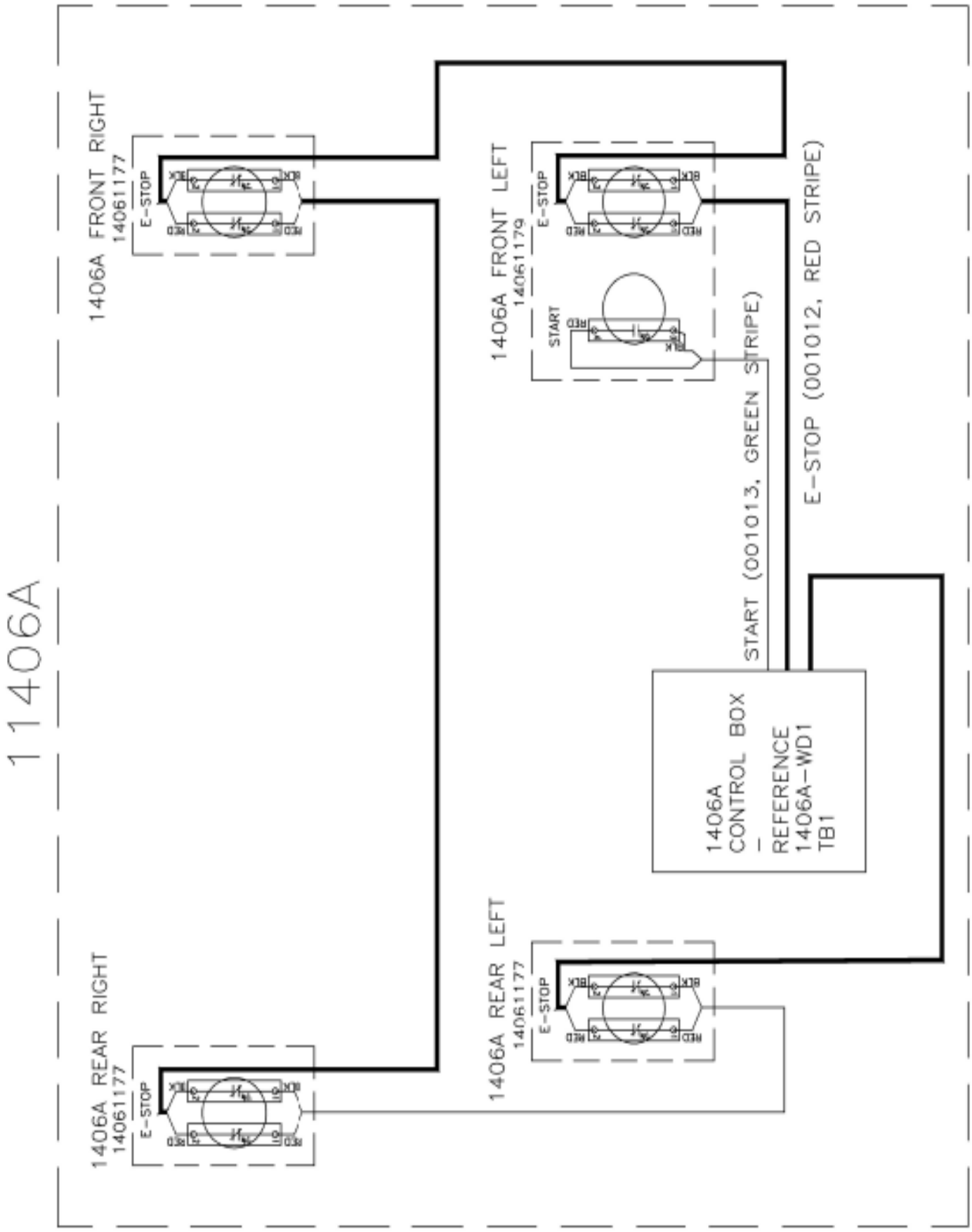

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