Model **1390HCE**

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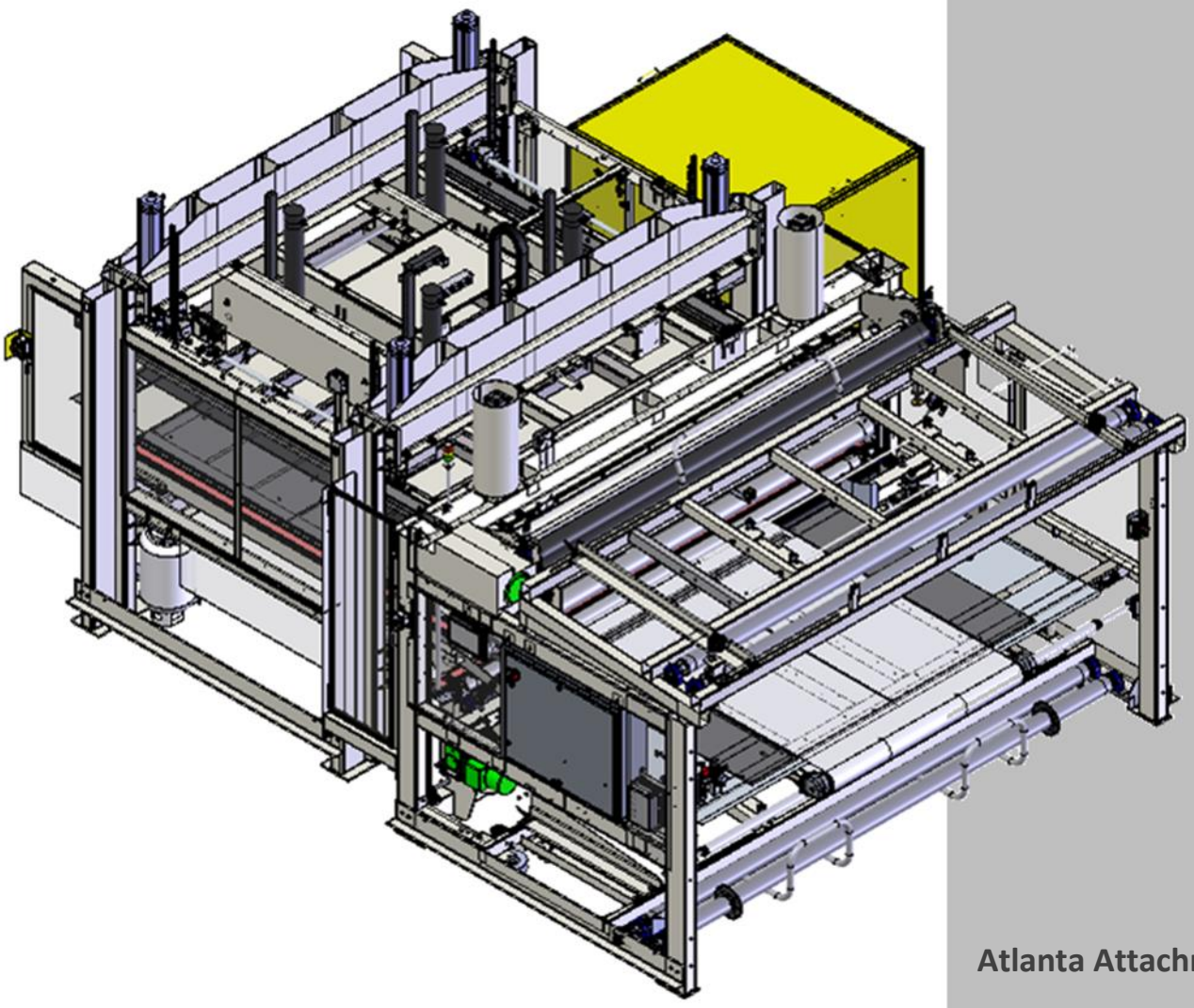
Technical Manual & Parts Lists



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Atlanta Attachment Company, Inc.

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IMPORTANT
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This equipment is manufactured under one or more of the following patents:
4,280,421 ● 4,432,294 ● 4,466,367 ● 4,644,883 ● 5,134,947 ● 5,159,889 ● 5,203,270 ● 5,373,798 ● 5,437,238 ● 5,522,332 ● 5,524,563 ● 5,562,060 ● 5,634,418 ● 5,647,293 ●5,657,711 ● 5,743,202 ● 5,865,135 ● 5,899,159 ● 5,915,319 ● 5,918,560 ● 5,924,376 ●5,979,345 ● 6,035,794 ● 6,055,921 ● 6,202,579 ● 6,279,869 ● 6,295,481 ● 6,494,225 ●6,523,488 ● 6,574,815 ● 6,802,271 ● 6,834,603 ● 6,968,794 ● 6,994,043 ● 7,543,364 ●7,574,788 ● 7,647,876 ● 7,735,439

Foreign Patents: 9-520,472 ● 0,537,323 ● 92,905,522.6 ● 96,936,922.2 ● 2,076,379 ● 2,084,055
Other U.S. and Foreign Patents Pending.

Contents

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 Workstation 1331B&BD, 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 about 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 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 must 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.

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.

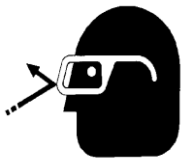
Faults or Errors

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 always be clearly visible and legible.
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 your factory about 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 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 must be stored for a longer period 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 must be loosened for the maintenance and repair work. Any safety mechanisms that must be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

The activities and intervals specified in the Instruction Manual for carrying out adjustments, maintenance and inspections must be observed, and parts replaced as specified.
All hydraulic and pneumatic lines should be examined for leaks, loose connections, rubbing and damage whenever the machine is serviced. Any defects found must be remedied immediately.

Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard.
Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control.
When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

Repair

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

Repair, Electrical

The power supply must be switched off (master switch off) and secured so that it cannot be switched on again inadvertently before starting any work on live parts.
Those parts of the machine and plant on which inspection, maintenance or repair work is to be carried out must be isolated from the power supply, if specified. The isolated parts must first be checked to determine that they are truly de-energized before being grounded and short-circuited. Adjacent live parts must also be isolated.
The protective measures implemented (e.g. grounding resistance) must be tested before restarting the machine after all assembly or repair work on electric parts.
Signal generators (limit switches) and other electrical parts on the safety mechanisms must not be removed or bypassed. Only use original fuses or circuit overloads with the specified current

rating. The machine must be switched off immediately if a fault develops in the electrical power supply.
The electrical equipment of our machines must be checked at regular intervals and any defects found must be remedied immediately.
If it is necessary to carry out work on live parts, a second person should be on hand to operate the emergency OFF switch or master switch with voltage release in the event of an emergency.
The working area should be cordoned off and marked by a warning sign. Only use electrically insulated tools.

Ventilation/Hazardous Gases

It is the end user's responsibility to ensure adequate ventilation is provided to exhaust all noxious or hazardous gases that may be present in the working environment.
Hydraulic and Pneumatic Systems
Work on hydraulic or pneumatic equipment shall only be carried out by persons with training, knowledge, and experience of hydraulic systems. Pressure lines shall be depressurized before starting any repair work.

General Liability

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

Starting Machine Movements

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

A Word to the End User

The end user has sole responsibility to enforce the use of safety procedures and guards on the machine. Any other safety devices or procedures due to local regulations should be retrofitted in accordance to these regulations and/or the EC Directive on the safety of machines.
Operator's position must always be readily accessible. Escape routes must always be kept clear and safety areas should be identified.

Safety Precautions

Safety should be a constant concern for everyone. Always be careful when working with this equipment. While normal safety precautions were taken in the design and manufacture of this equipment, there are some potential safety hazards.
Everyone involved with the operation and maintenance of this equipment should read and follow the instructions in this manual. Operate the equipment only as stated in this manual. Incorrect use could cause damage to the equipment or personal injury.
It is the owner's responsibility to make certain that the operator reads and understands this manual before operating this equipment. It is also the owner's responsibility to make certain that the operator is a qualified and physically able individual, properly trained in the operation of this equipment.
Specific safety warning decals are located on the equipment near the immediate areas of potential hazards. These decals should not be removed or obliterated. Replace them if they become non-readable.

- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS 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.

1. INSTALLATION

NOTE: It is important that the machine technician read this manual and is familiar with all the functions and safety concerns of the unit before Installing and operating.

Parts and Components

Infeed End

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

Optional : Overhead roll holder not shown

Optional : Hoist for loading the Top Film rolls not shown.

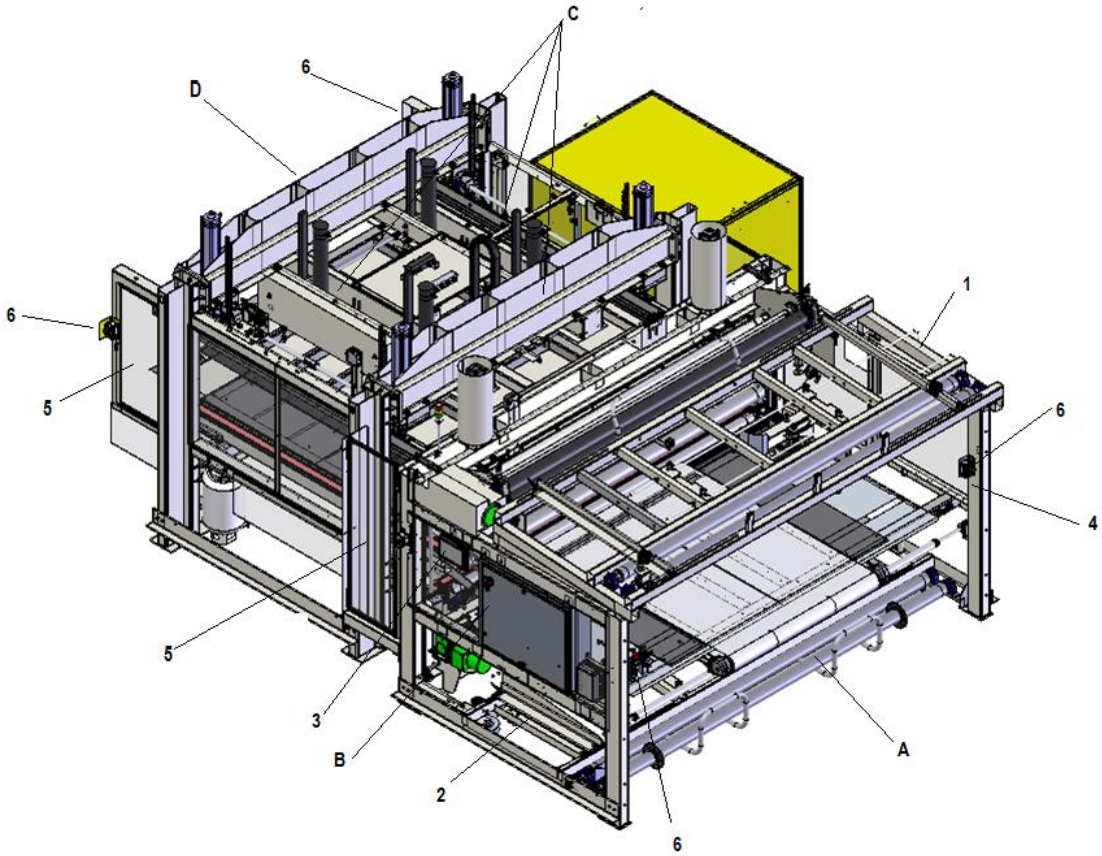
Machine Controls

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

Seal Area

7. Cross Seal
8. Right Side Seal
9. Left Side Seal
10. Compression 60 Tons

Outfeed End



Machine Specifications

Capacity & Production Specs.

Max. Width of Infeed:	85” inches
Min. Width of Infeed:	29” inches
Max Height under Pressure Roller:	20” inches
Roll capacity, top & bottom (12” DIA)	4 rolls (12” dia)
Infeed/outfeed conveyor height (inch)	36.0 inches
Overall height	104” inches
Max Film width (inch)	197” inches
Film width: Top (inch)	110” inches
Film width: Bottom (inch)	110” inches
Machine Weight (lbs.)	28,000 lbs
Shipping weight (lbs.)	30,000 lbs

Power Requirements

Volts	480 V, 3-phase 50/60 Hz
Amps	48A Full Load
Air Consumption in SCFM	35 SCFM
Air Pressure	80 psi
Power and Air Connection	Left, Mid, Side

Physical Specs:

Overall Dimensions	197” W X 223” L X 104” H (inches)
Overall Height w/ Hoist Option	13’ ft

Pressure Gauge Settings:

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

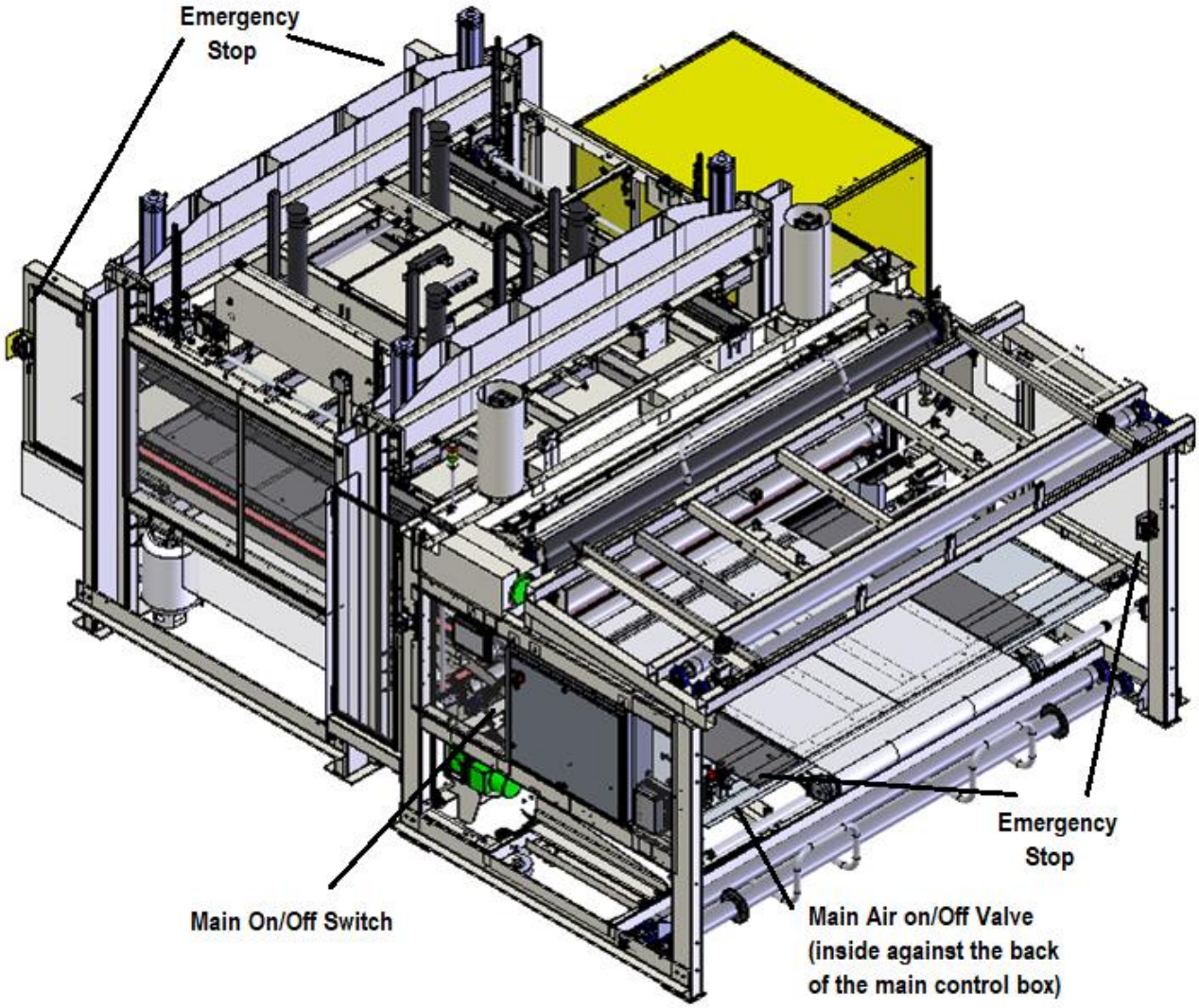
Mattress Size Limitations:

Feed in width.....	84” Wide X 20” high mattress

Machine Safety

The 1390HCE Auto-Pack is large machine and has many powerful drives and mechanisms. ANYONE assigned to operate and/or maintain this machine must be properly trained by an Atlanta Attachment technician, or a trained and qualified factory mechanic. Operation and/or maintenance of this machine by untrained personnel may result in a serious injury or even death.
ANYONE assigned to operate and/or maintain this machine, must read, understand, and follow the safety instructions and guidelines listed below mentioned in following pages.
ANYONE assigned to operate or maintain this machine MUST READ AND BE FAMILIAR with the location and operation of ALL operator machine controls, with particular emphasis on the following:
Main Electrical Power ON/OFF switch
Main Air Supply ON/OFF valve
Four Emergency-Stops, located on:

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



WARNING 1

In auto mode, this machine can start automatically at any time. Therefore, when the machine is turned on:
- NEVER ENTER INSIDE THE MACHINE
- NEVER CRAWL UNDER THE MACHINE
- NEVER CLIMB ON TOP OF THE MACHINE
- NEVER REACH INSIDE THE MACHINE FOR ANY REASON
- NEVER PLACE ANY PART OF YOUR BODY INSIDE THE MACHINE
- AFTER PRESSING START, THE INFEED BELTS WILL RUN CONTINUOUSLY AND WILL AUTOMATICALLY PROCESS MATERIAL.

WARNING 2

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

WARNING 3

To perform any machine maintenance always follow steps below:
1. FIRST, POWER DOWN THE MACHINE AND LOCK-OUT THE ELECTRICAL AND THE PNEUMATIC POWER SOURCES.
2. WAIT UNTIL SEAL BARS COOL OFF SUFFICIENTLY (APROX. 3 HOURS) BEFORE SERVICING THE SEAL BARS OR THE NEARBY AREAS OF THE MACHINE.

NOTE: Caution

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

Lockout/Tagout Program

"Lockout/Tagout (LOTO)" refers to specific practices and procedures to safeguard employees from the unexpected energization or startup of machinery and equipment, or the release of hazardous energy during service or maintenance activities. This requires that a designated individual turns off and disconnects the machinery or equipment from its energy source(s) before performing service or maintenance and that the authorized employee(s) either lock or tag the energy-isolating device(s) to prevent the release of hazardous energy and take steps to verify that the energy has been isolated effectively. The following references provide information about the LOTO process.

Equipment Energy Control Procedure
Lockout/Tagout Program

Description:	Auto Pack Workstation	Model:	**1390HCE**
Manufacturer:	Atlanta Attachment Co.	Location	

Energy		**Location**	**Magnitude**	**Control Method**
Electrical:		Disconnect/Ctrl Box	480V 3-Ph	Lockout & Tag
Pneumatic:		Main Regulator	90 PSI	Lockout & Tag
Gravity:		Cut bar Assy, presser belt Assy, Seal Bar assembly, Plastic Holder Clamp		

Remember to Release All Stored Energy!

Shutdown Procedure:

1. Inform all affected personnel that the machine will be in Lockout status.
2. Turn the power and pneumatic disconnects to the OFF position.
3. Fill out the tag with necessary information of the Lockout.
4. Install the Lockout device.
5. Verify all stored electrical energy has been released by pressing the power on button

. Also, use meter to test circuits in the electrical panel to insure stored energy is released there as well.

Perform necessary maintenance, services and/or repairs.

Startup Procedure:

1. Inform all affected personnel that the Lockout of this machine is being removed.
2. Replace any guards or safety devices which may have been removed during maintenance.
3. Remove the Lockout device and tag.
4. Turn the power and pneumatic disconnects to the ON position.
5. Push the green button on the back of the control panel to turn the machine on.
6. Inform all affected personnel that the Lockout has been removed and that the machine is ready for normal production operation.

Approved By: _____ Date: _____

2. OPERATION

Machine Start (Cold)

1. Turn the Main On/Off switch to the ON position. See Fig. 3.

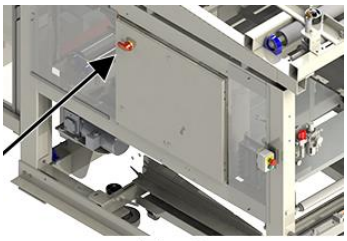


Fig 3

2. Turn the Main Air valve to the ON position. The pressure gauge should be set to 80 PSI. See Fig. 4.

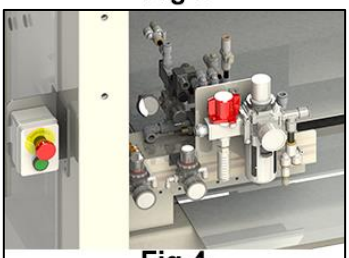


Fig 4

3. Press the green POWER ON push button. See Fig. 5.

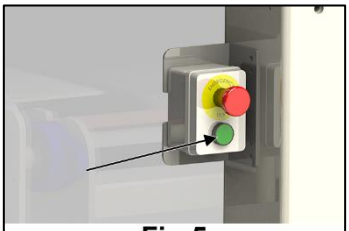


Fig 5

The Seal Bars begin to heat up at this point. It takes approx. 15 minutes to get the Seal Bars to their operating temperature.

Note: The Standard machine Temperature Settings are:
Side Seal Bars - 260 ºF
Cross Seal Bar - 290 ºF

Note: Under the normal machine conditions, the start screen will appear on the touch screen. When the green light on the light tower is on, the machine has reached operating temperature and is ready to run. If the green light does not illuminate, it usually indicates that one or more Emergency Stops are not reset, or other error condition exists.

Refer to “Light Tower Indicator” on page 24 of this manual for further light tower color explanation.

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

Note: The Seal Bars will not seal properly until they reach their proper temperature. The machine will not run until the seal bars have reached the proper temp.

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

Machine Start (Warm)

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

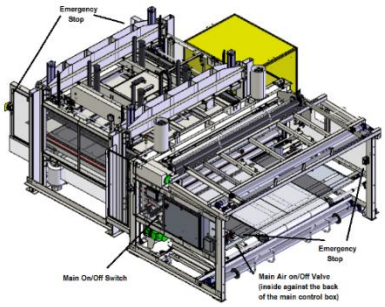
Note: The Seal Bars will not seal properly until they reach their proper temperature.

2. Press the Start button on the touch screen. See Fig 6.
Machine is now ready for production.

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

Side Doors

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



Note: Side Doors can be used to stop the machine if necessary.
Opening either side door initiates a safety pause.
Press blue button to reset

Film Loading

Bottom Film Loading

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

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

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

Important note!
The film rolls must be loaded such that they unwind clockwise, looking from the left side of the machine (see “Film Routing” on page 19).

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

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

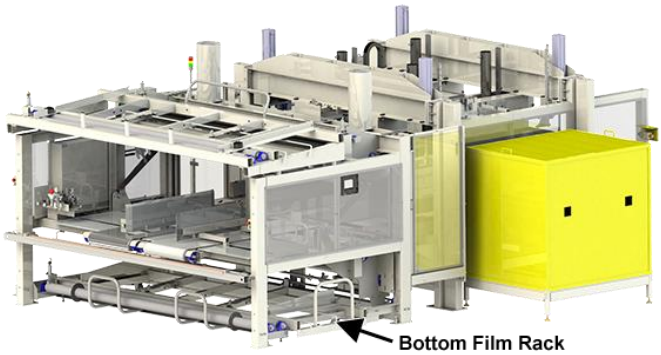


Fig 7

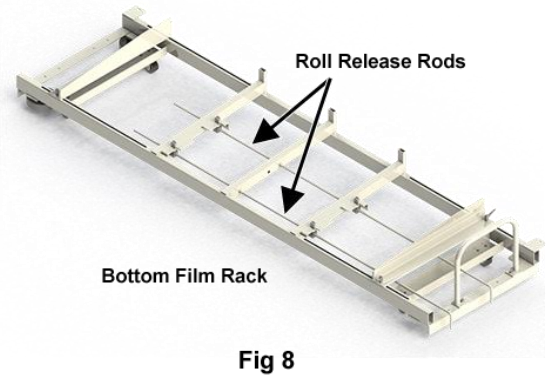


Fig 8

Top Film Loading

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

Important note! The film rolls must be loaded such that they unwind counterclockwise, looking from the left side of the machine (see “Film Routing” on page 19).

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

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

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

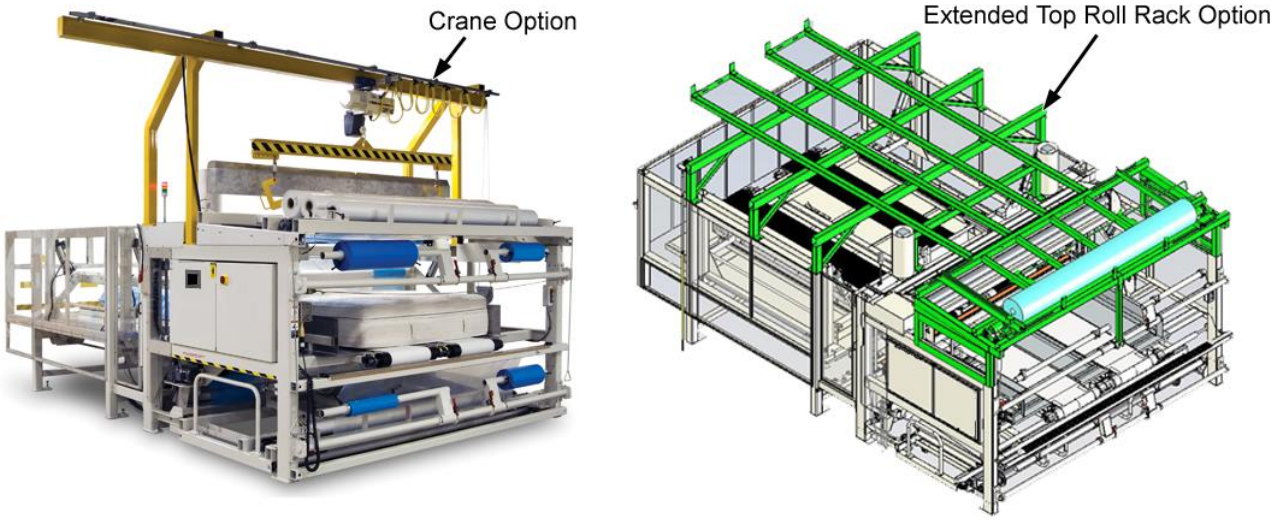


Figure 9

Film Routing

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

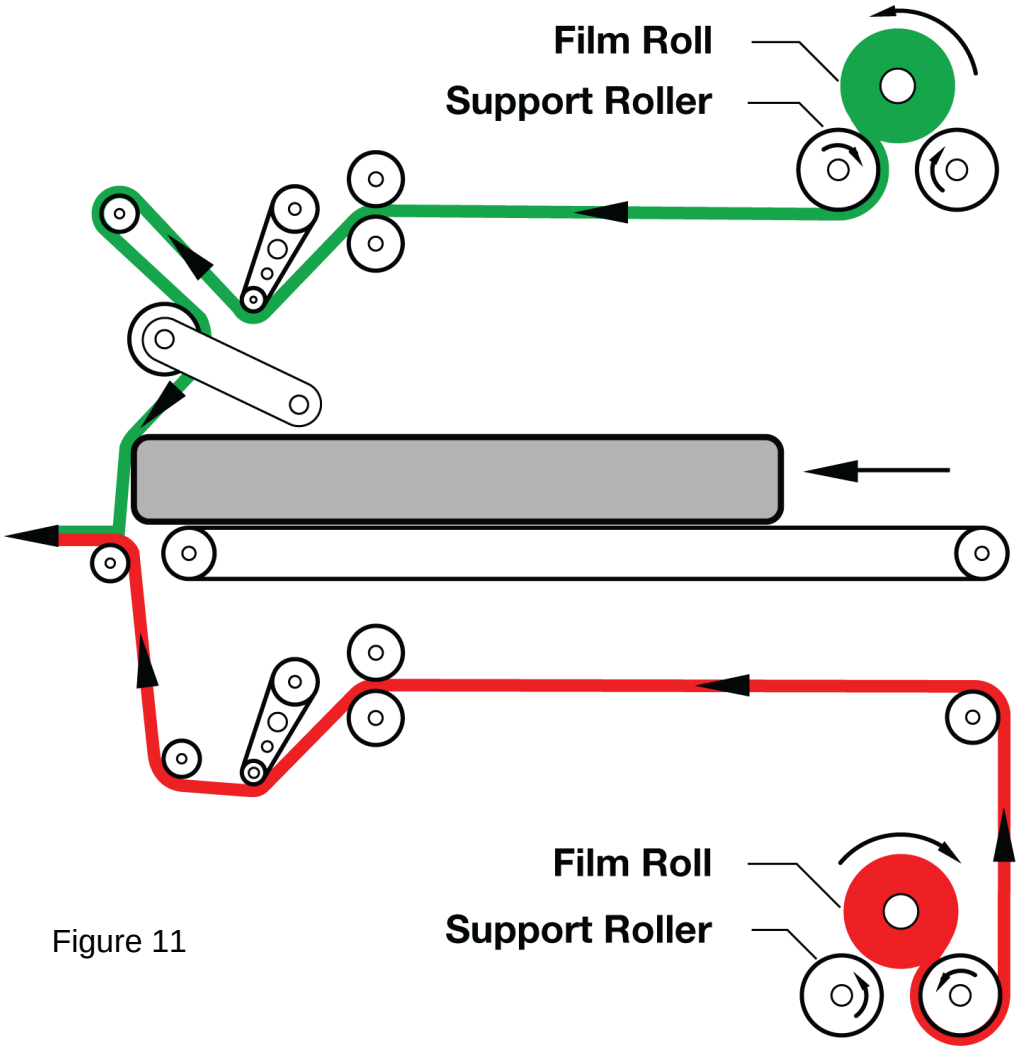


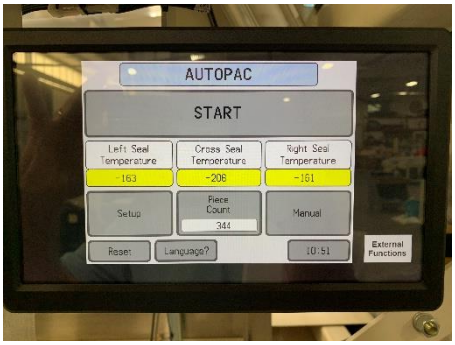
Figure 11

Film Splicing

1. When the plastic film runs out (from any roll), load a new roll onto the black support rollers and route the new film according to the illustration above.
2. Tie the corners of the old film and new film together.
3. From the Home screen, press the Manual button.
4. Press either the Top or Bottom Film Forward until the new film has progressed past the Cross Seal.
   Note: While pressing Film Forward, ensure the film does not wrap around the pinch rollers.
5. Align the top and bottom film and press the Cross Seal button on the Manual screen.
   Note: If the film is folded between the pinch rollers, use the manual toggle switch to open the rollers and correct.

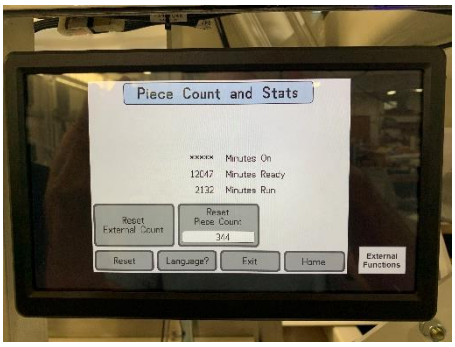
Machine Controls

Main Screen



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

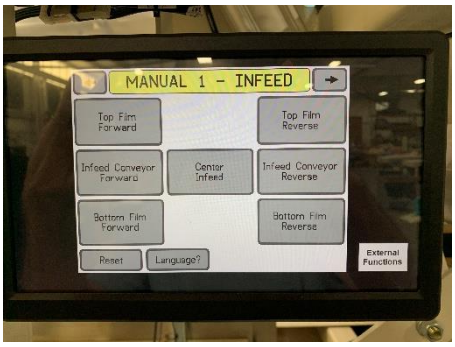
Piece Count



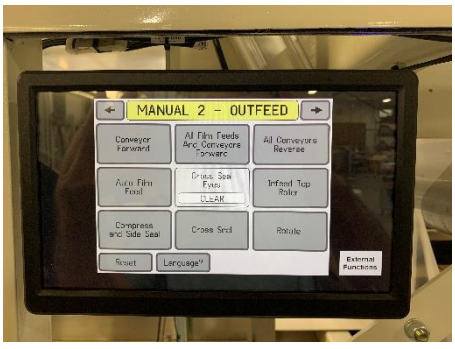
When this button is pressed and from this screen you can reset the piece count and/or the optional External count display.

Manual screens 1, 2 and 3

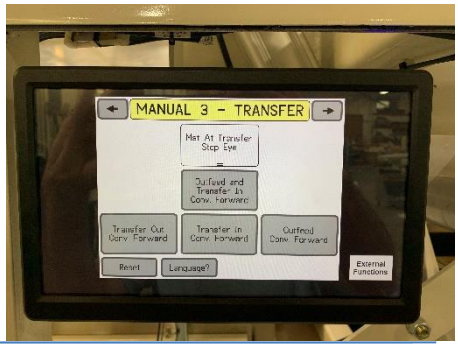
When this button is pressed on the start screen, manual functions become accessible. Pressing the right and left arrows at the top allows access to additional screens



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



Manual 2: provides controls for the outfeed conveyor, cross sealing, side sealing.

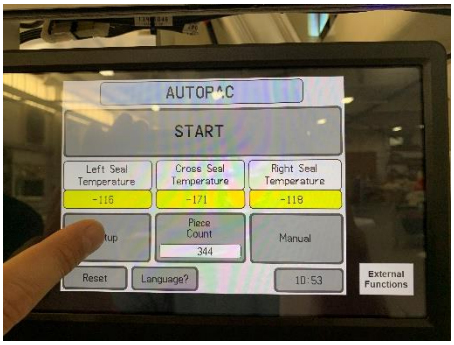


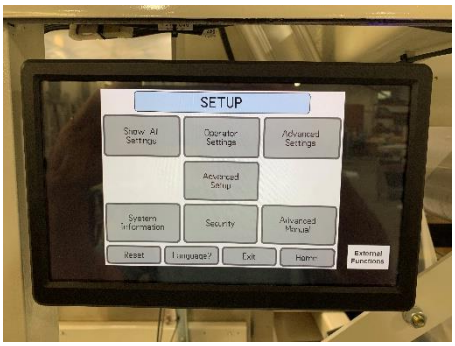
Manual 3: provides controls for the transfer functions

Setup

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

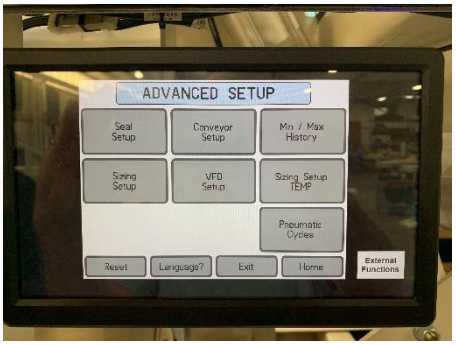
Note: When in the Advanced Manual screen, the heat to the seal bars is turned off. Use extreme caution when in Advanced Manual mode.

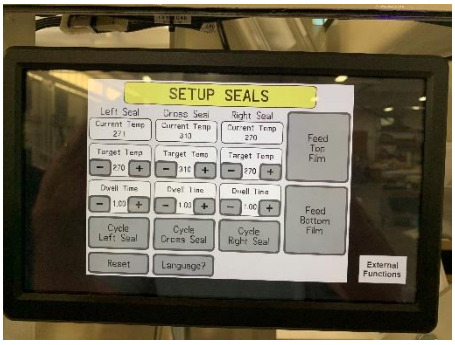




Setup Seals

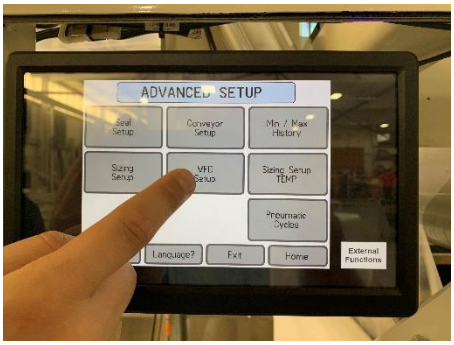
Pressing the Seal Setup button on the Advanced Setup screen will bring you to the Setup Seals screen. From this screen you can change the temperature and the dwell time. You can also activate the seal bars and feed film.

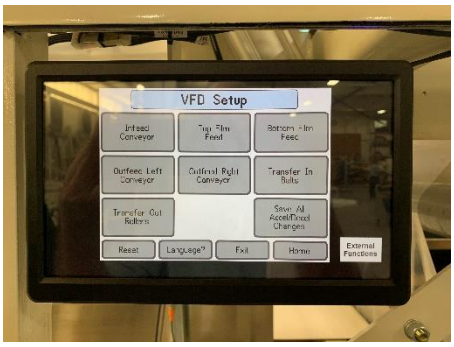


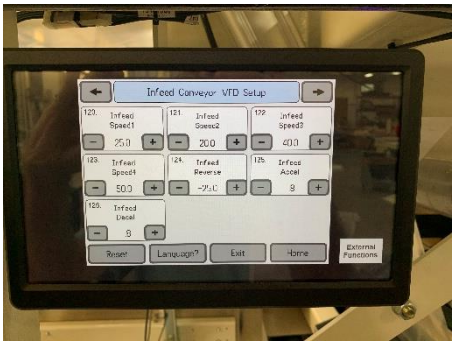


VFD Controls

Pressing the VFD Setup button on the Advanced Setup screen will bring you to the Setup VFD Drive Speeds. From these screens you can access and change all drive speeds

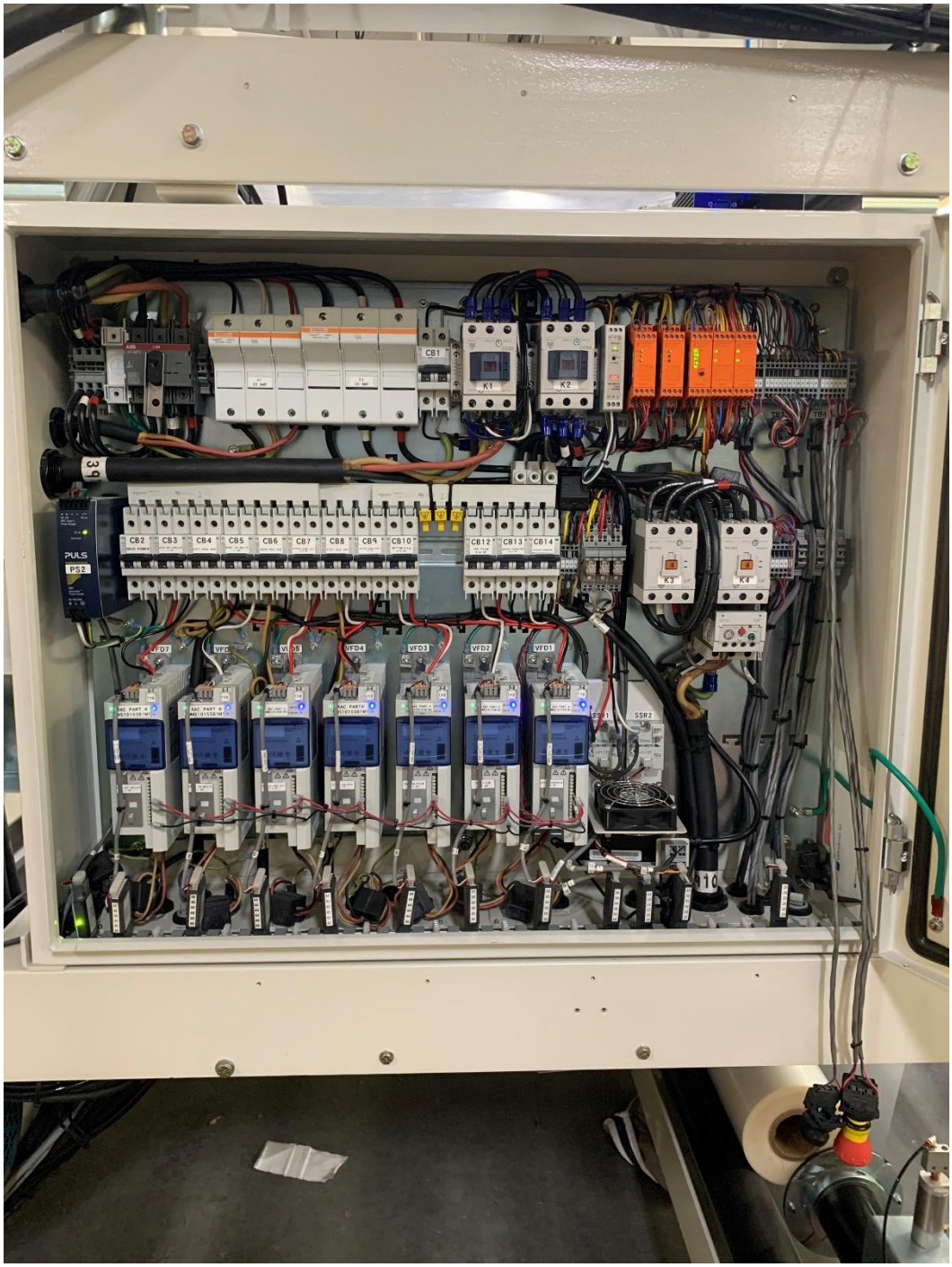






Main Control Panel

Contains: serial bus modules, main breaker, and individual breakers, along with VFD Drives,



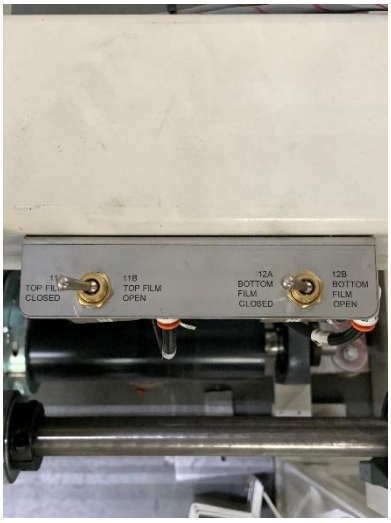
Other Operator Controls

1. Emergency Stop & Reset buttons **-**
   Allows the machine to be stopped and safety circuit reset if tripped.
   Located on each side of input and output end of the machine for operator convenience.

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

2. Film Rollers Activation Switches

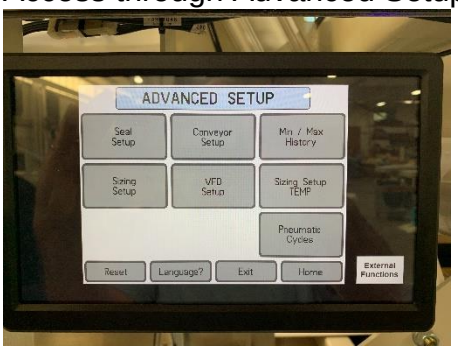
Located on the right side of infeed assembly. Allows the operator access and ability to open and close rollers for loading or adjusting of film



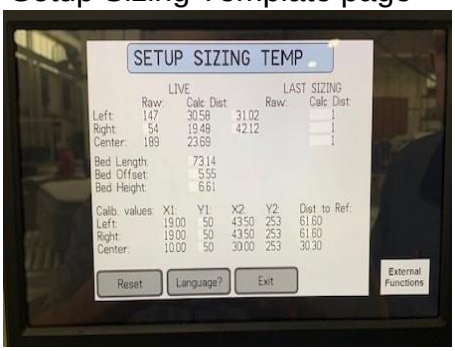
Mattress Location / Position Monitors / Lasers

Measures and advising on position of mattress during loading process. See pages 111 & 112

Access through Advanced Setup



Setup Sizing Template page



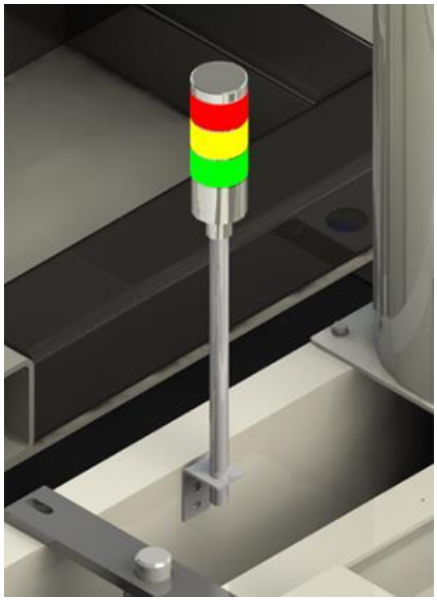
Left monitor

Center monitor

Right Monitor

Light Tower Indicator

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



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

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

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

Note: If the above indications do not solve the problem, please refer to “Troubleshooting” on page **44** of this manual for additional help or call Atlanta Attachment Company’s service department at 770-963-7369.

3. SERVICE

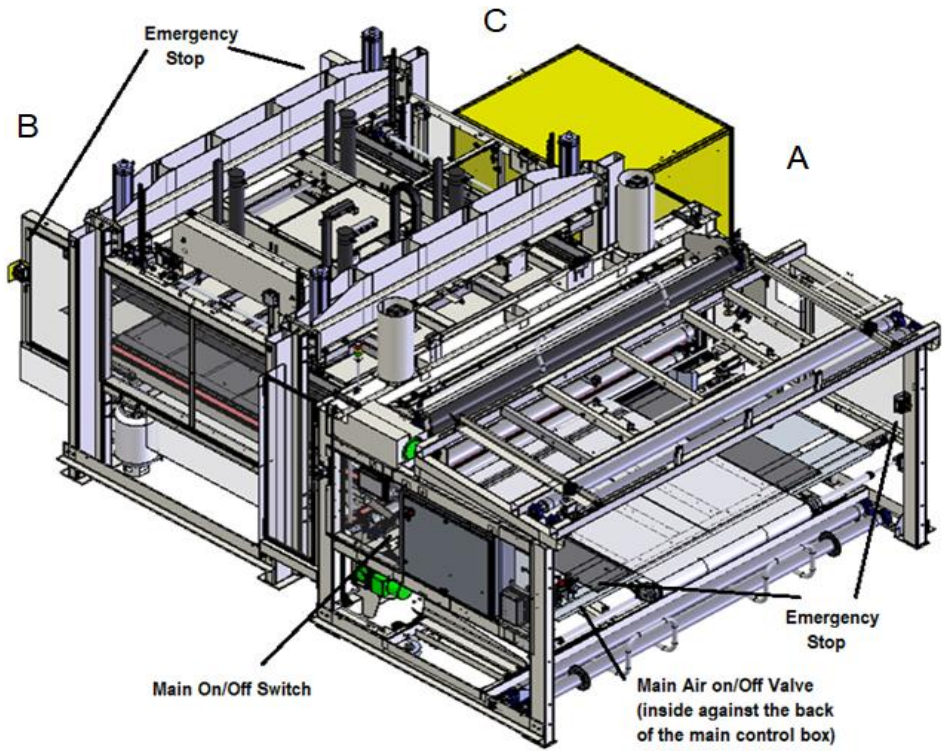
Seal Bar Maintenance and Replacement

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

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

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

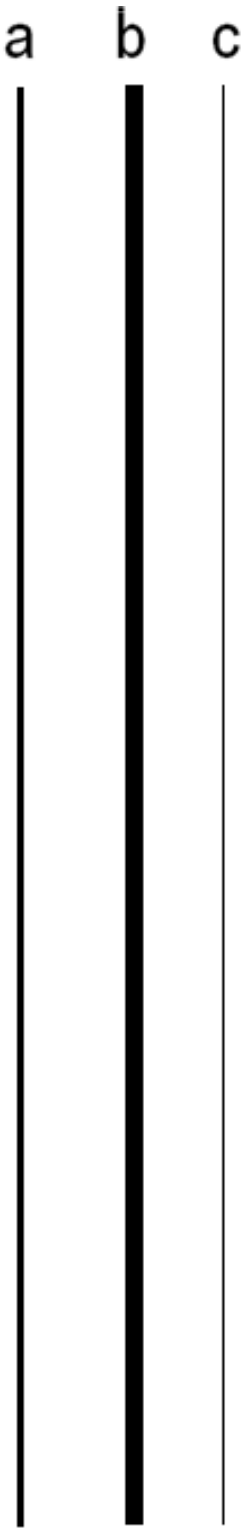
Sealing Bar	Temperature º F / º C	Closing Time
Cross Seal	290 º F / 143 º C	1.7-2.7 sec.
Right edge	260 º F / 127 º C	1.7-2.7 sec.
Left edge	260 º F / 127 º C	1.7-2.7 sec.



There are four major variables for obtaining a good weld.

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

2. Dwell Time: The value is set via the control panel. Sealing time is expressed in 0.01 seconds.



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

4. Condition of seal bars: upper seal bars black coating is smooth with no cut or scraps and a dull finish. Check the PTFE tape is in good condition.

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

Explanation of chart written out below: ⟶

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

.

(b) Excessive time or temperature. The melted plastic bubble appears irregularly, several of which are joined together and, in some cases, bundling between these portions.
The weld is not constant throughout.

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

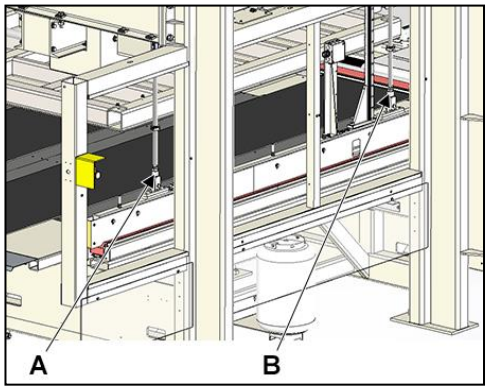
Cleaning seal bars: for best performance, seal bars should be kept clean, clean whenever necessary with a soft cloth dampened with WD-40. Be very careful not to scratch or disturb the coating on the upper heat seal bar as this will cause sticking and film buildup and poor seal quality.

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

Side Sealing Bars

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

(A). - Welding is even and the depth of a weld's right.
The melted plastic appears with small bubbles and a connecting line between these bubbles. The weld is constant throughout.



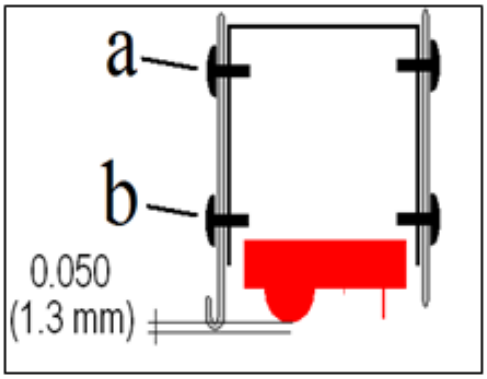
(B). - Sealing bars are too deep
To set the depth of the shaft, loosen the nuts (a), (b) and rotate the cylinder shaft clockwise from top view on both cylinders which support the seal bars. Rotate the shaft ¼ turn at a time and test the quality of the seal between each setting.

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

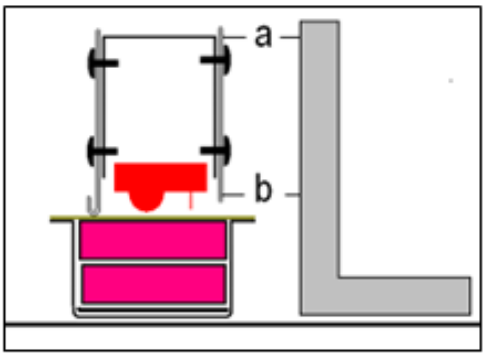
(D). - Heat sealing bar is not parallel with the non-stick tape lengthwise.
Adjust the parallelism between the heat seal bar and nonstick ribbon by loosening the nut (a) or (b) and rotate the corresponding cylinder rod. Rotate the shaft ¼ turn at a time and test the quality of the seal between each setting.

(E). - Irregularity along the sealing

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



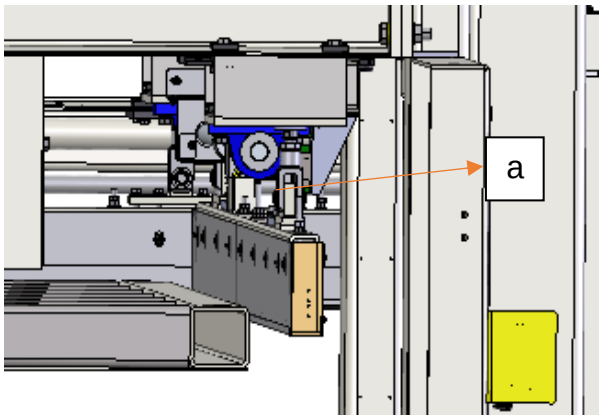
2. Verify that the sealing bar is parallel with reference to the non-stick tape. Rest the cooled seal bar on the non-stick tape and place a square on the tabletop next to seal bar and check the distance between the top of the heat baffle (a) and the bottom (b). You should have equal reference to the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



alignment on page **28**.

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

Alignment of Seal Bars
Loosen the clevis screws (a) and adjust up or down to meet the proper angle. Check after each adjustment to ensure bar is level with bottom tray.



(F). - Random irregularities in the seals.

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

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

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

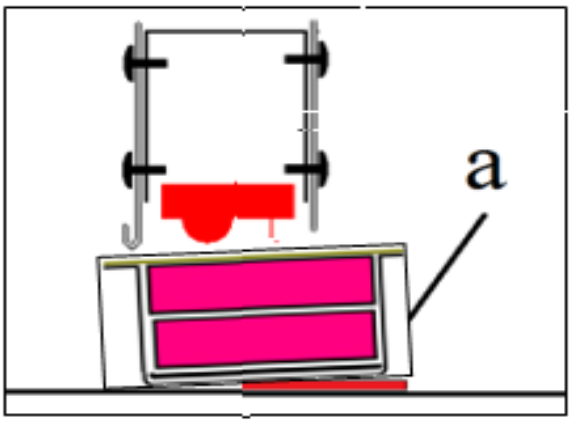
(G). - Irregularities constant seal.

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

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

(H). Shimming Bottom Tray

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

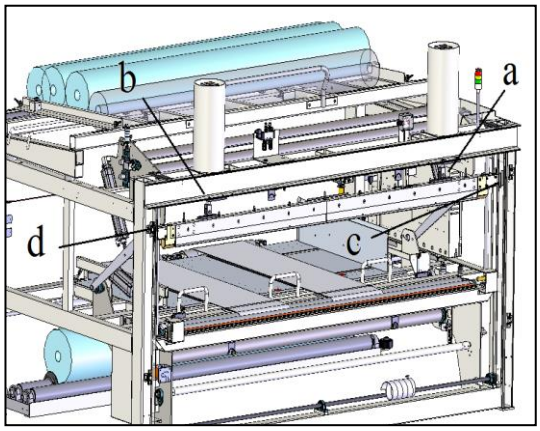


4. Check the upper sealing bars for damage, they should look black with a dull finish all along the bar. If any shinny areas are seen along the bar, it is damaged and needs replacement.

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

Symptoms and adjustments of the cross-seal Bar

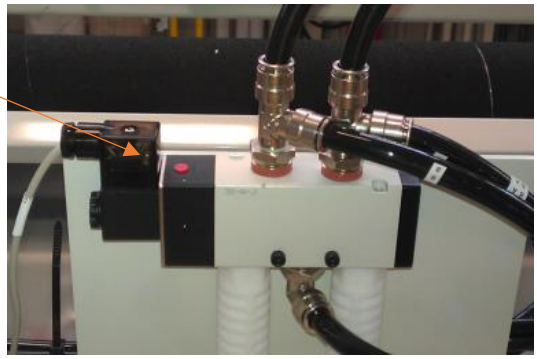
(a) through (g) as described in the previous paragraphs are types of heat-sealing problems that also apply to the cross-seal bar with the following additions:



(I). Bar-Gradient
Position cross seal bar to the height as pictured until you see the four bolts (C) & (D) in the chain guard opening. Loosen these bolts with a 7/16 wrench as well as the 30mm nut above the clevis on the cylinder where pressure needs to be added. Rotate the cylinder shaft counterclockwise from top view ¼ turn only, then tap the cylinder cycle button on the solenoid valve.
approximately…(1/10 sec) to jog cylinders.

Tighten the four chain bolts with a 7/16 wrench and test seal. Repeat if needed, otherwise tighten nut above clevis to complete adjustment.

Cylinder fire button

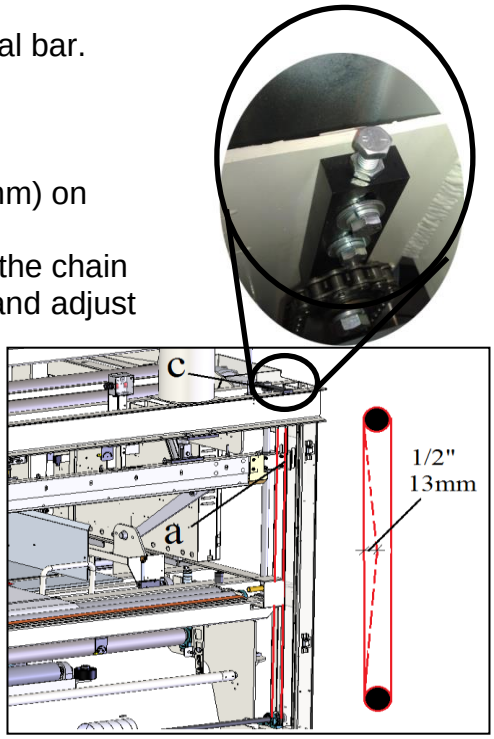


Cross Seal Bar chain tension

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

To check tension and adjust if needed:

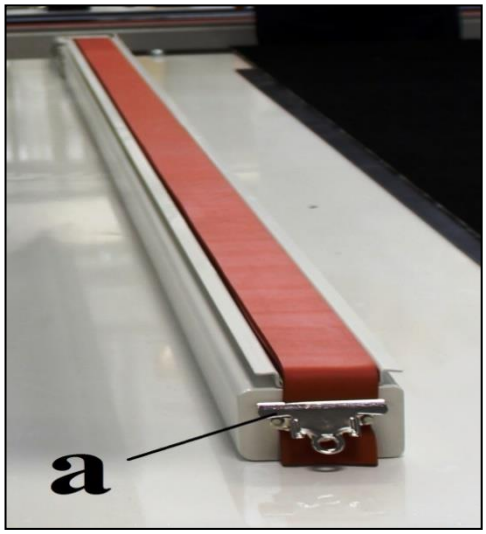
The chain (a) displacement is approximately 0.5 inches (12 mm) on center if light pressure is applied to the chain.
The adjusting tensioners (c) are located at the upper ends of the chain system. Use a 9/16 wrench to loosen the two mounting bolts and adjust the tension bolt. Retighten the mounting bolts.



Note: *Tension should be checked every three months.*

Replacement of Nonstick Tape

1. Make sure heat seal bars are in the up position.
2. Open the clamping system (a) peal back non-stick tape
3. Inspect the silicone rubber backing under tape for cuts. If cut or damaged, replace silicone rubber cushion in that area as they are all glued together. After replacement follow the procedure for system realignment.
4. Pull out enough new tape from the roll located in front of raised rail to cover silicone padding.
5. Align the tape and adhere to the silicone rubber and metal flanges of support tray.
6. Cut the excess tape and mount into the front clamping system. (A)



Replacing Silicone Rubber Padding:

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

With seal bar in the up position remove non-stick tape. Next remove the damaged silicone padding completely. Clean glue off with mineral spirits.

(DO NOT LOOSEN ANY OF THE SCREWS BENEATH THE SILICONE PADDING AS THIS WILL DISRUPT THE SEAL BAR LOWER RAIL ALIGNMENT!)

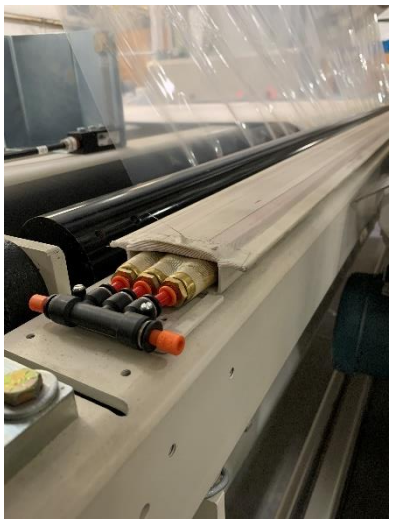
Glue new padding to the rail. Secure PTFE tape and if required see shimming the seal bar after lower rubber replacement.

Side Seal and Cross Seal Bladder Adjustments

Reference parts 1406995 and 13901145

1406995 Cross Seal

Note: 10 – 15 psi is average setting



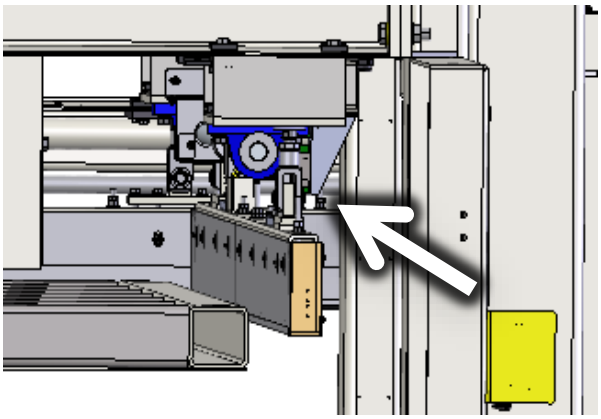
13901145 Side Seals

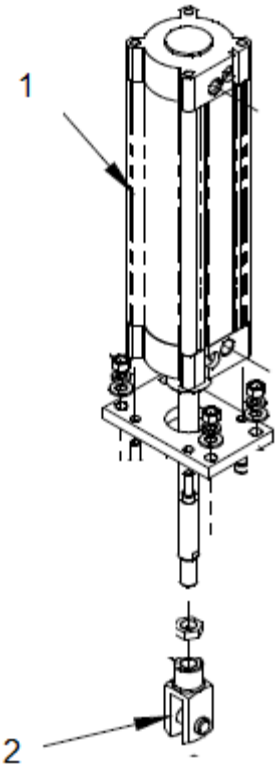
Note: 10 – 15 psi is average setting

Adjusting the Seal Bar Downward Pressure

Note: For side seal and cross seal bars.

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





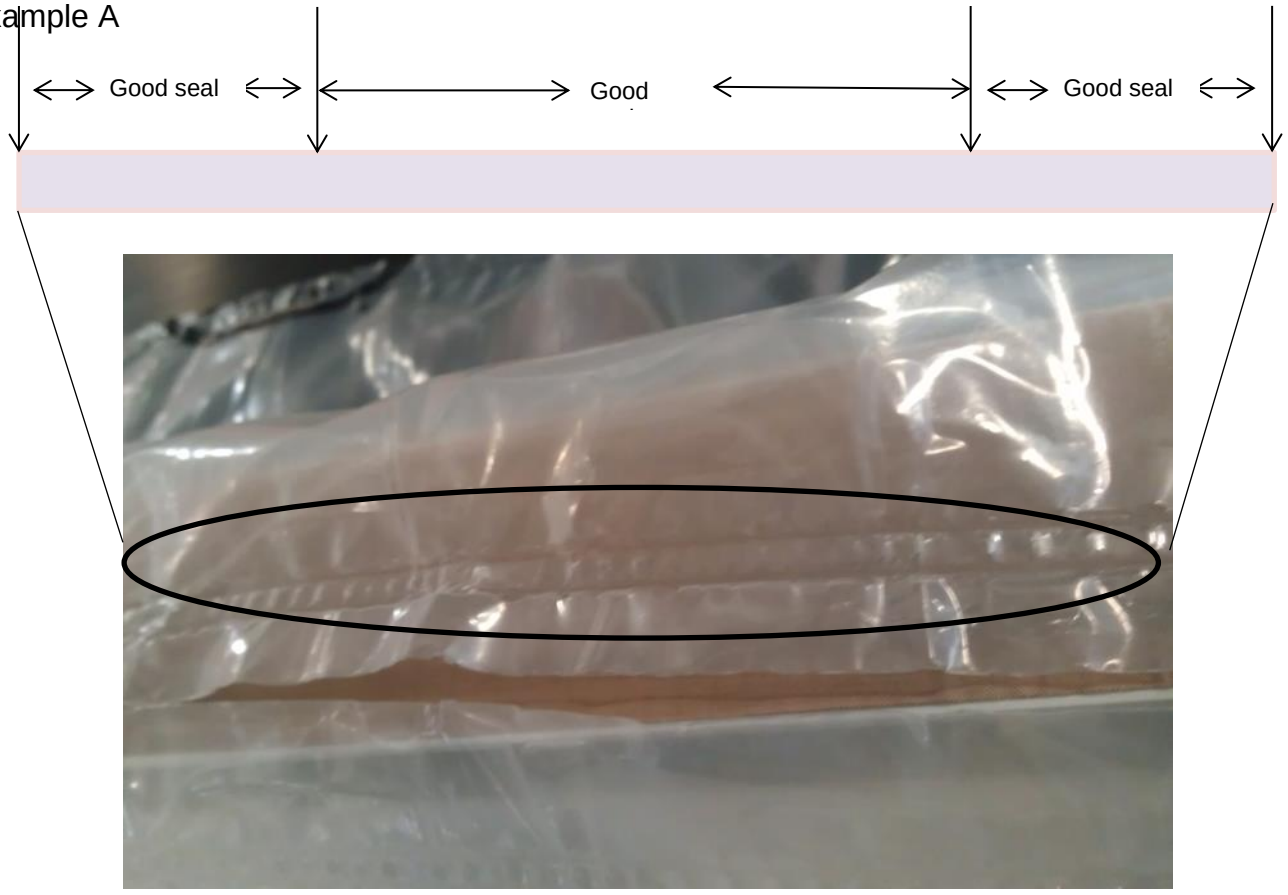
Loosen nut above clevis (2) on each cylinder rod and rotate rod cylinder (1) counterclockwise ¾ turn. Take a sample set of plastic layers used in production and perform a seal. What we are trying to determine is a sealing pressure point. The object is to get the heated seal bar sealing the plastic evenly with as little force as possible.

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

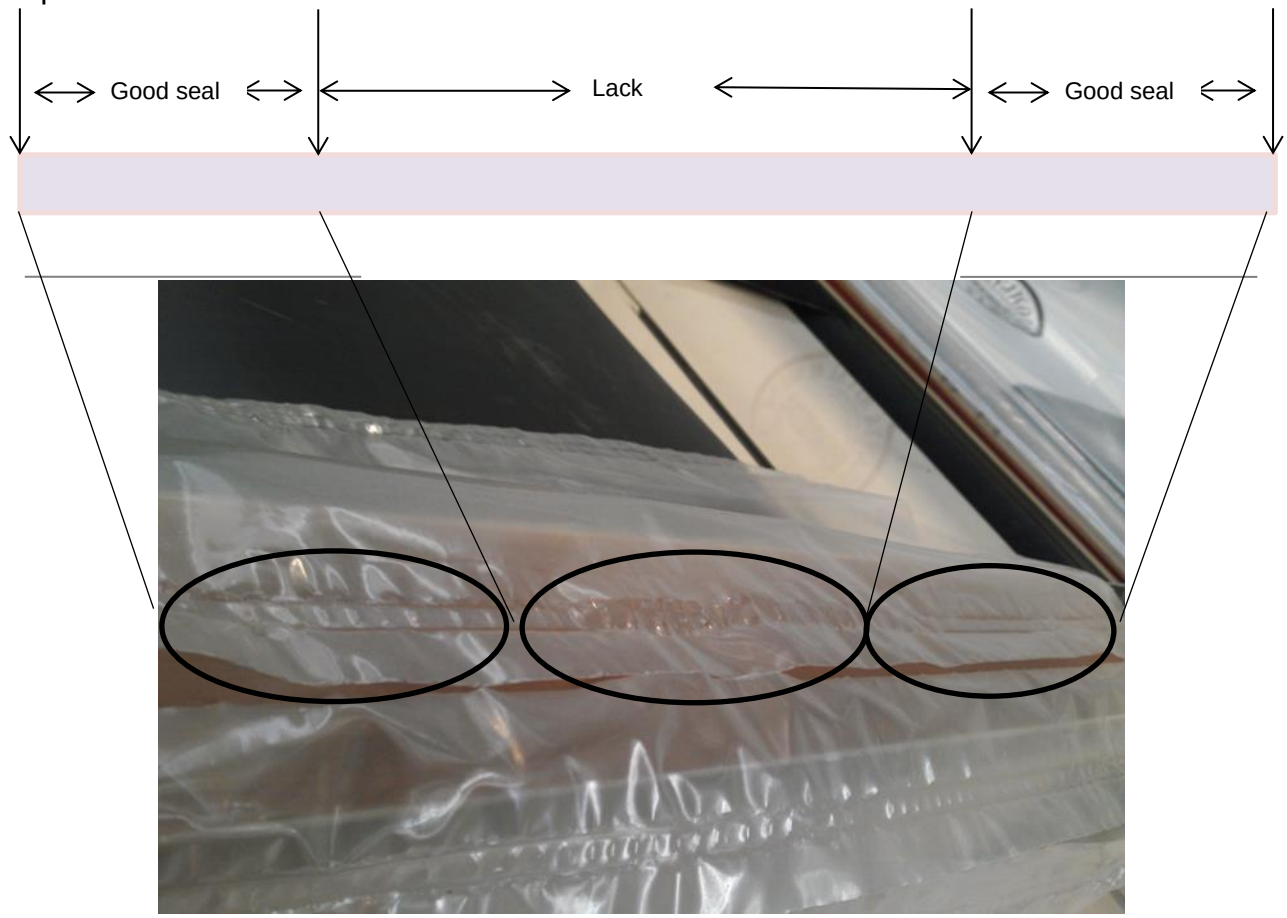
Once you have Example A, try to decrease pressure by a ½ turn on both cylinders and see if you get Example B.

If not, keep decreasing until you see Example B, If so, then increase pressure ½ turn and tighten the cylinder rod nuts and you are finished.

Example A



Example B

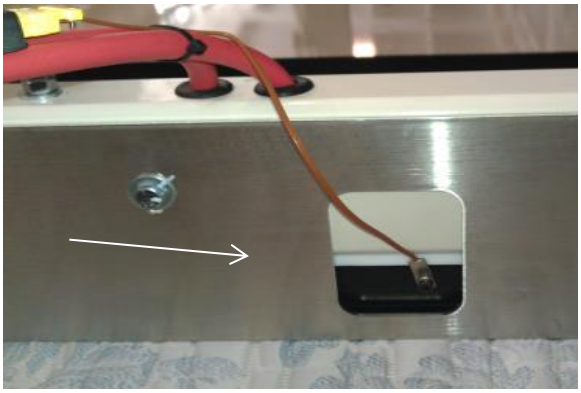


Upper Seal Bar Element Replacement

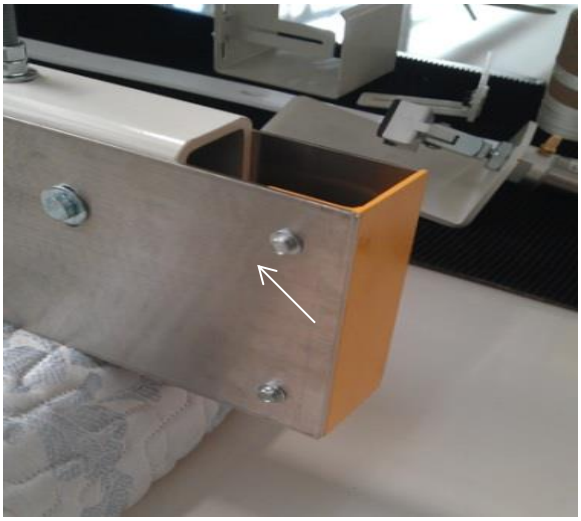
WARNING: Wait until the heat-sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by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

1) Turn Power supply off

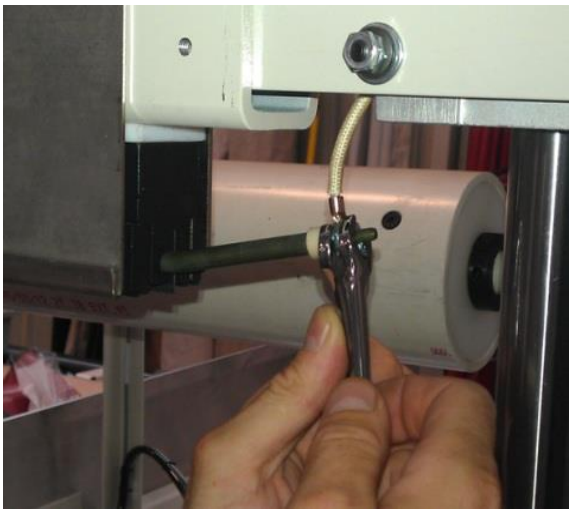
2) Remove thermo-couple wire.



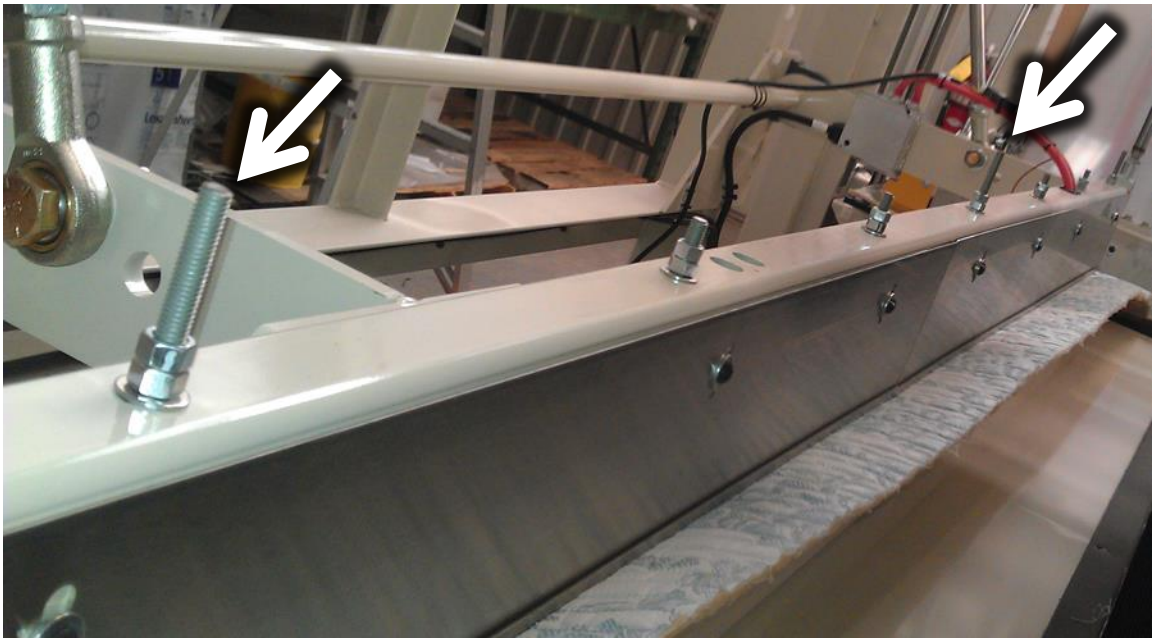
3) Remove protective end plates from seal bar

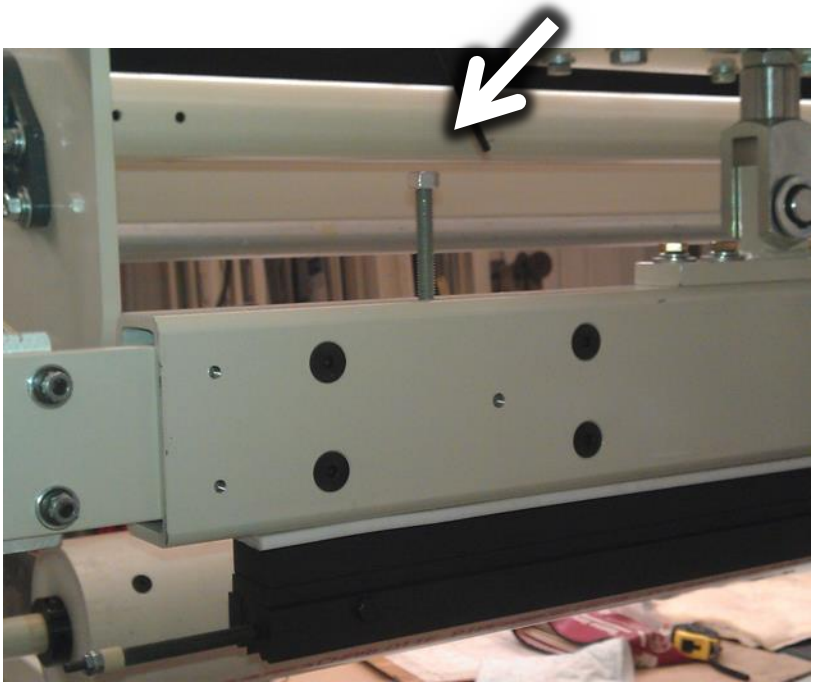


4) Disconnect wire from both ends of heating element.



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

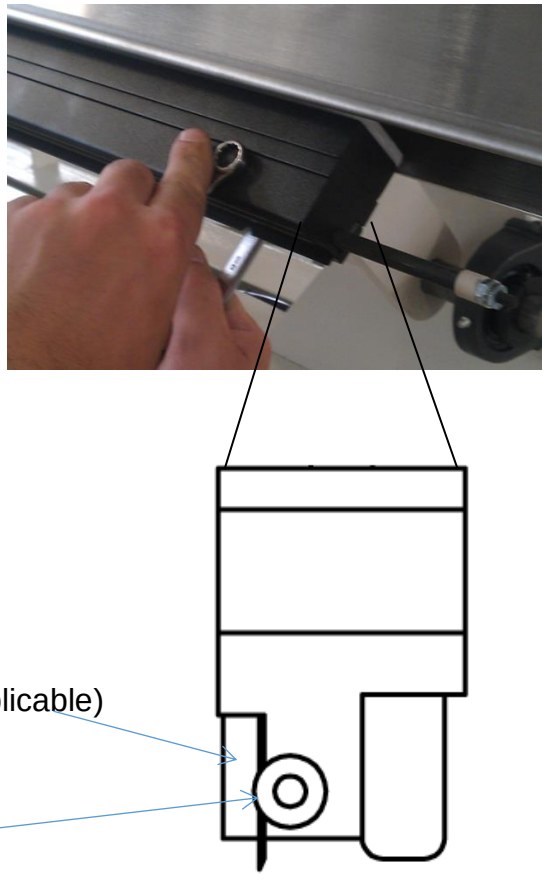




6) Remove all the remaining nuts from shorter studs. This will allow the seal bar assembly to slide out pass stainless steel guards far enough for servicing.

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

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



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

9) Remove damaged heating element.

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

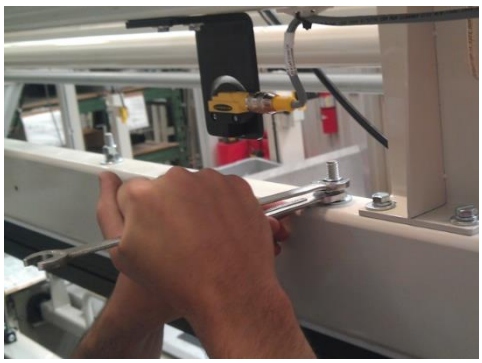
Reverse steps 1 thru 10 to complete replacement with special attention to steps 7, 6, 5, & 4.

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

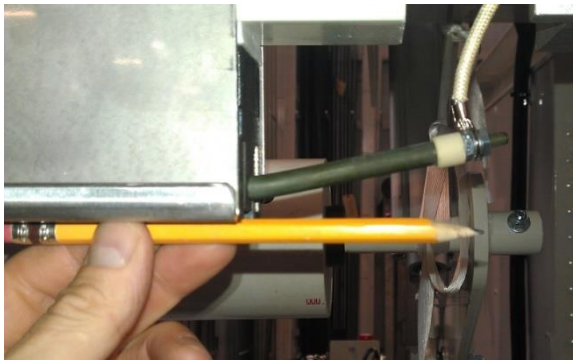
On step (6) & (5) Push seal bar assembly up with one hand as you tighten the first set of nuts with the other hand. After all of the nuts are finger tight; use a wrench to turn each nut ¼ to a ½ turn to finish compression of nylon gasket.

(**WARNING DO NOT TIGHTEN PAST ½ TURN**!)

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



(4) Bend heat element up approximately 30 degrees.



After replacement is complete refer to Adjusting the Seal bar beginning on page 315 for final adjustments.

Shimming the Seal Bar

Note: For cross seal bar see symptoms and adjustment of cross seal bar; once adjustment is complete, move to #3 on this page 29.

Follow procedures for replacing Left and Right seal edge or heating element page.34.

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

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

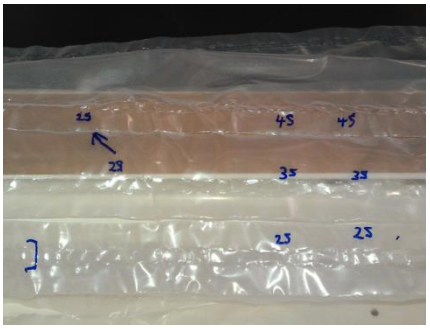
1) Setup test plastic as seen on right

2) Adjusting the Seal bar Pressure

Somewhere between Example A and B on page 32 is a good starting point for a new setup before moving on to shimming. Always make this adjustment **before** shimming.

3) Shimming rail system.

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



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

Mattress Size Adjustments

The 1390HCE basic machine is designed to assist with manually centering the mattress by showing its position as referenced by the numerical numbers shown on the position laser

Note: It will not automatically detect and adjust for variations in bed sizes unless it is equipped with optional centering guide part number **1390HCE-KIT1**

Before this machine is shipped, it is adjusted and tested according to the customer's bed specifications and should not need to be readjusted.

Mattress Location / Position Monitors/Lasers

Measures and advising on position of mattress during loading process.

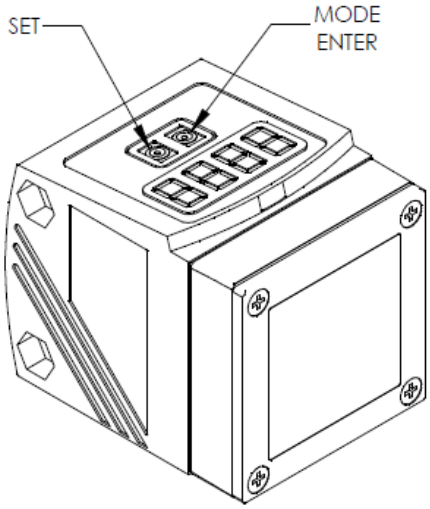
See page 116 and 117 for programing instructions.

Left monitor

Center monitor

Right Monitor

SENSOR	UNI (units)	OUT2 (output 2)	RATE (sampling rate)	ASP (analog start point)	AEP (analog end point)
LEFT (length)	Inches	I (4-20ma)	50	19.0	43.5
RIGHT (length)	Inches	I (4-20ma)	50	19.0	43.5
CENTER (height)	Inches	I (4-20ma)	50	10.0	30.0
PLATEN (height)	Inches	I (4-20ma)	50	16.0	37.0



Maintenance

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

Daily

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

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

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

Weekly

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

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

Monthly

Check the chain tension on all four motor drives. Adjust as needed.
Check the tension of the input and output belts. Adjust as needed.

Quarterly

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

Bi-Annually

Replace the air supply filter element.

Operator Shift Maintenance Charts

Two(2) Printable Sheets

Technician Maintenance Charts

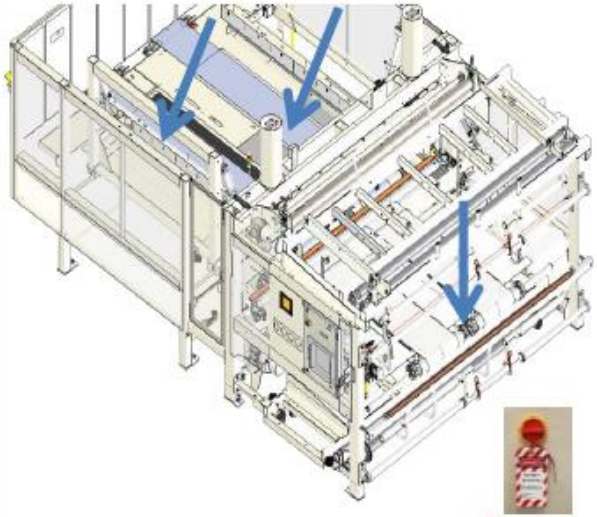
Four(4) Printable Sheets

Preventative Maintenance **(Shift Schedule)**	**1390HCE Auto Pack**	Frequency START MID END

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

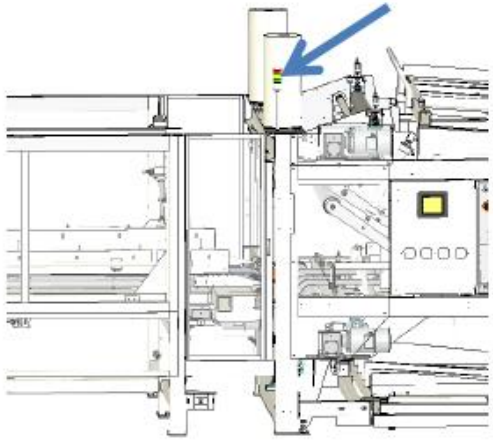
START

Safety is First Priority! Follow all Lockout/tagout procedures, before working on machine



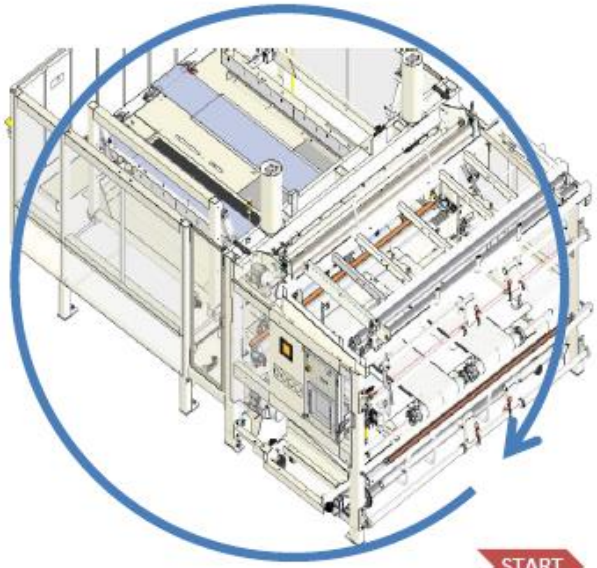
START

1. Check all conveyor belts for damage, rips tension and alignment / tracking of the belts..



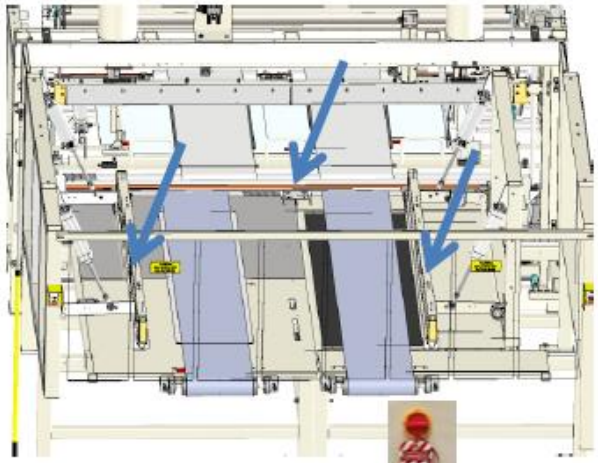
START

2. Check to see if the light tower indicator is working properly.



START

3. Check for unusual noises and or air leaks. Alert a technician.



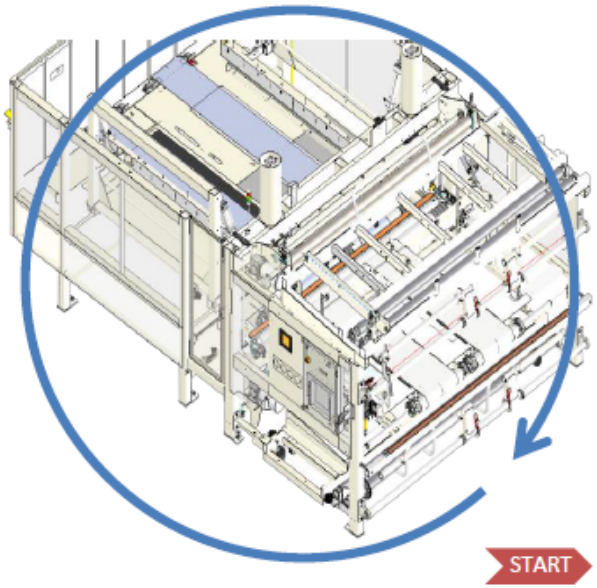
START MID

4. Check PTFE tape on lower three seal bars. Tape should be smooth no tears or cracking.

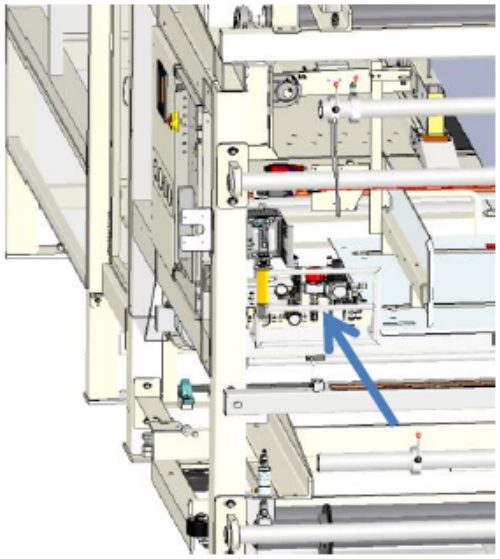
START MID

5. Inspect seal bars for any damage, cracks and wear. **See note at end on seal bars**

Preventative Maintenance **(Shift Schedule)**	**1390HCE Auto Pack**	Frequency START MID END



6. Complete a general cleaning of machine.



7. Check air system for moisture. Drain regulator bowl and/or alert a Technician.

VERY Important Message:

Upper seal bars have a coating, and the Lower Seal bars are made of PTFE which is a non-stick material. Use extreme caution when inspecting seal bars . If everything looks perfect DO NOTHING. If this Teflon material is scratched or torn in some areas, it will cause buildup on the seal bar. If this happens, a clean thick rag with WD-40 sprayed on it, should be used to wipe the seal bar to keep it clean. By doing this it will prevent buildup and burn through.

Additional Maintenance List or Notes:

** Warning **

Never for any reason

Enter Inside the machine
Crawl under the machine
Climb on top of the machine
Reach inside the machine
Place any body parts inside the machine

After pressing the start button, the infeed belts will run continuously and will automatically process materials or products.

** Warning **

Never for any reason

Perform any machine maintenance unless the machine is properly powered down and cool.

Lockout/tagout procedures must be followed.

In manual mode, machine may be prompted to execute any of its functions. Only a properly trained operator or technician should work on or use the machine in manual mode of operation to prevent injury or machine damage.

Preventative Maintenance (**Mechanic schedule**)

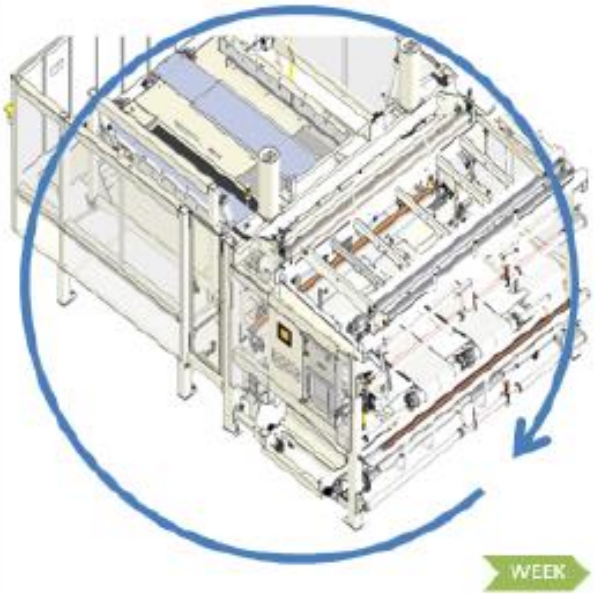
1390HCE Auto Pack

Frequency — DAY | WEEK | MONTH

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

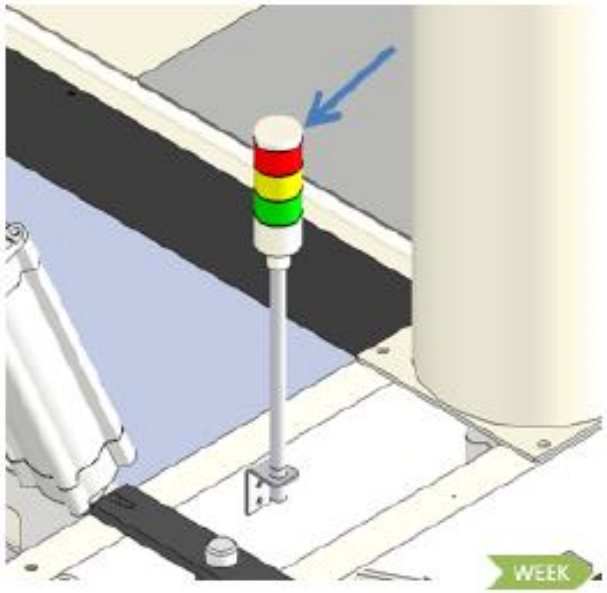
DAY | WEEK | MONTH

Safety is First Priority! Follow all Lockout/tagout procedures, before working on machine



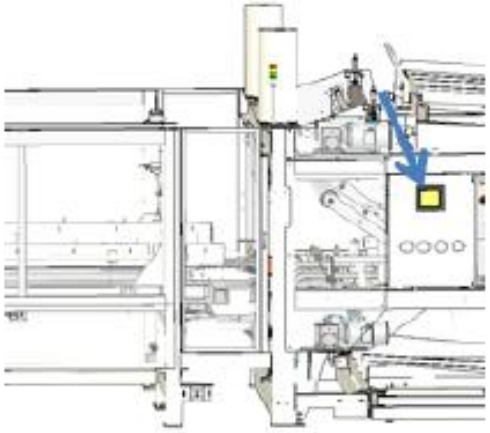
WEEK

1. Check for unusual noises and or air leaks.
2. Proceed with general cleaning of machine



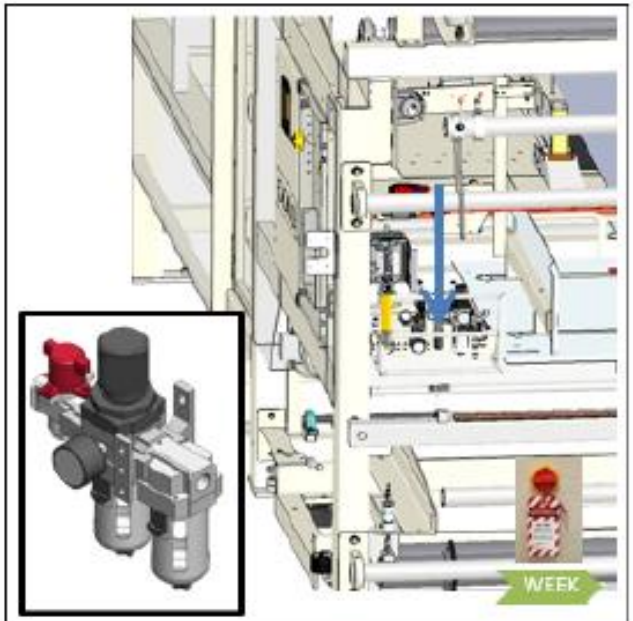
WEEK

3. Check to see that Light tower functions properly.



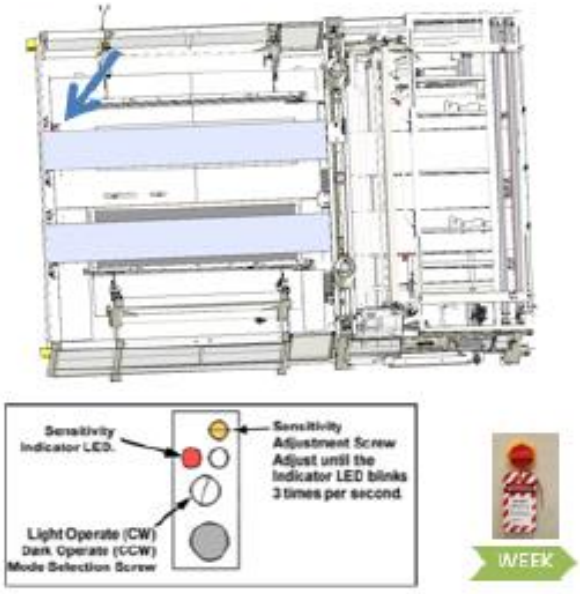
WEEK

4. Check screen operation, Recalibrate only if having issues . Procedure in operator's manual .



WEEK

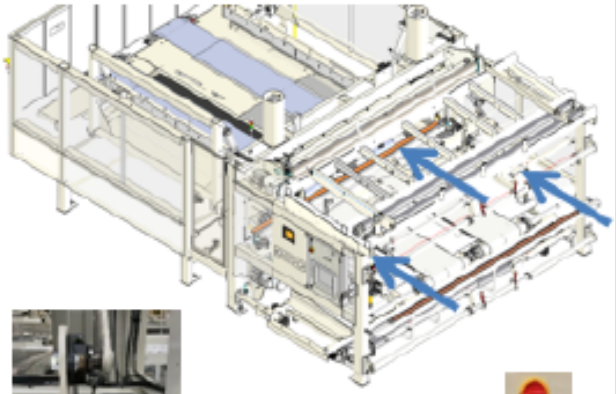
5. Check air filter and replace as needed.



WEEK

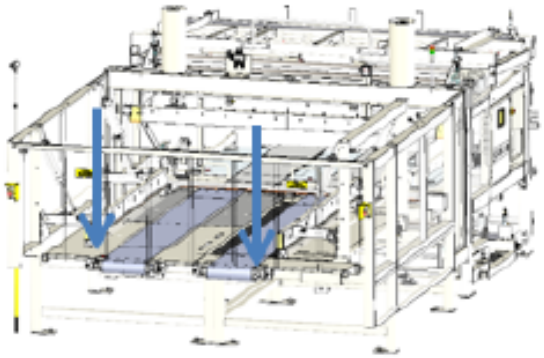
6. Check and clean photo eyes and reflective tape in out-feed area. Replace tape if damaged.

Preventative Maintenance (**Mechanic schedule**)	**1390HCE Auto Pack**	Frequency DAY WEEK MONTH



WEEK

6.a. Check and clean Sizing Laser eyes on both sides and center top of in-feed.



WEEK

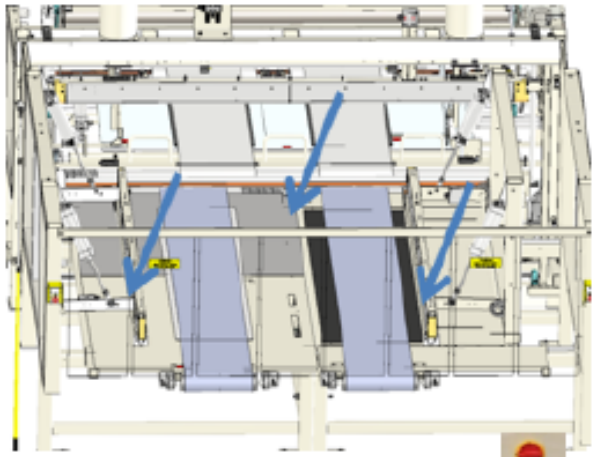
7. Clean area around conveyor belts and roller bearing on in-feed and out-feed assemblies.

VERY Important Message:

Upper seal bars have a coating and the Lower Seal bars are made of PTFE which is a non-stick material. Use extreme caution when inspecting seal bars . If everything looks perfect DO NOTHING. If this Teflon material is scratched or torn in some areas, it will cause buildup on the seal bar. If this happens, a clean thick rag with WD-40 sprayed on it, should be used to wipe the seal bar to keep it clean. By doing this it will prevent buildup and burn through.

caution

Never reuse cleaning rags in this procedure. Always discard after cleaning!



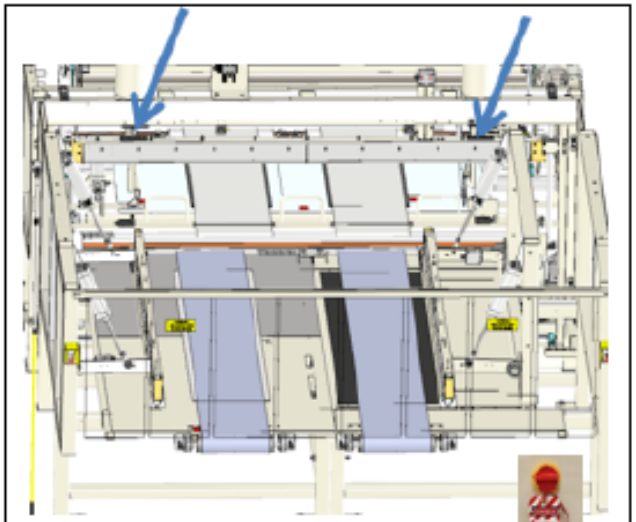
WEEK

8. Check PTFE tape on lower seal bars. Tape should be smooth w/ o tears or cracks.

VERY Important Message:

Check area of tape where the seal bar knife presses down on the PTFE tape. If the tape is cut , check the silicone rubber cushion underneath the tape for cuts or damage. If damaged it is possible to flip over the cushion and use the bottom side. If damage is too severe , switch the top cushion with the bottom one or replace with new cushion.

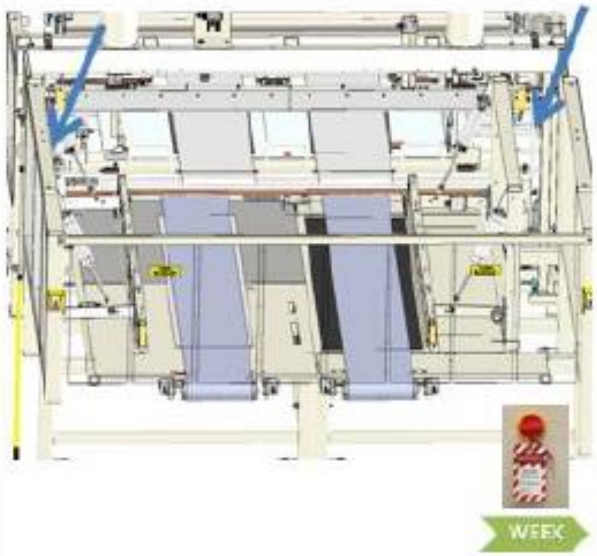
caution



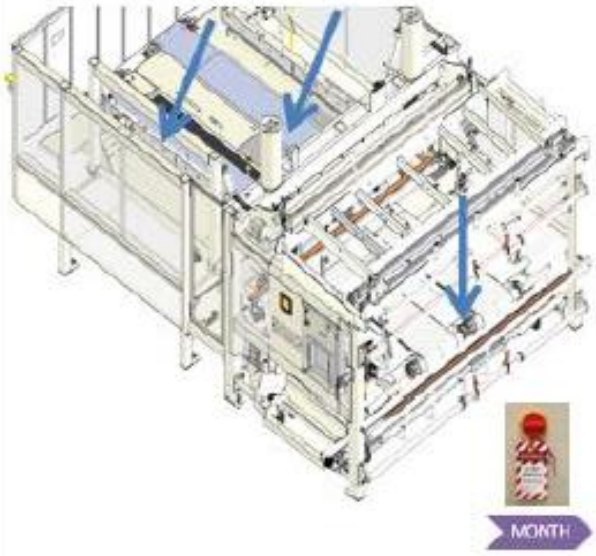
WEEK

9. Clean cross seal bar cylinders and lubricate. Do not touch cylinders shafts with bare hands.

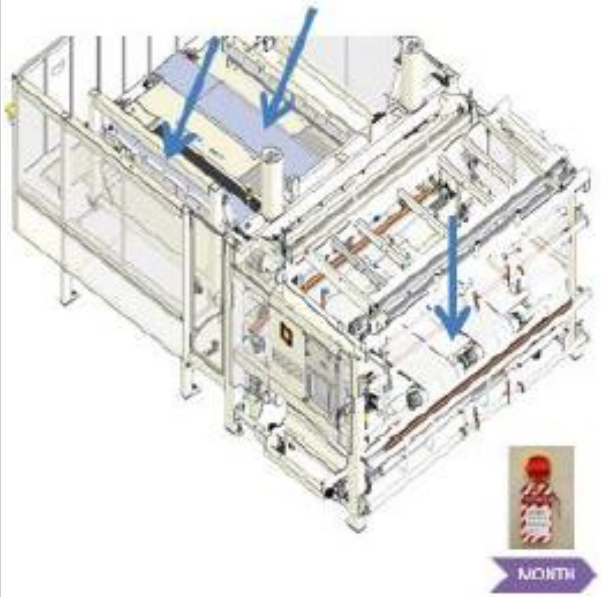
Preventative Maintenance (**Mechanic schedule**)	**1390HCE Auto Pack**	Frequency DAY WEEK MONTH



10. Clean seal bar guides and lubricate. Do not touch with bare hands.

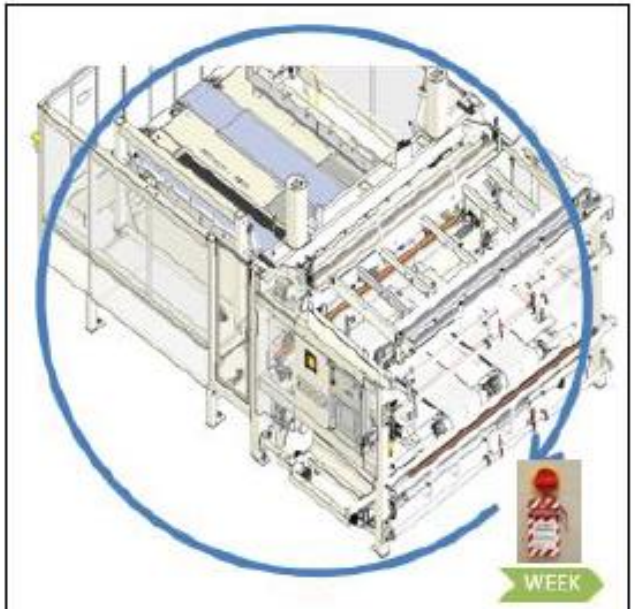


11. Check all conveyor belts for cracks , tears, rips, check seams and tension.

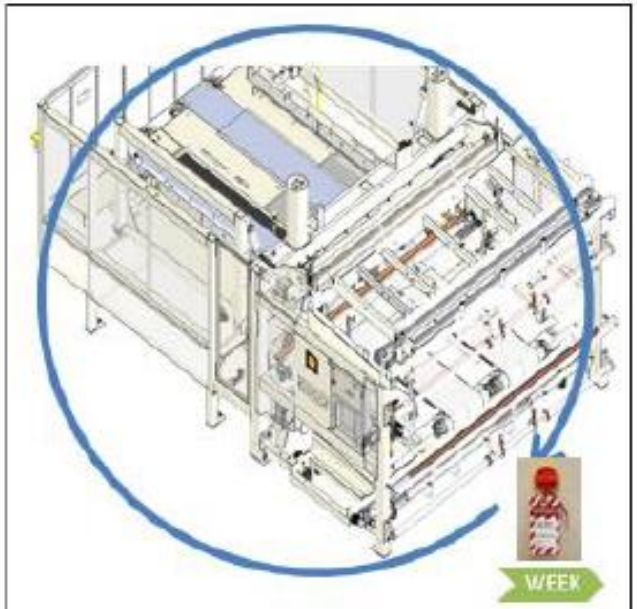


11. a. Check the alignment of the belts. Make sure all three(3) are tracking properly.

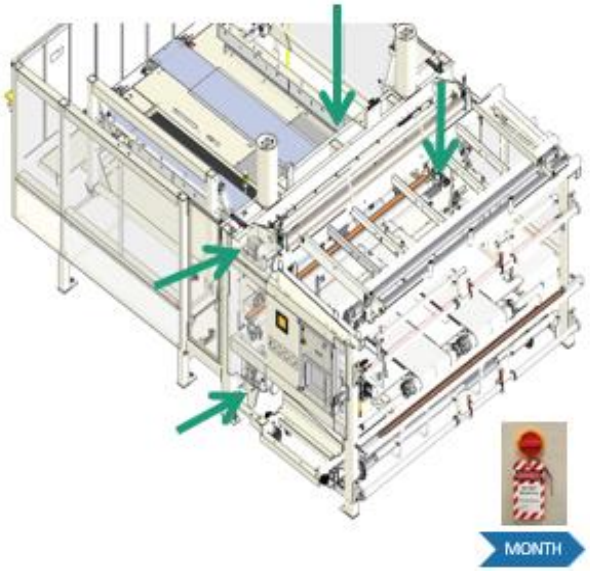
11. b. Check tension on single infeed and both outfeed belts. Adjust as needed.



12. Check all conveyor roller bearings and lubricate w/ PTFE based grease.



13. Check all other bearings and lubricate.

Preventative Maintenance (**Mechanic schedule**)	**1390HCE Auto Pack**	Frequency DAY WEEK MONTH
		
14. Check chain tension on drive motors. 3 in infeed section and 1 in the outfeed.	15. Change Hydraulic oil filter yearly or as required due to multiple shift operations.	

Additional Maintenance List or Notes:

** Warning **

Never for any reason

Enter Inside the machine
Crawl under the machine
Climb on top of the machine
Reach inside the machine
Place any body parts inside the machine

After pressing the start button, the infeed belts will run continuously and will automatically process materials or products

** Warning **

Never for any reason

Perform any machine maintenance unless the machine is properly powered down and cool.

Lockout/tagout procedures must be followed.

In manual mode, machine may be prompted to execute any of its functions. Only a properly trained operator or technician should work on or use the machine in manual mode of operation to prevent injury or machine damage.

Lockout Procedure

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

Turn off the main air lockout valve and let the airlines and the air tank bleed-off completely. Install a lockout padlock in the air lockout valve.

Turn off the main electrical switch and lock it out.
Wait until all seal bars cool off sufficiently before attempting to work near any of the seal bars.

See Page 15 for Lockout / Tagout Program and details

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

Troubleshooting

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

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

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

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

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

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

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

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

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

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

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

The Side or Cross Seal is spotty in appearance.

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

The seal is good in appearance but weak.

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

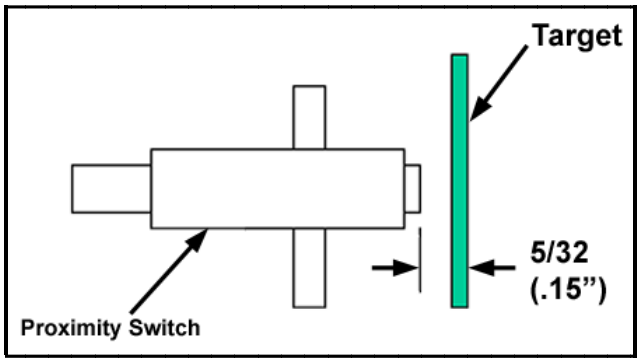
Machine continues to run even after the film (top or bottom) has run out.

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

Sensor Adjustments

Proximity Switch

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



Cross Seal Photo Detector

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

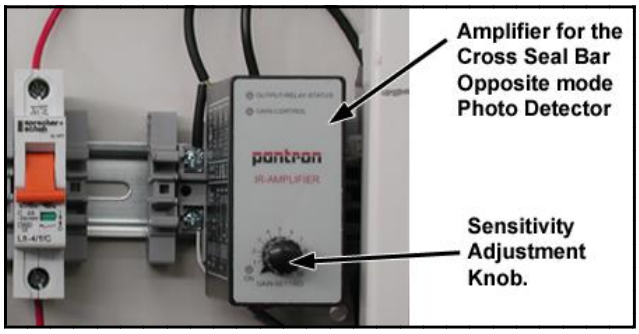
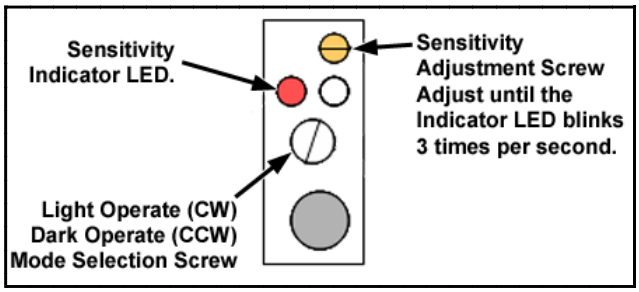


Photo Eye

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

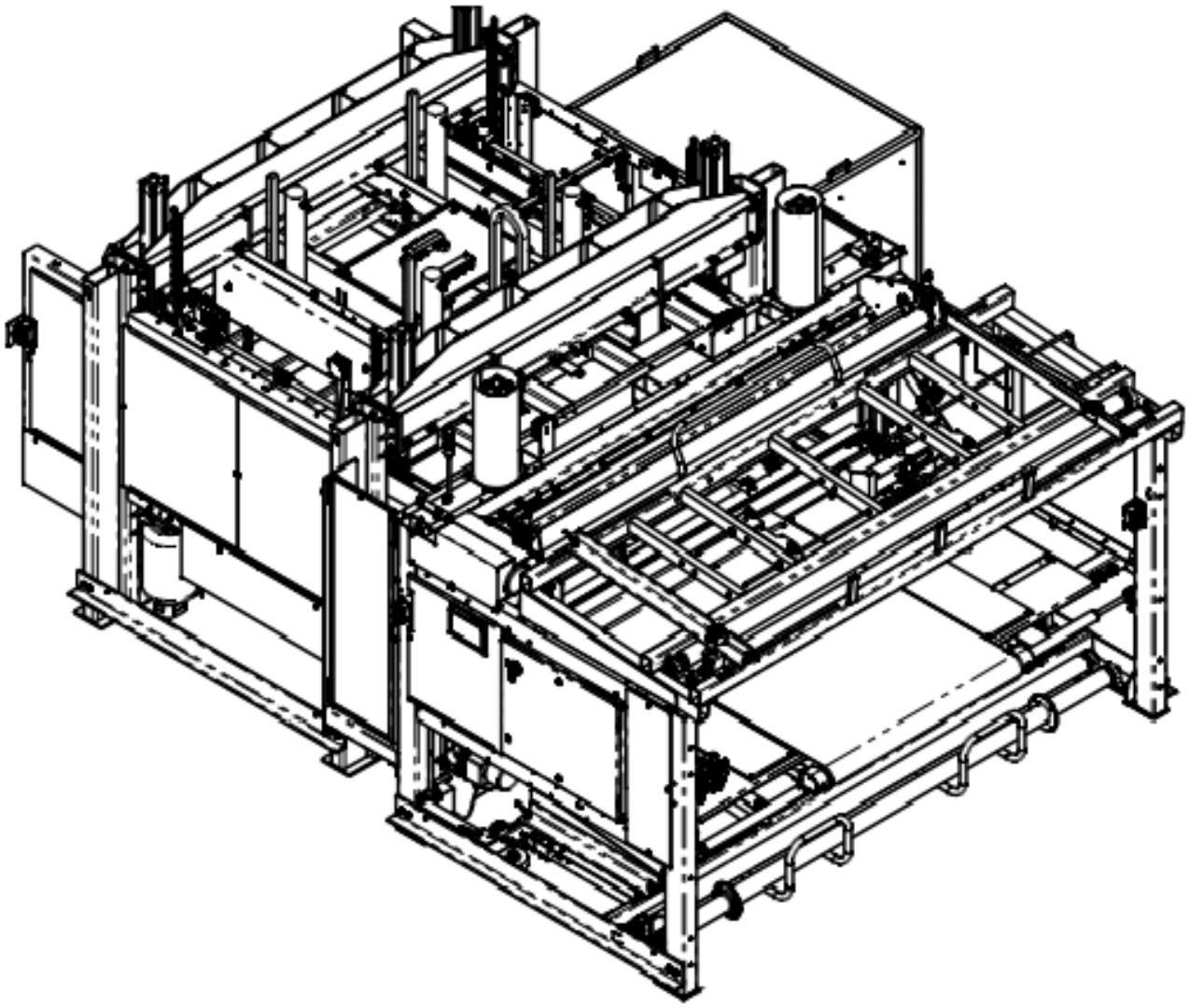


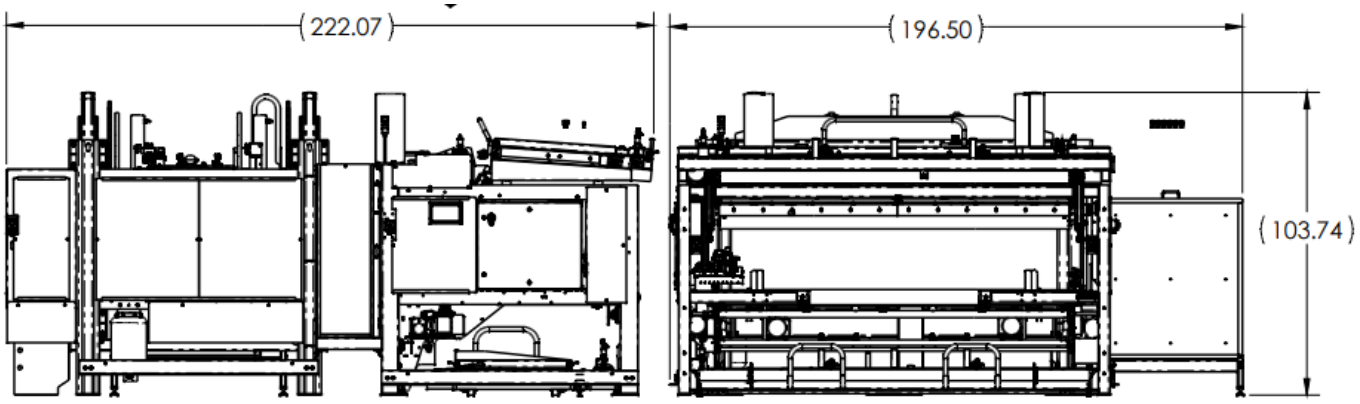
4. ASSEMBLY DRAWINGS & PARTS LISTS

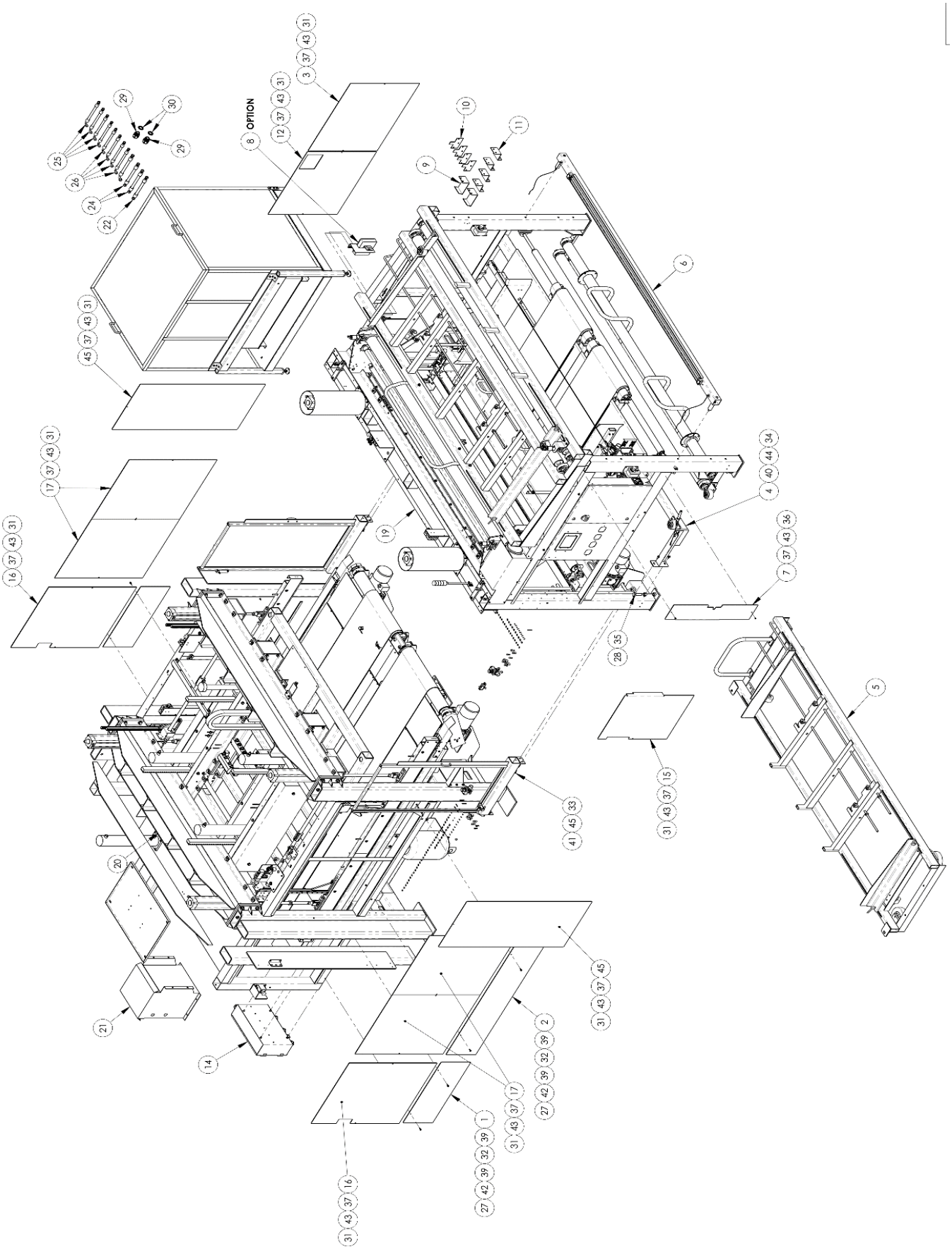
The materials contained herein are confidential and proprietary information of Atlanta Attachment Company. In addition to any confidentiality and non-disclosure obligations that currently exist between you and Atlanta Attachment Company, your use of these materials serves as an acknowledgment of the confidential and proprietary nature of these materials and your duty not to make any unauthorized use or disclosure of these materials.

11390HCE Auto Pack, Hyd Comp, Without Infeed Center Guide

AAC Drawing Number 9009011 Rev 2





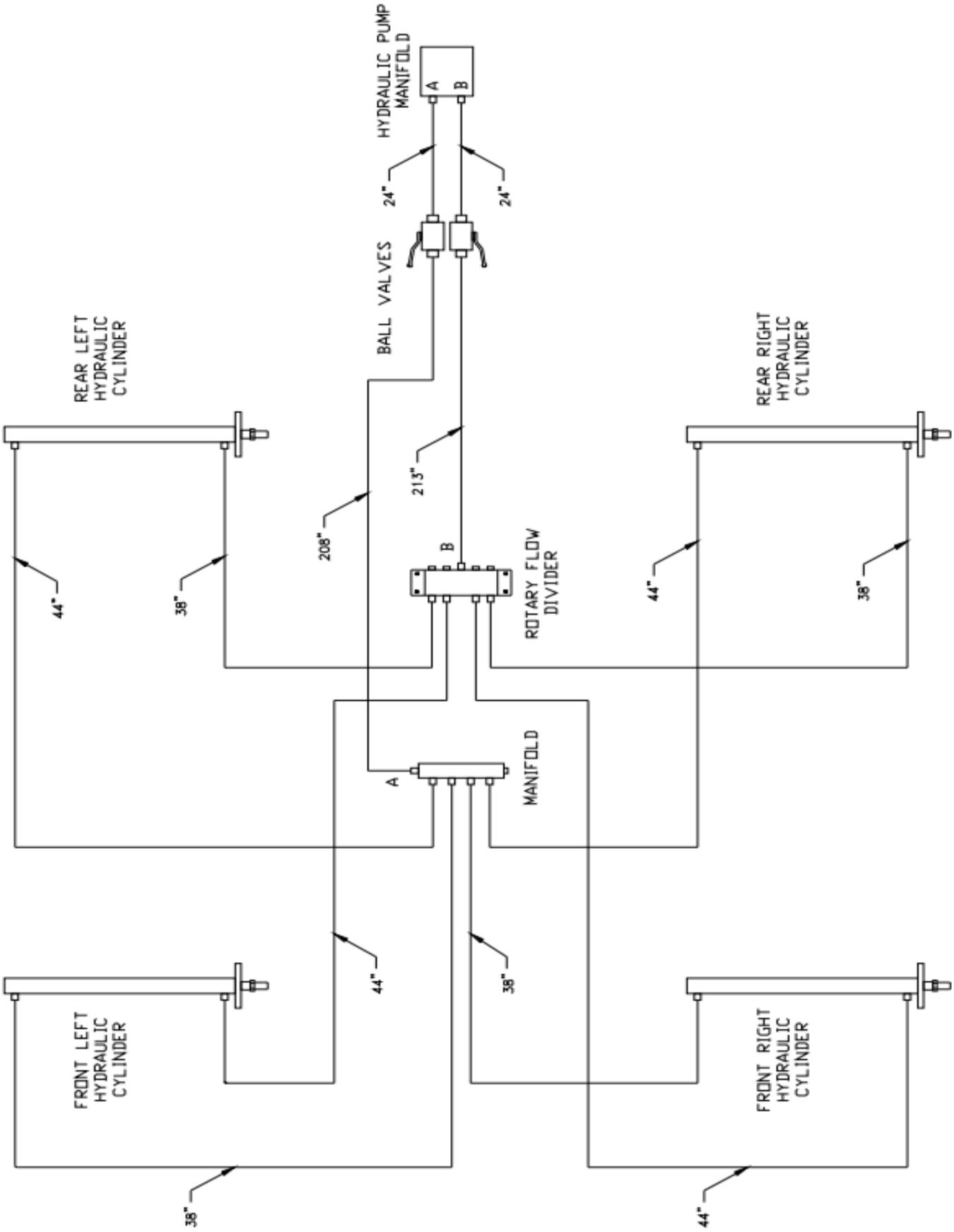

OPTION

1390HCE Parts List

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	*1	1390-LAB1	LABEL,DANGER,VOLTAGE,
2	*6	1390-LAB2	LABEL, DANGER, HOT SURFACE 1390A
3	*4	1390-LAB3	LABEL, WARNING, START AUTO KEEP AWAY,
4	*2	1390-LAB4	LABEL, IMPORTANT, YELLOW 1390A
5	*1	1390-LAB5	LABEL, FILM ROUTING
6	*2	1390-LAB7	LABEL, CAUTION, YELLOW
7	*2	1390-LAB8	LABEL, PRECAUTION, SPANISH YELLOW, 1390A
8	*4	1390-LAB13	LABELS, CAUTION, NVR CLIMB LAS
9	*2	1390-LAB14	LABELS, CAUTION, LONG LASER EN
10	*4	1390-LAB15	LABELS, MISC, BLACK W/YELL LA
11	*2	1390-LAB16	LABELS, CAUTION, BIG, BLK/YL L
12	1	1390HC-HD	HYDRAULIC DIAGRAM, 11390HCB
13	1	1390HCD-WD3	SCHEMATIC,SAFE PAUSE ESTOP
14	1	1390HCE-PD	DIAGRAM, PNEUMATIC
15	1	1390HCE-WD1	WIRING DIAGRAM,CONTROL BOX,POWER
16	1	1390HCE-WD2	WIRING DIAGRAM, SBUS
17	1	1390HCE-WD4	1390HCE/1306FF SAFETY WIRING
18	2	1060008	PLATE,NUT,8-32X.50
19	1	1386772	SIDE SEAL GUARD, LONG
20	1	1390003	SIDEPANEL #3, LEXAN
21	1	1390457	MOUNT,LOWER CASTER
22	1	1390500	ROLL HOLDER FRAME, LOWER
23	2	1391923	ANGLE,SHIPPING
24	2	1394000	SHIPPING BRACKET 1
25	4	1394284	SHIPPING BRACKET 2
26	4	1394285	SHIPPING BRACKET 3
27	1	1406240	HYDRAULIC PUMP ASSY
28	4	1406657	SIDE SEAL GUARD, LH & RH
29	1	13061105	VALVE ASSY, DUAL 4-WAY MANUAL
30	1	13901074	GUARD, LEFT FRONT-INFEED
31	1	13901100	INPUT CONVEYOR
32	2	13901188	GUARD,DOOR PANEL,LH & RH
33	2	13901189	SIDE PANEL, REAR RIGHT
34	1	13901200	EXIT ASSY W/ HYD COMP
35	2	13901202	ANGLE,SHIPPING
36	1	13901331	PC HMI MOUNT ASSEMBLY KIT
37	1	13901332	GUARD, LEXAN-INFEED LH
38	1	13901379	RH SIDEPANEL PC HMI, LEXAN
39	2	14061302	SIDE SEAL GUARD, SHORT
40	1	14061303	SIDE SEAL GUARD, LONG
41	6	AAQPR-2-3	QUICK PLUG REDUCER
42	6	AAQUY-2-2	QUICK UNION Y,1/2X1/2
43	1	EEJBC375CG	GATEWAY PC, PWR CABLE
44	1	EENMK015KD	TRANSFORMER,480-240
45	4	HH3028080838	HYD HOSE, 38", 8X8X1/2
46	4	HH3028080844	HYD HOSE, 44", 8X8X1/2
47	2	HH30210101024	HYD HOSE, 24", 10X10X5/8
48	1	HH302101010208	HYD HOSE, 208", 10X10X5/8
49	1	HH302101010213	HYD HOSE, 213", 10X10X5/8
50	*1	LIGHT TOWER	LABEL, LIGHT TOWER
51	*3	MMSG1305	TAPE, TEX PTFE, 3.4W X 54'L, 6 MIL
52	8	NNH7/8-9	7/8-9 HEX NUT
53	1	RB8467	LOCKNUT,NYLON,1"NPT
54	1	RBM4524	STRAIN RELIEF,1-1/4 NPT, .87-.1.26, BLK
55	1	RBM8439	STRAIN RELIEF,1"NPT
56	1	RBM9144	LOCKNUT,NYLON,1-1/4"NPT
57	32	SSBC98048	10-32 X 3/4 BUTTON CAP SC
58	24	SSHC25064	3/8-16 X 1,HEX CAP
59	8	SSHC49192	7/8-9 X 3 HEX CAP
60	4	SSSC90040	8-32 X 5/8 SOC CAP SC
61	4	WWF8	WASHER, FLAT, #8
62	32	WWF10	WASHER, FLAT, #10, COM
63	24	WWFS3/8	WASHER,FLAT,SAE,3/8
64	24	WWL3/8	WASHER,LOCK, 3/8
65	4	WWL8	WASHER,LOCK,#8
66	33	WWL10	WASHER,LOCK,#10

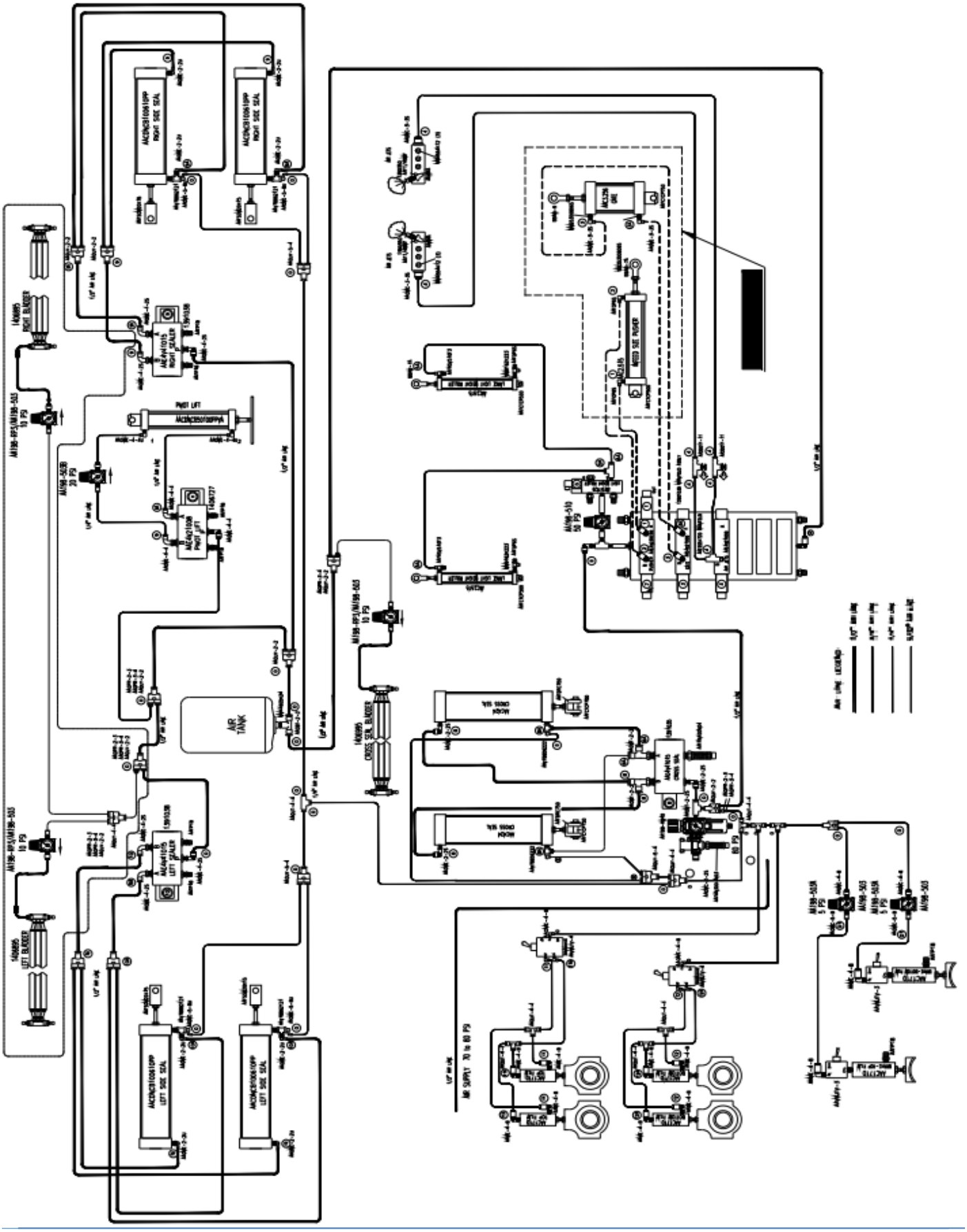
1390HC-HD Hydraulic Diagram

AAC Drawing Number 125990C Rev 0



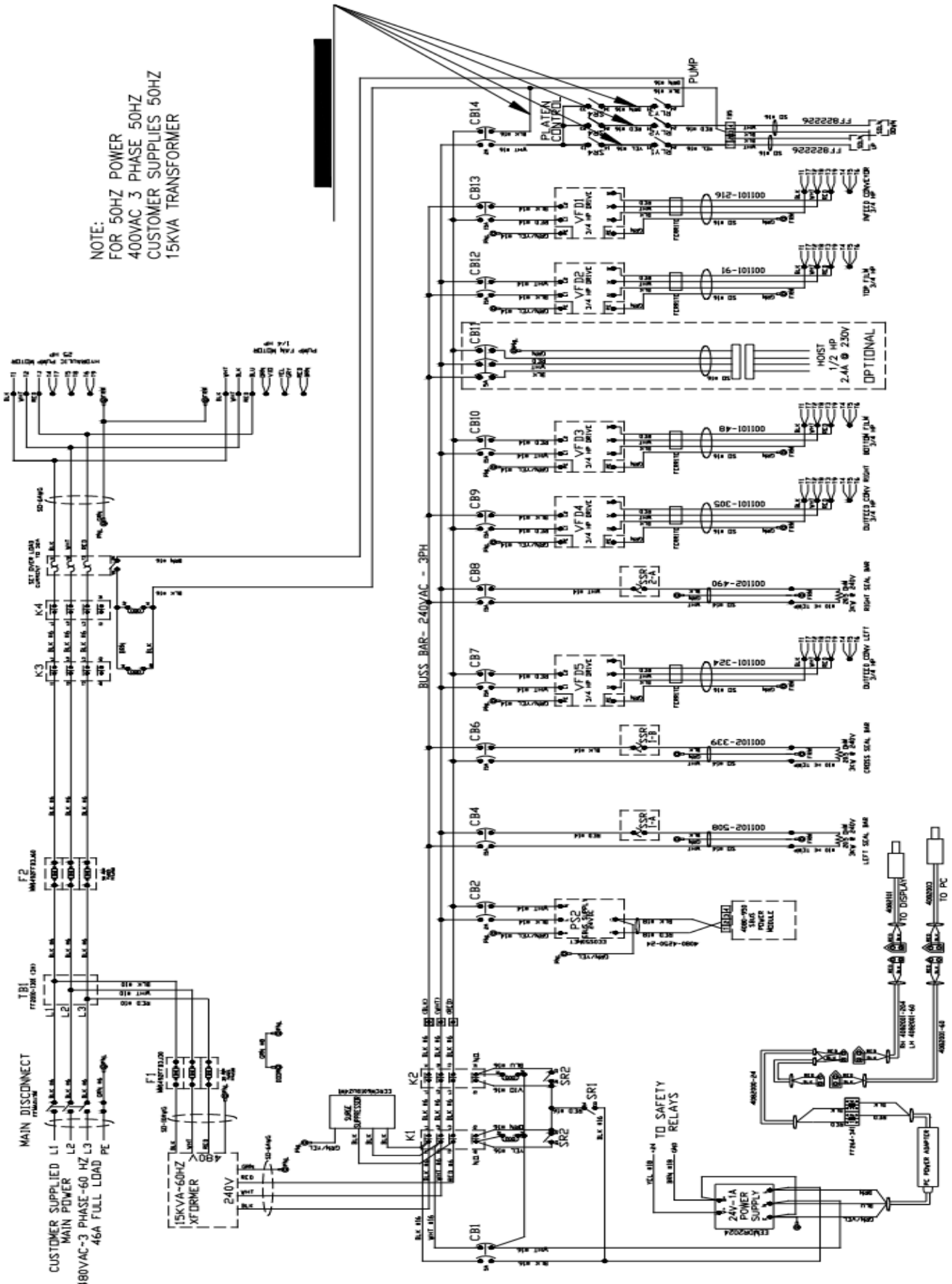
1390HCE-PD Pneumatic Diagram

AAC Drawing Number 125788D Rev 0



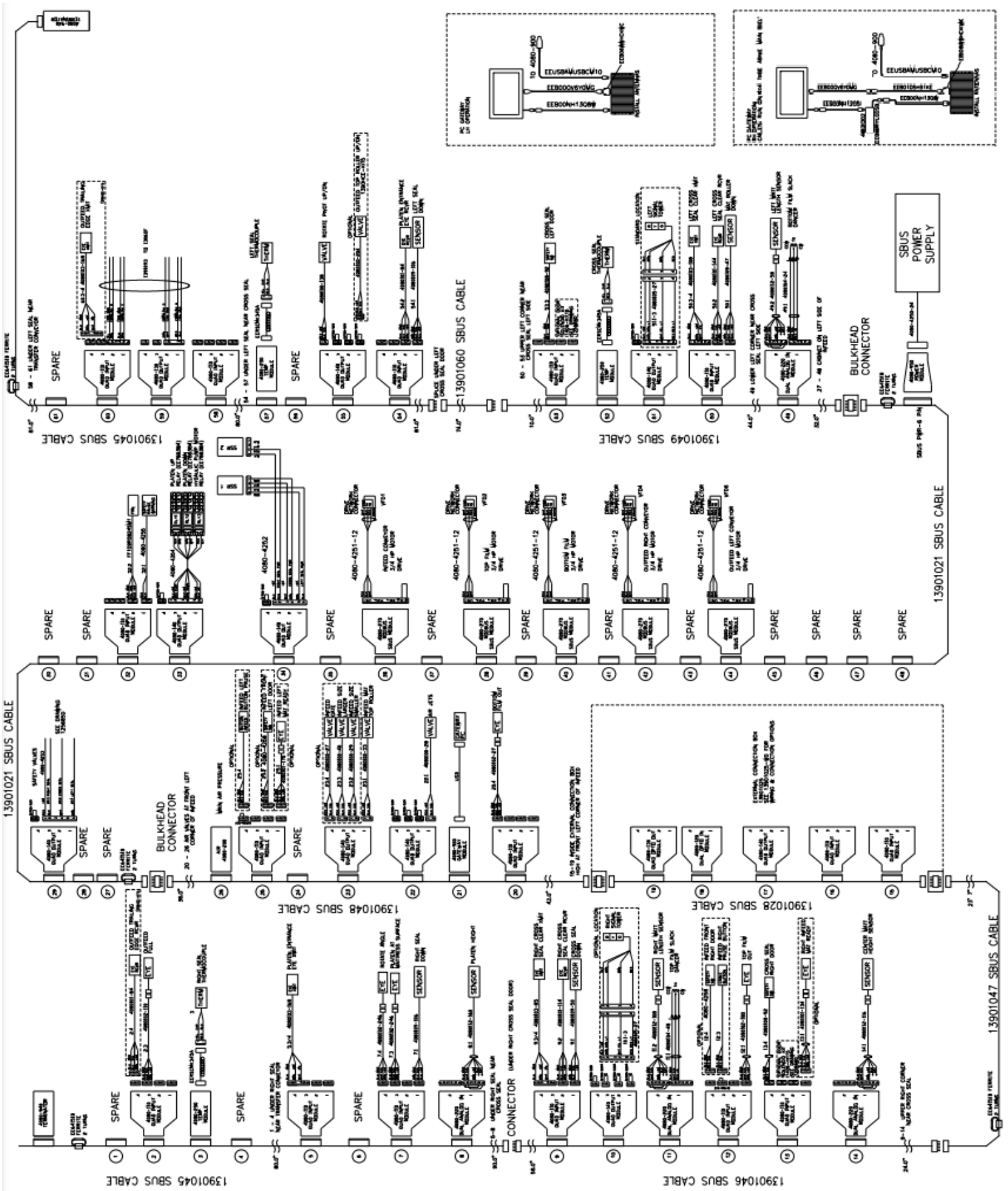
1390HCE-WD1 Wiring Diagram, Power Control Box

AAC Drawing Number 125953D Rev 0



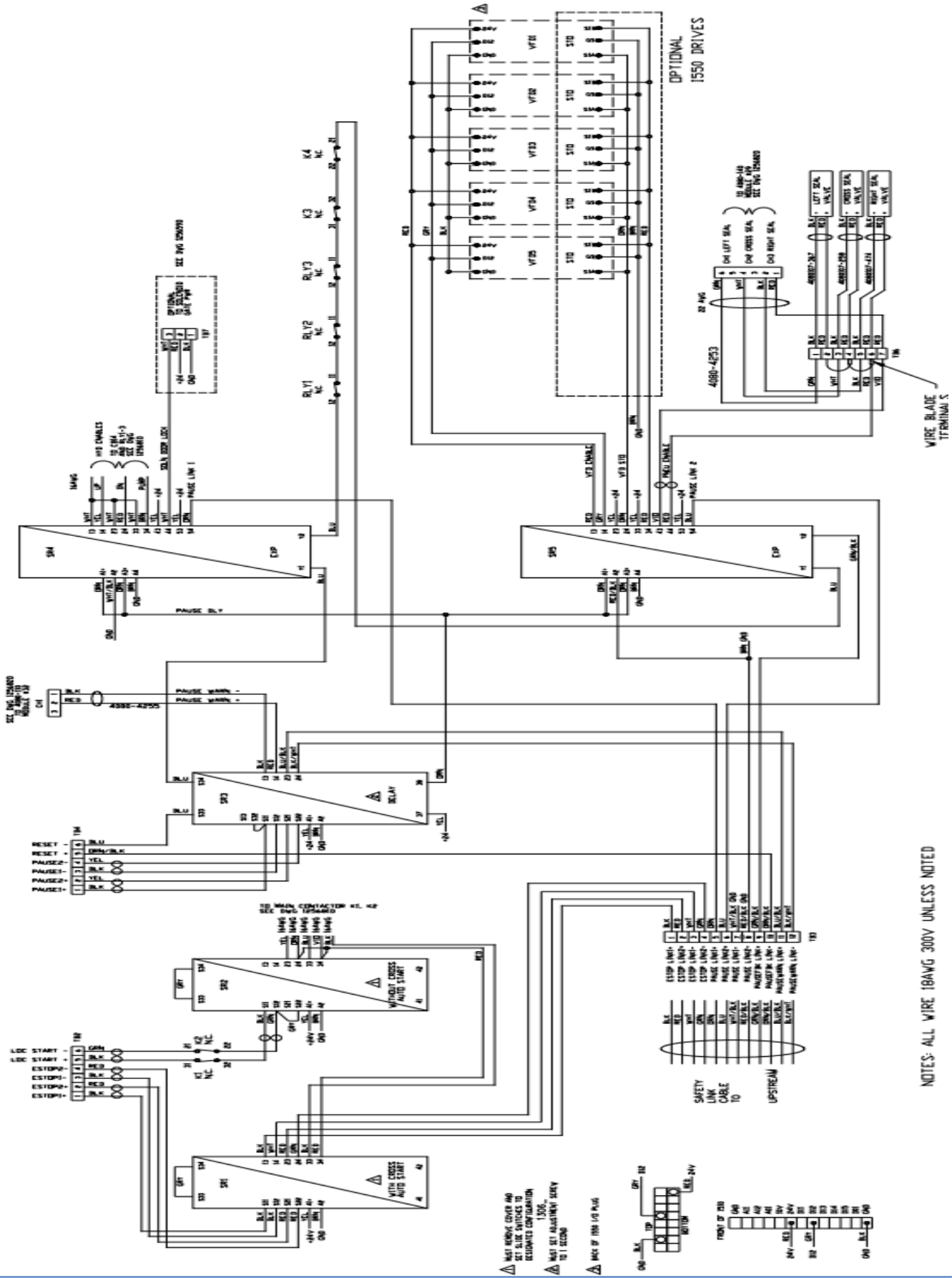
1390HCE-WD2 Wiring Diagram, Serial Bus

AAC Drawing Number 125787D Rev3



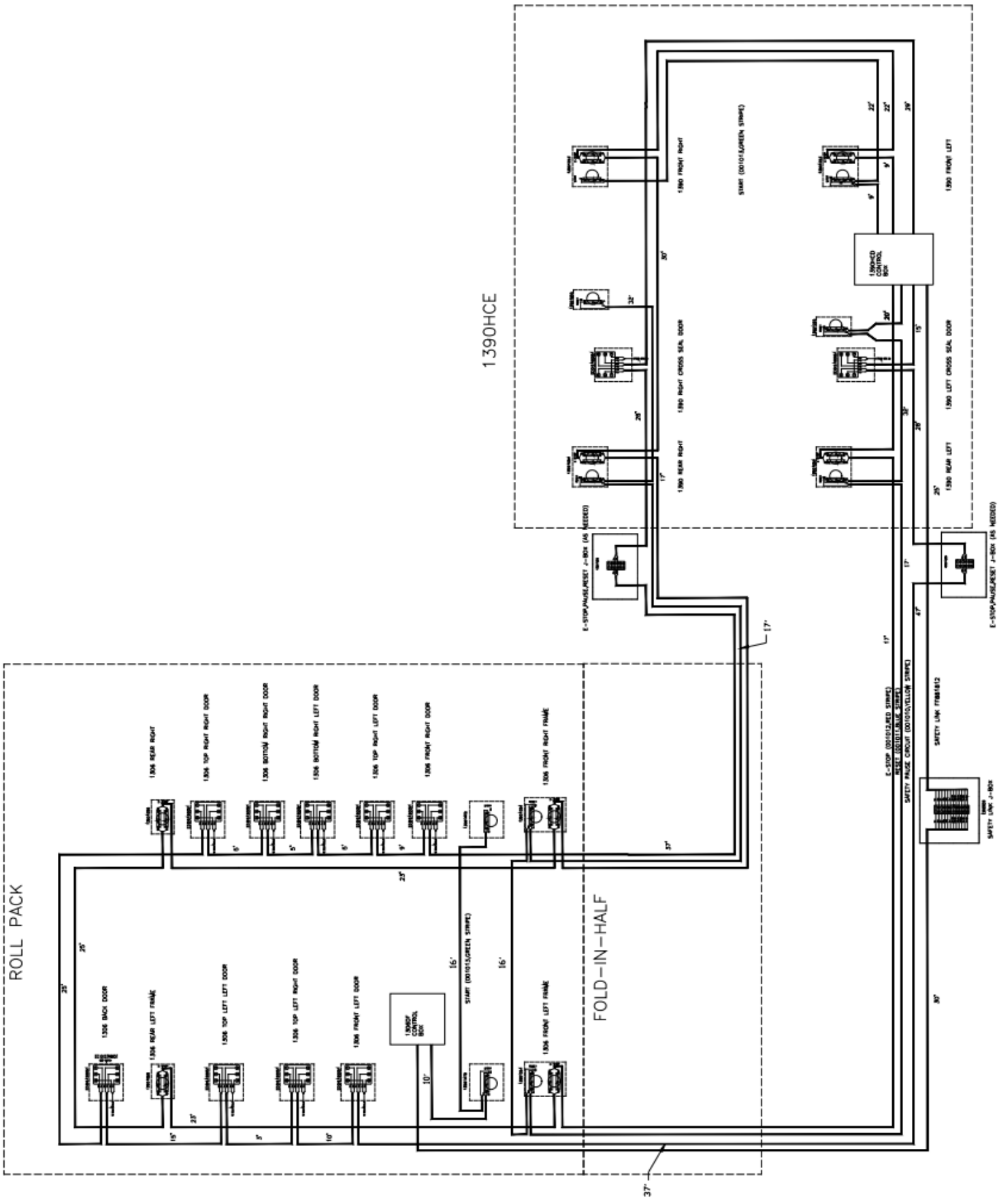
1390HCD-WD3 Wiring Schematic, Safe Pause & E-Stop

AAC Drawing Number 125685D Rev 0 E-Stop



1390HCE-WD4 Safety Wiring Circuit, 1390HCE & 1306FF

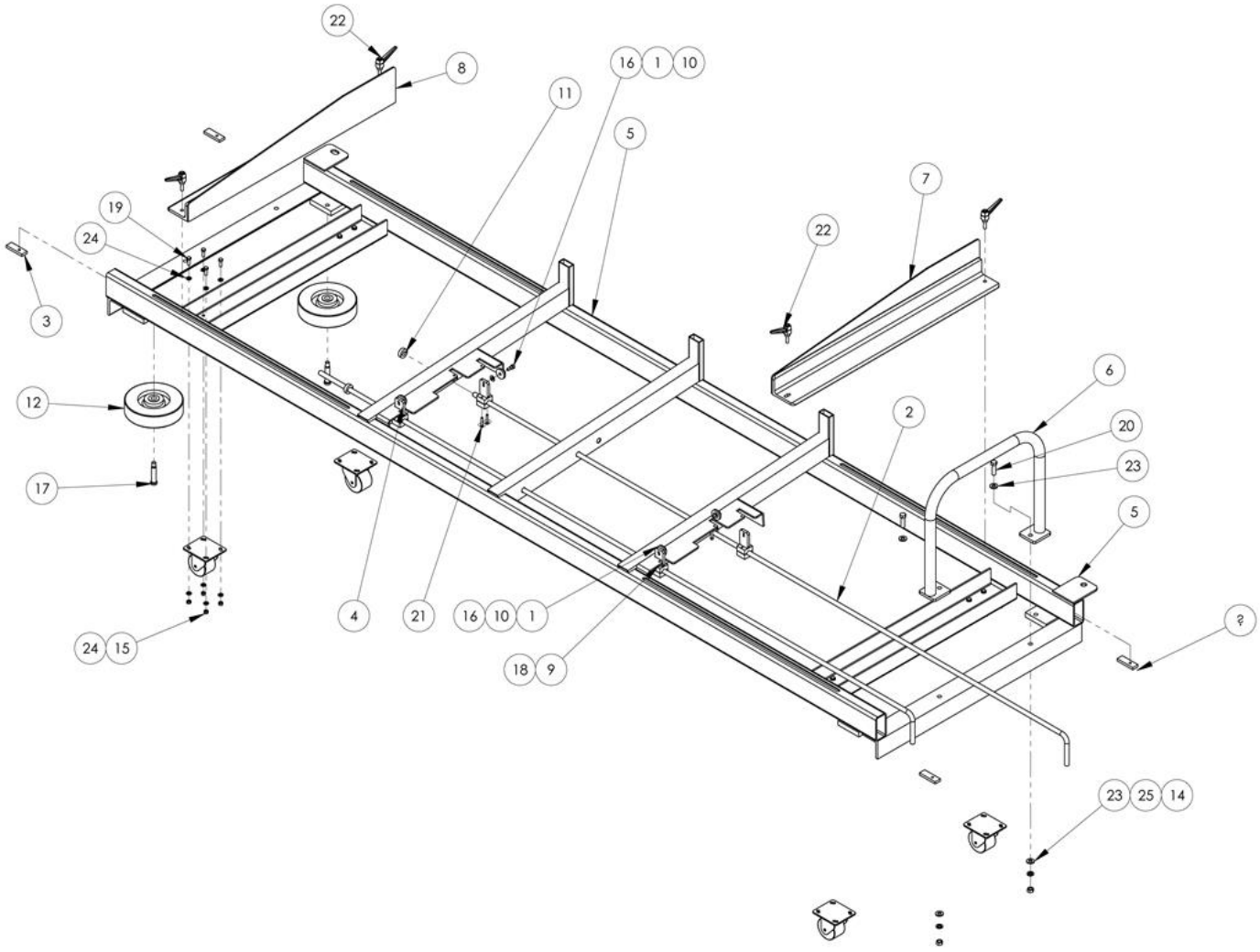
AAC Drawing Number 125882D Rev 2



1390500 Lower Roll Holder Frame

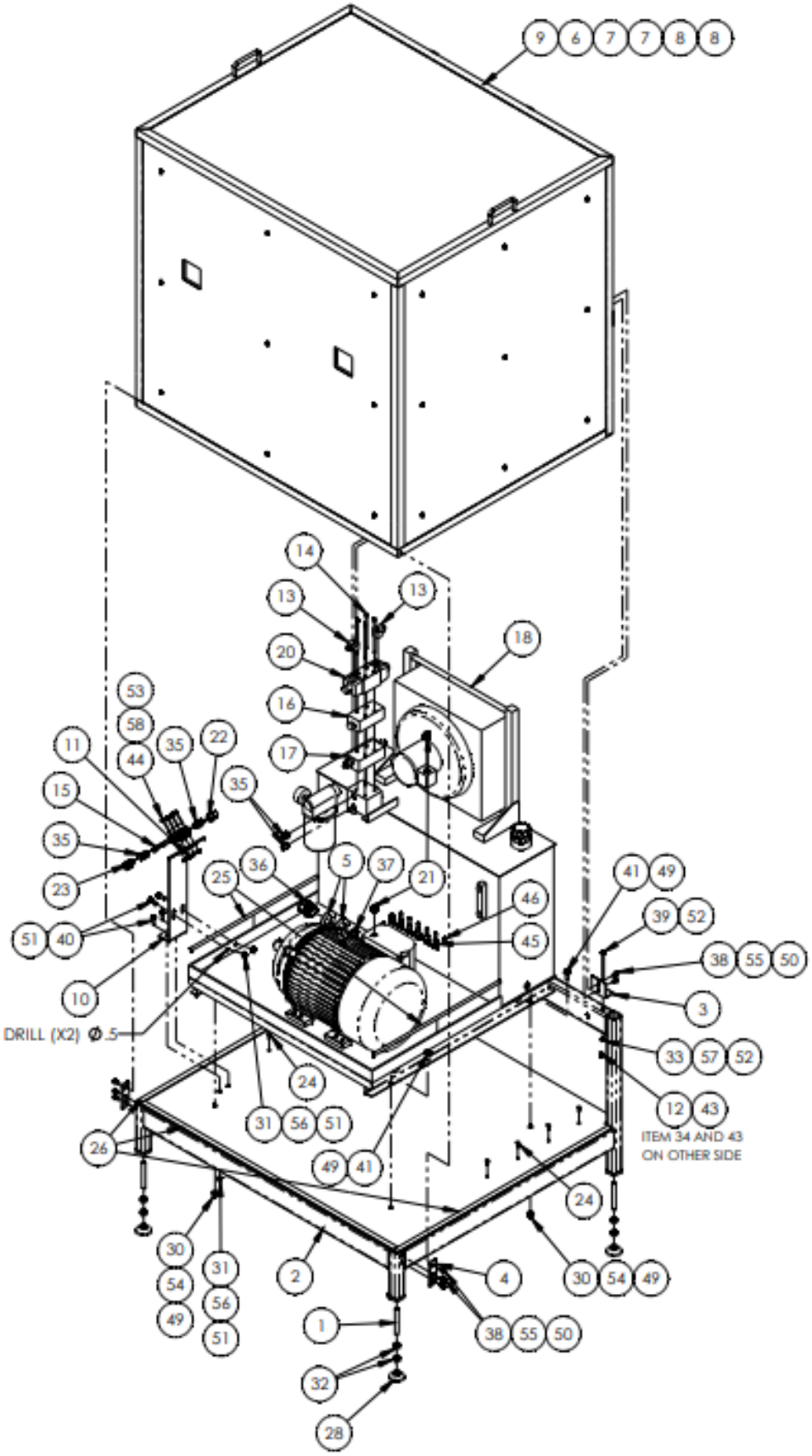
AAC Drawing Number 1390500 Rev 5

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	4	1390198	ROLL RELEASE DISK	14	2	NNH1/2-13	NUT,HEX,1/2-13
2	2	1390458	ROD, ROLL STOP	15	16	NNK5/16-18	KEP NUT, 5/16-18
3	4	1390459	NUT PLATE-SIDE ROLLER ADJ	16	4	SSAS024024	SHOULDER BOLT 3/8 X 3/8L
4	4	1390463	ROLL STOP, WELD'T	17	2	SSAS048160	SHOULDER BOLT 3/8 X 2.5L
5	1	1390508	FRAME WELDT- BOTTOM ROLLS	18	4	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
6	1	1390559	HANDLE ASSEMBLY	19	16	SSHC10064	5/16-18 X 1 HHCS
7	1	1390565	RIGHT IDLER ROLLER, ROLL	20	2	SSHC45112	1/2-13 X 1-3/4 HHCS, G8
8	1	1390566	LEFT IDLER ROLLER, ROLL	21	8	SSSC05080	SREW,SOCKET CAP 1/4-28X1-1/4
9	4	BB1L038	BEARING,BALL,.375B	22	4	TTH32430	HANDLE,THRD,3/8-16X1-1/4
10	4	BBTRA613	WASHER,THRUST,STL, .375B	23	4	WWFS1/2	WASHER,FLAT,SAE,1/2
11	2	CCCL10F	CLAMP COLLAR- 5/8 ID	24	32	WWFS5/16	WASHER,FLAT,SAE,5/16
12	2	MM082008	CASTER,PPP,1200LBS/WHEEL	25	2	WWL1/2	1/2 LOCK WASHER
13	4	MM16CA03201-S	CASTER,SWIVEL, 3.25" STEEL				



1406240 Hydraulic Pump Assembly

AAC Drawing Number 1406240 Rev 0

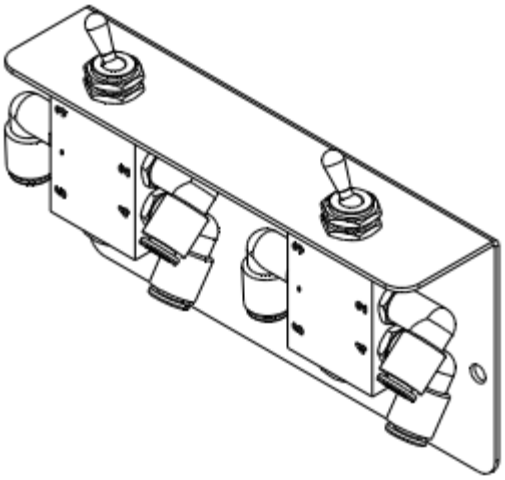


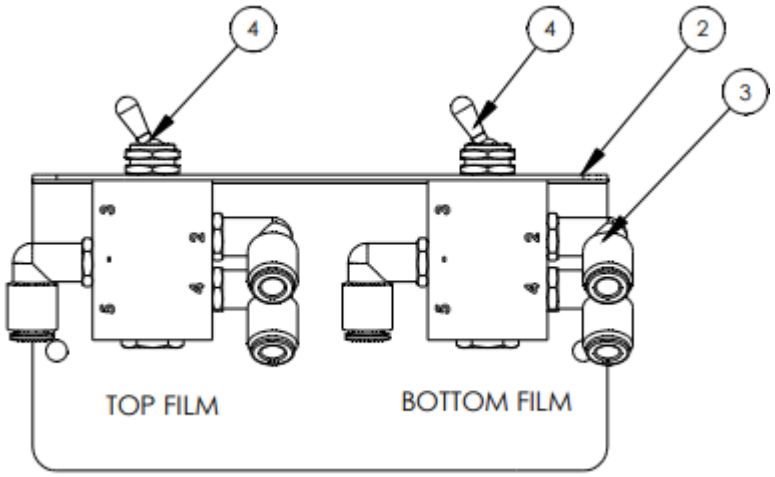
1406240 Parts List

Item #	Qty	Part Number	Description	Item #	Qty	Part Number	Description
1406240							
1	4	0411-1063	ROD, FULL THREAD, 5/8-11 X 5"	29	37	NNE10-32	NUT, ELASTIC LOCK, 10-32
2	1	1406250	FRAME, PUMP, HYDRAULIC	30	4	NNH1/2-13	NUT, HEX, 1/2-13
3	2	1406275	GUARD MOUNT ANGLE	31	4	NNH3/8-16	NUT, HEX, 3/8-16
4	2	1406276	GUARD MOUNT BRACKET	32	2	NNH5/16-18	NUT, HEX, 5/16-18
5	2	1406293	STRAIN RELIEF WASHER	33	8	NNH5/8-11	NUT, HEX, 5/8-11
6	1	1406824	SOUNDPROOFING PANEL, FRONT	34	1	PPP2220	CLAMP, CABLE, 1"OD, SST, EPDM
7	2	1406825	SOUNDPROOFING PANEL, SIDE	35	6	PPP64001008	FITTING, HYDRAULIC, STRT 7/8-1
8	2	1406826	SOUNDPROOFING PANEL, REAR	36	1	RBM4524	STRAIN RELIEF,LIQ TIGHT,1-1/4
9	1	1406835	GUARD, PUMP, HYDRAULIC	37	1	RBM9144	NYLON LOCKNUT, 1-1/4NPT
10	1	14061326	MTG BRKT, HOSE, BALL VALVE, 14	38	10	SSHC05048	SCREW, HEX CAP 1/4-28X3/4
11	2	14061327	NUT PLATE, 10-32, 37.5MM CTC,	39	2	SSHC10320	SCREW, HEX CAP 5/16-18X5
12	1	AAF3/16	CLAMP, BLACK PLASTIC 3/16 DIA.	40	4	SSHC25080	SCREW, HEX CAP, GRADE 8 3/8-16
13	2	FFSC18-0	SOLENOID CONNECTOR,18MM DIN,23	41	4	SSHC45080	SCREW, HEX CAP 1/2-13X1-1/4
14	1	HYBD05-625	BOLT KIT, HYD, VALVE STACK, 6.	42	37	SSPS98048	SCREW, PAN HD SLOTTED 10-32X3/
15	2	HYBV450249	BALL VALVE,HYD,7250 PSI,3/4-16	43	2	SSSC98032	SCREW, SOCKET CAP 10-32X1/2
16	1	HYC05MSV	CHECK VALVE, HYD, DUAL PILOTED	44	4	SSSC98128	SCREW, SOCKET CAP 10-32X2
17	1	HYF05MSV	FLOW CONTROL, HYD, DUAL PORT,	45	6	TT30454	CONNECTOR, WIRE, EX LARGE MIN
18	1	HYMG18	HYD PUMP, 18G/M, 25HP, 45 GAL	46	6	TTMB70473	WIRE CONNECTOR-SMALL ORANGE
19	10	HYOT32	OIL, HYDRAULIC, QUANTUM 32, 5	47	37	WWFE012	WASHER, FENDER, 3/16
20	1	HYVSD05-220V	SOLENOID VALVE, HYD BI DIR, OP	48	37	WWFE032	WASHER, FENDER, 1/2
21	2	K-235	ROMEX CONNECTOR, 3/8"	49	8	WWFS1/2	WASHER, FLAT, SAE, 1/2
22	2	MM1277K29	PLASTIC CAP, 7/8-14	50	10	WWFS1/4	WASHER, FLAT, SAE, 1/4
23	2	MM1277K41	PLASTIC PLUG, 7/8-14	51	8	WWFS3/8	WASHER, FLAT, SAE, 3/8
24	5	MM1629134	ADHESIVE, LOCTITE, SPRAY, PROF	52	4	WWFS5/16	WASHER, FLAT, SAE, 5/16 .70 OD
25	8	MM4267	CABLE TIE MOUNT, TUBING, PUSH-	53	41	WWFS10	WASHER, FLAT, SAE, 10
26	4	MM8507K22	EDGE TRIM, PUSH ON 1/4" OPENIN	54	4	WWL1/2	WASHER, LOCK, 1/2
27	156	MM93745K55	FOAM, FIRM, BUNA-N, 1/8X1 ADHE	55	10	WWL1/4	WASHER, LOCK, 1/4
28	4	MML-2	LEVELING FOOT, 5/8-11 SOCKET,	56	4	WWL3/8	WASHER, LOCK, 3/8
29	37	NNE10-32	NUT, ELASTIC LOCK, 10-32	57	2	WWL5/16	WASHER, LOCK, 5/16
30	4	NNH1/2-13	NUT, HEX, 1/2-13	58	4	WWL10	WASHER, LOCK, 10

13061105 Valve Assembly

AAC Drawing Number 13061105 Rev 1



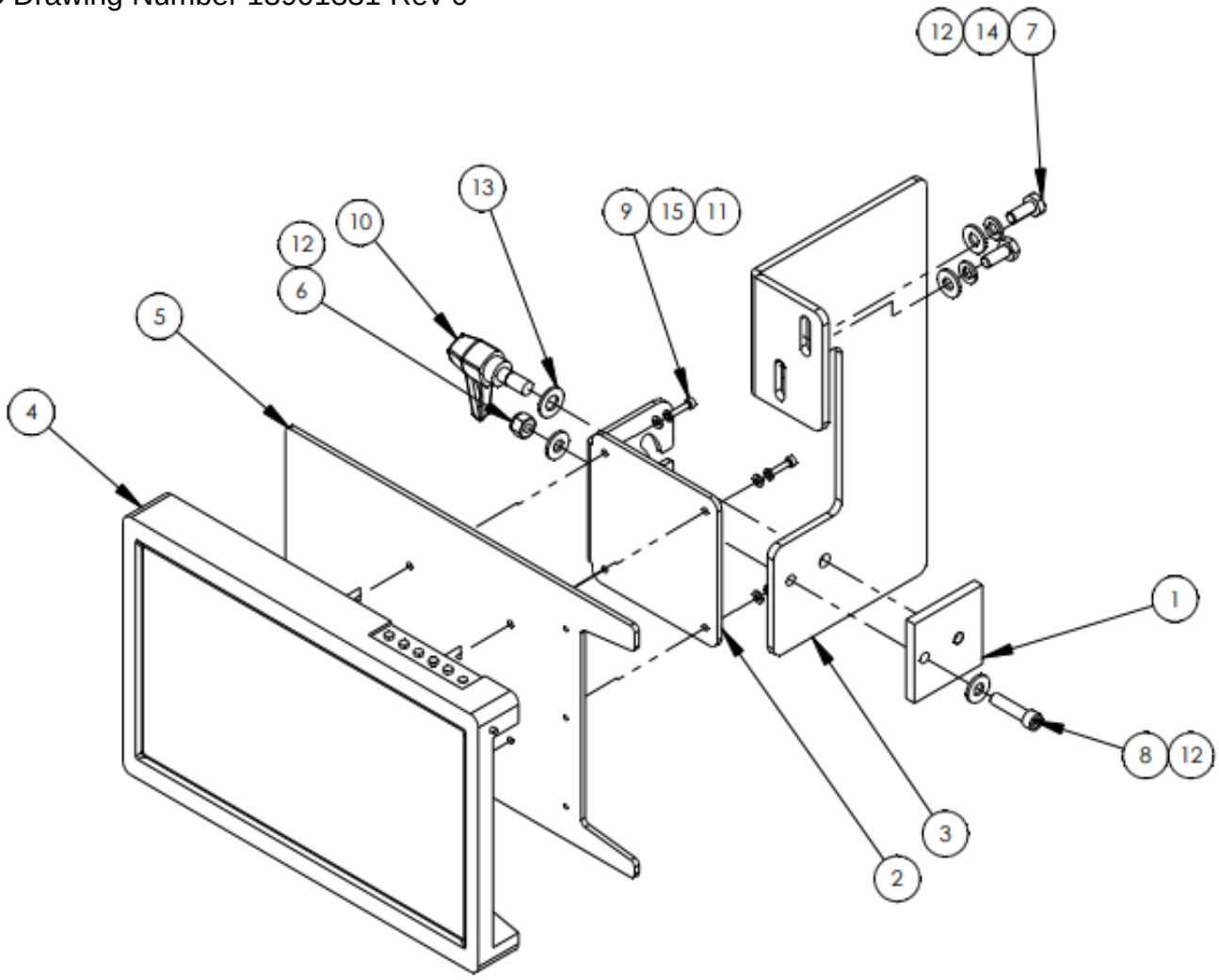


ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	*1	1390HCD-LAB1	LABEL, VALVE ASSY, DUAL 4-WAY
2	1	13061106	MOUNT, DUAL MAN. TOGGL VALVE
3	6	AAQME-4-8	QUICK MALE ELBOW, 1/4T
4	2	AAVMJTV-4	VALVE TOGGLE 4W, 1/8NPT

" * " ITEM(S) NOT SHOWN

13901331 PC HMI Mount Assembly

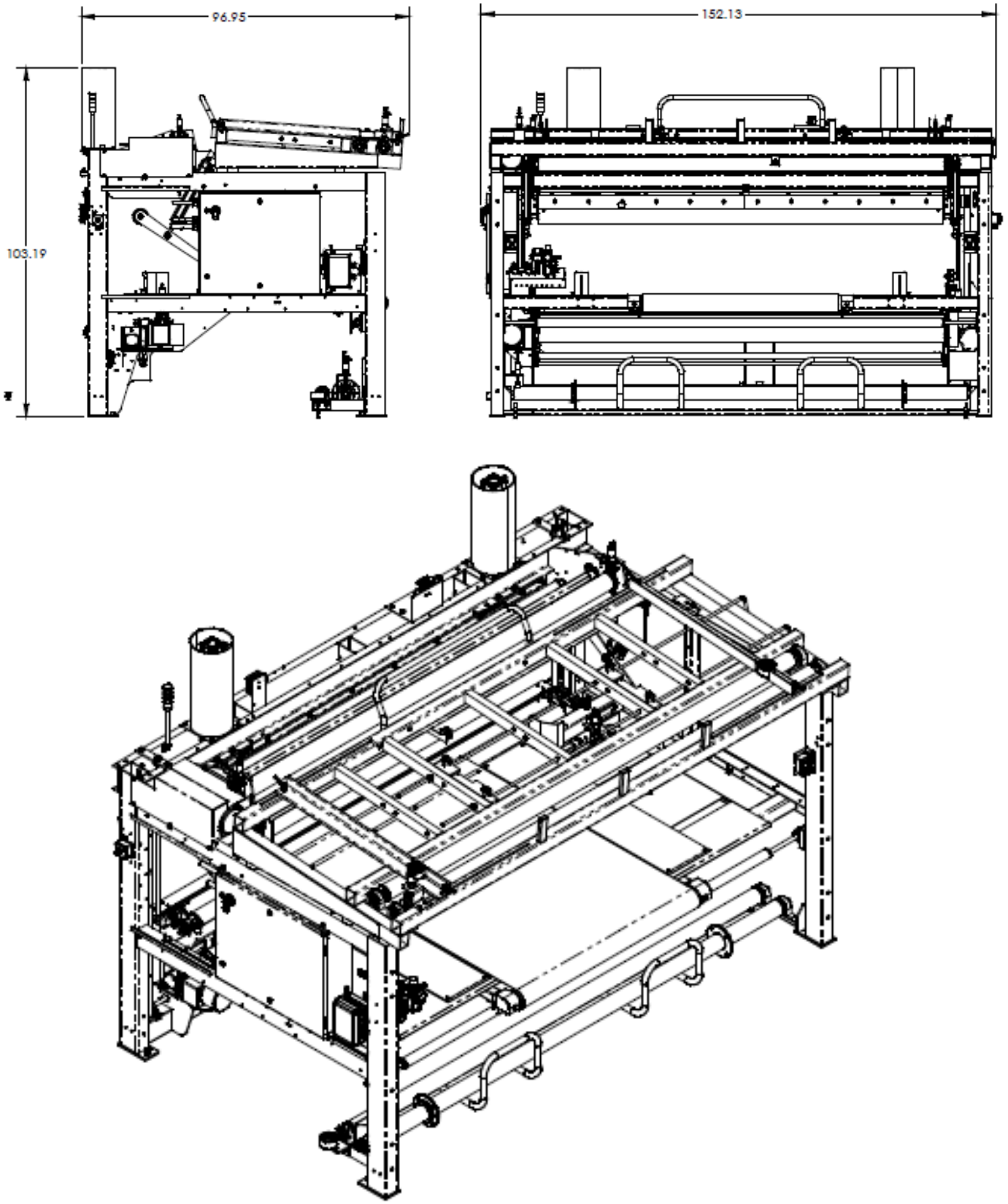
AAC Drawing Number 13901331 Rev 0

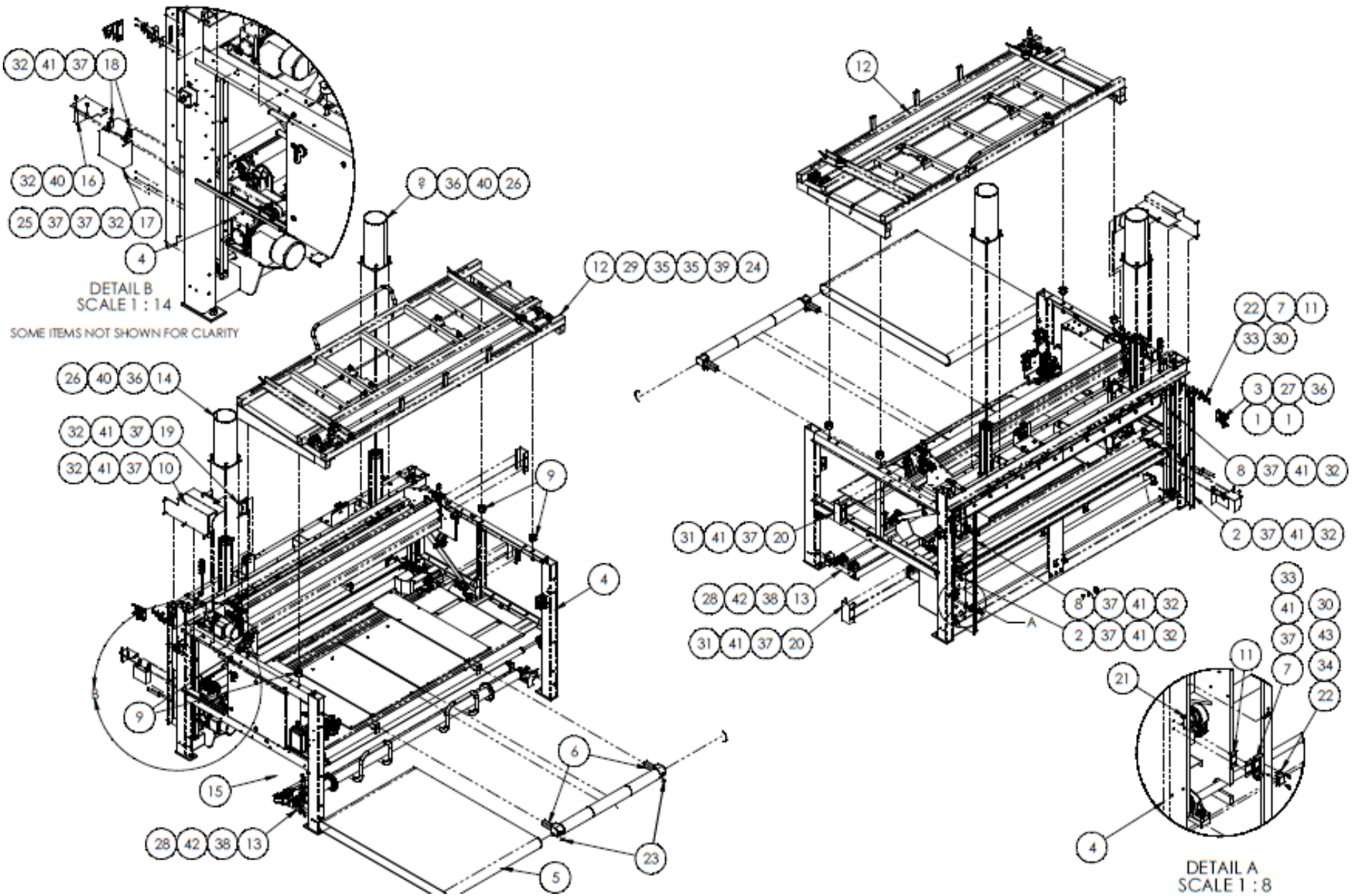


ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	0411-3708	NUT PLATE,BOX MOUNT
2	1	13901328	MOUNT, HMI, PC DISPLAY
3	1	13901329	MOUNT, TOUCH SCREEN
4	1	4082105	TOUCHSCREEN, 10",SUB ASSEMBLY
5	1	4082105B	HMI BACKING PLATE, EEE10TSM
6	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
7	2	SSHC01040	1/4-20 X 5/8 HHCS
8	1	SSSC01064	1/4-20 X 1 SOC CAP
9	4	SSSCM3X16	M3-0.5X16 ,SOCKET CAP
10	1	TTH32425	HANDLE,THRDED,5/16-18X3/4
11	4	WWFM3	FLAT WASHER, M3
12	4	WWFS1/4	WASHER,FLAT,SAE,1/4
13	1	WWFS5/16	WASHER,FLAT,SAE,5/16
14	2	WWL1/4	WASHER,LOCK, 1/4
15	4	WWLM3	WASHER, LOCK, M3

13901100 Input Conveyor

AAC Drawing Number 13901100 Rev 1




DETAIL B
SCALE 1 : 14
SOME ITEMS NOT SHOWN FOR CLARITY
DETAIL A
SCALE 1 : 8

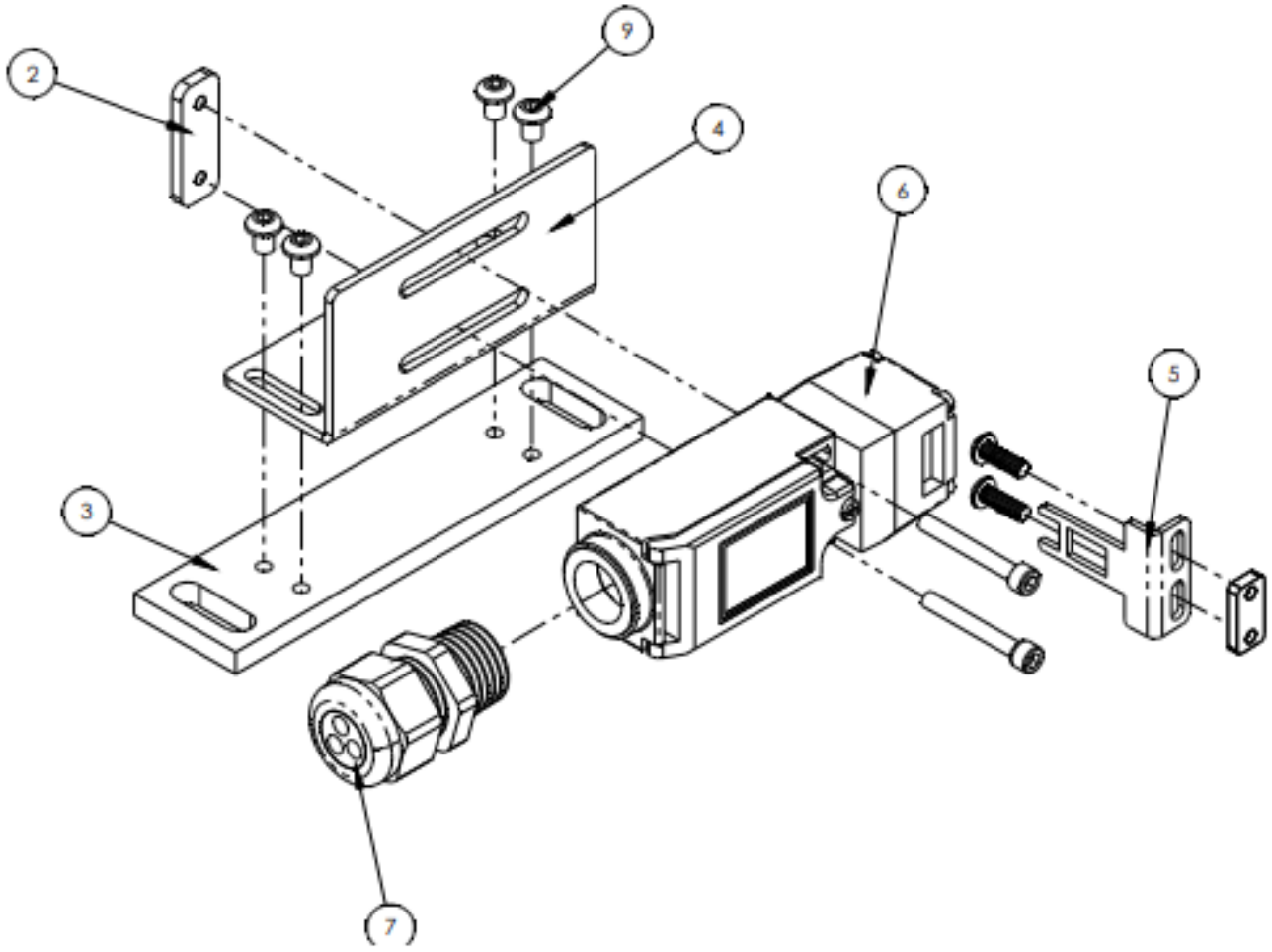
13901100 Parts List

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	4	1318377	SAFETY SWITCH MOUNT
2	2	1390067	GUARD, CHAIN, SEAL-BAR, R
3	2	13901091	SAFETY INTERLOCK SWITCH ASSY
4	1	13901104	INPUT CONVEYOR ASSY. #4
5	1	13901119	BELT,CONVEYOR,FRONT,58"
6	1	13901120	ROLLER ASSY, 58"
7	4	1390159	SPACER,LATCH,LEFT
8	2	1390394	GUARD, CHAIN, SEAL-BAR, R
9	4	1390617	TOP RACK SPACER
10	1	1390623	GUARD, CHAIN, UPR ROLLER
11	4	1390969	PLATE, SPACER, DOOR LATCH
12	1	1391054	ROLL HOLDER FRAME
13	1	1391056	LOWER ROLL FEED
14	2	1391091	GUARD, CYLINDER
15	3	1391176	MTG BRKT, SIX MODULE STAT
16	1	1391178	GUARD, CHAIN, LWR ROLLER
17	1	1391179	GUARD, LOWER FILM GEAR BO
18	2	1391180	MTG BRKT, LOWER FILM MOTO
19	1	1391435	GUARD, CHAIN, UPR ROLLER
20	2	1391873	GUARD, ROLLER BEARINGS
21	4	1394286	NUT PLATE
22	2	1406847	BELT GUIDE PULLEY ASSY

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
23	4	MM1676A12	MAGNETIC CATCH
24	2	MM2421K31	GREASE FITTING, FLUSH-STYLE
25	5	NNH1/2-13	NUT,HEX,1/2-13
26	2	NNK10-32	KEP NUT, 10-32
27	8	SSHC01048	1/4-20 X 3/4 HEX CAP
28	8	SSHC01080	HEX HEAD 1/4-20 X 1-1/4
29	4	SSHC25080	3/8-16X1-1/4 HHCS
30	5	SSHC45192	1/2-13X3 HEX CAP
31	8	SSSC80032	6-32 X 1/2 SOC CAP SC
32	8	SSSC98024	10-32 X 3/8 SOC CAP
33	32	SSSC98032	10-32X1/2, SOC CAP
34	8	SSSC98048	10-32 X 3/4 SOC CAP
35	10	WWFS1/2	WASHER,FLAT,1/2, SAE
36	16	WWFS1/4	WASHER,FLAT,SAE,1/4
37	48	WWFS10	WASHER, FLAT, #10, SAE
38	4	WWFS3/8	WASHER,FLAT,SAE,3/8
39	8	WWFS6	WASHER, FLAT, #6
40	5	WWL1/2	1/2 LOCK WASHER
41	14	WWL1/4	WASHER,LOCK, 1/4
42	44	WWL10	WASHER,LOCK,#10
43	4	WWL3/8	WASHER,LOCK, 3/8
44	8	WWL6	WASHER,LOCK,#6

13901091 Safety Interlock Switch Assembly

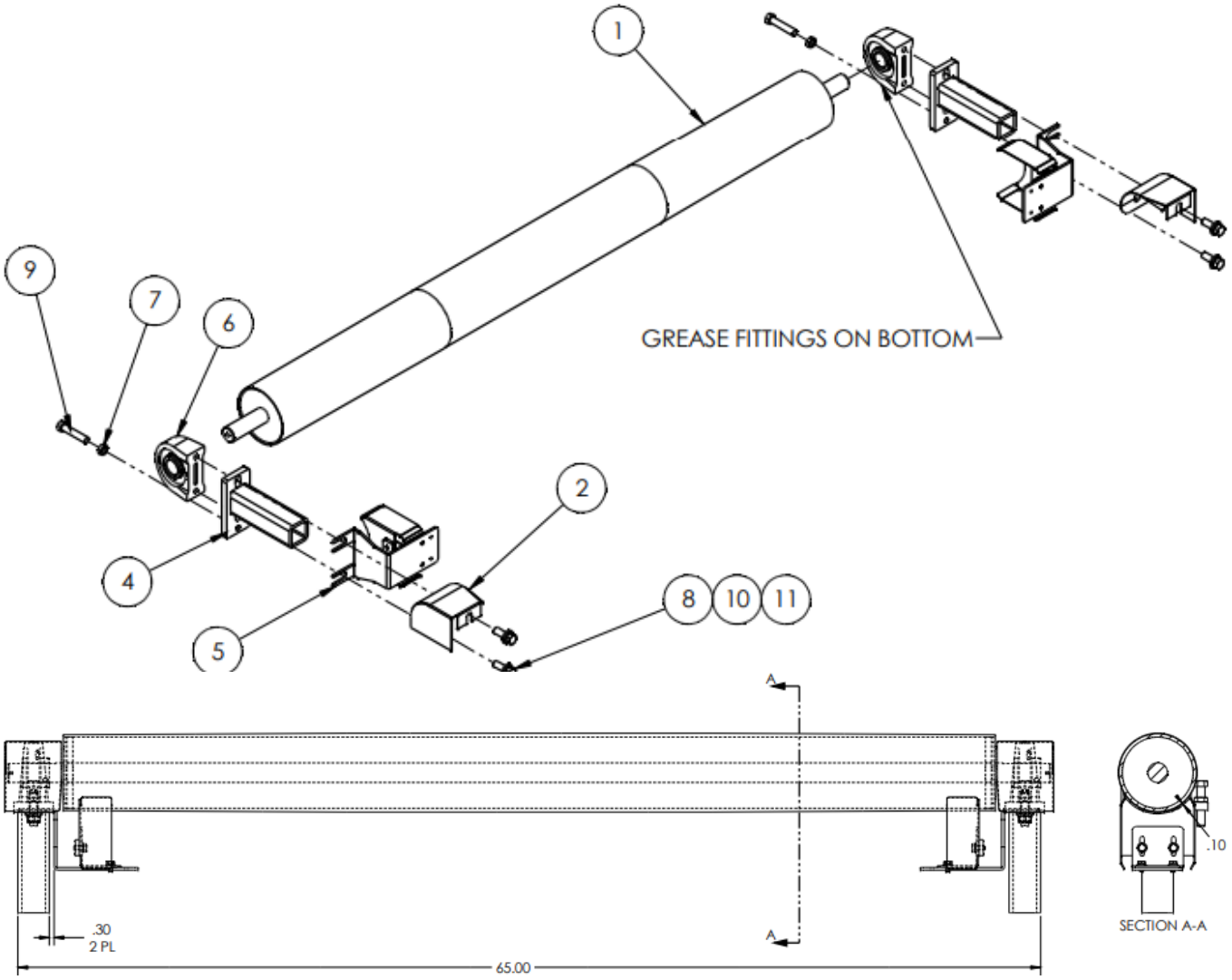
AAC Drawing Number 13901091 Rev 2



ITEM NO.	RIGHTHAND/Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1060008	PLATE,NUT,8-32X.50
2	1	1307374	PLATE, NUT, 8-32 X 22MM CTC X 10 GA
3	1	1318377	SAFETY SWITCH MOUNT
4	1	13901092	SAFETY SW MNT FOR EEIDIS190051
5	1	EE140103	KEY,SAFETY SW,IDIS,90 DEG
6	1	EEIDIS190051	SWITCH, SAFETY, DOOR.
7	1	FFM3200GAH-SM	STRAIN RELIEF, 1/2NPT, 3 HOLE, BLK
8	2	SSBC90032	8-32X1/2 BUTTON CAP
9	4	SSBC98016	10-32 X 1/4 BUTTON CAP SC
10	2	SSSC90080	#8-32 X 1-1/4 SOC CAP SC
11	2	WWL6	WASHER,LOCK,#6

13901120 Roller Assembly, 58”

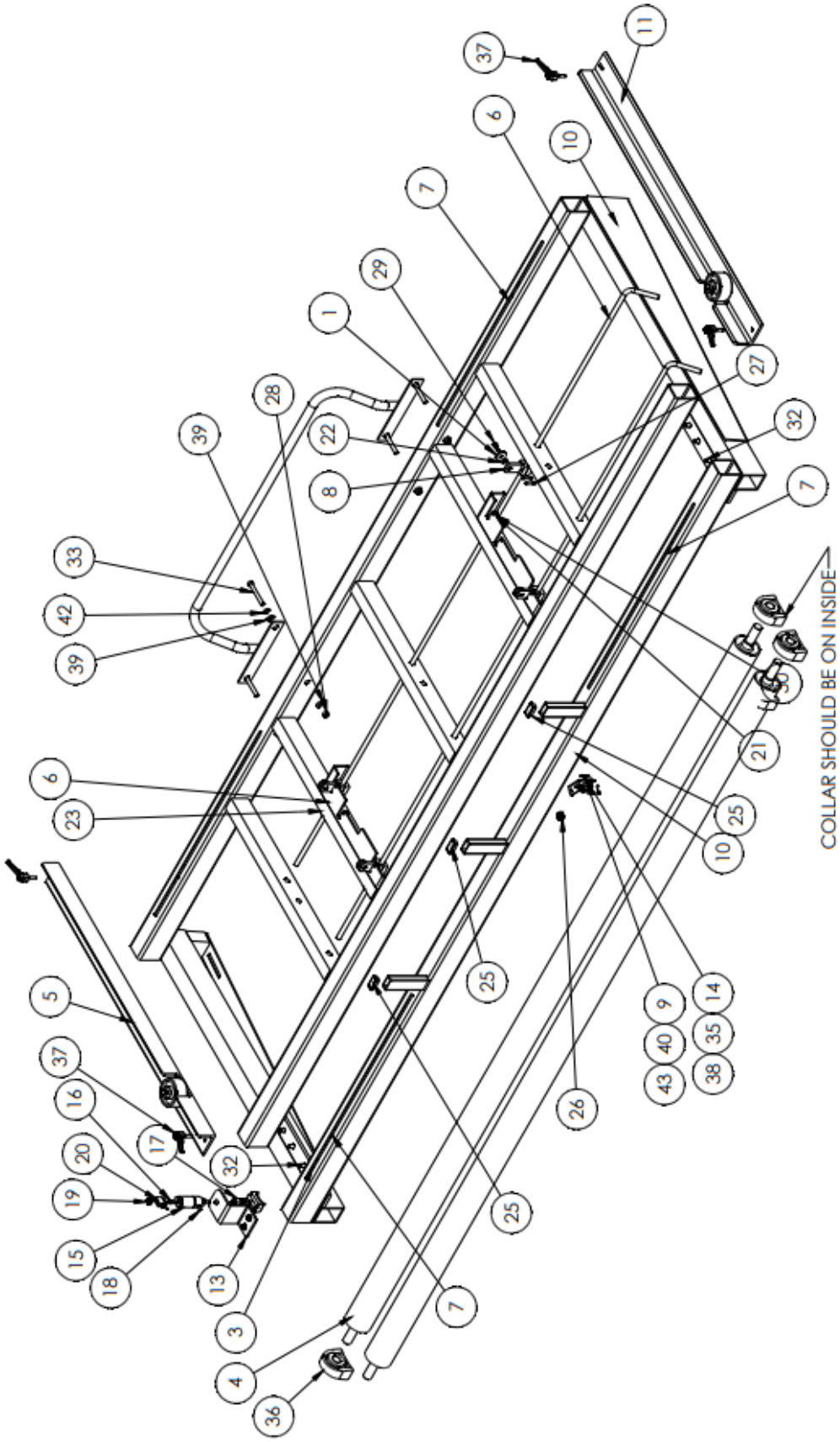
AAC Drawing Number 13901120 Rev 0



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	13901117	IDLER-ROLLER, 58" BELT
2	1	13901214	PILLOWBLOCK COVER, RIGHT
3	1	13901215	PILLOWBLOCK COVER, LEFT
4	2	1390282	WELDMENT, BELT-TENSIONER
5	2	1390681	GUARD, ROLLER
6	2	MMUCPA207-20	1.25" BEARING
7	2	NNJ1/2-13	1/2-13 JAM NUT
8	4	SSHC45096	1/2-13 X 1-1/2 HEX HEAD
9	2	SSHC45160F	1/2-13X2-1/2 HEX CAP
10	4	WWFS1/2	WASHER,FLAT,1/2, SAE
11	4	WWL1/2	1/2 LOCK WASHER

1391054 Roll Holder Frame

AAC Drawing Number 1391054 Rev 3



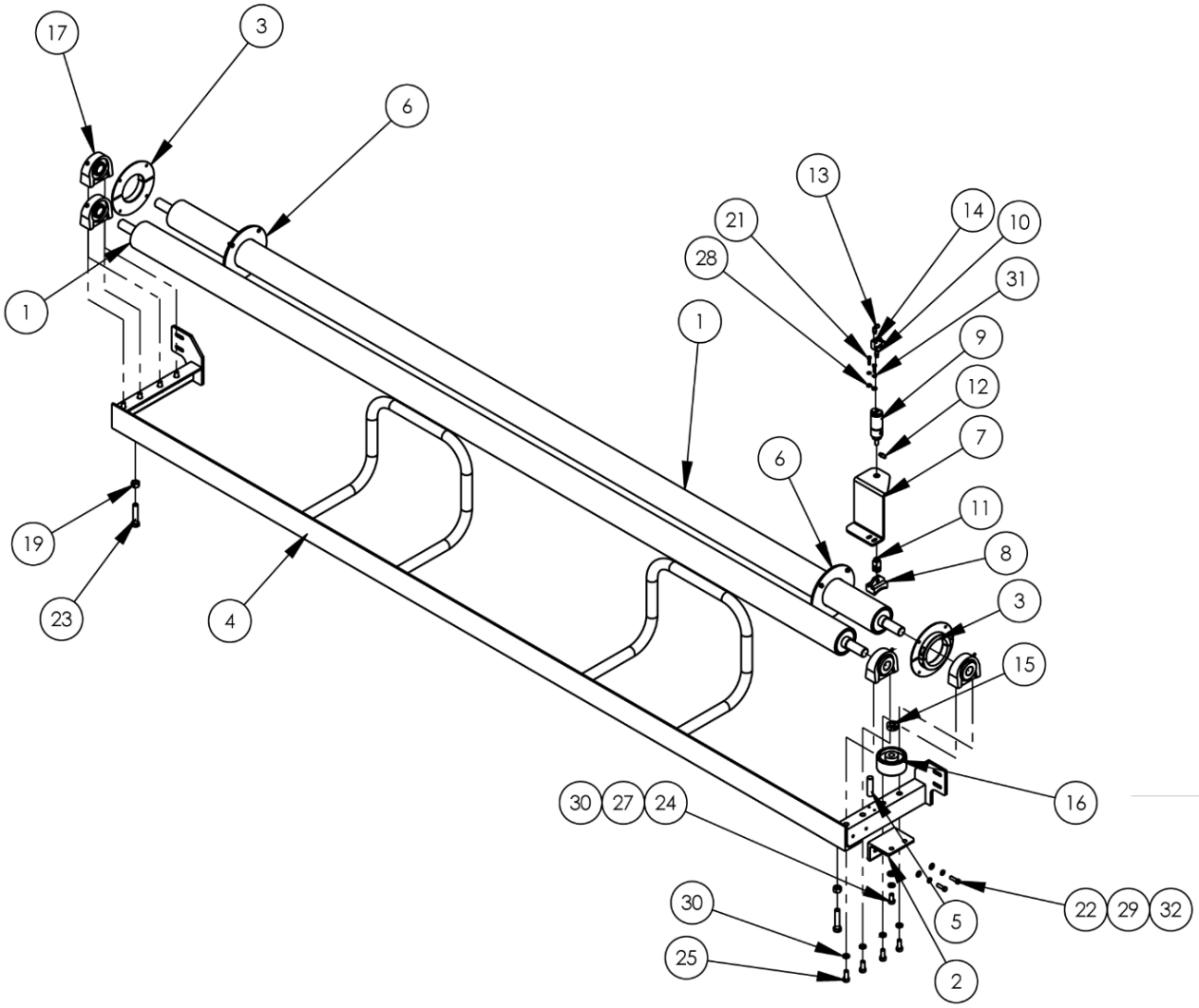
1391054 Parts List

No	Qty	Part Number	Description
1	4	1390198	ROLL RELEASE DISK 1390A
2	1	1390233	ROLL STOP TUBE TOP RACK, 1390
3	1	1390276	NUT PLATE, ROLL BRAKE MNT TOP
4	2	1390405	ROLLER, WELDMENT SUPPORT
5	1	1390412	SIDE ROLLER, ROLL HOLDER
6	2	1390458	ROD, ROLL STOP
7	4	1390459	NUT PLATE, SIDE ROLLER ADJ
8	4	1390463	ROLL STOP, WELDMNT 1390
9	1	1390468	BRKT, EYE MNT, LH
10	1	1390470	FRAME WELMENT, TOP ROLL
11	1	1390759	SIDE ROLLER, LONG 1390
12	1	1391096	BRAKE BLOCK ASSY TOP AND BOTTOM
13	1	1391098	MNT BRKT ROLL BRAKE, TOP
14	1	1975-412A	PLATE, NUT, 4-40@.95 CTC 12 GA
15	1	AAC171D	CYLINDER, AIR, DA 1-1/2 BORE,
16	1	AAF122A-A	1/8" NPT HEX CLOSE NIPPLE
17	1	AAFCT-15	CLEVIS AIR CYLINDER SMC NY-125
18	1	AAFP18	MUFFLER, 1/8 NPT SINTERED BRON
19	1	AAQME-5-8	QUICK MALE ELBOW 5/32X1/8NPT
20	1	AAVMJTV-3	VALVE, TOGGLE, 3 WAY, 1/8NPT
21	4	BB1L038	BEARING, BALL, .375B, .87D, .2
22	4	BBTRA613	WASHER, THRUST, STEEL 3/8 .375
23	2	CCCL10F	COLLAR, CLAMP, 5/8
24	1	FFSM312LVQ	PHOTOCELL, 10-30VDC WITH 4 PIN
25	3	MM132-1496	END CAP, RECT, BLACK 1 X 2 X 1
26	2	MM9307K63	GROMMET, 1/2ID, 13/16 HOLE 1-1
27	4	MMGRPA207-20	BEARING, PILLOW BLOCK, 1.25 GR
28	4	NNH1/2-13	NUT, HEX, 1/2-13
29	4	SSAS024024	SCREW, ALLEN SHOULDER 3/8X3/8,
30	4	SSFC01040	SCREW, FLAT ALLEN CAP 1/4-20X5
31	2	SSHC25064	SCREW, HEX CAP 3/8-16X 1
32	8	SSHC45096	SCREW, HEX CAP 1/2-13X1-1/2
33	4	SSHC45256	SCREW, HEX CAP 1/2-13X4
34	8	SSSC05080	SCREW, SOCKET CAP 1/4-28X1-1/4
35	2	SSSC70064	SCREW, SOCKET CAP 4-40X1
36	2	SSSC98032	SCREW, SOCKET CAP 10-32X1/2
37	4	TTH32430	HANDLE, THREADED 3/8-16X1-1/4
38	2	WWF4	WASHER, FLAT, 4
39	16	WWFS1/2	WASHER, FLAT, SAE, 1/2
40	2	WWFS10	WASHER, FLAT, SAE, 10
41	2	WWFS3/8	WASHER, FLAT, SAE, 3/8
42	12	WWL1/2	WASHER, LOCK, 1/2
43	2	WWL10	WASHER, LOCK, 10
44	2	WWL3/8	WASHER, LOCK, 3/8

1391056 Lower Roll Feed

AAC Drawing Number 1391056 Rev 2

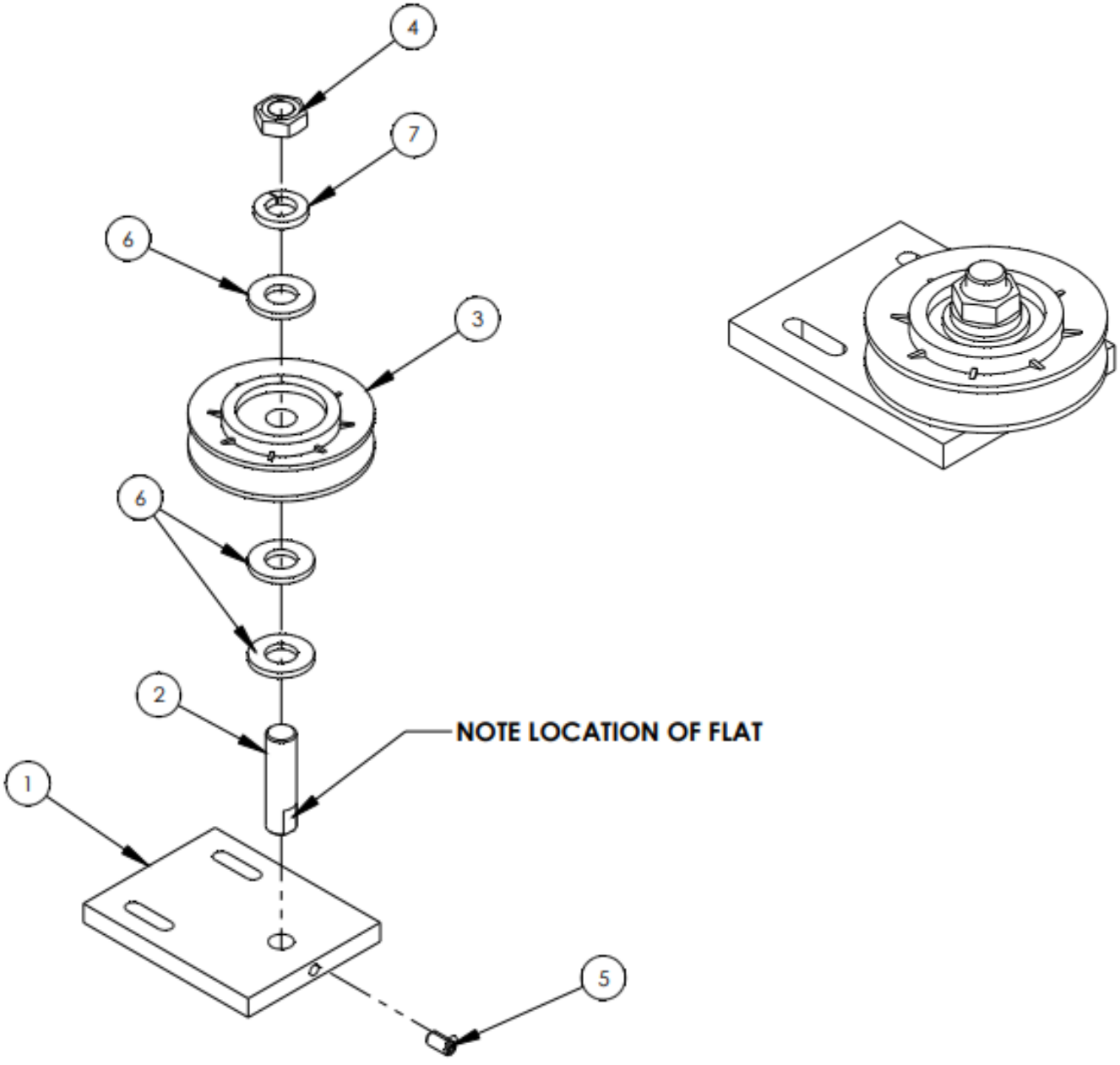
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	1390405	SUPPORT ROLLER WELDT	17	4	MMGRPA207-20	1.25" BEARING, GRIP-IT
2	1	1390804	BOTTOM ROLLER MTG BRKT FO	18	8	NNE10-32	NUT,ELASTIC LOCK
3	2	1390810	GUIDE PLATE ASSY, LOWER R	19	2	NNH5/8-11	NUT,HEX,5/8-11
4	1	1390811	LOWER ROLLER WELDMENT	20	8	SSFC98048	#10-32 X .75 SHCSF
5	1	1390812	AXEL, GLIDE WHEEL	21	2	SSHC01064	1/4-20 X 1 HHCS
6	2	1390882	SIDE PLATE- BOTTOM ROLL	22	2	SSHC25080	3/8-16 X 1-1/4 HEX CAP
7	1	1391095	MTG. BRKT. BRAKE	23	2	SSHC41192F	5/8-11X4 HEX CAP FULL THD
8	1	1391096	BRAKE BLOCK ASSY, 1390B	24	1	SSHC45064	1/2-13X1 HEX CAP
9	1	AAC171D	CYLINDER,AIR,DA,1-1/2 B,1 ST	25	8	SSHC45080	1/2-13X1-1/4 HEX CAP
10	1	AAF122A-A	1/8" NPT HEX CLOSE	26	8	WWF10	WASHER, FLAT, #10, COM
11	1	AAFCT-15	CLEVIS,AIR CYL,7/16-20	27	1	WWFS1/2	WASHER,FLAT,SAE,1/2
12	1	AAFP18	MUFFLER,1/8 NPT, BRONZ	28	2	WWFS1/4	WASHER,FLAT,SAE,1/4
13	1	AAQME-5-8	QUICK MALE ELBOW	29	2	WWFS3/8	WASHER,FLAT,SAE,3/8
14	1	AAVMJTV-3	VALVE,TOGGLE	30	9	WWL1/2	1/2 LOCK WASHER
15	1	CCCL12F	CLAMP COLLAR- 3/4	31	2	WWL1/4	WASHER,LOCK,1/4
16	1	MM2419T31	WHEEL, 4"OD X 2"W X 3/4 B	32	2	WWL3/8	WASHER, LOCK, 3/8



1406847 Belt Guide Pulley Assembly

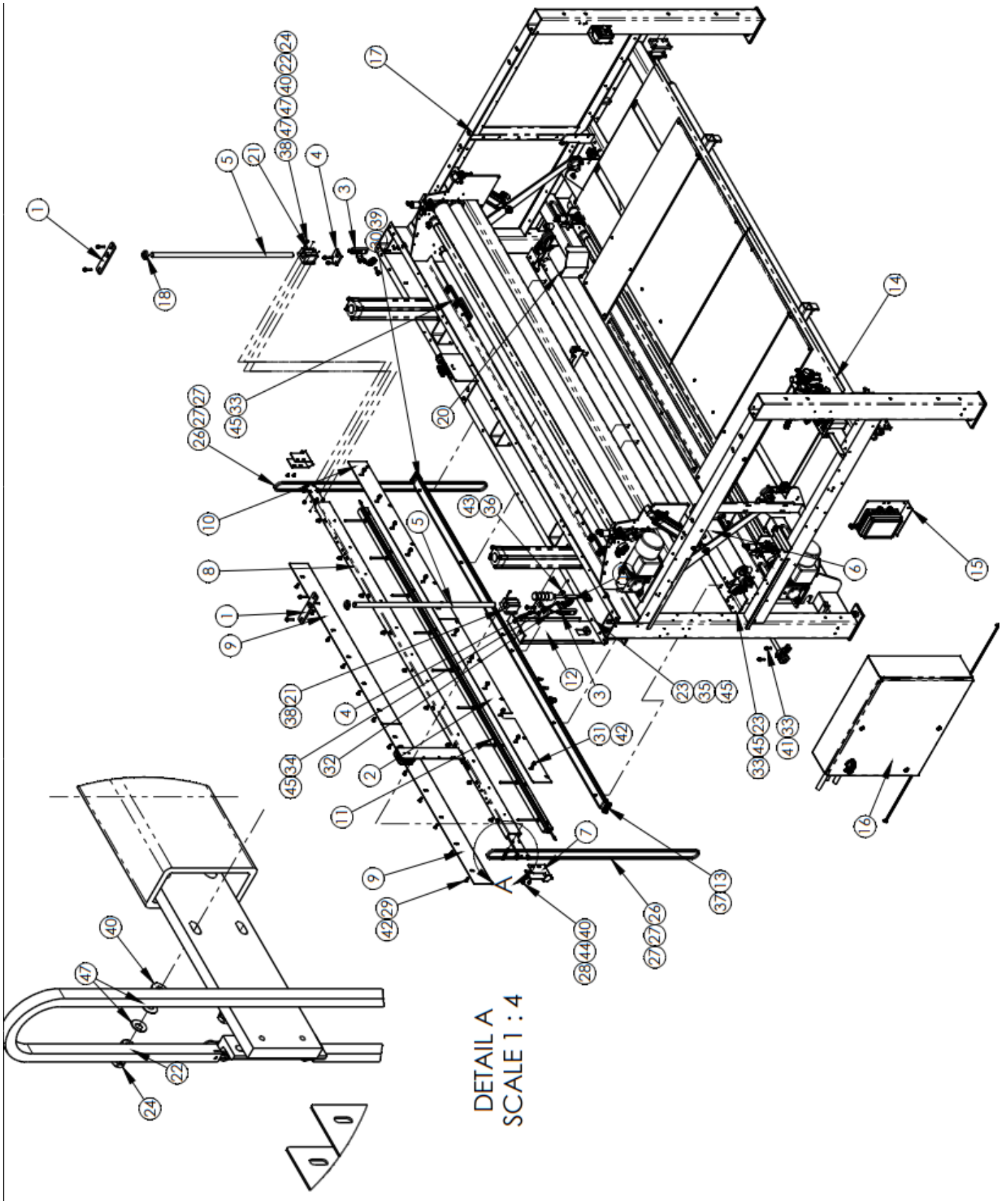
AAC Drawing Number 1391056 Rev 2

ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1406846	GUIDE PULLEY MTG BRKT
2	1	1406848	THREADED ROD, 1/2-13 X 3
3	1	MM6234K53	PULLEY, V-BELT, NYLON
4	1	NNJ1/2-13	NUT,JAM, 1/2-13
5	1	SSSS01032	SCREW, SET, 1/4-20 X 1/2
6	3	WWFS1/2	WASHER,FLAT,1/2, SAE
7	1	WWL1/2	1/2 LOCK WASHER



13901104 Input Conveyor Assembly. # 4

AAC Drawing Number 13901104 Rev 1



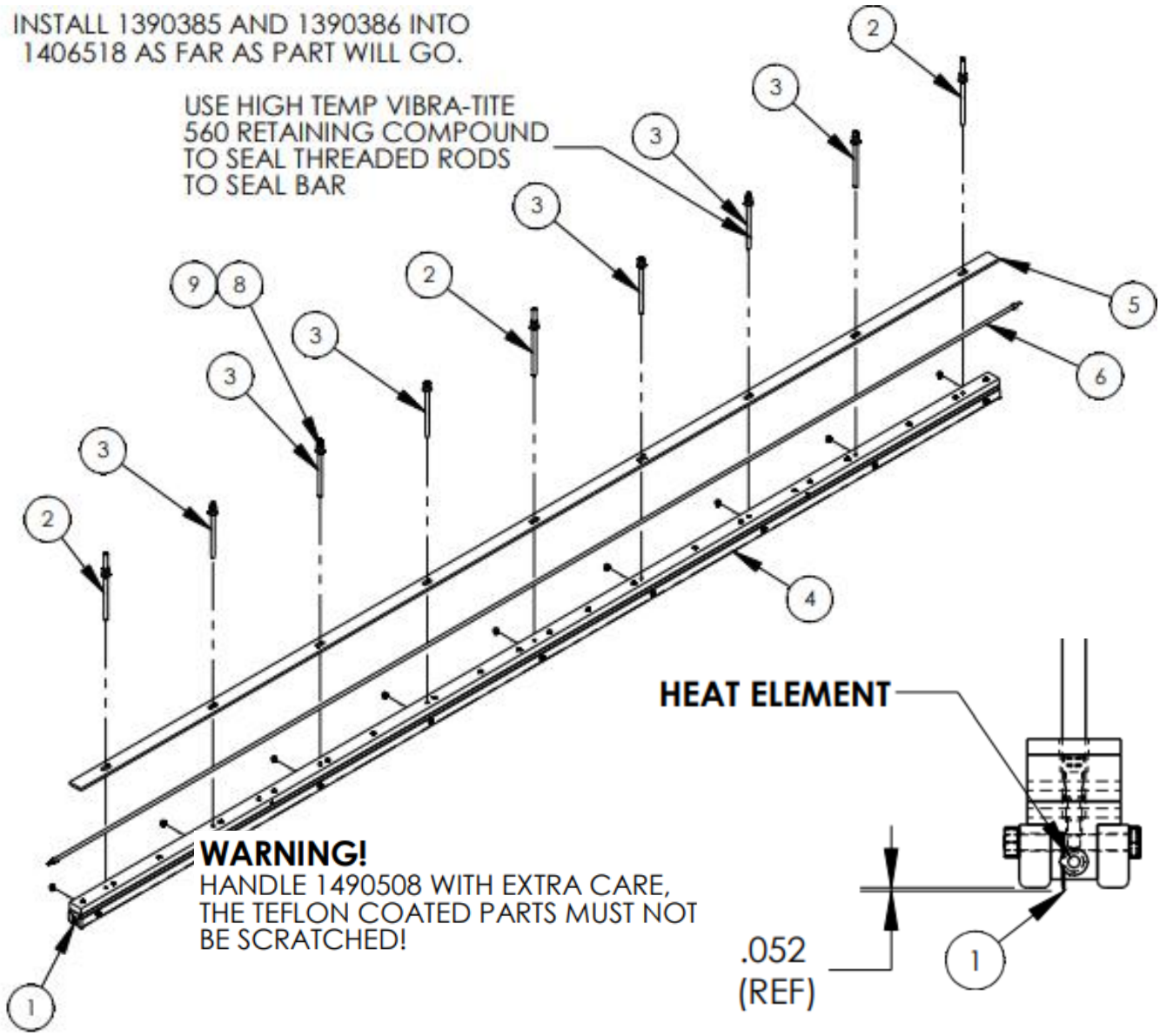
13901104 Parts List

ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	2	1390324	TOP BRACKET LINEAR SHAFT
2	1	1390337	INPUT GUARD CROSS SEAL RT
3	2	1390342	TOP CHAIN TENSIONER
4	2	1390343	LOWER LINEAR BRKT CROSS
5	2	1390346	SHAFT,ROLLER
6	1	1390484	SHAFT ASSY,IDLER SPKTS
7	2	1390485	END PLATE, CROSS SEAL
8	1	1390609	MOUNT, CROSS SEAL BAR
9	2	1390858	INPUT GUARD CROSS SEAL
10	1	1390967	INPUT GUARD CROSS SEAL LT
11	1	1406519	SEAL BAR 120" ASSEMBLY
12	1	1406823	SUPPORT, CENTER CROSSBAR
13	1	1406995	BLADDER SEAL KIT, 120"
14	1	1490345	IDLER ROLLER ASSY. FILM
15	1	13901025	ENCLOSURE, SBUS, EXTERNAL
16	1	13901080	CABINET, ELECT CNTRL 1390HCD
17	1	13901103	INPUT CONVEYOR ASSY. #3
18	2	CCCL20F	COLLAR,1 1/4" CLAMP TYPE
19	2	MM41E15	SPROCKET, 1/2 P, 15T
20	1	MM9307K63	GROMMET,1/2ID,13/16 HOLE
21	2	MMPB20M	LIN. PILLOW-BLOCK,MOD.
22	8	NNH1/4-28	NUT,HEX,1/4-28
23	8	NNH3/8-16	3/8-16 HEX NUT
24	8	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
25	2	NNJ3/8-16	3/8-16 JAM NUT
26	267"	PPP40	CHAIN, #40 RIVET
27	4	PPP40CL	LINK, CONNECTING, #40
28	4	SSBC01040	1/4-20 X 5/8 BUT HEAD
29	12	SSBC10064	5/16-18 X 1 BUT HEAD
30	2	SSBC98048	#10-32 X 3/4 BUT HEAD
31	12	SSHC10064	5/16-18 X 1" HEX HEAD
32	2	SSHC25080	3/8-16 X 1-1/4 HEX HEAD
33	18	SSHC25096	3/8-16 X 1-1/2 HEX HEAD
34	4	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
35	4	SSHC25128	3/8-16 X 2 HEX HEAD
36	2	SSHC45112	1/2-13 X 1-3/4 HEX HEAD
37	6	SSPS98032	#10-32 X 1/2 PAN HD SLOT
38	8	SSSC05096F	1/4-28X1-1/2 SOC CAP FUL
39	2	WWFE016	WASHER,FENDER,LARGE,1/4
40	12	WWFS1/4	WASHER,FLAT,SAE,1/4
41	34	WWFS3/8	WASHER,FLAT,SAE,3/8
42	24	WWFS5/16	WASHER,FLAT,SAE,5/16
43	2	WWL1/2	1/2 LOCK WASHER
44	4	WWL1/4	WASHER,LOCK, 1/4
45	26	WWL3/8	WASHER,LOCK, 3/8
46	24	WWL5/16	WASHER,LOCK, 5/16
47	16	WWS307-1	WASHER,SPRING,BELVEL

1406519 Seal Bar 120” Assembly

AAC Drawing Number 1406519 Rev 3

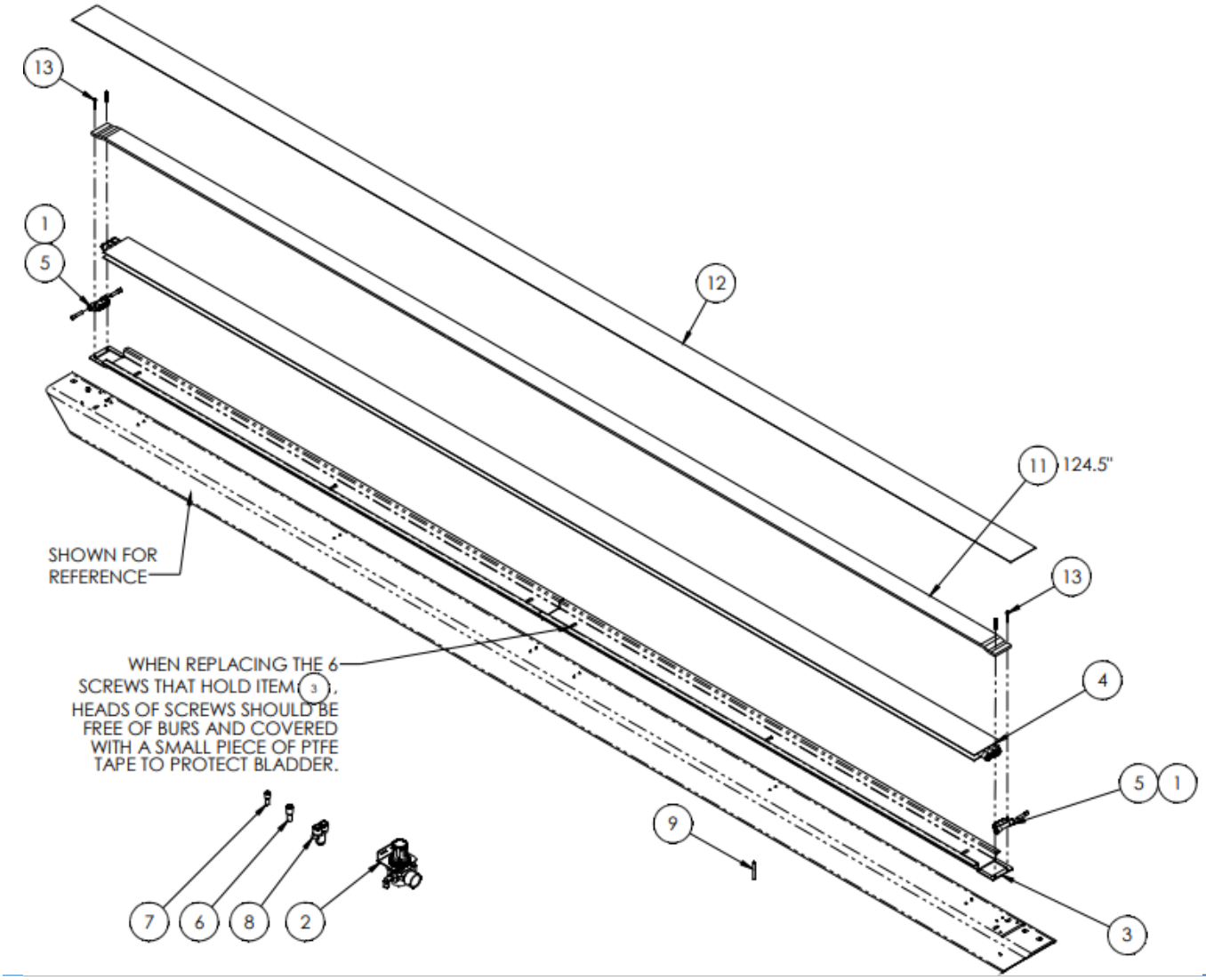
ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1390333	CUT BLADE 120"
2	3	1390385	THREADED ROD, 7.5"
3	6	1390386	THREADED ROD, 6.25"
4	1	1406518	SEAL BAR 120" ASSEMBLY
5	1	1490508	STRIP, INSULATING
6	1	EERBN125A10A-4	HEAT ELEMENT,125L,.315D
7	1	MM860-150G	SILICONE HEAT TRANSFER COMPOUND,
8	18	NNH3/8-16	NUT,HEX,3/8-16
9	9	WWFS3/8	WASHER,FLAT,SAE,3/8



1406995 Bladder Seal Kit 120”

AAC Drawing Number 1406995 Rev 10

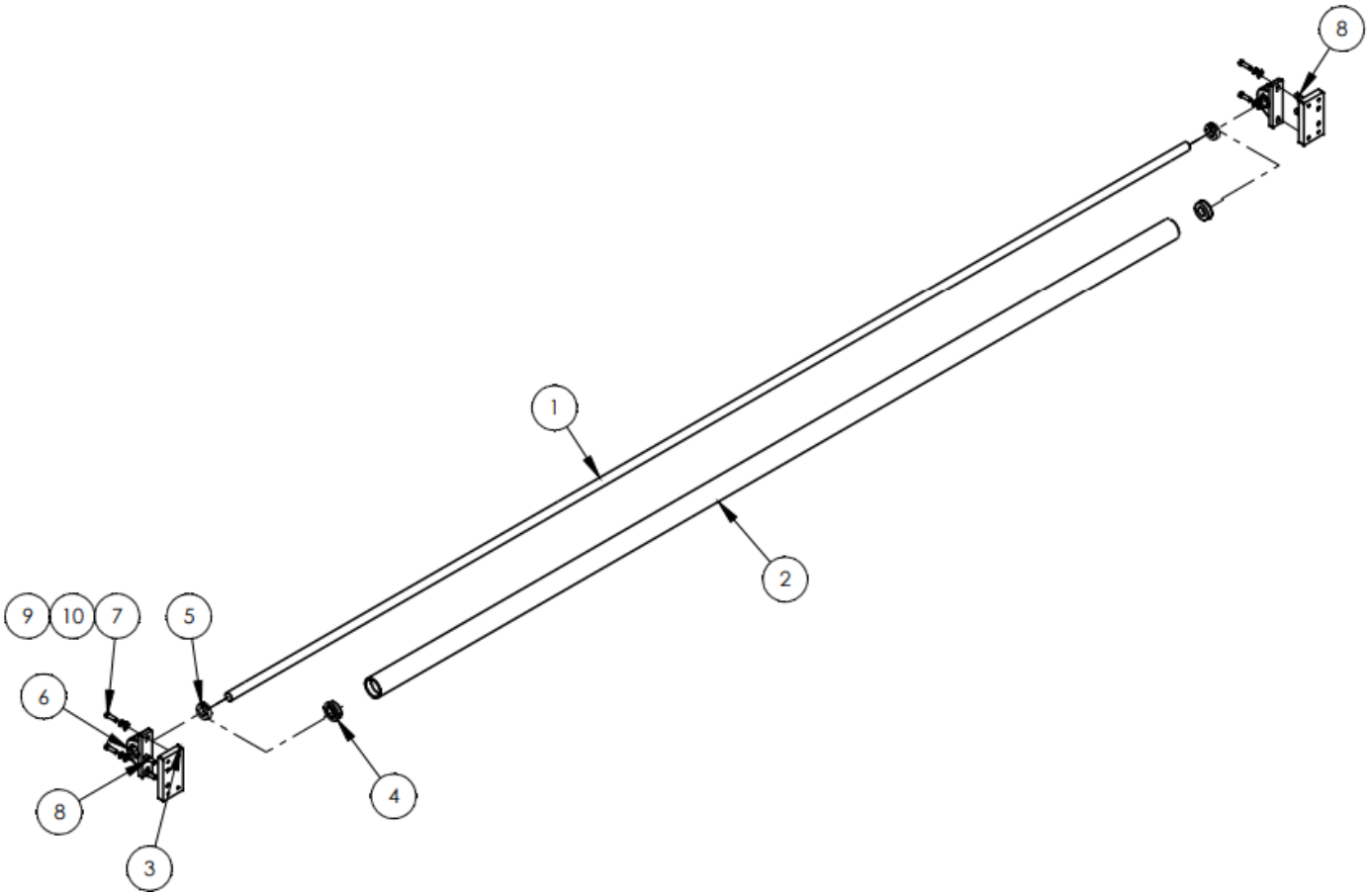
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	3	1406938	QUICK PLUG 1/4, MODIFIED
2	1	1406942	REGULATOR ASSY, MODIFED
3	2	13901203	TROUGH, SEAL BAR 120"
4	1	14061357	BLADDER ASSY, 120"
5	2	AAQMF-4	MANIFOLD, 3, 1/4-1/4-1/4
6	1	AAQPR-2-3	QUICK PLUG REDUCER
7	1	AAQPR-3-4	QUICK REDUCER 3/8-1/4
8	1	AAQUY-2-2	QUICK UNION Y,1/2X1/2
9	10'	AATP4-1	1/4" OD POLYURETHANE
10	1 KIT ONLY	DDB#29	#29 DRILL BIT
11	1	MMRF118914	SILICONE,STRIP,2.25X.25TK
12	1	MMSG1305	TAPE, TEX PTFE, 3.4W X 54'L, 6 MIL
13	4	SSFC70064	SCREW, FLAT ALLEN CAP 4-40 X 1
14	2	SSSC90032	SCREW, SOCKET CAP
15	2	SSSC90080	SCREW, SOCKET CAP
16	1 KIT ONLY	TTA8-32	8-32 TAP



1490345 Idler Roller Assembly Seal Kit 120”

AAC Drawing Number 1490345 Rev 0

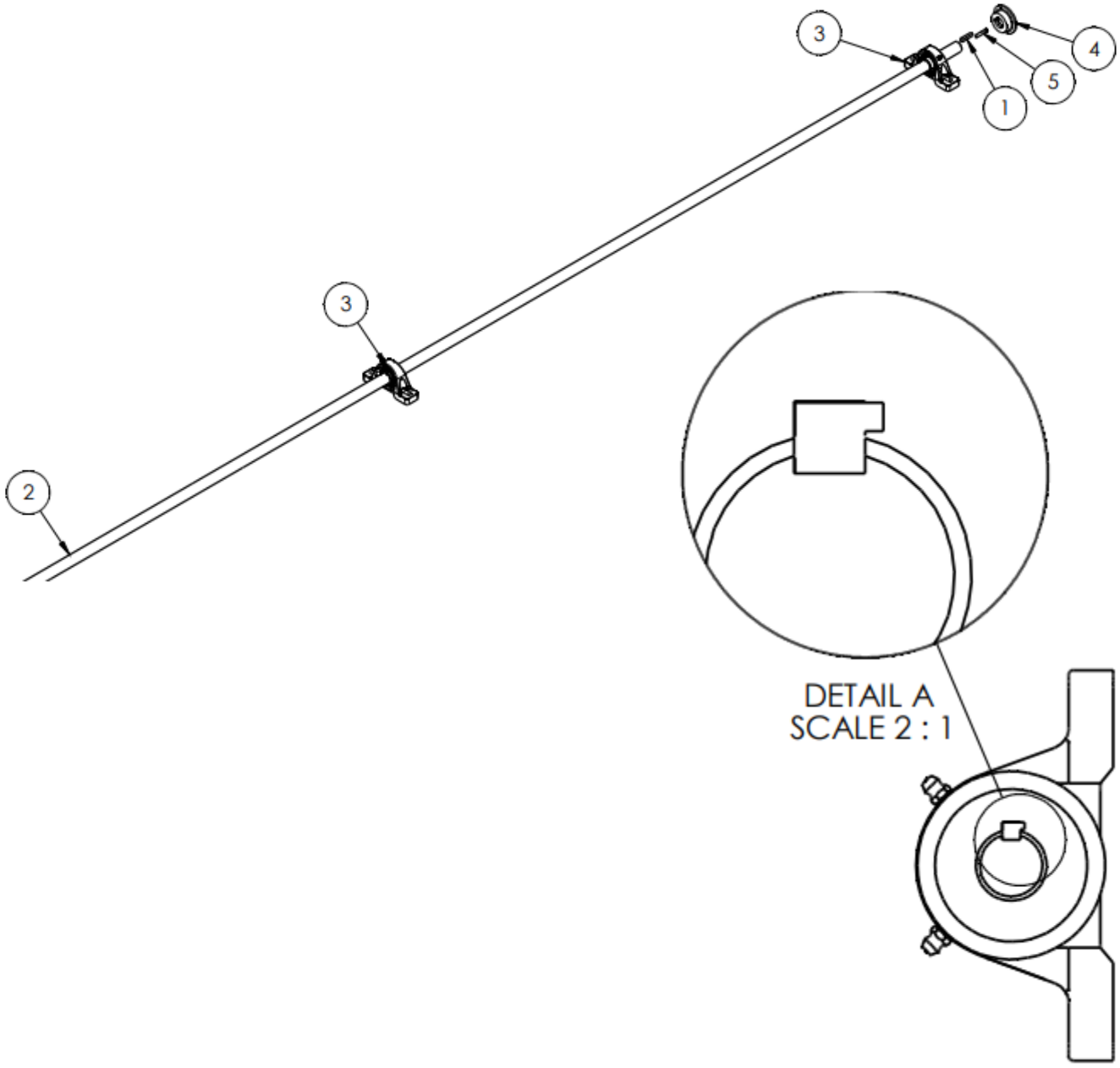
ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1390446	TURN-AROUND ROD
2	1	1390464	TUBE, IDLER ROLLER
3	2	1490346	SPACER, PILLOW BLOCK
4	2	BBF-1000-4	BEARING, BALL, 1 1/4 B, UNGRD
5	2	CCCL16F	COLLAR,1" CLAMP TYPE
6	2	MMVPLS-116	BEARING,PILLOW BLOCK 1.0B
7	4	SSHC25080	3/8-16 X 1-1/4 HHCS
8	4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



1390484 Shaft Assembly, Idler Sprockets

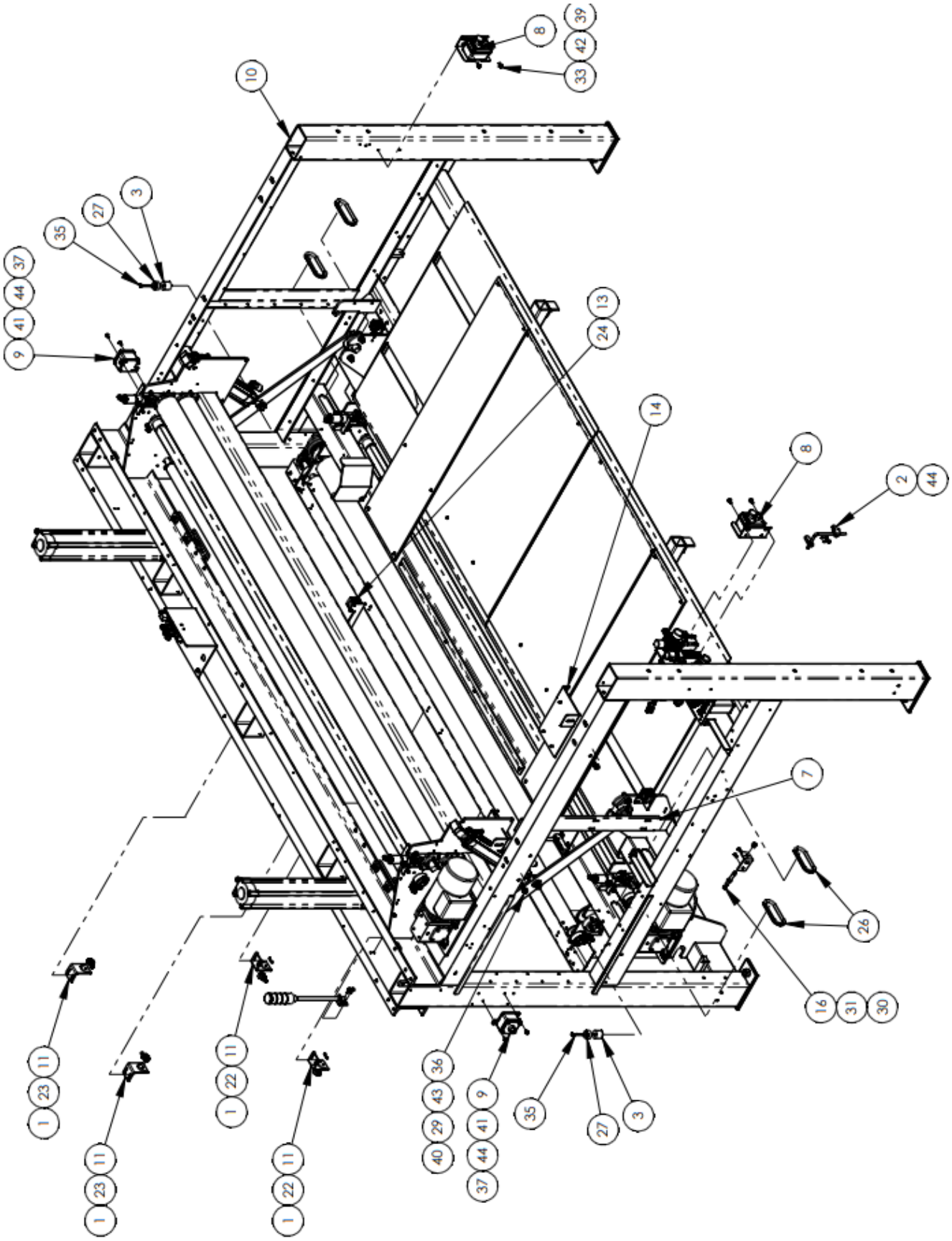
AAC Drawing Number 1390484 Rev 3

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	2	1386645	MODIFIED SPROCKET, 1B, #40 X15T
2	1	1390355	JACK SHAFT CROSS SEAL
3	2	1390997	KEY, 1/4 X 1.25L, W/STEP
4	2	IIS016X112	ROLL PIN 1/8 DIA X 1 1/2 SS
5	3	MMUCP205-16	BEARING,PILLOW BLOCK,1"



13901103 Input Conveyor Assembly. # 4

AAC Drawing Number 13901104 Rev 1



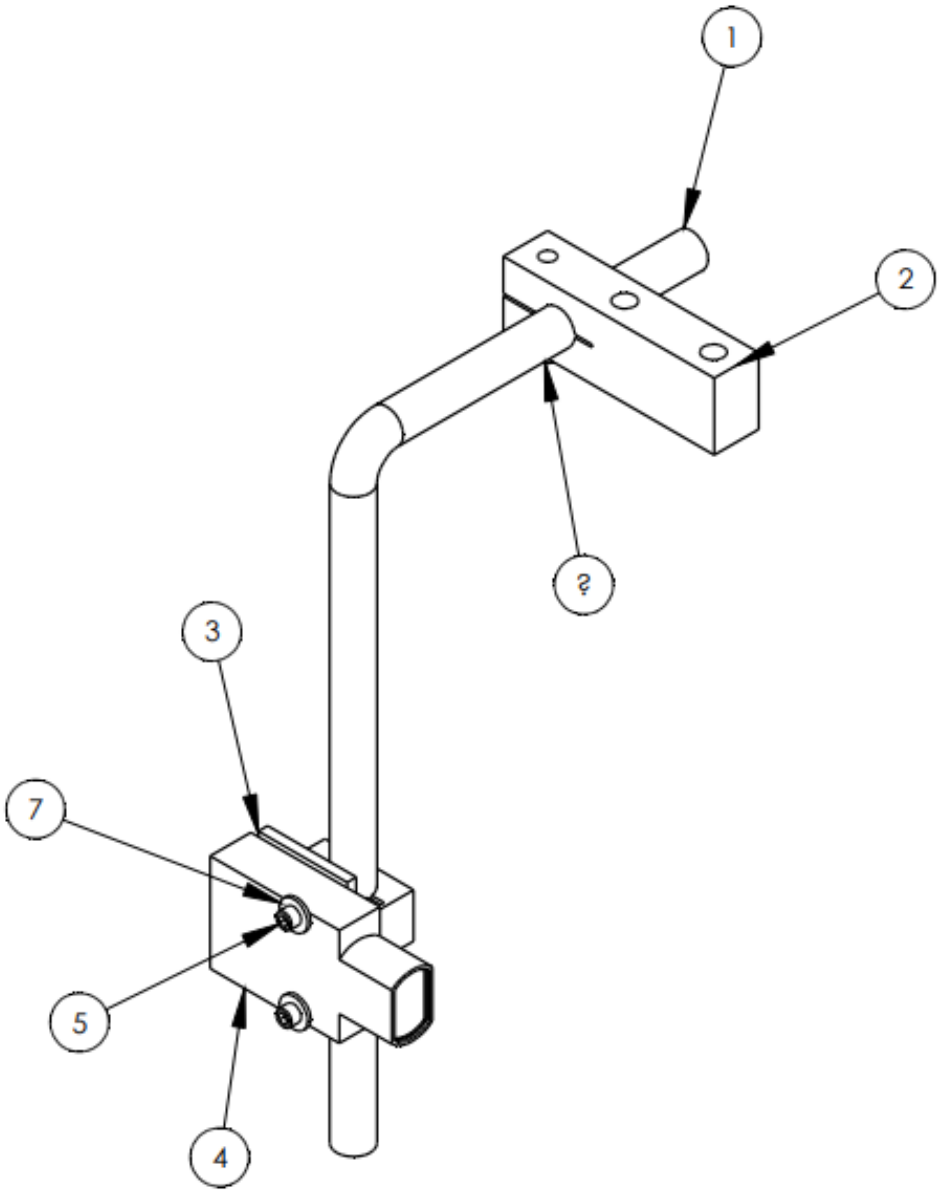
13901103 Parts List

ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	4	1975-412A	PLATE,NUT,4-40,.95CTC
2	1	1390443	SENSOR ASSEMBLY, FILM OUT
3	2	1390478	SPACER, BUMPER
4	2	1390703	BRACKET, DAMPENING MOUNT
11	4	1390846	BRACKET, EYE MOUNT,LH
6	1	13901032	TOP MTG BRKT, MAIN BOX
7	1	13901041	CABLE TRACK, 1390 CABINET
8	2	13901053	BUTTON BOX, E-STOP/START
9	2	13901055	BUTTON BOX, RESET,BLUE
10	1	13901102	INPUT CONVEYOR ASSY. #2
11	1	13901111	SIZING SENSOR MTG BRKT, LEFT
12	1	13901112	SIZING SENSOR MTG BRKT, RIGHT
13	1	13901113	SIZING SENSOR MTG BRKT, TOP
14	1	13901326	TOP MTG BRKT, MAIN BOX, PC MOUNT
15	*50	AAF3/16	CLAMP, BLACK PLASTIC, 3/16 DIA
16	2	AAPR025IF2B	SHOCK 5/8 STK,1/2-20 THD
17	*100	AATP1/2	1/2" OD POLYURETHANE
18	*300	AATP3/8	3/8" OD POLYURETHANE
19	*150	AATP4-1	1/4" OD POLYURETHANE
20	*75	AATP5/32	5/32" OD POLYURETHANE
21	1	EELES302RAG	TOWER,SIGNAL,LED,RAG
22	2	FFQS18VN6RQ8	SENSOR,LASER RECEIVER,NPN

ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
23	2	FFQS186LEQ8	SENSOR,LASER EMITTER
24	3	I (4-20ma mode)	PHOTOELECTRIC, PNP, 3.5M
25	*50	MM5X521	RIVET,POP,1/8D,.313-.375
26	*6	MM8507K22	EDGE TRIM
27	2	MM9540K28	BUMPER, 1-1/2 DIA, 70A
28	*36	MMT9945	TAPE,REFLECTIVE,2" WIDE
29	2	NNH3/8-16	NUT,HEX,3/8-16
30	4	NNJ1/2-20	NUT, JAM, 1/2-20
31	1	NNK1/4-20	KEP NUT, 1/4-20
32	4	SSHC01032	1/4-20 X 1/2 HHCS
33	4	SSHC01048	1/4-20 X 3/4 HEX CAP
34	2	SSHC01096	1/4-20 X 1-1/2 HHCS
35	2	SSHC01144	HEX HEAD, 1/4-20 X 2-1/4
36	2	SSHC25096	3/8-16 X 1 1/2 HHCS
37	4	SSHC98040	10-32X5/8 HEX HD
38	2	SSSC98072	10-32 X 1-1/8 SOC CAP
39	6	WWFS1/4	WASHER,FLAT,SAE,1/4
40	4	WWFS3/8	WASHER,FLAT,SAE,3/8
41	4	WWFS10	WASHER, FLAT, #10, SAE
42	6	WWL1/4	WASHER,LOCK, 1/4
43	2	WWL3/8	WASHER,LOCK, 3/8
44	6	WWL10	WASHER,LOCK,#10

1390443 Sensor Assembly, Film Out

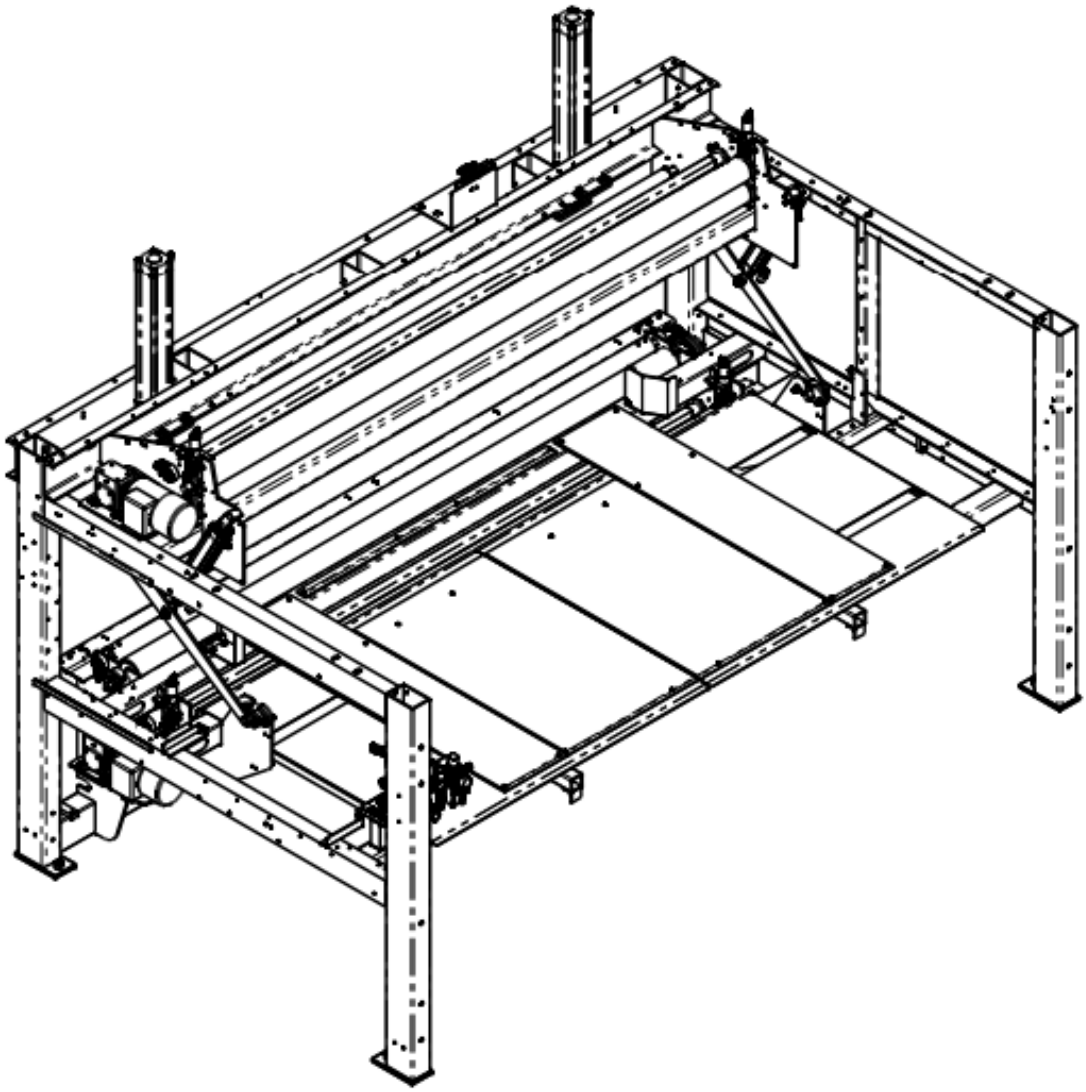
AAC Drawing Number 1390443 Rev 0

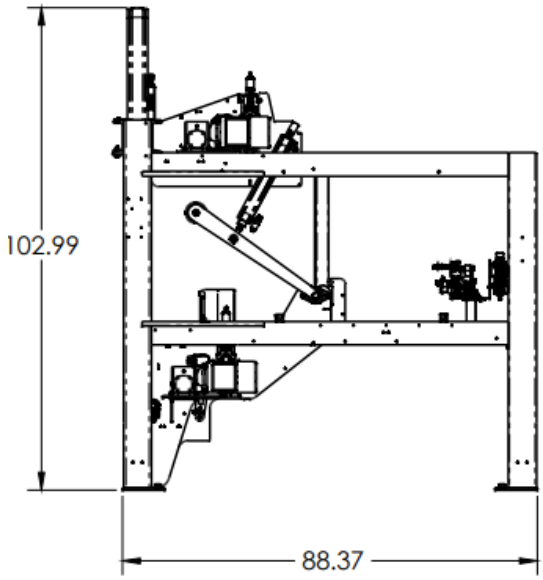


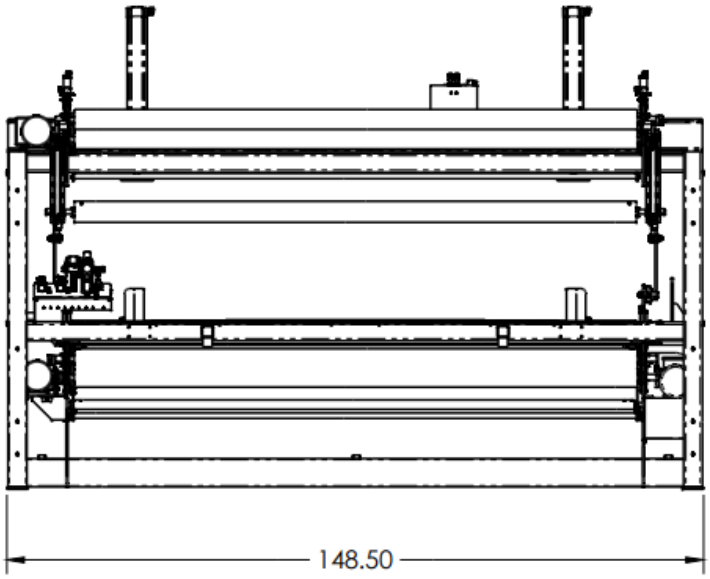
ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1335-316	ROD, SS, "L", 3/8, 4.0 X
2	1	23080	BLOCK,CLAMP,EYE
3	1	23132A	HOLDER, EYE, 3/8 ROD
4	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
5	2	SSSC70040	4-40 X 5/8, SCREW,SOCKET CAP
6	2	SSSC98040	10-32 X 5/8 SOC CAP
7	2	WWF4	WASHER, FLAT, #4

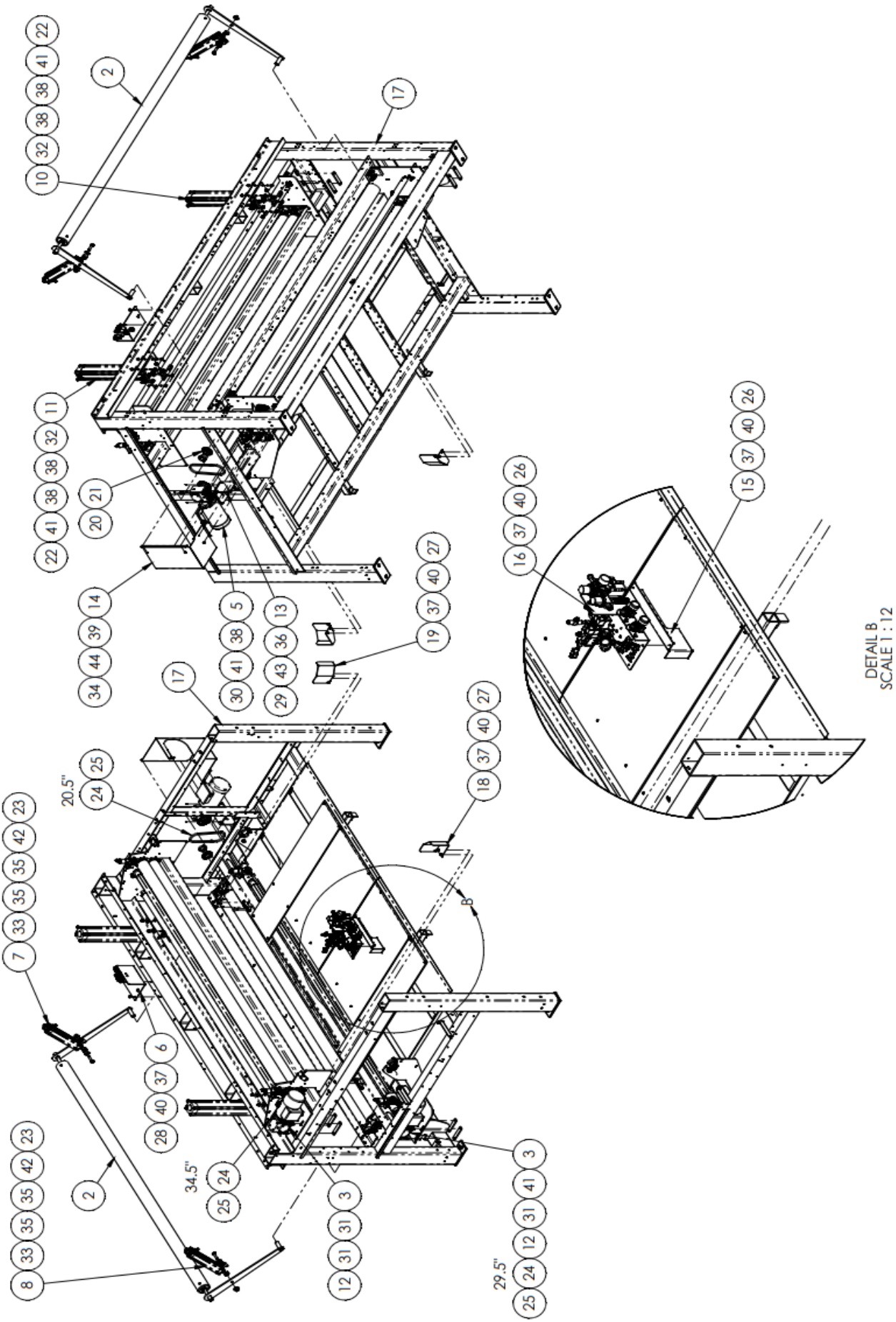
13901102 Input Conveyor Assembly # 2

AAC Drawing Number 13901102 Rev 1







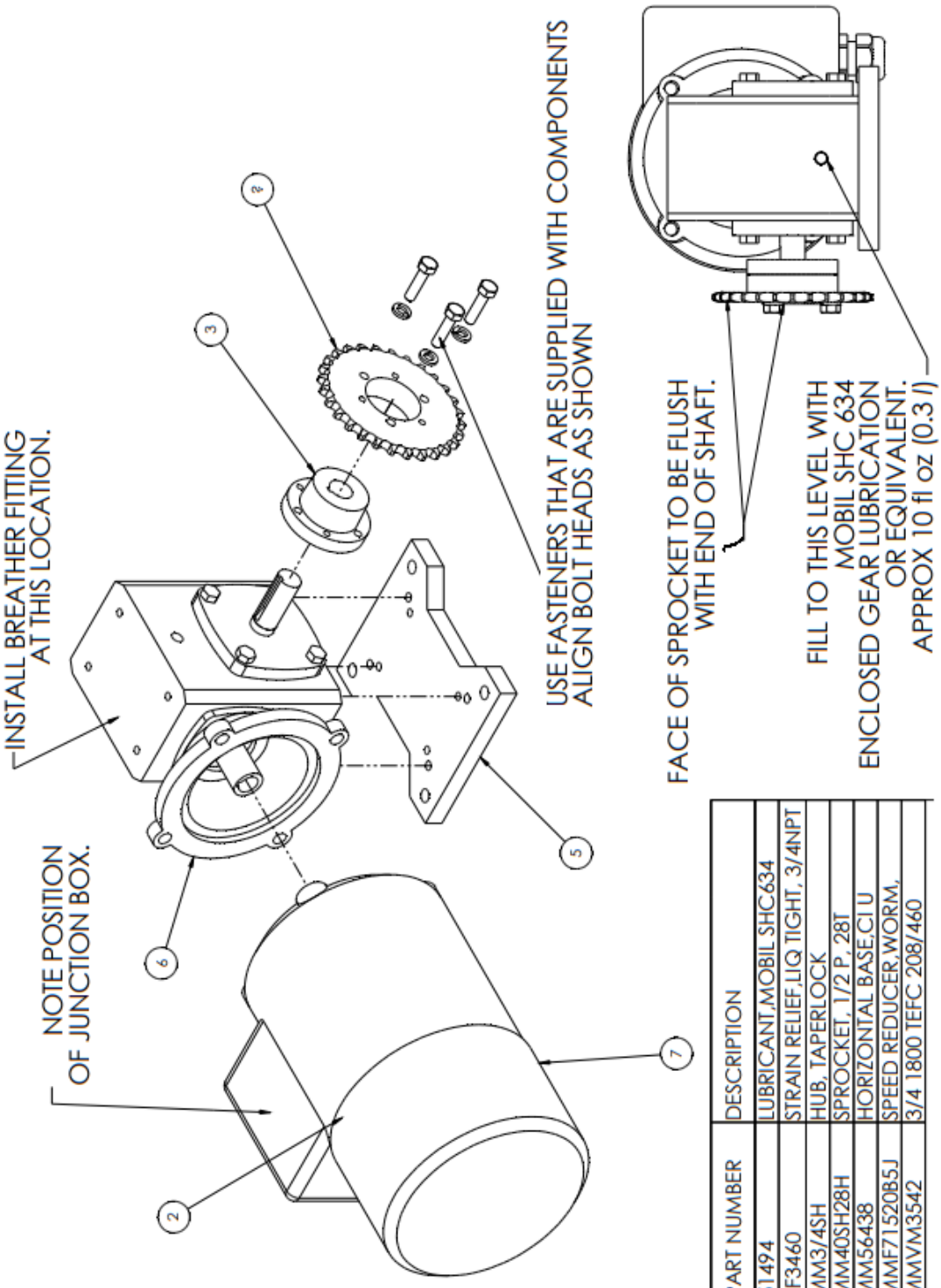

DETAIL B
SCALE 1 : 12
20.5"
34.5"
29.5"

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	3	1390160	KEY, 1/4 X 1.25L
2	1	1390297	PVC ROLLER ASM
3	2	1390473	MOTOR/REDUCER ASSY
4	2	1390498	BLOWER/MANIFOLD ASSY
5	1	1390979	MOTOR ASSEMBLY
6	1	1391035	VALVE ASSY, CROSS SEAL
7	1	1391062	CYL ASSY, LRG INFEED ROLL
8	1	1391063	CYL ASSY, LRG INFEED ROLL
9	2	1391068	ARM, PVC ROLLER
10	1	1391071	CYLINDER ASSY. CROSS SEAL
11	1	1391145	CYLINDER ASSY. CROSS SEAL
12	4	1391177	NUT PLATE, GEAR MOTOR MTG
13	1	1396850	MOTOR MOUNTING ANGLE
14	1	1396853	GUARD, CHAIN, INFEED MTR
15	1	13901031	BKT, MOUNT, SOL ASBLY
16	1	13901040	VALVE BANK ASSEMBLY
17	1	13901101	INPUT CONVEYOR ASSY #1
18	1	13901204	AIR JET GUARD, LEFT
19	1	13901206	AIR JET GUARD, RIGHT
20	3	MM11/4SH	HUB, TAPERLOCK
21	3	MM40SH21H	SPROCKET, 1/2 P, 21T
22	8	NNH3/8-16	NUT,HEX,3/8-16

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
23	2	NNH5/8-11	NUT,HEX,5/8-11
24	84.5"	PPP40	CHAIN, #40 RIVET
25	3	PPP40CL	LINK, CONNECTING, #40
26	4	SSHC01040	1/4-20 X 5/8 HHCS
27	4	SSHC01048	1/4-20 X 3/4 HEX CAP
28	2	SSHC01064	1/4-20 X 1 HHCS
29	1	SSHC10064	5/16-18 X 1 HHCS
30	1	SSHC25080	3/8-16X1-1/4 HHCS
31	8	SSHC25096	3/8-16 X 1 1/2 HHCS
32	8	SSHC25128	3/8-16 X 2 HEX CAP
33	2	SSHC41160	5/8-11X2-1/2 HEX CAP
34	2	SSHC98032	10-32X1/2 HEX HD
35	4	WWF5/8	WASHER,FLAT,5/8
36	1	WWF5/16	WASHER,FLAT,5/16
37	10	WWFS1/4	WASHER,FLAT,SAE,1/4
38	17	WWFS3/8	WASHER,FLAT,SAE,3/8
39	2	WWFS10	WASHER, FLAT, #10, SAE
40	10	WWL1/4	WASHER,LOCK, 1/4
41	17	WWL3/8	WASHER,LOCK, 3/8
42	2	WWL5/8	WASHER,LOCK 5/8
43	1	WWL5/16	WASHER,LOCK, 5/16
44	2	WWL10	WASHER,LOCK,#10

1390473 Motor Reducer Assembly

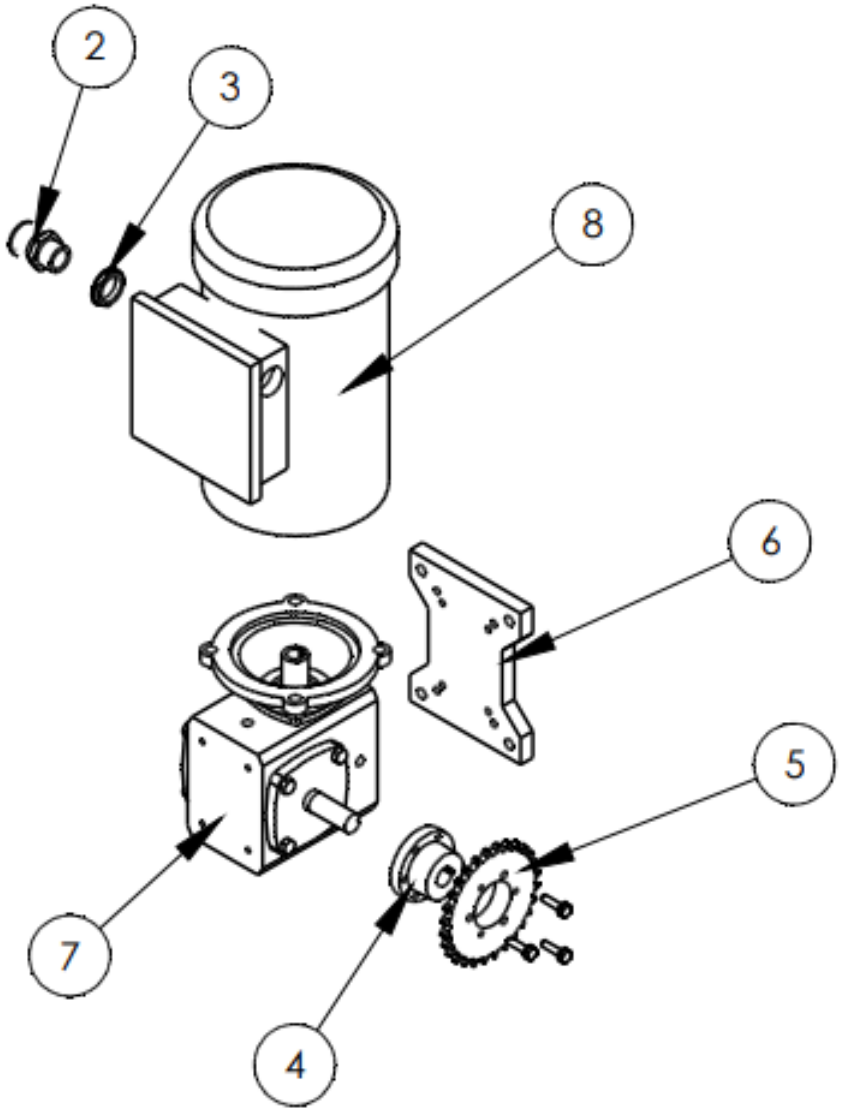
AAC Drawing Number 1390473 Rev 3



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

1390979 Motor Assembly

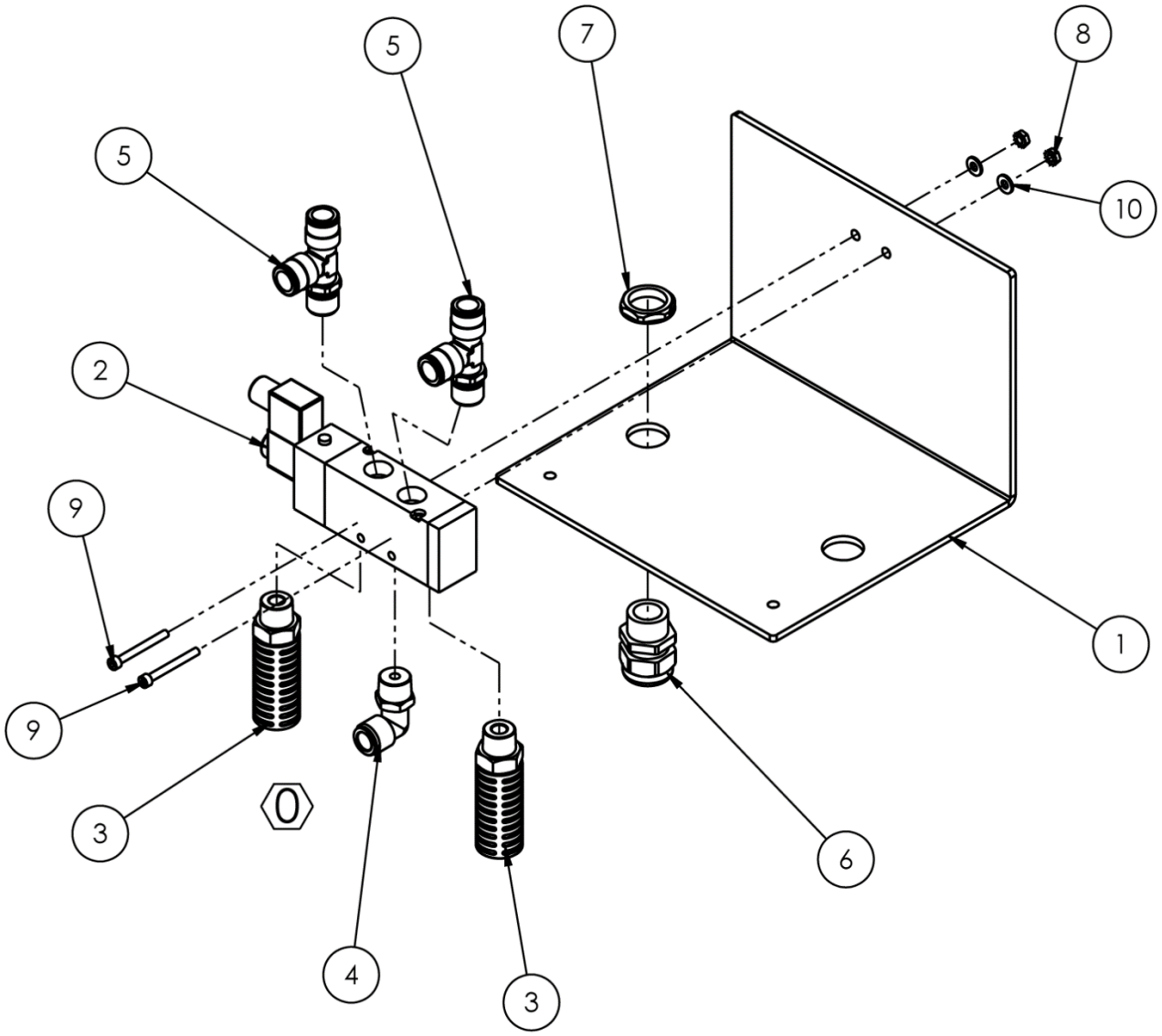
AAC Drawing Number 1390979 Rev 0



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	51494	LUBRICANT,MOBIL SHC634
2	1	FF3460	STRAIN RELIEF,LIQ TIGHT
3	1	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK
4	1	MM3/4SH	HUB, TAPERLOCK
5	1	MM40SH28H	SPROCKET, 1/2 P, 28T
6	1	MM56438	HORIZONTAL BASE,CI U
7	1	MMF71520B5J	SPEED REDUCER,WORM,
8	1	MMVM3542	MOTOR,3PH,3/4HP,230/460V

1391035 Cross Seal Valve Assembly

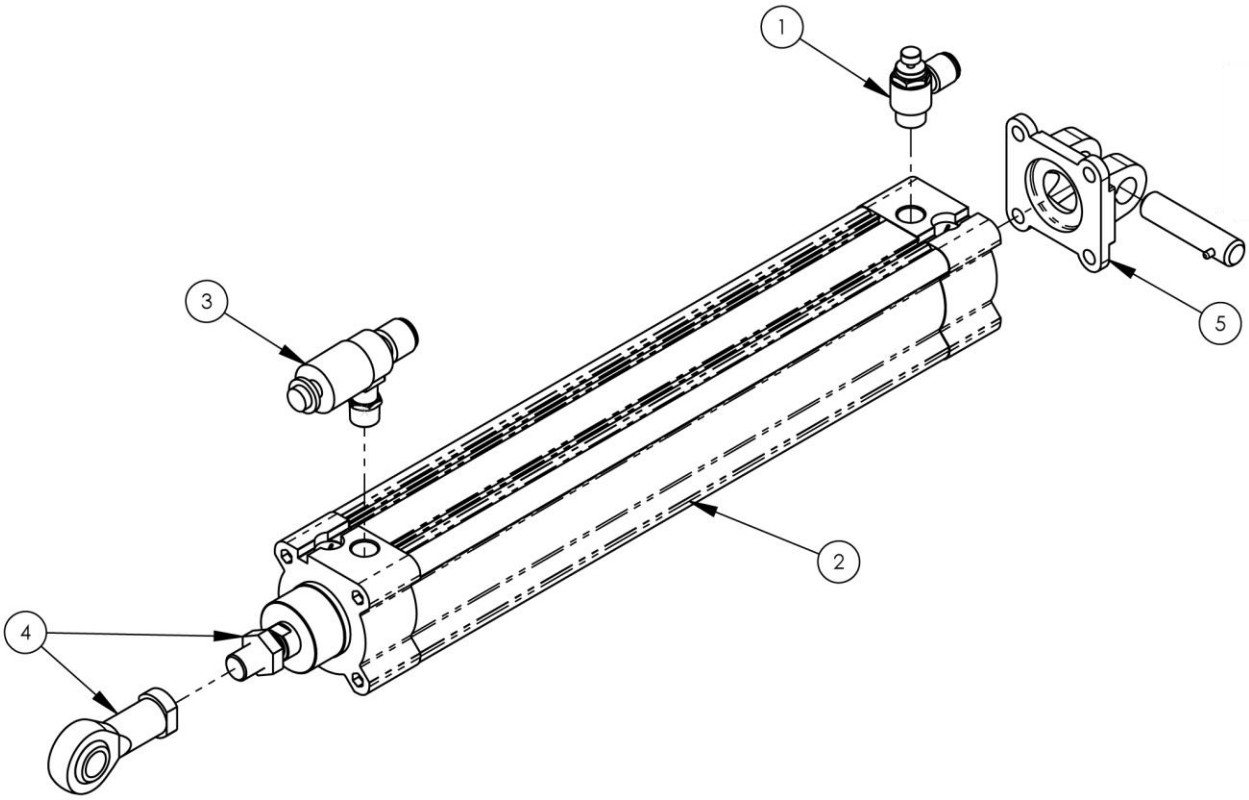
AAC Drawing Number 1391035 Rev 1



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

1391062 Cylinder Assembly, Large Infeed Roll

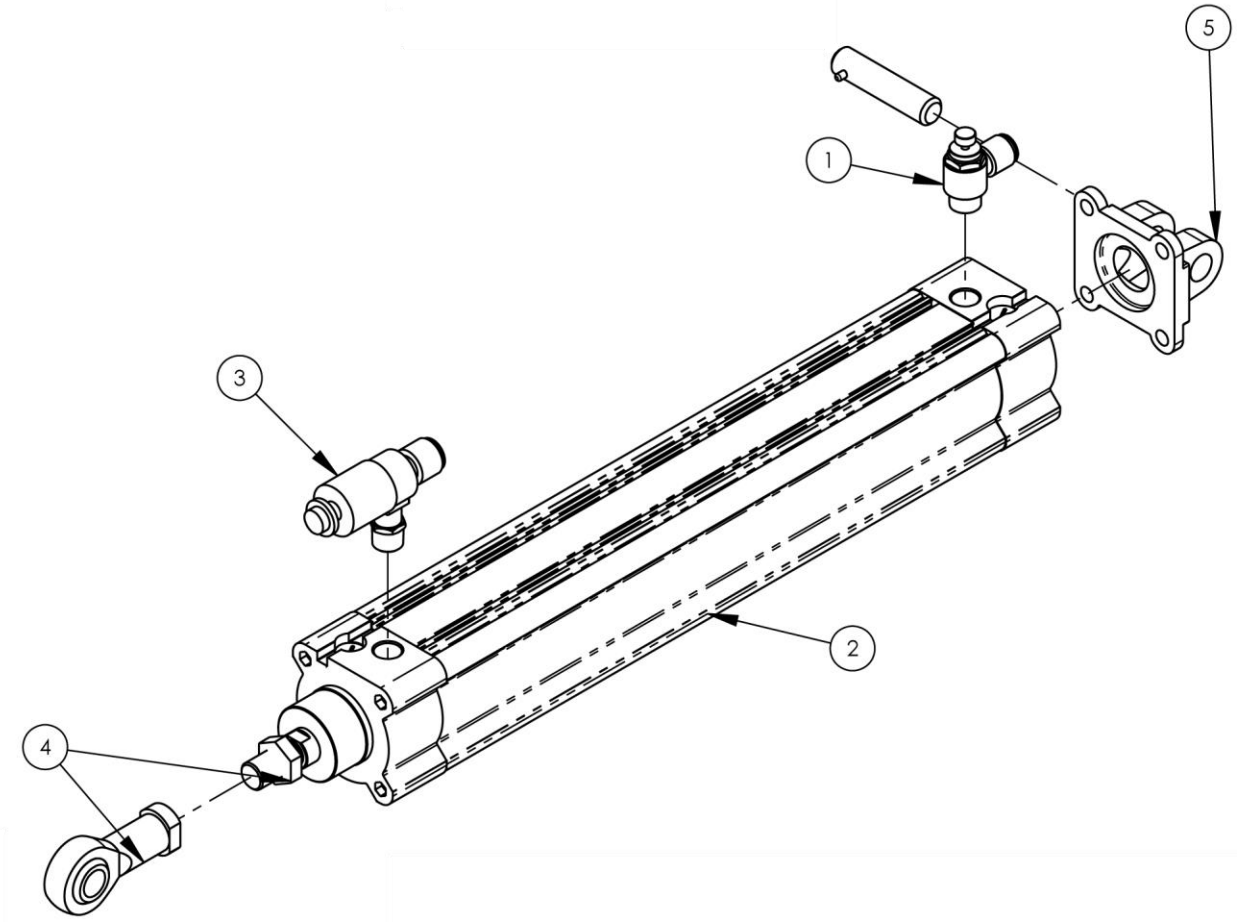
AAC Drawing Number 1391062 Rev 0



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

1391063 Cylinder Assembly, Large Infeed Roll

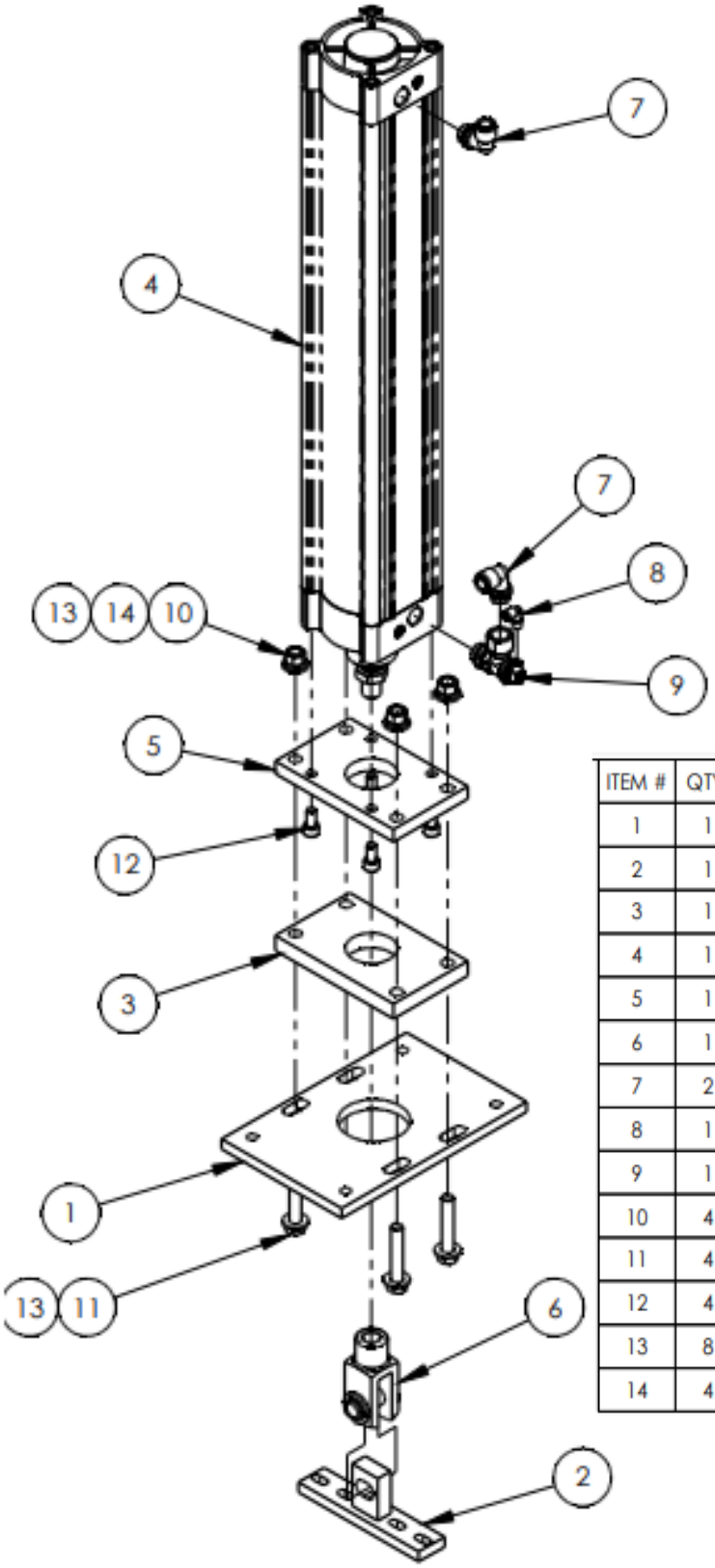
AAC Drawing Number 1391063 Rev 1



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

1391071 Cross Seal Cylinder Assembly

AAC Drawing Number 1391071 Rev 2

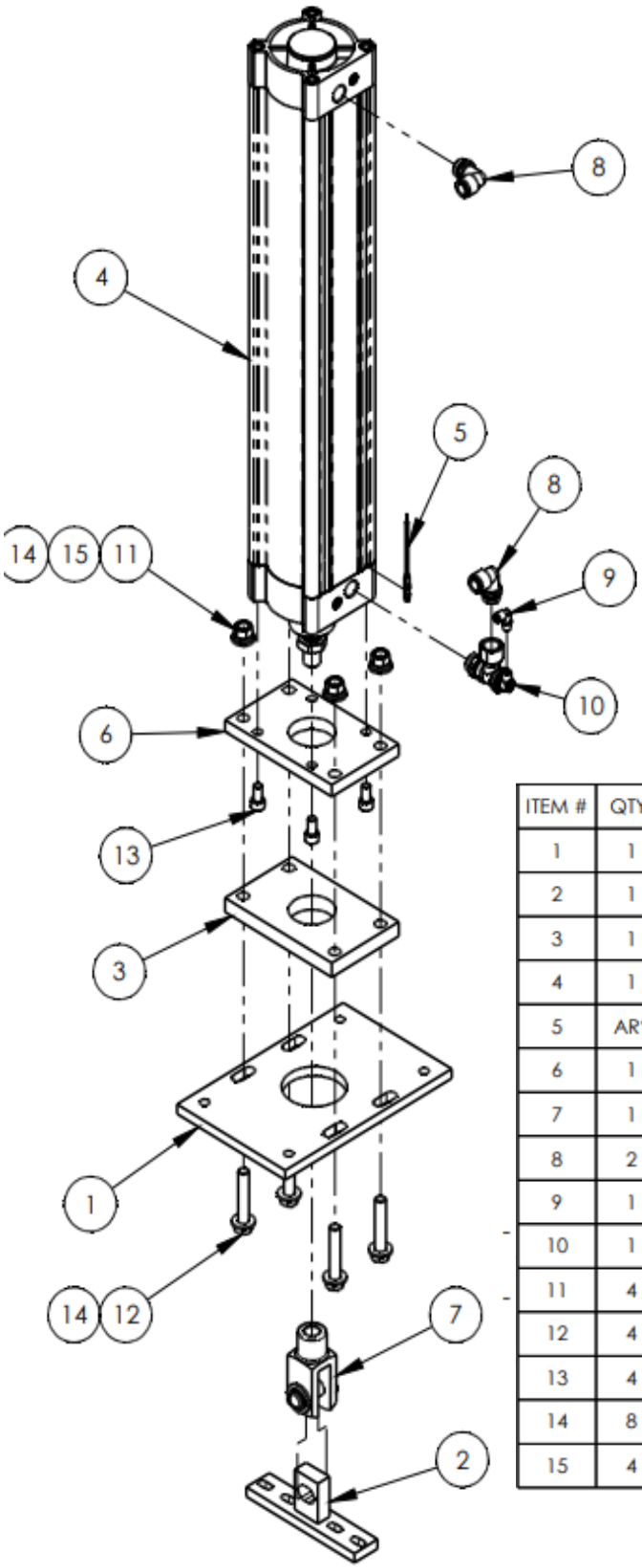


ITEM #	QTY.	PART #	DESCRIPTION
1	1	1391072	CYLINDER MOUNT PLATE-END
2	1	1391073	CROSS SEAL CYL. MNT
3	1	1391075	SPACER,MOUNTING PLT,- DNC
4	1	AACDNCB100600PP	CYLINDER, AIR, ISO, 100BX600 METRIC ISO
5	1	AAFNC100	FLANGE,MOUNTING PLT,- DNCB100610
6	1	AAFSGM20X15	CLEVIS,ROD,M20 X 1.5
7	2	AAQME-2-2U	FITTING, 1/2T-1/2 UNIFIT
8	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
9	1	AAV78862121	VALVE, BLOCKING, R1/2
10	4	NNH1/2-13	NUT,HEX,1/2-13
11	4	SSHC45176	1/2-13X2-3/4 HEX CAP
12	4	SSSCM10X20	CAP SCREW 10MM X 20MM
13	8	WWFS1/2	WASHER,FLAT,1/2, SAE
14	4	WWL1/2	1/2 LOCK WASHER

- ONLY USE THE WASHERS PROVIDED WITH THE CLEVIS.
- DO NOT USE THE JAM NUT PROVIDED WITH THE CLEVIS, USE THE ONE FROM THE CYLINDER.

1391145 Cross Seal Cylinder Assembly

AAC Drawing Number 1391145 Rev 2



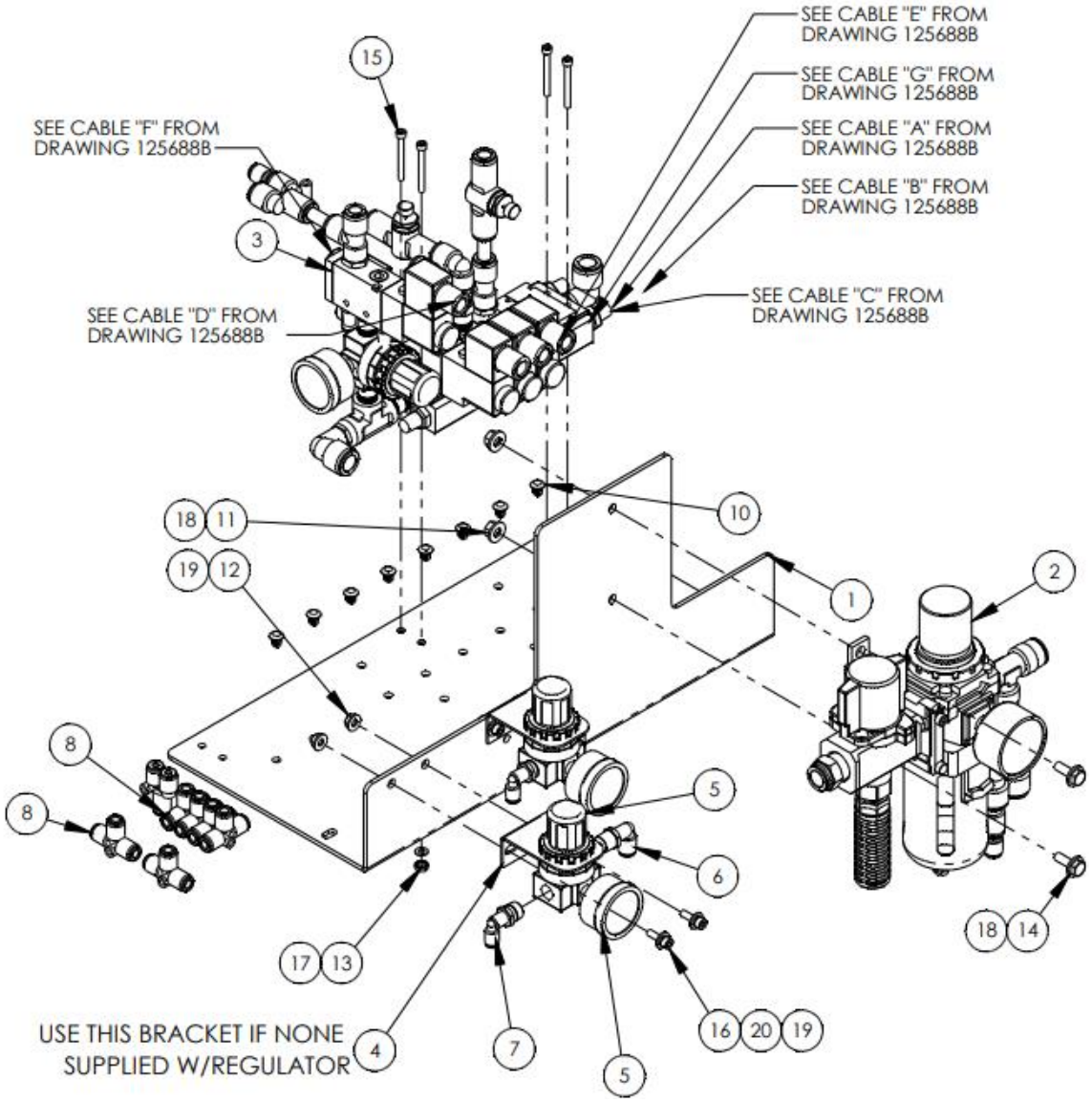
ITEM #	QTY.	PART #	DESCRIPTION
1	1	1391072	CYLINDER MOUNT PLATE-END
2	1	1391073	CROSS SEAL CYL. MNT
3	1	1391075	SPACER,MOUNTING PLT,- DNC
4	1	AACDNCB100600PP	CYLINDER, AIR, ISO, 100BX600 METRIC ISO
5	AR*	AAESME8MDS24	SENSOR FOR FESTO ISO CYL
6	1	AAFNC100	FLANGE,MOUNTING PLT,- DNCB100610
7	1	AAFSGM20X15	CLEVIS,ROD,M20 X 1.5
8	2	AAQME-2-2U	FITTING, 1/2T-1/2 UNIFIT
9	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
10	1	AAV78862121	VALVE, BLOCKING, R1/2
11	4	NNH1/2-13	NUT,HEX,1/2-13
12	4	SSHC45176	1/2-13X2-3/4 HEX CAP
13	4	SSSCM10X20	CAP SCREW 10MM X 20MM
14	8	WWFS1/2	WASHER,FLAT,1/2, SAE
15	4	WWL1/2	1/2 LOCK WASHER

*AS REQUIRED - THIS SENSOR REPLACES THE OLD STYLE AAESME8KLED24 FOR THE OLD STYLE CYLINDERS. PLEASE REFER TO 1391162 CABLE KIT.

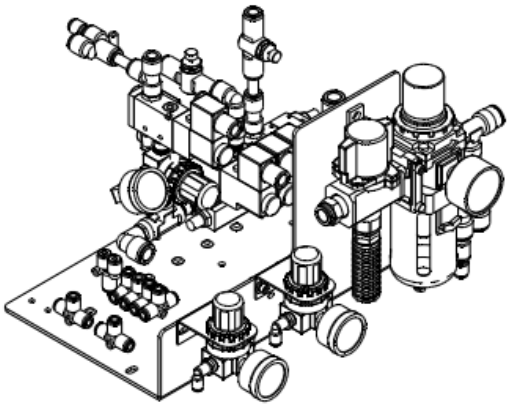
- ONLY USE THE WASHERS PROVIDED WITH THE CLEVIS.
- DO NOT USE THE JAM NUT PROVIDED WITH THE CLEVIS, USE THE ONE FROM THE CYLINDER.

13901040 Valve Bank Assembly

AAC Drawing Number 13901040 Rev 0



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1391105	PLATE, MOUNTING
2	1	1391116	MAIN REGULATOR ASSEMBLY
3	1	13901039	VALVE STACK ASSY
4	2	4130-002	BRACKET, REGULATOR
5	2	AAMSR20008	REGULATOR, 0-140 PSI RELIEVING, W/BRKT.
6	2	AAQME-4-4	ELBOW, MALE,Q, 1/4 TUBE, 1/4 NPT
7	2	AAQME-5-4	ELBOW, MALE 5/32X1/4NPT
8	6	AAQUT-4-4	QUICK UNION T 1/4X1/4
9	1	AAQUY-5-4	Y UNION, 5/32X1/4
10	8	EEPBMSH25C	MOUNT,CABLE TIE,NYLON
11	2	NNK1/4-20	KEP NUT, 1/4-20
12	4	NNK10-32	KEP NUT, 10-32
13	4	NNK8-32	KEP NUT, 8-32
14	2	SSHC01048	1/4-20 X 3/4 HEX CAP
15	4	SSSC90096	#8-32 X 1-1/2 SOC CAP SC
16	4	SSSC98040	10-32 X 5/8 SOC CAP
17	4	WWF8	WASHER, FLAT, #8
18	4	WWFS1/4	WASHER,FLAT,SAE,1/4
19	8	WWFS10	WASHER, FLAT, #10, SAE
20	4	WWL10	WASHER,LOCK,#10

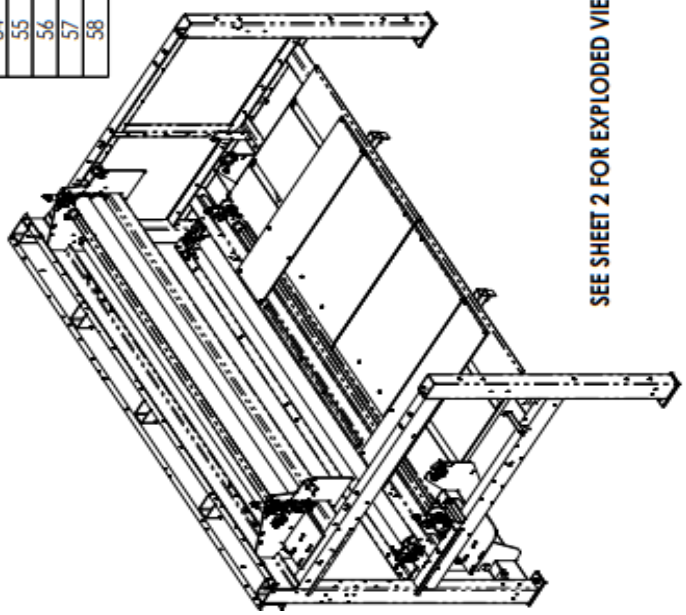


13901101 Input Conveyor Assembly #1

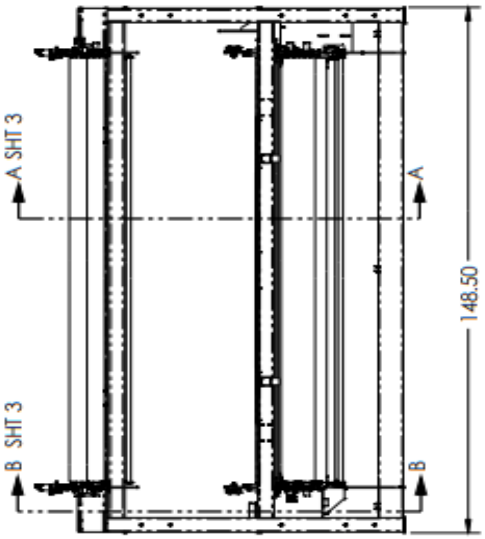
AAC Drawing Number 13901101 Rev 3

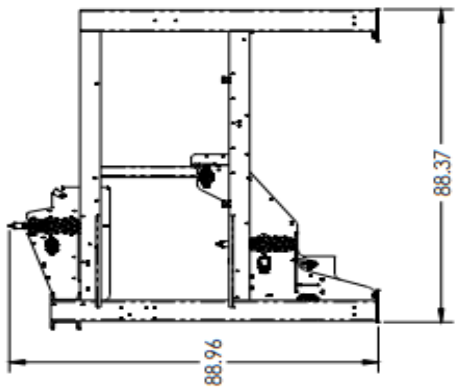
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1390224	ROLLER, DRIVE ASSY
2	2	1390360	ROLLER ASSY,4-1/4",DRIVE
3	2	1390365	ROLLER ASSY,4-1/4",IDLER
4	4	1390378	PINCH ROLLER AIR CLAMP
5	7	1390491	SHAFT, STUD
6	1	1390698	ROLLER, IDLER, FILM
7	2	1390699	WELDMENT, IDLER ROLLER
8	2	1391132	BRACKET, POT MNT.
9	2	1391133	SHAFT, DANCER BAR
10	2	1391147	COVER-POT, DANCER ARM
11	2	1391151	BAR,DANCER ASBLY
12	1	1391432	SHAFT, STUD, LONG
13	2	1391461	PLATE, TOP
14	1	13901105	BELT SLIDE PLATE, LEFT
15	1	13901106	BELT SLIDE PLATE, RIGHT
16	1	13901107	BELT SPACER-IN-FEED
17	1	13901125	FRAME WELDMENT, INPUT
18	2	13901224	SLIDE PLATE, 14" WIDE
19	2	13901557	PLATE, NUT, 3/8-16@2.00 CTC
20	1	13901558	TUBE,F,4X4X.25WX135.25L
21	2	CCCL6F	CLAMP COLLAR- 3/8
22	1	MM1JA	HUB, TAPERLOCK,1 B
23	1	MM11/4SH	HUB, TAPERLOCK
24	1	MM40JA15H	SPROCKET, 1/2 P, 15T
25	1	MM40SH25H	SPROCKET, 1/2 P, 25T
26	2	MMUCPA207-20	1.25" BEARING
27	2	NNE3/8-16	NUT, ELASTIC 3/8-16
28	16	NNE10-32	NUT,ELASTIC LOCK
29	4	NNH1/2-13	NUT,HEX,1/2-13
30	2	NNH3/8-16	NUT,HEX,3/8-16
31	28	NNH5/16-18	NUT,HEX, 5/16-18
32	8	NNJ3/8-16	3/8-16 JAM NUT
33	2	NNK8-32	NUT,KEP,8-32
34	19"	PPP40	CHAIN,#40 RIVET
35	1	PPP40CL	LINK,CONNECTING,#40
36	4	SSFC98048	#10-32 X .75 SHCSF
37	28	SSHC10096	5/16-18 X 1-1/2 HHCS
38	4	SSHC25096	3/8-16 X 1 1/2 HHCS
39	8	SSHC25096F	3/8-16 X 1 1/2 HEX HEAD
40	2	SSHC25224F	3/8-16 X 3.5 HHCS, FULL T
41	4	SSHC45080	1/2-13X1-1/4 HEX CAP
42	4	SSHC45128	1/2-13 X 2,HEX CAP
43	6	SSPP90024	8-32X3/8 PAN PHLPS
44	20	SSPS98048	#10-32X3/4 PAN HD SLTD
45	2	SSSC90048	#8-32 X 3/4 SOC CAP SC
46	10	UUCFB205-16	BEARING, FLANGE, 3 BOLT
47	2	UUCFL207-20	1.25" BEARING, FLANGE
48	8	UUCT207-20	PEER207-TAKEUP-BEARING
49	6	WWF8	WASHER, FLAT, #8
50	16	WWFS1/2	WASHER,FLAT,1/2, SAE

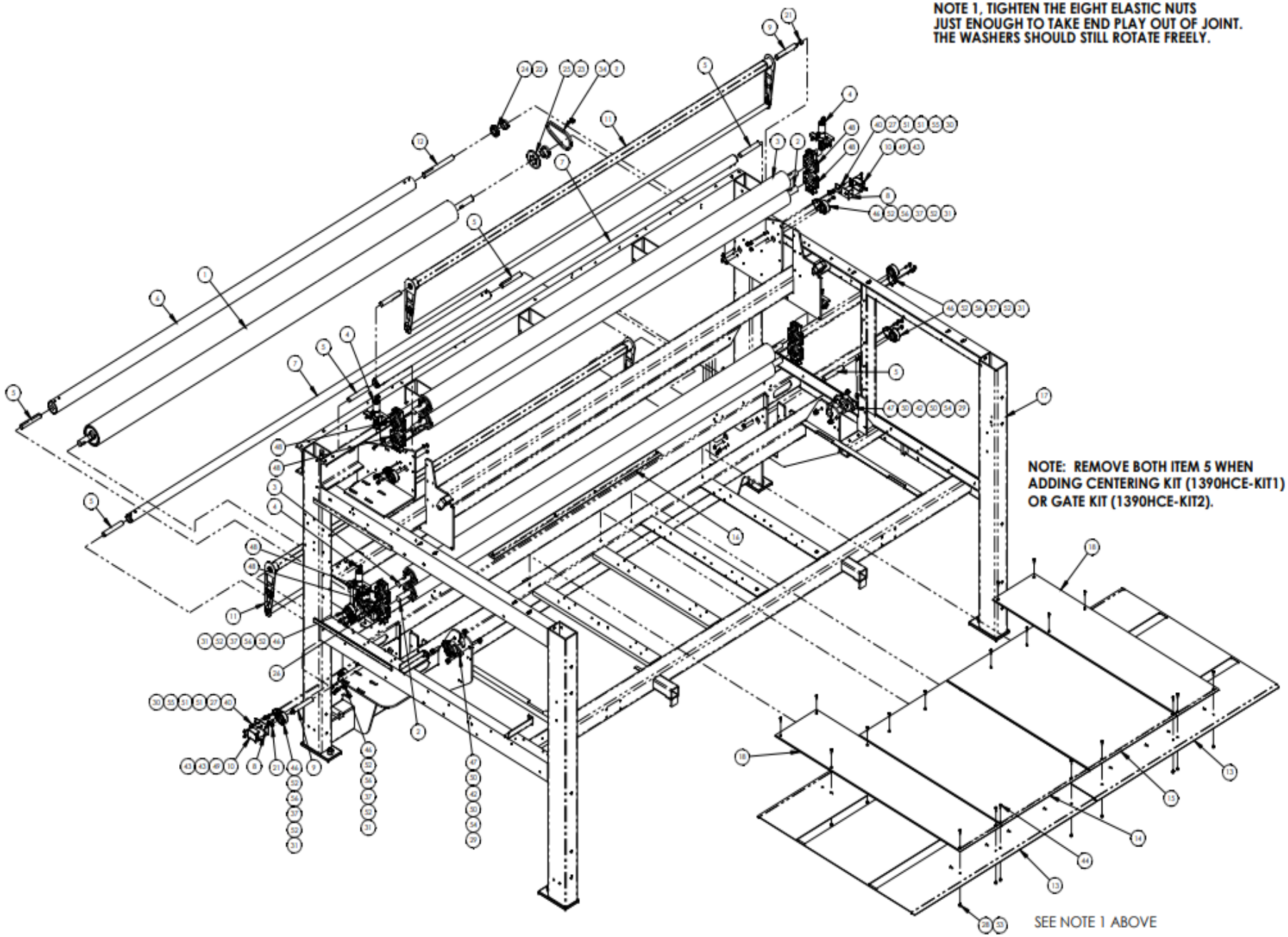
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
51	8	WWFS3/8	WASHER,FLAT,SAE,3/8
52	56	WWFS5/16	WASHER,FLAT,SAE,5/16
53	16	WWFS10	WASHER, FLAT, #10, SAE
54	4	WWL1/2	1/2 LOCK WASHER
55	6	WWL3/8	WASHER,LOCK, 3/8
56	28	WWL5/16	WASHER,LOCK, 5/16
57	6	WWL8	WASHER,LOCK,#8
58	1	ZZZSH-310	DOUBLE SIDED TAPE

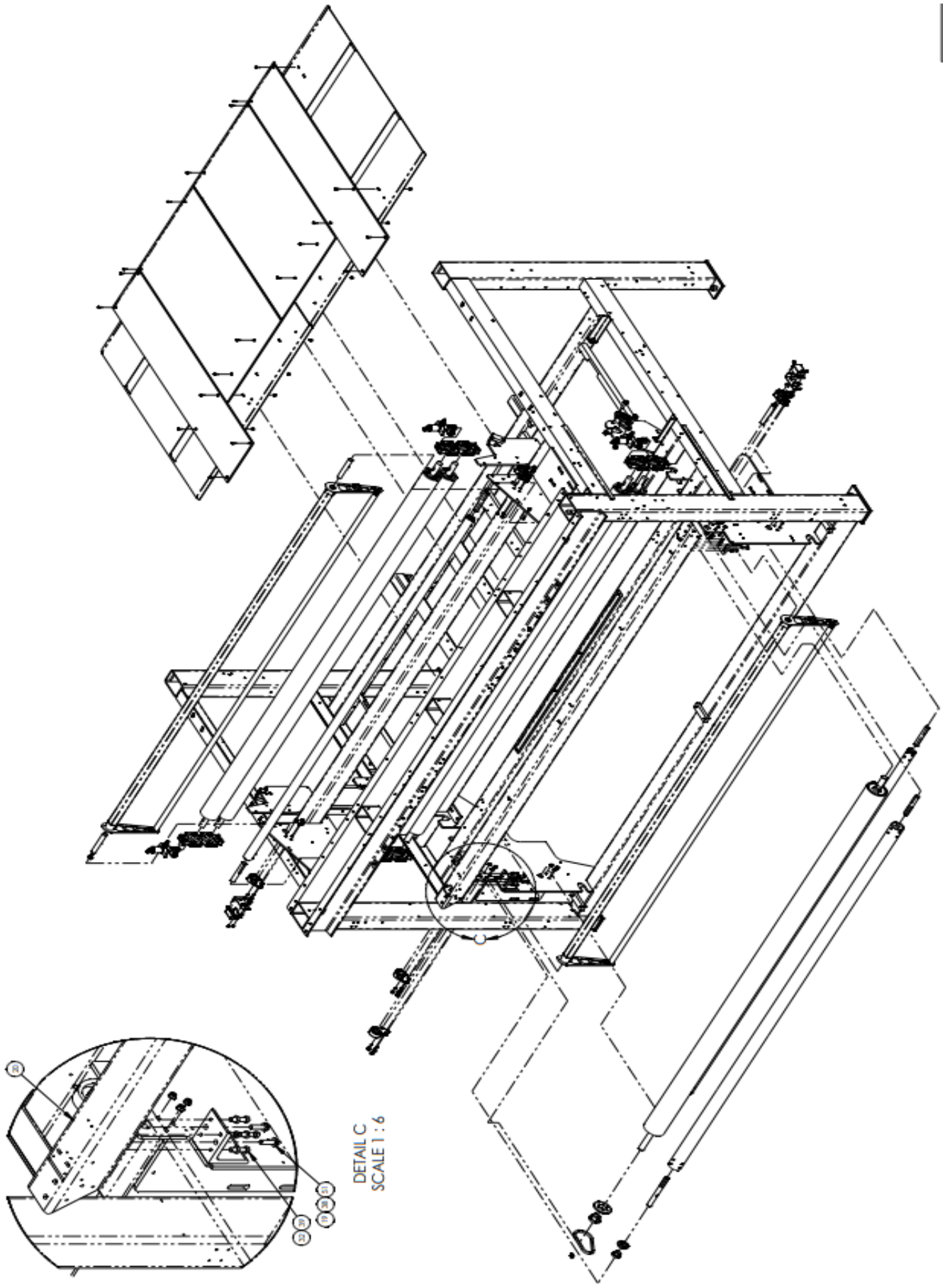


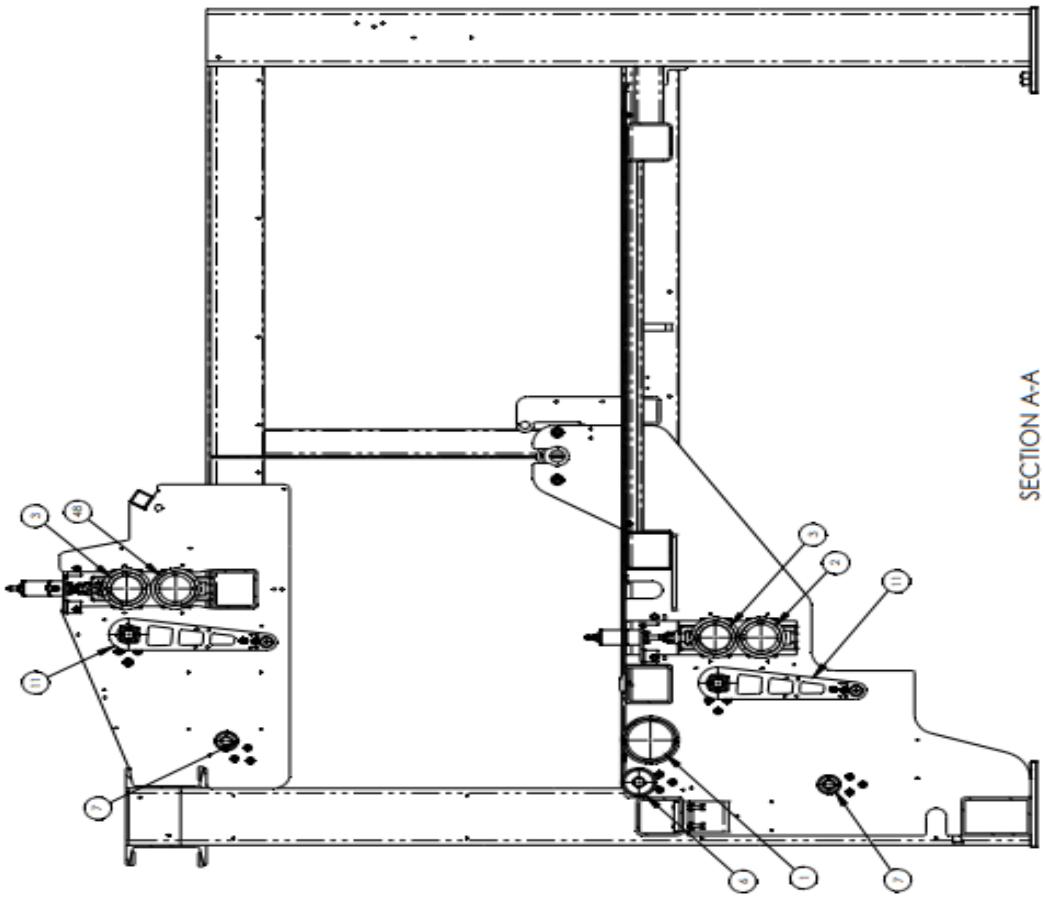
SEE SHEET 2 FOR EXPLODED VIEWS

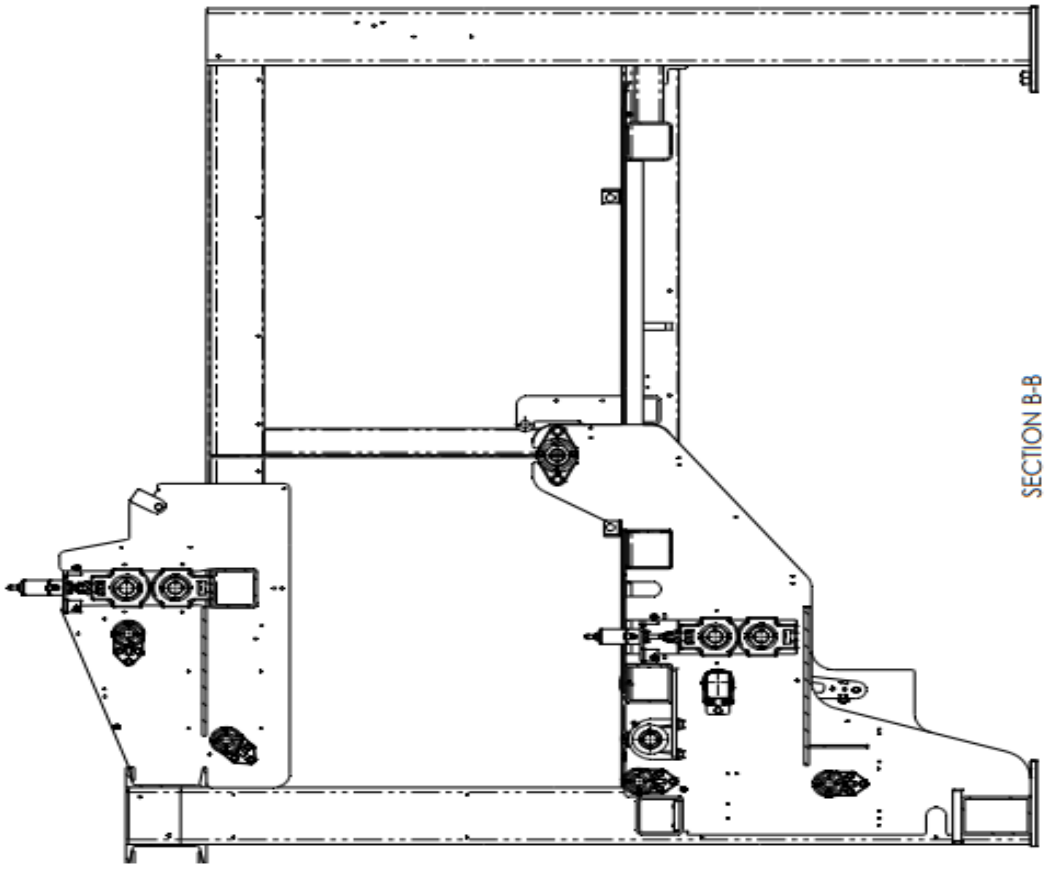





NOTE 1, TIGHTEN THE EIGHT ELASTIC NUTS
JUST ENOUGH TO TAKE END PLAY OUT OF JOINT.
THE WASHERS SHOULD STILL ROTATE FREELY.
NOTE: REMOVE BOTH ITEM 5 WHEN
ADDING CENTERING KIT (1390HCE-KIT1)
OR GATE KIT (1390HCE-KIT2).
SEE NOTE 1 ABOVE

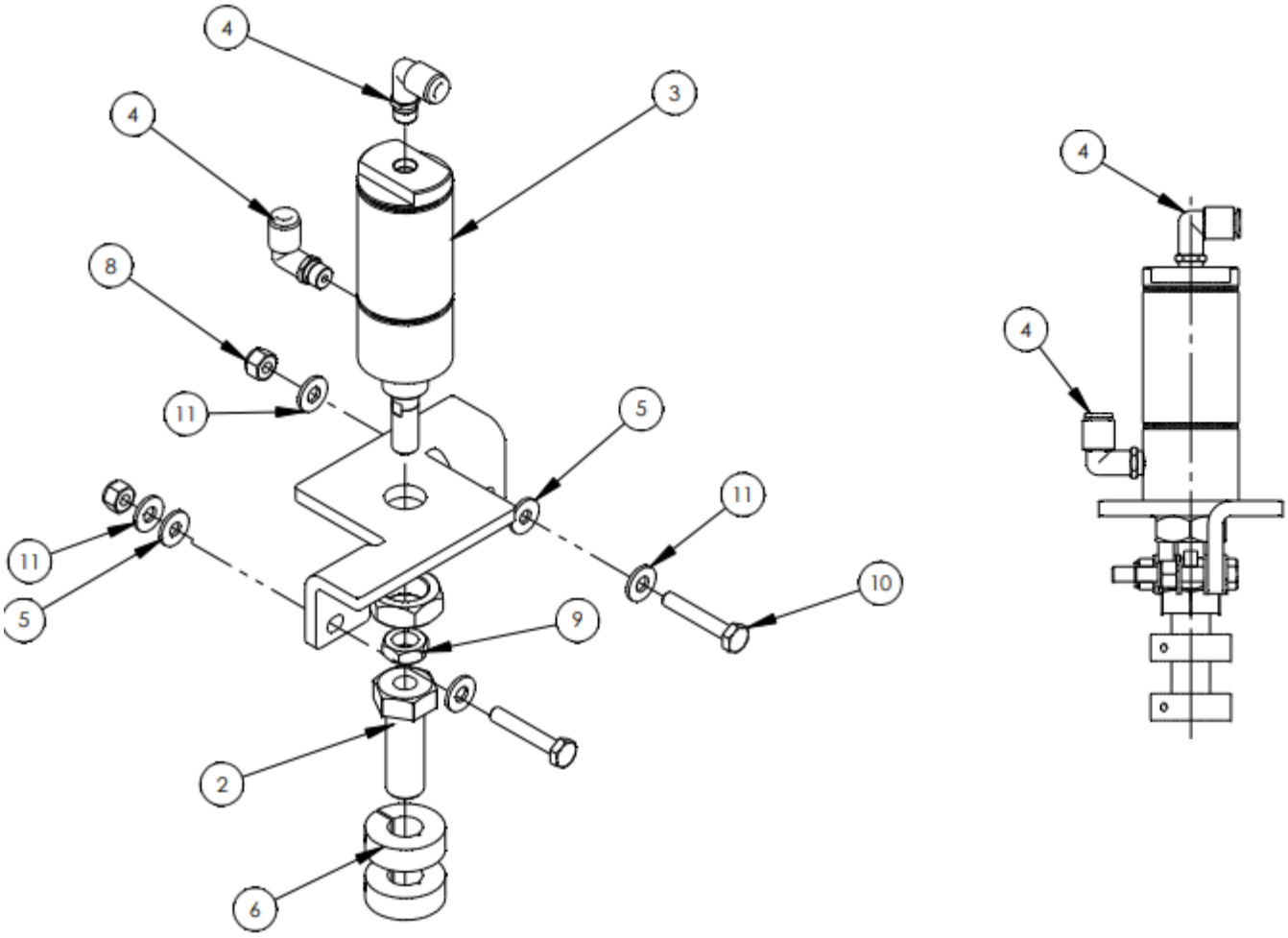

DETAIL C
SCALE 1 : 6


SECTION A-A


SECTION B-B

1390378 Pinch Roller Air Clamp

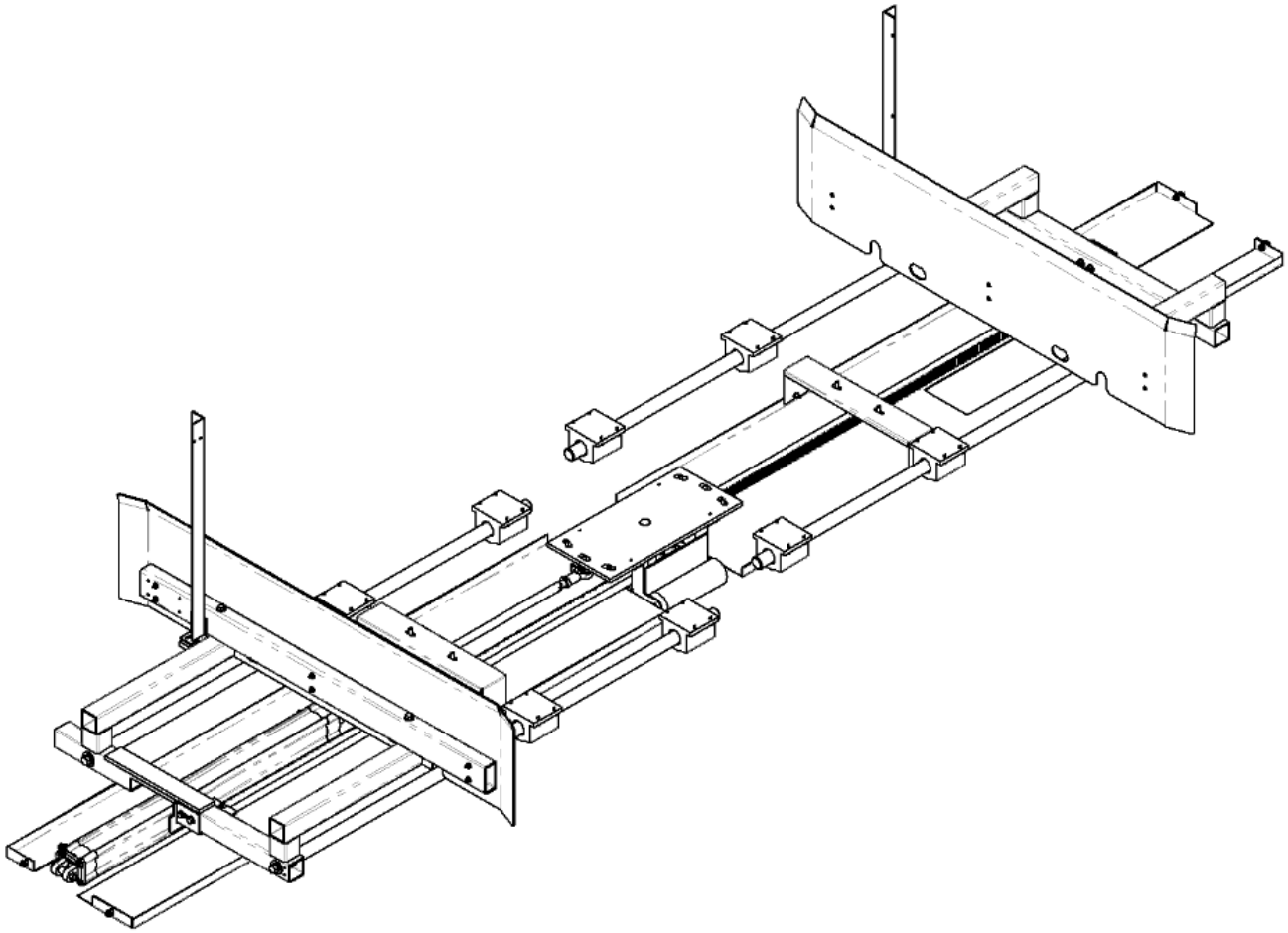
AAC Drawing Number 1390378 Rev 1

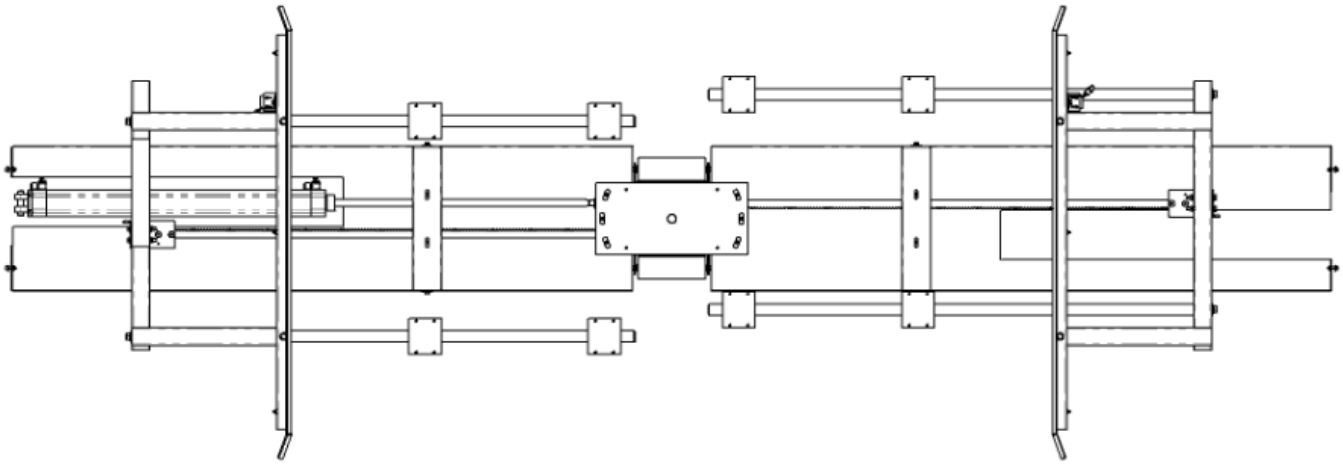


ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1390264	PLATE, ROLL LIFT
2	1	1390377	ADAPTOR, ROD END
3	1	AAC171D	CYLINDER,AIR,DA,1-1/2 B,1 ST
4	2	AAQME-4-8	QUICK MALL ELBOW, 1/4 T
5	2	BBTT601	WASHER,THRUST,BRONZE
6	2	CCCL10FT	CLAMP COLLAR, THD. 5/8-18
8	2	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
9	1	NNJ7/16-20	NUT,JAM,7/16-20
10	2	SSHC01096	1/4-20 X 1-1/2 HHCS
11	4	WWFS1/4	WASHER,FLAT,SAE,1/4

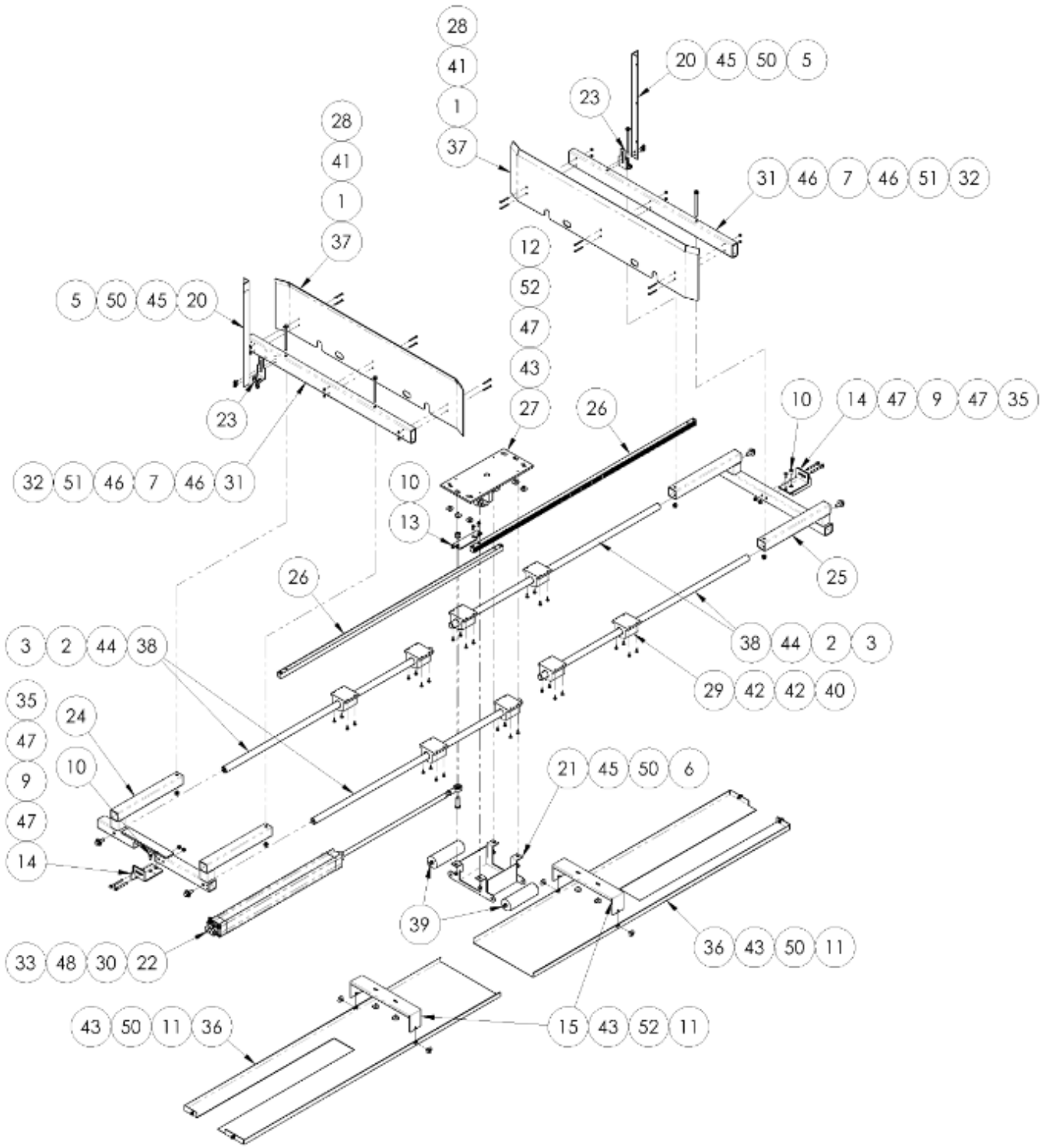
1390HCE-KIT1 (Optional) Centering Guide

AAC Drawing Number 9009059 Rev 2





Centering Guide Parts Diagram

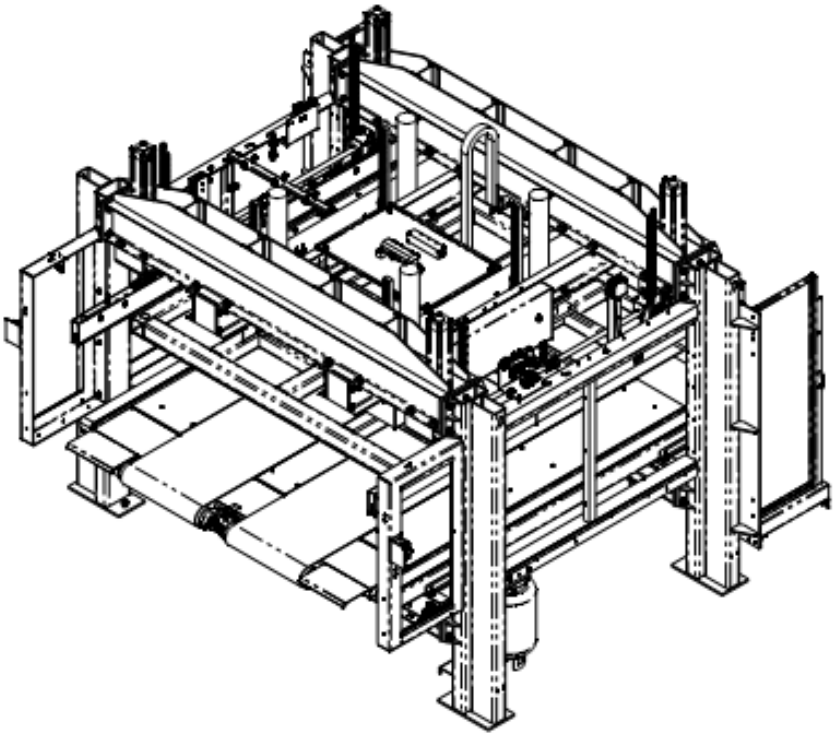


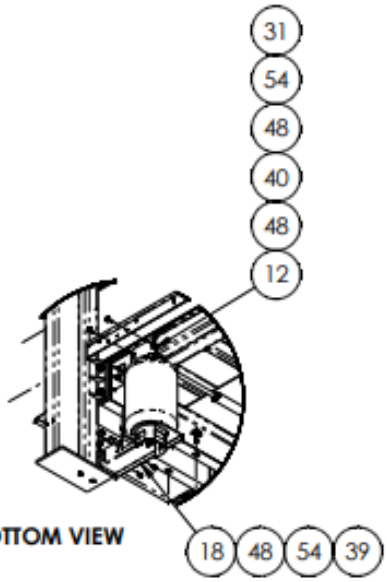
1390HCE-KIT1 parts list

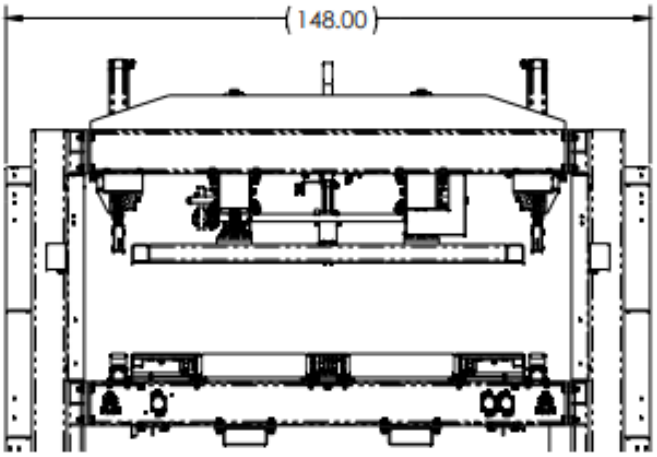
ITEM	QTY	PART NUMBER	DESCRIPTION
1	12	SSFC98128	#10-32 X 2 FLAT CAP
2	4	WWL1/2	1/2 LOCK WASHER
3	4	SSHC45096	1/2-13X1-1/2 HEX CAP
4	4	SSSC01056	1/4-20 X 7/8 SOC CAP
5	4	SSHC01048	1/4-20 X 3/4 HEX CAP
6	4	SSSC01032	1/4-20X1/2 SOC CAP
7	4	SSHC25352	3/8-16X5-1/2,HEX CAP
8	*1	AATP3/8	3/8" OD POLYURETHANE
9	4	SSHC10192	5/16-18 X 3 HEX CAP SC
10	6	SSFC10056	5/16-18 X 7/8 FLAT HD CAP
11	8	SSHC20048	5/16-24 X 3/4 HEX CAP
12	6	SSSC20048	5/16-24X3/4 SOC CAP
13	1	1391472	BRACKET, GEAR RACK PULLER
14	2	1391470	BRACKET, GEAR RACK PUSHER
15	2	1391698	BRACKET, GUARD SUPPORT
16	*1	4080101-134	CABLE ASSY,12MM,BLU/BLK/BRN,134"
17	*1	4080101-170	CABLE ASSY,12MM,BLU/BLK/BRN,170"
18	*1	4080100-29	CABLE ASSY,VALVE,DIN,29"
19	*1	4080100-40	CABLE ASSY,VALVE>SBUS,DIN, 40"
20	2	1391610	CABLE SUPPORT BRACKET
21	1	13901118	COVER, IDLER GEAR ASBLY
22	1	1391464	CYLINDER ASSY-INFEED SIDE
23	2	1406933	EYE/BKT ASSY, BLACK BORDERS
24	1	1391491	FRAME WELDMENT, PUSHER,LT
25	1	1391492	FRAME WELDMENT, PUSHER,RT
26	2	1391468	GEAR RACK, 10DP, 1" FACE
27	1	1391478	IDLER GEAR ASBLY
28	12	NNK10-32	KEP NUT, 10-32
29	8	MMP20	LIN.PILLOW-BLOCK,SEALIGN
30	1	1391695	MODIFIED 5/8-11 X 2 HHCS
31	2	1391483	MOUNT, GUIDE TUBE
32	4	NNH3/8-16	NUT,HEX,3/8-16
33	1	NNH5/8-11	NUT,HEX,5/8-11
34	4	NNK1/4-20	NUT,KEP,1/4-20
35	4	NNK5/16-18	NUT,KEP,5/16-18
36	2	1391626	PAN, GREASE GUARD
37	2	1391482	PLATE, PUSHER ASBLY
38	4	1391467	ROD,THOMSON,1-1/4OD
39	2	RM4408NG	ROLLER,2.5"DIA,8" BTW FRM
40	32	SSHC98048	SCREW, HEX CAP #10-32X.75
41	12	WWF10	WASHER, FLAT, #10, COM
42	32	WWFS10	WASHER, FLAT, #10, SAE
43	14	WWFE020	WASHER,FENDER,5/16
44	4	WWF1/2	WASHER,FLAT,1/2
45	16	WWFS1/4	WASHER,FLAT,SAE,1/4
46	8	WWFS3/8	WASHER,FLAT,SAE,3/8
47	14	WWFS5/16	WASHER,FLAT,SAE,5/16
48	1	WWL5/8	WASHER,LOCK 5/8
49	32	WWL10	WASHER,LOCK,#10
50	12	WWL1/4	WASHER,LOCK, 1/4
51	4	WWL3/8	WASHER,LOCK, 3/8
52	10	WWL5/16	WASHER,LOCK, 5/16

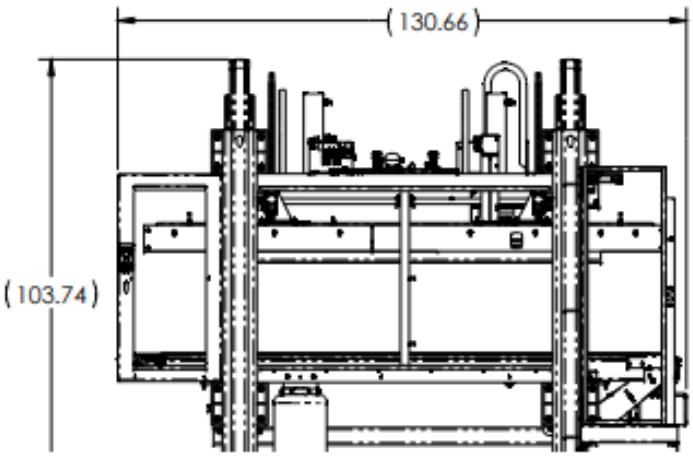
13901200 Exit Assembly / Conveyor

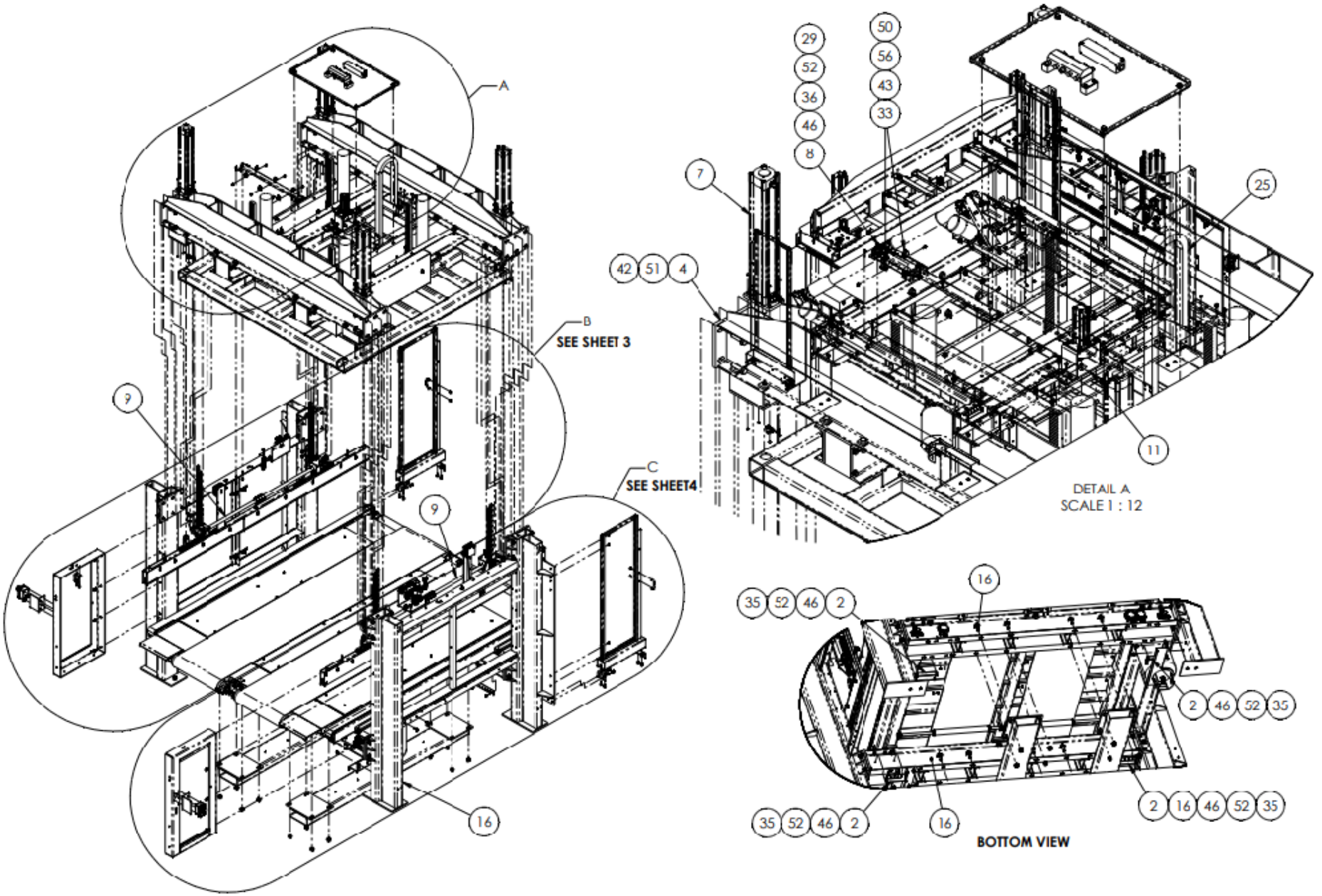
AAC Drawing Number 13901200 Rev 1










A
B
SEE SHEET 3
C
SEE SHEET4
9
9
16
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43
33
7
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42
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4
11
DETAIL A
SCALE 1 : 12
16
35
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46
2
2
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52
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2
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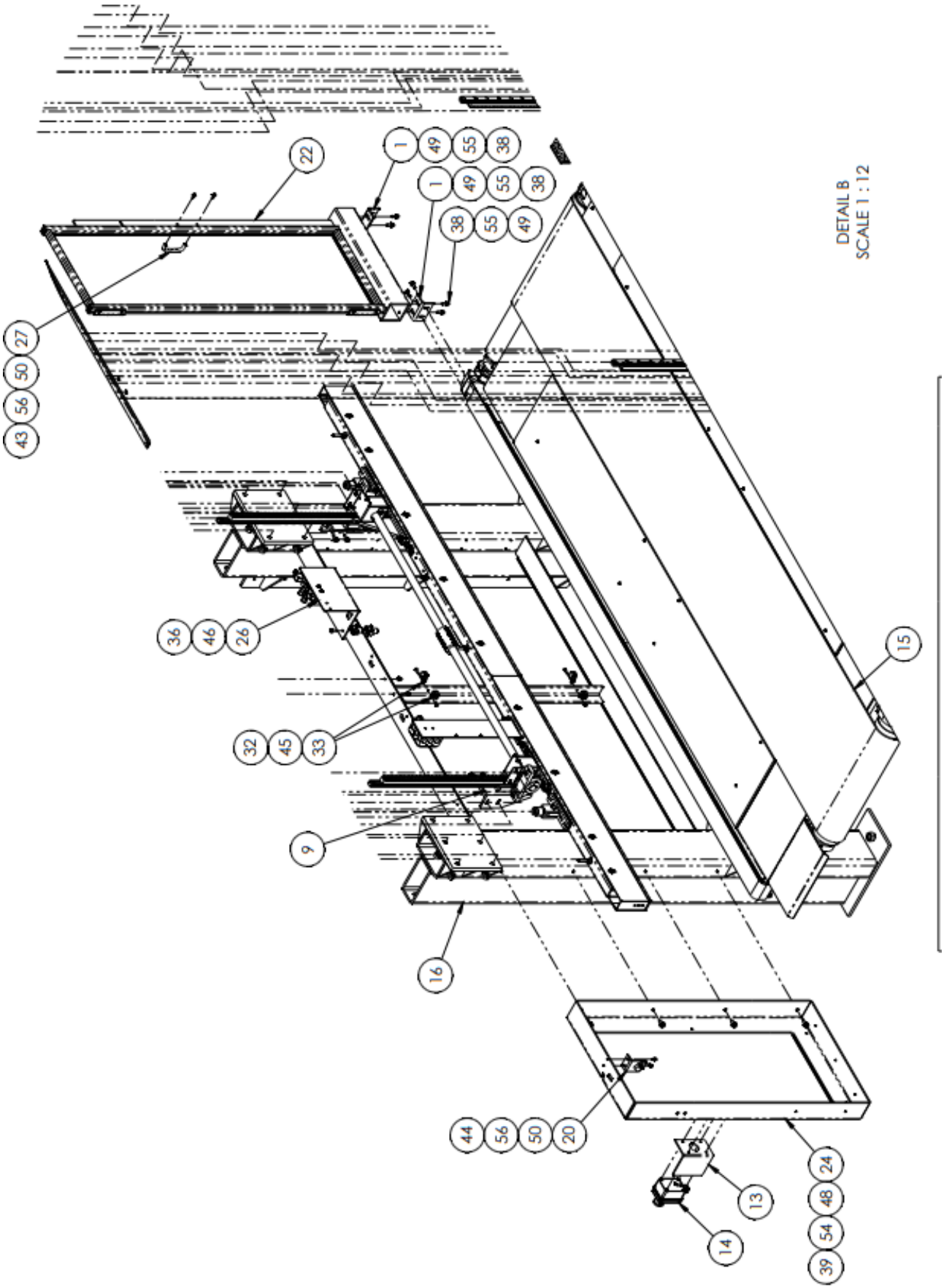
35
52
46
2
16
BOTTOM VIEW


DETAIL B
SCALE 1 : 12
22
1
49
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27
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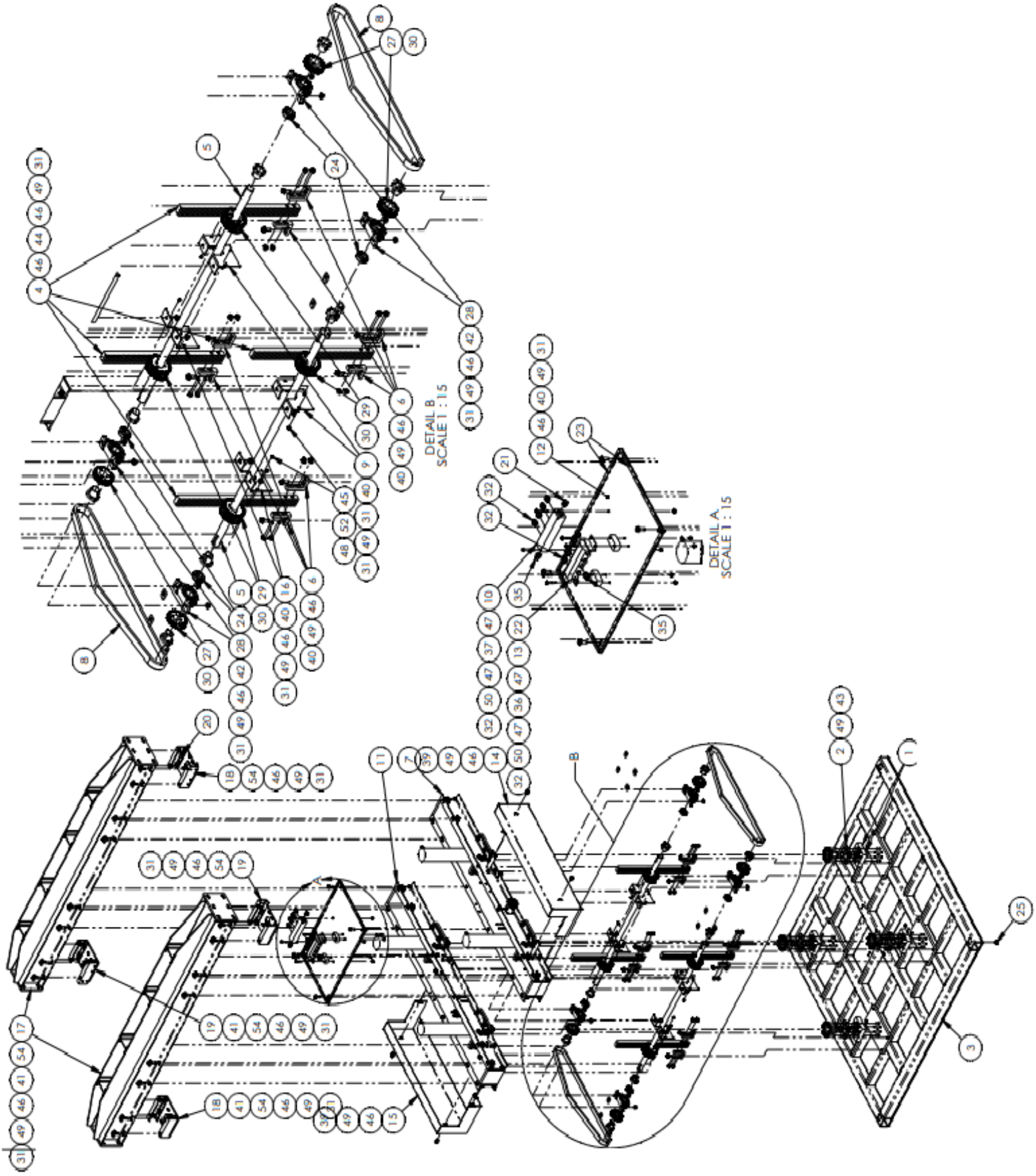
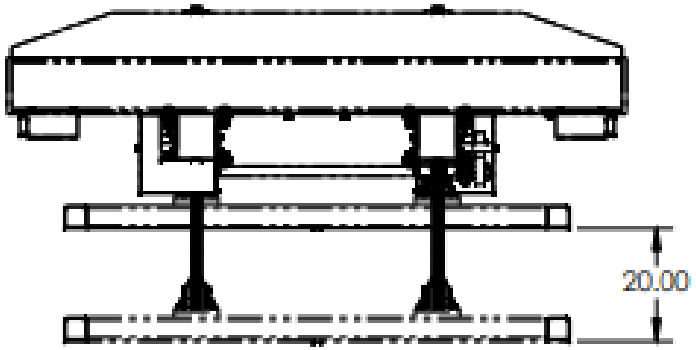
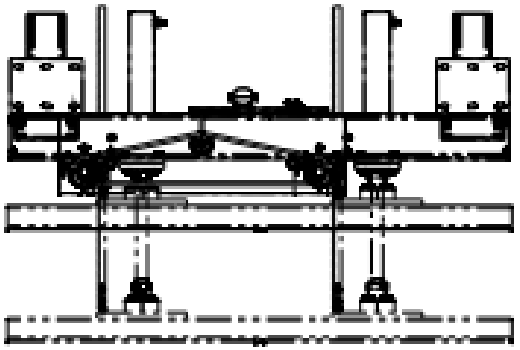
ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	4	1390384	PLATE, MOUNTING
2	4	1391176	MTG BRKT, SIX MODULE STAT
3	1	1406260	UPPER STOP EYE ASSY
4	1	1406570	HYD COMP,120" SIDESEAL
5	1	1406573	VALVE ASSY, SIDE SEAL, LH
6	2	1406595	CYLINDER ASSY. SIDE SEAL
7	2	1406596	CYLINDER ASSY. SIDE SEAL
8	1	1406621	HYDRAULIC HOSE SUPPORT
9	2	1406640	SIDE SEAL SYNC BAR ASSY
10	2	1406645	SIDE SEAL BAR ASSY, 110"
11	1	1406715	MATTRESS PIVOT ASSY
12	1	1406830	AIR TANK ASSY.
13	2	13901079	E-STOP GUARD, 1390HCD
14	2	13901082	BUTTON BOX, E-STOP/RESET
15	2	13901158	BELT, OUTPUT CONVEYOR
16	1	13901160	OUTFEED CONVEYOR ASSY
17	2	13901170	FORKLIFT TUBE WELDMENT
18	1	13901171	BOTTOM PLATE, AIR TANK
19	2	13901172	TUBE,F,4X4X.25WX22.3L
20	1	13901173	OUTFEED FULL EYE ASSY
21	1	13901178	DOOR FRAME, LEFT
22	1	13901179	DOOR FRAME, RIGHT
23	1	13901183	REAR GUARD FRAME WELDMENT, LEFT
24	1	13901184	REAR GUARD FRAME WELDMENT, RIGHT
25	1	14061320	PLATEN HEIGHT DETECT ASSY
26	1	14061322	VALVE ASSY, SIDE SEAL, RH
27	2	MM1897A24	HANDLE,DOOR,PULL,OVAL,5/8
28	1	MMT9945	TAPE,REFLECTIVE,2" WIDE
29	8	NNH1/4-20	NUT,HEX,1/4-20
30	40	NNH3/4-10	NUT,HEX,3/4-10
31	2	NNH3/8-16	NUT,HEX,3/8-16
32	3	NNH10-32	HEX-NUT 10-32 REG.
33	12	PPP2220	CLAMP,CABLE,1.0" OD
34	8	SSBC01032	1/4-20 X 1/2 BUT CAP SC
35	8	SSHC01048	1/4-20 X 3/4 HEX CAP
36	6	SSHC01064	1/4-20 X 1 HHCS
37	2	SSHC01096	1/4-20 X 1-1/2 HHCS
38	12	SSHC10064	5/16-18 X 1 HHCS
39	10	SSHC25064	3/8-16 X 1,HEX CAP
40	2	SSHC25080	3/8-16X1-1/4 HHCS
41	16	SSHC34160	3/4-10 X 2-1/2 HEX CAP
42	24	SSHC34192	3/4-10 X 3 HEX CAP
43	10	SSHC98040	10-32X5/8 HEX HD
44	2	SSSC98032	10-32X1/2, SOC CAP
45	3	SSSC98048	10-32 X 3/4 SOC CAP
46	22	WWFS1/4	WASHER,FLAT,SAE,1/4
47	48	WWFS3/4	WASHER, .797ID X 1-1/2OD
48	14	WWFS3/8	WASHER,FLAT,SAE,3/8
49	12	WWFS5/16	WASHER,FLAT,SAE,5/16
50	12	WWFS10	WASHER, FLAT, #10, SAE
51	24	WWFT3/4	WASHER, .797ID X 1-1/2OD
52	16	WWL1/4	WASHER,LOCK, 1/4
53	16	WWL3/4	3/4 LOCK WASHER
54	12	WWL3/8	WASHER,LOCK, 3/8
55	12	WWL5/16	WASHER,LOCK, 5/16
56	12	WWL10	WASHER,LOCK,#10
57	16	WWSQ096M	WASHER,SQUARE STRUCTURAL, MOD

1406570 Hydraulic Compression, 120” Side Seal

AAC Drawing Number 1406570 Rev 8







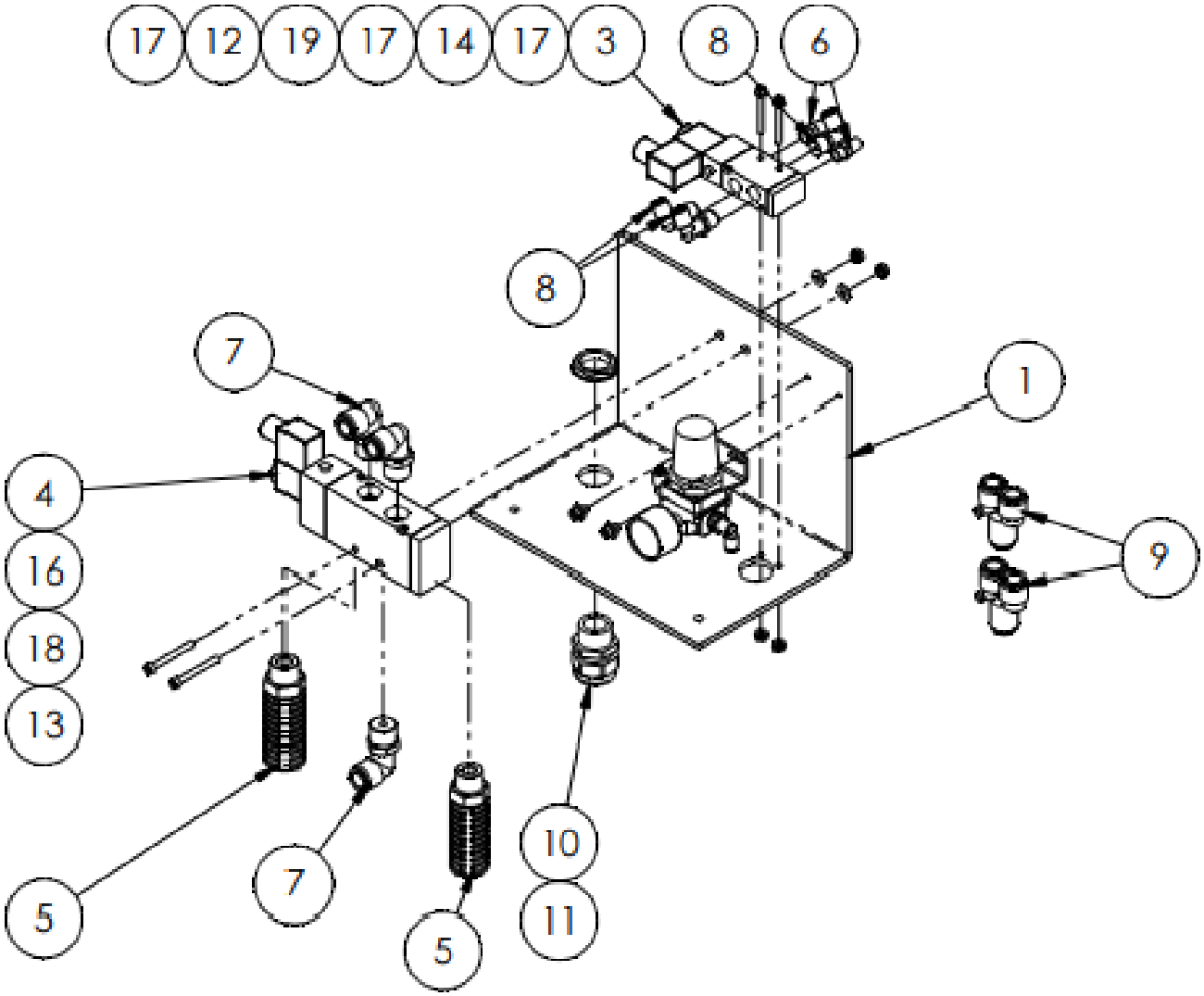
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	8	1406141	SPLIT COUPLING
2	4	1406150	SPLIT COUPLING PLATE
3	1	1406170	COMPRESSION PLATEN
4	4	1406191	GEAR RACK,6DP,2"F,20 PA
5	2	1406207	TRANSFER SHAFT
6	8	1406208	GEAR RACK MOUNT
7	1	1406210	PLATEN PRESS ASSY, LEFT
8	2	1406213	CHAIN, PLATEN TRANSFER
9	2	1406217	SPROCKET GUARD
10	1	1406219	HYDRAULIC MANIFOLD
11	1	1406220	PLATEN PRESS ASSY, RIGHT
12	1	1406223	MANIFOLD MOUNT PLATE
13	2	1406227	FLOW DIVIDER SPACER
14	1	1406520	PLATEN CHAIN GUARD, LEFT
15	1	1406525	PLATEN CHAIN GUARD, RIGHT
16	2	1406551	SPROCKET GUARD
17	2	1406562	PLATEN SUPPORT BEAM
18	2	1406599	SIDE SEAL CYL/GEARBOX MNT
19	2	1406601	SIDE SEAL CYL/GEARBOX MNT
20	32	1406894	WASHER, SQ STRUCT., .546ID,
21	1	HF50925K419	FITTING,HYD,PLUG
22	1	HYBEC-0FE	FLOW DIVIDER, HYD
23	10 FT	MM100-.125	DOOR TRIM - BLACK
24	4	MM6436K25	COLLAR,SPLIT,1.75ID,2PC
25	1	MM8087K16	PLUG,KNOCK-OUT,1"
26	*6	MM502030	Silicone Sealant Caulk
27	4	MMD50P22	SPROCKET,22T,50P,TYPE 12

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
28	4	MMGRP209-28	BEARING,PILLOW BLOCK,1.75
29	4	MMGYSS6P30	GEAR,SPUR,6P,30T,20PA
30	8	MMP1X1.75	BUSHING,SPLIT TAPER,1.75B
31	44	NNH1/2-13	NUT,HEX,1/2-13
32	6	NNH1/4-20	NUT,HEX,1/4-20
33	16	NNH3/4-10	NUT,HEX,3/4-10
32	8	PPP64000810	STR 3/4-16MJIC,7/8-14MORB
35	2	PPP64001010	STR 7/8-14MJIC,7/8-14MORB
36	4	SSHC01144	HEX HEAD, 1/4-20 X 2-1/4
37	2	SSHC01192	HEX HEAD BOLTS, 1/4-20 X 3
38	16	SSHC34176	3/4-10 X 2-3/4 HEX CAP
39	4	SSHC45064	1/2-13X1 HEX CAP
40	20	SSHC45112	1/2-13 X 1-3/4 HHCS, G8
41	16	SSHC45128	1/2-13 X 2,HEX CAP
42	8	SSHC45144	1/2-13X2-1/4 HEX CAP
43	32	SSHC45192	1/2-13X3 HEX CAP
44	8	SSHC45288	1/2-13X4-1/2 HEX CAP
45	6	SSHC98032	10-32X1/2 HEX HD
46	64	WWFS1/2	WASHER,FLAT,1/2, SAE
47	12	WWFS1/4	WASHER,FLAT,SAE,1/4
48	6	WWFS10	WASHER, FLAT, #10, SAE
49	88	WWL1/2	1/2 LOCK WASHER
50	6	WWL1/4	WASHER,LOCK, 1/4
51	16	WWL3/4	3/4 LOCK WASHER
52	6	WWL10	WASHER,LOCK,#10
53	32	WWSQ096M	WASHER,SQUARE STRUCTURAL, MOD
54	16	WWSQ08032SM	WASHER, SQ STRUCT., MOD

" * " ITEM(S) NOT SHOWN

1406573 Valve Assembly, Side Seal, LH

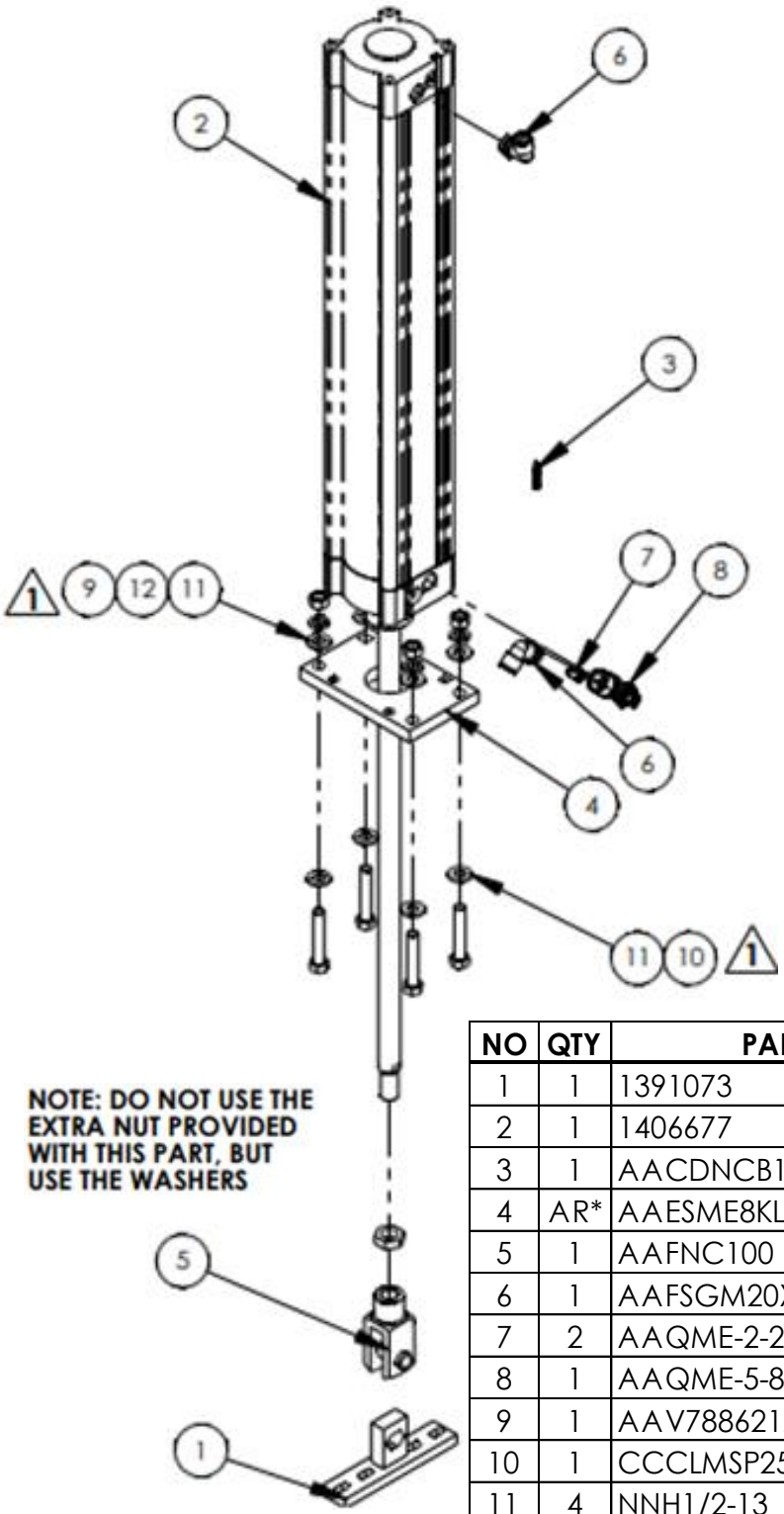
AAC Drawing Number 1406573 Rev 2



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1406591	MOUNT, VALVE,JUNCTION BOX
2	1	AA198-503B	REG,0-30 W/GAUGE& BRKT, R
3	1	AAE4V21008	VALVE, 1/4" PORTED, 24VDC
4	1	AAE4V41015	VALVE, 1/2" PORTED, 24VDC
5	2	AAFAN400N04	MUFFLER, 1/2NPT, PLASTIC
6	2	AAFP18	MUFFLER,1/8 NPT, BRONZ
7	3	AAQME-2-2S	FITTING,ELBOW,1/2NPT,1/2
8	3	AAQME-4-4	ELBOW, MALE,Q, 1/4 TUBE, 1/4 NPT
9	2	AAQUY-2-2	QUICK UNION Y,1/2X1/2
10	1	FF3234	STRAIN RELIEF,3/4NPT
11	1	FF8465	NUT,LOCK, 3/4NPT,NYLON,BLK
12	2	NNH8-32	NUT,HEX, 8-32 REG.
13	2	NNK10-32	KEP NUT, 10-32
14	2	SSSC90096	#8-32 X 1-1/2 SOC CAP SC
15	2	SSSC98024	10-32 X 3/8 SOC CAP
16	2	SSSC98112	SCR, SOC CAP 10-32 X 1-3/4
17	4	WWF8	WASHER, FLAT, #8
18	4	WWFS10	WASHER, FLAT, #10, SAE
19	2	WWL8	WASHER,LOCK,#8
20	2	WWL10	WASHER,LOCK,#10

1406595 Cylinder Assembly Side Seal Front W/ Sensor

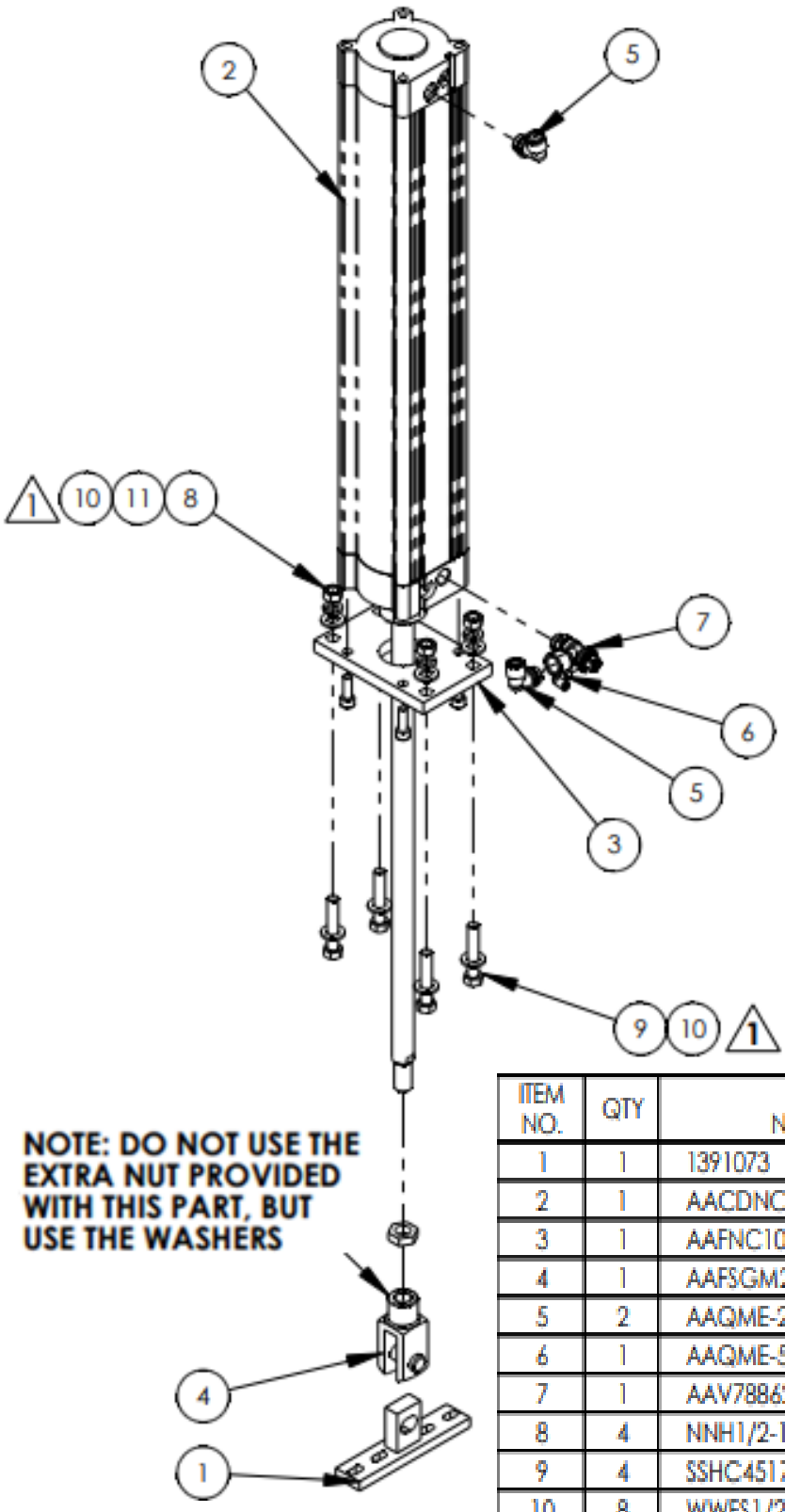
AAC Drawing Number 1406595 Rev 4



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

1406596 Cylinder Assembly Side Seal Rear WO/Sensor

AAC Drawing Number 1406596 Rev 4

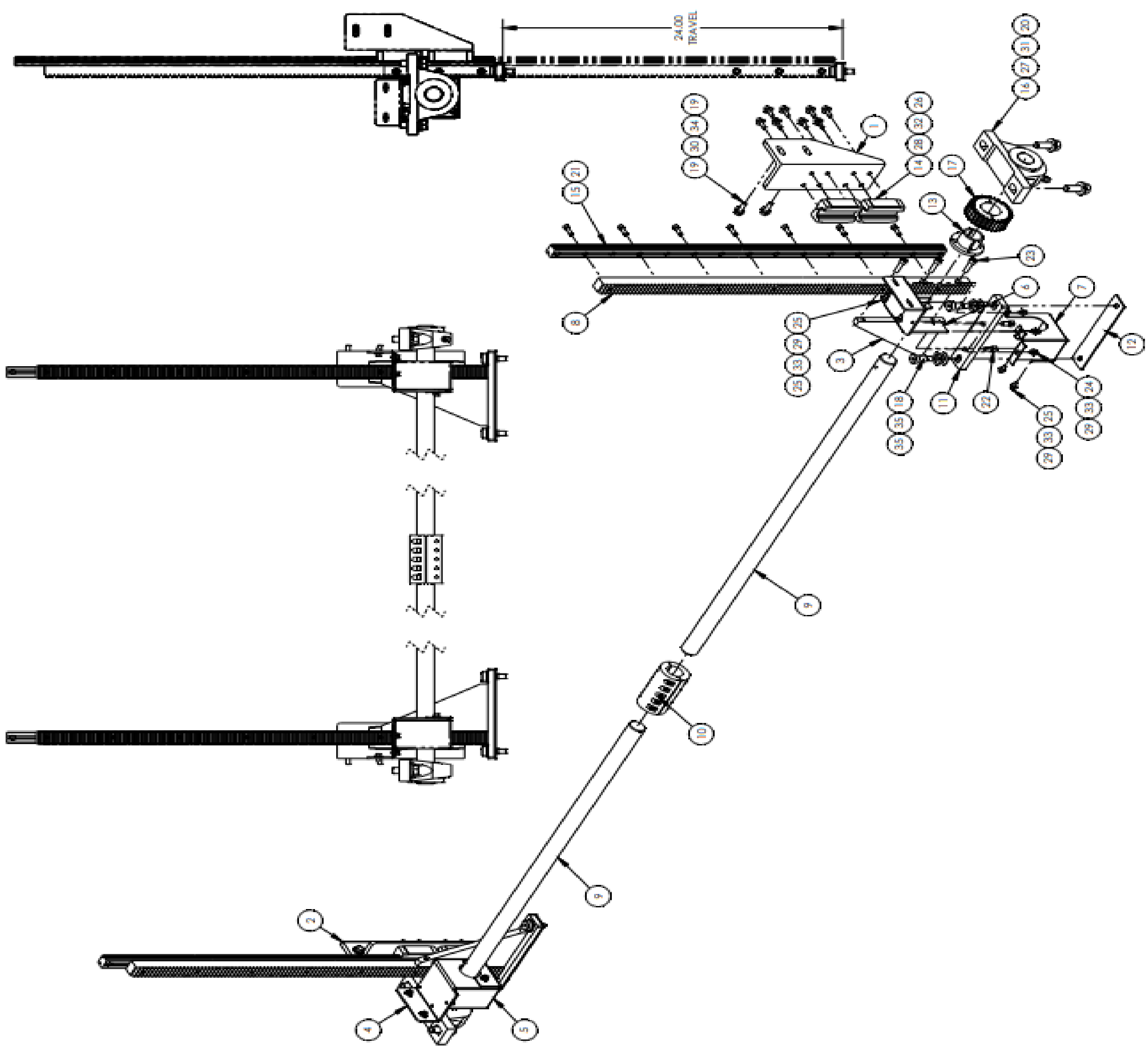


ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1391073	CROSS SEAL CYL. MNT
2	1	AACDNCB100610PP	CYLINDER,AIR,ISO,100BX610S
3	1	AAFNC100	FLANGE,MOUNTING PLT,- DNCB100610
4	1	AAFSGM20X15	CLEVIS,ROD,M20 X 1.5
5	2	AAQME-2-2U	FITTING, 1/2T-1/2 UNIFIT
6	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
7	1	AAV78862121	VALVE, BLOCKING, R1/2
8	4	NNH1/2-13	NUT,HEX,1/2-13
9	4	SSHC45176	1/2-13X2-3/4 HEX CAP
10	8	WWFS1/2	WASHER,FLAT,1/2, SAE
11	4	WWL1/2	1/2 LOCK WASHER

1406640 Side Seal Sync Bar Assembly

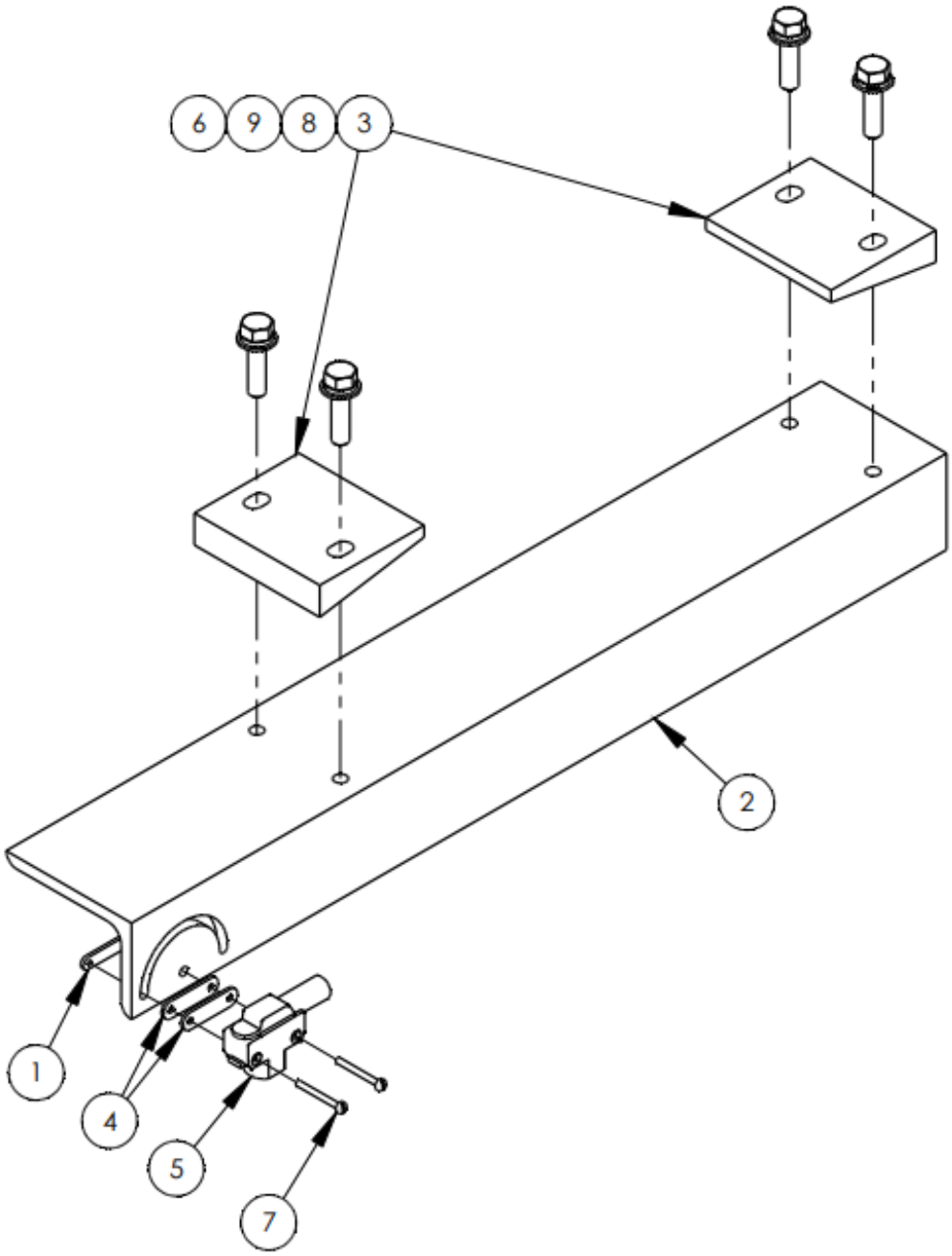
AAC Drawing Number 1406640 Rev 3

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	13901087	MTG. BRKT. RAIL,RACK LH
2	1	13901088	MTG. BRKT. RAIL,RACK RH
3	2	1390831	GUSSET, RACK MNT
4	1	1390864	GUARD BASE-COMPRESSION
5	1	1390863	GUARD, GEAR, COMPRESSION
6	1	1390872	GUARD BASE-COMPRESSION
7	1	1390873	GUARD, GEAR COMPRESSION
8	2	1406681	RACK, SIDE SEAL BAR SYNC
9	2	1406661	SHAFT, JACK, 34.5" LG
10	1	1406676	COUPLING, 2-PIECE, 1.25BORE
11	2	1406685	BASE PLATE, FLOATINGMNT
12	2	1406712	SPACER PLATE,SIDE SEAL
13	2	MMI14H	HUB, TAPERLOCK, H STYLE
14	4	MMEGH25CA	LINEAR BEARING
15	2	MMEGR25R0840C	RAIL, LINEAR, AG SERIES
16	2	MMGRP207-20	BEARING, PILLOW BK. 1.25B
17	2	MMNSS10H30	GEAR,SPUR,10P,30T,1"F,14.5PA
18	4	SSAX032048	SCREW,ALLEN SHOULDER
19	4	SSHC10064	5/16-18 X 1 HHCS
20	4	SSHC45096	1/2-13X1-1/2 HEX CAP
21	14	SSSC01048	1/4-20 X 3/4" SOC CAP SC
22	4	SSSC10040	5/16-18 X 5/8 SOC CAP
23	6	SSSC10072	SOCKET CAP 5/16-18X 1-1/8
24	6	SSSC98024	10-32 X 3/8 SOC CAP
25	8	SSSC98032	10-32X1/2 SOC CAP
26	16	SSSCM6X20	M6 X 20, SOC CAP
27	4	WWFS1/2	WASHER,FLAT,1/2, SAE
28	16	WWFS1/4	WASHER,FLAT SAE,1/4
29	14	WWFS10	WASHER, FLAT, #10, SAE
30	4	WWFS5/16	WASHER,FLAT,SAE,5/16
31	4	WWL1/2	1/2 LOCK WASHER
32	16	WWL1/4	WASHER,LOCK, 1/4
33	14	WWL10	WASHER,LOCK,#10
34	4	WWL5/16	WASHER,LOCK, 5/16
35	8	WWS9712K74	WASHER, SPRING



1406260 Upper Stop Eye Assembly

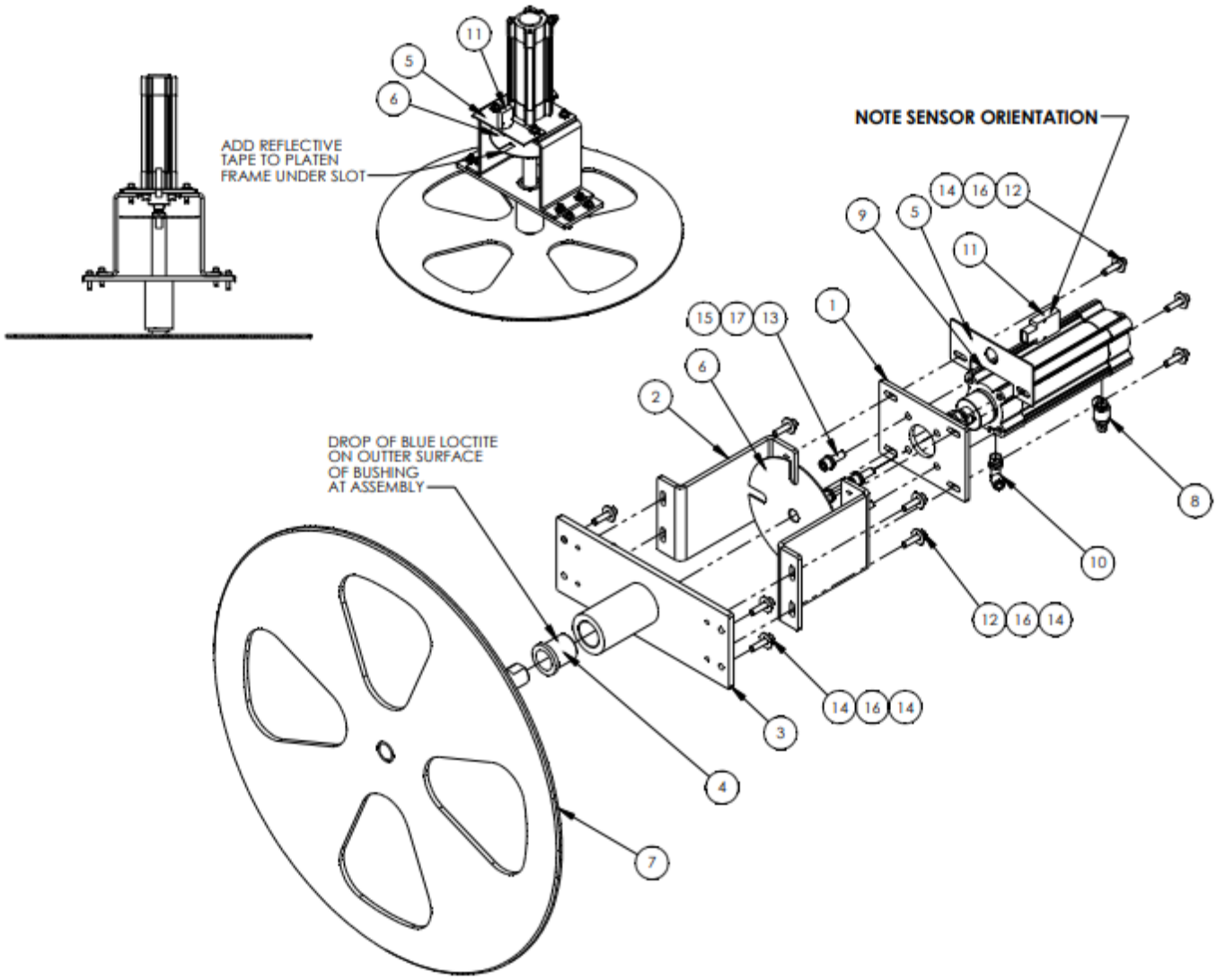
AAC Drawing Number 1406260 Rev 1



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1975-412A	PLATE,NUT,4-40,.95CTC
2	1	1406259	UPPER STOP EYE MOUNT
3	2	1406261	CLAMPING WEDGE
4	2	1406262	WASHER PLATE, .95 CTC
5	1	FFQS186LEQ8	SENSOR,LASER EMITTER
6	4	SSHC20080	5/16-24 X 1-1/4 HEX CAP
7	2	SSPS70064	4-40 X 1 PAN HD SLOTTED
8	4	WWFS5/16	WASHER,FLAT,SAE,5/16
9	4	WWL5/16	WASHER,LOCK, 5/16

1406715 Mattress Pivot Assembly

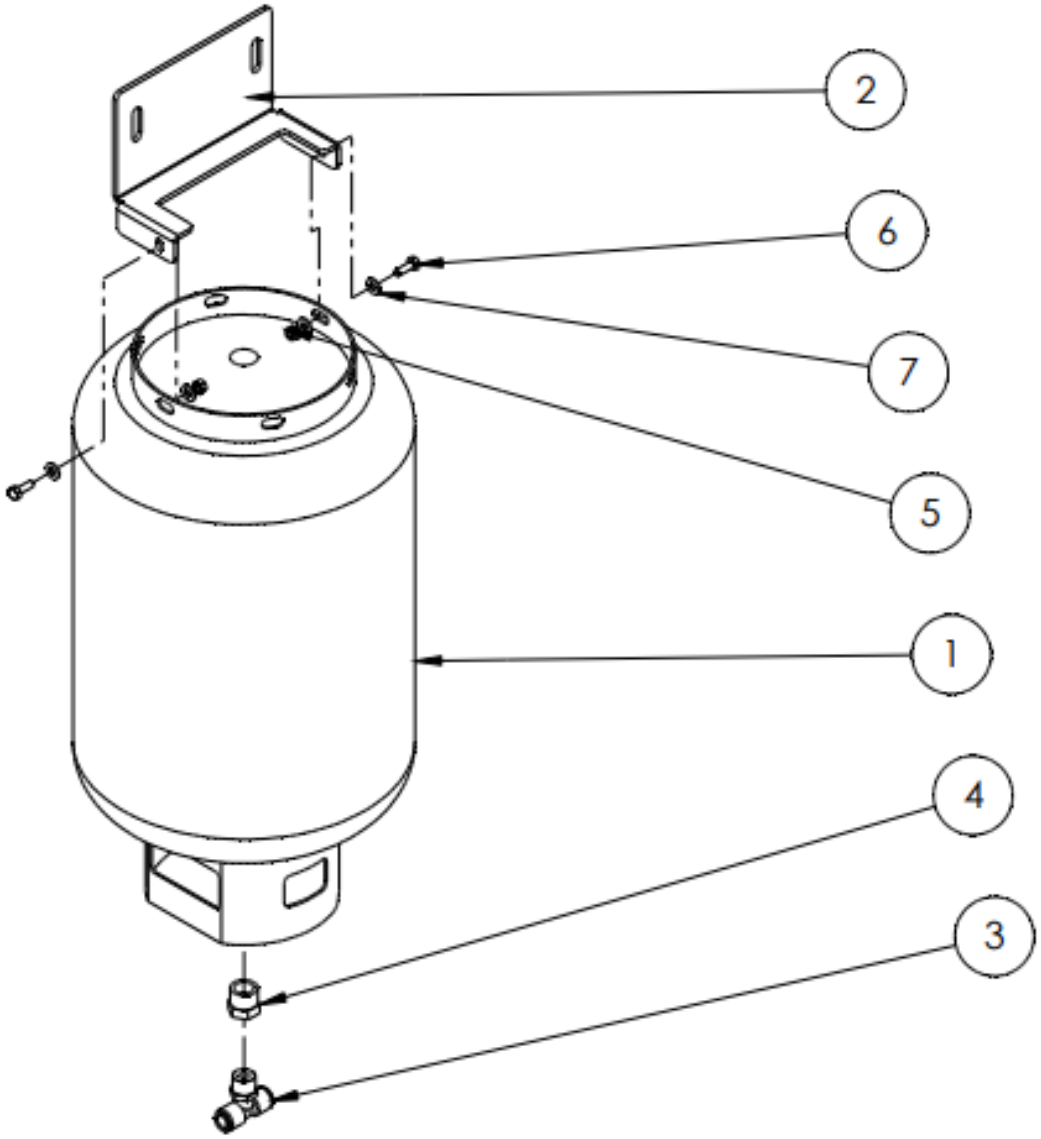
AAC Drawing Number 1406715 Rev 6



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1406717	MOUNT. CYLINDER
2	1	1406719	BRACKET, CYLINDER OFFSET
3	1	1406720	MOUNT, PIVOT ASEMBLY
4	1	1406724	BEARING,BRONZE, MOD
5	1	1406837	EYE BKT, PIVOT ASSY
6	1	1406838	ENCODER DISC
7	1	1406890	PIVOT POST, WELDED
8	1	AA198RA404U	FLOW CONTROL,1/4PTX1/4
9	1	AACDNCB50100PPVA	CYLINDER,AIR,ISO,50BX100
10	1	AAQME-4-4U	ELBOW, MALE,1/4X1/4NPT
11	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
12	12	SSSC01064	1/4-20 X 1 SOC CAP
13	4	SSSCM8X25	SCREW,SOC CAP,M8X25
14	12	WWF1/4	WASHER, FLAT, 1/4", COM
15	4	WWFM8	WASHER, FLAT, M8 I.D.
16	12	WWL1/4	WASHER,LOCK, 1/4
17	4	WWLM8	M8 LOCK WASHER

1406830 Air Tank Assembly

AAC Drawing Number 1406830 Rev 0

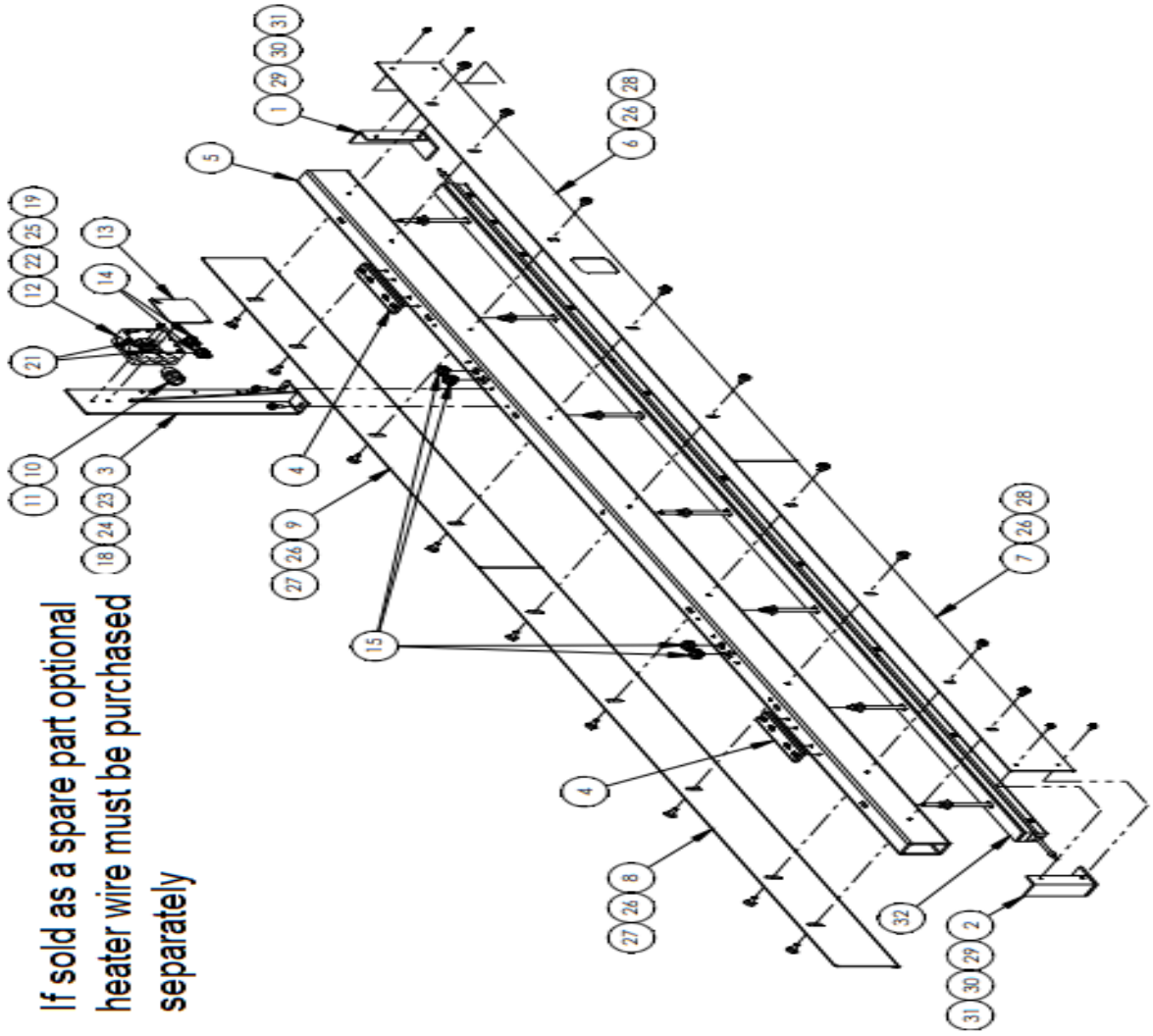


ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	261007	AIR TANK ASSEMBLY
2	1	1406829	TOP PLATE, AIR TANK
3	1	AAQBT-2-2	QUICK BRANCH "T"
4	1	MM44605K24	HEX BUSHING, 3/4 X 1/2
5	2	NNK1/4-20	KEP NUT, 1/4-20
6	2	SSHC01048	1/4-20 X 3/4 HEX HEAD
7	4	WWFS1/4	WASHER FLAT, 1/4

1406645 Side Seal Bar Assembly 110”

AAC Drawing Number 1406645 Rev 0

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

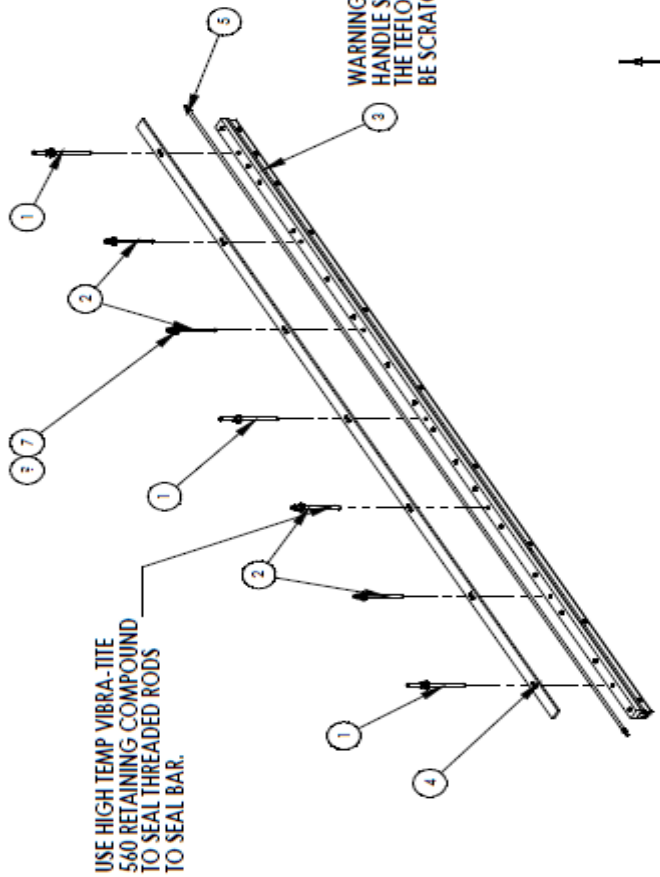


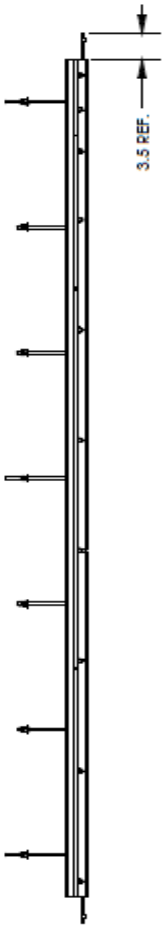
If sold as a spare part optional heater wire must be purchased separately

1406635 Seal Bar 110”

AAC Drawing Number 1406635 Rev 2

ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	3	1390385	THREADED ROD, 7.5"
2	4	1390386	THREADED ROD, 6.25"
3	1	1406630	SEAL BAR ASSY, 110"
4	1	1406891	SPACER, PTFE, 110" LONG
5	1	EEFBN115A10A-13	HEAT ELEMENT,115L,315D
6	1	MM860-150G	SILICONE HEAT TRANSFER COMPOUND,
7	14	NNH3/8-16	NUT,HEX,3/8-16
8	7	WWF3/8	WASHER,FLAT,3/8 OR 10MM

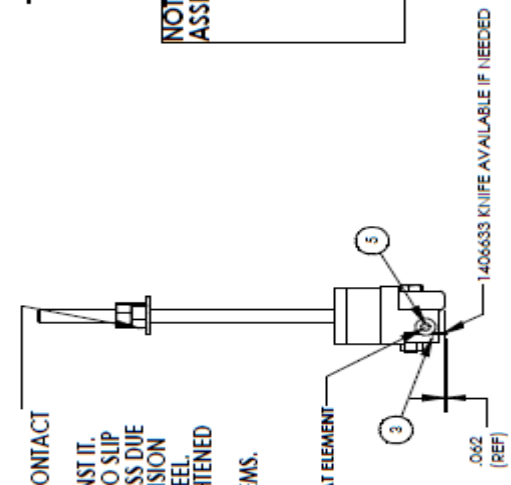




NOTE: TO INSTALL HEATING ELEMENT IT IS NECESSARY TO PARTIALLY DISASSEMBLE THE SEAL BAR ASSEMBLY AS FOLLOWS:

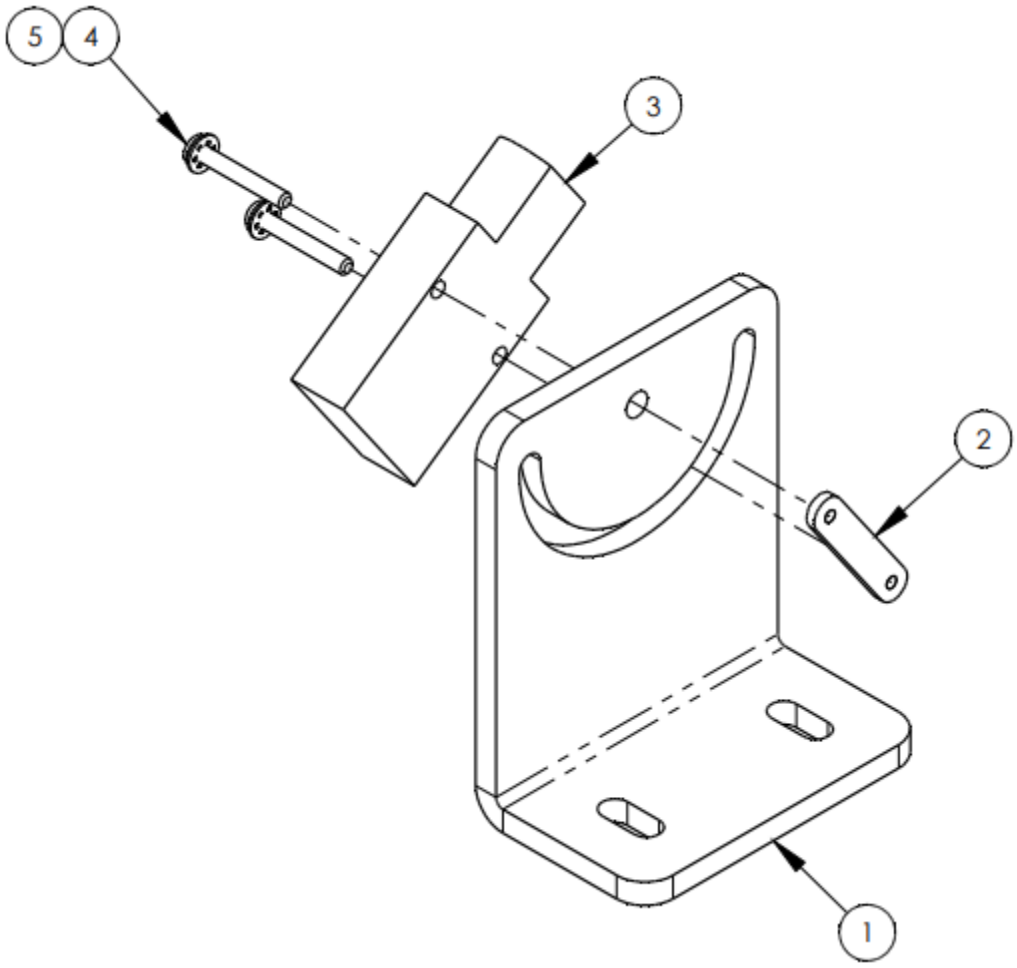
FIRST: READ THE WARNING NEXT TO ITEM 1 BALOON!

1. **UNSCREW KEP NUTS AND REMOVE THE SPACER.**
2. **INSTALL HEAT ELEMENT AND CENTER IT IN THE GROOVE (REF DIM 3.5" EACH END)**
3. **INSTALL THE KNIFE BLADE (ONLY IF REQUESTED BY CUSTOMER).**
4. **REINSTALL THE SPACER.**
5. **REINSTALL AND TIGHTEN KEP NUTS.**
6. **APPLY HEAT TRANSFER COMPOUND TO HEAT ELEMENT**



13901173 Outfeed Full Eye Assembly

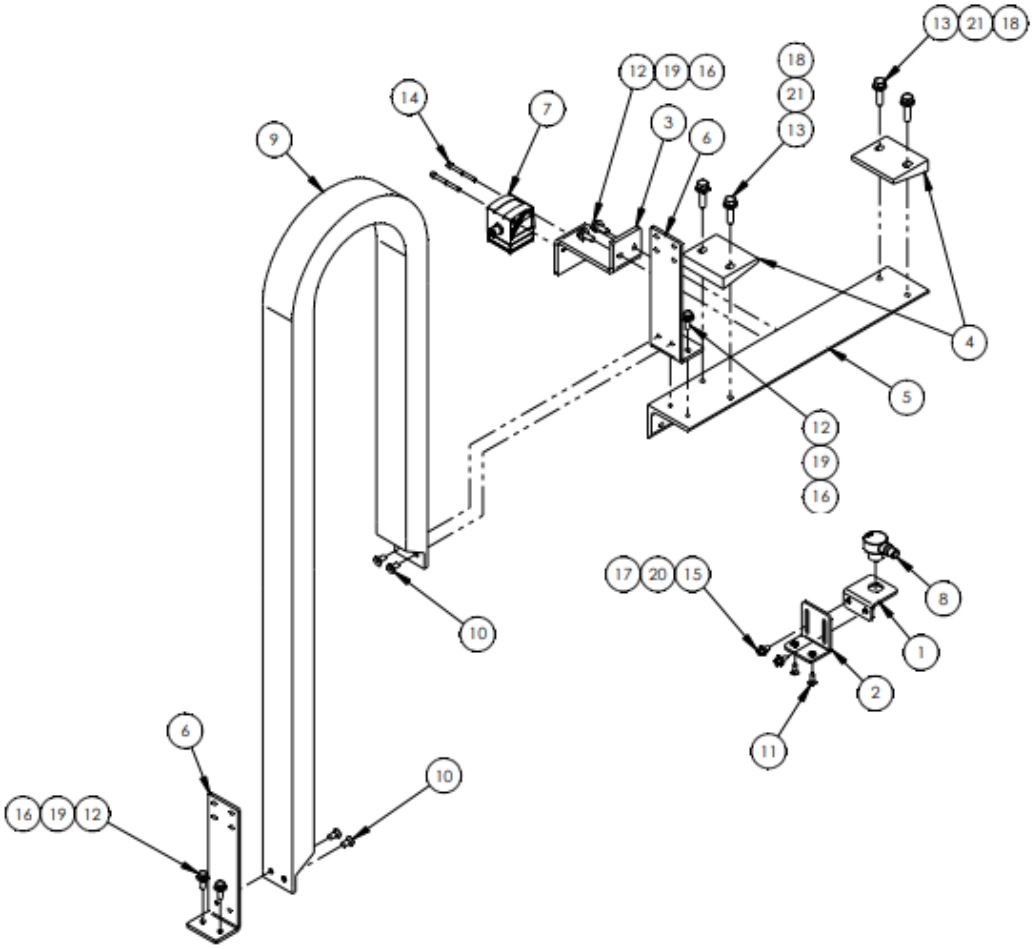
AAC Drawing Number 13901173 Rev 0



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1390468	BRACKET, EYE MOUNT,LH
2	1	1975-412A	PLATE,NUT,4-40,.95CTC
3	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
4	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
5	2	WWSI4	WASHER,INT. TOOTH

14061320 Platen Height Detect Assembly

AAC Drawing Number 14061320 Rev 0



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1315062	BRACKET, BACKSTOP SENSOR
2	1	1315067	MOUNT, BACKSTOP SENSOR
3	1	14061314	HEIGHT SENSOR MOUNT BRKT
4	2	1406261	CLAMPING WEDGE
5	1	1406546	PLATEN HEIGHT PROX MOUNT
6	2	1406547	CABLE TRACK SUPPORT BRKT
7	1	EEO1D102	DISTANCE SENSOR, 10-30VDC
8	1	FFT18FF25Q	EYE,FIXED FIELD, 1IN
9	1	MM45021-37	DUCT,WIRE PLASTITRAK
10	4	SSFC01032	1/4-20 X 1/2 FLAT ALN CAP
11	2	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
12	6	SSHC01048	1/4-20 X 3/4 HEX CAP
13	4	SSHC20080	5/16-24 X 1-1/4 HEX CAP
14	2	SSSC90112	#8-32 X 1-3/4 SOC CAP SC
15	2	SSSC98032	10-32X1/2, SOC CAP
16	6	WWFS1/4	WASHER,FLAT,SAE,1/4
17	2	WWFS10	WASHER, FLAT, #10, SAE
18	4	WWFS5/16	WASHER,FLAT,SAE,5/16
19	6	WWL1/4	WASHER,LOCK, 1/4
20	2	WWL10	WASHER,LOCK,#10
21	4	WWL5/16	WASHER,LOCK, 5/16

EEO1D102-INS1 Programming Instructions

AAC Drawing Number 9009082 Rev 0

SENSOR	UNI (units)	OUT2 (output 2)	RATE (sampling rate)	ASP (analog start point)	AEP (analog end point)
LEFT (length)	Inches	I (4-20ma)	50	19.0	43.5
RIGHT (length)	Inches	I (4-20ma)	50	19.0	43.5
CENTER (height)	Inches	I (4-20ma)	50	10.0	30.0
PLATEN (height)	Inches	I (4-20ma)	50	16.0	37.0

Programming steps:

Note: A pen (or even small screwdriver) works well for pressing the 2 buttons:

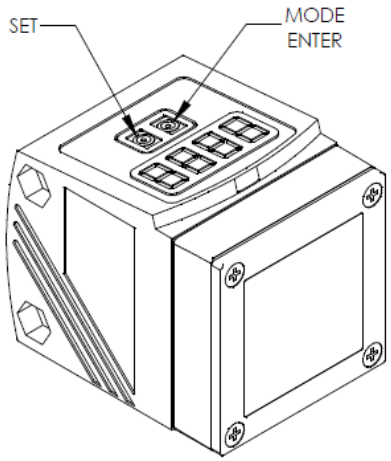
1. Apply power (red display on sensor should be active)

Set UNI (units)

1. Press [Mode/Enter] repeatedly until "EF" (extended functions) is displayed
2. Press [Set]
3. Press [Mode/Enter] repeatedly until "Uni" (units) is displayed
4. Hold [Set] for about 5 seconds (until the display stops blinking)
5. Press [Set] until the display reads "Inch"
6. Press [Mode/Enter] to save the change

Set OUT2 (output 2)

1. Press [Mode/Enter] repeatedly until "OUT2" (output 2 mode) is displayed
2. Hold [Set] for about 5 seconds (until the display stops blinking)
3. Press [Set] until the display reads "I" (4-20ma current mode)
4. Press [Mode/Enter] to save the change



Set RATE (sampling rate)

1. Press [Mode/Enter] repeatedly until "TEAC" is displayed
2. Press [Set] once and wait until the display shows "rATE"
3. Hold [Set] for about 5 seconds (until the display stops blinking)
4. Press [Set] until the display reads "50" (50 Hz sampling mode)
5. Press [Mode/Enter] to save the change

Set ASP (analog start point)

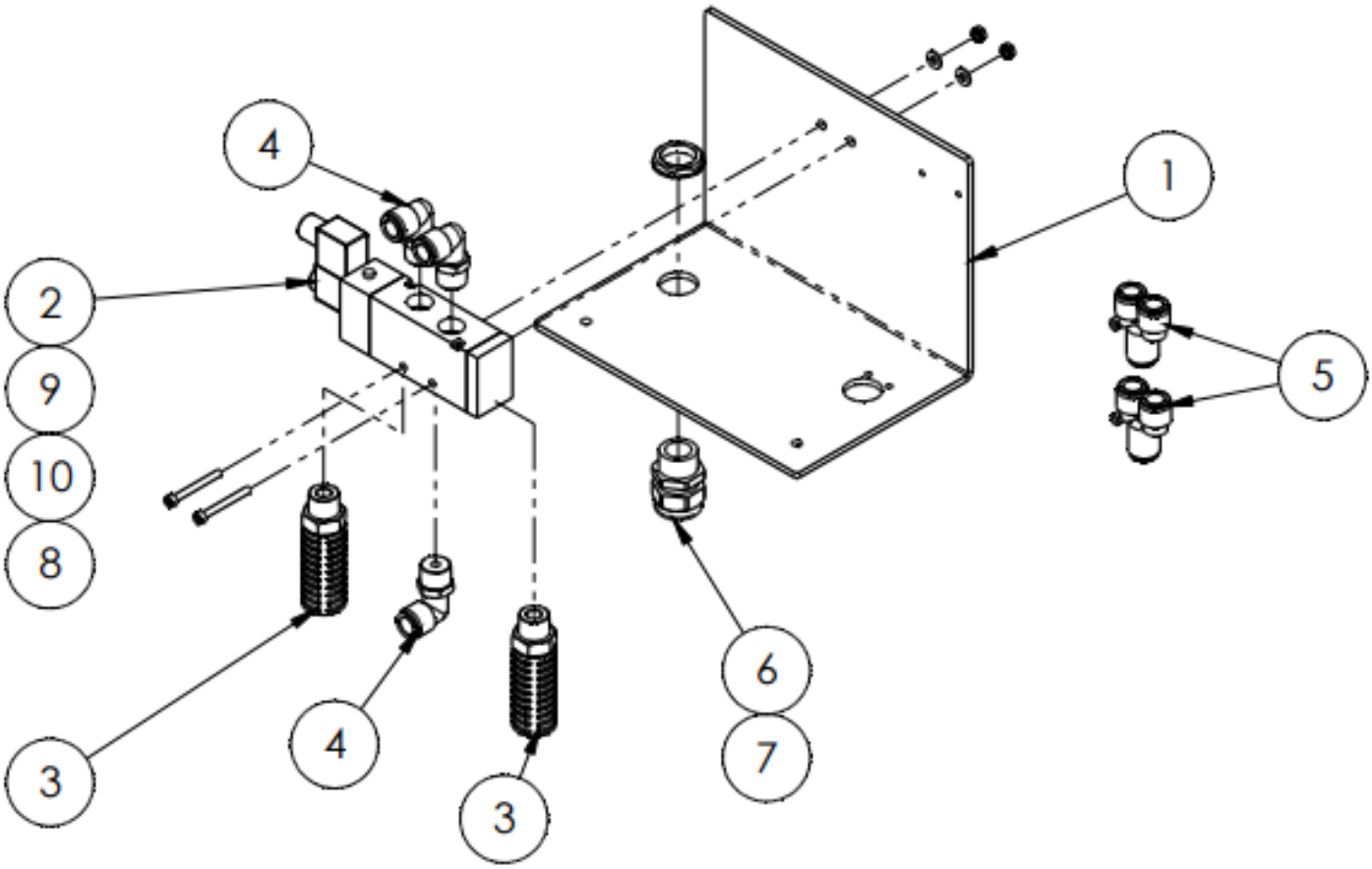
1. Press [Mode/Enter] repeatedly until "ASP" (analog start point) is displayed
2. Hold [Set] for about 5 seconds (until the display stops blinking)
3. Press or hold [Set] to change the value to the desired value
4. Press [Mode/Enter] to save the change

Set AEP (analog end point)

1. Press [Mode/Enter] repeatedly until "AEP" (analog end point) is displayed
2. Hold [Set] for about 5 seconds (until the display stops blinking)
3. Press or hold [Set] to change the value to the desired value
4. Press [Mode/Enter] to save the change

14061322 Valve Assembly, Side Seal RH

AAC Drawing Number 14061322 Rev 0



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

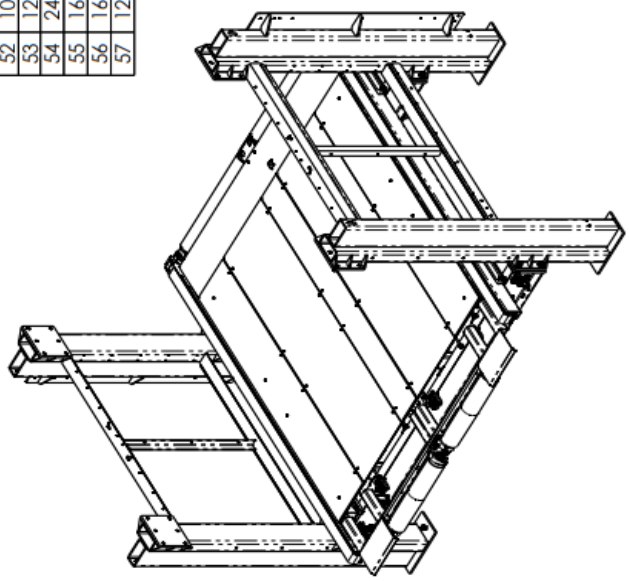
13901160 Outfeed Conveyor Assembly

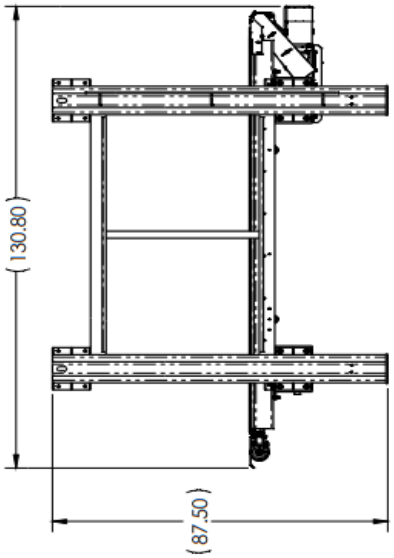
AAC Drawing Number 13901160 Rev 3

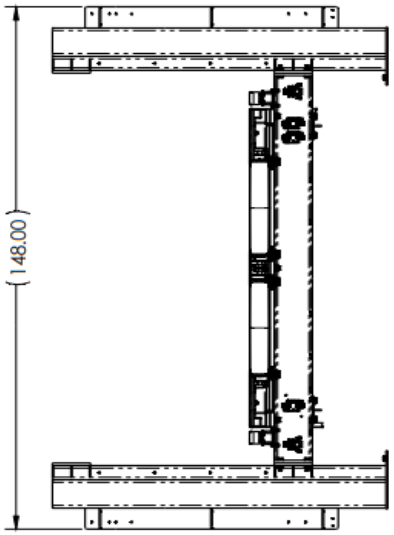
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	12	WWL1/2	1/2 LOCK WASHER
2	12	SSHC45352	1/2-13X5 HEX CAP
3	4	SSHC01032	1/4-20 X 1/2 HHCS
4	8	SSHC01048	1/4-20 X 3/4 HEX CAP
5	18	WWL3/4	3/4 LOCK WASHER
6	6	SSHC34160	3/4-10 X 2-1/2 HEX CAP
7	12	SSHC34128	3/4-10 X 2 HEX CAP
8	24	SSHC34192	3/4-10 X 3 HEX CAP
9	24	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
10	16	SSHC10096F	5/16-18 X 1-1/2 HHCS
11	40	SSFC90048	8-32 X 3/4 FLAT AL CAP
12	10	SSSC90040	8-32 X 5/8 SOC CAP SC
13	4	1390277	ASSY, ROLLER, SUPPORT
14	2	13901143	BELT GUARD MTG BRKT
15	2	13901153	BELT GUARD MTG BRKT
16	8	13901163	BELT GUIDE PULLEY ASSY
17	2	13901152	CHAIN-GUARD, CONV. DRIVE
18	16	CCCL16F	COLLAR,1" CLAMP TYPE
19	1	13901140	FRONT TABLE ASSEMBLY
20	2	13901058	J-BOX, E-STOP,PAUSE,RESET
21	1	13901059	J-BOX, SAFETY LINK
22	1	13901126	LOWER COMPRESSION TABLE
23	2	13901145	LOWER SIDE SEAL ASSY
24	2	13901124	LOWER SUPPORT BEAM
25	16	NNSH3/8-16	NUT, SQUARE, 3/8-16
26	40	NNE8-32	NUT,ELASTIC LOCK, 8-32
27	12	NNH1/2-13	NUT,HEX,1/2-13
28	16	NNH3/4-10	NUT,HEX,3/4-10
29	8	NNH3/8-16	NUT,HEX,3/8-16
30	16	NNH5/16-18	NUT,HEX, 5/16-18
31	1	13901150	OUTFEED CONV MOTOR ASM, LEFT
32	1	13901155	OUTFEED CONV MOTOR ASM, RIGHT
33	1	13901175	OUTFEED SIDE FRAME, LEFT
34	1	13901185	OUTFEED SIDE FRAME, RIGHT
35	2	13901166	PANEL, TOP UHMW, BELT
36	1	13901164	PANEL, TOP UHMW, NARROW
37	2	13901165	PANEL, TOP UHMW, WIDE
38	1	13901130	REAR TABLE ASSEMBLY
39	2	1406942	REGULATOR ASSY, MODIFED
40	1	13901151	ROLLER CHAIN, #40X41"
41	1	1406741	ROLLER CHAIN, #40X44"
42	4	13901159	SHAFT, BELT SUPPORT
43	6	13901157	TABLE MTG PLATE
44	50	WWF8	WASHER, FLAT, #8
45	24	WWSQ080	WASHER, SQ STRUCT. .438ID, 1-1/4 X 1-1/4
46	34	WWFS3/4	WASHER, .797ID X 1-1/2OD
47	24	WWFT3/4	WASHER, .797ID X 1-1/2OD
48	24	WWFS1/2	WASHER,FLAT,1/2, SAE
49	12	WWFS1/4	WASHER,FLAT,SAE,1/4
50	32	WWFS3/8	WASHER,FLAT,SAE,3/8

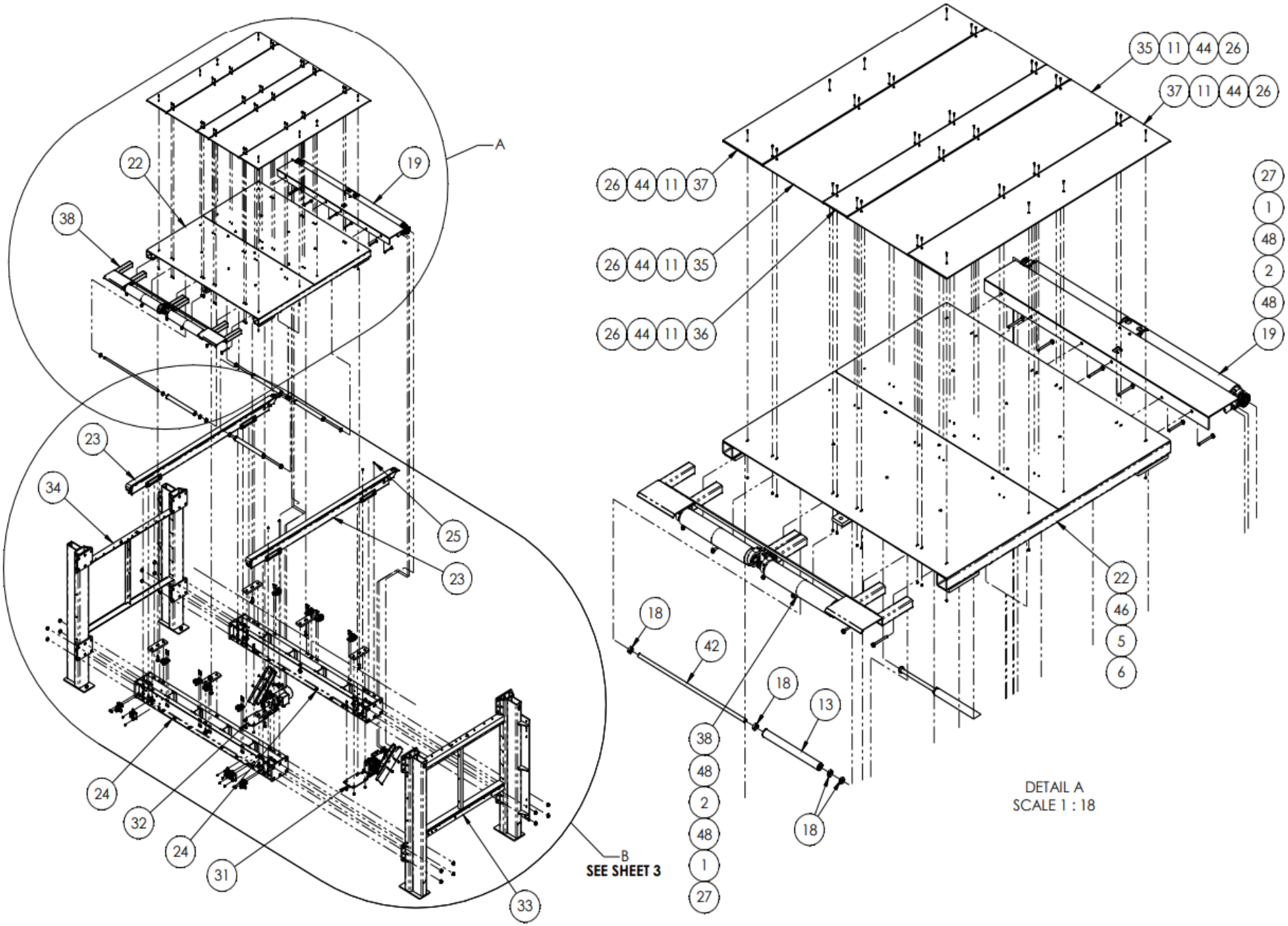
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
51	16	WWFS5/16	WASHER,FLAT,SAE,5/16
52	10	WWL8	WASHER,LOCK,#8
53	12	WWL1/4	WASHER,LOCK, 1/4
54	24	WWL3/8	WASHER,LOCK, 3/8
55	16	WWL5/16	WASHER,LOCK, 5/16
56	16	WWSQ044	WASHER,SQUARE STRUCTURAL
57	12	WWSQ096M	WASHER,SQUARE STRUCTURAL, MOD

SEE SHEET 2 FOR EXPLODED VIEW








A
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SEE SHEET 3
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26 44 11 37
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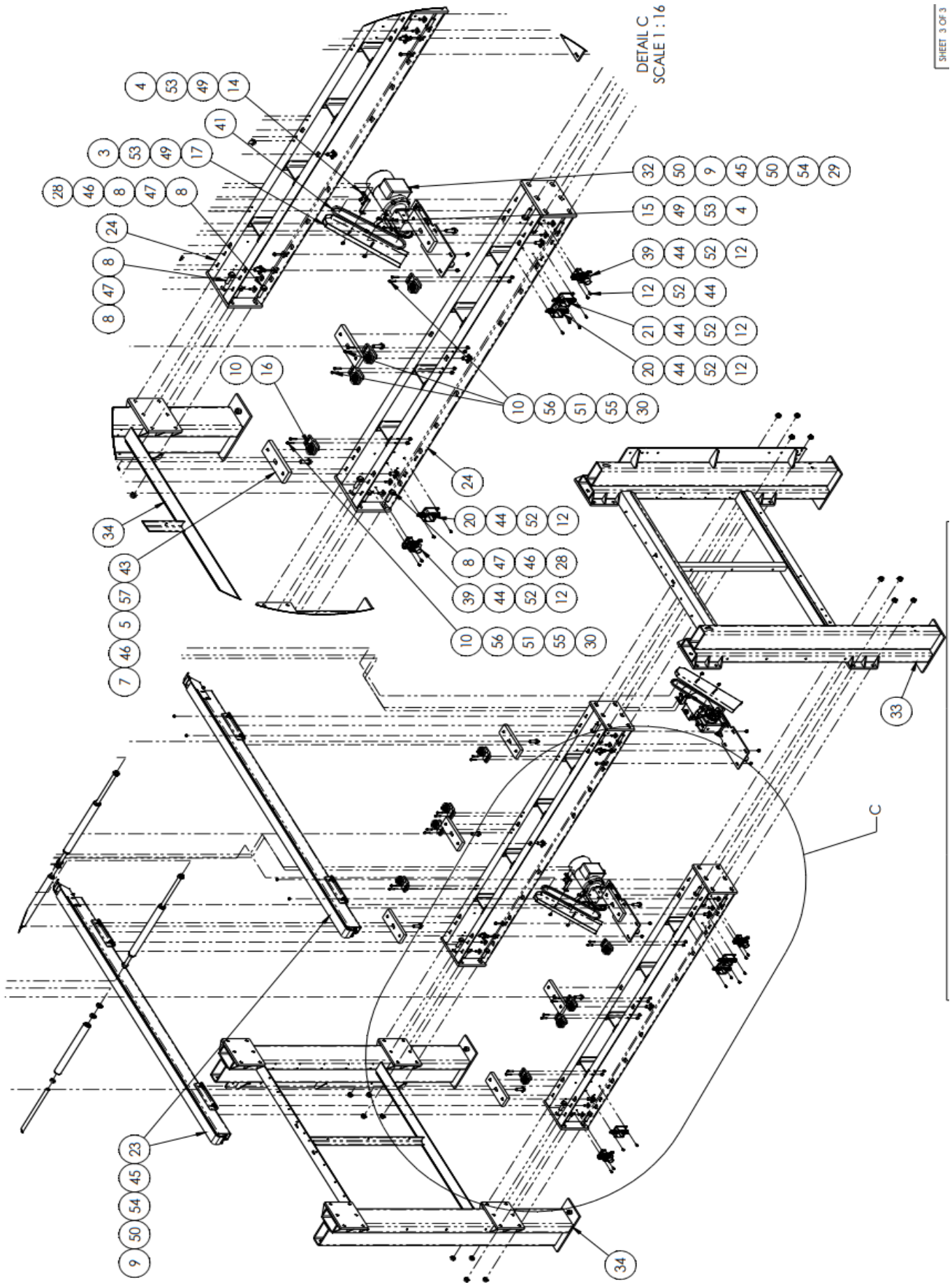
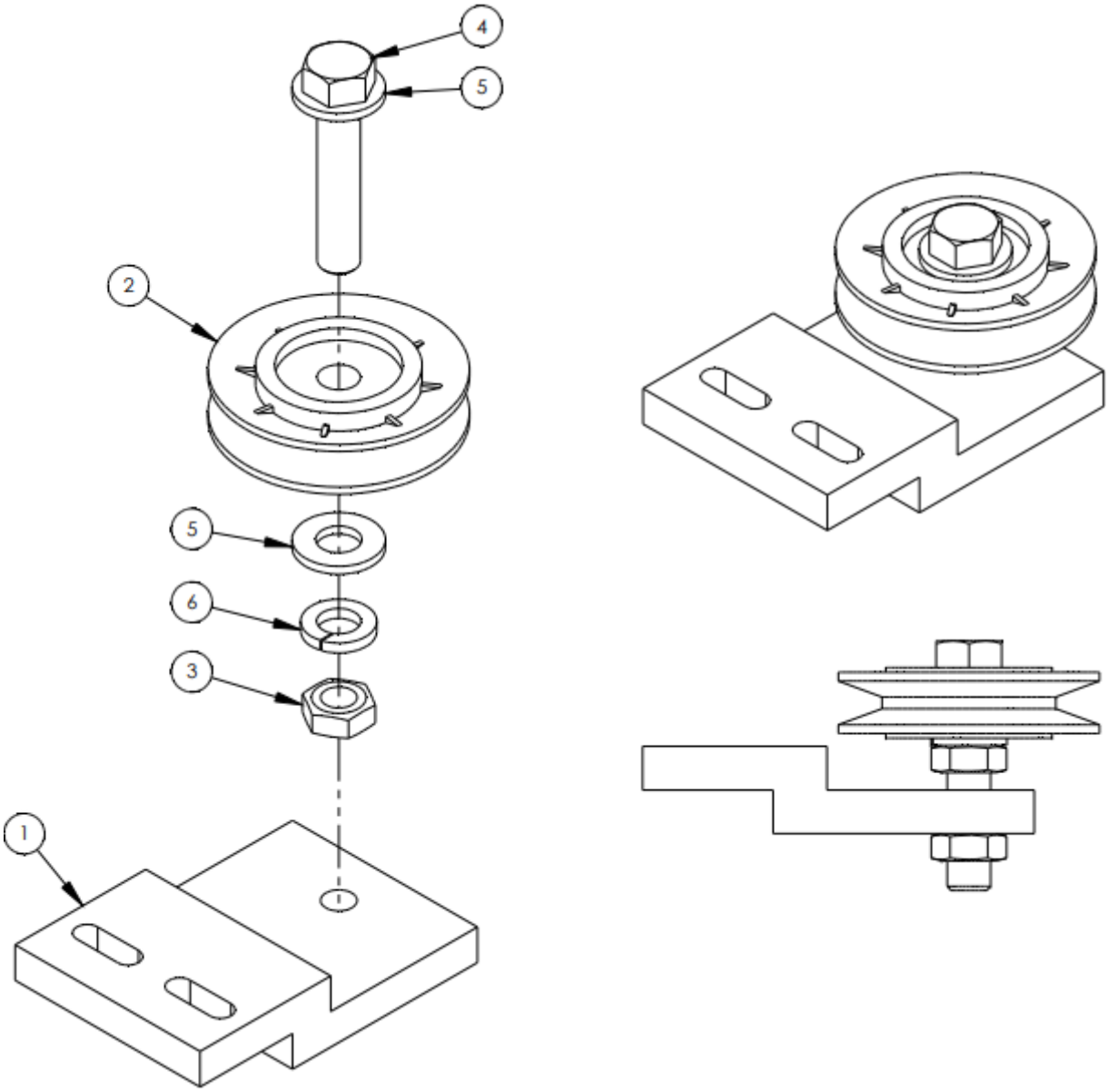
DETAIL A
SCALE 1 : 18


DETAIL C
SCALE 1 : 16
SHEET 3 OF 3
C

13901163 Belt Guide Pulley Assembly

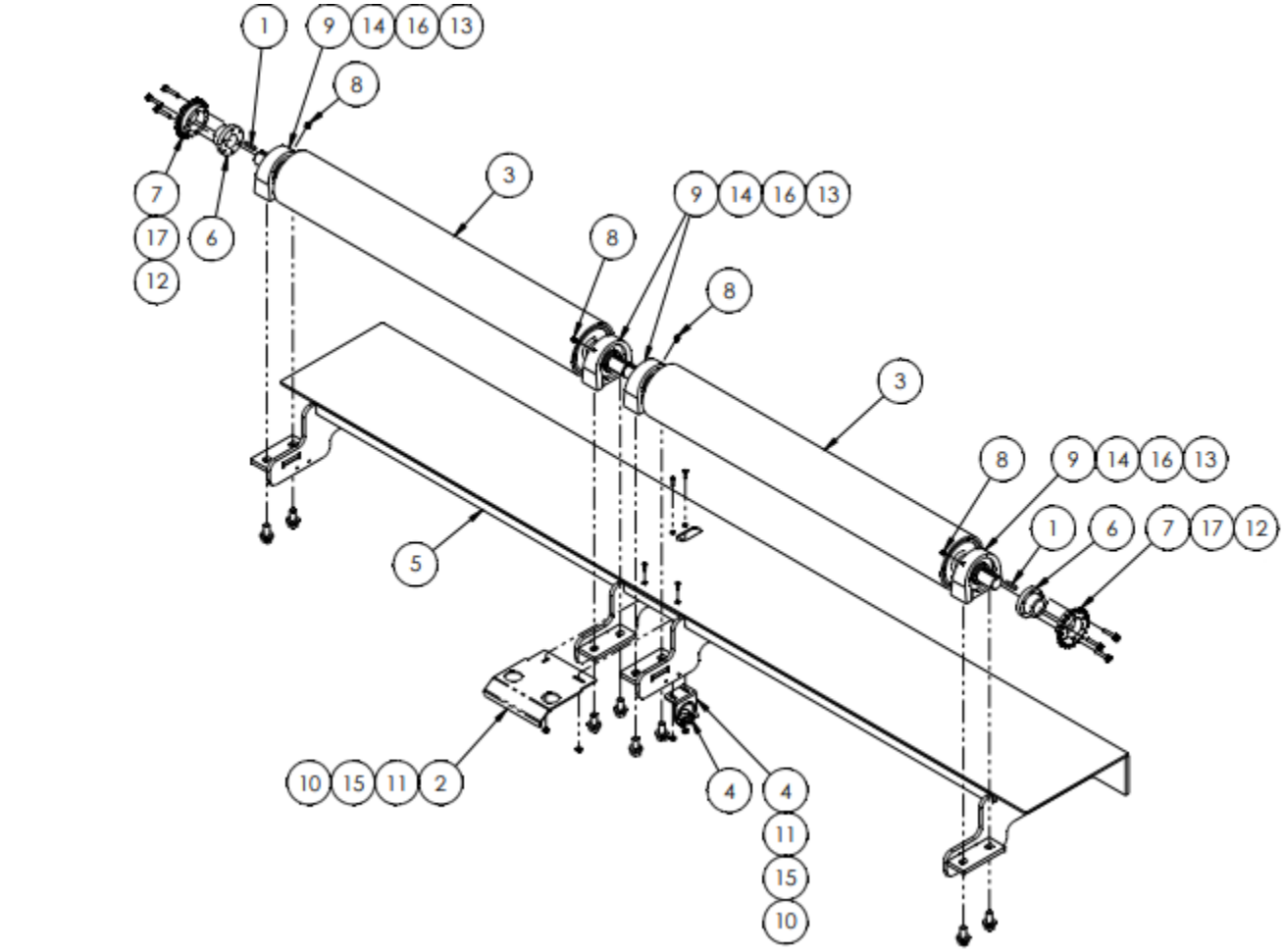
AAC Drawing Number 13901163 Rev 0

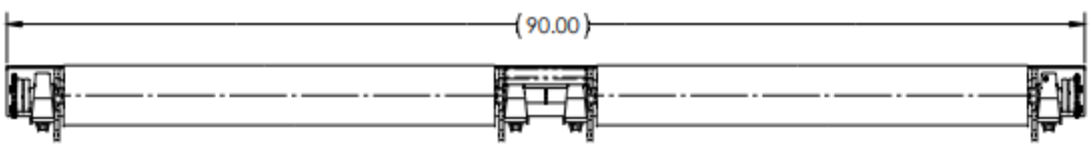


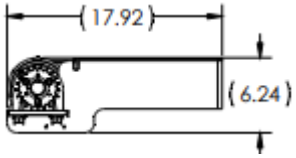
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	13901162	GUIDE PULLEY MTG BRKT
2	1	MM6234K53	PULLEY, V-BELT, NYLON
3	2	NNJ1/2-13	1/2-13 JAM NUT
4	1	SSHC45160F	1/2-13X2-1/2 HEX CAP
5	2	WWFS1/2	WASHER,FLAT,1/2, SAE
6	1	WWL1/2	1/2 LOCK WASHER

13901140 Front Table Assembly

AAC Drawing Number 13901140 Rev 1



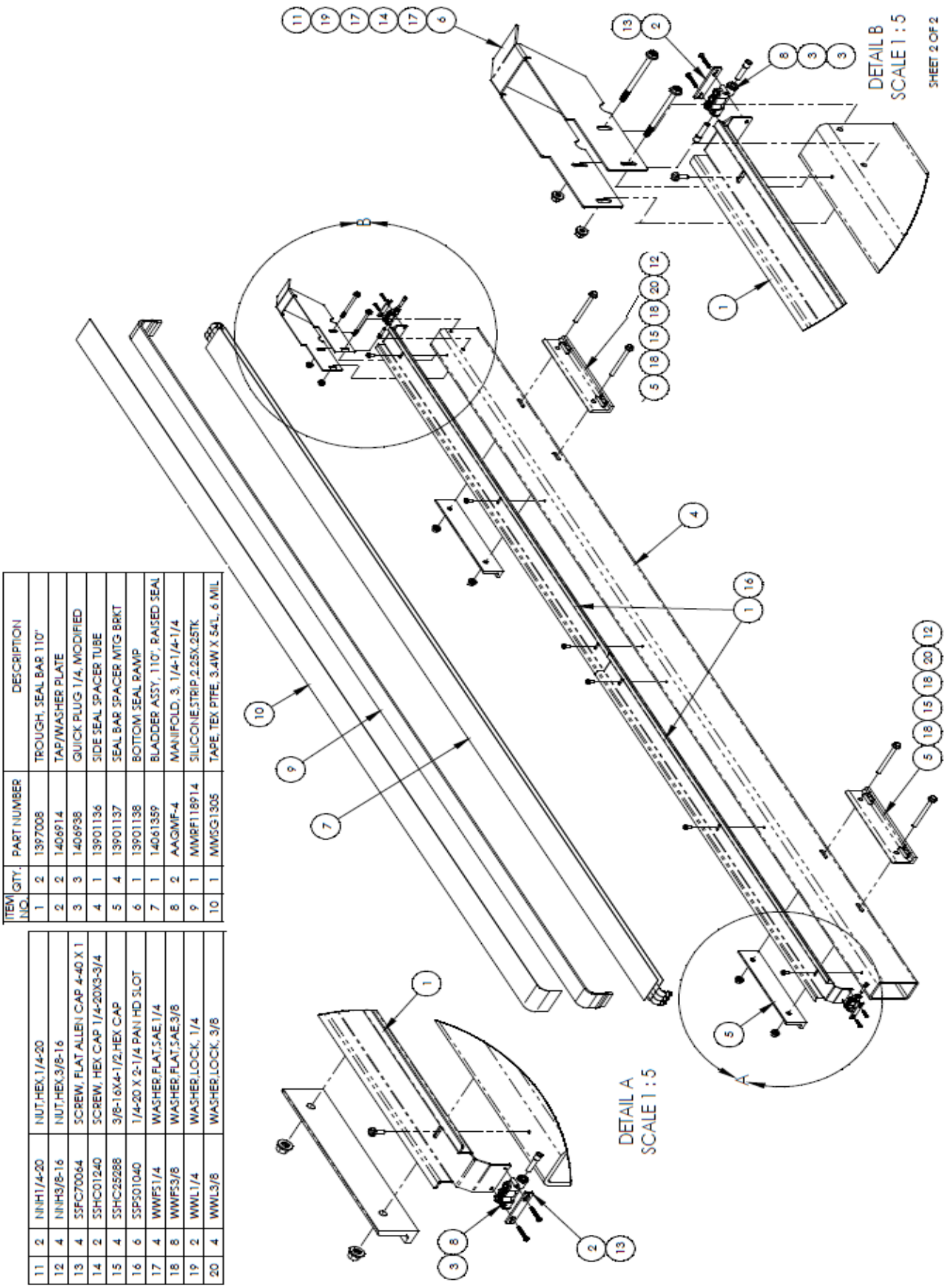




ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	2	1390160	KEY, 1/4 X 1.25L
2	1	1390225	GUARD, COUPLING
3	2	1406155	DRIVE-ROLLER REAR CONV.
4	1	1406265	LOWER STOP EYE ASSY
5	1	13901144	TABLE EXTENSION WELDMENT, FRONT
6	2	MM11/4SH	HUB, TAPERLOCK
7	2	MM40SH21H	SPROCKET, 1/2 P, 21T
8	4	MM2421K31	GREASE FITTING, FLUSH-STYLE
9	4	MMUCPA207-20	1.25" BEARING
10	4	NNK10-32	KEP NUT, 10-32
11	4	SSFC98040	#10-32 X 5/8 FLAT ALLEN
12	6	SSHC01096	1/4-20 X 1-1/2 HHCS
13	8	SSHC45080	1/2-13X1-1/4 HEX CAP
14	8	WWFS1/2	WASHER,FLAT,1/2, SAE
15	4	WWFS10	WASHER, FLAT, #10, SAE
16	8	WWL1/2	1/2 LOCK WASHER
17	6	WWL1/4	WASHER,LOCK, 1/4

13901145 Lower Side Seal Bladder and Tray Assembly

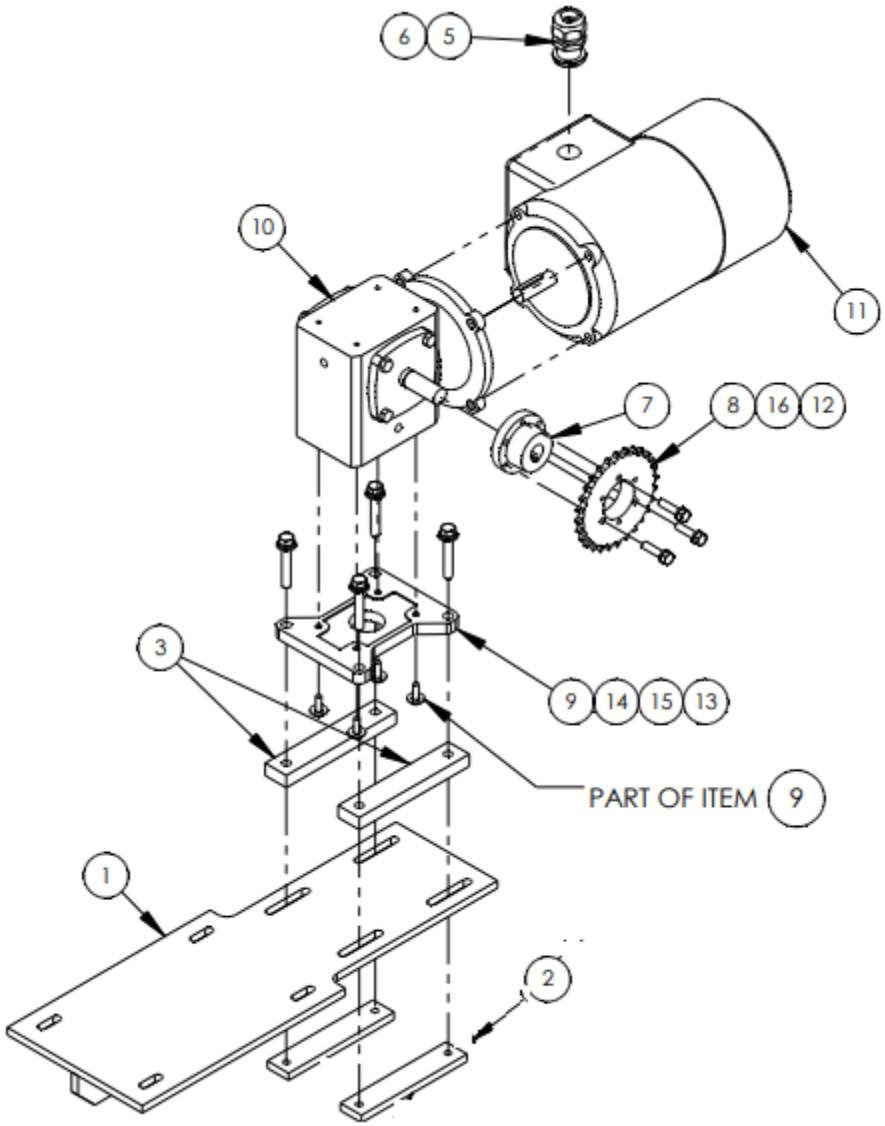
AAC Drawing Number 13901145 Rev 2



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	2	1397008	TROUGH, SEAL BAR 110"
2	2	1406914	TAP/WASHER PLATE
3	3	1406938	QUICK PLUG 1/4, MODIFIED
4	1	13901136	SIDE SEAL SPACER TUBE
5	4	13901137	SEAL BAR SPACER MTG BRKT
6	1	13901138	BOTTOM SEAL RAMP
7	1	14061359	BLADDER ASSY, 110", RAISED SEAL
8	2	AAGMF-4	MANIFOLD, 3, 1/4-1/4-1/4
9	1	MMBF118914	SILICONE STRIP, 2.25X.25TK
10	1	MMSG1305	TAPE, TEX PTFE, 3.4W X 54'L, 6 MIL
11	2	NNH1/4-20	NUT,HEX,1/4-20
12	4	NNH3/8-16	NUT,HEX,3/8-16
13	4	SSFC70064	SCREW, FLAT ALLEN CAP 4-40 X 1
14	2	SSHC01240	SCREW, HEX CAP 1/4-20X3-3/4
15	4	SSHC25288	3/8-16X4-1/2,HEX CAP
16	6	SSP501040	1/4-20 X 2-1/4 PAN HD SLOT
17	4	WWF51/4	WASHER,FLAT,SAE,1/4
18	8	WWF53/8	WASHER,FLAT,SAE,3/8
19	2	WWL1/4	WASHER,LOCK, 1/4
20	4	WWL3/8	WASHER,LOCK, 3/8

13901150 Outfeed Conveyor Motor Assembly, Left

AAC Drawing Number 13901150 Rev 0

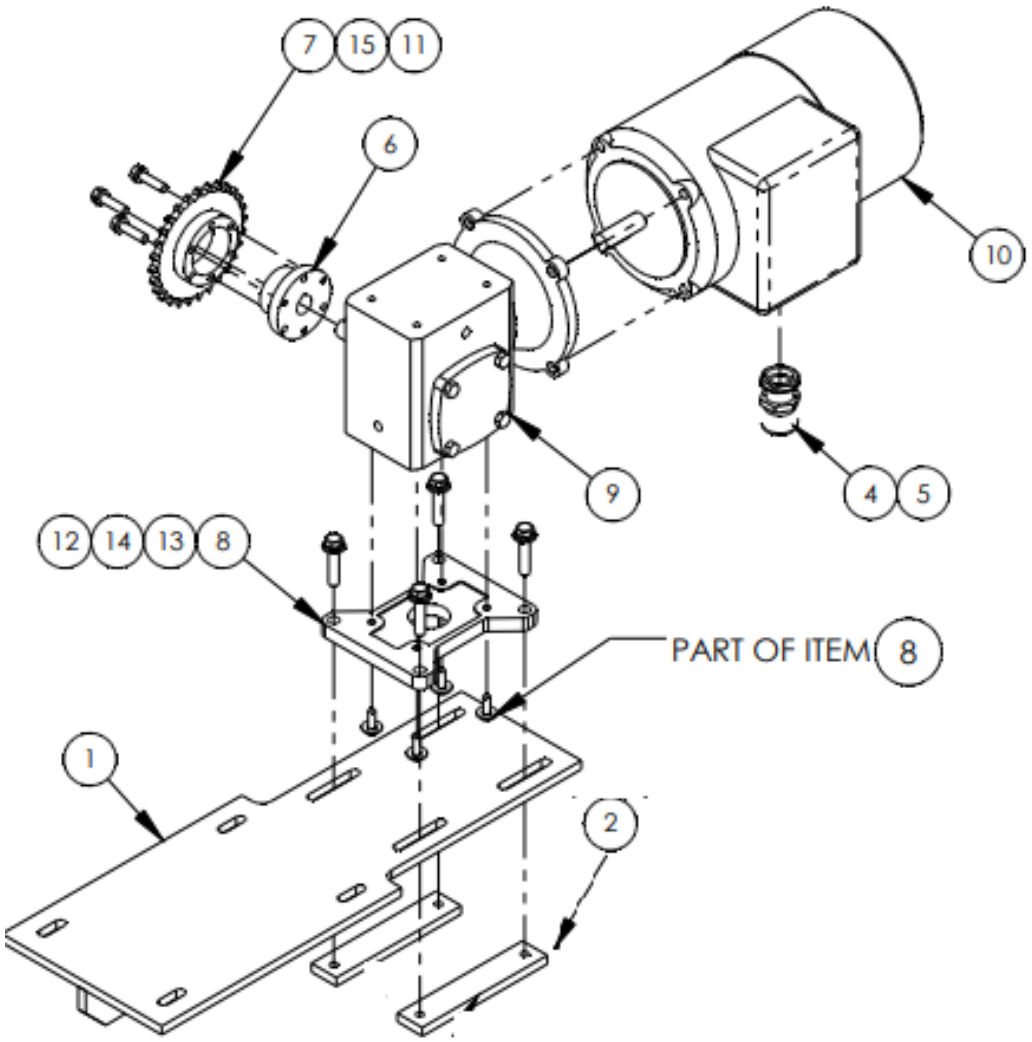


ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	13901148	OUTFEED MOTOR MTG BRKT
2	2	1391177	NUT PLATE, GEAR MOTOR MTG
3	2	1406813	5/8 SPACER
4	*1	51494	LUBRICANT,MOBIL SHC634
5	1	FF3460	STRAIN RELIEF,LIQ TIGHT, 3/4NPT
6	1	FF8465	NUT,LOCK, 3/4NPT,NYLON,BLK
7	1	MM3/4SH	HUB, TAPERLOCK
8	1	MM40SH28H	SPROCKET, 1/2 P, 28T
9	1	MM56438	HORIZONTAL BASE,CI U
10	1	MMF71520B5J	SPEED REDUCER,WORM,
11	1	MMVM3542	3/4 1800 TEFC 208/460
12	3	SSHC10080	HEX HEAD, 5/16-18 X 1-1/4
13	4	SSHC25144	3/8-16X2-1/4 HEX CAP SC
14	4	WWFS3/8	WASHER,FLAT,SAE,3/8
15	4	WWL3/8	WASHER,LOCK, 3/8
16	3	WWL5/16	WASHER,LOCK, 5/16

" * " ITEM(S) NOT SHOWN

13901155 Outfeed Conveyor Motor Assembly, Right

AAC Drawing Number 13901155 Rev 0

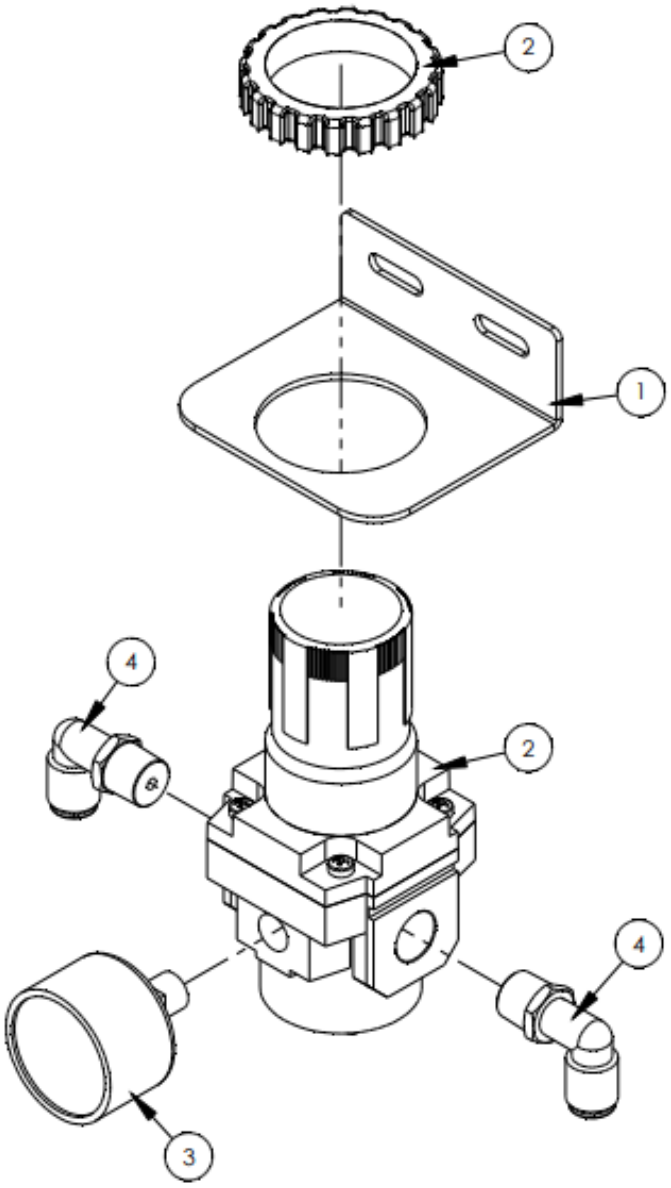


ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	13901148	OUTFEED MOTOR MTG BRKT
2	2	1391177	NUT PLATE, GEAR MOTOR MTG
3	*1	51494	LUBRICANT,MOBIL SHC634
4	1	FF3460	STRAIN RELIEF,LIQ TIGHT, 3/4NPT
5	1	FF8465	NUT,LOCK, 3/4NPT,NYLON,BLK
6	1	MM3/4SH	HUB, TAPERLOCK
7	1	MM40SH28H	SPROCKET, 1/2 P, 28T
8	1	MM56438	HORIZONTAL BASE,CI U
9	1	MMF71520B5J	SPEED REDUCER,WORM,
10	1	MMVM3542	3/4 1800 TEFC 208/460
11	3	SSHC10080	HEX HEAD, 5/16-18 X 1-1/4
12	4	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
13	4	WWFS3/8	WASHER,FLAT,SAE,3/8
14	4	WWL3/8	WASHER,LOCK, 3/8
15	3	WWL5/16	WASHER,LOCK, 5/16

" * " ITEM(S) NOT SHOWN

1406942 Regulator Assembly, Modified

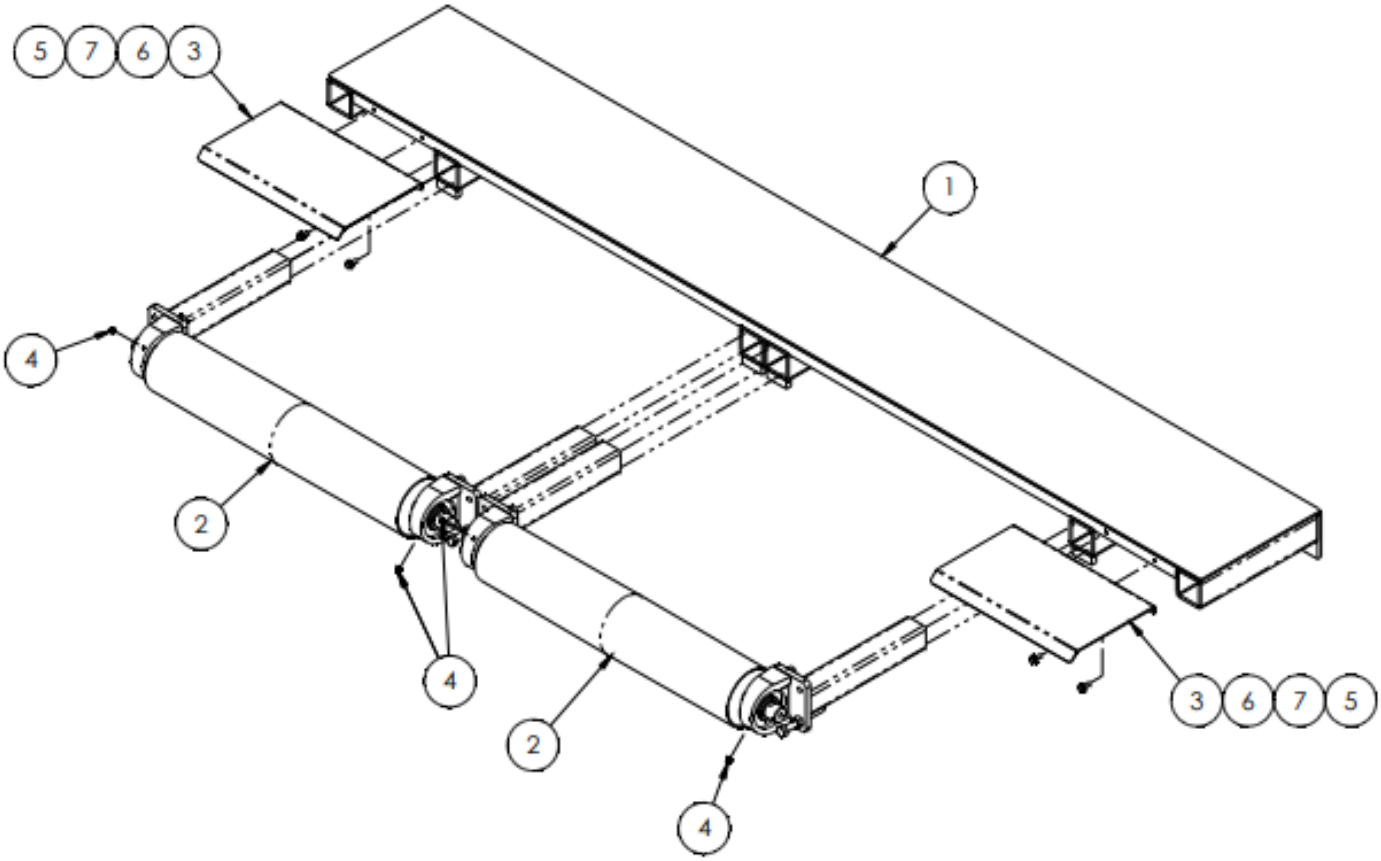
AAC Drawing Number 1406942 Rev 2

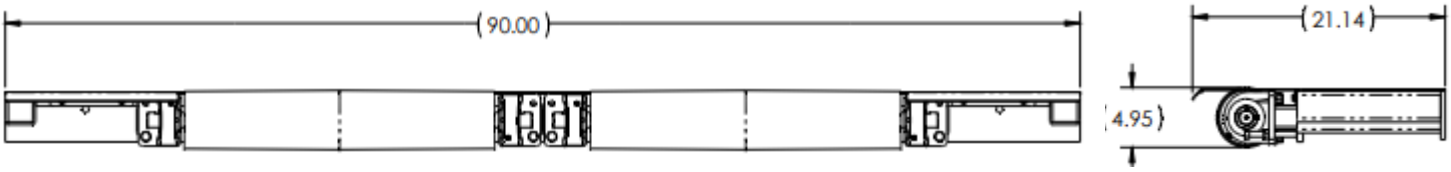


ITEM #	QTY.	PART #	DESCRIPTION
1	1	0411-071	BRKT,REGULATOR
2	1	1406940	REGULATOR, MODIFIED
3	1	AA198-503	0-30PSI AIR GAGE 1/8NPT
4	2	AAQME-4-4	ELBOW, MALE,Q, 1/4 TUBE, 1/4 NPT

13901130 Rear Table Assembly

AAC Drawing Number 13901130 Rev 0

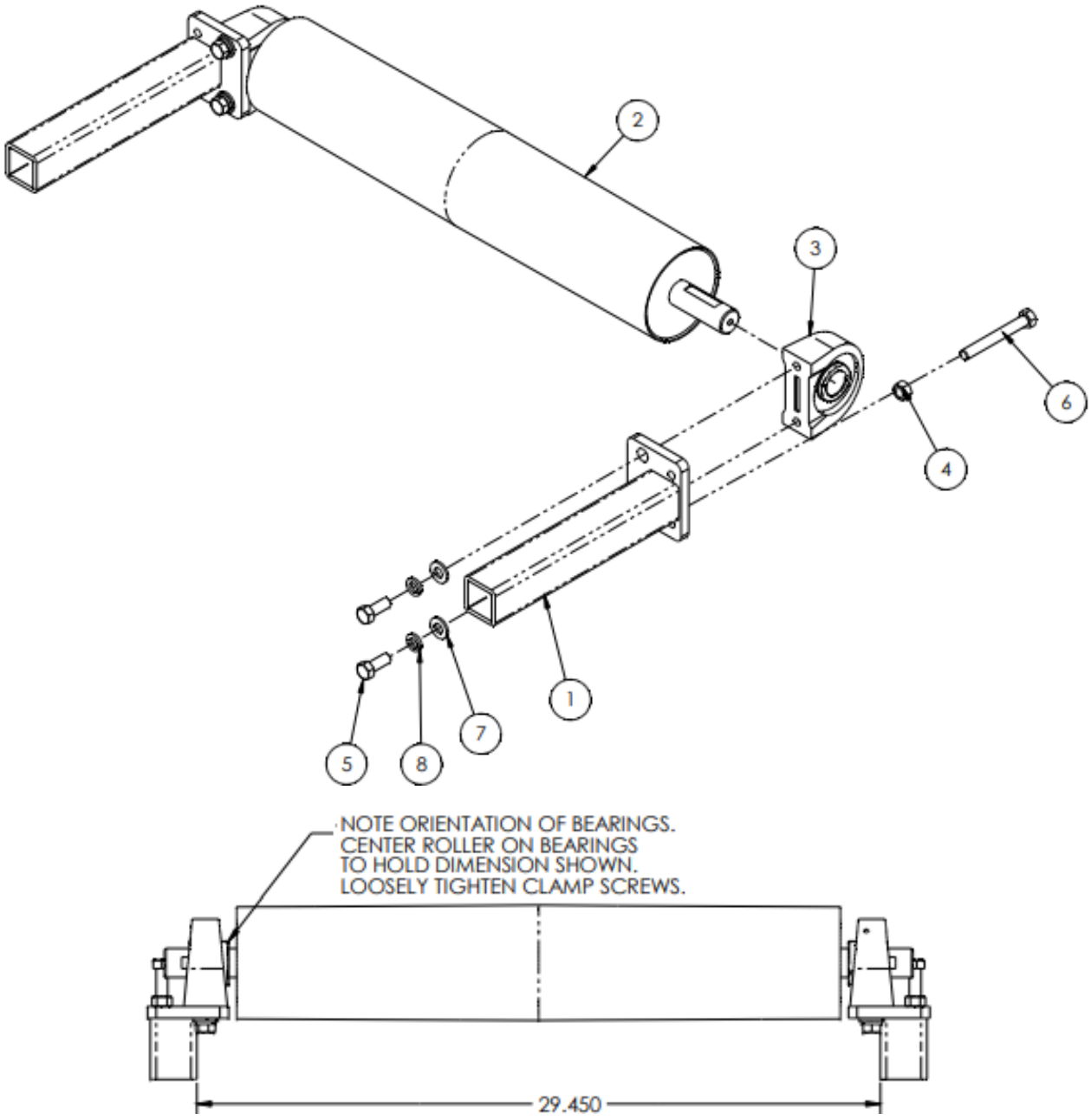




ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	13901129	TABLE EXTENSION WELDMENT, REAR
2	2	1406845	IDLER ROLLER ASSY
3	2	1406899	EXIT TABLE EXTENSION
4	4	MM2421K31	GREASE FITTING, FLUSH-STYLE
5	4	SSHC01048	1/4-20 X 3/4 HEX CAP
6	4	WWFS1/4	WASHER,FLAT,SAE,1/4
7	4	WWL1/4	WASHER,LOCK, 1/4

1406845 Idler Roller Assembly

AAC Drawing Number 1406845 Rev 0



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	2	1406840	WELDMENT, BELT-TENSIONER
2	1	1406842	IDLER ROLLER, 26"
3	2	MMUCPA207-20	1.25" BEARING
4	2	NNH1/2-13	NUT,HEX,1/2-13
5	4	SSHC45080	1/2-13X1-1/4 HEX CAP
6	2	SSHC45256F	1/2-13X4 FULL THD HEX CAP
7	4	WWFS1/2	WASHER,FLAT,1/2, SAE
8	4	WWL1/2	1/2 LOCK WASHER

5. TRAINING

Check	Description	Time Hrs.
	Safety Instructions	0.5
	Installation • Set up • Power On cycle	1.5
	Operation • Individual components • Serial Bus operator label • Operation Description • With / without dustcover • Maintenance Operator Label	3
	Service • Lock out tag out • Operation sequence Mechanical level	1
	Mechanical Adjustments • Table Adjustments • Tension wheel • Clamp fingers • Staplers	3
	Pneumatic components • Plumbing diagram • FRL unit • Solenoid valve manifold • Pressure adjustments • Pressure switch	1.5
	Electric component • Wiring diagram • Photoelectric Sensor	1.5
	Serial Bus • Touch screen • Modules • Program update • Technical screens	2
	Maintenance Technical Level	1
	Troubleshooting	0.5
	Evaluate any questions.	0.5

Participants: _____ _____

_____ _____

Instructor: _____ **Date:** _____

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 based on 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 Garantia

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libres de defectos de mate-rial 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 prim-ero.
- AAC garantiza la operación satisfactoria de sus máquinas en base de las normas aceptadas de la industria siempre y cuando se instale use y mantenga de forma apropiada.
- La garantía de AAC no puede ser cambiado o modificado y no está sujeto a cualquier otra garantía implicado por otro agente o distribuidor menos al menos que sea autorizado por AAC antes de cual-quier 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 peri-odo de ochocientas (800) horas.
- Componentes mecánicos que fallen por defectos de materiales o de fabricación que han sido manu-facturados por AAC son garantizados por un periodo de ochocientas (800) horas.
- Componentes comprados (Motores, Cabezales,) son protegidos debajo de la garantía del fabricante.
- AAC asistirá con el manejo de todo reclamo de garantía bajo la garantía del fabricante.

Lo Que No Está Garantizado

- Falla de repuestos al raíz de uso incorrecto, falta de mantenimiento, lubricación o modificación.
- Daños ocurridos a raíz de mal transporte, accidentes, incendios o cualquier daño como resultado de servicio por personas no autorizados o instalaciones incorrectas de conexiones eléctricas o neumáti-cas.
- 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.

Notes

6. INDEX

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