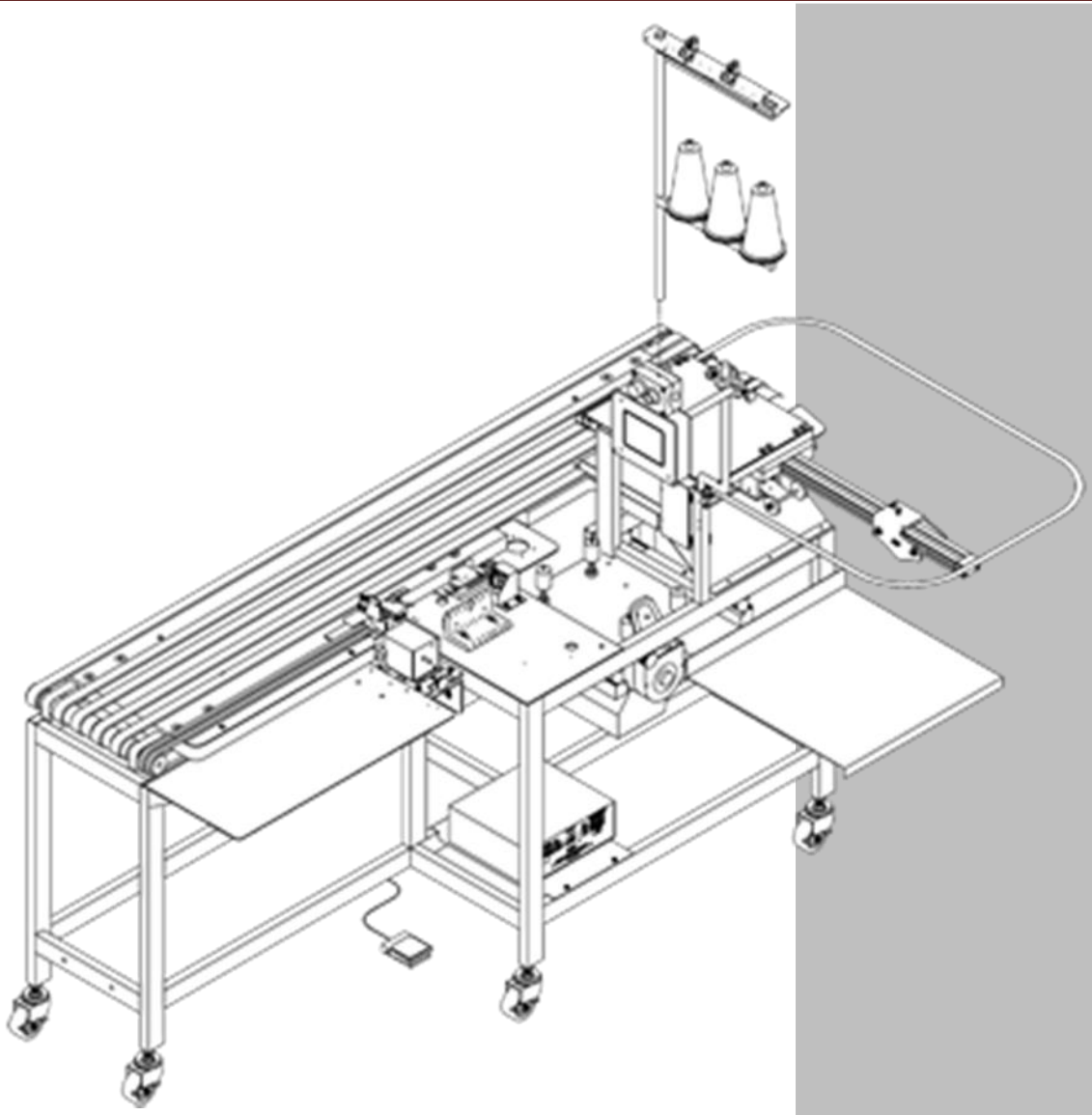
Model **211ES**

Rev 1.3 Updated January 30, 2023

Technical Manual & Parts Lists



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ATLANTA ATTACHMENT COMPANY, INC.

Confidential and Proprietary Information

This equipment may be protected by one or more US and foreign patents.

For a complete list visit
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IMPORTANT

It is important to read and understand the information contained within this manual before attempting to operate the machine. Atlanta Attachment Co., Inc. shall not be held liable for damage resulting from misuse of the information presented within, and reserves the right to change the information contained within, without prior notification.

Contents

Important Safety Instruction

This part of the Instruction Material is provided for the safe use of your equipment. It contains important information to help work safely with 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 1390B Autopack should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

- The Instruction Material comprises:
- Safety information
- Operator Instructions
- Electrical and Pneumatic diagrams

And may also include;

- A list of recommended spare parts
- Instruction Manual(s) for components made by other manufacturers
- The layout and installation diagram containing information for installation

Intended Use

Our machines are designed and built in line with the state of the art and the accepted safety rules. However, all machines may endanger the life and limb of their users and/or third parties and be damaged or cause damage to other property, particularly if they are operated incorrectly or used for purposes other than those specified in the Instruction Manual.

Exclusion of Misuse

Non-conforming uses include, for example, using the equipment for something other than it was designed for, as well as operation without duly installed safety equipment. The risk rests exclusively with the end user.

Conforming use of the machine includes compliance with the technical data, information and regulations in all parts of the complete Instruction Material, as well as compliance with the maintenance regulations. All local safety and accident prevention regulations must also be observed.

Liability

The machine should only be operated when in perfect working order, with due regard for safety and the potential dangers, as well as in accordance with the Instruction Material. Faults and malfunctions capable of impairing safety should be remedied immediately. We cannot accept any liability for personal injury or property damage due to operator errors or non-compliance with the safety instructions contained in this booklet. The risk rests exclusively with the end user.

The Instruction Material should always be kept near the machine so that it is accessible to all concerned.

The local, general, statutory and other binding regulations on accident prevention and environmental protection must also be observed in addition to the Instruction Material. The operating staff must be instructed accordingly. This obligation also includes the handling of dangerous substances and provision/use of personal protective equipment.

The Instruction Material should be supplemented by instructions, including supervisory and notification duties with due regard for special operational features, such as the organization of work, work sequences, the personnel deployed, etc.

The personnel's awareness of the dangers and compliance with the safety regulations should be checked at irregular intervals.

Choice and Qualification of Personnel

Ensure that work on the machine is only carried out by reliable persons who have been appropriately trained for such work - either within the company, by our field staff or at our office - and who have not only been duly appointed and authorized, but are also fully familiar with the local regulations. Work on the machine should only be carried out by skilled personnel, under the management and supervision of a duly qualified engineer.

This not only applies when the machine is used for production, but also for special work associated with its operation (start-up and maintenance), especially when it concerns work on the hydraulic or electrical systems, as well as on the software/serial bus system.

Training

Everyone working on or with the machine should be duly trained and informed with regard to correct use of the safety equipment, the foreseeable dangers which may arise during operation of the machine and the safety precautions to be taken. In addition, the personnel should be instructed to check all safety mechanisms at regular intervals.

Responsibilities

Clearly define exactly who is responsible for operating, setting-up, servicing and repairing the machine. Define the responsibilities of the machine operator and authorize him to refuse any instructions by third parties if they run contrary to the machine's safety. This applies in particular for the operators of machines linked to other equipment. Persons receiving training of any kind may only work on or with the machine under the constant supervision of an experienced operator. Note the minimum age limits permitted by law.

A Word to the Operator

The greatest danger inherent in our machines:
is that of fingers, hands or loose clothing being drawn into a machine by live, coasting or rotating tools or assemblies or of being cut by sharp tools or burned by hot elements.

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines

All machines are delivered with safety equipment, which shall not be removed or bypassed during operation.

The correct functioning of safety equipment on machines and systems should be checked every day and before every new shift starts, after maintenance and repair work, when starting up for the first time and when restarting (e.g. after prolonged shutdowns).

If safety equipment has to be dismantled for setting-up, maintenance or repair work, such safety equipment shall be replaced and checked immediately upon completing the maintenance or repair work. All protective mechanisms shall be fitted and fully operational whenever the machine is at a standstill or if it has been shut down for a longer period of time.

Damage

If any changes capable of impairing safety are observed in the machine or its mode of operation, such as malfunctions, faults or changes in the machine or tools, appropriate steps must be taken immediately, the machine switched off and a proper lockout tagout procedure followed. The machine should be examined for obvious damage and defects at least once per shift. Damage found shall be immediately remedied by a duly authorized person before resuming operation of machine.

The machine should only be operated when in perfect working order and when all protective mechanisms and safety equipment, such as detachable protective mechanisms, emergency STOP systems, etc. are in place and operational.

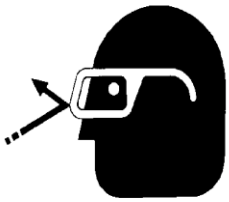
Faults or Errors

The machine must be switched off and all moving or rotating parts allowed to come to a standstill and secured against accidental restart before starting to remedy any faults or errors.

Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.
Clothing, Jewelry, Protective Equipment
Long loose hair, loose-fitting clothes, gloves and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

Protective Eyewear



Protective eyewear that has been tested by the local authorities should be worn whenever there is a possibility of loose or flying objects or particles such as when cleaning the machine with compressed air.

Tools

Always count the number of tools in your possession before starting work on the machine. This will allow you to check that no tools have been left behind inside the machine. Never leave a tool in the machine while working.

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

Smoking and open flame (e.g. welding work) should be prohibited in the production area due to the risk of fire and explosions.

Workplace

A clear working area without any obstructions whatsoever is essential for safe operation of the machine. The floor should be level and clean, without any waste.

The workplace should be well lit, either by the general lighting or by local lights.

Emergency STOP

The emergency STOP buttons bring all machine movements to a standstill. Make sure you know exactly where they are located and how they work. Try them out. Always ensure easy access to the nearest emergency STOP button while working on the machine.

First Aid

1. Keep calm even when injured.
2. Clear the operator from the danger zone. The decision of what to do and whether to seek additional assistance rests entirely with you, particularly if someone has been trapped.
3. Give First Aid. Special courses are offered by such organizations as the employers' liability insurance association. Your colleagues should be able to rely on you and vice versa.
4. Call an ambulance. Do you know the telephone numbers for the ambulance service, police and fire service?

Important Notices

Reporting and Fighting Fires

Read the instructions posted in the factory with regard to reporting fires and the emergency exits. Make sure you know exactly where the fire extinguishers and sprinkler systems are located and how they are operated. Pass on the corresponding information to the firemen when they arrive. Ensure there are enough signs to avoid fire hazards.

The following fire extinguishers may be used:
- Dry powder extinguishers, ABC fire-extinguishing powder.
- Carbon dioxide fire extinguishers to DIN 14461 for electronic components. Great care must be exercised when using carbon dioxide fire extinguishers in confined, badly ventilated rooms (see DIN 14406 and 14270).

Isolate the machine from the power supply if a fire breaks out. Do not use water on burning electrical parts until it is absolutely certain that they have been completely disconnected from the power supply. Burning oils, lubricants, plastics and coatings on the machine can give off gases and vapors that may be harmful to your health.
A qualified person should be consulted to repair the damage after a fire.

Electrical Power Supply

Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.
In practice, this may mean that the technician, electrician and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.

Energy sources (electrical/pneumatic/hydraulic, etc.) for the equipment shall be turned off or disconnected and the switches locked or labeled with a warning tag. It is the responsibility of the employer to establish control procedures. Follow lockout/tagout procedures before, setup and/or any service or maintenance work is performed, including lubrication, cleaning or clearance of jams.

Caution: The machine is still not completely de-energized even when the master switch is off.

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.

- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

- Kinetic energy - Note that some motors or spindles, for example, may continue to run or coast run on after being switched off.

- Potential energy - Individual assemblies may need to be secured if necessary for repair work.

Delivery of the Machine/Packaging

Note any markings on the packaging, such as weights, lifting points and special information. Avoid temperature fluctuations. Condensation may damage the machine.

Transport Damage

The packaging and machine must immediately be examined for signs of damage in transit. Such damage must be reported to the shipper/transporter within the applicable time limits. Contact Atlanta Attachment Company and/or your transport insurer immediately, if signs of damage are visible. Never operate a damaged machine.

Interim Storage

If the machine has to be stored temporarily, it must be oiled or greased and stored in a dry place where it is protected from the weather in order to avoid damage. A corrosion-inhibiting coating should be applied if the machine has to be stored for a longer period of time and additional precautions taken to avoid corrosion.

Transporting the Machine

Disconnect the machine from all external connections and secure any loose assemblies or parts. Never step under a suspended load. When transporting the machine or assemblies in a crate, ensure that the ropes or arms of a forklift truck are positioned as close to the edge of the crate as possible. The center of gravity is not necessarily in the middle of the crate. Note the accident prevention regulations, safety instructions and local regulations governing transport of the machine and its assemblies.

Only use suitable transport vehicles, hoisting gear and load suspension devices that are in perfect working order and of adequate carrying capacity. Transport should only be entrusted to duly qualified personnel.

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.
All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.
Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.

Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.
Protect against unauthorized access.
Ensure that the machine and accessories are set up in a stable position.
Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Local Regulations

Particular attention must be paid to local and statutory regulations, etc. when installing machines and the plant (e.g. with regard to the specified escape routes). Note the safety zones in relation to adjacent machines.

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.
Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.
Retighten all screw connections that have to be loosened for the maintenance and repair work. Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

The activities and intervals specified in the Instruction Manual for carrying out adjustments, maintenance and inspections must be observed and parts replaced as specified.

All hydraulic and pneumatic lines should be examined for leaks, loose connections, rubbing and damage whenever the machine is serviced. Any defects found must be remedied immediately.

Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard. Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control.

When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

Repair

Replacement Parts

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

Repair, Electrical

The power supply must be switched off (master switch off) and secured so that it cannot be switched on again inadvertently before starting any work on live parts.

Those parts of the machine and plant on which inspection, maintenance or repair work is to be carried out must be isolated from the power supply, if specified. The isolated parts must first be checked to determine that they are truly de-energized before being grounded and short-circuited. Adjacent live parts must also be isolated.

The protective measures implemented (e.g. grounding resistance) must be tested before restarting the machine after all assembly or repair work on electric parts.

Signal generators (limit switches) and other electrical parts on the safety mechanisms must not be removed or bypassed. Only use original fuses or circuit overloads with the specified current rating. The machine must be switched off immediately if a fault develops in the electrical power supply.

The electrical equipment of our machines must be checked at regular intervals and any defects found must be remedied immediately.

If it is necessary to carry out work on live parts, a second person should be on hand to operate the emergency OFF switch or master switch with voltage release in the event of an emergency. The working area should be cordoned off and marked by a warning sign. Only use electrically insulated tools.

Ventilation/Hazardous Gases

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

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

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

Description

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

The 2211ES is a versatile unit for hemming sleeves, pockets and bodies. Itis available with picker stacker, return conveyor and fold in half stacker.

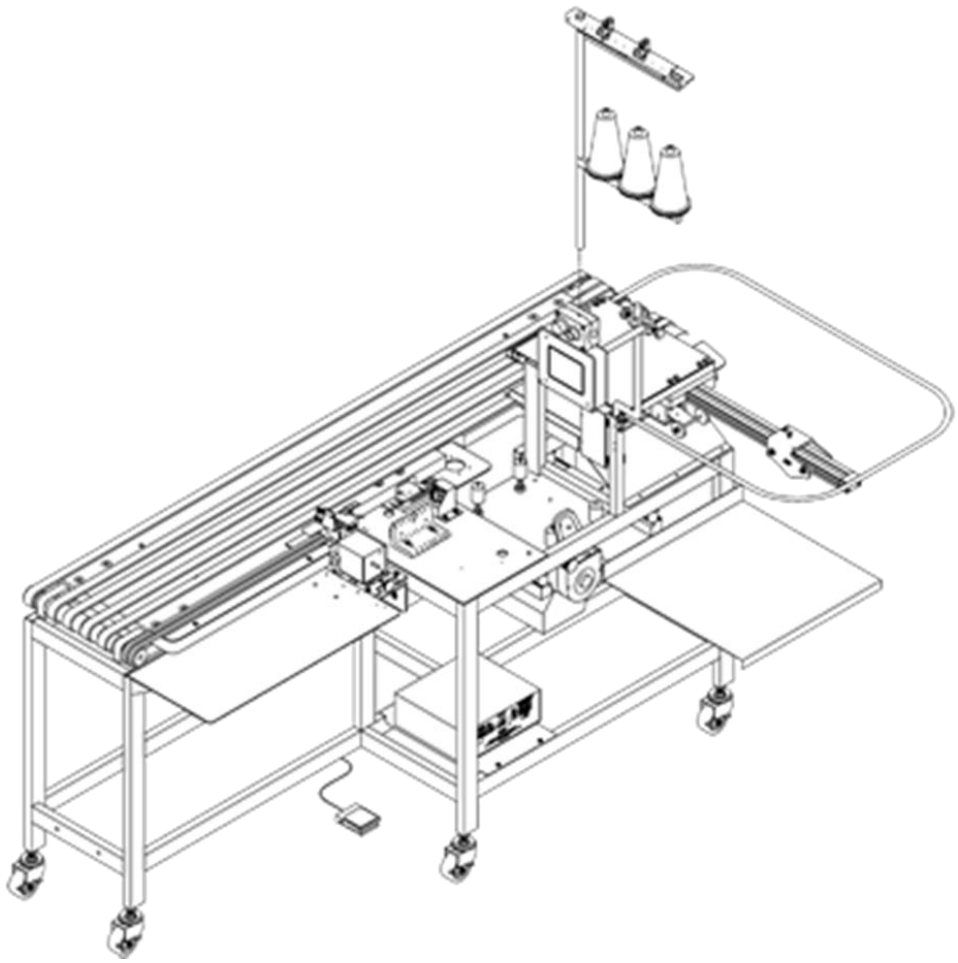
The modular design of AAC's Two Needle Hemmer allows the flexibility of picking the combination of components to design a custom system best suited to the need.

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

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

CAUTION:

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



Operating Instructions

2211ES
Two-Needle Hemmer

READ ALL THESE INSTRUCTIONS BEFORE OPERATING MACHINE!

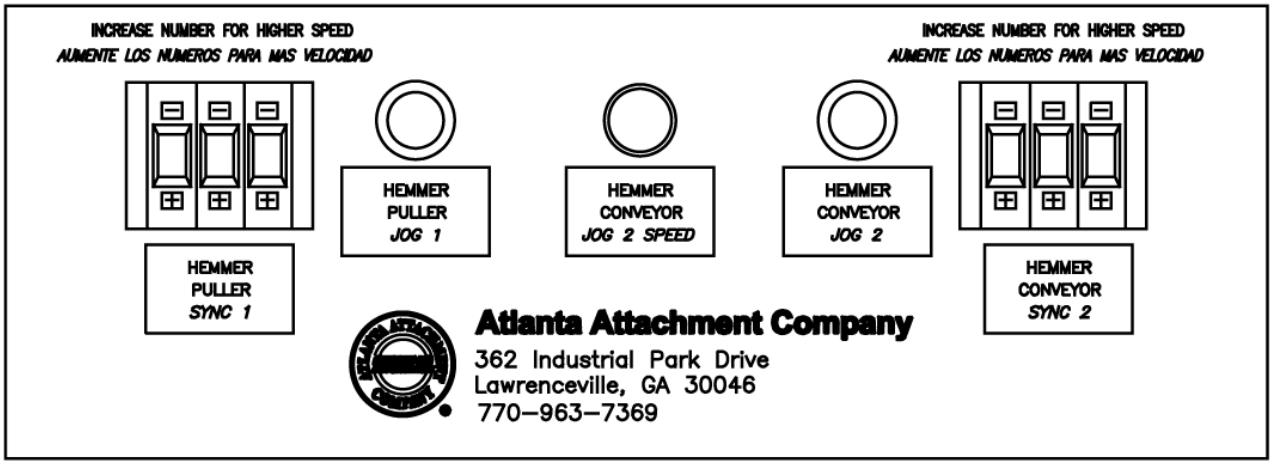
Wire the power cord to 208-230 VAC, 1 phase.

Connect 1/4" airline to the air input connector with 10CFM. Check regulators for proper PSI. The regulator should be set to 70 PSI.

There is a control box mounted below the sewing head (see page 1-8). This box controls the stepping motor that drive the conveyors and the Chain Puller. The three thumbwheels on the top box are set to synchronize the two conveyors to the sewing machine. If you change the sewing stitch length, it will be necessary to adjust these
numbers to re-synchronize the conveyors to the sewing machine. Decreasing the number makes the conveyors go slower. For example, if you changed the stitch length from 10 SPI to 11 SPI, you would need to decrease the number in the thumbwheels by 10% to match the 10% shorter stitch length. There is also a “Jog” button on the
top box. Pressing this button will run the conveyors when the sewing machine is not running. On the back of the box, there is a fuse holder and an on/off switch. Leave the switch on, except to do maintenance on the stepper motors or conveyors.

Control Box

AP-28-800N
Conveyor Speed Control Box



Instructions for 211ES

Note: The rows of buttons across the bottom of the screen are called Standard buttons. They will appear or change based on the needs of the current screen.

1. RESET: Always brings the machine back to its original power up state.
2. HELP: Will take you to a help screen pertaining to the screen you are currently in.
3. LANGUAGE: Allows you to change to a different language.
4. EXIT: Leaves the current screen and takes you to an appropriate screen (usually back one level or to the previous screen you were on).
5. START: Starts an event or function based on current screen information.
6. CONTINUE: Used to restart an event or function that has been temporarily paused or suspended.
7. HOME: Leaves the current screen and takes you to an appropriate screen (usually to the main operating screen.
8. CLOCK: While on the Main Screen it allows you to set the time and date. On all other screens it is a display only.

211ES Main Screen:

1. Leading Chop: This setting allows the user to control the amount of time from the sew eye seeing the leading edge of a sleeve till the leading edge chain chop occurs. The higher the number the shorter the length of chain.
2. Piece Counter: This is an adjustable piece counter that increment every time the stacker operates in automatic mode.
3. Trailing Chop: This setting allows the user to control the amount of time from the sew eye seeing the trailing edge of a sleeve till the trailing edge chain chop occurs. The lower the number the shorter the length of chain.
4. Manual Cut: Pressing this button manually activates the thread chop knife.
5. Conveyor Stop: This setting Controls the length of time the conveyor runs after hemming is finished. It must be set high enough to allow the last sleeve loaded to be stacked. The higher the number the longer the conveyor will run. This setting also affects whether the machine runs continually or stops between sleeves. If the gap between sleeves is large enough the machine will stop and will have to be restarted by pressing the Start in Automatic Mode button or pressing the foot switch. Conversely, if the gap is less the allotted the machine will run continually as long as sleeves are being loaded.
6. Conveyor Jog: This button allows the operator the manually run the conveyor if needed.
7. Advanced Functions: This button takes you to the Advanced Functions screen
8. Operator Screen: This button takes you to the Operator Screen (see pg. 1-12).
9. Start in Automatic Mode: This button starts the machine in automatic mode allowing the machine to run continually as long as sleeves are being loaded.
10. Switch to Manual Mode: This button takes you to a screen which allows the operator to manually run the sewing head in either sewing or chaining mode

Advanced Functions:

1. Advanced Settings: This button gives access to all available settings for the machine. Mechanic security level required.
2. Manual Input Test: This button takes you to the Manual Input Test screen which allows you to test the input devices on the machine, such as: photoelectric eyes and switches. Mechanic security level required.
3. Security: Allows you to change your current level of security or change the password for your security level or any level below you. Appropriate security level required.
4. Manual Output Test: This button takes you to the Manual Output Test screen which allows you to activate the output devices on the machine, such as: conveyor motor and stacker cycle. Mechanic security level required.
5. Style: Once the machine is adjusted for a particular type sleeve or material the style may be saved and recalled at a later time. Mechanic security level required saving styles, operators may recall styles.
6. Maintenance: Provides a list of routine maintenance tasks. Mechanic security level required.
7. Language: This button takes you to the Language screen which allows you to switch to any language listed on the screen.
8. Statistics: This button takes you to the Statistics screen which displays statistical information on the operation of the machine. Resetting the statistics requires a supervisor security level.
9. System Information: This button takes you to a screen that displays various information about the machine, such as: serial number or software revision number.

Advanced Settings 1:

Note: All objects on Advanced Settings screens 1 and 2 are buttons that take you to a setting screen that will allow you to adjust the setting an will give a brief description of how the setting works.

1. Leading Edge Chain Cut: Same as Leading Chop on 211ES Main Screen.1-9
2. Foot Down Delay: Time from the sew eye seeing the leading edge of the sleeve till the presser foot drops. The foot should drop at the first stitch in the sleeve. If set too early it will cause thread breaks.
3. Foot Up Delay: Time from the sew eye seeing the trailing edge of the sleeve till the presser foot lifts to allow chaining, and pressure is applied to the chain puller. The foot should lift at the last stitch in the sleeve. If set too late it will cause thread breaks.
4. Chain Puller Delay: Time from the sew eye seeing the leading edge of the sleeve till the puller goes into idle mode for chaining. The downward pressure should be removed at the first stitch in the sleeve. The chain puller only applies downward pressure when in chaining mode.
5. Head Stop Delay: Time from the sew eye seeing the trailing edge of the sleeve till the head stop sewing.
6. Chop On Time: Time the knife stays in the down position. Too small prevents the knife from cutting reliably, too large causes the leading edge chain to wad up in front of the knife.
7. Trailing Edge Chain Cut Delay: Time from the sew eye seeing the trailing edge of the sleeve till the chain cutter cuts. Same as Trailing Chop (1-9)
8. Conveyor Jog Off Delay: Time the conveyor runs after hemming is finished. Same as Conveyor Stop Pg 1-9)

Advanced Settings 2:

1. Jam Detect Time: Time from the sew eye seeing the leading edge of the sleeve till the sleeve should arrive under the stacker eye.
2. Chop Gap Time: Time of gap from the ends of the trailing and leading edge chains. If gap is smaller than this setting, only the leading edge cut will occur. A single cut between sleeves is preferred.
3. Stacker Return Delay: Controls how long the stacker clamp stays open to release the sleeve. This delay starts when the stacker limit switch is tripped. Once expired, the stacker reverses direction. If set too low, the stacker will reverse directions too soon and preventing the sleeve from stacking properly.
4. Stacker Switch Timeout: Time that the stacker switch can be engaged without causing a jam error.
5. Sew Eye Timeout: Time that the sew eye may see fabric continuously without causing a jam error.
6. Stacker Eye Timeout: Time that the stacker eye may see continuous fabric without causing a jam error.
7. Stacker Switch Jam Timeout: Time that the stacker switch can be engaged without causing a jam error.

Manual Input Test:

Note: While testing input devices the machine WILL NOT start in automatic mode.
A rectangle around the name of an input device is used to denote a change in its state. An example is when you manually cover the sew eye a rectangle appears around the name SEW EYE.

Operator Screen:

1. Contrast: This setting adjusts the contrast of the screen for easier viewing. The higher number the lighter the screens.
2. Stacker Enable: This setting allows the operator switch the stacker cycle on or off. 0 = off or disabled and 1 = on or enabled.
3. Waste System: This button turns on the waste vacuum system and the blowers on the chain puller and the top conveyor.
4. Stacker Cycle: This button manually activates the stacker cycle.
5. Style: Same as Advanced Functions (See pg. 1-9)
6. Inside, Outside and Looper Detect: This setting allows the operator switch the inside needle thread detector on or off. 0 = off or disabled and 1 = on or enabled.

Possible Machine Errors:

1. **Thread break on outside needles.**
   Possible Solutions:
   A. Check thread and replace if broken.
   B. Make sure thread is routed properly through sensor.
   C. Adjust tension on sensor.
   D. Replace or re-program sensor.
2. **Thread break on inside needles.**
   Possible Solutions:
   A. Check thread and replace if broken.
   B. Make sure thread is routed properly through sensor.

C. Adjust tension on sensor.
D. Replace or re-program sensor.

3. Thread break on looper.
Possible Solutions:
A. Check thread and replace if broken
B. Make sure thread is routed properly through sensor.
C. Adjust Sensitivity of sensor (Light goes off as thread moves through it.
D. Replace sensor.

4. Low air pressure detected.
Possible Solutions:
A. Air shutoff valve is closed.
B. Airline is disconnected from machine.
C. Air supply pressure is below 80 PSI.
D. Air regulator is adjusted below 70 PSI.
E. Air pressure switch is disconnected.
F. Air pressure switch is needs adjustment.
G. Air pressure switch has failed.
H. Module #5 has failed.

5. Possible sleeve jam. Relative setting: Jam Detect Time
Possible Causes:
A. Sleeve is jammed under the presser foot.
B. Sleeve is jammed under the conveyor.

6. Stacker bypassed return limit switch. Relative setting: Stacker Switch Timeout.
Possible Causes:
A. Stacker switch timeout setting set to low.
B. Possible defective limit switch.

7. Foot pedal pressed at power up or Reset.
Possible Causes:
A. Something is pressing down on the switch.
B. Possible defective foot pedal.

8. Stacker limit switch has been engaged too long. Relative setting: Stacker Switch Jam Timeout.
Possible Causes:
A. Stacker is jammed at switch.
B. Possible defective limit switch.

9. Sew eye is covered at automatic startup.
Possible Causes:
A. The sew eye is prevented from seeing the reflective tape. All eyes must be clear to start the machine in automatic mode. Manual can be use to remove material from under the foot. Restart in Automatic starts the machine as if it were in the middle of a sleeve.
B. Possible defective sew eye.

10. Sew eye has been covered too long. Relative setting: Sew Eye Timeout.
Possible Causes:
A. The sew eye is prevented from seeing the reflective tape.
B. The conveyor has stopped.
C. Possible jam under sew eye.
D. Possible defective sew eye.

11. Stacker eye has been covered too long. Relative setting: Stacker Eye Timeout.
Possible Causes:
A. The stacker eye is prevented from seeing the reflective tape.
B. The conveyor has stopped.
C. Possible jam under stacker eye.

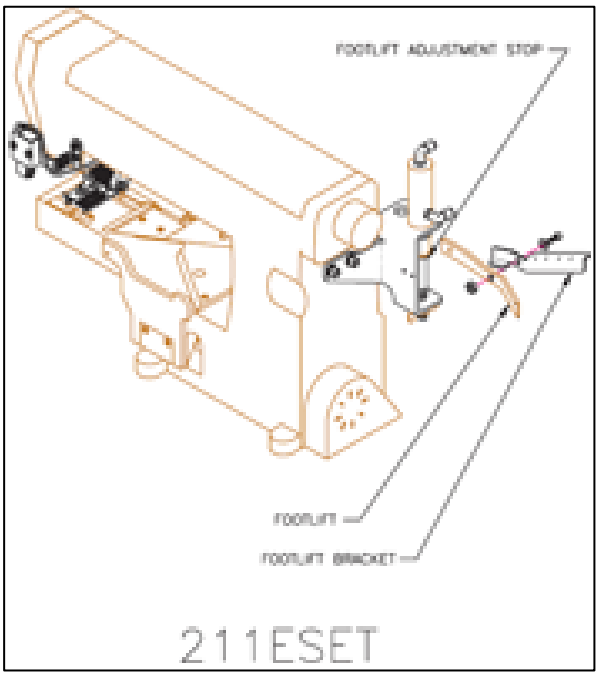
D. Possible defective stacker eye.

Conveyor Speed Control

Suggested setting for the conveyor speed control for 8SPI - 300. To synchronize with the head increase conveyor speed until the material pleats then decrease until pleating stops. If stitch length is changed repeat above procedure. (See page 1-8 and 1-17)

Footlift Setting

The height the foot lifts during chain off (Approx. 1/32") is adjusted with the stud screw located behind the sewing head next to the handwheel and below the footlift cylinders (see below).

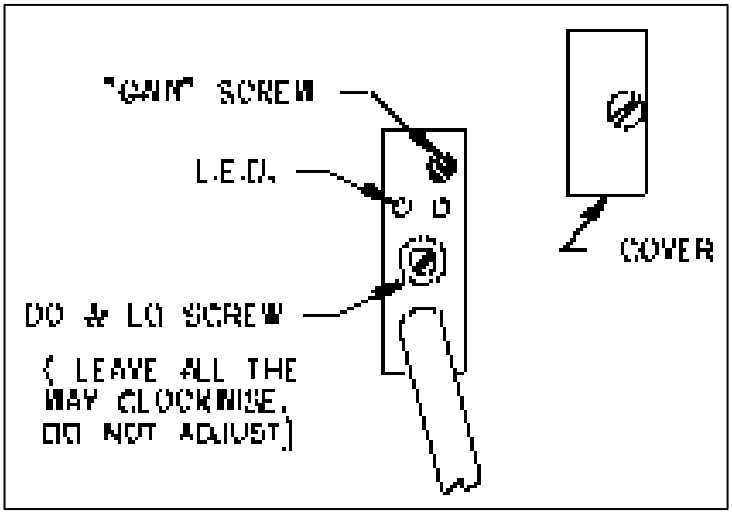


Electric Eye Sensor Adjustment

To adjust the sensor, first remove the clear plastic cover from the end of the sensor. There are two adjusting screws under the cover. One is labeled “GAIN” and is used to set the sensitivity of the sensor. The other screw is labeled “DO & LO” and should always be fully clockwise.

Adjustment

With the end of the sensor pointing at the center of the reflective tape, turn the “GAIN” screw counter-clockwise until the red L.E.D. indicator is not on. Then turn the “GAIN” screw clockwise until the L.E.D. indicator comes on. Then turn the “GAIN” screw one full turn clockwise. The L.E.D. indicator should be blinking slowly. Cover the eye so that the sensor cannot see the reflective tape and the L.E.D. should go out.



Thread Break Detectors

A. Adjustment and function of looper thread break detector.

This type of thread detector monitors the consistent movement of thread at a 5 degree angle (see Fig. 1) over a ceramic surface. With the unit running in manual mode, the three LED's on the detectors must not be on. The presence of a red light on any of the detectors indicates thread breakage or mis adjustment, thus causing the unit to stop.

B. Thread break detector adjustment procedure.

To adjust thread detector, switch control panel to manual. Depress the chain switch to make unit run and chain-off. Take precaution that the chain is under chain puller before running. Looking at the face of the thread detector with unit running in manual chaining mode, turn blue nylon screw (see Fig. 2) counterclockwise until you see the LED light up. Turn screw clockwise until LED goes out. Turn 1/16" more CW.

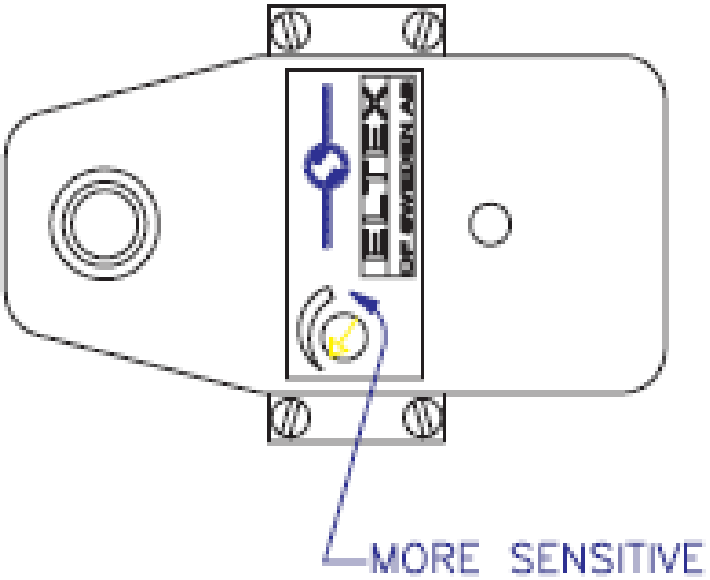
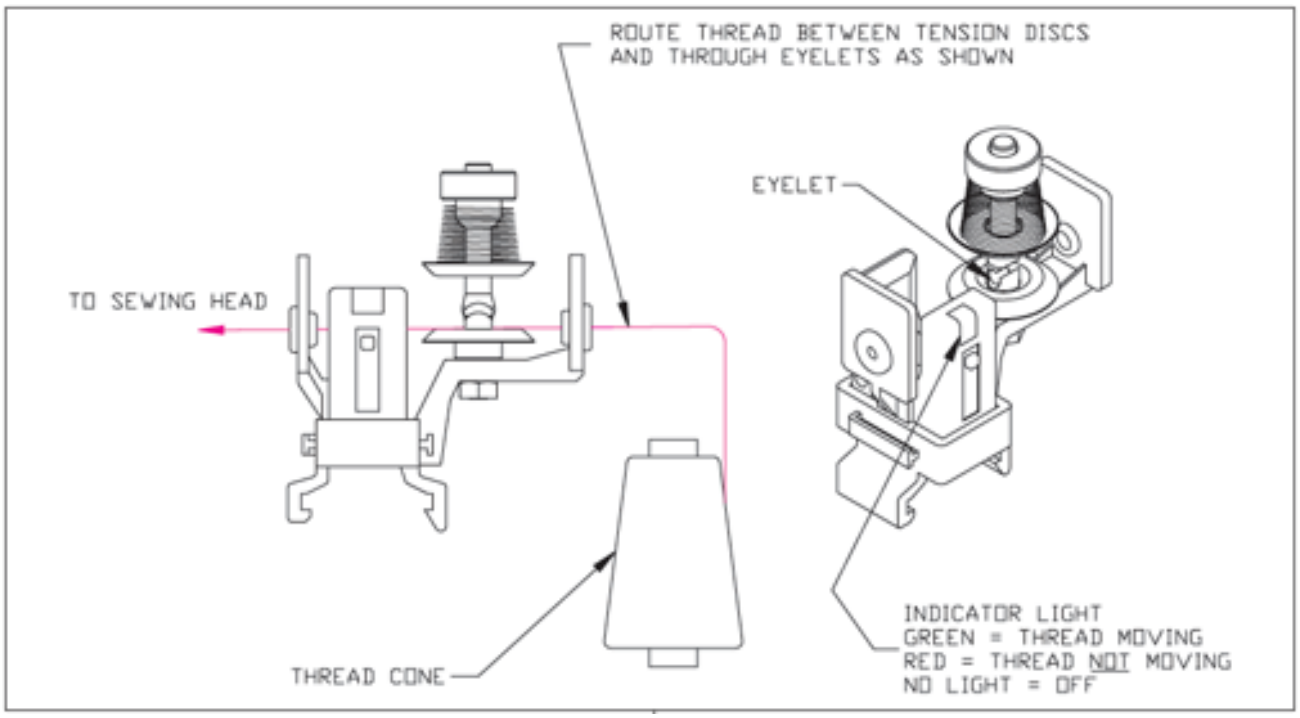


Fig. 2

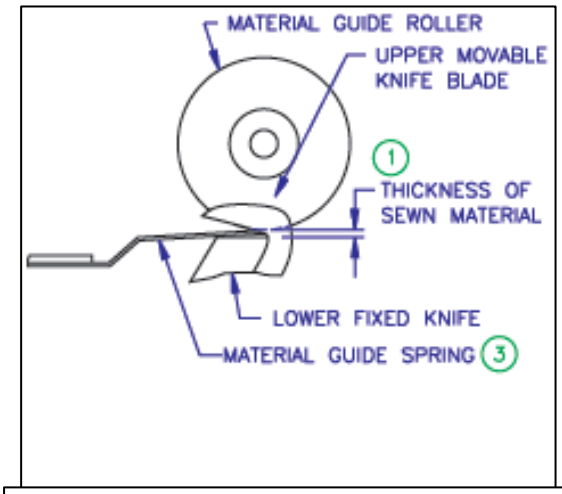
Thread Sensor Instructions



Adjustments to the Material Edge Trimming Guide System

The Material Guide Roller Should Be Adjusted In three Dimensions

1. The material guide roller should be located vertically to be the thickness (1) (Fig. 1) of the sewn material above the lower fixed knife. This is accomplished by loosening the two 1/4-20 bolts (2) (Fig. 4, page 1-17) attaching the material guide roller support block to the frame of the upper conveyor. Care should be taken to keep the support block moved to the right as it is also used to tension the drive belt. Once the adjustment is made, tighten the two 1/4-20 bolts securely. The material guide spring (3) (Fig. 1) should be adjusted to be only slightly above the lower fixed knife.
The material guide spring is only used to exert light pressure to hold the sewn material against the material guide roller. Excessive pressure will cause the sewn material to drag and premature
wear to the material guide spring.



2. The material guide roller should be adjusted along the sewing plane so as to be centered at the right 1/3 (Fig. 2) of the cutting edge of the upper movable knife blade. This is accomplished by loosening the two 1/4-20 bolts (4) (Fig. 4, page 19) located in the slotted holes of the upper conveyor mounting bracket. After locating the material guide roller properly, tighten the two 1/4-20 bolts securely.

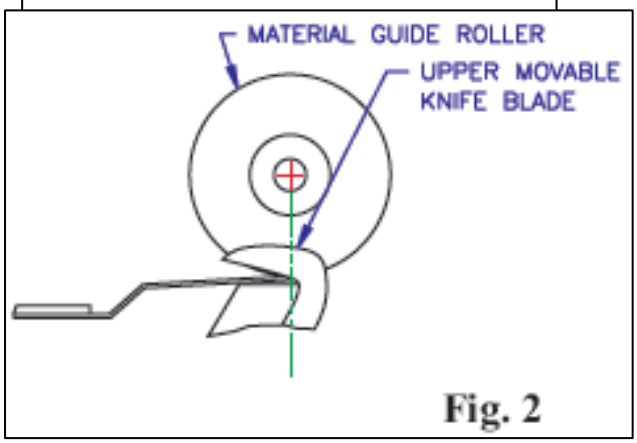


Fig. 2

3. The material guide roller should be adjusted along the drive shaft to leave 1/16" clearance between the roller and the upper movable knife blade. This is accomplished by loosening the set screws (5) (Fig. 3) in the material guide roller and moving the roller along the shaft until the desired 1/16" clearance is reached. Tighten the set screws.

Note:
This adjustment will have to be repeated every time the material trimming knife is adjusted for the amount of trim off.

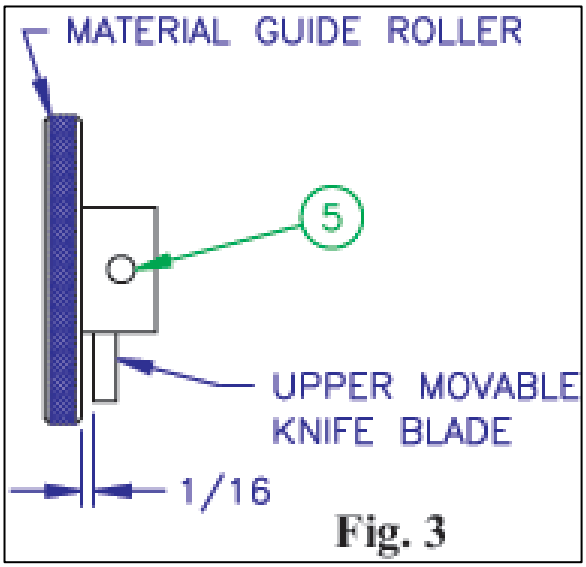


Fig. 3

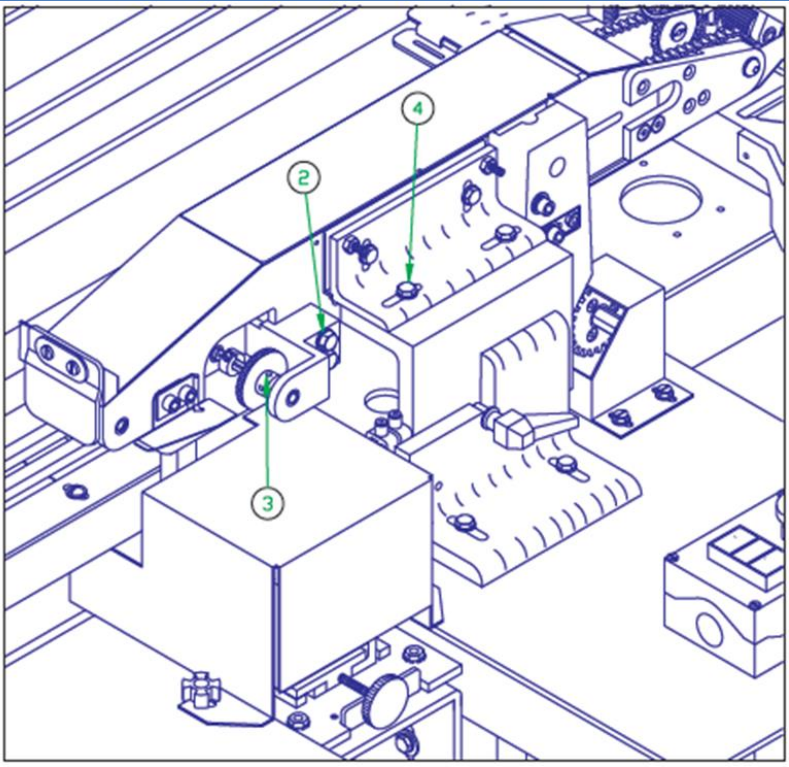


Fig. 4

Adjustment to the Thread Chain Puller and Speed Control

1. The thread chain puller should be down anytime the sewing head is running without material. After the sew eye is sees the leading edge of the
sleeve and the Chain Puller Delay has elapsed, the pressure on the chain puller is released. After the sew eye sees the trailing edge of the sleeve and the Foot Up Delay has elapsed, the presser foot lifts and pressure on the chain puller is applied. Chain Puller
Delay and Foot Up Delay settings are described on pg. 16.

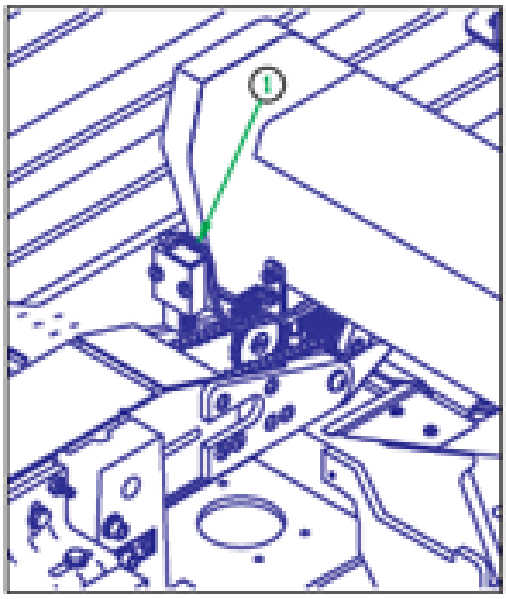


Fig. 1

2. There are two adjustments that can be made to the chain puller: height and levelness.

Height Adjustment
In adjusting the height of the puller, set the puller so that there is 1/2" clearance between the puller roller and the chaining plate. This adjustment is made by loosening the two socket cap screws in (Fig. 2, item 1) and positioning it so that the proper clearance is obtained.

Level Adjustment
After the proper height adjustments have been made the roller must be set so that it is level with the chaining plate. This adjustment should be made with the power OFF. Care should be taken in making this adjustment, as an improper adjustment may cause thread breakage and skipped stitches during the chaining process. Loosen the two 5/16-18 hex cap bolts (Fig. 2, item 2,)that secure the puller to the mounting bracket . It may or may not be necessary to raise or remove the presser foot to make this adjustment. When the roller is level with the chaining plate tighten the two hex cap bolts.

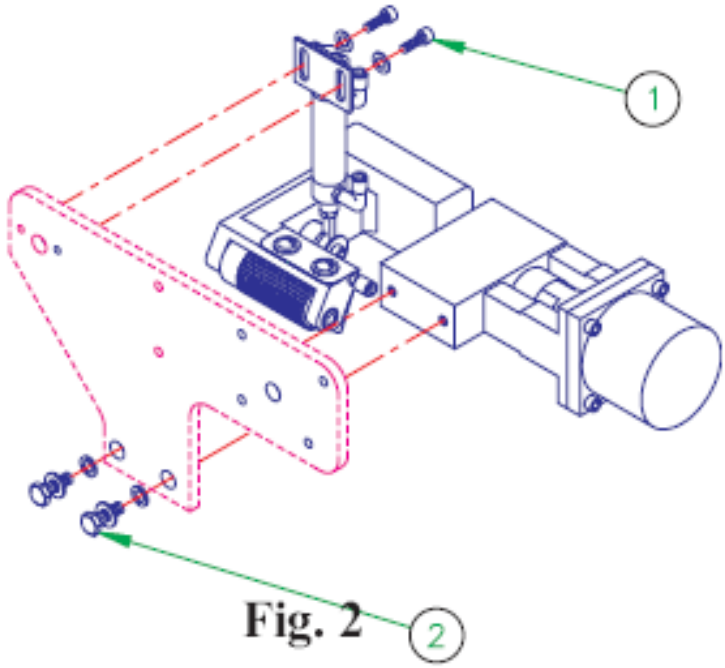


Fig. 2

Troubleshooting

1. Chain cutter knife not cutting.
A. Manually activate solenoid valve and check operation of air cylinder.
B. Disconnect air pressure and check hardware for mechanical problems.
C. Check cutting blades for proper adjustment. (Pg. 4-11)
D. Check cables and wiring for loose connections.
E. Check Chop On time Delay.

2. Sewing Head will not run.
A. Check if Emergency switch is ON.
B. Check cable at computer "B" socket and at motor socket.
C. Check eye in front of foot.

3. Edge trimming knife not cutting cleanly.
A. Check sharpness of knives.
B. Check knife adjustment.
C. Check top conveyor alignment. Right conveyor belt must be parallel to line of feed and aligned with edge of fabric at edge of folder.
D. Plastic roller must be kept close to top knife blade. See "adjustment to material edge trimming guide system" page 1-16.

4. Foot does not raise and drop at edge of sleeve.
A. Check Foot down delay setting.
B. Check electric eye adjustment at front of foot.
C. Check reflective tape.

5. Machine skipping or breaking thread.
A. See adjustment in manual on page 1-17.
B. Check needle thread tension too tight or too loose.
C. In case of thread breaking during chaining, check the levelness of the puller to the chaining plate. This is very critical to proper chaining. See page 1-17 for adjustment of levelness.
D. Chaining must be checked in "MANUAL MODE"

6. Thread chain wraps around roller.

A. Check air jets on puller bracket.
B. Check that the trimmer venturi is working.
C. Check roller for wear or burrs.

7. Machine stops while front electric eye remains covered.

A. Check adjustment of front eye.
B. Check for thread breaks.
C. Check sew eye time out setting.

8. Thread break sensor tripping without broken thread.

A. Adjust thread break detectors per manual (page 1-15).

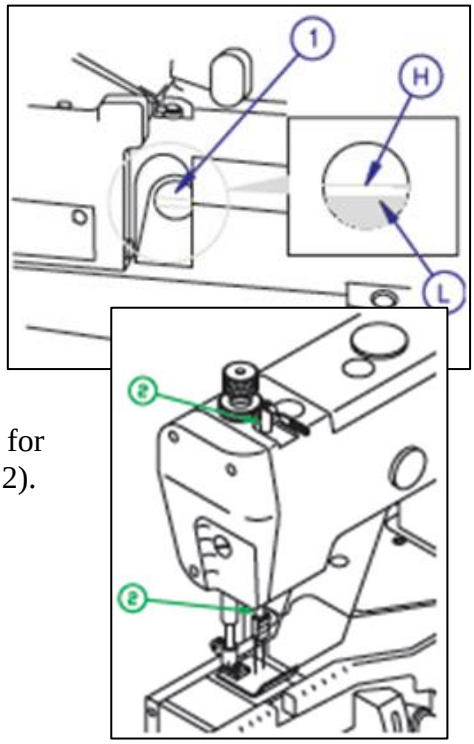
9. Machine runs-away when power is turned on.

A. Be sure power is turned on to all control boxes.
B. Disconnect remote treadle plug at sewing motor and apply power. If machine runs-away then replace defective Motor.
C. If machine runs-away when remote treadle cable is plugged back in then replace defective AAC control box.
D. Sew pedal is jammed in sewing position.

10. Stepping motor will not run in automatic, JOG, or runs backwards.

A. Check the socket at the stepping motor for broken or bent pins.
B. Check the stepping motor cable and plugs for loose connections.
C. Check pulleys and belts.
D. With power turned off and the stepping motor still plugged in, turn the stepping motor shaft by hand. Moderate resistance to turning indicates a defective stepper motor control box or shorted cable. Make this test again with the other end of the cable disconnected at the stepper motor control box to see if it is the control box or cable.

Sewing Head Maintenance



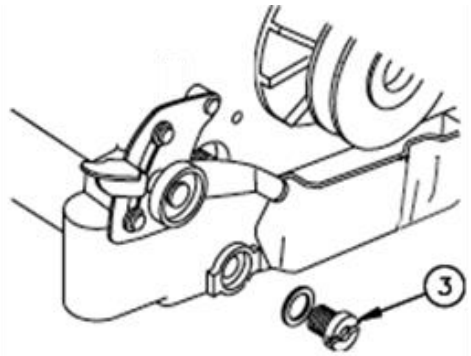
1. Oil Level

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

2. Manual Oiling

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

3. Oil Change



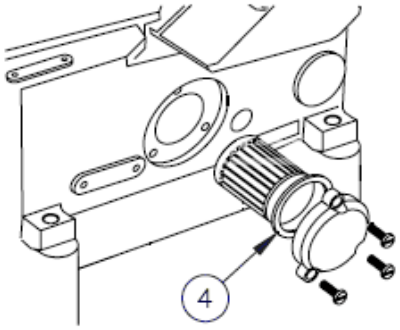
Change oil after the first month in operation. After that, change oil every 6 months.

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

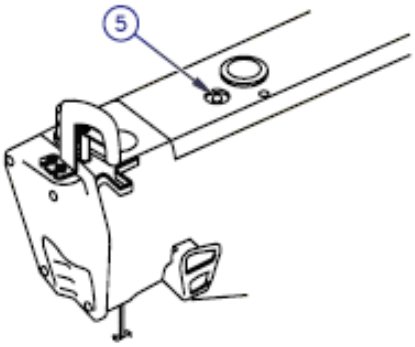
4. To Drain Oil

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

5. Checking and Replacing Oil Filter



If oil filter (item 4) is clogged, normal lubrication cannot be kept. Check and clean it every 6 months at the time of the regular oil change.



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

Suggested Sewing Guidelines for Pegasus W664

1. Needle Height Adjustment
The standard setting is as shown in Table 1. The needle height is the distance (a) (see Fig. 3) between the left needle point and the needle plate surface when the needle bar is in the highest position.

A. When the needle bar is in the highest position, the mark P on the handwheel (item 1) should meet mark A (see Fig. 2).

B. **To Adjust**

Loosen screw (item 2), and move the needle bar (item 3) up or down, adjust the needle bar height corresponding to needle gauge (see Fig 1.)

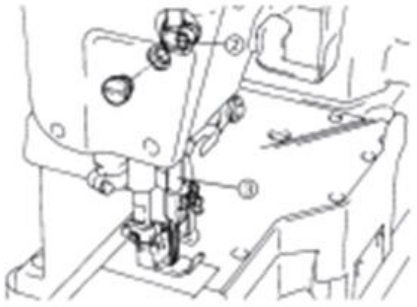


Fig. 1

Note:
After this adjustment, prior to tighten the screw (item 2), make sure that each needle passes through the center of the needle hole in the needle plate and that the gap (b) (see Fig. 3) is even as shown.

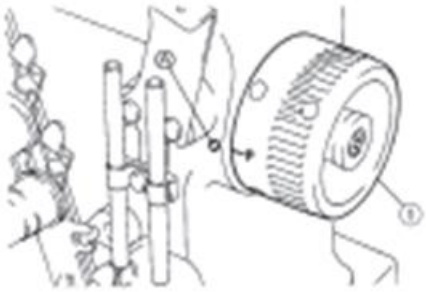
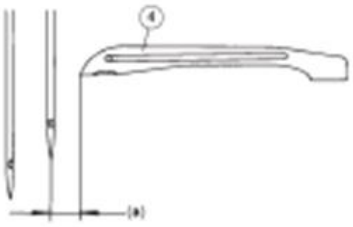


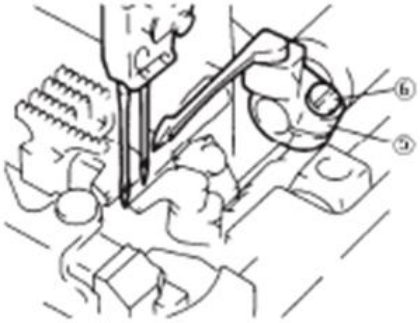
Fig. 2

Needle Height Table 1

	2-Needle
Needle gauge	Left needle height (a)
3.2mm	9.1mm
4.0mm	8.6mm
4.8mm	8.2mm
5.6mm	7.8mm

Fig. 3





2. Setting Position of Looper

A. Adjusting distance (a) .Set the distance (a) correctly according to the needle gauge as shown in Table 2. The distance (a) is from the right needle center line to the looper point when the looper (item 4) (see Fig. 4) is at the right most position. To adjust, loosen screw (item 6) and move looper holder (item 5) right or left. The distance (a) between the left (see Fig. 5).

Looper Setting Table 2

2-Needle	
Needle gauge	Distance (a)
3.2mm	4.7 - 5.0mm
4.0mm	4.3 - 4.6mm
4.8mm	3.9 - 4.2mm
5.6mm	3.5 - 3.8mm

B. Checking the Position of the Looper and Left Needle. When the looper point is behind the left needle centerline, it should be 1mm above the top of the left needle eye (see Fig. 6).

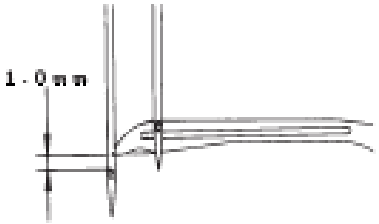


Fig. 6

Note:

For cotton & spun polyester this setting should be .8mm

When the left needle comes down and its point is flush with the top of the looper blade, the distance between the looper eye center and the left needle centerline should be 5.0 - 6.0mm (see Fig. 7).

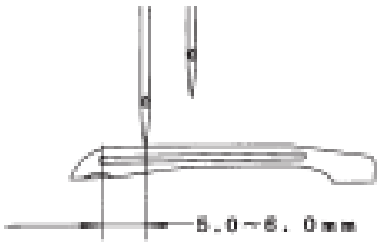


Fig. 7

C. **Clearance between Needle and Looper Point**.
Set the clearance between the left needle and the looper point to .05 - .1mm when the looper point is behind the left needle centerline. For cotton and spun polyester this setting should be .02 - .05mm (see Fig. 8).To adjust, loosen screw (item 6) of looper holder (item 5) and move looper holder back or forth(see Fig. 9).

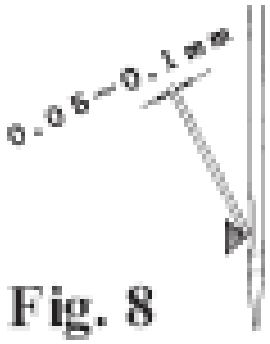


Fig. 8

Note:
The right needle and the looper point come in contact slightly when the looper point passes the right needle centerline from right most position (under the condition that the needle guard does not work.)

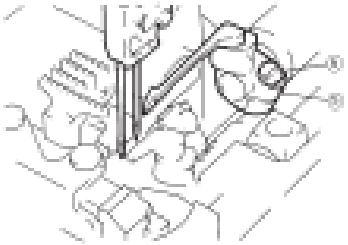


Fig. 9

3. Adjusting Looper Avoiding Motion
Please note that the looper avoiding motion may not be necessary to be adjusted unless otherwise an extremely different size needle is fitted. When the looper (item 4) goes in front of the needles to the right from its left most position and the clearance between
the center of looper eye and left needle centerline is approximately 3.0 - 3.5mm, make adjustment so that the top of left needle and the looper (b) (see Fig. 10) touch each other slightly in the following manner.

A. Re-adjust the looper avoiding motion according to the needle size. (See Figs. 8 and 9).

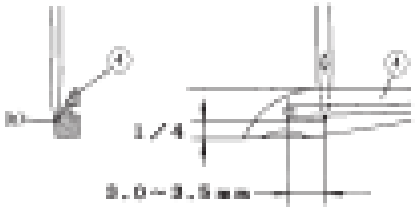


Fig. 10

B. IN Case An Extremely Fine Needle Is Used:
Loosen nut (item 7) and move the crank pin (item 8) back in the direction of A as illustrated in Fig. 11.

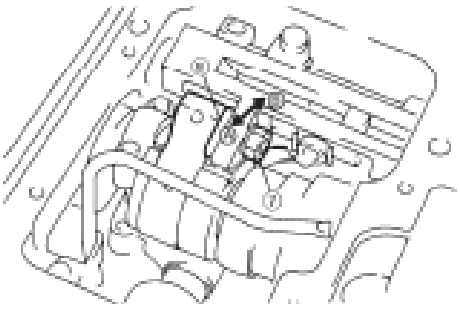


Fig. 11

C. In Case an Extremely Thick Needle is
Used:
Loose nut (item 7) and move the crank pin (item 8) forth in the direction of B as illustrated in Fig. 11.

4. Adjusting Needle Guard (Rear)

A. Adjust so that the line (A) of needle guard (rear) (item 1) is at bottom of the right needle eye as shown in Fig.12 when the needle bar is in the lowest position.

To adjust, loosen screw (item 2) and move needle guard (rear) (item 1) up or down (see Fig. 12).

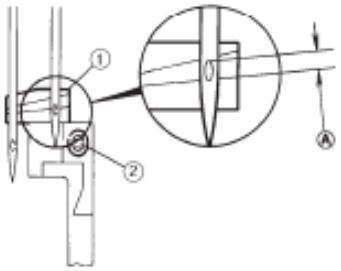


Fig. 12

B. When the looper point comes to the right needle centerline from right most position: The clearance between the right needle and the looper point is 0 -.05mm. To adjust, loosen screw (item 3) and move needle guard (rear) (item 1) back or forth (see Fig. 13).

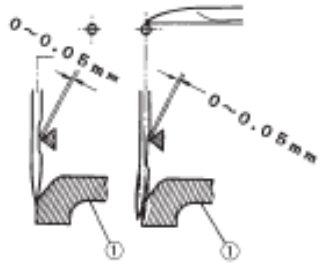


Fig. 13

C. When the looper point comes the middle needle centerline: The right needle and needle guard (rear) (item 1) touch each other slightly with 0 - .05mm clearance between the right needle and the looper point. To adjust, loosen screw (item 3) and turn needle guard (rear) left or right (see Fig.14).

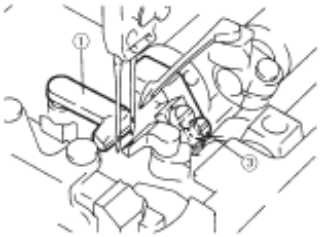


Fig. 14

5. Adjust Needle Guard (Front)

When the looper (item 4) advances to the left, it passes behind the needle, the clearance (a) between the needles and the needle guard (front) (item 5) should be as small as possible still sufficient for the needle threads to pass through it (see Fig. 15). Adjust in the following manner.

.

A. Loosen screw (item 6), turn needle guard (front) (item 5) right or left and adjust the clearance (a) to be in parallel (see Fig. 16).

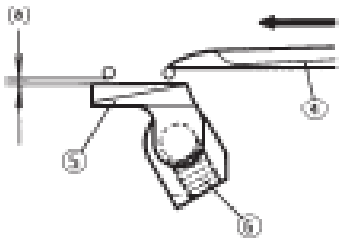


Fig. 15

B. Loosen screw (item 7), move needle guard (front) (item 5) back and forth and adjust the clearance (a) (see Figs. 15 and 16).

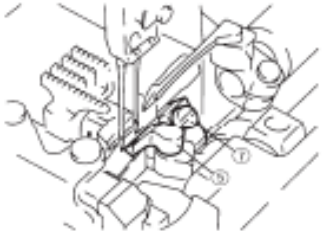
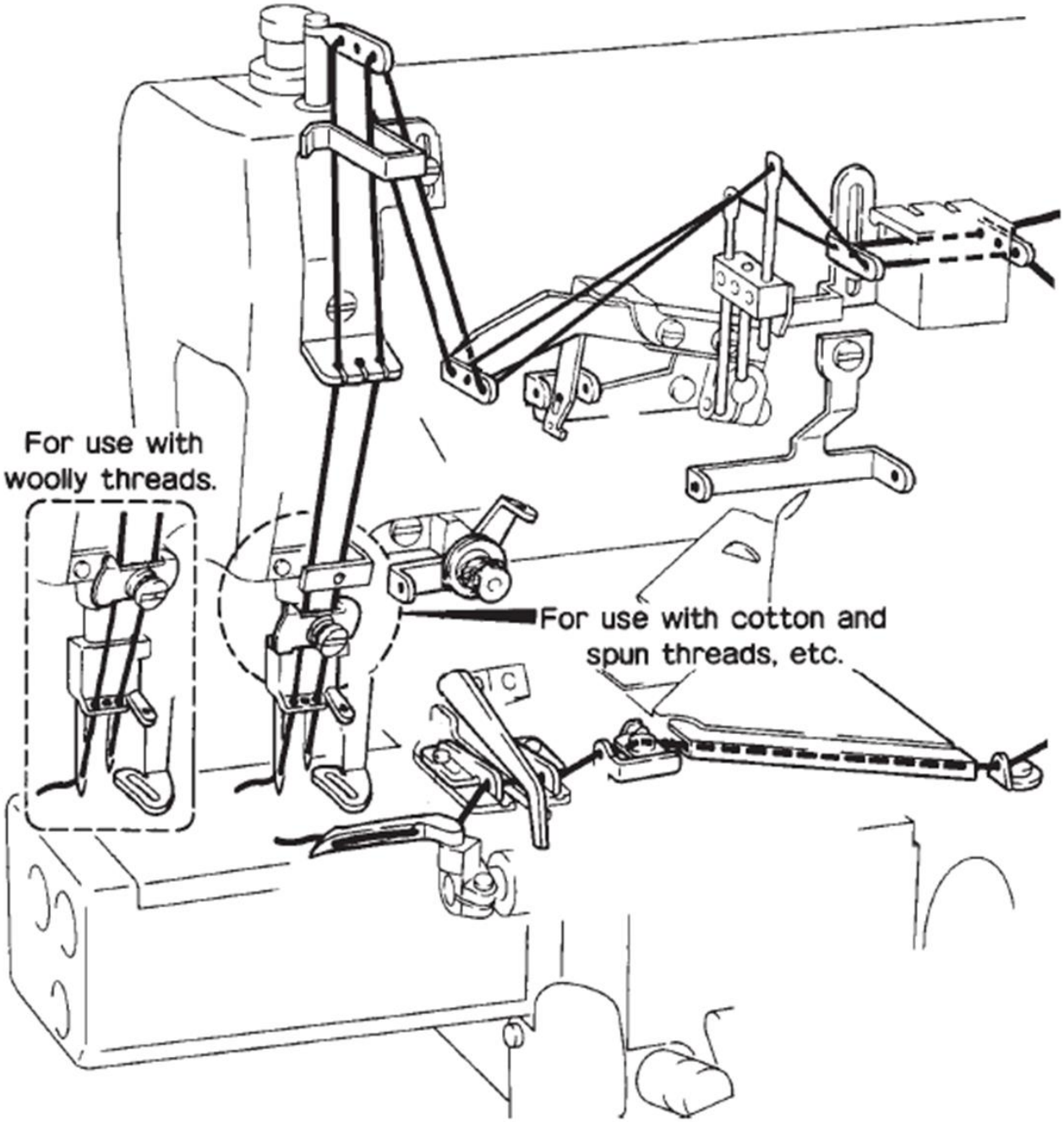


Fig. 16


For use with
woolly threads.
For use with cotton and
spun threads, etc.

6. Adjusting Needle Thread Take-up
(Cotton/Spun Poly)
In the standard setting, the top edge of bracket “6" should be horizontal when the needle bar is in the lowest position. The distance between the line (a) of bracket ”6" and the line (b) of the needle thread take-up should be 85mm. To adjust, loosen screws “7" &”8" (see Fig. 17).

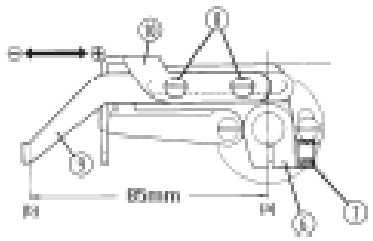


Fig. 17

Note:
To tighten the needle thread, move needle thread take-up “9" in the (-) direction. To loosen the needle thread, move it in the (+) direction. Adjust according to the thread characteristics, etc. (see Fig. 17).

Note:
Take care not to move spreader thread take-up“10" from its original position (see Fig. 17).

7. Adjusting Needle Thread Guide (Cotton/Spun Poly)
Needle thread guide"11" should center screws “12". To adjust, loosen screw ”12" and move needle thread guide “11" up or down. Adjust needle thread guide ”13" & “14" to distance shown. To adjust, loosen screws”15" & “16" (seeFig.18).

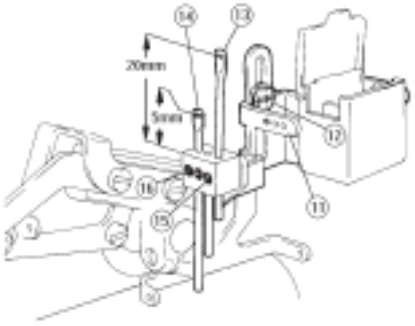


Fig. 18

Note:
To tighten the needle thread, move needle thread guides “13" &”14" upward. To loosen, move them downward. Adjust this depending on the characteristics of the threads to be used (see Fig. 18).

8. Adjusting Needle Thread Guard (Cotton/Spun Poly)
Set needle thread guard “19" with screw ”20" as shown. To adjust, loosenscrew"20" (see Fig. 19).

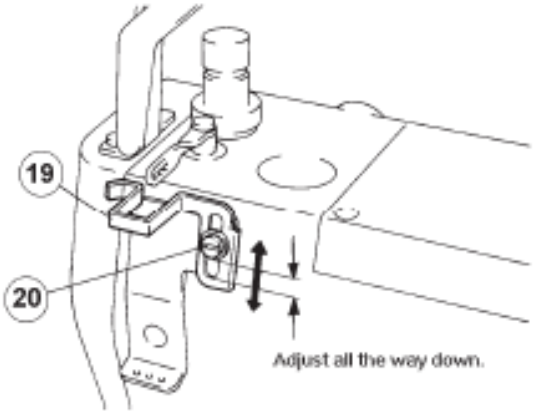


Fig. 19

9. Adjusting Looper Thread Take-up (Cotton/Spun Poly)

For sewing cotton thread adjust looper thread take-up as shown in (Fig. 20).

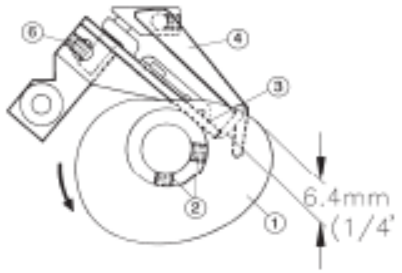


Fig. 20

10. Setting Thread Guides (Cotton/Spun Poly)

Set thread guides all the way forward as shown for cotton thread in Fig 21.

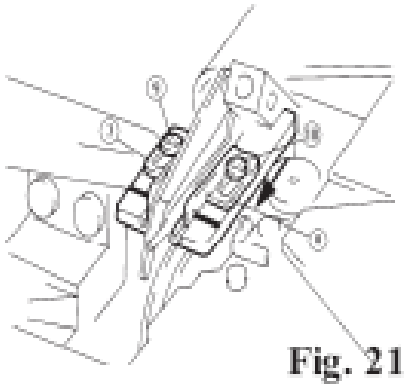


Fig. 21

Suggested Sewing Guidelines for Rimoldi

1. Positioning Of the Needles (Fig.1)

The machine has been tuned with RIM needles. The needles are in the correct position on the horizontal plane when, with their points inserted in the needle plate, they are centered with the eyelet. The needles are in the correct position on the vertical plane when distance “a ”between the point of the needle in its uppermost position and the plane of the needle plate is as shown in the phasing table which comes with the head. To adjust, loosen screw A on clamp B and adjust it. Next tighten the clamp screws, making sure that it is pushed up home against the needle bar. Adjust pin C so that it touches the needle holding clamp and then lock it with screw E. Tighten up clamp screw A on clamp . Distance “a” on the interlock stitch machine should be measured considering the right needle. Screw down the clamp screw tightly. The distance “a” must fall between the point of the right hand needle and the Surface of the needle plate.

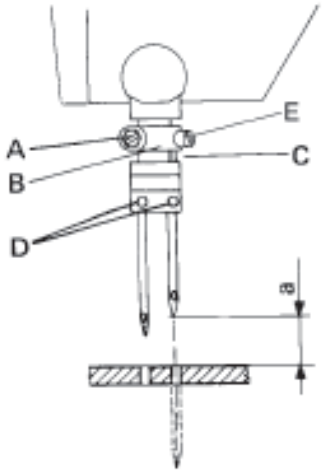


FIG. 1

2. Positioning the Presser-foot And Setting Presser Spring Regulator (Fig. 2)

The presser-foot is in the correct position when the needles pass through the center of the slots in the presser-foot. The needles can be centered by loosening screw C which blocks the presser foot at the bar Remember that with the presser-foot raised about 4.5 mm. above the needle plate, the tensioning plates must be open. If they are not, loosen nut A and move arm B as necessary. To adjust the pressure applied by the presser-foot, screw or unscrew knob D as required.

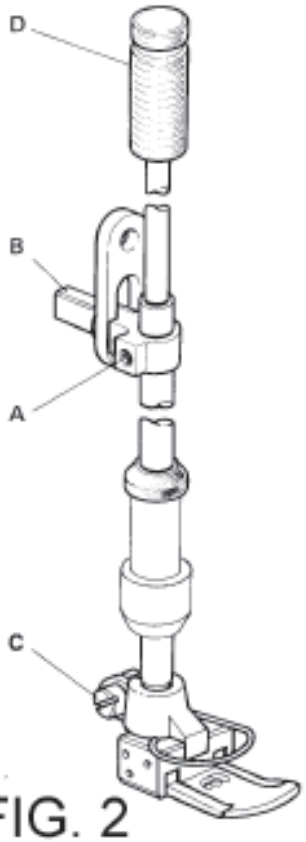


FIG. 2

3. Setting The Lower Looper
(Fig. 3)

Insert looper A in the looper holder positioning it at the top with calibrator 315910-0-00 (supplied with all the machines) to obtain dimension W (see value on phase sheet Pg. 33) which represents the distance between the back looper and the bottom of the needle plate. Block it at the reference level of the leg with screw B. Check that the measurements correspond with those in the phase instructions (attached to the machine).

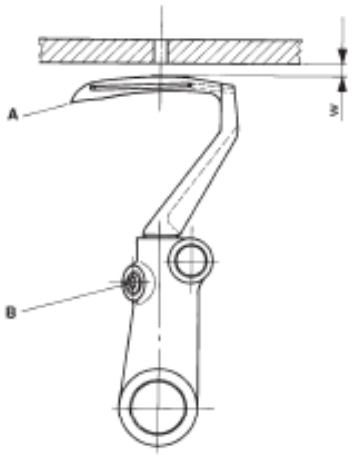


FIG. 3

In the case of need to carry out corrections, operate as follows:

A. To obtain dimension “b” (Fig. 4) move the looper to the extreme right, slacken screw L (Fig. 5) of clip M and operate on the N rod of the master connection rod (Fig.5) until the dimension prescribed in the phase instructions is obtained.

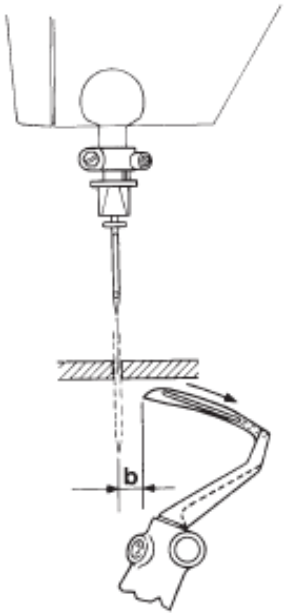


FIG. 4

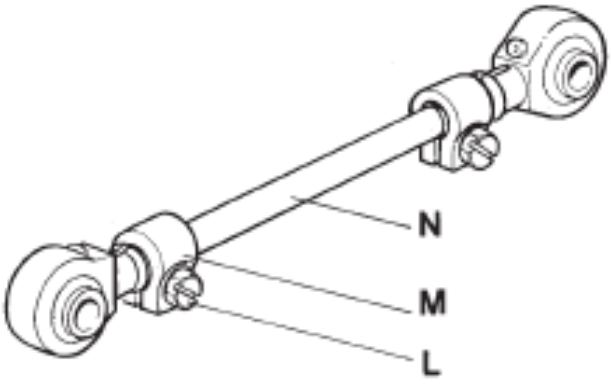


FIG. 5

B. To obtain dimension 0.05 (Fig.6) which represents the distance between the end of the looper and the groove of the needle during its stroke from right to left, loosen screw G (Fig.7) and adjust by turning shaft H.

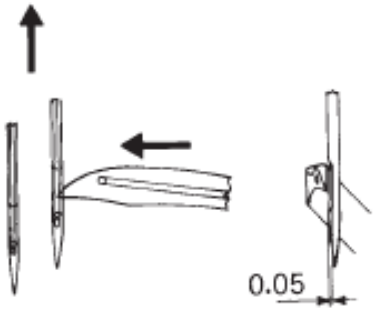


FIG. 6

C. On lowering, the needles should come into contact with the back of the looper blade and bend. In order to obtain this, it is necessary to line up the index line on the cam crown with notch M on joint N. Important - in the case of slackening of screws E and F (Fig. 7), the reference line on the crown of C must coincide with line M on the face of con-rod N.

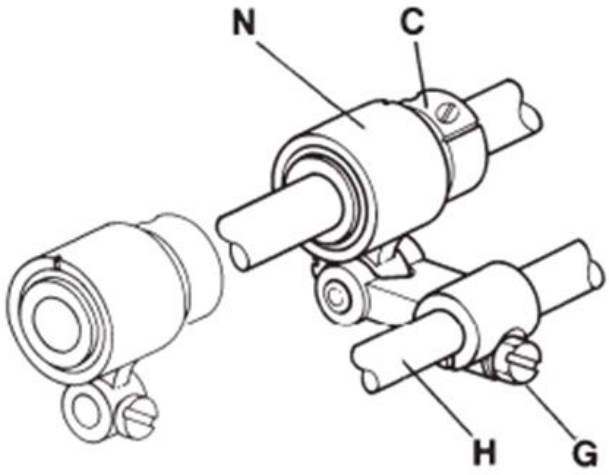
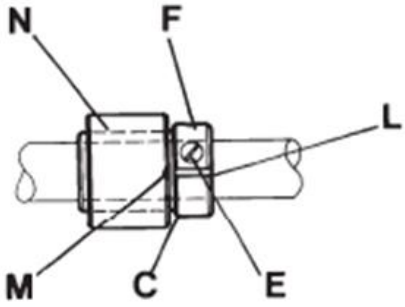


FIG. 7



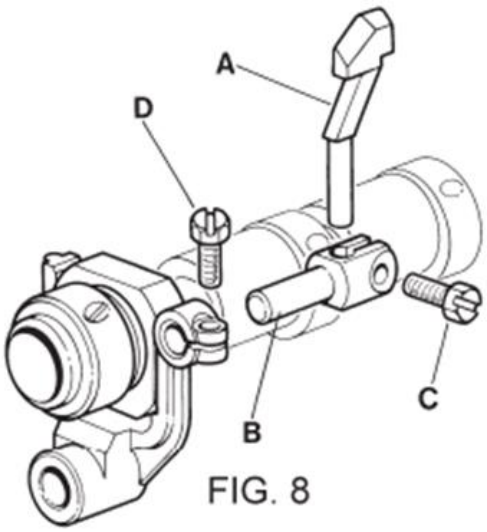


FIG. 8

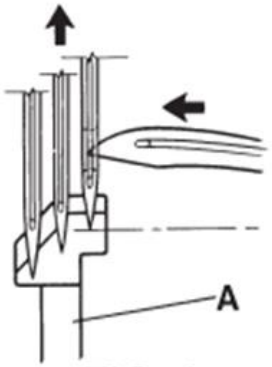


FIG. 9

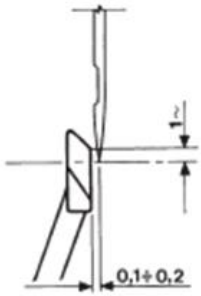


FIG. 10

4. Setting Needle Guard (Fig. 8)

Bring Looper point (Turning machine in direction of operation) as shown in Fig. 9. By loosening screws C & D (Fig. 8) adjust needle guard to setting on Fig 9 and 10.

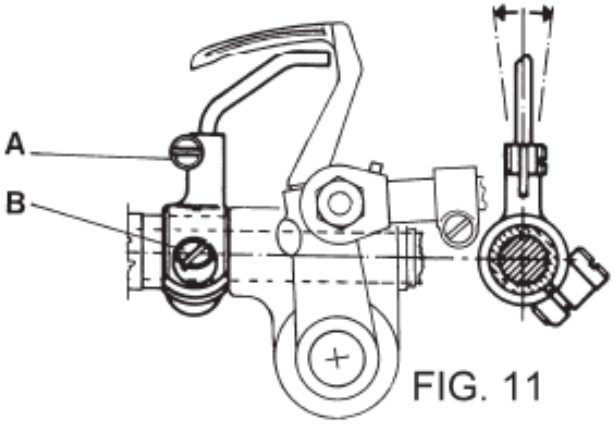


FIG. 11

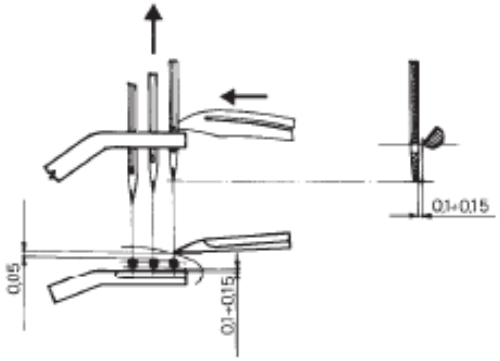


FIG. 12

5. Setting Front Needle Guard (Fig. 11)

Set front needle guard as per (Fig. 12) by loosening off screws A and B (fig. 11)

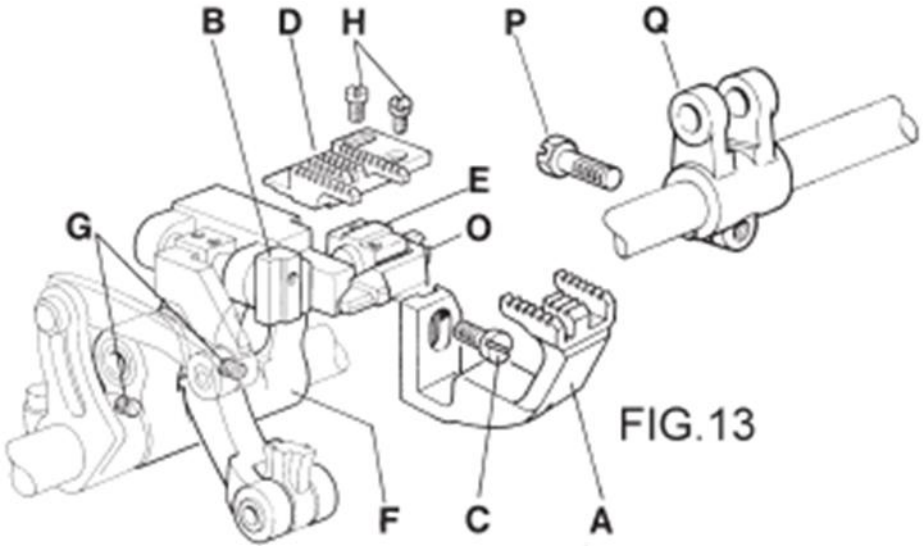


FIG.13

6. Assembling Feed Dogs on Feed Dog Support (Fig. 13)

With screw C assemble the front feed dog A in its seating in the slot of feed dog support B. Assemble the main differential feed dog D without tightening it down on feed dog bracket E with the two screws H. Align feed dogs A and D Tighten the two screws H.

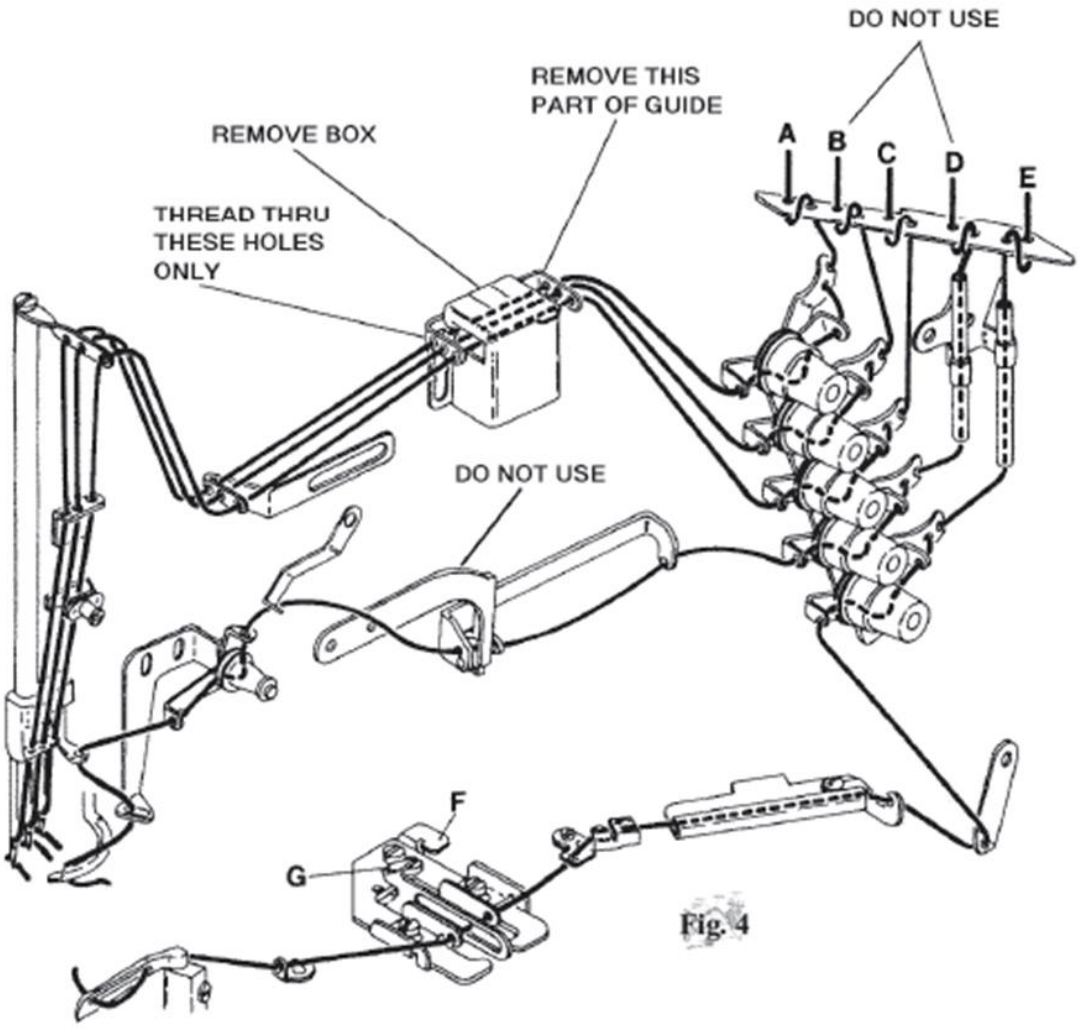
7. Centering Feed Dogs (Fig. 13)

Loosen the two screws G - Assemble the needle plate and center the feed dog A and D in a lateral sense in the slots of the needle plate moving the entire differential unit F. - Tighten screws G - While turning the handwheel in operating direction check that the feed dogs do not touch the needle plate at the bottom of the slots; if this should happen loosen screw P of the fork Q inside the base.
- Turn unit F and carry out the centering of the feed dogs with respect to the slots in the needle plate.
-Tighten screw P.

Phase Sheet :

TESTE	POSIZIONE E CALIBRO AGHI	SISTEMA AGHI	VALORI DI FASE					
			A	B	W			
TF71-... TF73-...		RIM63	11	6	1.2			
TF71-... TF73-...	3.5	RIM63	12 12	4.25 4.25	1.2			
TF71-... TF73-...	4.5 4.5	RIM63	12.5 12.5	3.75 3.75	1.2			
TF71-... TF73-...	6 6	RIM63	12.5 12.5	3.75 3.75	1.2			

Suggested Guidelines for Yamato VC2600



1. Threading the Machine

Threading should be made correctly referring to the illustration. Improper threading might cause skip stitch, thread breakage and uneven tension. A, B, C needle thread D...top cover thread E Looper thread.

Threading for two needle machine is shown in the illustration above. Easy threading is possible with the lifting up of Supporting Plate by pressing Lever (F).

After threading, return it back to the original position by pressing part (G) without fail.

2. Gauge Set Installation.

Remove old gauge set; refer to machine specifications for proper settings.
Machine specifications should have a tolerance no more than (+) or (-) 0.1mm. Incorrect setting may cause thread breakage, skipped stitches and improper chaining. “Therefore, all adjustments must be checked before installation of new gauge components.”

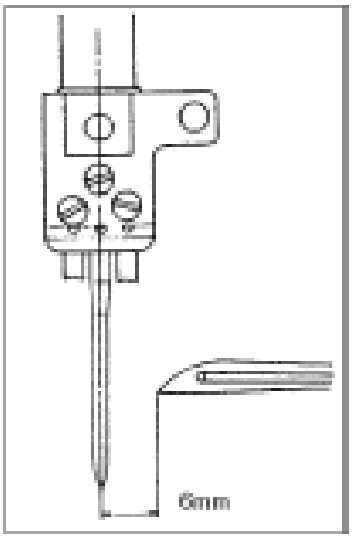


Fig. 5

A. Movement of Looper to Right

The distance from the point of Looper to the center of Needle Bar is 6 mm when Looper moves to the extreme right end. (Fig. 5)

B. Needle to Looper Distance

The table at center shows the distance of Looper moved to the right from the center of Right Needle.

Needle To Looper Distance	
Needle Distance (Mark)	Movement of Looper to Right End (mm)
3.2mm (32)	4.4 (A)
4.0mm (40)	4.0 (B)
4.8mm (48)	3.6 (C)
5.6mm (56)	3.2 (D)

C. Looper Adjustment

To adjust the distance of the Looper at the extreme right position loosen Screw (A) of Looper Holder.(Fig. 6)

Use Timing Gauge (No. 0095220- supplied on extra order), to make correct adjustment.

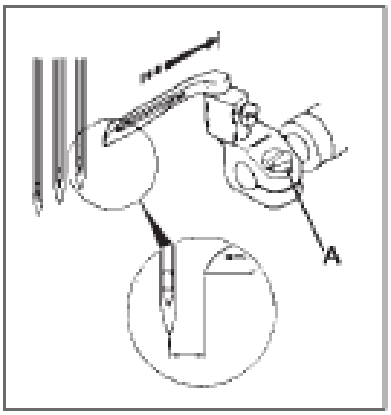


Fig. 6

D. Use of Looper Gauge

Put the right needle in "V" groove corresponding to Marks (A-E) on the Gauge then apply the point of Looper to the Gauge and tighten Screw (A). (Fig. 7)

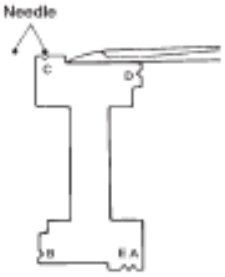


Fig. 7

*Recommended adjustment when moving Looper Holder, especially to adjust it to right and left, make adjustment with caution so that it does not move back and forth.

E. Height of Needle

In turning the machine, when the point of Looper comes to the center of left Needle it is standard that the point passes the place 0.8 mm above the top edge of eye on the back of needle. (Fig.8).

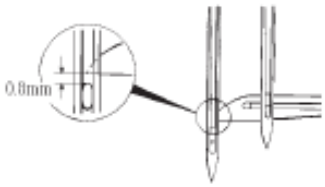


Fig. 8

F. Looper Position

When looper passes 1 mm to left of left needle top of needle eye should be at same level with bottom of looper. (Fig. 8.1)

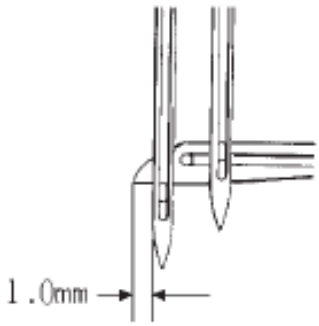


Fig. 8.1

G. 2 Needle Machines when the point (A) of Looper meets left Needle (F), there should be a clearance of 0.2- 0.3 mm between them. Adjust this loosening Screw (D) on Looper Holder.

Push right Needle (E) with the effect of rear Needle Guard and provide a clearance of 0-0.05mm between Needle (E) and point of Looper (Fig. 9).

(Refer to items concerned to Needle Guard)

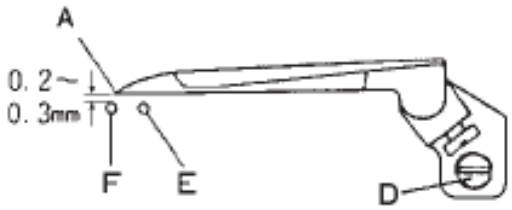


Fig. 9

H. Position of Rear Needle Guard when Needles are at their lowest position, the line (A) of rear Needle Guard is set with the center of needle eyes.(Fig. 10).

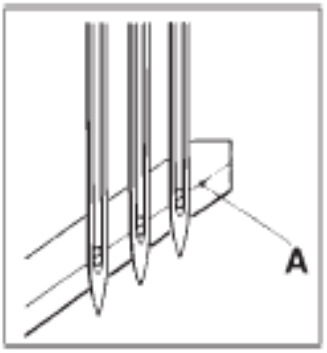


Fig. 10

Note; Make sure not to trap the thread loop. Thicker thread may need more clearance at the eye.

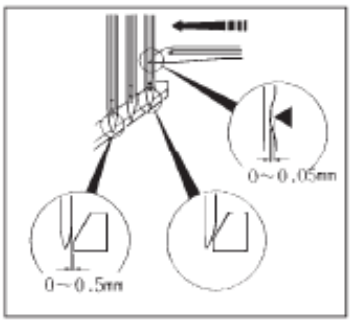


Fig. 11

This is the standard position. *Adjust the height of Needle Guard (Rear) by loosening Screw (B) so that the line (A) will come to the center of each eye, when Needles lower to lowest positions, and when the point of Looper passes the back of each Needle, Right Needle is pushed forward leaving a clearance of 0-0.05mm for left Needle.(Fig. 11) By loosening Screw (C), adjust the clearance between right Needle and Looper to be 0-0.05mm when the point of Looper comes to the center of Right Needle. At this moment, the clearance of 0-0.05mm should also be provided between Needle (left) and the Guard (Rear) by loosening Screw (B). (Fig.12)

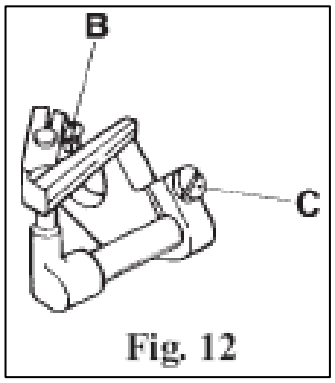


Fig. 12

***Recommended adjustments**

Because both adjustments of height and longitudinal position of rear Needle Guard are made by loosening only one Screw (B), it must be done most carefully to keep the proper relation to the positioning.

I. **Changing Avoiding Momentum of Looper**

When Looper returns from extreme left, on the standard locus of its movement, it is standard that the point of left Needle contacts the back face of Looper by 0.3mm (Needle is pushed backward).(Fig. 13)

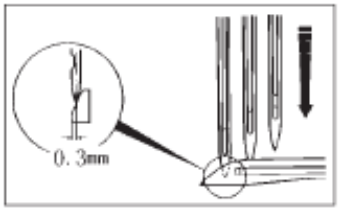


Fig. 13

Note: At the time of shipment, the avoid movement of Looper has been adjusted suitably to the use of Needle (#65- 75). The standard adjustment is not suitable when using Needle of #80-90, adjust the avoiding movement of Looper according to the following procedure.*Fix Screw (A) of Looper Rocker Adjusting Pin by screwdriver after removing Crank Chamber Cover and loosen Nut (B), then adjust the avoiding movement by moving Looper Rocker Connecting rod back and forth. (See Fig. 14) Looper Bar Guide has the Mark (C). When the Countermark (D) on the Connecting Rod is moved to your side beyond Mark (C), the avoiding movement of Looper will increase and when moved to rear it will decrease. Troubles occurring by improper adjustment.*Too little avoiding movement of Looper will increase the degree of touch of Needle to the back of Looper and cause the destruction of needle point. *Too much avoiding movement of Looper-Will increase the clearance between Needle and the back of Looper will cause skip stitch on the way of Looper to right.

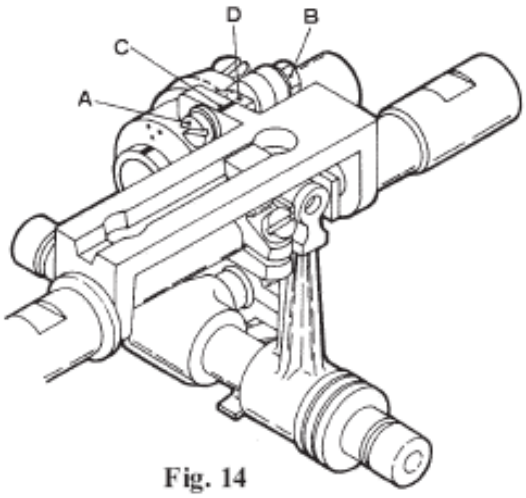


Fig. 14

J. Position of Front Needle Guard when the point of Looper passes at the center of Left Needle, The front Needle Guard must be at 1.5-2.0 mm above the needle point, and also there should be a clearance of 0-0.3 mm respectively between the point of Looper and each Needle.(Fig. 15) *By loosening Screw (A), adjust the height of Front Needle Guard so that the point of Looper will be at 1.5-2.0 mm above the point of left needle when passing center.

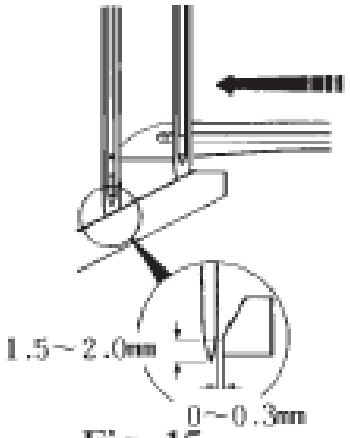


Fig. 15

*By loosening Screws (A) and (B), adjust the longitudinal position of front Needle Guard so that there should be clearance of 0-0.3 mm between the Guard and each of Needles respectively when the point of Looper passes each center of Needles.(Fig. 16)

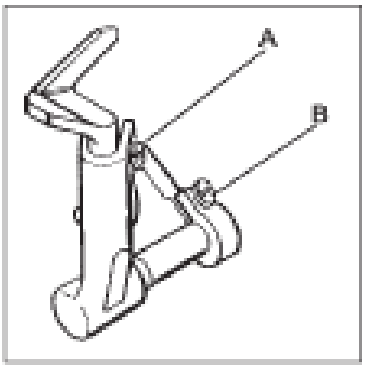


Fig. 16

*Recommended Adjustments at the time of shipment of machines, Front Needle Guard has been adjusted to come nearest to left Needle when
the point of Looper passes at the center of Needle. In case of readjusting timing of movement of front Needle Guard, loosen Screw (C) (Fig.17) and move Needle Guard Eccentric (D). The standard adjustment is to set Countermark on the Shaft with center of Screw, which is the rear one to rotating direction.

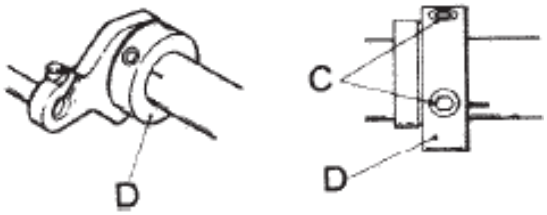


Fig. 17

Note: When tightening Screw (B) check there is no play left to right after adjustment.

3. Thread Handling Adjustments

Yamato VC2600: Before sewing on the unit, depending on present thread being used, you must adjust the following thread handling components.

A. Position of Needle Thread Take-up (Cotton/Spun Polyester)

There should be 57 mm to
Needle Thread Take-Up Eyelet (A) from the center of Screw (B) when Needle Bar is at the highest position and also the portion (a) of
Needle Thread Take-Up Bracket is horizontal (Fig.18) this is the standard position of the Eyelet (A). *To adjust the position of Needle Thread Take-Up Eyelet, loosen Screw (C) and make the portion (a) of Take-Up Bracket horizontal when Needle Bar is at the highest position.*To adjust the position of Take-Up (A) to right or left, loosen 2 Screws (B) and move the Eyelet to right or left.

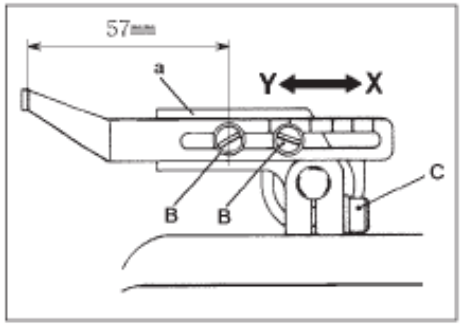


Fig. 18

***Recommended Adjustments**

When Needle Thread Take-Up Eyelet (A) is moved to the direction Y (over 57 mm) the needle thread will have a touch of tightness and to X (less than 57 mm) the thread becomes loose.

B. Position of Needle Thread Guide

In case of using thread of Polyester Spun or the like, when Needle Bar is at the lowest position, the center of thread eye of Needle Bar Thread Eyelet (A) should be parallel with the top face of Needle Thread Guide (B) at the same height. This is the standard position of Needle Thread Guide.

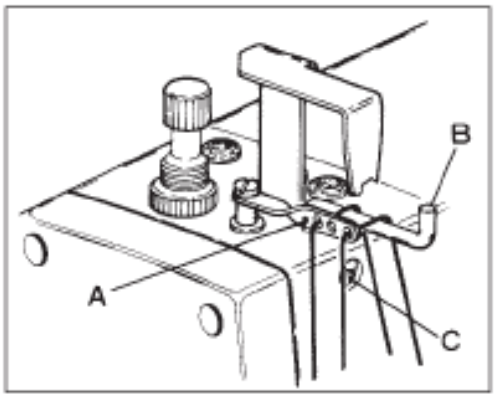


Fig. 19

C. Height Adjustment

*To adjust the height and position to right or left, loosen Screw (C) and move the Guide (B) to right or left and up or down. *For sewing 100% cotton thread or spun polyester, take thread guide (B) and turn to the side. Do not use in this case.

*Recommended Adjustments

*When using wooly thread (stretchable), set Needle Thread Guide at the place highest possible.
*If skip stitch is caused because of the needle thread loop is formed too small, set the Guide higher.
*When skip stitch is caused because of the needle thread loop formed too large, set the Guide lower or turn it to the rear side.

D. Position of Thread Take-up Eyelet
The mark (A) of the Supporting Plate meets thread eyes of Thread Take-Up Eyelet (B) and (C).(Fig. 20) This is the standard position of Eyelets. *When the Eyelets are moved to the front side after loosening Screws of the Thread Take-Up (B) and (C), the looper thread will be sewn loosely and when they are moved to opposite side the thread will be sewn tightly. *When using wooly thread, move Eyelets (B) and (C) (Fig.20) fully to the front without threading on Needle Thread Retainer Disc (D).(Fig. 21) *(Cotton/Spun Polyester) Set thread guides all the way forward as shown.

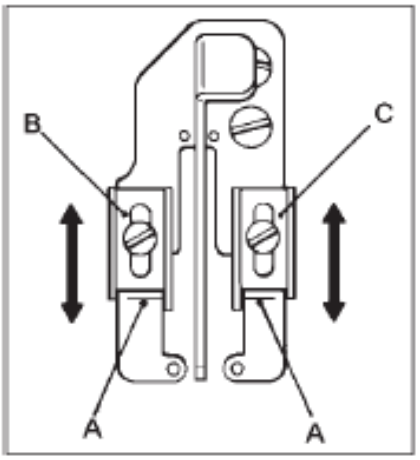


Fig. 20

*** Recommended Adjustments**
With different thread than wool, too much thread loop created by moving eyelets to the front ma cause skip stitches

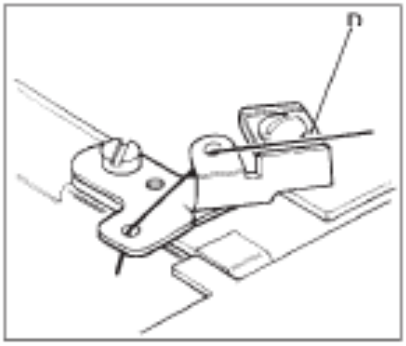


Fig. 21

E. Position of Looper Thread Take-up Set position of looper thread take-up so that thread begins pull off as looper starts to descend to the right from far left position. At this setting, the thread cam will have approximately 6.4mm or 1/4" pull off showing at the above Take-up position. See figure 22. To adjust, it may be necessary to move the thread cam in increments of 0.3mm or 1/64". Make Cast-Off Plate be in the center of groove on Looper Thread Take-Up.

1) Apply Cast-Off Plate (A) to Collar (B) to make it come to the center of groove on Looper Thread Take-Up (D) (Fig. 23). Then adjust the lateral position of the Take-Up (D) loosening Screw (C).

2) On the return way of Looper to right, when the point of left Needle reaches approximately the center line of blade of Looper (Fig. 24), the looper thread should be adjusted to come off the highest place of Looper Thread Take-Up (D) (Fig. 22). This adjustment is made by loosening Screw (C) and moving the Take-Up (D).

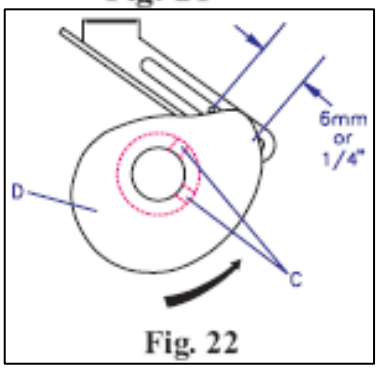


Fig. 22

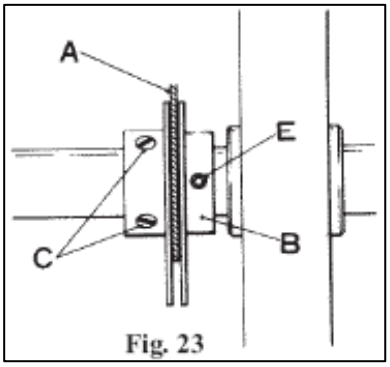


Fig. 23

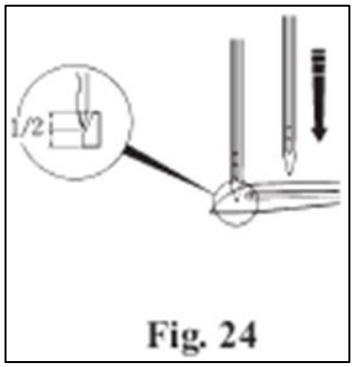


Fig. 24

***Recommended Adjustments**

Reference: Better seams can be obtained if th adjustment 2) changed according to the looper thread to be used as follows.(Fig. 25 Incorrect settings may cause unit to chain improperly.

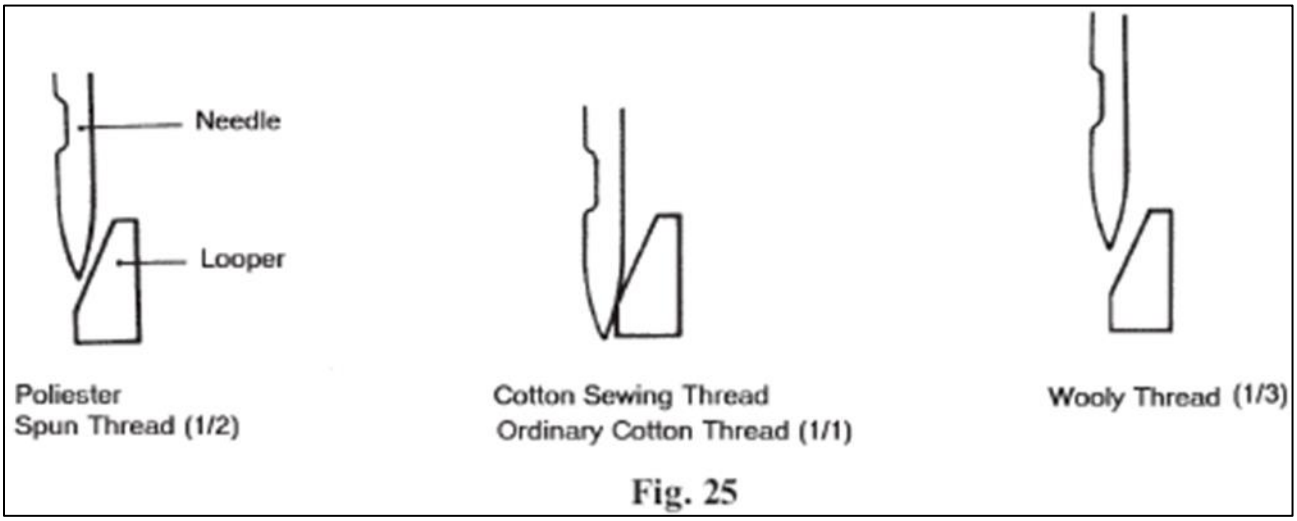


Fig. 25

Preventative Maintenance Schedule

1. Daily Maintenance:

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

2. Weekly Maintenance:

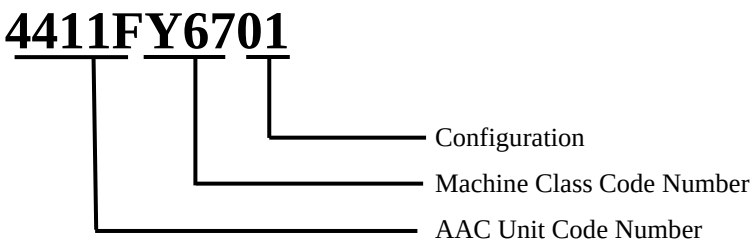
A. Use low-pressure air blower gun to clean inside of sewing head, remove throat plate to gain access.
B. Check sharpness of edge trimming and thread chopping knives; sharpen as needed to maintain keen edge.
C. Check level of thread lubricant reservoirs; fill with silicone oil as necessary (if required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

3. Monthly Maintenance:

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

Configuration

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



Sewing Machine Codes

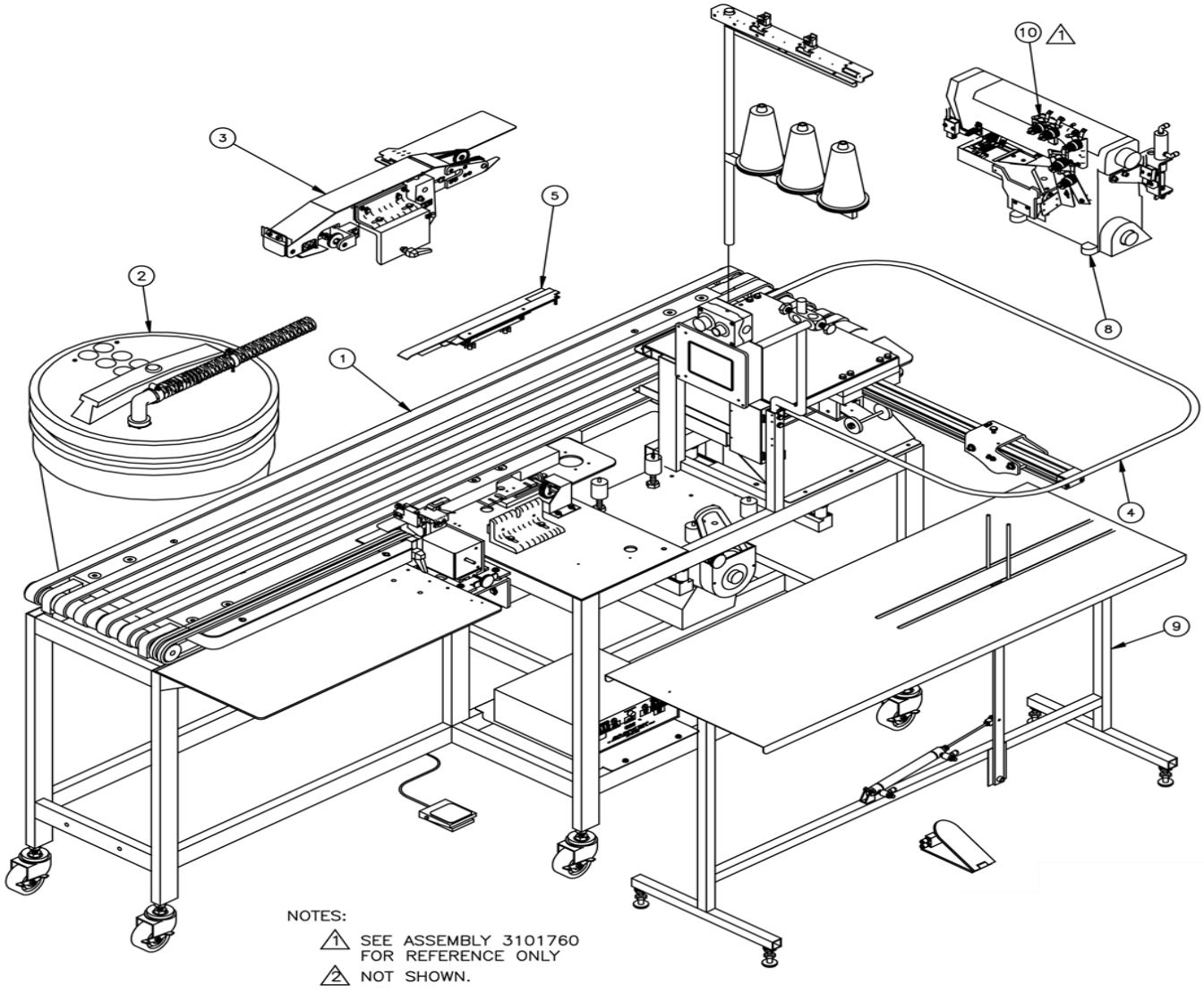
G67	PEGASUS 5.6mm
R67	IMOLDI 4.5mm
R68	RIMOLDI 6.00mm
S67	SINGER 5.6mm
Y66	YAMATO 4.8mm
Y67	YAMATO VC2700-156M 5.6 mm
Y68	YAMATO 6.4mm

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.

2211ESY6202 Auto Hemmer Yamato 5.6mm W/Panasonic Motor

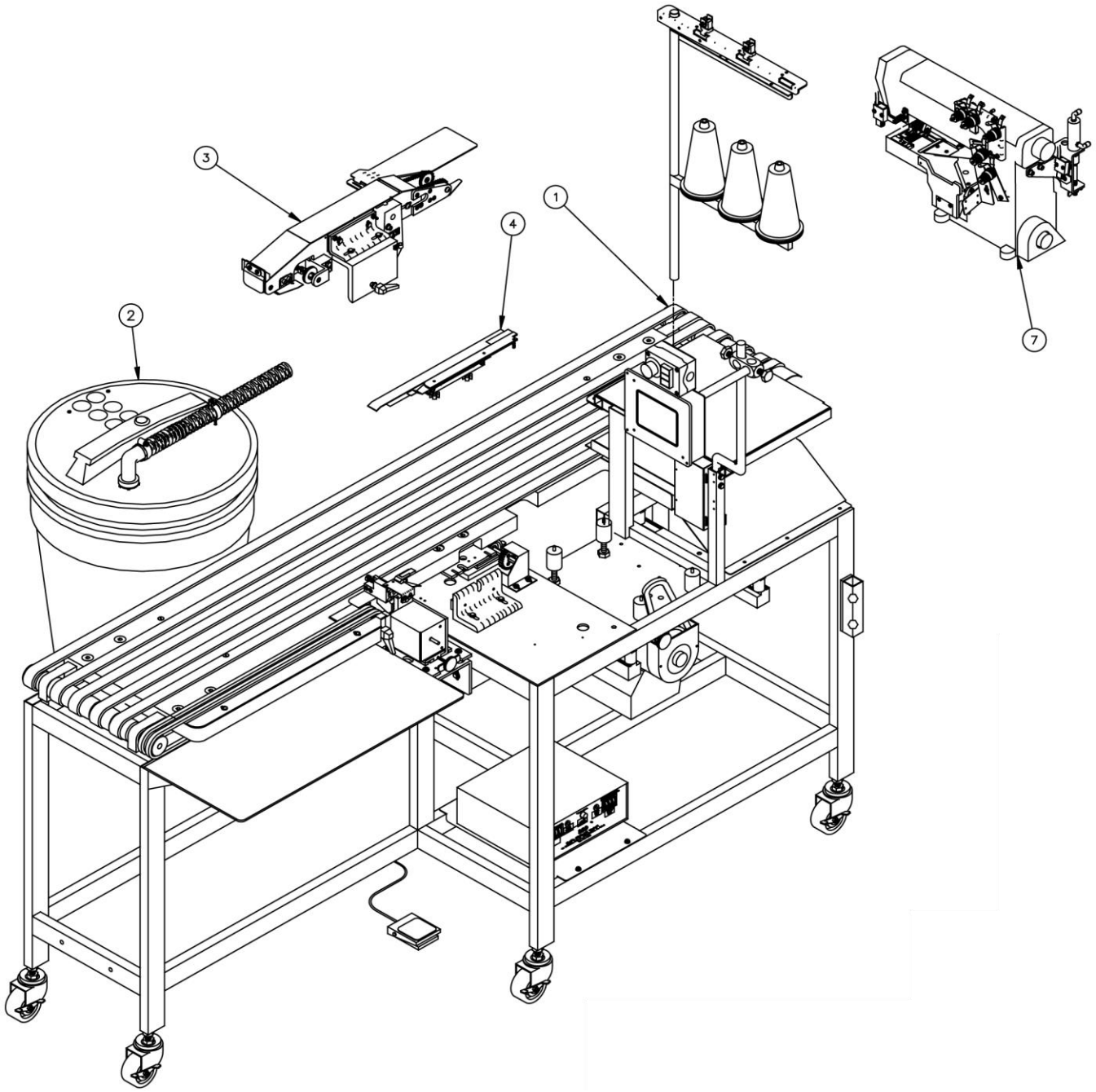
AAC Drawing Number 192066C Rev 0



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-126C	Table Assembly	9	1	211-162	Indexing Table
2	1	0411-1300	Waste System	10	1	See 3101760	Thread Tensioner
3	1	211-134	Top Conveyor	.	1	93863	Tension Cap
4	1	211-151A	Stacker	.	1	90847	Tension Spring
5	1	211-G6606C	Hemming Folder	.	1	90071	Tension Retainer
6	1	211ES-PD1	Pneumatic Diagram	.	1	177	Felt Washer
7	1	211ES-WD1	Wiring Diagram Panasonic	.	2	31111	Tension Disc
8	1	211-2N	Hemmer Head	.	1	9835	Tension Post
8.1	1	SYAM-2700D	Yamato Sewing Head	.	1	90812	Tension Ferrule
8.2	1	211-127B	Stitching Head Assembly	.	1	90856	Tension Eyelet
8.3	1	211-061C	Needle Pl. Mod. 5.6mm	.	1	90807	Thread Guide
8.4	1	211-062C	Foot mMod. 5.6mm	11	1	ZZ211ES	Technical Manual
8.5	1	211-063C	Feed Dog Mod 5.6mm				

2211ESY6704 Auto Hemmer Yamato 5.6mm Ga. W/Panasonic Motor

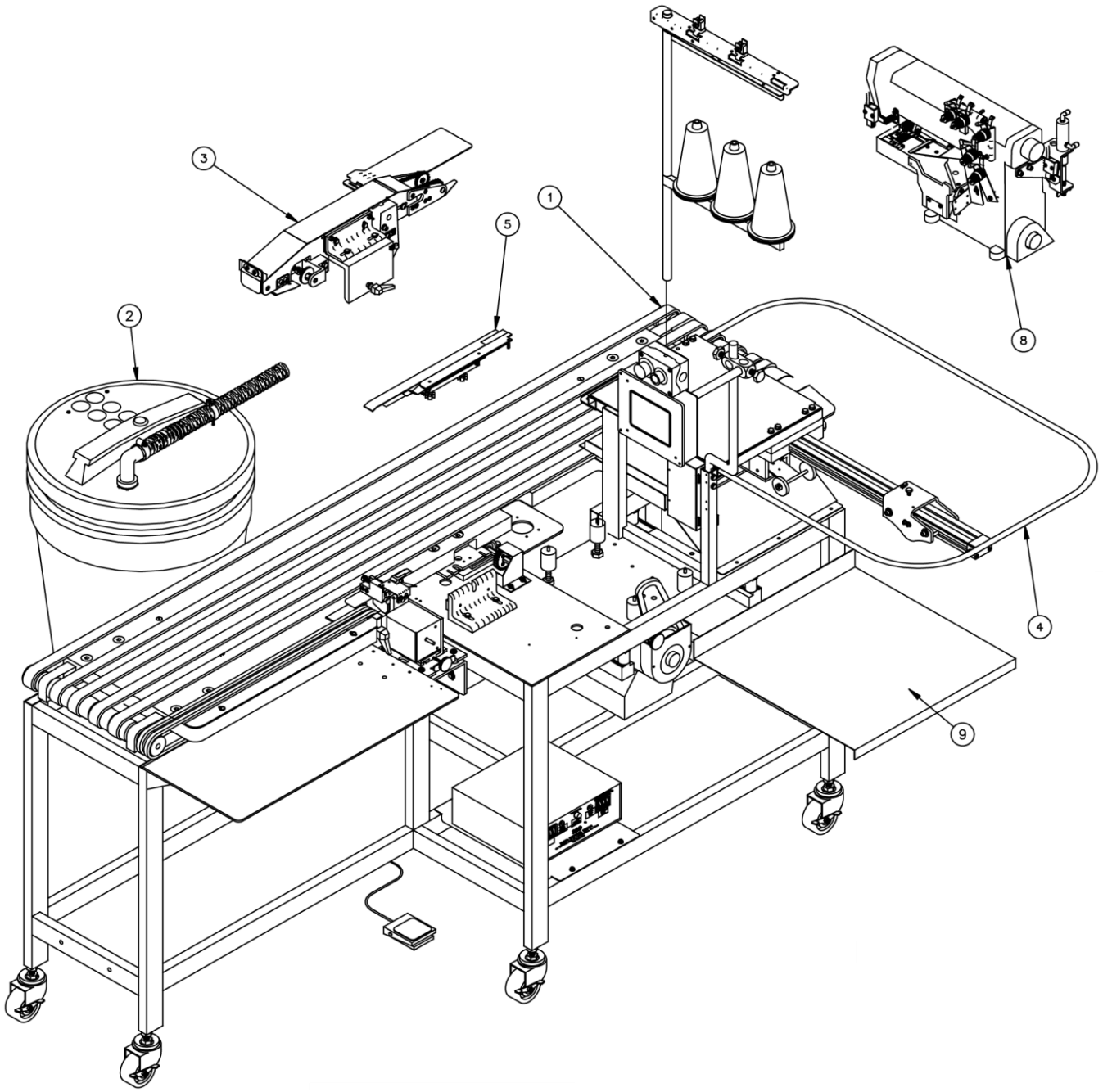
AAC Drawing Number 192575C Rev 0



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-126C	Table Assembly	7.1	1	SYAM-2700J	Yamato Sewing Head
2	1	0411-1300	Waste System	7.2	1	211-061C	Needle Pl. 5.6 mm Ga.
3	1	211-134	Top Conveyor	7.3	1	211-062C	Foot 5.6 mm Ga.
4	1	211-G6606C	Hemming Folder	7.4	1	211-063C	Feed Dog 5.6mm Ga.
5	1	211ES-PD1	Pneumatic Diagram	7.5	1	211-127B	Sewing Head Assembly
6	1	211ES-WD1	Wiring Diagram Pana	8	1	ZZ211ES	Technical Manual
7	1	211-2P	Hemmer Head				

2211ESY6207 Auto Hemmer Yamato 5.6mm W/Panasonic Motor

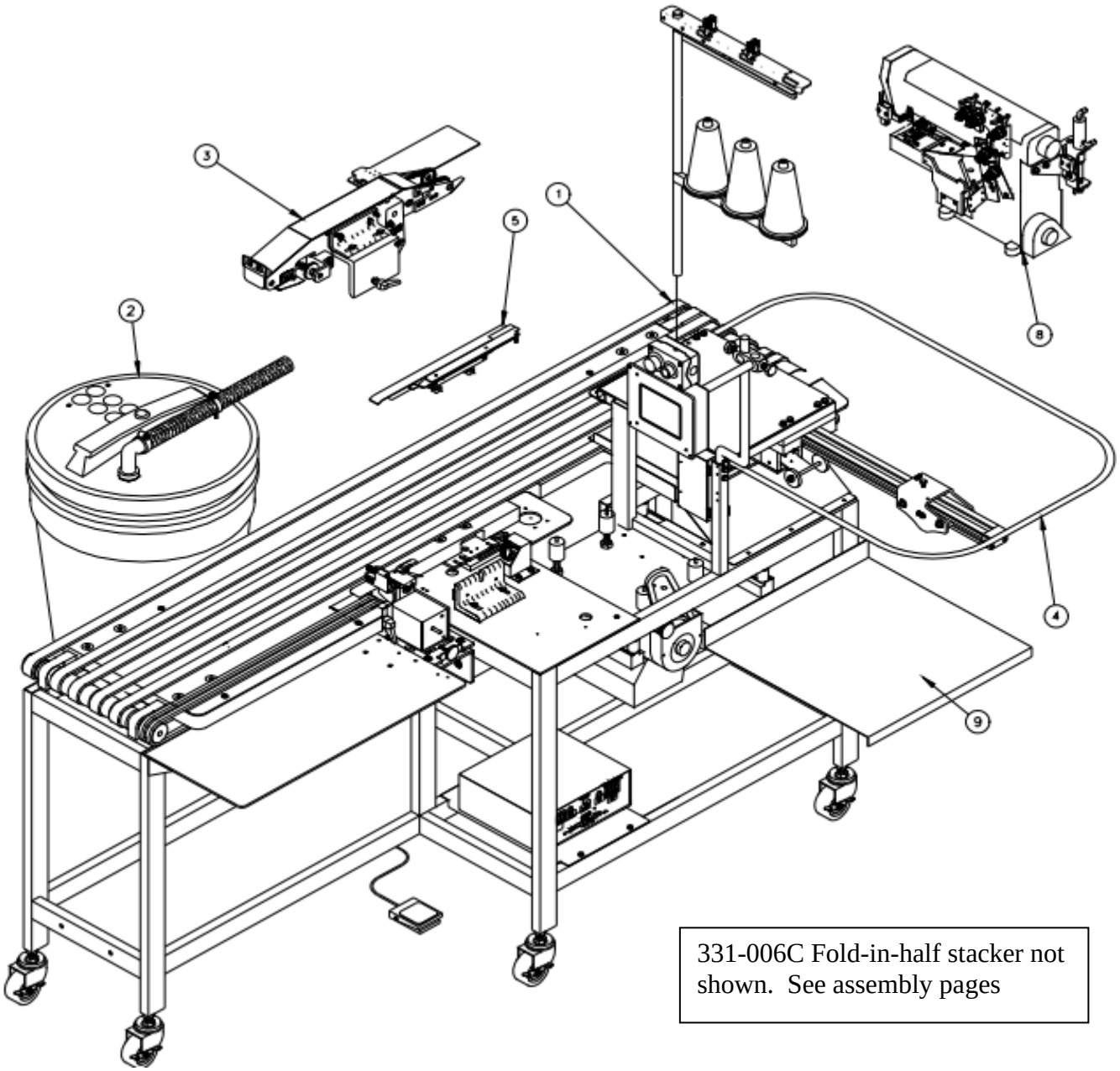
AAC Drawing Number 192065C Rev 1



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-126C	Table Assembly	8.1	1	SYAM-2700J	Yamato Sewing Head
2	1	0411-1300	Waste System	8.2	1	211-061C	Needle Pl. 5.6 mm Ga.
3	1	211-134	Top Conveyor	8.3	1	211-062C	Foot 5.6 mm Ga.
4	1	211-151A	Stacker	8.4	1	211-063C	Feed Dog 5.6mm Ga.
5	1	211-G6606C	Hemming Folder	8.5	1	211-127B	Sewing Head Assembly
6	1	211ES-PD1	Pneumatic Diagram	9	1	211-141	Bundle Table
7	1	211ES-WD1	Wiring Diagram Pana	10	1	ZZ211ES	Technical Manual
8	1	211-2P	Hemmer Head				

2211ESEY6408 Auto Hemmer, Yamato 5.6mm W/Efka Motor

AAC Drawing Number



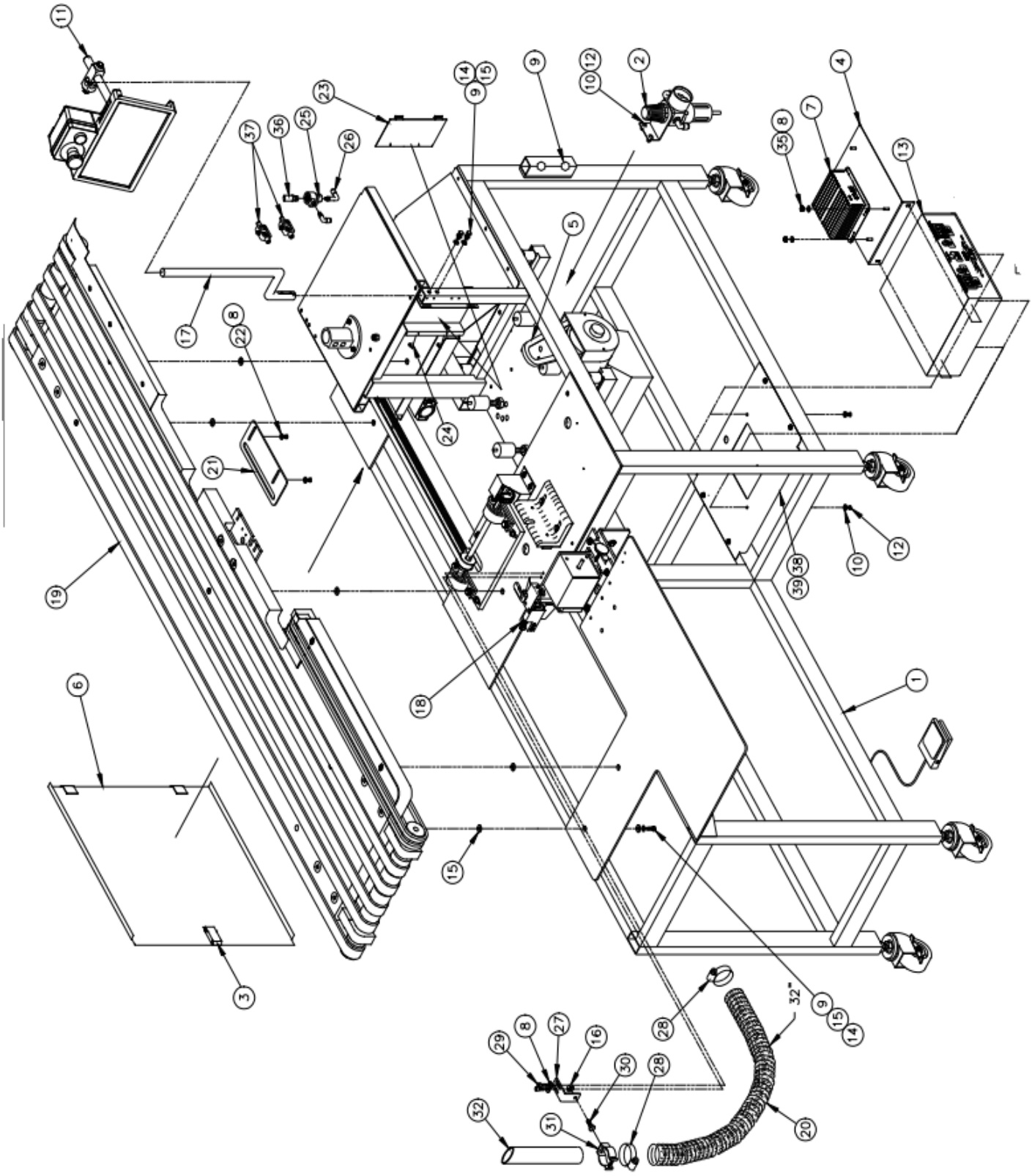
331-006C Fold-in-half stacker not shown. See assembly pages

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	10	Folding Stacker	311-006C
1	9	TABLE, BUNDLE	211-141
1	8.1	SEWING HEAD,YAMATO	SYAM-2700J
1	8	HEMMER SEAMER HEAD	211-127B
1	7	DIAGRAM,WIRING,SBUS,EFKA	211ES-WD2
1	6	PNEUMATIC DIAGRAM	211ES-PD1

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	5	HEMMING FOLDER	211-G6606C
1	4	STACKER	211-151A
1	3	TOP CONVEYOR	211-134
1	2	WASTE SYSTEM	0411-1300
1	1	TABLE ASSEMBLY	211-126E

211-126E Table Assembly

AAC Drawing Number 191075A Rev 2



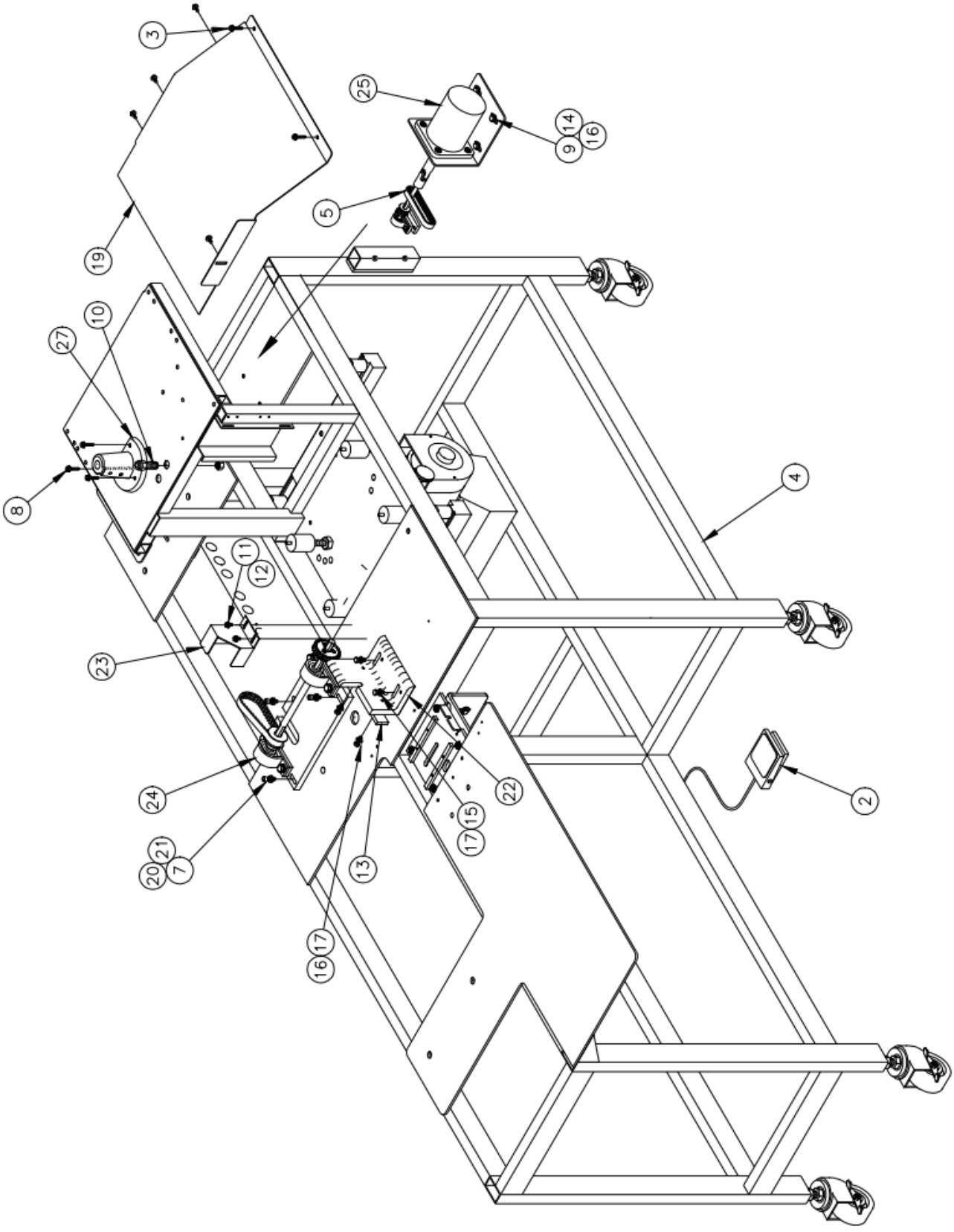
211-126E parts list

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	40	DIAGRAM, PNEUMATIC	211ES-PD1
4	39	SCREW, HEX SHEET METAL #10X1/2	SSZH#10032
1	38	MOUNT, CONTROL BOX AP-28-800N ON 211ES	211-208
2	37	IN-LINE FLOW CONTROL	AA2000F-03
1	36	PAPER MUFFLER, 1/4"	MMU002A
1	35	NUT, KEP, 10-32	NNK10-32
1	34	DIAG.,WIRING,EFKA, POCKET	211PS-WD2
1	33	DIAG.,WIRING,EFKA	211ES-WD2
1	32	TUBE, WASTE	211-157
1	31	CLAMP, TUBE	MM16300
1	30	SCREW, HEX CAP 1/4-20 x 1/2	SSHC01032
2	29	SCREW, SOCKET CAP 10-32 x 1/2	SSSC98032
2	28	CLAMP, HOSE	MM5415K16
1	27	MOUNT, WASTE TUBE	211-156
2	26	QUICK MALE EL	AAQME-5-8
1	25	QUICK EXHAUST VALVE	AAVSQE1
2	24	ROUND SLOTTED 6-40 x 1/4	SSRS85016
1	23	WIRE COND. COVER	011-084
2	22	SCREW, PAN SLOTTED 10-32 x 1/2	SSPS98032
1	21	EYE MOUNT	211-152

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2.7ft	20	HOSE, FLEX	MMFH150
1	19	LWR. CONVEYOR	211-128
1	18	EDGE TRIMMER	211-121A
1	17	CONTR. BOX SUPP.	211-126-2
1	16	1/4-20 KEP NUT	NNK1/4-20
12	15	FLAT WASHER	WWF1/4
7	14	1/4 LOCK WASHER	WWL1/4
1	13	CONTROL BOX, STEPPER	AP-28-800NN
6	12	SCREW, PAN HD SLOTTED 8-32 x 1/2	SSPS90032
1	11	HMI PLOE MOUNT WITH BEND UP WITH E-STOP AND START	4082006
6	10	FLAT WASHER	WWF8
9	9	SCREW, HEX CAP 1/4-20 x 3/4	SSHC01048
4	8	FLAT WASHER	WWFS10
1	7	PC GATEWAY	EEJBC375CG
1	6	DOOR, ELEC. BOX	010-122
1	5	V BELT	ZX3840
1	4	PC GATEWAY MOUNT AP-28-800	4082007
1	3	SLIDE LATCH	MM40450010
1	2	REG. W/GA. & NUT	AA198-5102
1	1	TABLE ASSEMBLY	211-125E

211-125E Table Sub-Assembly

AAC Drawing Number 191074A Rev 2



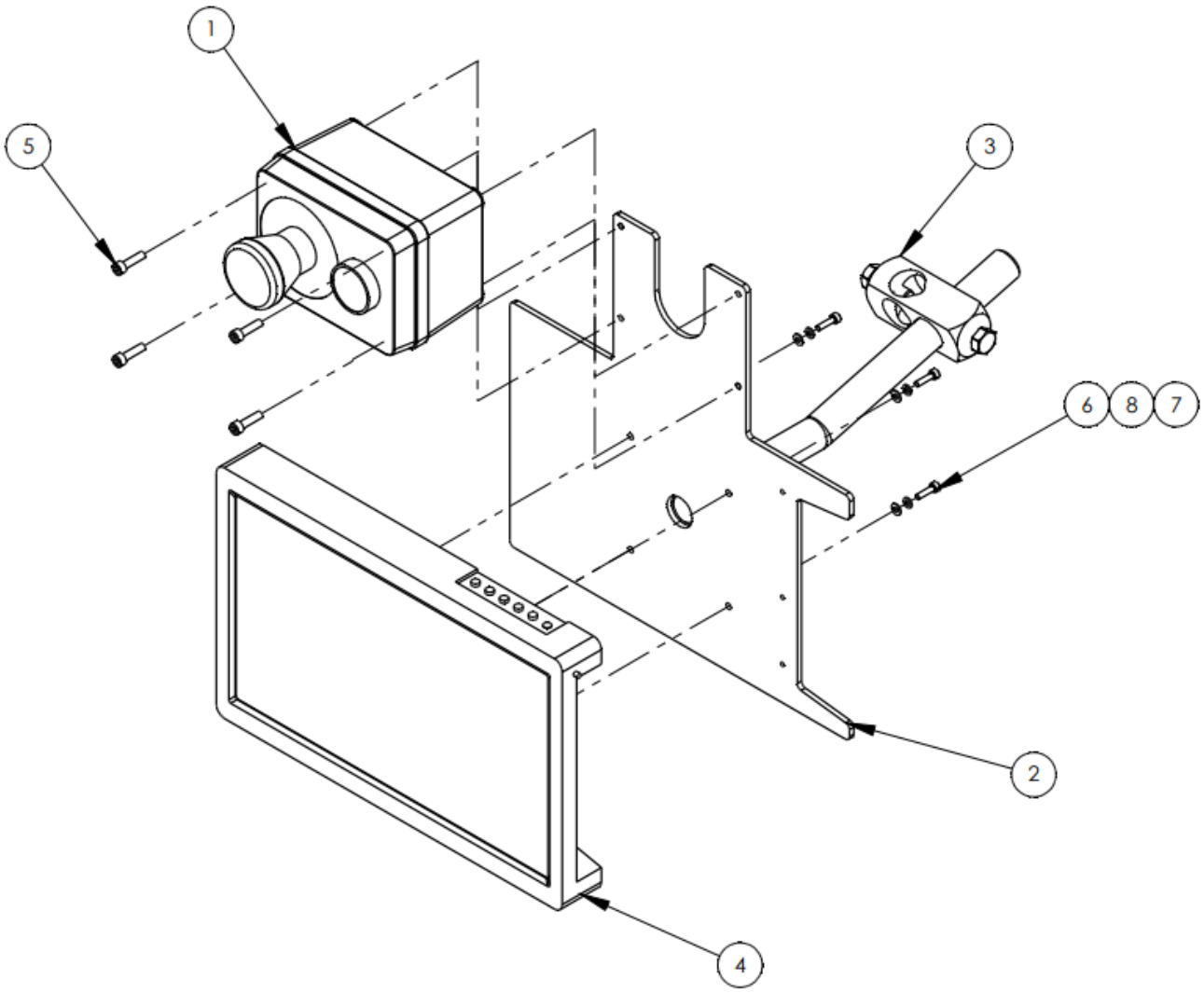
211-125E parts

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
4	14	1/4 LOCK WASHER	WWL1/4
1	13	SHIM,CONV. MOUNT	011-054
2	12	FLAT WASHER	WWF8
2	11	8-32X3/8	SSPP90024
1	10	BULKHEAD	AAQBU-3-3
4	9	SCREW, HEX CAP 1/4-20 X 5/8	SSHC01040
3	8	SCREW, FLAT CAP ALLEN 1/4-20 X 3/4	SSFC01048
3	7	SCREW, HEX CAP 5/16-24 X 1	SSHC20064
	6		
1	5	GEAR BELT	GG285L050
1	4	BOTTOM SIDE ASSY	211-124E
5	3	SCREW, HEX SHEET METAL 10-16 x 1/2	SSZS93032
1	2	DIAGRAM,WIRING,SBUS,EFKA	211PS-WD2
1	1	DIAGRAM,WIRING,SBUS,EFKA	211ES-WD2

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	27	BASE STAND	265157
	26		
1	25	DRIVE MOTOR	211-G6602
1	24	TRANSFER DR. ASSY.	211-034
1	23	TOP COVER, CONV. DR.	211-030
1	22	TOP CONVEYOR MT	211-029
3	21	5/16 LOCK WASHER	WWL5/16
3	20	FLAT WASHER	WWF5/16
1	19	PULLER COVER	011-006A
1	18	DIAGRAM, PNEUMATIC	211ES-PD
4	17	SCREW, HEX CAP 1/4-20 X 7/8	SSHC01056
6	16	1/4 SAE WASHER	WWFS1/4
2	15	FLAT WASHER	WWF1/4

4082006 HMI Touch Screen Assembly

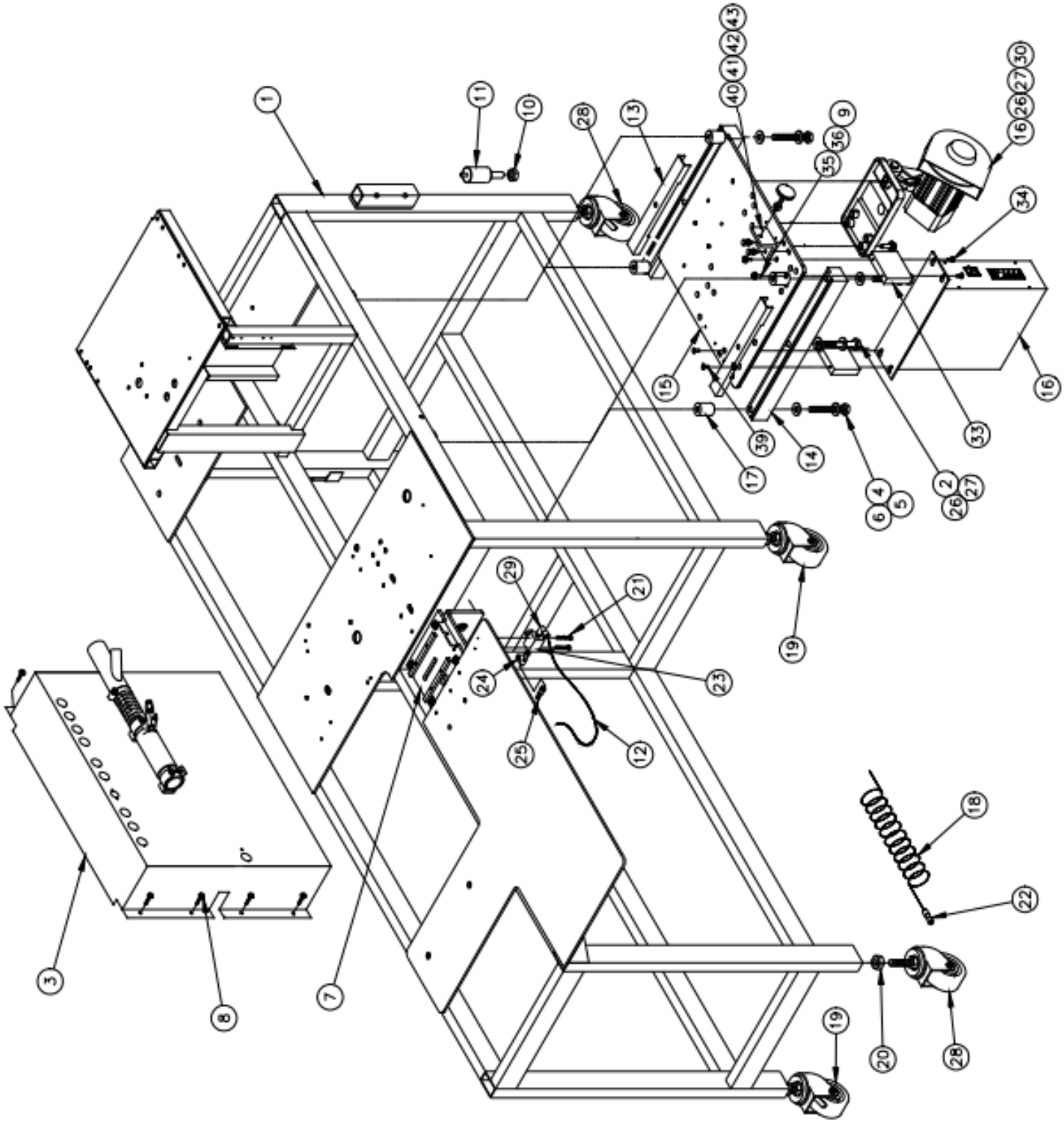
AAC Drawing Number 4082006 Rev 0



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

211-124E Table Sub-Assembly

AAC Drawing Number191073A4 Rev 2



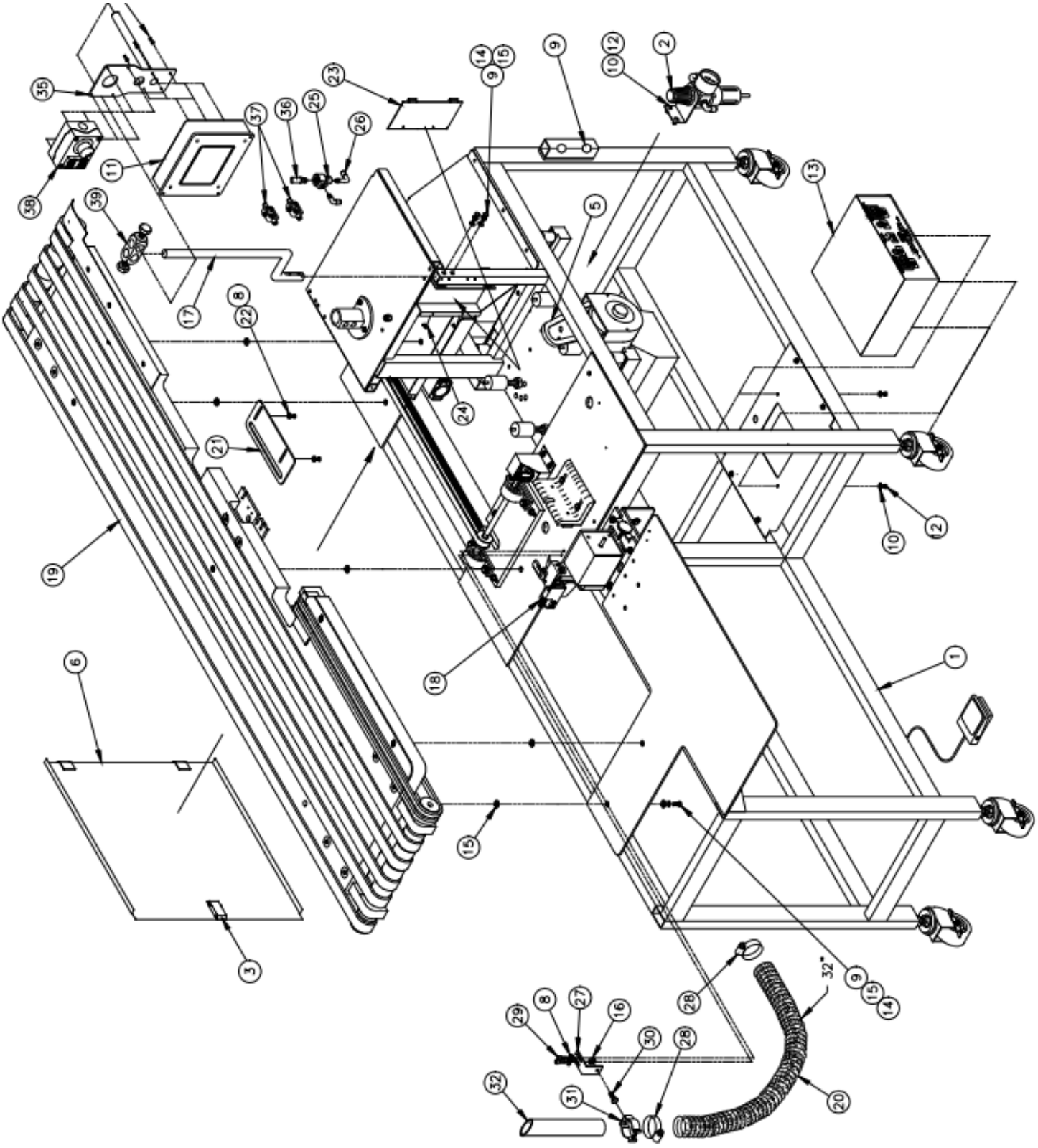
211-124E parts list

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	43	LOCK WASHER, 1/4"	WWL1/4
2	42	SCREW, HEX CAP 1/4-20X1/2	SSHC01032
1	41	TORQUE KNOB ASSEMBLY	011-117
1	40	ANGLE BLOCK	011-100
2	39	SCR,FLAT HD,10-32X1/2	SSFC98032
1	38	MOTOR CABLE,SYNC	0211-703A
1	37	MOTOR CABLE,TRDL	010-127D
2	36	FLATWASHER,#10	WWFS10
2	35	SCR,HWX CAP,10-32X1	SSHC98040
4	34	SCR,PAN HEAD, 10-32X3/8	SSPS98024
2	33	SPACER,EFKA BOX	0411-3928
1	32	DIAGRAM,WIRING,SBUS,EFKA	211ES-WD2
1	31	DIAGRAM, PNEUMATIC	211ES-PD
3	30	SCREW, HEX CAP 5/16-18 X 1.0	SSHC10064
1	29	QUICK ELBOW	AAQME-4-8
3	28	CASTER, RUBBER	MM503022LB
5	27	WASHER, FLAT	WWF5/16
5	26	WASHER, LOCK	WWL5/16
1	25	QUICK REDUCER	AAQPR-5-4
1	24	QUICK RUN T	AAQMT-4-8
1	23	SWITCH	AAVMB32

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	22	QUICK UNION	AAQSU-5-5
2	21	SCREW, PAN HD SLOTTED 6-32 X 1 1/2	SSPS80096
5	20	1/2-13 NUT	NNH1/2-13
2	19	RUBBER CASTER	MMTP113LPS
1	18	COIL HOSE	AAVBG35B
4	17	SPACER	211-140
1	16	EFKA MOTOR	4059-DC1500
1	15	MOTOR HD MT PLATE	013-091
2	14	HEAD/MOTOR SLIDE RAIL	011-098
2	13	CLAMP BRACKET	011-099
3'	12	AIRLINE	AATP4-1
4	11	ISOLATOR POST	211-124A
4	10	1/2-20 JAM NUT	NNJ1/2-20
2	9	LOCKWASHER,#10	WWL10
8	8	SCREW, HEX SHEET METAL #10 X 1/2	SSZH#10032
1	7	EDGE TRIMMER MT	211-120
4	6	3/8 LOCK WASHER	WWL3/8
4	5	3/8 FLAT WASHER	WWF3/8
4	4	SCREW, HEX CAP 3/8-16 X 3	SSHC25192
1	3	ELECTRONIC ASSEMBLY	211-209
2	2	SCREW, HEX CAP 5/16-18 X 1 3/4	SSHC10112
1	1	WELDMENT FRAME	211-119

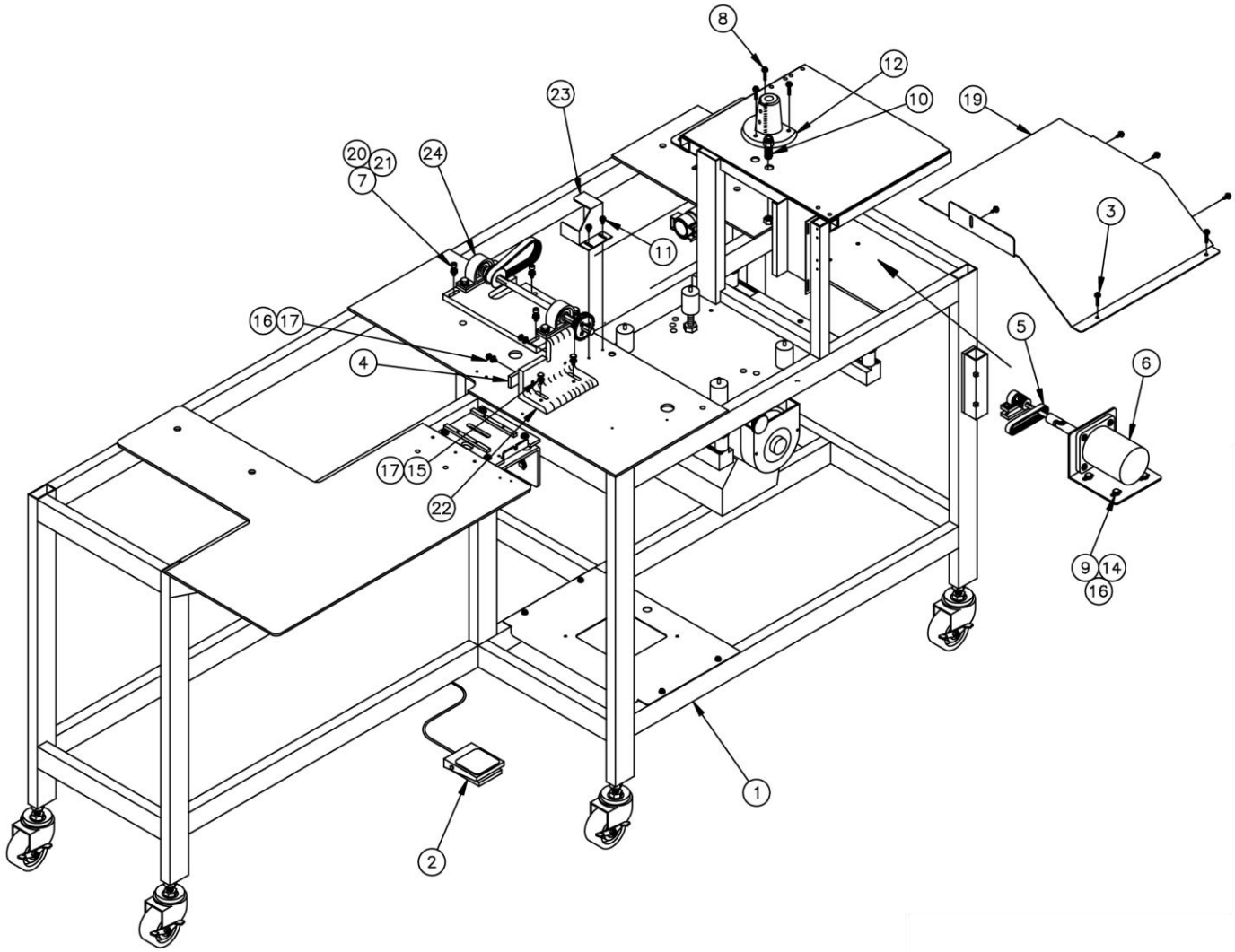
211-126C Table Assembly

AAC Drawing Number 191928C Rev 7



211-126C parts list

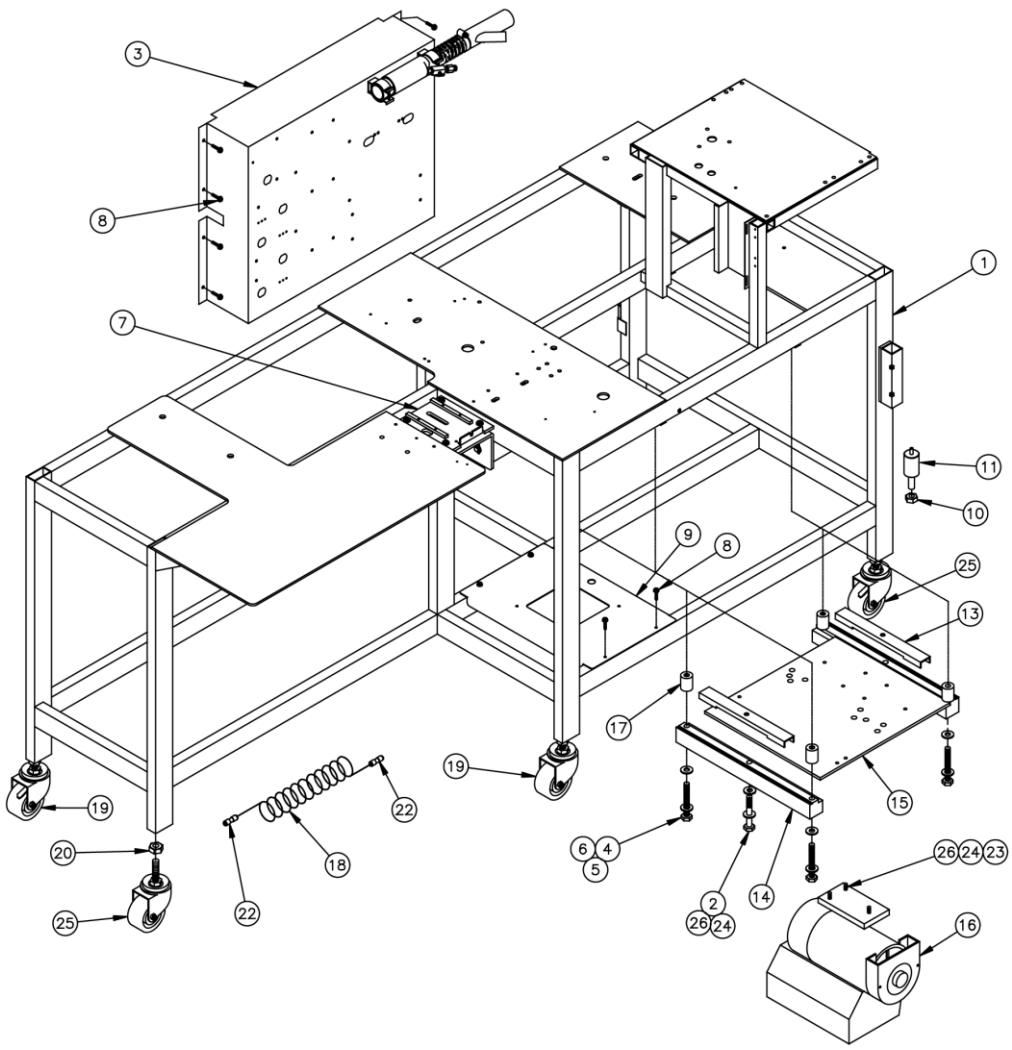
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-125A	Table Assembly	21	1	211-152	Eye Mount
2	1	AA198-5102	Reg W/ Ga & Nut	22	2	SSPS98032	Scr,Pn Hd Sl 10-32x1/2
3	1	MM40450010	Slide Latch	23	1	011-084	Wire Conduit Cover
4	4	SSPS80032	Scr,Pn Hd Sl 6--32x1/2	24	2	SSRS85016	Scr Rnd Sl 6-40 x 1/4
5	1	ZX3840	V Belt	25	1	AAVSQE1	Quick Exhaust Valve
6	1	010-122	Door, Elec Box	26	2	AAQME-5-8	Quick Male Elbow
7	4	WWFS6	SAE Flat Washer	27	1	211-156	Waste Tube Mount
8	4	WWFS10	SAE Flat Washer	28	2	MM5415K16	Hose Clamp
9	9	SSHC01048	Scr,Hx Cp 1/4-20x3/4	29	2	SSSC98032	Scr, So Cp 10-32x1/2
10	6	WWF8	Flat Washer	30	1	SSHC01032	Scr, Hx Cp 1-1/4-20x1/2
11	1	4080-004	Control, SBUS, AEI	31	1	MM16300	Tube Clamp
12	6	SSPS90032	Scr,Pn Hd Sl 8-32x1/2	32	1	211-157	Waste Tube
13	1	AP-28-800NN	Control Box, Stepper	33	AR	211ES-PD1	Pneumatic Diagram
14	7	WWL1/4	1/4 Lock Washer	34	AR	211ES-WD1	Wiring Diagram Pana
15	12	WWF1/4	Flat Washer	35	1	40-112A	Touch Screen Mount
16	1	NNK1/4-20	1/4-20 Kep Nut	36	1	MMU002A	Paper Muffler, 1/4”
17	1	211-126-2	Control Box Supp	37	2	AA2000F-03	In-Line Flo Control
18	1	211-121A	Edge Trimmer	38	1	1278-6010	Start/Stop Button Assembly
19	1	211-128	Lower Conveyor	39	1	28201	Large Block
20	2.7Ft	MMFH150	Flex Hose				



211-125A Table Assembly

AAC Drawing Number 191929C Rev 1

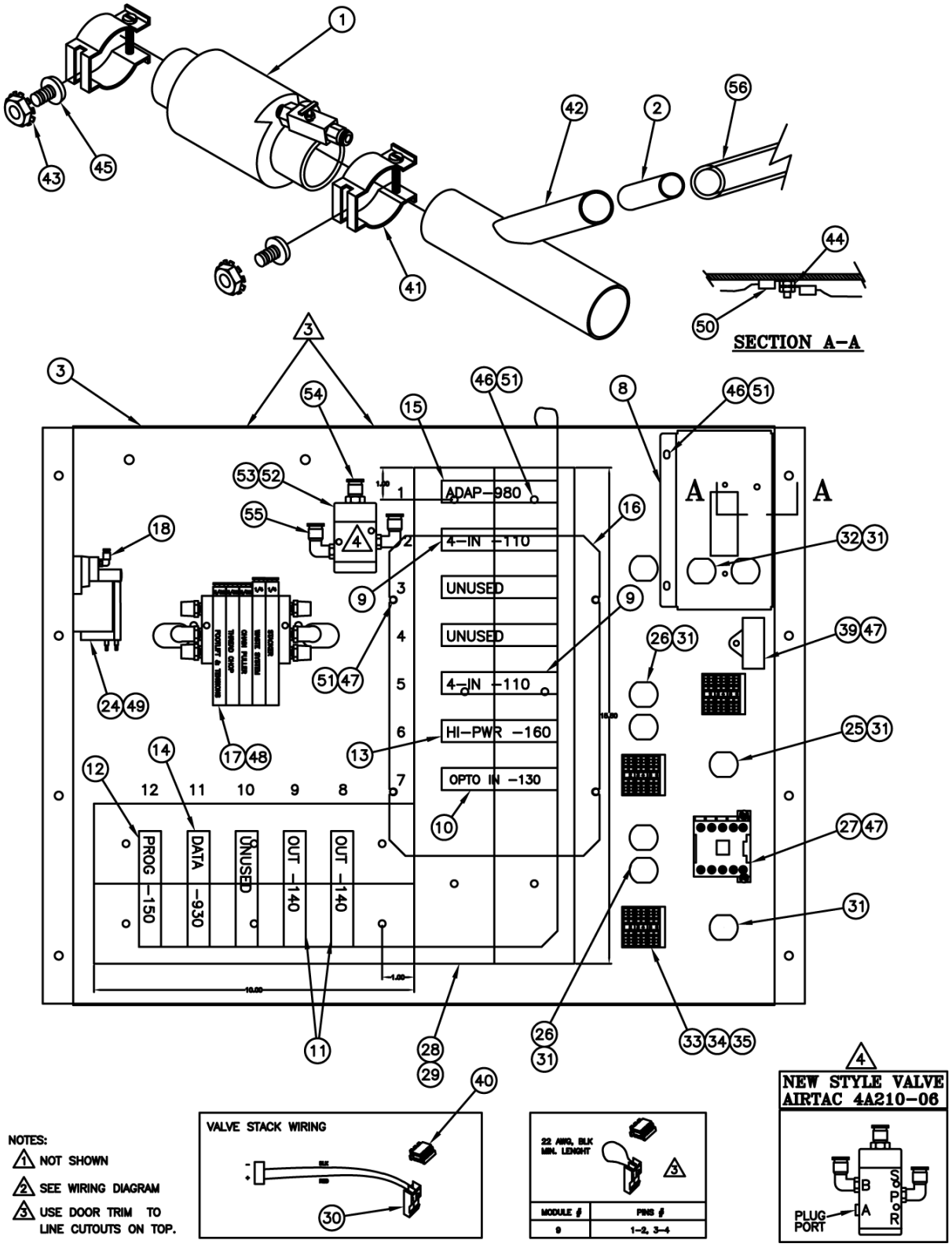
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-124B	Bottom Side Assembly	13	AR	211ES-WD1	Wiring Diagram Pana
2	1	0411-1903	Foot Switch	14	4	WWL1/4	Lock Washer
3	6	SSZS93032	Scr,Hx Sh me 10-16x1/2	15	2	WWF1/4	Flat Washer
4	1	011-054	Shim Conv. Mount	16	6	WWFS1/4	SAE Washer
5	1	GG285L050	Gear Belt	17	4	SSHC01056	Scr,Hx Cp 1/4-20x7/8
6	1	211-G6602	Drive Motor	18	AR	211ES-PD1	Pneumatic Diagram
7	3	SSHC20064	Scr,Hx Cp 5/16-24x1	19	1	011-006A	Puller Cover
8	3	SSFC01048	Scr,Fl Cp Al 1/4-20x3/4	20	3	WWF1/56	Flat Washer
9	4	SSHC01040	Scr,Hx Cp 1/4-20x5/8	21	3	WWL5/16	Lock Washer
10	1	AAQBU-3-3	Bulkhead	22	1	211-029	Top Conveyor Mount
11	2	SSZH#10064	Scr,Hx Sh Me No.10x1.0	23	1	211-030	Top Cover, Conv Dr
12	1	265157	Base Stand	24	1	211-034	Transfer Dr Assy



211-124B Bottom Side Assembly

AAC Drawing Number 191930C Rev 1

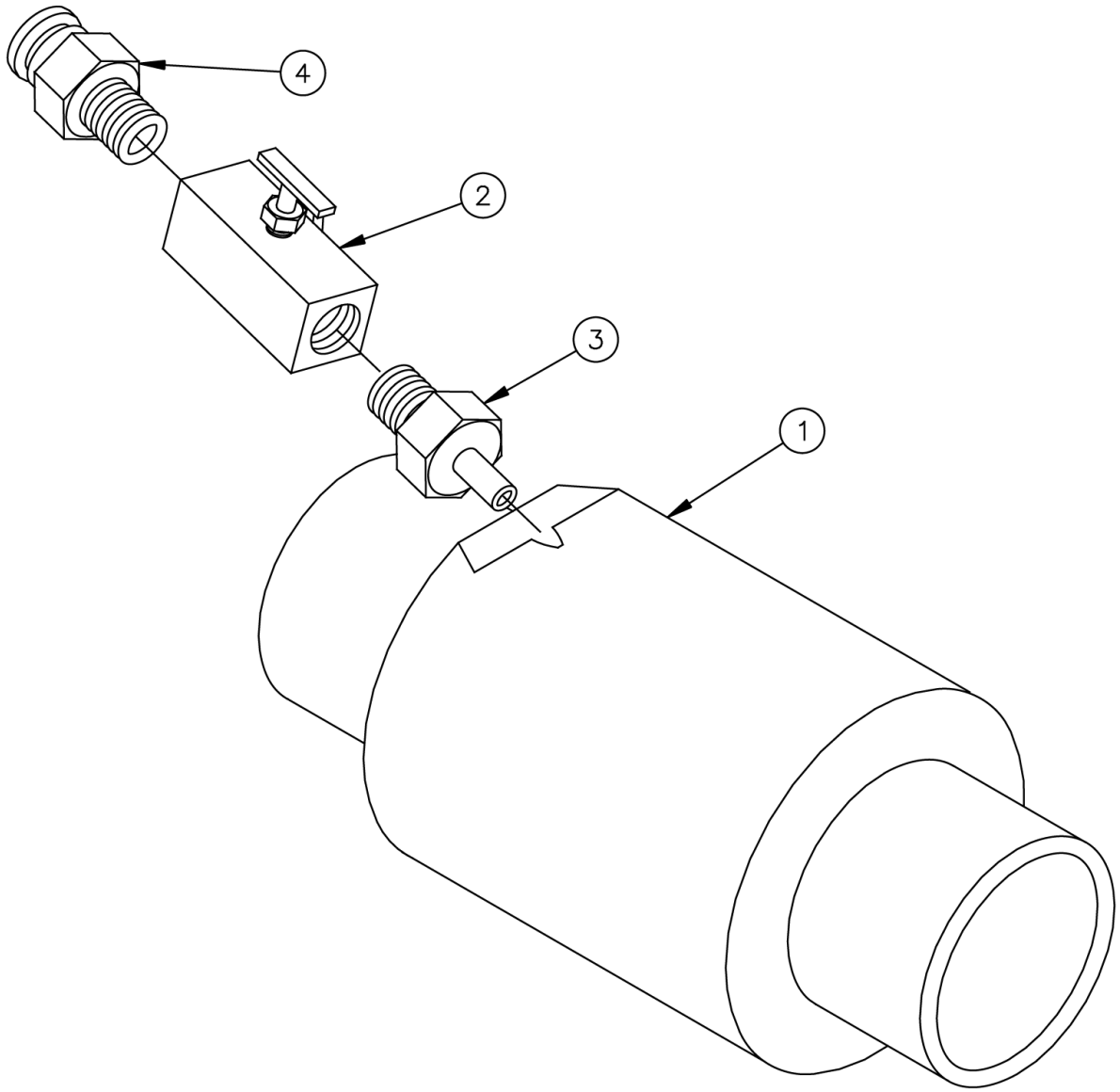
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-119	Weldment Frame	14	2	011-098	Head/Motor Slide Rail
2	2	SSHC10112	Scr,Hx Cp 5/16-18x1 3/4	15	1	013-091	Motor Head Mount Plate
3	1	211-209	Electronic Assembly	16	1	4059-D7-NS	Panaservo, AC Motor
4	4	SSHC25192	Scr,Hx Cp 3/8-16x3	17	4	211-140	Spacer
5	4	WWF3/8	3/8 Flat Washer	18	1	AAVBG35B	Coil Hose
6	4	WWL3/8	3/8 Lock Washer	19	2	MMTP113LPS	Rubber Caster
7	1	211-120	Edge Trimmer Mount	20	5	NNH1/2-13	1/2-13 Nut
8	12	SSZH#10032	Scr,Hx Sh me #10x1/2	21	1	211ES-PD1	Pneumatic Diagram
9	1	211-208	Control Box Mount	22	1	AAQSU-5-5	Quick Union
10	4	NNJ1/2-20	1/2-20 Jam Nut	23	3	SSHC10064	Scr,Hx Cp 5/16x1
11	4	211-124A	Isolator Post	24	5	WWF5/16	Washer, Flat
12	AR	211ES-WD1	Wiring Diagram Pana	25	3	MM503022LB	Rubber Caster
13	2	011-099	Clamp Bracket	26	5	WWL5/16	Washer, Lock


SECTION A-A
ADAP-980
4-IN -110
UNUSED
UNUSED
4-IN -110
HI-PWR -160
OPTO IN -130
PROG -150
DATA -930
UNUSED
OUT -140
OUT -140
12 11 10 9 8
NOTES:
1 NOT SHOWN
2 SEE WIRING DIAGRAM
3 USE DOOR TRIM TO LINE CUTOUTS ON TOP.
VALVE STACK WIRING
22 AWG. BLK MIN. LENGHT
MODULE #
PINS #
0
1-2, 3-4
NEW STYLE VALVE AIRTAC 4A210-06
PLUG PORT
DOOR

211-209 Electronic Assembly

AAC Drawing Number 191924C Rev.8

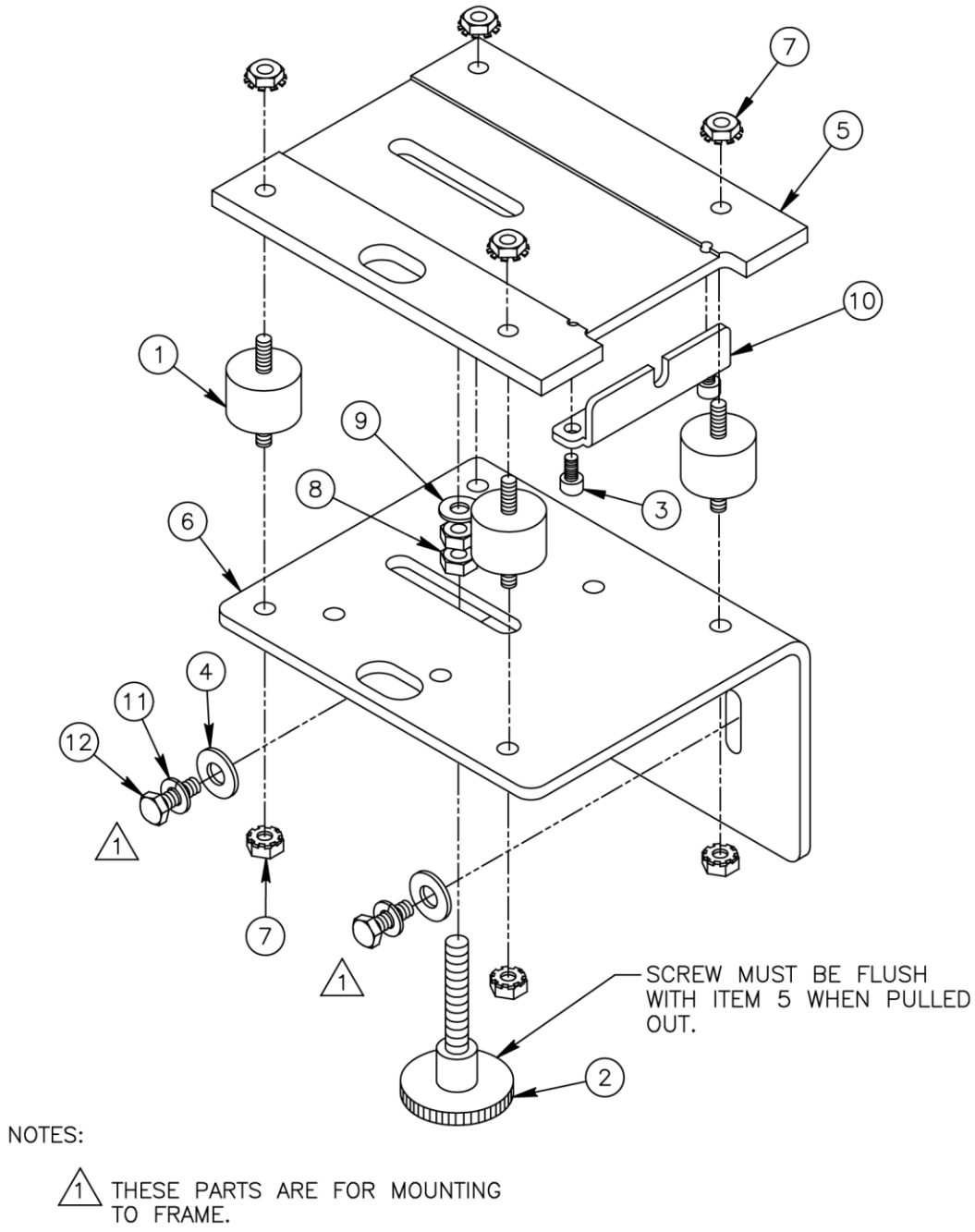
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	0411-1057	WASTE ASSEMBLY	30	6	FF100F2202	CONNECTOR, 2 PIN
2	1	211-132A	TUBE, ADAPTOR	31	9	FF1724	STRAIN RELIEF
3	1	211-204	PANEL, ELECTRICAL	32	20'	FF19510	CABLE, 3 COND.
4	1	211-207	CABLE PACKAGE	33	9	FF264-341	TERMINAL BLOCK
5	1	211ES-LAB1	LABEL, VALVES	34	3	FF264-347	TERMINAL BLOCK
6	1	211ES-PD1	DIAGRAM, PNEU.	35	3	FF264-371	TERMINAL, END
7	1	211ES-WD1	DIAGRAM, WIRING	36	2	FF3077-28	WIRE, 16 GA
8	1	40-320	DISCONNECT, AC	37	2'	FF3077-6	WIRE, 16 GA
9	2	4080-110	MODULE, QUAD IN	38	2'	FF3077-7	WIRE, 16 GA
10	1	4080-130	MODULE, OPTO ISO	39	1	FFRAV781BW	MODULE, TVS
11	2	4080-140	MODULE, QUAD OUT	40	6	FFSC10002	COVER, STRAIN RELIEF
12	1	4080-150	MODULE, PROGRAM	41	2	MM16300	CLAMP, TUBE
13	1	4080-160	MODULE, SINGLE OUT	42	1	MMYSB1.5X3	COUPLING, Y
14	1	4080-930	MODULE, DATA	43	2	NNK1/4-20	NUT, 1/4-20 KEP
15	1	4080-980	MODULE, SBUS-CONT	44	2	NNK8-32	NUT, 8-32 KEP
16	1	4080-990R	POWER SUPPLY	45	2	SSHC01032	SCREW, HEX CAP 1/4-20 X 1/2
17	1	AAE211E-5	SOLENOID ASSEMBLY	46	14	SSPS90016	SCREW, PAN SLOTTED 8-32 X 1/4
18	1	AAQME-5-10	ELBOW, QUICK	47	7	SSPS90024	SCREW, PAN HEAD SLOTTED 8-32 X 3/8
19	1	AAQPR-5-4	REDUCER, QUICK	48	2	SSPS90080	SCREW, PAN HD SLOTTED 8-32 X 1-1/4
20	1	AAQUT-4-4	UNION T, QUICK	49	2	SSSC70024	SCREW, SOCKET CAP 4-40 X 3/8
21	2	AAQUY-4-4	UNION Y, QUICK	50	2	TTSRBS82908	TERMINAL RING
22	1'	AATP4-1	AIRLINE, 1/4	51	18	WWF8	WASHER, FLAT
23	1'	AATP5/32	AIRLINE, 5/32	52	1	AAV125B	PILOT VALVE
24	1	AAVF51FM1B	SWITCH, LOW AIR	53	2	SSPS90064	SCREW, PAN HEAD SLOTTED 8-32 X 1.0
25	8'	EE16-3C2406	CABLE, 3 COND.	54	1	AAQMC-5-8	QUICK MALE CONN.
26	2	EE17518	CORD, POWER	55	2	AAQME-4-8	QUICK MALE ELBOW
27	1	EECA491024	CONTACTOR, MINI	56	1.5'	AATP5/8	TUBING, NYLON, CLEAR
28	4.4'	EEDC2X2	COVER, WIRE DUCT	57	2'	MM100-1/8	DOOR TRIM - BLACK
29	4.4'	EEDF2X2	DUCT, WIRE	58			



0411-1057 Waste Venturi Assembly

AAC Drawing Number 190467B Rev 0

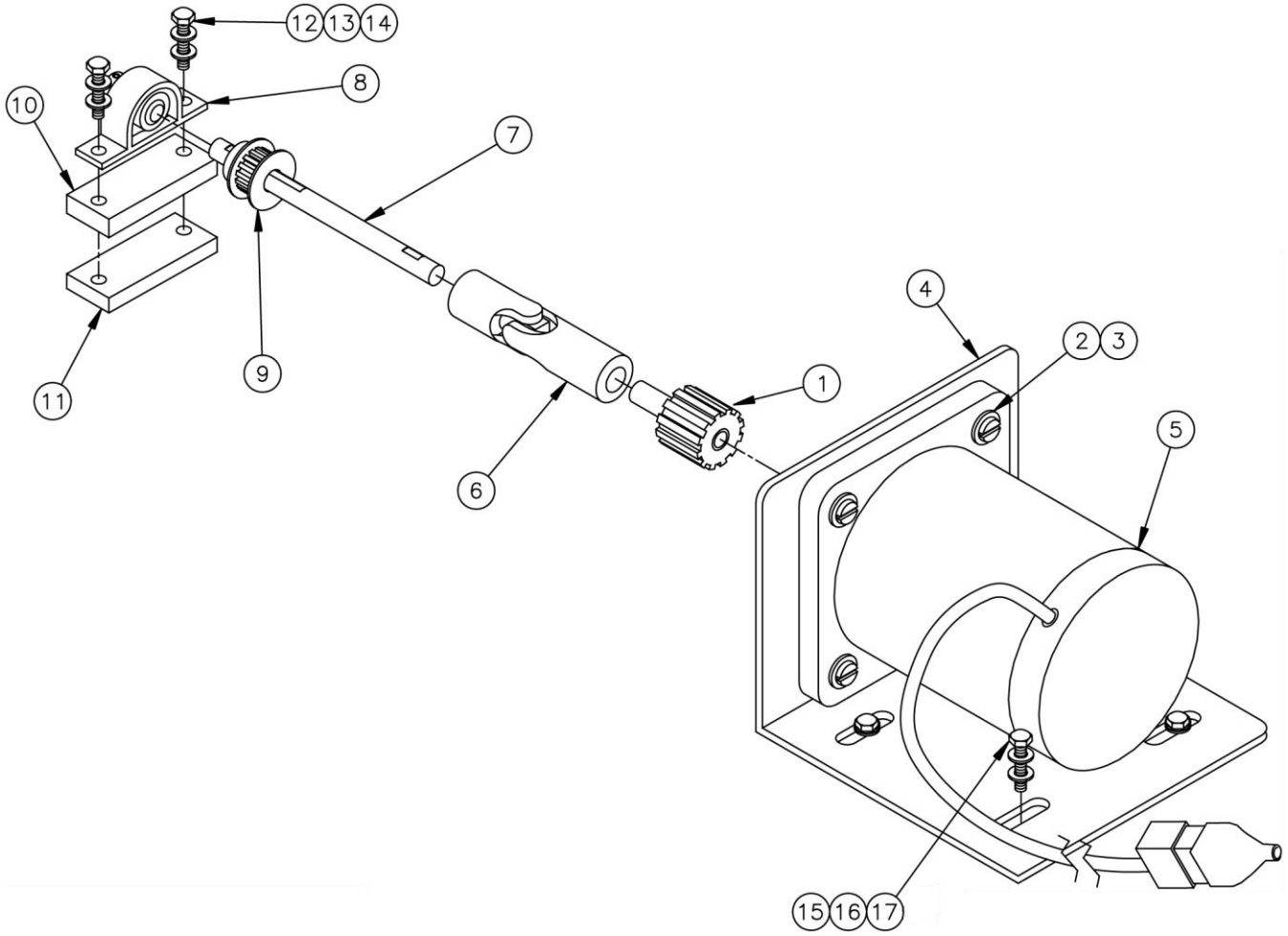
NO.	QTY	PART #	DESCRIPTION
1	1	211142	Waste Venturi
2	1	AAF2304-2	Needle Valve
3	1	AAF10684	Brass Fitting
4	1	AAQMC-4-8	Quick Male Connect



211-120 Edge Trimmer Mount Assembly

AAC Drawing Number 191009B Rev 7

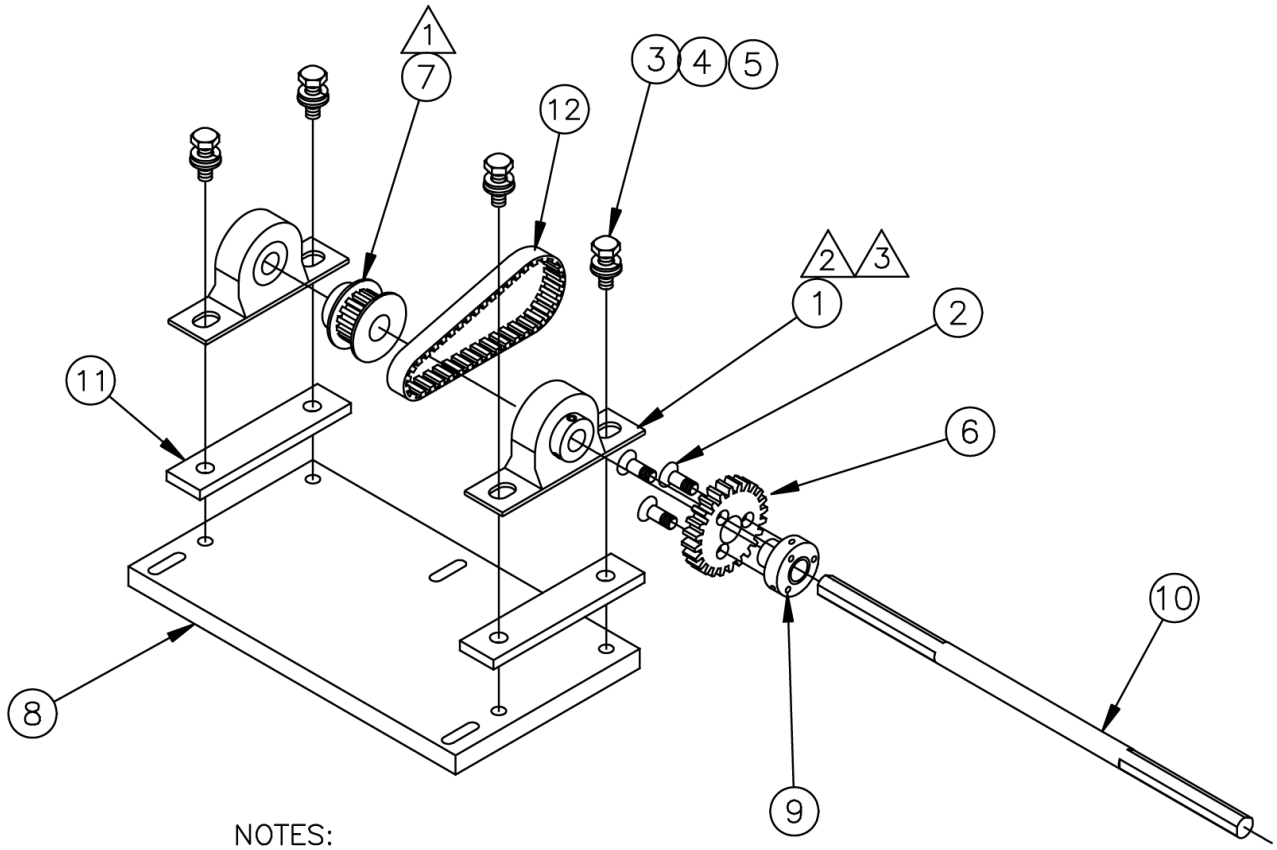
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	4	MMB6002	Mount, Vibration, Motor	7	8	NNK1/4-20	Nut, Kep, 1/4-20
2	1	TTK32309	TorK Knob-Stub	8	2	NNJ5/16-18	Nut, Jam
3	2	SSSC98024	Scr,So Cp 10-32x3/8	9	1	WWFS5/16	Washer, SAE
4	2	WWFS1/4	1/4 SAE Washer	10	1	211-160	Adjustment BrKt
5	1	010-039A	Plate, Motor Mounting	11	2	WWL1/4	LocK Washer
6	1	0411-1801	Angle, Motor Support	12	2	SSHC01040	Scr,Hx Cp 1/4-20x5/8



211-G6602 Drive Train Assembly

AAC Drawing Number 190182B Rev 5

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-025	Gear Pulley	11	1	211-069	Nut Pl
2	4	SSPS98032	Scr,Pan Sltd 10-32x1/2	12	2	SSHC10144	Scr,Hx Cp 5/16-18x2-1/4
3	4	WWSI10	#10 Int Lock Washer	13	2	WWF5/16	Washer
4	1	011-018	Bracket, Motor	14	2	WWL5/16	Lock Washer
5	1	011-020	Stepper Motor	15	4	WWF1/4	Washer
6	1	A-2010U	1/2 Bore U-Joint	16	4	WWL1/4	Lock Washer
7	1	211-026	Shaft	17	AR	SSHC01048	Hex Cap Screw
8	1	MM2X897	1/2 Pillow Block		AR	SSHC01056	Hex Cap Screw
9	1	211-045	Gear		AR	SSHC01064	Hex Cap Screw
10	1	211-051	Spacer, P. Block				



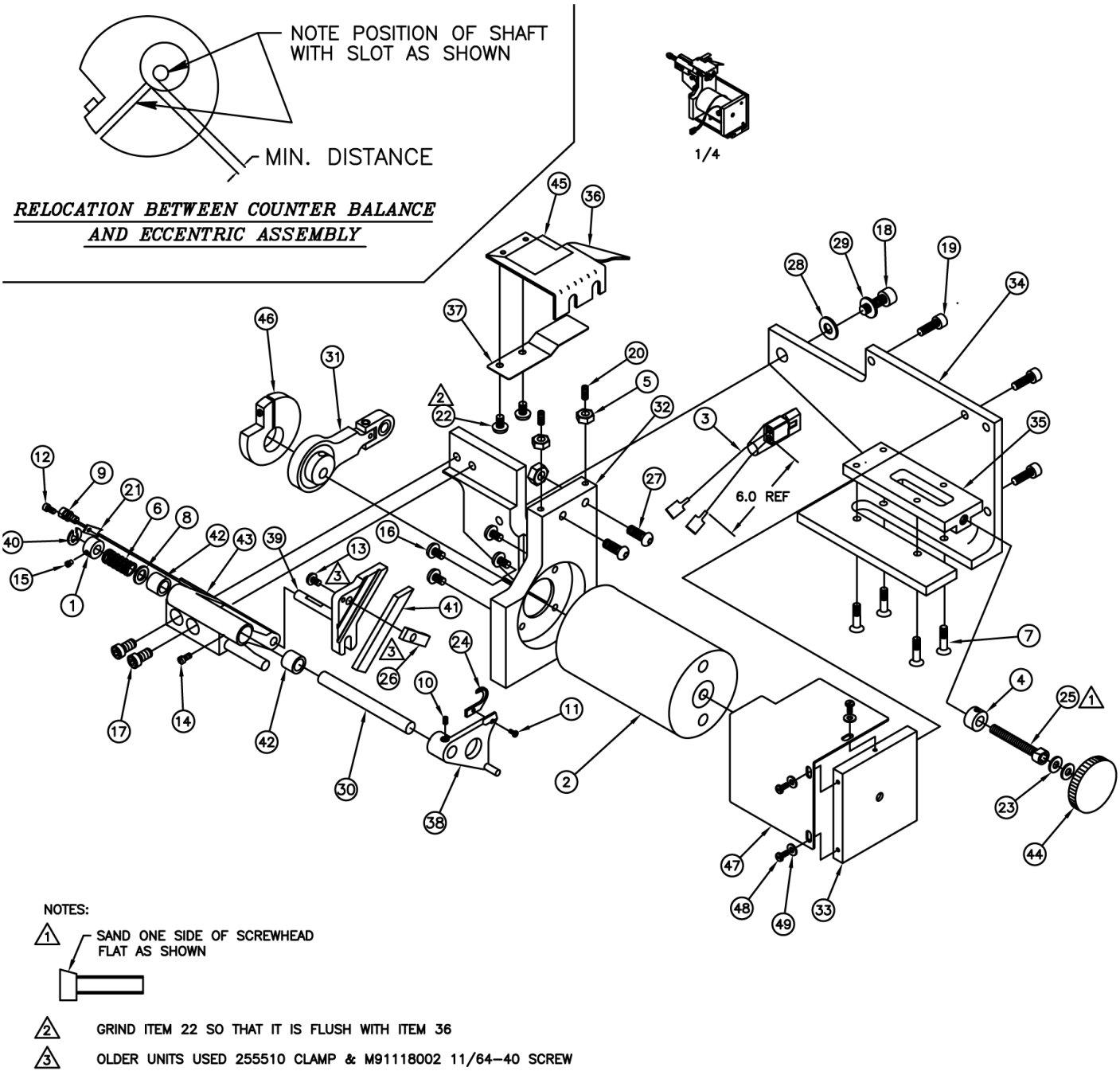
NOTES:

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

211-034 Transfer Drive Assembly

AAC Drawing Number 290131B Rev 8

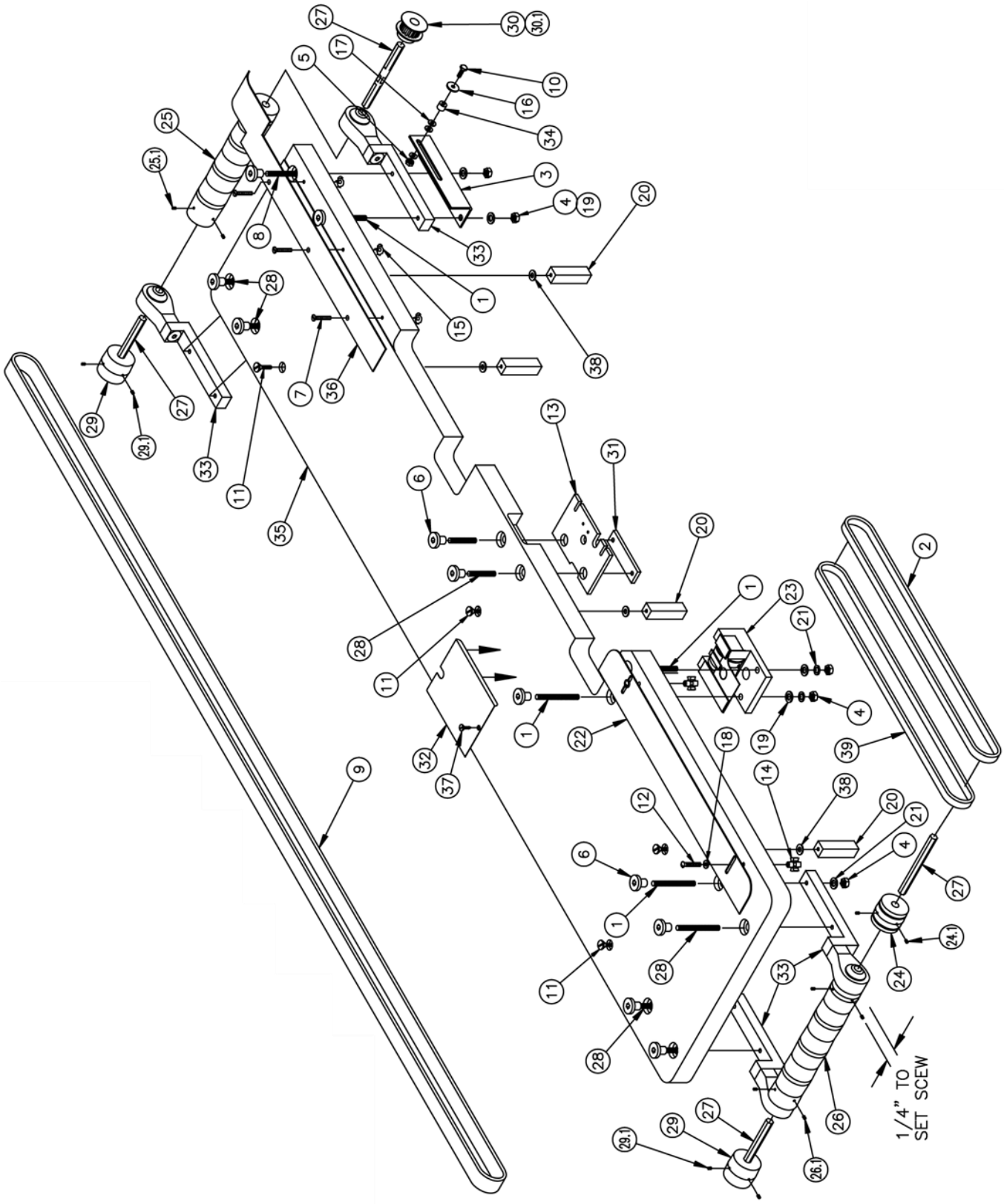
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	MM2X897	1/2 Pillow Blocks	7	1	211-057	Pulley, Mod
2	3	SSFC90048	Scr,Fl Al Cp 8-32X3/4	8	1	211-028	Pl Top Conv Dr
3	4	SSHC20048	Scr,Hx Cp 5/16-24X3/4	9	1	211-047	Gear Adaptor
4	4	WWF5/16	Washer, 5/16 USS	10	1	211-048	Rod, Top Conv Dr
5	4	WWL5/16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


NOTE POSITION OF SHAFT WITH SLOT AS SHOWN
MIN. DISTANCE
RELOCATION BETWEEN COUNTER BALANCE AND ECCENTRIC ASSEMBLY
1/4
6.0 REF
NOTES:
1 SAND ONE SIDE OF SCREWHEAD FLAT AS SHOWN
2 GRIND ITEM 22 SO THAT IT IS FLUSH WITH ITEM 36
3 OLDER UNITS USED 255510 CLAMP & M91118002 11/64–40 SCREW

211-121A Edge Trimmer Assembly, SBUS

AAC Drawing Number 192051C Rev 5

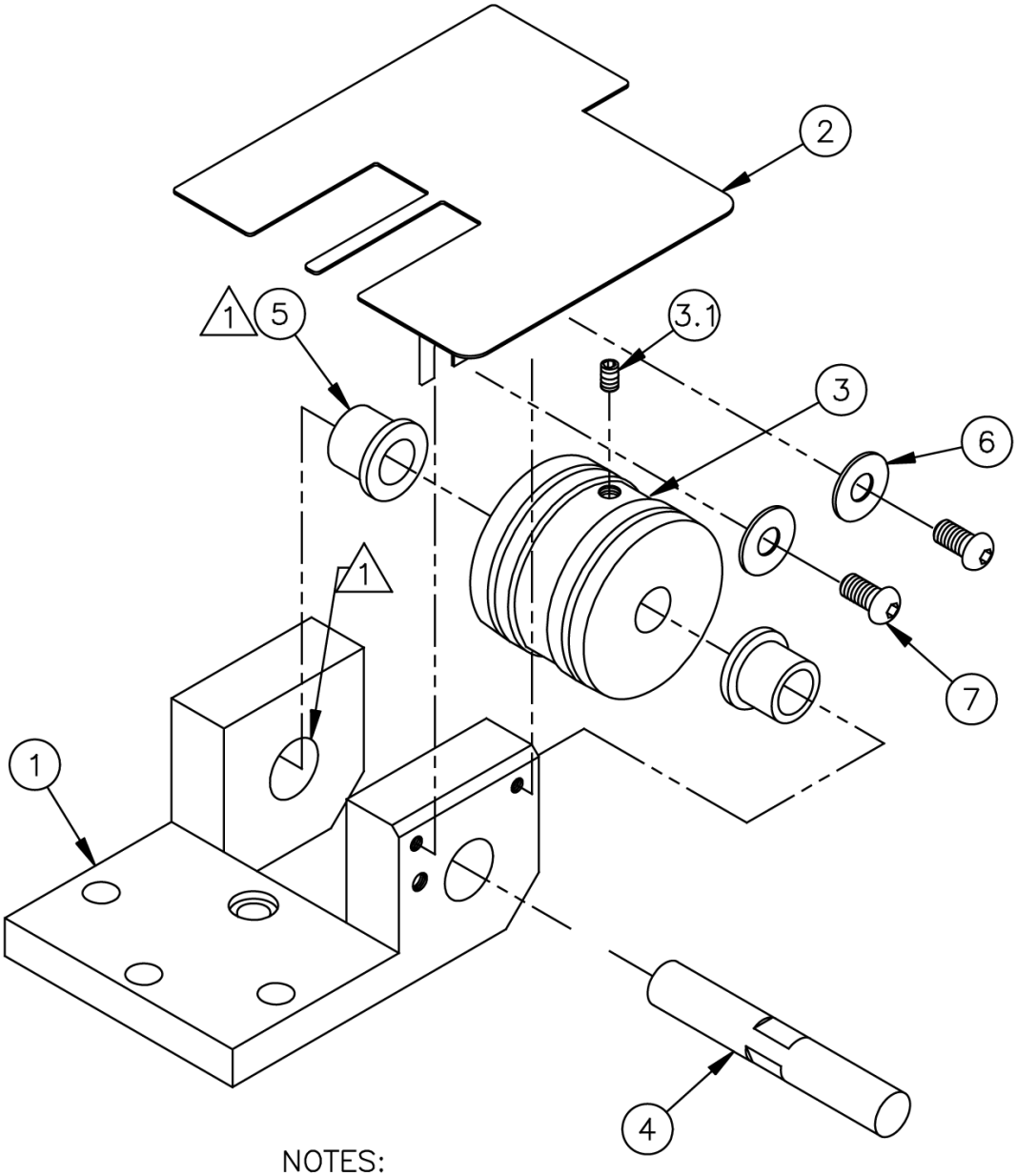
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	CC192024	COLLAR	26	1	255510-PEG	CLAMP
2	1	EEMS221005C	MOTOR	27	2	SSBC01032	SCREW, BUTTON CAP 1/4-20 X 1/2
3	1	211-172	CABLE	28	1	WWFS1/4	SAE WASHER
4	1	CCSC41/4	1/4 SET COLLAR	29	1	WWL1/4	LOCK WASHER
5	2	NNH8-32	HEX NUT	30	1	255508-2	SHAFT
6	1	RR306105	SPRING	31	1	010-027	ECCENTRIC ASSY
7	4	SSFC90032	SCREW, FLAT ALLEN CAP 8-32 X 1/2	32	1	010-029A1	DC MOTOR MOUNT
8	1	SSM207045	WASHER	33	1	010-029B1	DC MOTOR MOUNT
9	1	SSM255513	SCREW 11/64-40 X 7/32	34	1	010-031	MOUNT, MOTOR
10	1	SSM4547	SCREW, SOCKET SET M6 X .75 X 5	35	1	010-032	BLOCK, MOTOR ADJ.
11	1	SSM5109	SCREW 1/8-44 X 13/64	36	1	010-036A	PLATE,CUTTER GUARD
12	1	SSM7010	SCREW M3 X .5 X 6mm	37	1	010-042	PLATE,SPRING,CUTTER
13	1	SSSCM5X10	SCREW M5 X 10 SOC CAP	38	1	255507-91	HOLDER,UPPER CUTTER
14	1	SSM7036	SCREW M4 X .7 X 6mm	39	1	255509	HOLDER,LOWER CUTTER
15	1	SSM22570	SCREW, FILLISTER, 182-40 X 3/16	40	1	202522	RING
16	4	SSPS80032	SCREW, PAN HD SLOTTED 6-32 X 1/2	41	1	204351	CUTTER, LOWER
17	2	SSSC01040	SCREW, SOCKET CAP 1/4-20 X 5/8	42	2	240099	NEEDLE BEARING
18	1	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1	43	1	255506	BRACKET, CUTTER
19	4	SSSC95040	SCREW, SOCKET CAP 10-24 X 5/8	44	1	TTK32315	TORQUE KNOB
20	2	SSSS90032	SCREW, SOCKET SET 8-32 X 1/2	45	1	MMFELT	1 X 1.25 FELT PAD
21	1	255511-PEG	GUIDE	46	1	010-037A	COUNTER BALANCE
22	2	SSTS85008	SCREW, TRUSS SLOTTED 6-40 X 1/8	47	1	211-137	COVER
23	2	SSTS85008	5/32 BRASS WASHER	48	3	SSPS80024	SCREW, PAN SLOTTED 6-32 X 3/8
24	1	306394	CUTTER, UPPER	49	3	WWFS6	WASHER, FLAT, SAE
25	1	SSSC05128F	SCREW, SOCKET CAP 1/4-28 X 2	50	0	010-042A	PLATE,SPRING,CUTTER


1/4" TO
SET SCEW

211-128 Lower Conveyor Assembly

AAC Drawing Number 190012D Rev 8

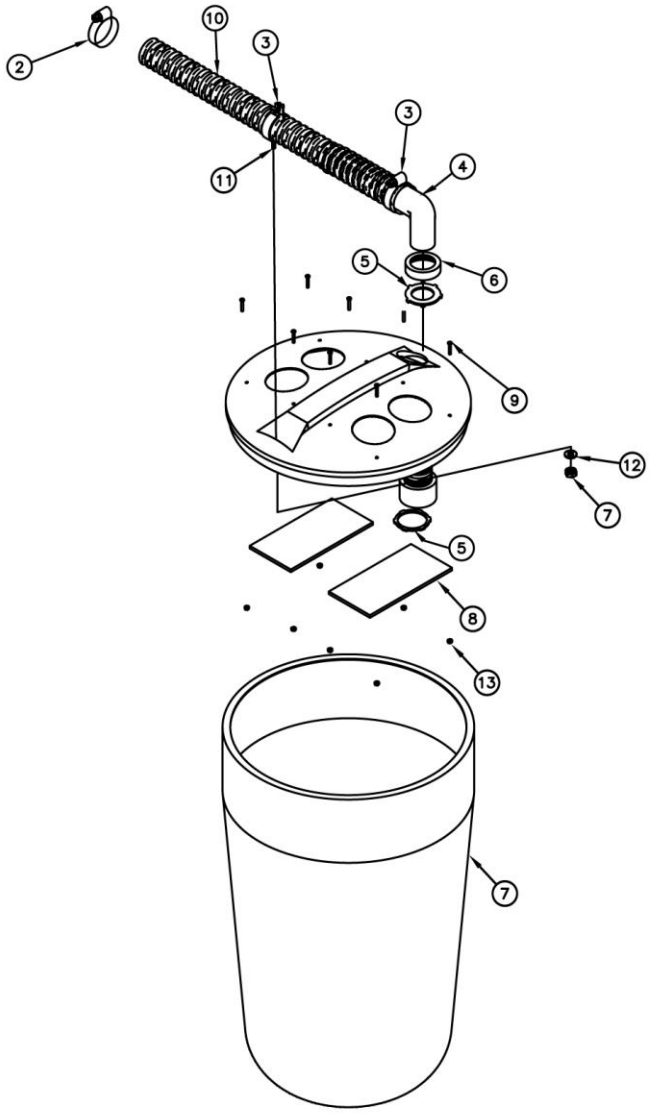
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	4	K-102-21	Threaded Rod 2/12	23	1	211-123	Belt Idler, Narrow
2	1	211-101	Belt, Urethane	24	1	010-049	Roller, Aluminum
3	1	211-004A	Mount, Tensioner	24.1	2	SSSS01032	Scr,So St 1/4-20x1/2
4	5	NNH5/16-18	NUT HEX, 5/16-18	25	1	010-050	Roller, Aluminum
5	1	NNK1/4-20	Nut, Kep, 1/4-20	25.1	4	SSSS01032	Wcr,So St 1/4-20x1/2
6	12	NNM103	Nut, 5/16-18	26	1	010-051	Roller, Aluminum
7	3	SSFS90128	Scr,Fl Sl 8-32x2.0	26.1	4	SSSS01032	Scr,So St 1/4-20x1/2
8	1	350254A	Rod, Threaded 2-1/4	27	4	010-052	Shaft, Plain
9	5	211-102	Belt, Urethane	28	7	350254	Rod, Threaded
10	1	SSHC01064	Scr,Hx Cp 1/4-20x1	29	2	23055	Roller, Aluminum
11	5	SSFS01160	Scr, Fl Sl 1/4-20x 2/12	29.1	4	SSSS01024	Scr,So St 1/4-20x3/8
12	2	SSTS95160	Scr,Tr Sl 10-24x2 1/2	30	1	211-055	Gear Pulley
13	1	211-036	Folder Mount Plate	30.1	2	SSSS01024	Scr,So St 1/4-20x3/8
14	2	TTCL1BPPK1	Knob, Plastic	31	1	211-038	Nut Pl Folder Mt
15	3	TTIW8-32	Threaded Insert	32	1	211-099	Cutter Plate
16	1	WWFE016	1/4 Fender Washer	33	4	010-145	Rod End Bracket
17	3	WWFS1/4	Washer, Flat SAE	34	1	A-2014-7	Cam Follower
18	2	WWFS10	No. 10 SAE Washer	35	1	211-035	Table Top, Lwr Conv
19	4	WWFS5/16	Washer, Flat SAE 5/16	36	1	011-008A	Plate Sleeve Support
20	5	0411-1608	Standoff, Medium	37	1	SSWFP06080	Scr,Fl Wd Ph No.6x1 1/4
21	2	WWL5/16	Washer, Lock, 5/16	38	5	WWF1/4	Washer, Flat
22	1	0411-1605	Edge Guide	39	1	211-101A	Belt, Urethane



211-123 Narrow Belt Idler Assembly

AAC Drawing Number 190701B Rev 3

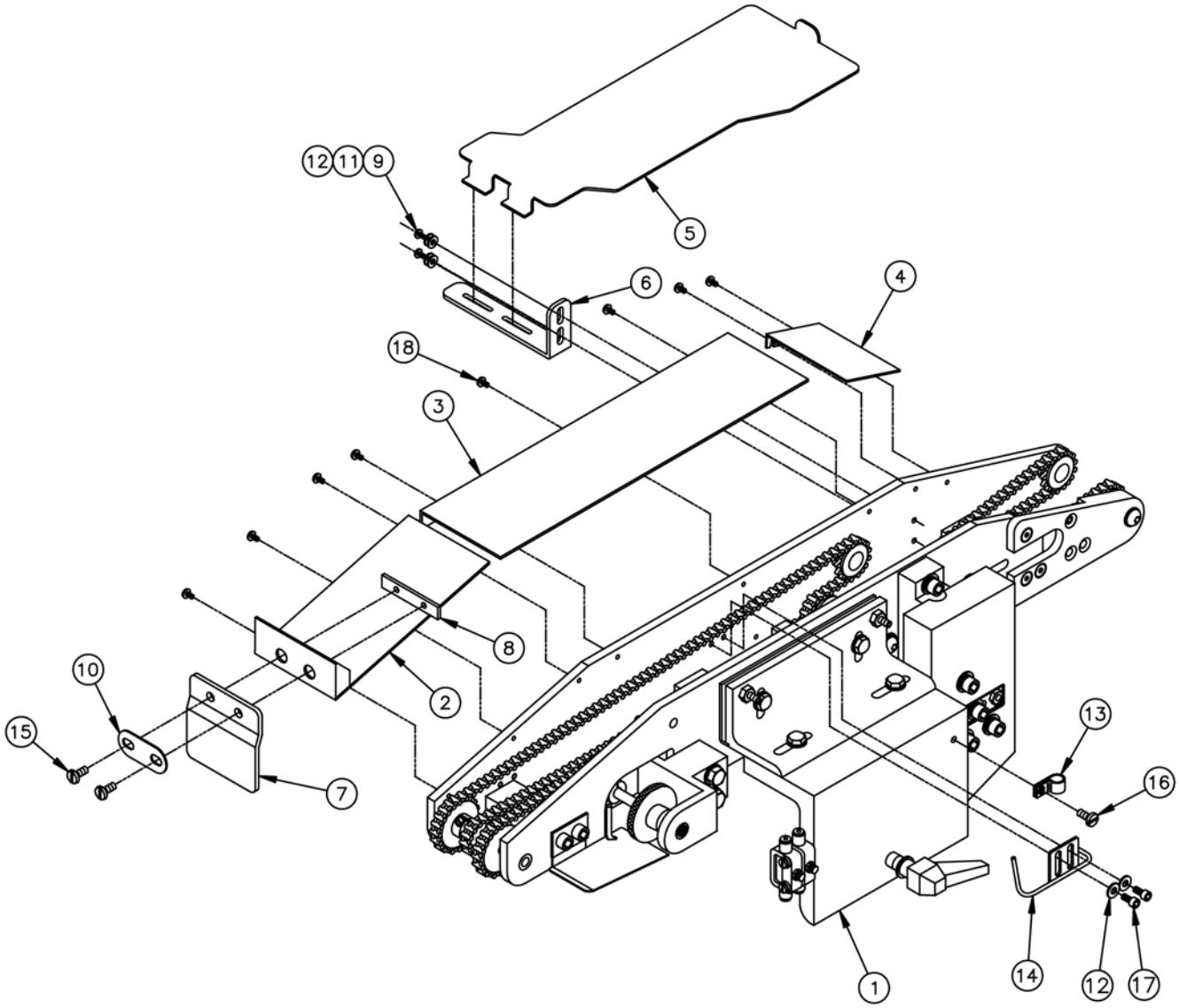
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	010-047D	Yoke, Roller	4	11	010-047B	Shaft
2	1	211-109C	Plate, Stripper	5	2	UUFF609-01	Bearing, Bronze, Flng
3	1	010-047C	Roller	6	2	WWFS10	Washer, SAE #10
3.1	2	SSSS01032	Scr,So St 1/4-20x1/2	7	2	SSBC98024	Scr,But Cp 10-32x3/8



0411-1300 Waste Container Assembly

AAC Drawing Number 191225C Rev 10

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	MMTC32GTAN	CONTAINER, WASTE	8	2	26285A	FILTER, WASTE SYS
2	2	MM5415K16	HOSE CLAMP	9	8	SSPS90064	SCREW, PAN HD SLOTTED 8-32 X 1
3	1	MM16300	TUBE CLAMP	10	6'	MMFH150	FLEX HOSE
4	1	MMRPL150	PLAIN ELBOW	11	1	SSHC01032	SCREW, HEX CAP 1/4-20 X 1/2
5	2	MMTC32GLN	1 1/2 CONDUIT LOCK NUT	12	1	WWF1/4	WASHER, FLAT
6	1	MMTC32GR	REDUCER	13	8	NNK8-32	8-32 KEP NUT
7	1	NNK1/4-20	NUT	14			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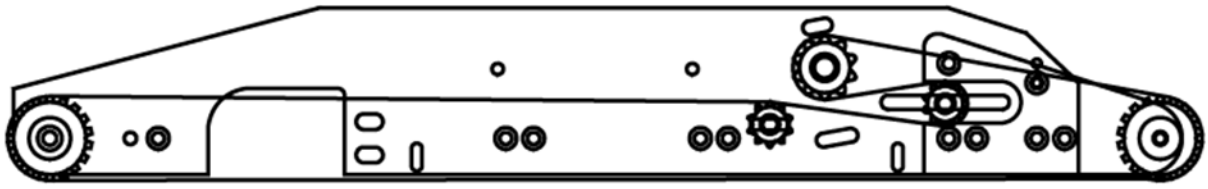
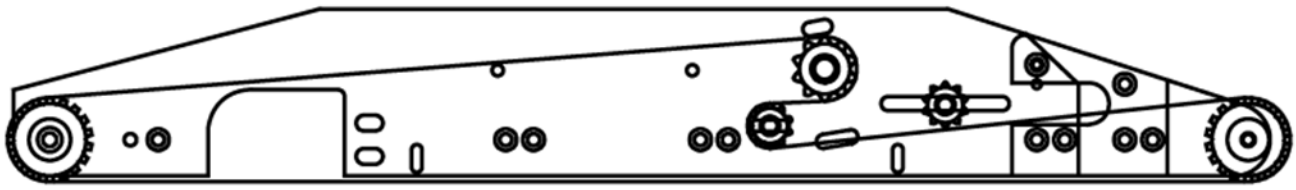
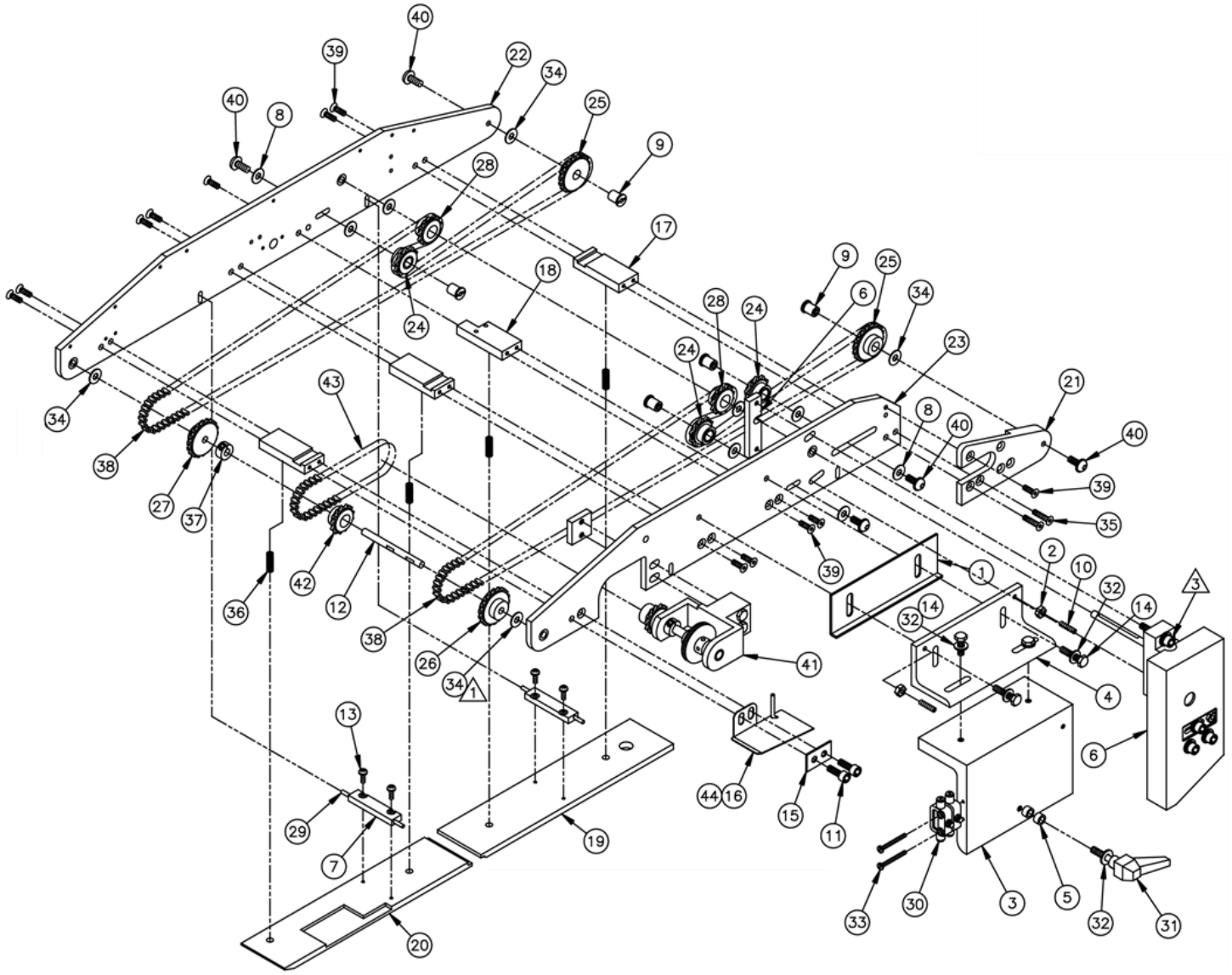




211-134 Top Conveyor, 2 Belt

AAC Drawing Number 191307C Rev 12

NO	QTY	PART #	DESCRIPTION
1	1	211-171	TOP CONVEYOR, GENERIC
2	1	211-139	BRACKET, REAR
3	1	011-046A	COVER, TOP CONVEYOR
4	1	211-138	BRACKET, FRONT
5	1	211-135	PLATE, SKID
6	1	211-136	MOUNT, SKID
7	1	011-138	GUARD, FINGER
8	1	F201-113	NUT PLATE
9	2	SSPS90032	SCREW, PAN SLOTTED 8-32 X 1/2
10	1	WW25DW	WASHER PLATE
11	2	WWL8	WASHER, LOCK
12	4	WWF8	WASHER, FLAT
13	1	AAF1/4	CLAMP, PLASTIC
14	1	2112-902	AIR UNCURLER
15	2	SSPS98024	SCREW, PAN SLOTTED 10-32 X 3/8
16	1	SSPS98032	SCREW, PAN SLOTTED 10-32 X 1/2
17	2	SSSC90024	SCREW, SOCKET CAP 8-32 X 3/8
18	8	SSTP80016	SCREW, TRUSS PHOLLIPS 6/32 X 1/4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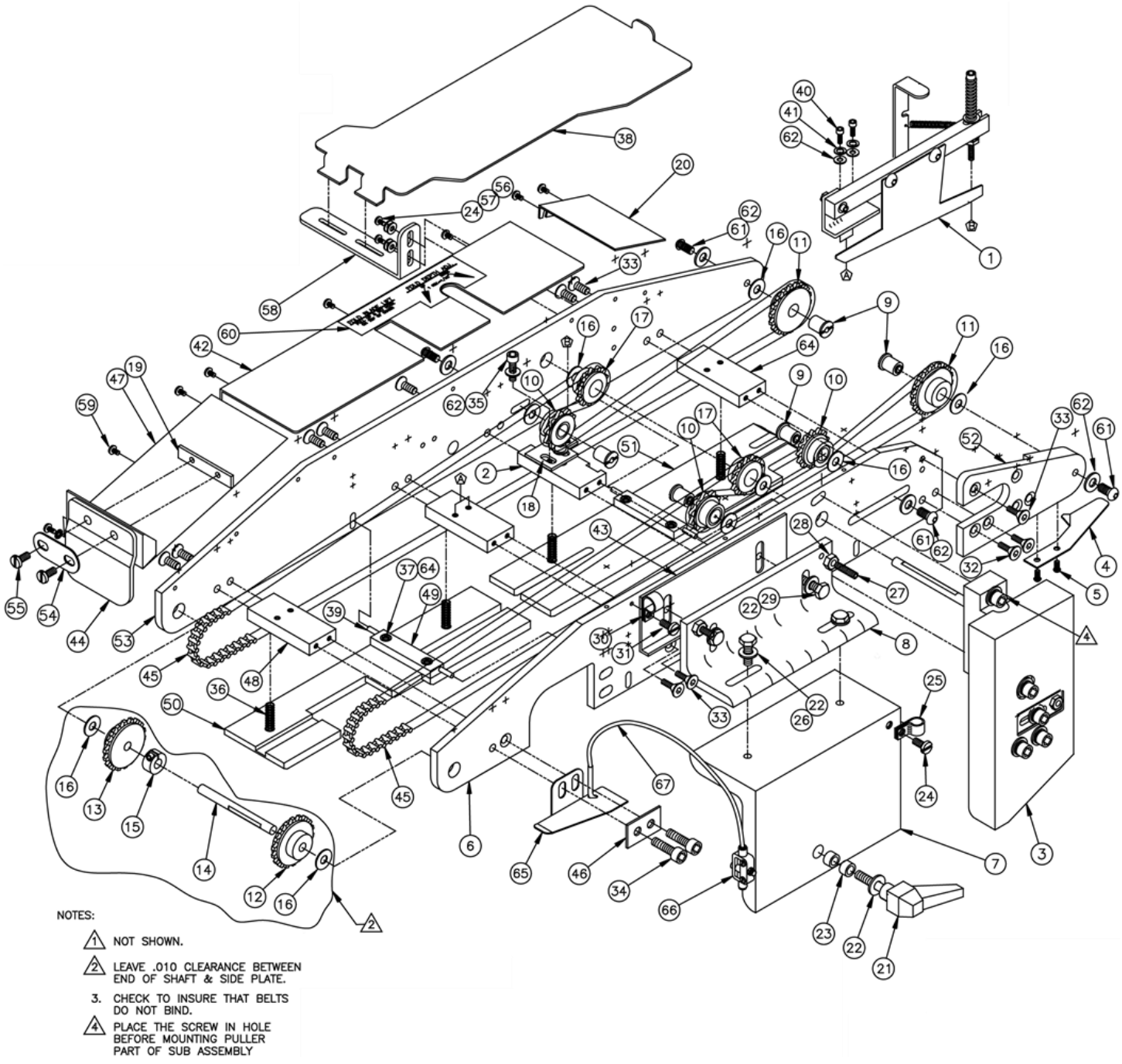
211-171 Top Conveyor Internal Components

AAC Drawing Number 191359C Rev 5

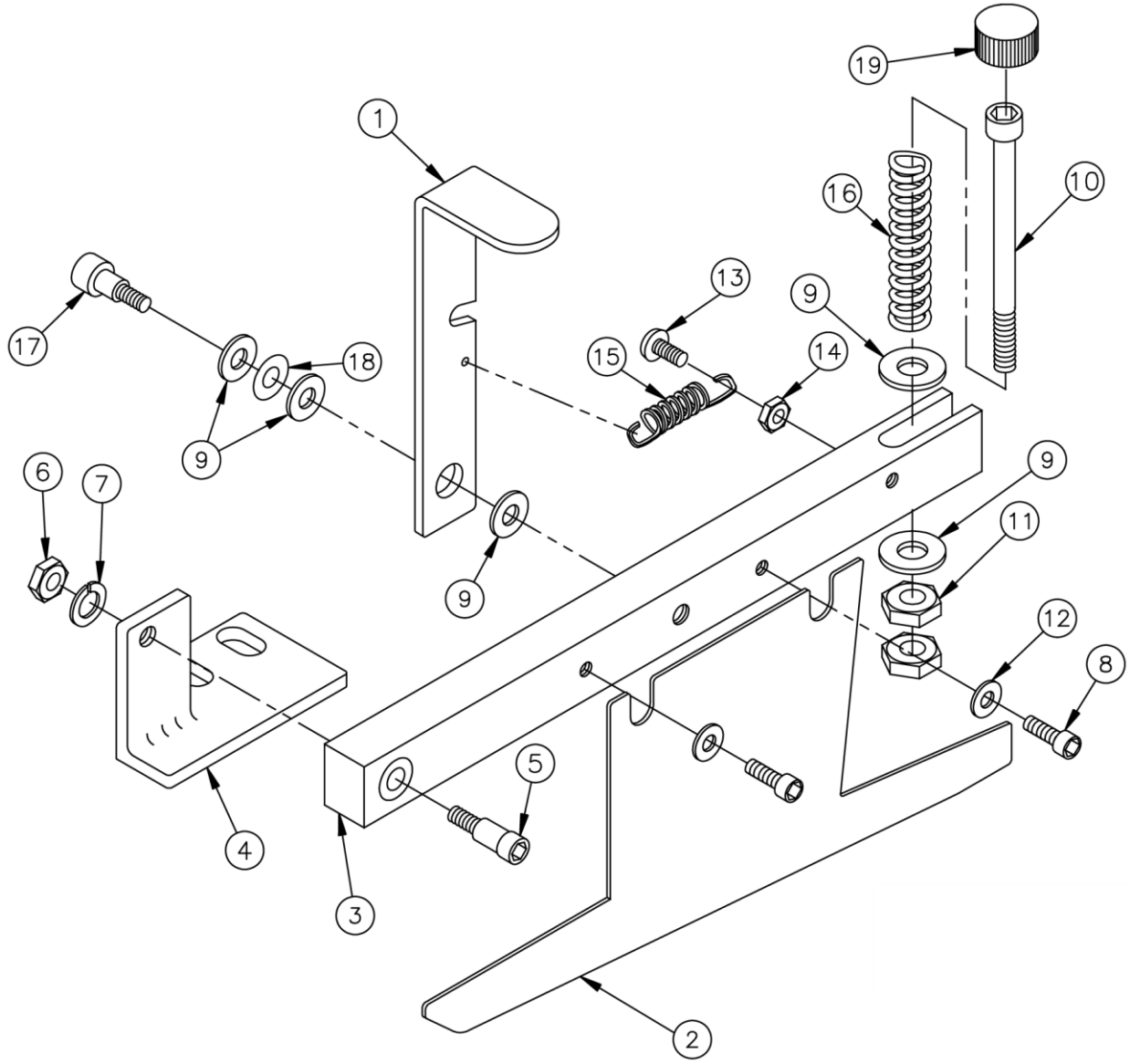
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	011-050	BracKet, Adjustment	23	1	211-003	Plate, Right Side
2	2	NNH10-32	Nut, Hex	24	3	211-049	SprocKet, Idler, 10T
3	1	011-052	Top Conv Mount	25	2	011-037	SprocKet, Idler, 18T
4	1	011-051	BrKt, Top Conv Mount	26	1	011-039	SprocKet, Drive, 18T
5	2	011-049	Spacer	27	1	011-040	SprocKer, Idler, 18T
6	1	311-002	Main Drive	28	2	MM66A-13	SprocKet, Drive, 13T
7	2	211-008	Pin Plate	29	4	IIS008x048	Spring Pin
8	3	WWFS10	Washer, Flat, SAE	30	2	AA2000F-03	Flow Control
9	5	011-041	Stud, Idler SprocKet	31	1	TTH32416	Threaded Handle
10	2	SSSS98048H	Scr,So St 10-32x3/4	32	5	WWF1/4	Washer, Flat
11	2	SSSC98048	Scr,So Cp 10-32x3/4	33	2	SSPS80096	Scr,Pn Sl 6-32x1 1/2
12	1	211-005	Axle, Front Drive	34	9	BBTRA411	Thrust Washer
13	4	SSPP80024	Scr,Pn Ph 6-32x3/8	35	2	SSFC98048	Scr,Fl Cp 10-32x3/4
14	4	SSHC01056	Scr,Hx Cp 1/4-20x7/8	36	4	RRLC024C10	Spring
15	1	WWP032	Washer Plate	37	1	CCCL4F	Clamp Collar
16	1	011-154	Material Edge Uncurler	38	2	MM25CCF210	Chain, 52.5 L
17	3	011-032A	Spacer	39	12	SSFC98032	Scr,Fl Cp 10-32x1/2
18	1	011-032B	Spacer, Knotched	40	5	SSBC98048	Scr,But Cp 10-32x3/4
19	1	211-007	Plate, Belt Pressure	41	1	311-001A	Feed Wheel Assy
20	1	211-006	Plate, Belt Pressure	42	1	MM66A-10	Sprocket, 10T
21	1	211-004	Nose Piece	43	1	MM25CCF040	Chain, 10.0 Long
22	1	211-002	Plate, Left Side	44	0.85	AATP5/32	Airline, 5/32


NOTES:
1. NOT SHOWN.
2. LEAVE .010 CLEARANCE BETWEEN END OF SHAFT & SIDE PLATE.
3. CHECK TO INSURE THAT BELTS DO NOT BIND.
4. PLACE THE SCREW IN HOLE BEFORE MOUNTING PULLER PART OF SUB ASSEMBLY

211-134B Top Conveyor, 2 Belts

AAC Drawing Number 191650C Rev 3

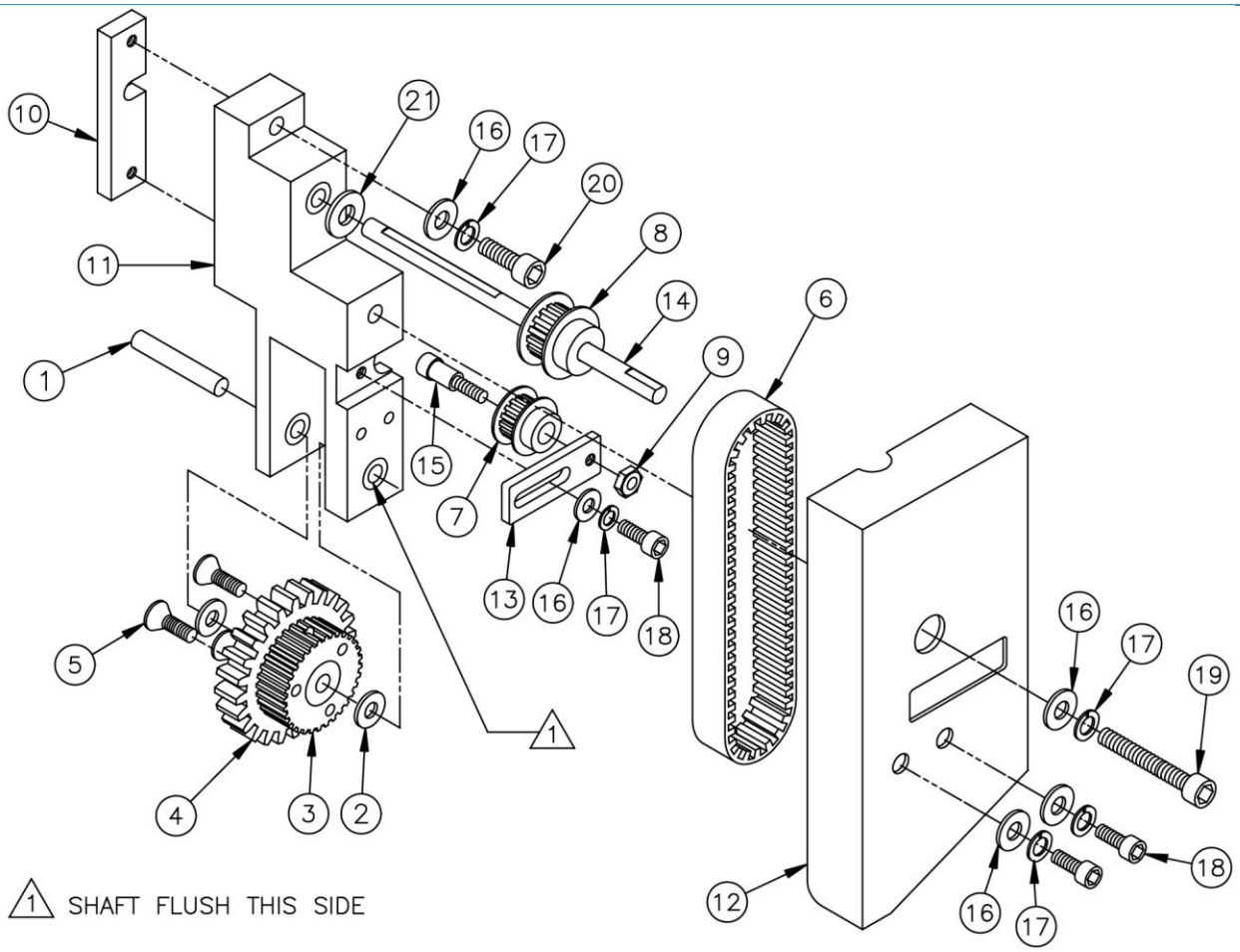
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	311-061	Keel Assembly	35	2	SSSC98032	Scr,So Cp 10-32x1/2
2	1	011032B	Spacer	36	4	RRLC024C10	Spring
3	1	311-002	Main Drive	37	4	SSPP80024	Scr,Pn Hd Ph 6-32x3/8
4	1	211-023	Fold Holder	38	1	211-135	Plate, Skid
5	2	SSBC80032	Scr,But Cp 6-32x1/2	39	4	IIS008x048	Roll Pin 1/8x1
6	1	211-003	Plate, Right	40	2	SSSC98024	Scr,so Cp 10-32x3/8
7	1	011-052	Upright Mount	41	2	WWL10	Lock Washer
8	1	011-051	Bracket, Top Conv	42	1	211-071	Top Cover
9	5	011-041	Idler Stud	43	1	011-050	Upper Conv Adj
10	3	211-049	10 Tooth Idler	44	1	011-138	Finger Guard
11	2	011-037	18 Tooth Idler	45	2	MM25CCF210	Chain, Flex-E-Pitch
12	1	011-039	18 Tooth Idler	46	1	WWP032	Washer Plate
13	1	011-040	18 Tooth Idler	47	1	211-139	Bracket, Rear
14	1	211-005	Front Axle	48	3	211-070	Spacer
15	1	CCCL4F	1/4 Clamp Collar	49	2	211-008	Pin Plate
16	9	BBTRA411	Thrust Washer	50	1	311-067	Pressure Plate Ft
17	2	MM66A-13	13 Tooth Idler	51	1	311-066	Pressure Plate R
18	1	211-083	Mount	52	1	211-004	Nose Piece
19	1	F201-113	Nut Plate	53	1	211-002	Left Side Panel
20	1	211-138	Bracket, Front	54	1	WW25DW	Washer Plate
21	1	TTH32416	1/4-20 Threaded Handle	55	2	SSPS98024	Scr,Pn Sl 10-32x3/8
22	5	WWF1/4	1/4 Washer	56	2	WWF8	Washer, Flat
23	2	011-049	Spacer, Clamp Screw	57	2	WWL8	Washer, Lock
24	3	SSPS90032	Scr,Pn Sl 8-32x1/2	58	1	211-136	Mount, Skid
25	1	AAF1/4	Plastic Clamp	59	8	SSPP80016	Scr,Pn Hd Ph 6-32x1/4
26	2	SSHC01040	Scr,Hx Cp 1/4-20x5/8	60	1	211-084	Label
27	2	SSSS98048H	Scr,So St 10-32x3/4	61	5	SSBC98048	Scr,But Cp 10-32x3/4
28	2	NH10-32	10-32 Hex Nut	62	9	WWFS10	SAE Washer
29	2	SSHC01064	Scr,Hx Cp 1/4-20x1	63	1	011-INST1	Instructions
30	1	AAF3/16	Plastic Clamp	64	4	WWSI6	#6 Int. Tooth Washer
31	1	SSPS80016	Scr,Pn Hd Sl 6-32x1/4	65	1	011-154	Uncurler Mat. Edge
32	2	SSFC98048	Scr,Fl Cp Al 10-32x3/4	66	1	AA2000F-03	In Line Flo Control
33	11	SSFC98032	Scr,Fl Cp Al 10-32x1/2	67	.5’	AATP5/32 5/32	Air Line
34	2	SSSC98048	Scr,So Cp 10-32x3/4				



311-061 Keel Assembly, ¾ Wide Cuff

AAC Drawing Number 190321B Rev 3

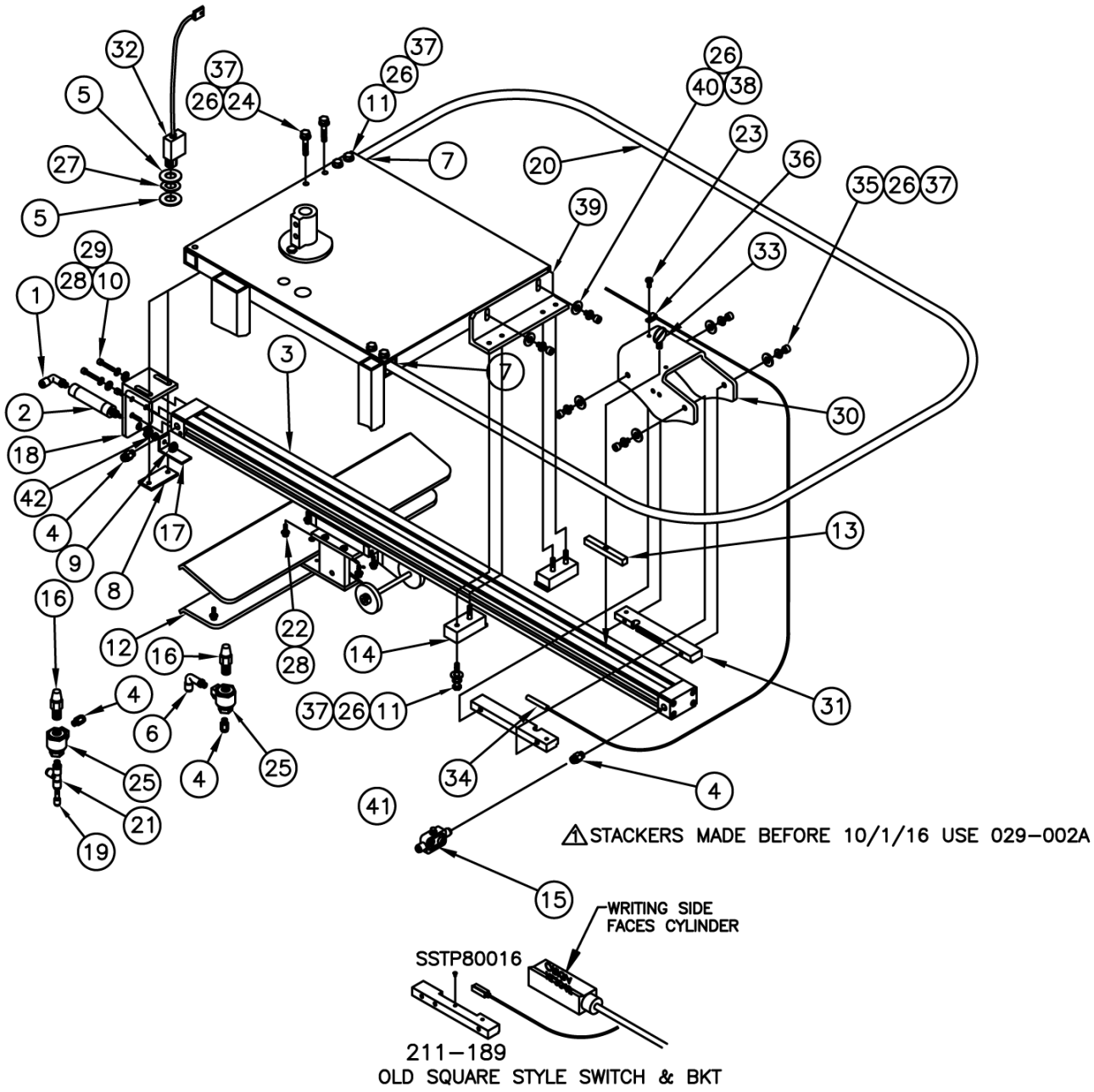
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-082	Latch, Tuck Fold	11	2	NNH10-32	Hex Nut, 10-32
2	1	211-080	Tuck Fold Blade	12	2	WWFS6	Washer
3	1	211-079	Mount, Tuck Fold	13	1	SSPS80032	Scr,Pn Hd Sl 6-32x1/2
4	1	211-081	Pivot, Tuck Fold	14	1	NNH6-32	Hex Nut
5	1	SSAS016024	Scr,So Sh 1/4x3/8,10-24	15	1	RRLE020B3	Spring Ext
6	1	NNH10-24	Hex Nut, 10-24	16	1	RRLC030D14	Spring Compression
7	1	WWL10	No. 10 Lock Washer	17	1	SSAS016016	Scr,Al Sh 1/4x1/4x10-24
8	2	SSSC95024	Scr,So Cp 10-24x3/8	18	1	WWS3502-27	Spring Washer
9	5	WWF10	No. 10 Washer	19	1	SST#10	Thumb Screw
10	1	SSSC98192	Scr,So Cp 10-32x3				



311-002 Top Conveyor, Main Drive

AAC Drawing Number 190255B Rev 7

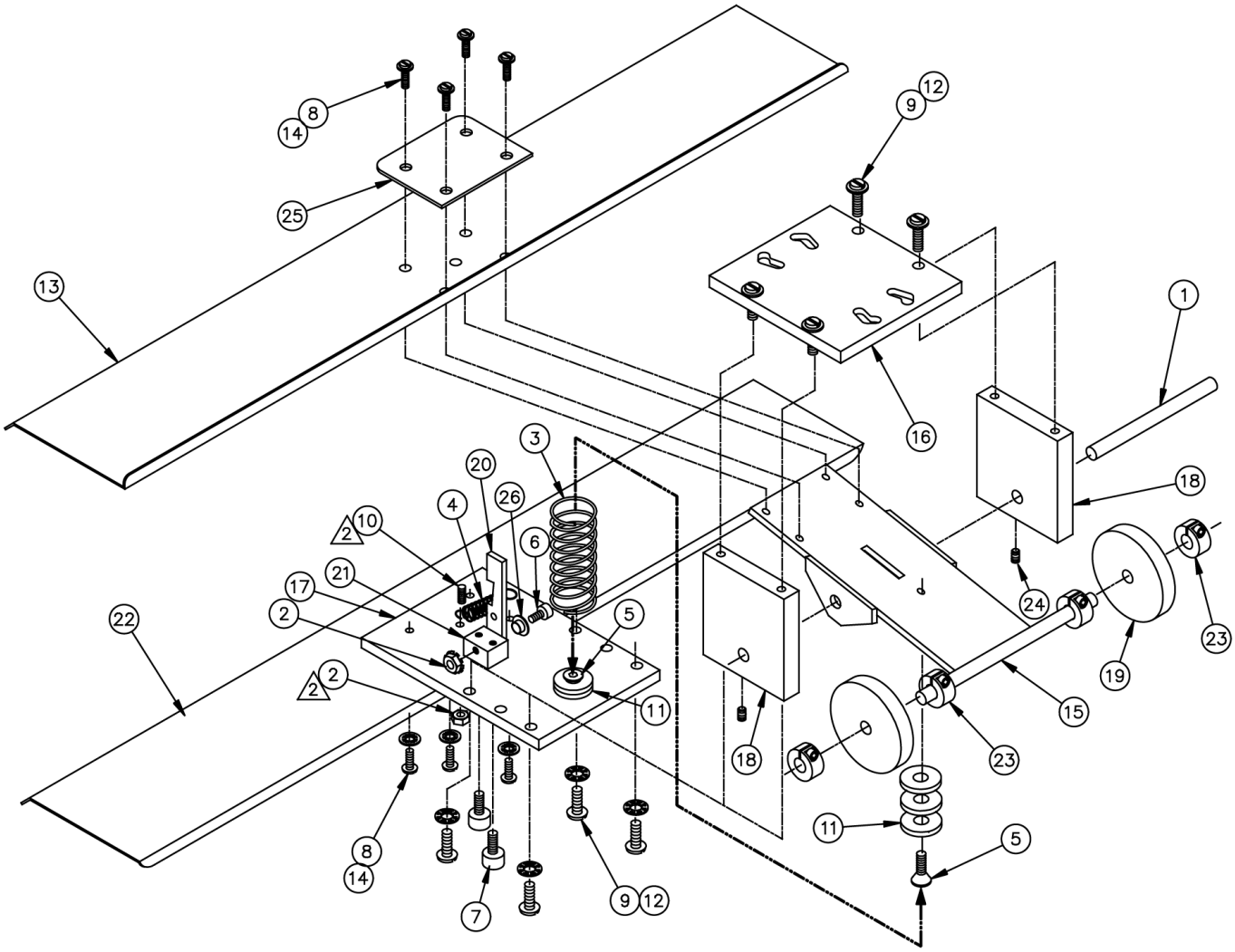
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	IID016X112	Dowel Pin	12	1	211-075	Belt Guard
2	2	BBTT601	Thrust Bearing	13	1	211-077	Tensioner
3	1	211-014	Pulley, Top Conveyor	14	1	211-076	Shaft Top Drive
4	1	211-013	Gear, Top Conveyor	15	1	SSAS016048	Scr,Al Sh 1/4x2/4,10-24
5	3	SSFC98040	Scr,Fl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


⚠STACKERS MADE BEFORE 10/1/16 USE 029–002A
WRITING SIDE FACES CYLINDER
SSTP80016
211–189
OLD SQUARE STYLE SWITCH & BKT

211-151A Stacker, Pick and Stack

AAC Drawing Number 191055B Rev 13

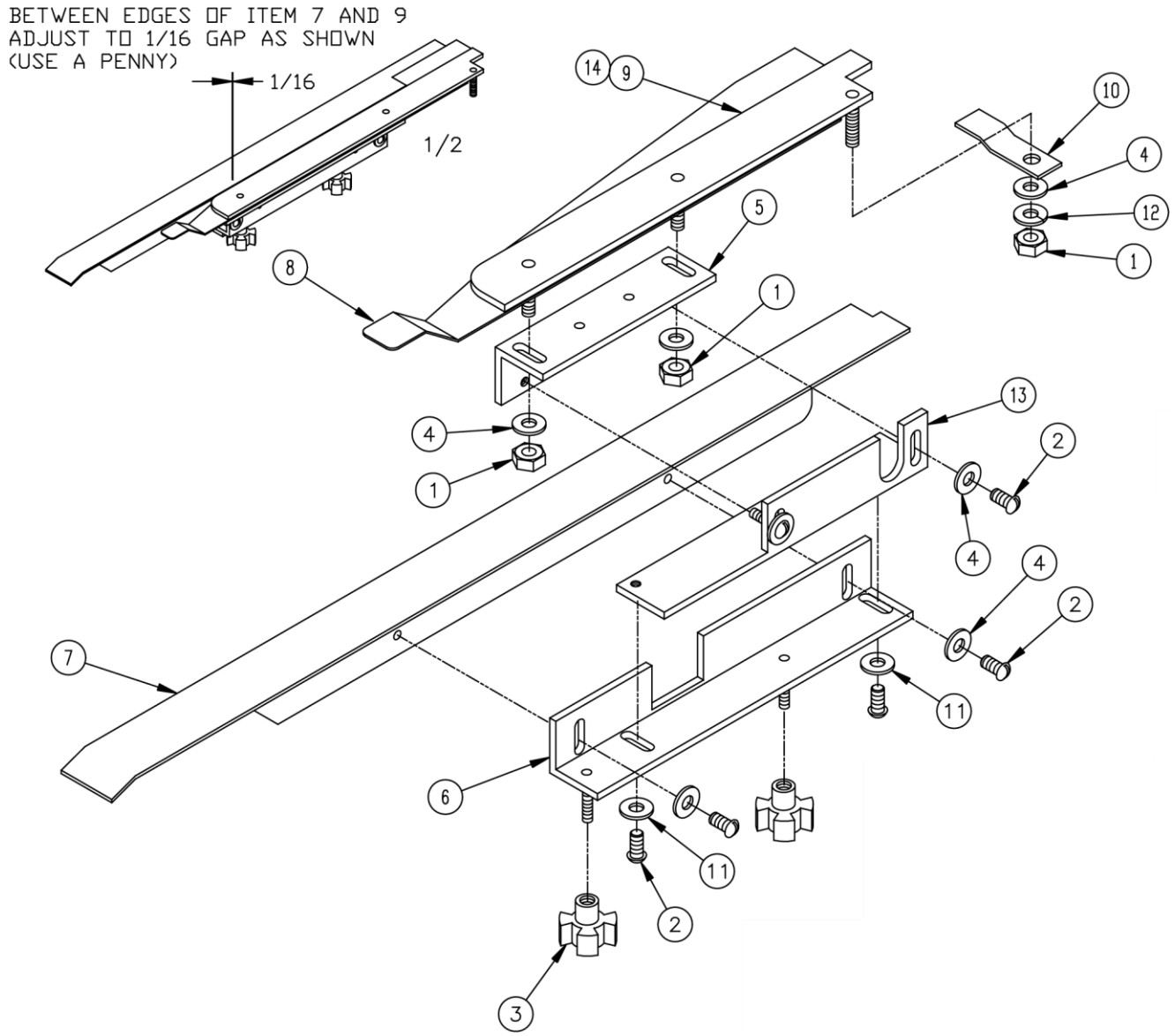
NO	QTY	PART #	DESCRIPTION
1	1	AAQME-5-10	QUICK MALE ELBOW
2	1	AAC8SH-.5A	CYLINDER, AIR
3	1	AACR25813	CYLINDER, RODLESS
4	4	AAQMC-4-8	QUICK MALE CONNECTOR
5	2	MM3088A434	SHIM
6	1	AAQME-4-8	QUICK MALE ELBOW
7	2	029-017	ROD, TAPPED
8	1	029-003A	NUT PLATE
9	1	NNE10-32	NUT, ELASTIC,10-32
10	4	SSSCM5X20	SCREW, SOCKET CAP M5-0.8 X 20
11	8	SSHC01080	SCREW, HEX CAP 1/4 X 1-1/4
12	1	016-014A	CLAMP, MATERIAL, ASSY
13	1	211-145A	PLATE, PRESSURE
14	2	211-186	MOUNT, AIR CYL, REAR
15	1	AA3000F-07	FLOW CONTROL
16	2	MMU002A	MUFFLER
17	1	029-002C	PUSHER, CLAMP CLOSER
18	1	211-185	BRACKET, PUSHER CYL.
19	1	AAQPR-5-4	PLUG IN REDUCER
20	1	029-005	GUARD, STACKER
21	1	AAQMT-4-8	MALE RUN TEE
22	4	SSSCM5X14	SCREW, SOCKET, CAP M5-0.8 X 14
23	1	SSPS98024	SCREW, PAN SLOTTED 10-32 X 3/8
24	2	SSHC01112	SCREW, HEX , CAP 1/84-20 X 1-3/4
25	2	AAVSQE1	EXHAUST VALVE
26	16	WWFS1/4	WASHER, FLAT, 1/4
27	1	WWSW3/4	WASHER, SPRING
28	8	WWFM5	WASHER,FLAT,M5
29	4	WWLM5	WASHER,LOCK,M5
30	1	211-188	OPENER, CLAMP
31	2	2211097	MOUNT, RAIL OPENER
32	1	FFSM312LVQ	EYE,W/PLUG,STACK
33	1	SSTO01048	SCREW, THUMB 1/4-20 X 3/4
34	1	AACR25813R	SWITCH, REED
35	4	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1
36	4	AAF1/8	1/8" PLASTIC CLAMP
37	16	WWL1/4	LOCK WASHER
38	2	SSSC01096	SCREW, SOCKET CAP 1/4-20 X 1-1/2
39	1	215-5016	MOUNT ANGLE
40	2	NNH1/4-20	HEX NUT,1/4-20
41	1	SSTP80016	SCREW, TRUSS HD PHILLIPS 6-32 X 1/4
42	1	NNJ10-32	NUT,JAM,THIN,10-32



016-014A Material Clamp Assembly

AAC Drawing Number 190681C Rev 13

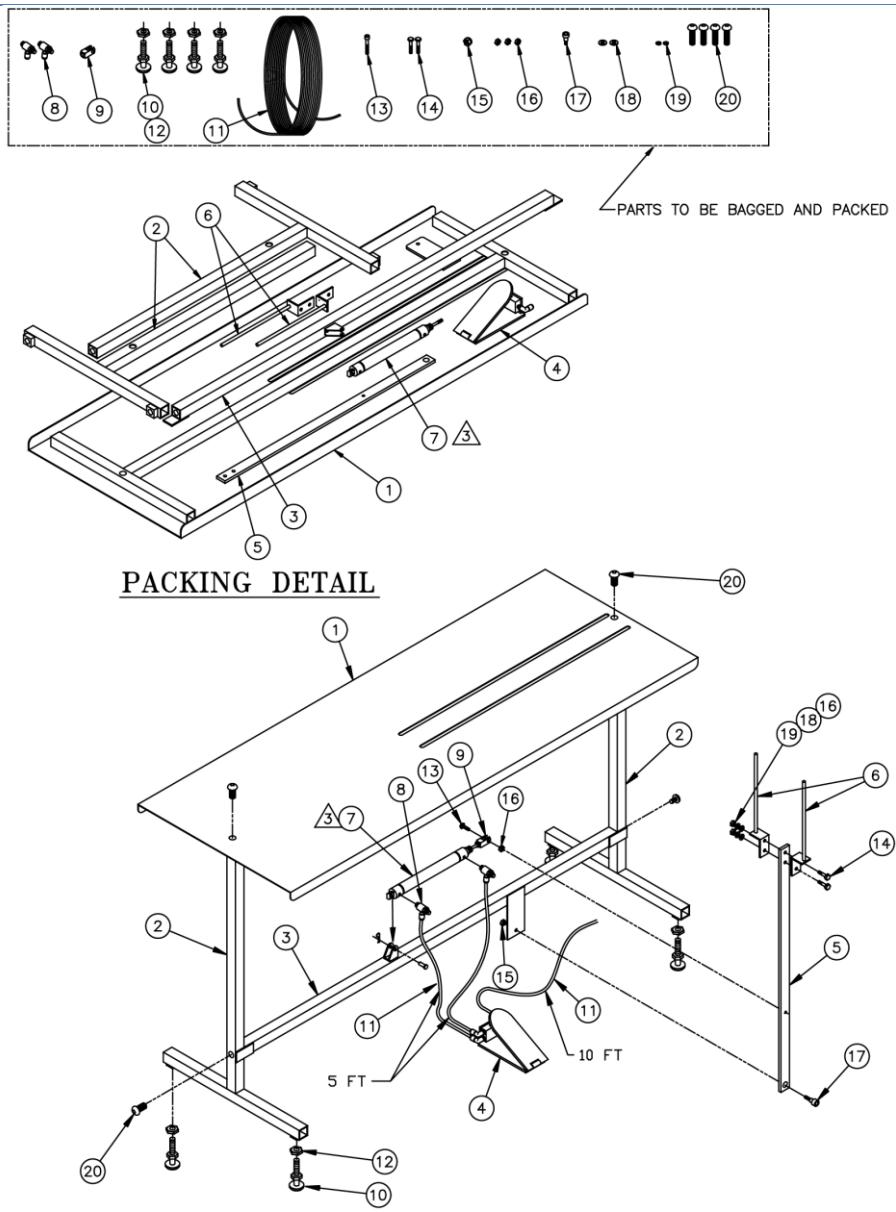
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	IID016X192	Dowel Pin, 1/4 X 3 "	14	8	WWSI8	Washer, Int Teeth, #8
2	1	NNK10-32	Nut, Kep 10-32	15	1	016-015	Bracket, Clamp Assy.
3	1	RRLC055J-7	Spring, .055X.72X2	16	1	016-016	Base Plate, Clamp Jaw
4	1	RRLE024B-6	Spring, .024 X .19 X. 94	17	1	016-017	Bkt, Bottom Clamp Jaw
5	2	SSFC90024	Screw, Flat Allen, 8-32	18	2	016-018	Support, Side
6	1	SSSC98056	Src, So Cp 10-32 x 7/8	19	2	013-040	Wheel, Clamp Opener
7	2	SSSC80024	Scr, So Cp 6-32x3/8	20	1	016-020B	Lever, Trip
8	8	SSBC90016	Screw, Pan Slotted 8-32	21	1	016-021	Mount, Trip Lever
9	8	SSPS98032	Screw, Pan Slotted 10-32	22	1	016-022B	Clamp Jaw
10	1	A-2206A	Threaded Rod	23	4	CCCL4F	Clamp Collar
11	6	WWF1/4	Washer, Flat 1/4	24	2	SSSP01016	Scr, Ny Pt, 1/4-20x1/4
12	8	WWSI10	Washer, Int Teeth, #10	25	1	016-022A	Stiffener
13	1	016-022C	Clamp Jaw	26	1	016-020B1	Bushing



211-G6606C Hemming Folder Assembly

AAC Drawing Number 190185B Rev 6

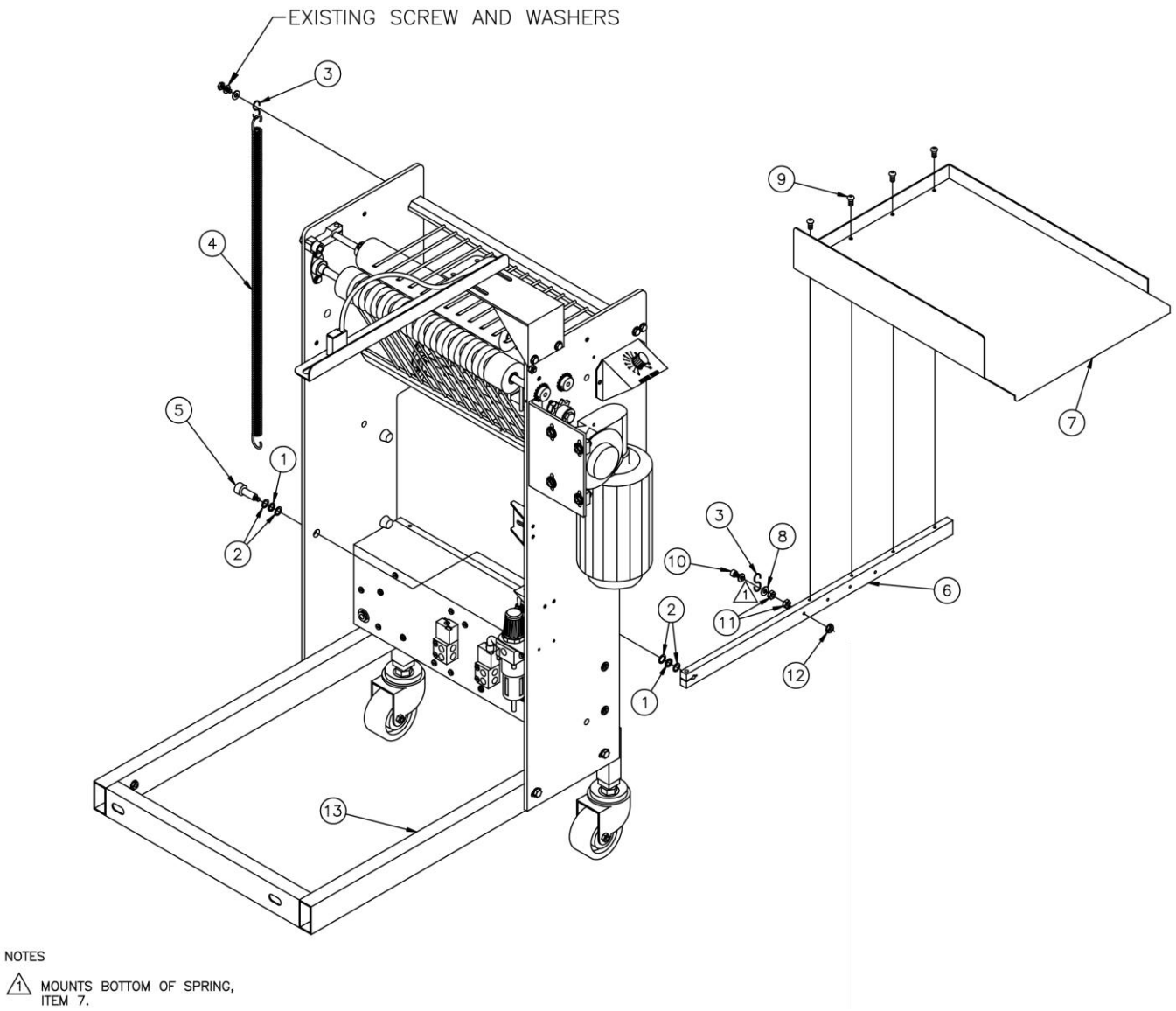
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	3	NNH10-24	Hex Nut	8	1	011-012A	Tongue, Folder
2	6	SSPS95024	Scr,Pn Sl 10-24x38	9	1	011-013A	Edge Guide, Right
3	2	TTCL1BPPK1	Knob, 10-24	10	1	011-060	Support, Lower Folder
4	7	WWFS10	Washer, SAE No. 10	11	2	WWB10S	Brass Washer No. 10
5	1	010-022A	Bracket, Folder Mount	12	1	WWL10	Washer, Lock
6	1	211-042	Base, Folder Mnt Brkt	13	1	010-022B	Folder Mount
7	1	011-011	Edge Guide, Folder	14	AR	311-085A	Edge Guide Spacer



211-162 Indexing Table

AAC Drawing Number 191010B Rev 4

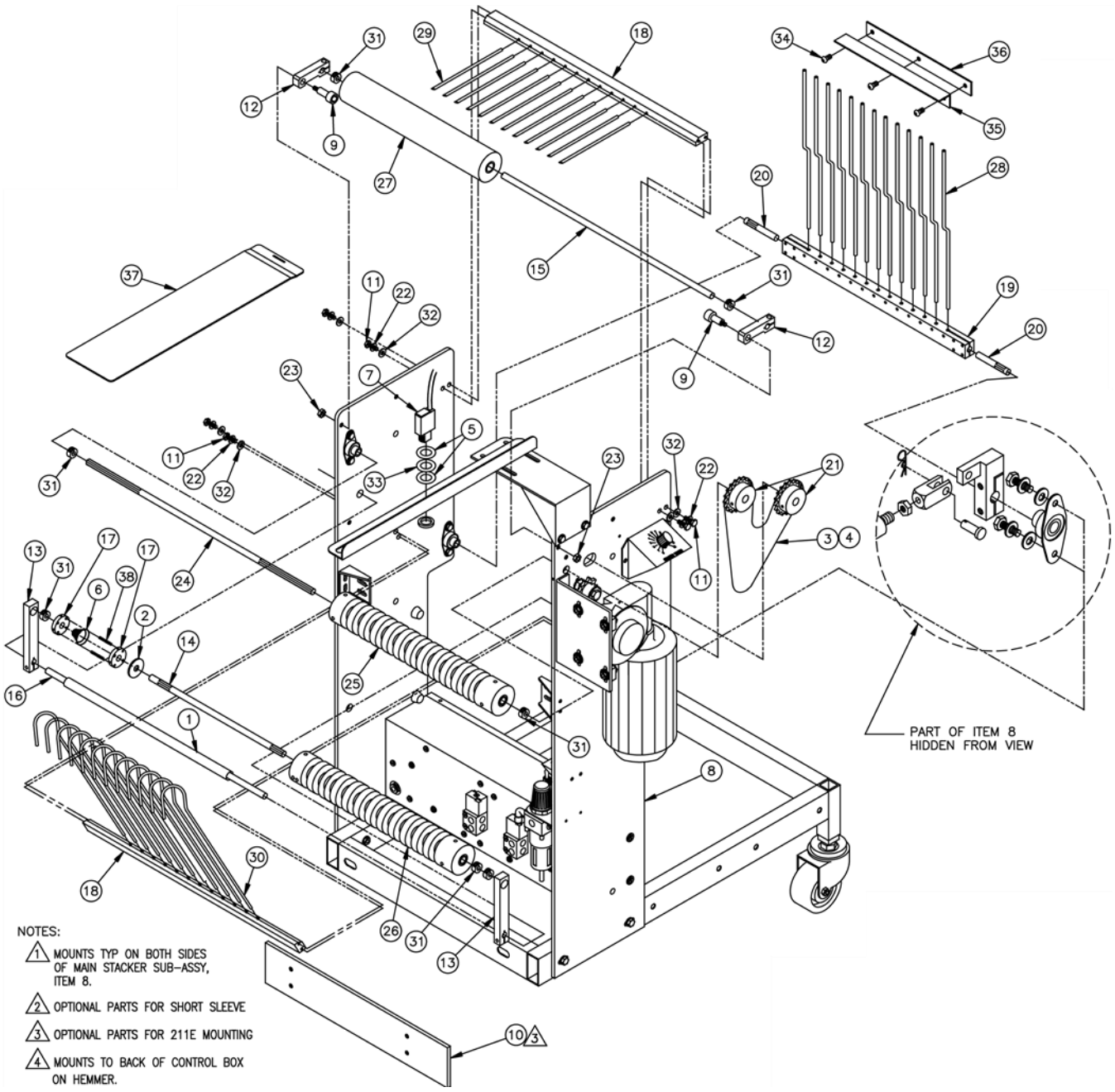
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	211-162-1	Table Top Weldment	11	20'	AATP5/32	5/32 Air Line
2	2	211-162B8	Leg Weldment	12	4	NNH1/2-13	Hex Nut
3	1	211-162B7	Stand Weldment	13	1	SSSC01096	Scr,So Cp 1/4-20x1-1/2
4	1	AA192-10DA	Foot Switch	14	2	SSHC01080	Scr,Hx Cp 1/4-20x1-1/2
5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



311-006 Fold In Half Stacker Assembly

AAC Drawing Number 190887C Rev 15

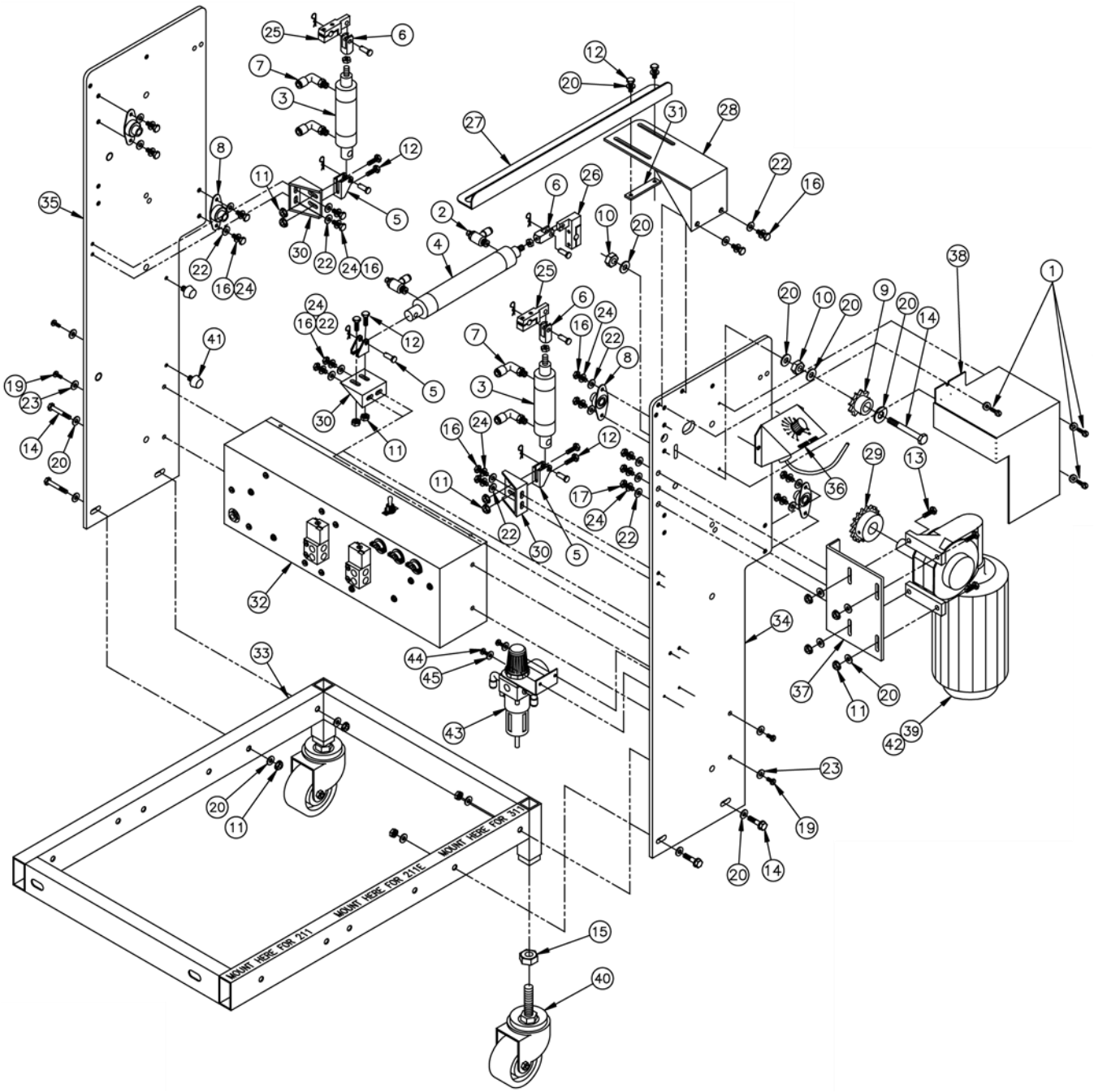
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	BBNTA613	Thrust Bearing	8	2	WWF1/4	Washer
2	4	BBTRA613	Thrust Washer	9	4	SSBC98032	Scr,But Cp 10-32x1/2
3	2	MMS064	Hook	10	1	SSSC98096	Scr,So Cp 10-32x1 1/2
4	1	RR9640K25	Spring, Ext. 11 "	11	2	NNH10-32	Hex Nut
5	1	SSAS024032	Scr,Al Sh 3/8x1/2	12	1	NNK10-32	Kep Nut
6	1	017-015	Arm, Support	13	1	311-006B	Main Stacker Sub-Assy
7	1	017-040	Tray, Bundle				


PART OF ITEM 8
HIDDEN FROM VIEW
NOTES:
1 MOUNTS TYP ON BOTH SIDES OF MAIN STACKER SUB-ASSY, ITEM 8.
2 OPTIONAL PARTS FOR SHORT SLEEVE
3 OPTIONAL PARTS FOR 211E MOUNTING
4 MOUNTS TO BACK OF CONTROL BOX ON HEMMER.

311-006B Fold In Half Assembly

AAC Drawing Number 191618C Rev 6

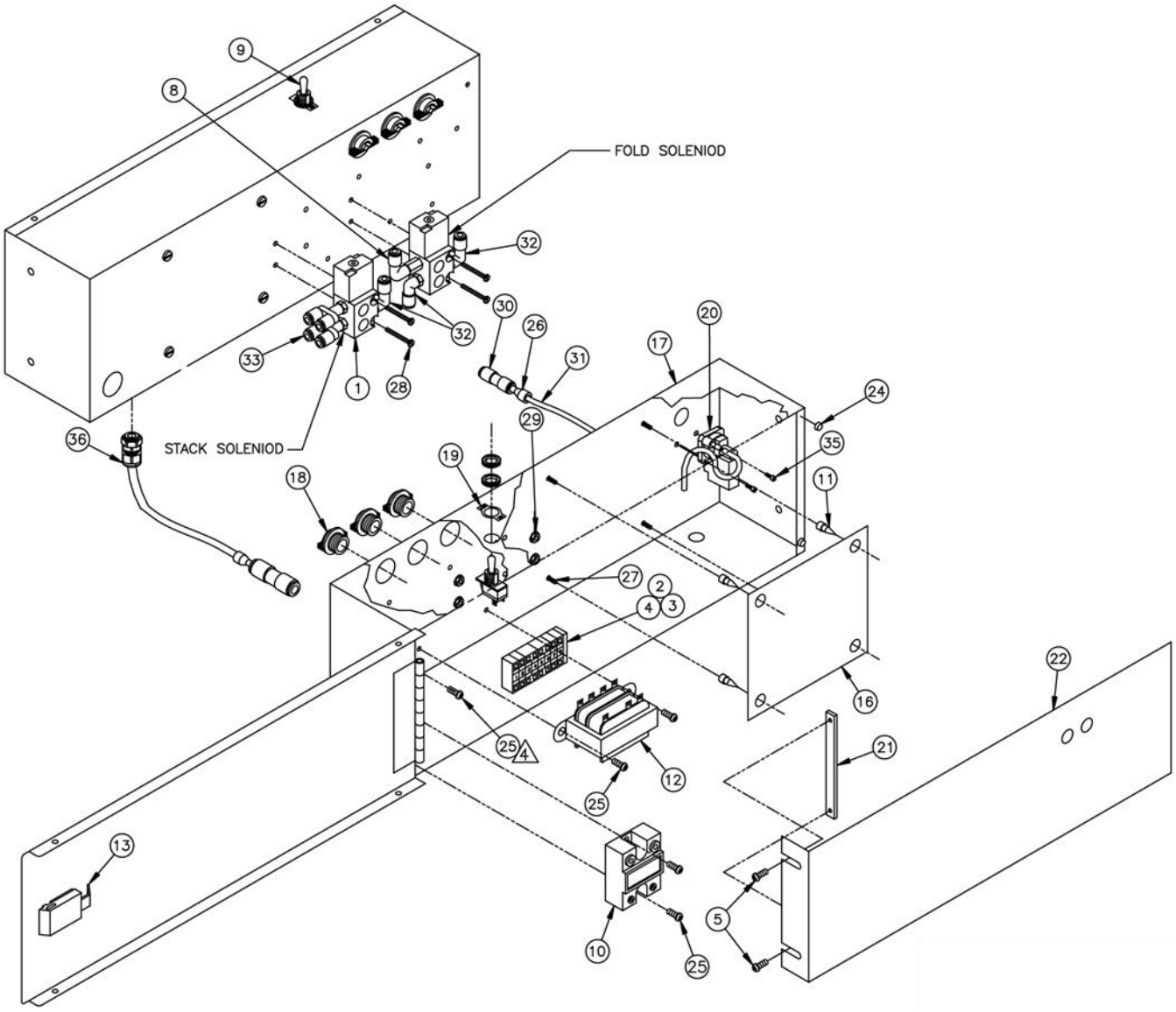
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	14 "	ZTH3/8	Heat Shrink	23	2	NNJ5/16-18	Jam Nut
2	1	BBTRA613	Thrust Washer	24	1	025-009	Axle, Main Drive
3	1.5’	MM35	Single Strand Chain	25	1	025-010	Roller, Main Drive
4	1	MM35CL	Connecting Link	26	1	025-011	Roller, Clutch Drive
5	2	MM3088A434	Shim	27	1	025-013A	Roller, Urethane
6	1	RRBEEHIVEM	Spring	28	13	025-014	Finger, Flip Stacker
7	1	FFSM312LV	Electric Eye	29	12	025-016	Finger, Shelf
8	1	311-006A	Main Stacker Sub-Assy	30	12	025-017A	Finger Stripper
9	2	SSAS024048	Scr,Al Sh 3/8x3/4	31	7	CCCL6F	Collar
10	1	211-175	Drop Adaptor	32	8	WWF1/4	Washer
11	6	SSHC01032	Scr,Hx Cp 1/4-20x1/2	33	1	WWSW3/4	Spring Washer
12	2	017-017	Arm, Idler Roller	34	0	SSBC98032	Scr,But Cp 10-32x1/2
13	2	017-019	Arm, Clutch Drive	35	0	311-040	Short Sleeve Stop
14	1	017-021	Axle, Clutch Drive	36	0	311-041	Short Sleeve Stop Mnt
15	1	017-022	Axle, Idler	37	0	311-039	Sled Extension
16	1	017-023	Axle, Pivot Clutch	38	2	IIS008X072	Spring Pin 1/8x1 1/8
17	2	017-024	Clutch Disc	39	AR	025-WD4	Wiring Diagram
18	2	017-027	Mount, Stripper Fing	40	AR	025-PD1	Pneumatic Diagram
19	1	017-030	Mount, Flip Stacker	41	1	EET8966 4	Pole Receptacle
20	2	017-032	Axle, Flip Stacker	42	11	K-233	Electrical Box
21	2	017-039	Sprocket, Mod	43	11	K-234 4x4	Cover
22	6	WWL1/4	Washer, Lock				


MOUNT HERE FOR 211
MOUNT HERE FOR 211E
MOUNT HERE FOR 311

311-006A Fold In Half Stacker Sub-Assembly

AAC Drawing Number 190888C Rev 12

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	3	SSPS90024	Scr,Pn Hd Sl 8-32x3/8	24	17	WWK5/16	Lock Washer
2	2	AA198RA508	Flow Control	25	2	017-018	Lever, Clutch Roller
3	2	AAC6DP-.5B	Cyl, Air, 1.06 B, .5 S	26	1	017-029	Lever, Cyl, Flip, Stkr
4	1	AAC6DP-2	Cyl, Air, 1.06 B, 2.0 S	27	1	017-036	Mount, Elec Eye
5	3	AAFBP-11C	Humphrey Bracket	28	1	017-037	Bracket, Elec Eye Mnt
6	3	AAFCT-11	Humphrey Clevis	29	1	017-038B	Sprocket, Mod, 15 Th
7	4	AAQME-5-8	Quick Male Elbow	30	3	017-041	Bracket Air Cylinder
8	4	BB6906	Bearing, Roller Flanged	31	1	017-046	Nut Plate
9	1	025-024	Sprocket, 8 Th, 3/8 B	32	1	025-001	Control Box Assembly
10	2	NNH1/4-20	1/4-20 Hex Nut	33	1	311-005	Mounting Brkt, Lower
11	14	NNK1/4-20	1/4-20 Kep Nut	34	1	025-006	Plate, R Side Frame
12	8	SSHC01032	Scr,Hx Cp 1/4-20x1/2	35	1	025-007	Plate, L Side Frame
13	4	SSHC01064	Scr,Hx Cp 1/4-20x1	36	1	025-008	Remote Potentiometer
14	5	SSHC01112	Scr,Hx Cp 1/4-20x1 3/4	37	1	025-015	Motor Mount
15	2	NNH1/2-13	Nut	38	1	025-020	Motor Guard
16	16	SSHC10032	Scr,Hx Cp 5/16-18x1/2	39	1	23218D	Motor Modification
17	3	SSHC10048	Scr,Hx Cp 5/16-18x3/4	40	2	MM503022LB	Caster
18	1	025-PD1	Pneumatic Diagram	41	2	51295A	Mount Isolator
19	4	SSPS90032	Scr,Pn Hd Sl 8-32x1/2	42	1	FF274-224	4 Pin Male Conn
20	18	WWFS1/4	SAE 1/4 Flat Washer	43	1	AA198-5102	Filter Regulator
21	1	025-WD4	Wiring Diagram	44	2	SSPP98032	Scr, Pn Hd Ph 10-32x1/2
22	19	WWF5/16	5/16 USS Washer	45	2	WWFS10	Flat Washer
23	7	WWF8	8 Flat Washer				


FOLD SOLENIOD
STACK SOLENIOD
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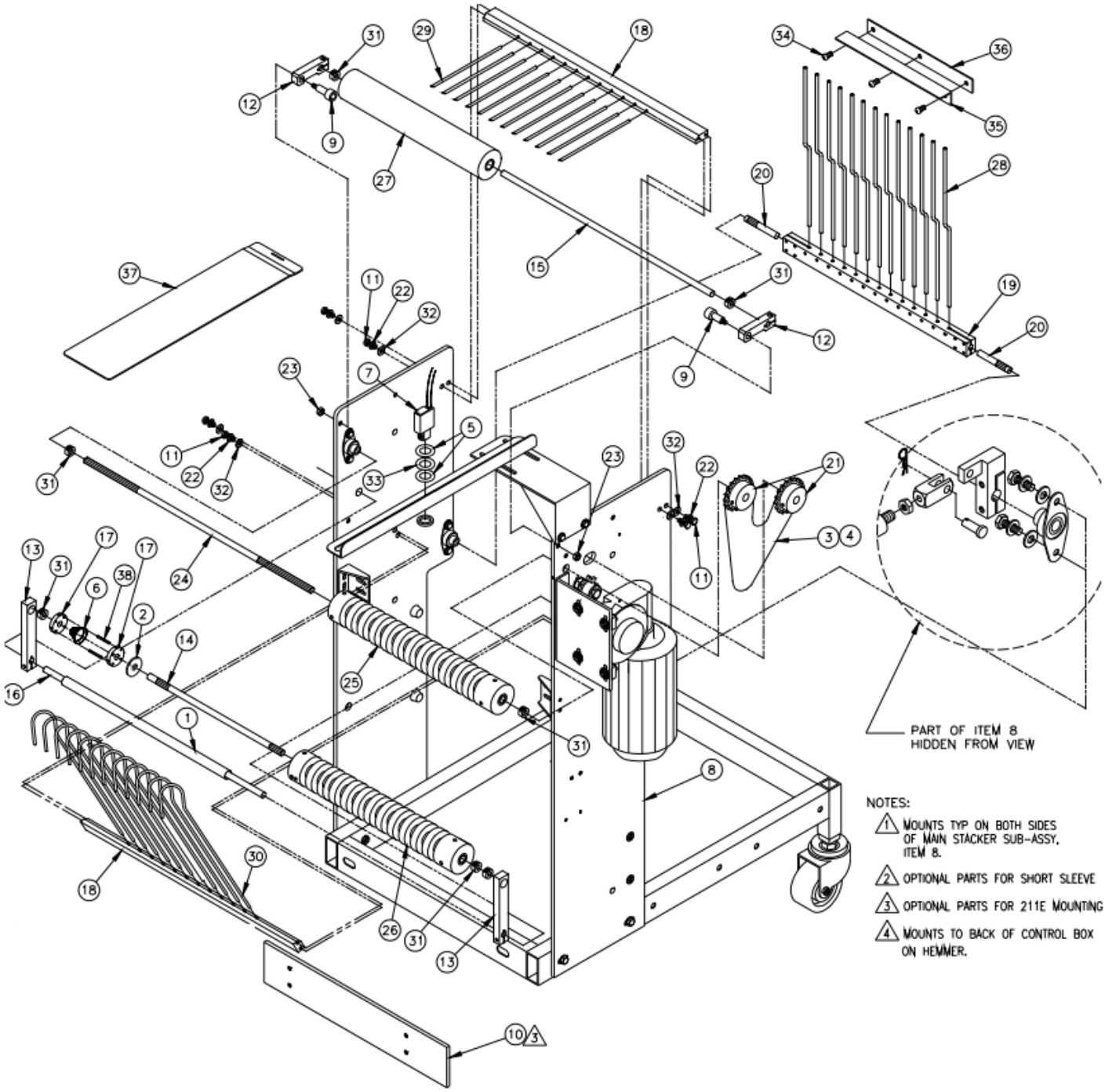
311-006C Fold in Half Stacker Assembly

AAC Drawing Number 190031D Rev 0

1	43	COVER, 4 x 4	K-234
1	42	BOX, ELECTRICAL	K-233
1	41	RECEPTACAL, 4 POLE	EET8966
1	40	PNEUMATIC DIAGRAM	025-PD1
1	39	WIRING DIAGRAM	025-WD4
2	38	SPRING PIN 1/8 X 1-1/8	IISO08X072
0	37	SLED EXTENSION	311-039
0	36	SHORT SLEEVE STOP MNT	311-041
0	35	SHORT SLEEVE STOP	311-040
0	34	SCREW, BUTTON CAP 10-32 x 1/2	SSBC98032
1	33	SPRING WASHER	WWSW3/4
6	32	WASHER	WWF1/4
7	31	COLLAR	CCCL6F
12	30	FINGER STRIPPER	025-017A
12	29	FINGER, SHELF	025-016
13	28	FINGER, FLIP STACKER	025-014
1	27	ROLLER, URETHANE	025-013A
1	26	ROLLER, CLUTCH DRIVE	025-011
1	25	ROLLER, MAIN DRIVE	025-010
1	24	AXLE, MAIN DRIVE	025-009
2	23	5/16-18 JAM NUT	NNJ5/16-18
6	22	WASHER LOCK	WWL1/4
2	21	SPROCKET, MOD.	017-039
2	20	AXLE, FLIP STACKER	017-032
1	19	MOUNT, FLIP STACKER	017-030
2	18	MOUNT, STRIPPER FING.	017-027
2	17	CLUTCH DISC	017-024
1	16	AXLE, PIVOT CLUTCH	017-023
1	15	AXLE, IDLER	017-022
1	14	AXLE, CLUTCH DRIVE	017-021
2	13	ARM, CLUTCH DRIVE	017-019
2	12	ARM, IDLER ROLLER	017-017
6	11	SCREW, HEX CAP 1/4-20 x 1/2	SSHC01032
1	10	DROP ADAPTOR	211-175 (3)
2	9	SCREW, ALLEN SHOULDER 5/8 X 3/4, 5/16-18	SSAS024048
1	8	MAIN STACKER SUB ASSY	311-006D
1	7	ELECTRIC EYE	FFSM312LV
1	6	SPRING	RRBEEHIVEM
2	5	SHIM	MM3088A434
1	4	CONNECTING LINK	MM35CL
1.5'	3	SINGLE STRAND CHAIN	MM35
1	2	THRUST WASHER	BBTRA613
14"	1	HEAT SHRINK	ZTH3/8
QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE

(4)

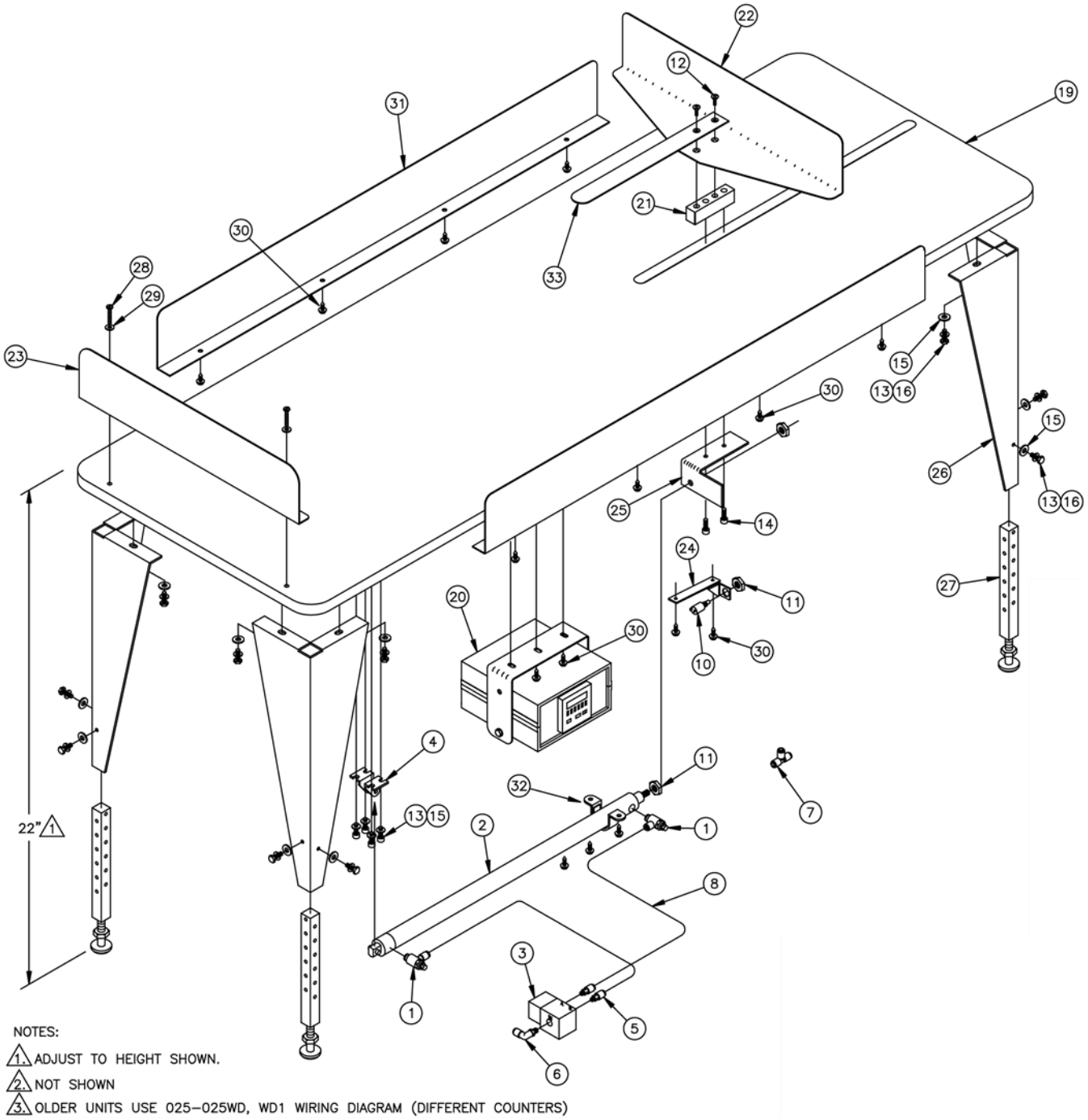
(2)


PART OF ITEM 8
HIDDEN FROM VIEW
NOTES:
1 MOUNTS TYP ON BOTH SIDES OF MAIN STACKER SUB-ASSY, ITEM 8.
2 OPTIONAL PARTS FOR SHORT SLEEVE
3 OPTIONAL PARTS FOR 211E MOUNTING
4 MOUNTS TO BACK OF CONTROL BOX ON HEMMER.

025-001 Control Box Assembly

AAC Drawing Number 190784C Rev 9

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	2	AAE45A24D	Air Solenoid Valve	19	1	W1061-1	Plate, On/Off
2	2	FF264-341	Dual Wago Terminal	20	1	AAVF51FM1B	Air Electric Switch
3	4	FF264-311	Single Wago Terminal	21	1	025-022	Nut Plate
4	1	FF264-371	End Cap	22	1	025-021	Guard, Platic Box
5	4	SSPP90032	Scr,Pn Ph 8-32x1/2	23	1	025-WD2	Wiring Diagram
6	1	EET8967	Plug, 4 Pole	24	2	MSLD-ECH	Bumper
7	1	FF274-234	4 Pin Female Conn	25	5	SSPPT90032	Scr,Pn Ph 8-32x1/2 st
8	1	AAQML-5-8	Quick Male Elbow, Long	26	1	AAQPR-8-5	Quick Plug Reducer
9	1	FF46F1864	Switch, Toggle, On/Off	27	4	SSPS80016	Scr,Pn Sl 6-32x1/4
10	1	FF89F957	Relay, 24VDC, 240AC	28	4	SSPS80064	Scr,Pn Sl 6-32x1.0
11	1	FFSPC56	Stand Off PC Mount	29	4	NNK6-32	Nut, Kep
12	1	FFTX24	Transformer, 24V, 2.4A	30	1	AAQSU-5-5	Quick St Union
13	1	MM40450010	Fastener, Latch Body	31	.5’	AATP4-3	Black Urethane Tube
14	1	025-WD4	Wiring Diagram	32	3	AAQME-5-8	Quick Male Elbow
15	9	TT1825	Female Quick Slide	33	2	AAQBY-5-8	Quick Branch Y
16	1	025-002	Logic Board	34	2	SSSC70024	Soc Cap Screw
17	1	025-023	Chassis, Control Box	35	1	FF3210	Strain Relief
18	3	K-235	Romax Connector				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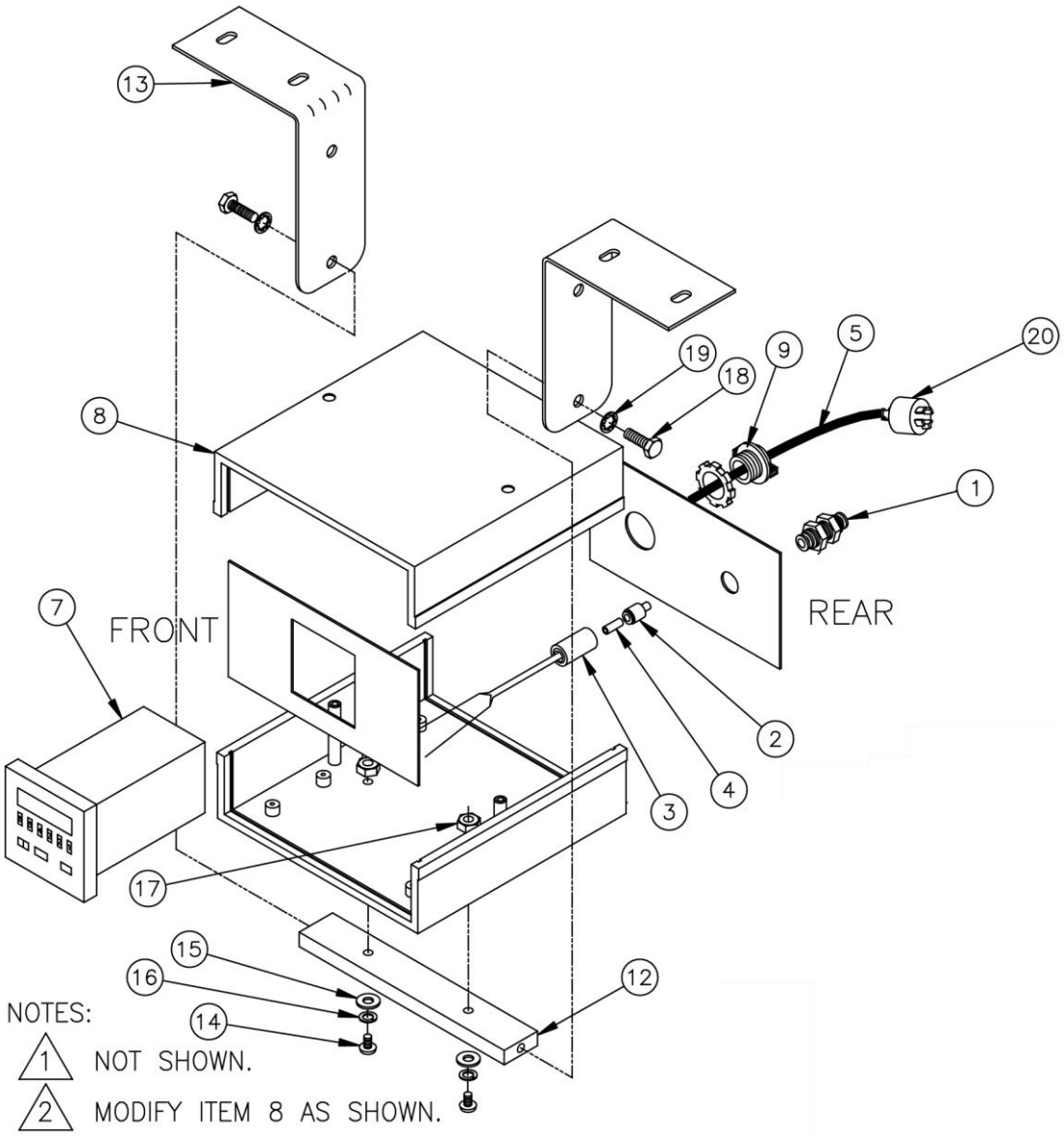
NOTES:
1. ADJUST TO HEIGHT SHOWN.
2. NOT SHOWN
3. OLDER UNITS USE 025–025WD, WD1 WIRING DIAGRAM (DIFFERENT COUNTERS)

025-025 Indexing Table for Fold in Half Stacker

AAC Drawing Number 191074C Rev 5

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	AA198RA408	Flow Control	18	1	025-025WD2	Wiring Diagram
2	1	AAC6DP-18	Air Cylinder	19	1	025-026	Table Top
3	1	AAE45A24A	Air Valve, 4 Way	20	1	025-027	Control Box Assembly
4	1	AAFFD-167	Pivot Bracket	21	1	025-028	Guide Block
5	2	AAQMC-4-8	Quick Male Conn	22	1	025-029	Material Pusher
6	1	AAQME-4-8	Quick Male Elbow	23	1	025-030	Material Stop
7	1	AAQUT-5-5	Quick Union T	24	1	1904-13	Button Valve Bracket
8	8’	AATP4-1	1/4" Airline	25	1	26196	Cylinder Mount Brkt
9	6’	AATP5/32	5/32" Airline	26	4	26197	Leg Mount
10	1	FF23F439	N.O. Switch	27	4	26238	Leg Assembly
11	3	NNJ5/16-24	5/16-24 Jam Nut	28	2	SSPS98064	Scr,Pn Sl 10-32x1.0
12	2	SSFC98032	Scr,Fl Al Cp 10-32x1/2	29	2	WWF10	Washer
13	20	SSHC01048	Scr,Hx Cp 1/4-20x3/4	30	15	SSZH#10032	Scr,Hx Sh Me #10x1/2
14	2	SSSC98032	Scr,So St 10-32x1/2	31	2	311-127	Edge Guide
15	20	WWFS1/4	Washer	32	2	MM2235	1 1/4 Strap
16	16	WWL1/4	Lock Washer	33	1	311-132	Material Guard
17	1	025-025PD	Pneumatic Diagram				

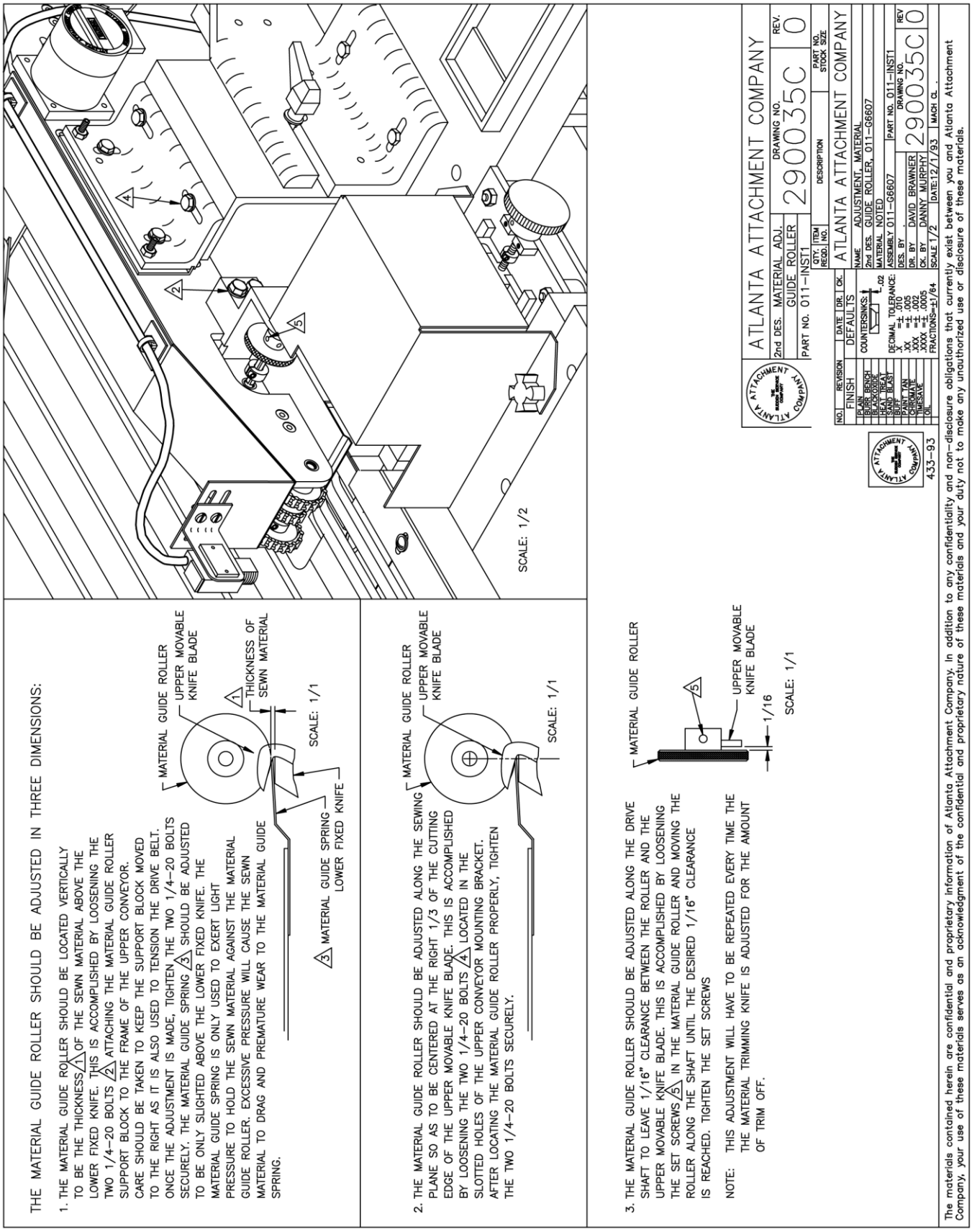


025-027 Control Box Assembly

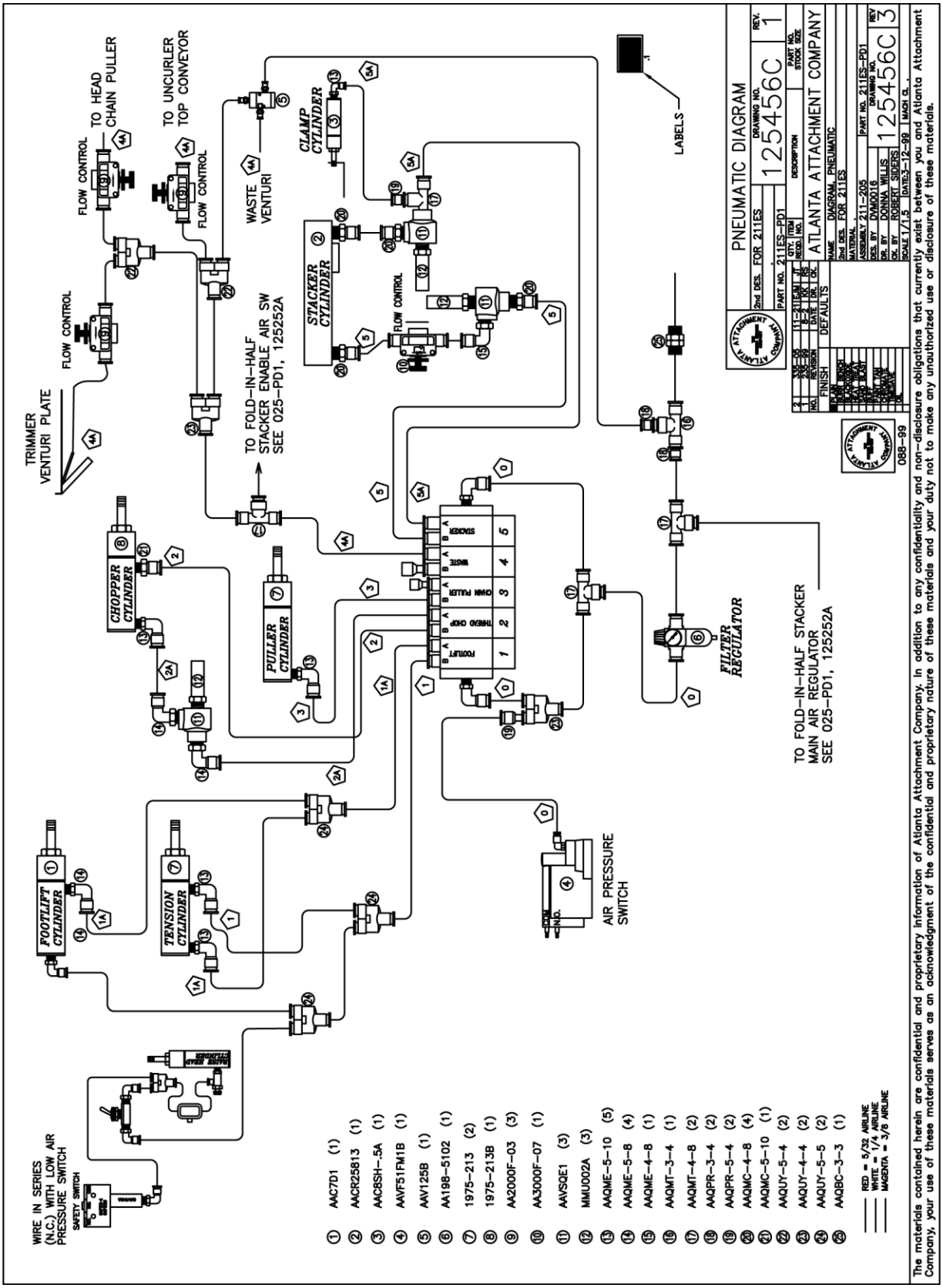
AAC Drawing Number 190367B Rev 4

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	AAQBU-5-5	Bulkhead Union	11	1	025-025PD	Pneumatic Diagram
2	1	AAQPR-8-5	Reducer	12	1	4000-08	Mounting Supp
3	1	AAE520301	Air Switch	13	1	4000-07	Mount
4	3 "	AATP4-3	1/8 Airline	14	2	SSPS98048	Scr,Pn Hd Sl 10-32x3/4
5	6’	EE18-3	Rub Coated Wire	15	2	WWFS10	Flat Washer
6	12’	EE8205	Wire	16	2	WWL10	Lock Washer
7	1	FF45610400	6 Digit Counter	17	2	NNH10-32	Hex Nut
8	1	4000-04	Plastic Box Mod	18	2	SSHC01032	Scr,Hx Cp 1/4-20x1/2
9	1	K-235	Romax Conn	19	2	WWSI1/4	Int Tooth Washer
10	1	025-025WD2	Wiring Diagram	20	1	EET8967	4 PolePlug

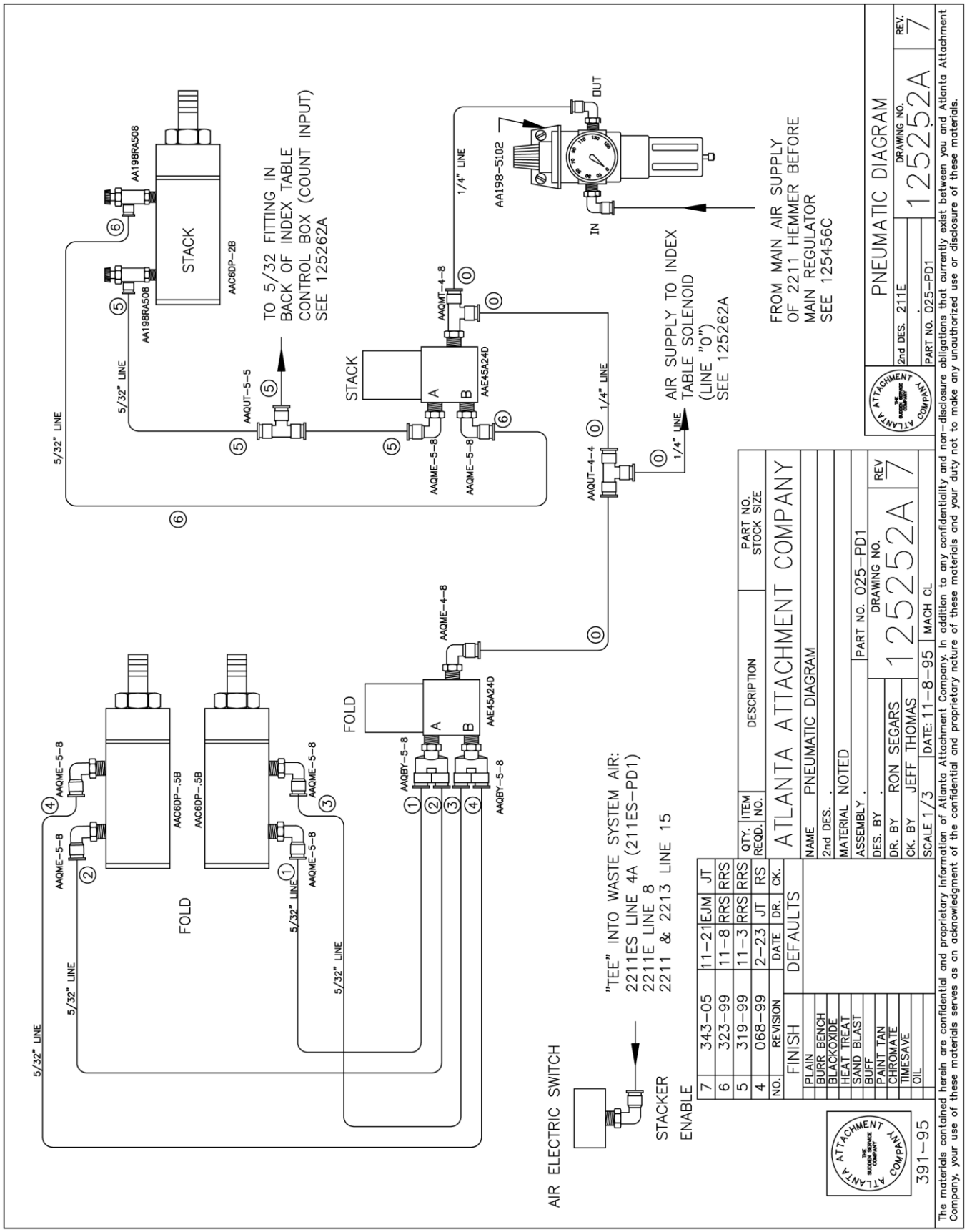
011-INST1 Material Adjustment



211ES-PD1 Pneumatic Diagram



025-PD1 Pneumatic Diagram

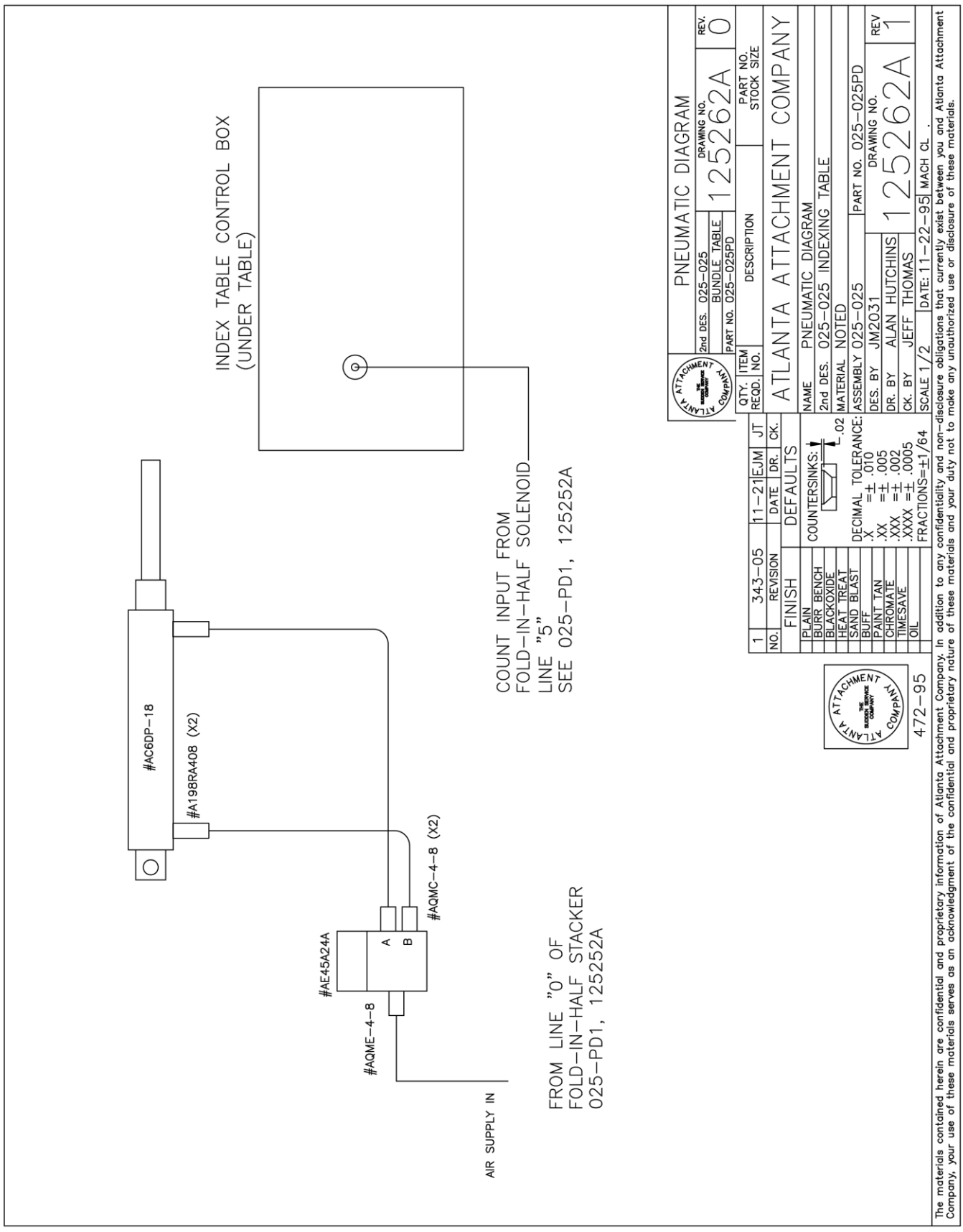


NO.	REVISION	DATE	DR.	CK.
7	343-05	11-21	EJM	JT
6	323-99	11-8	RRS	RRS
5	319-99	11-3	RRS	RRS
4	068-99	2-23	JT	RS

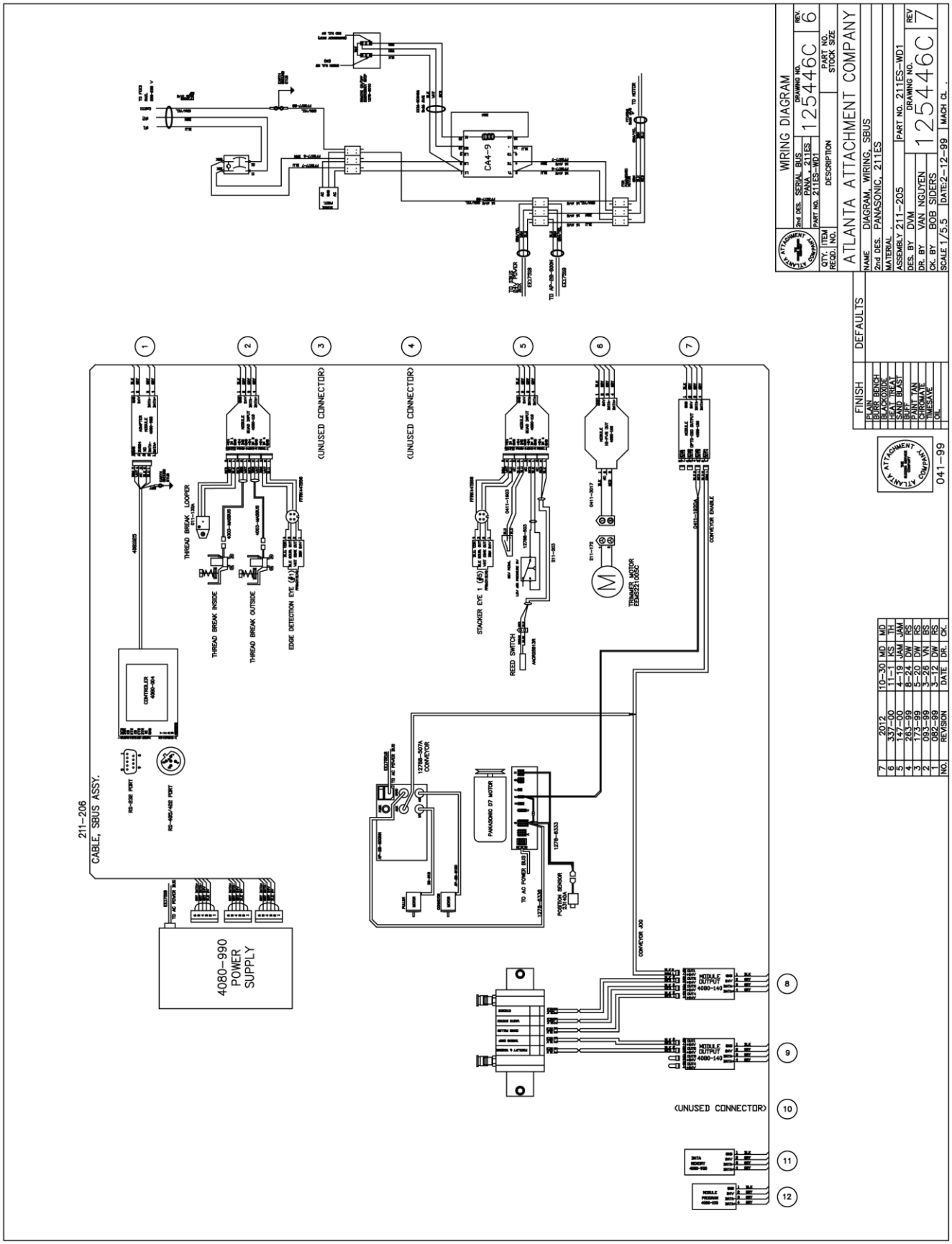
FINISH DEFAULTS
PLAIN
BURR BENCH
BLACKOXIDE
HEAT TREAT
SAND BLAST
BUFF
PAINT TAN
CHROMATE
TIMESAVE
OIL

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE

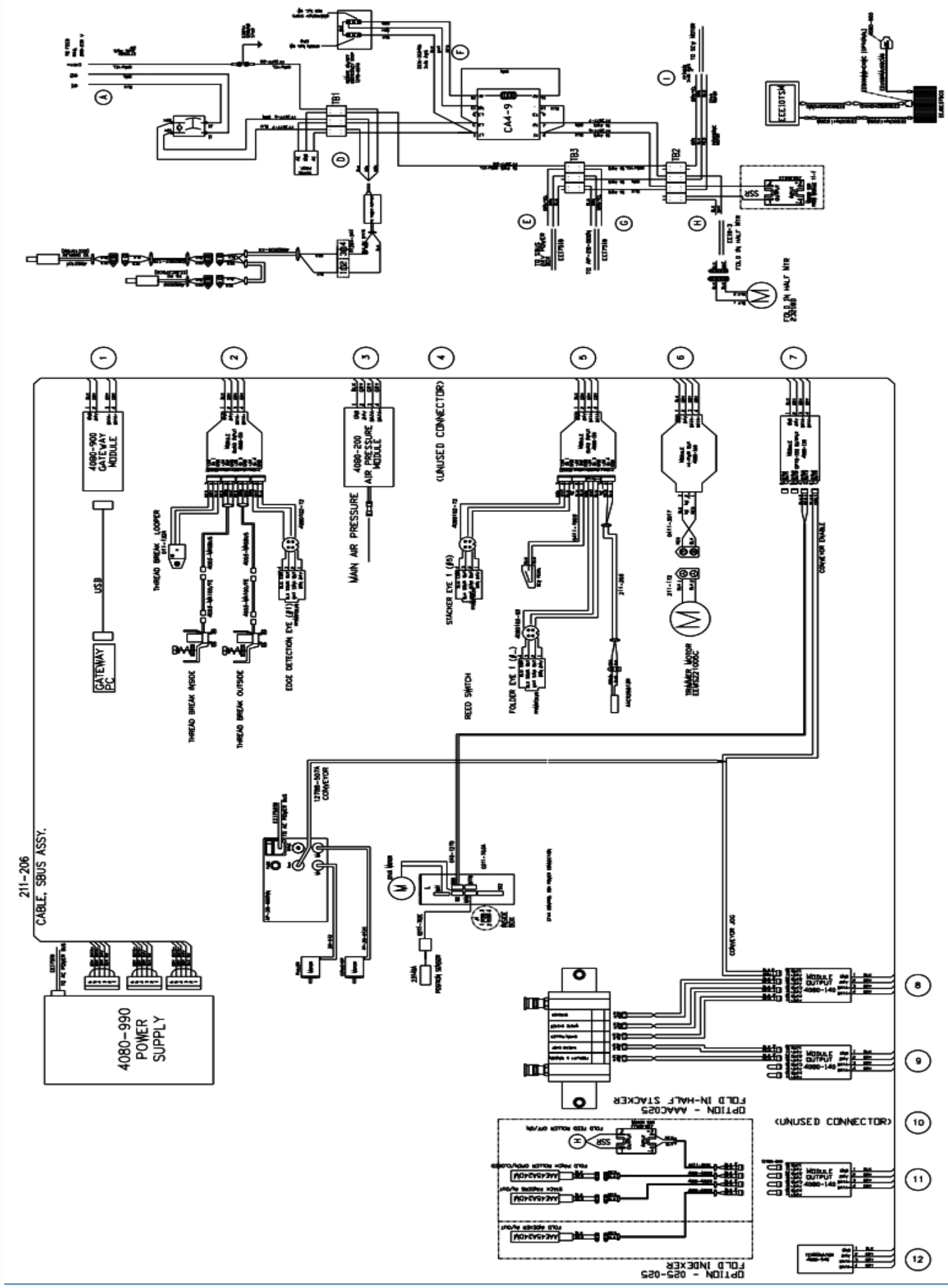
025-025PD Pneumatic Diagram



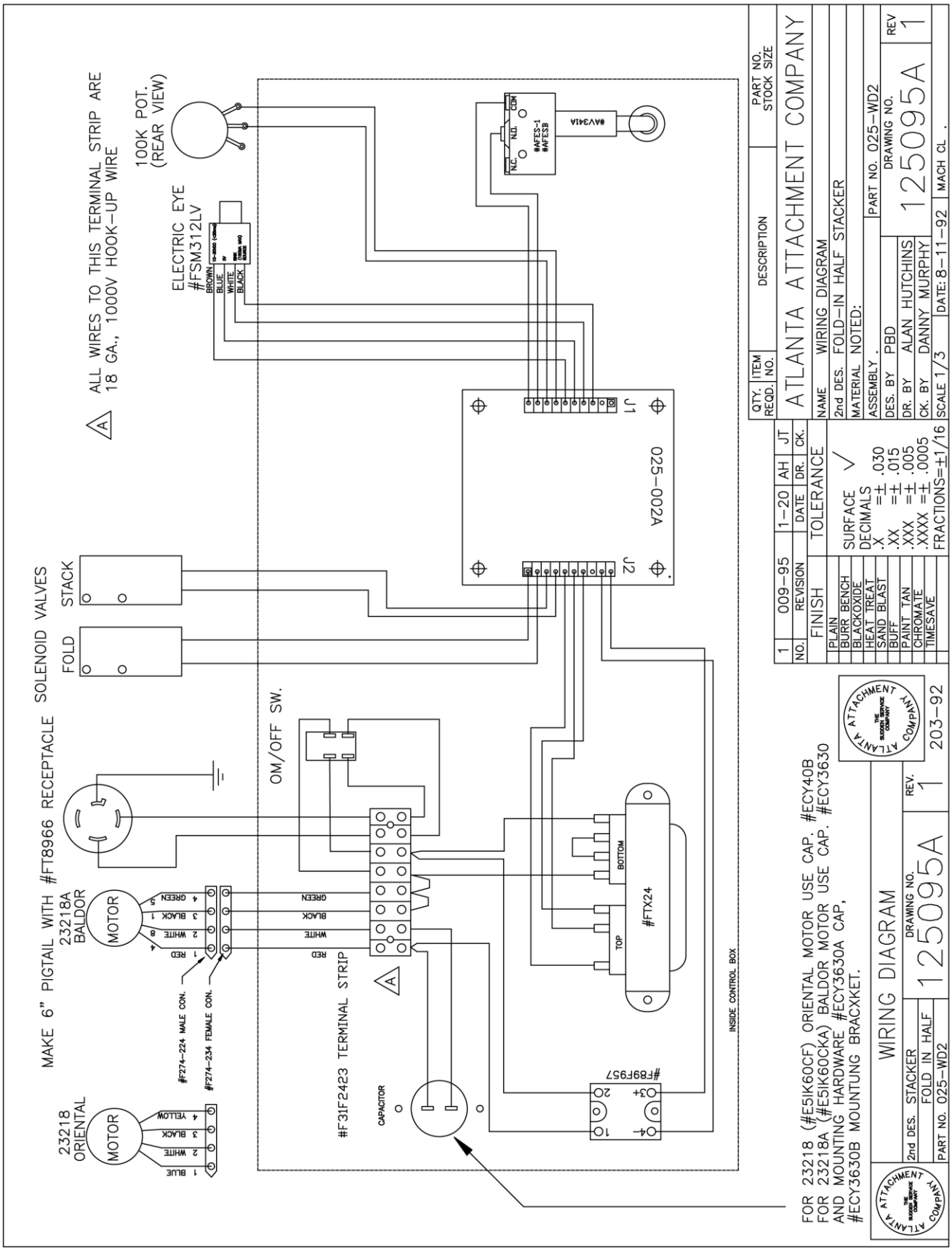
211ES-WD1 Wiring Diagram, SBUS



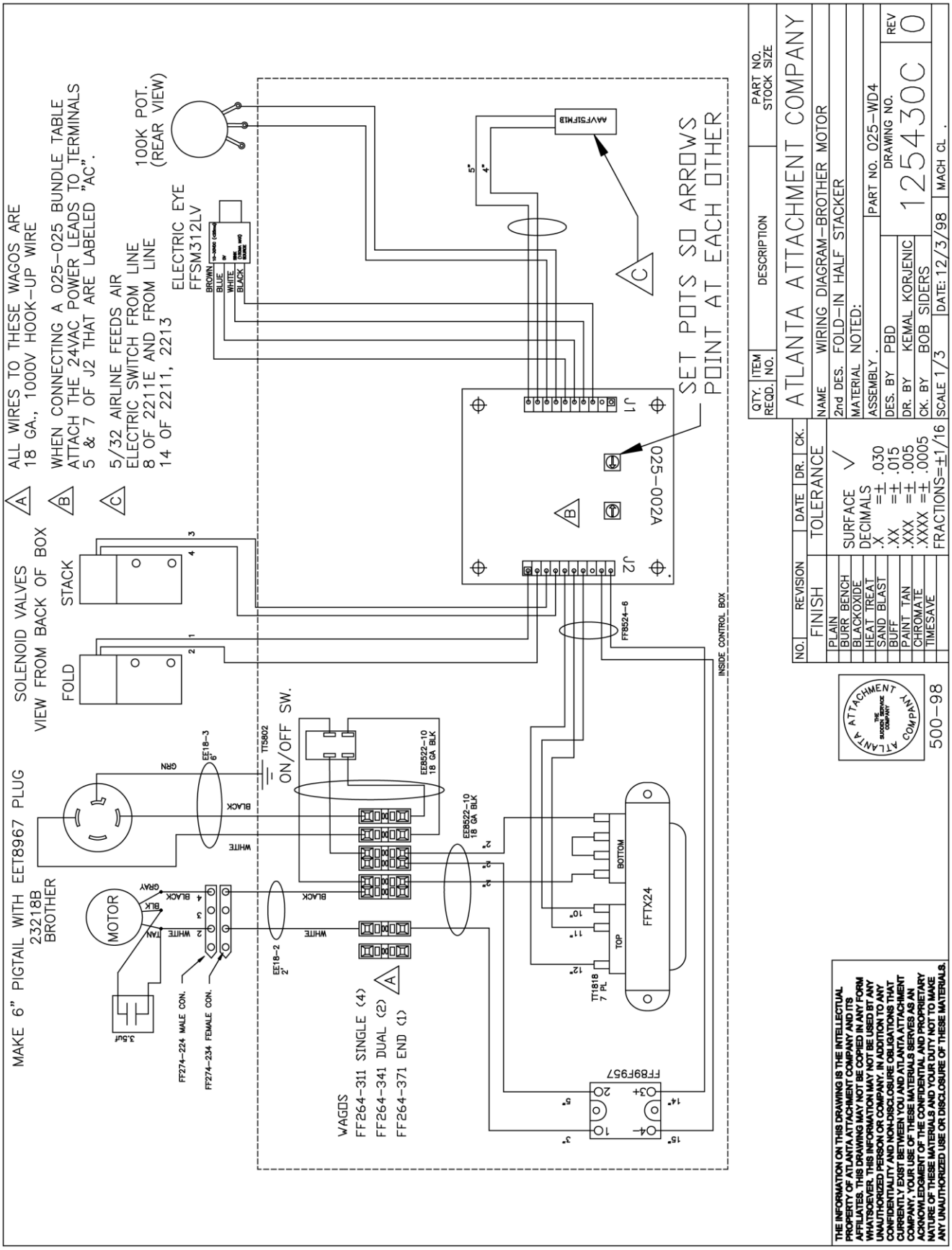
211ES-WD2 Wiring Diagram, SBUS



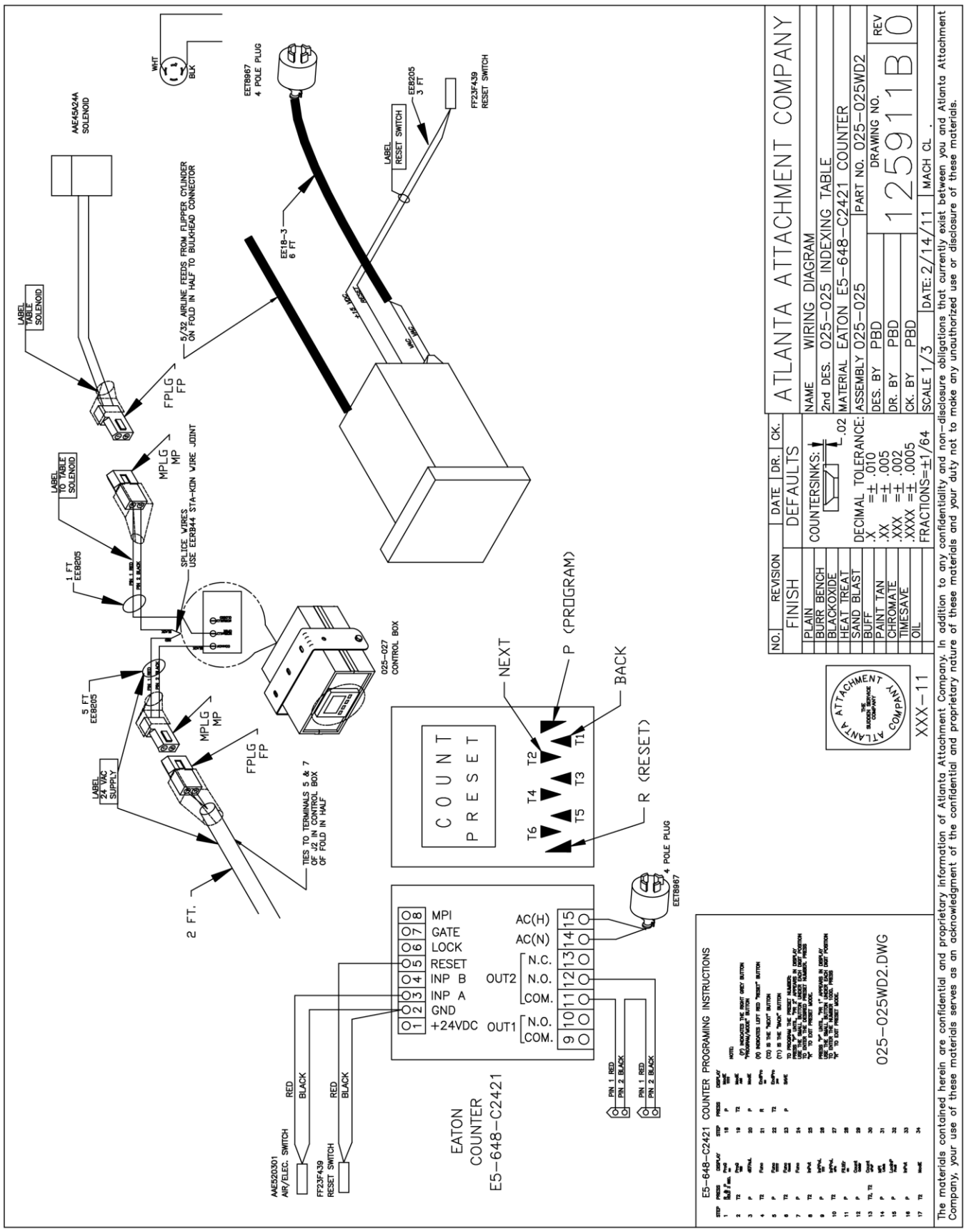
025-WD2 Wiring Diagram



025-WD4 Wiring Diagram



025-025WD2 Wiring Diagram

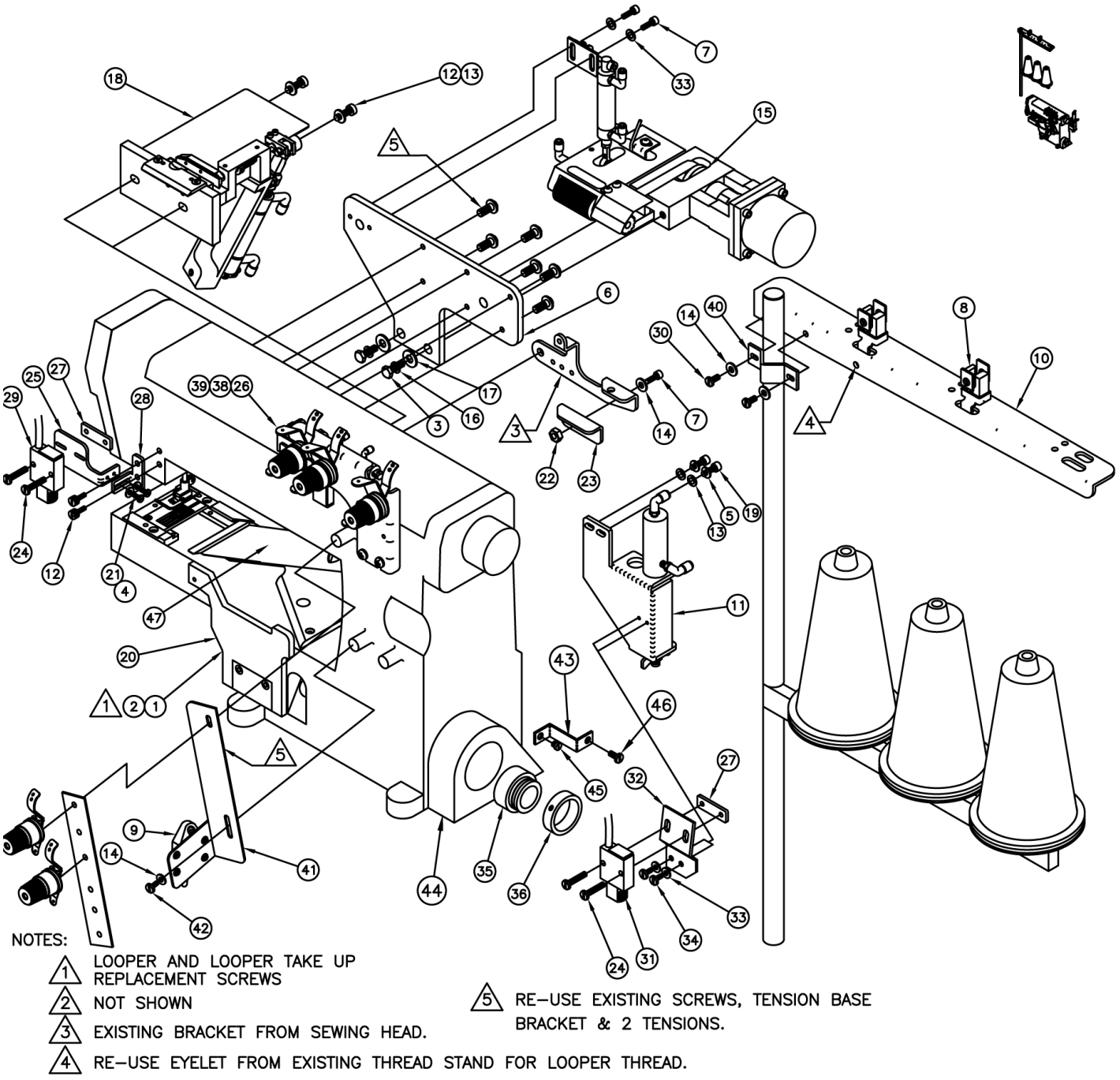


Sewing Head Details

for
2211ES Two Needle Hemmer

Gauge Parts

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


NOTES:
1 LOOPER AND LOOPER TAKE UP REPLACEMENT SCREWS
2 NOT SHOWN
3 EXISTING BRACKET FROM SEWING HEAD.
4 RE-USE EYELET FROM EXISTING THREAD STAND FOR LOOPER THREAD.
5 RE-USE EXISTING SCREWS, TENSION BASE BRACKET & 2 TENSIONS.

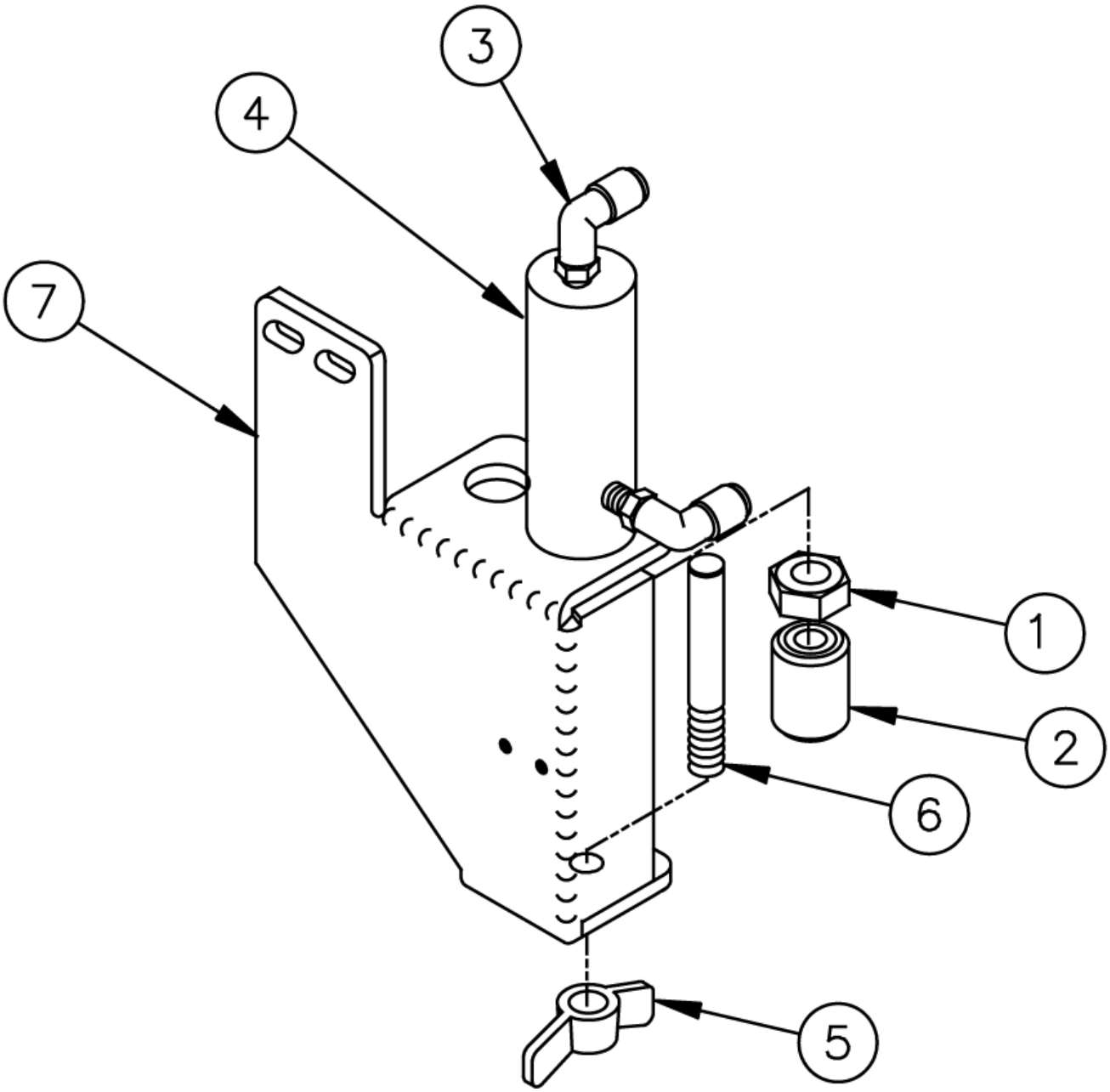
211-127B Sewing Head Assembly

AAC Drawing Number 192063C Rev 7

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	SSM7145	SEWING MACHINE SCREW	25	1	211-153	EYE MOUNT, FRONT
2	2	SSSS98008	SCREW, SOCKET SET 10-32 X 1/8	26	1	3101760	THREAD KIT
3	2	SSHC10064	SCREW, HEX CAP 5/16-18 X 1.0	27	2	1975-412A	NUT PLATE
4	2	WWB6S	WASHER, FLAT	28	1	211-154	EYE BRKT, REAR
5	2	WWL1/4	LOCK WASHER	29	1	FFSM312LVQ	ELECTRIC EYE
6	1	011-080	PULLER ASSY MOUNT	30	2	SSPS98048	SCREW,PAN HD SLOTTED 10-32 X 3/4
7	3	SSSC98024	SCREW, SOCKET CAP 10-32 X 3/8	31	1	23140A	ELECTRIC EYE
8	2	4003-IS3WT2	SENSOR	32	1	311-119	MOUNTING BRACKET
9	1	011-132A	THREAD STOP	33	4	WWF8	FLAT WASHER
10	1	0411-069C	BRKT, THREAD BRK	34	2	SSPS90024	SCREW, PAN HD SLOTTED 8-32 X 3/8
11	1	211-122D	FOOT LIFT SUB-ASY	35	1	311-128	TAPE MOUNTING
12	4	SSCM6X10	SCREW, CHEESE HEAD M6 X 10MM	36	1	311-129	TAPE MOUNTING
13	4	WWFS1/4	1/4 WASHER	37	1	1278-6333	CABLE, POSITION SENSOR
14	4	WWF10	WASHER, FLAT	38	1	3101760C	POST
15	1	2213009	CHAIN PULLER	39	1	311-126	MOUNT
16	2	WWL5/16	WASHER, LOCK	40	1	0411-070	CLAMP, SENSOR BRKT
17	2	WWFS5/16	WASHER, FLAT	41	1	0411-3554	BRKT, THREAD STOP
18	1	211-129A	CHAIN TRIMMER	42	1	SSPSM4X8	SCREW, PAN HD SLOTTED M4-.07 X 8
19	2	SSSCM6X16	SCREW, METRIC, SOCKET CAP M6 X 16MM	43	AR	0411-1051	YAM GUARD BRKT
20	1	011-102A	LOOPER COVER, MODIFIED	44	AR	0411-1052	YAM GUARD MOD
21	2	SSPS80016	SCREW, PAN SLOTTED 6-32 X 1/4	45	AR	SSCM6X10	SCREW, CHEESE HEAD M6 X 10
22	1	NNH10-32	NUT, HEX	46	AR	SSPS98024	SCREW, PAN SLOTTED 10-32 X 3/8
23	1	211-161B1	FOOTLIFT BRACKET	47	1	211-067A	COVER,LOOPER
24	4	FOOTLIFT BRACKET	SCREW, PAN SLOTTED 4-40 X 3/4	48			

Gauge Parts, Yamato

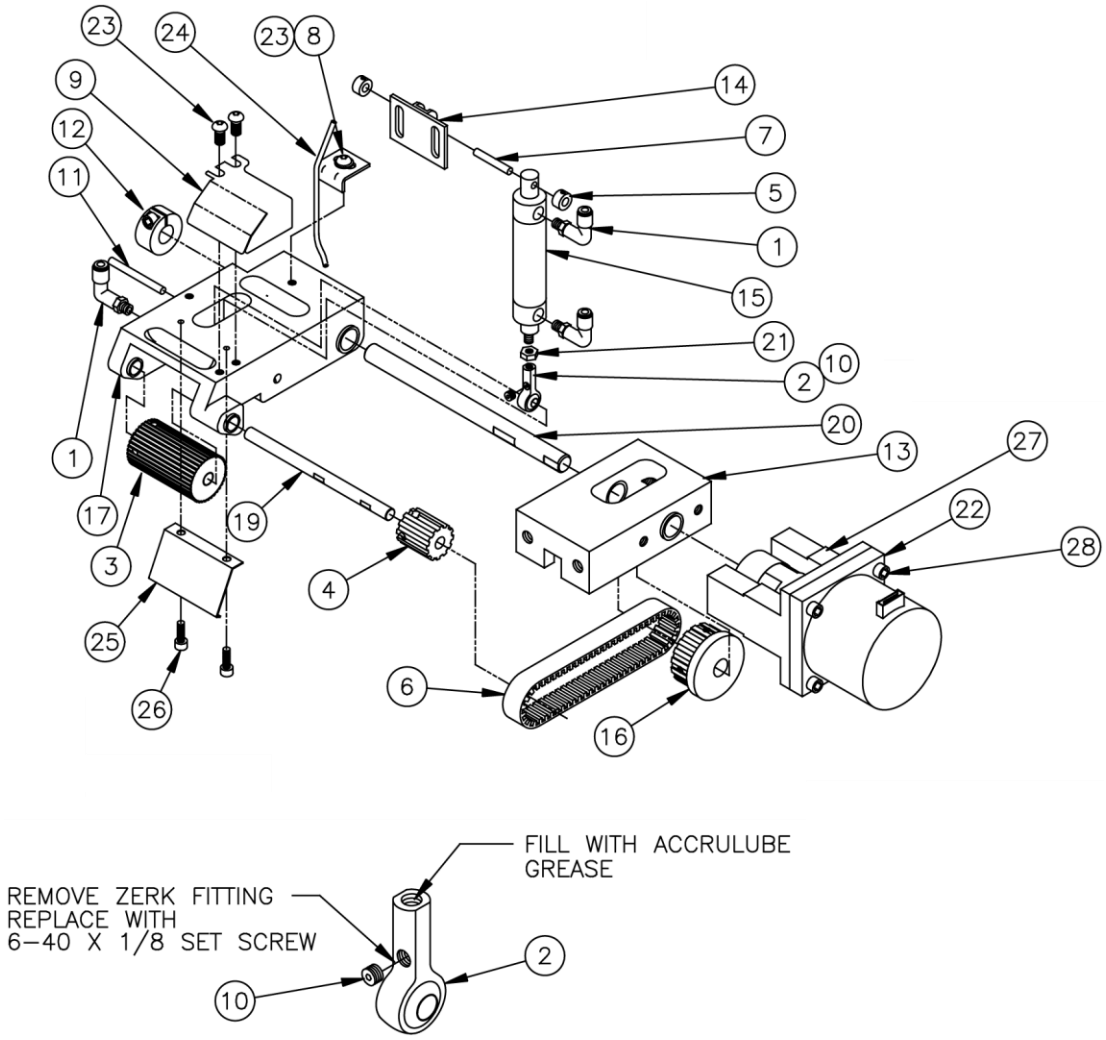
211Y48	Gauge Set For Yamato 4.8mm
0094800M	Needle Plate, Yamato 4.8mm
3107050M	Modified Foot, Yamato 4.8mm
3109001M	Feed Dog Modified, Yamato 4.8mm, 5.6mm
211Y56	Gauge Set For Yamato 5.6mm
0094801M	Needle Plate, Yamato 5.6mm
0064041M	Modified Foot, Yamato 5.6mm
3109001M	Feed Dog Modified, Yamato 4.8mm, 5.6mm
211Y64	Gauge Set For Yamato 6.4mm
0094802M	Needle Plate, Yamato 6.4mm
0064042M	Modified Foot, Yamato 6.4mm
3109003M	Feed Dog Modified, Yamato 6.4mm



211-122D Footlift Sub-Assembly

AAC Drawing Number 192003B Rev 0

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	NNJ1/4-28	Jam Nut	5	1	NNW3/8-24	Wing Nut
2	1	11200	Bumper	6	1	SSSC35192M	Scr, Post 3/8-24x3.0
3	2	AAQME-5-8	Quick Male Elbow	7	1	211-161B	Footlift Bracket
4	1	AAC7D-1	Cylinder				



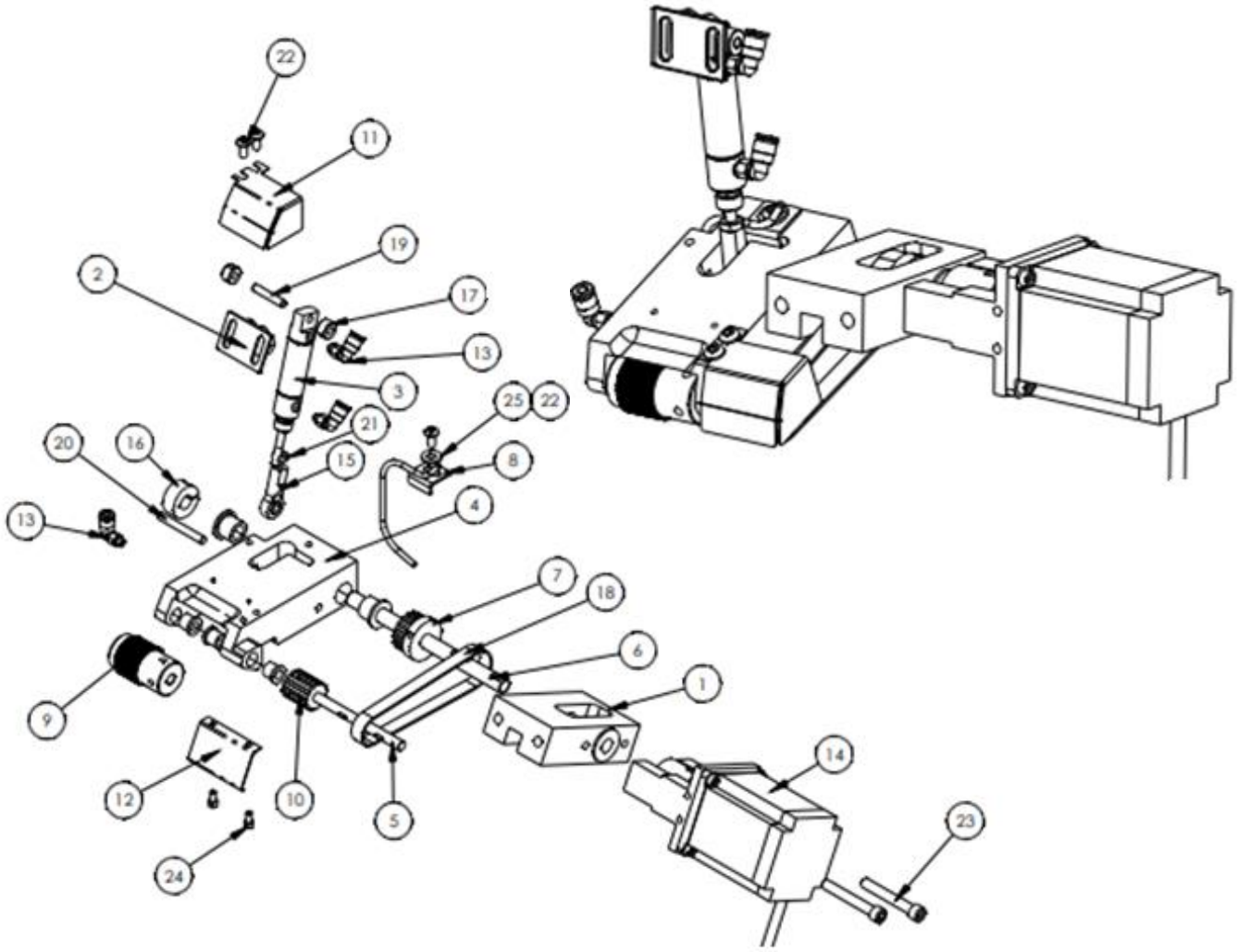
311-3000C Chain Puller Assembly

AAC Drawing Number 191023B Rev 6

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	3	AAQME-5-10	Quick Male Elbow	15	1	1975-213	Air Cylinder
2	1	BBAW-3Z	Rod End	16	1	311-3004A	Pulley, 16 Tooth
3	1	311-3010	Chain Puller Roller	17	1	311-3001C	Puller Arm
4	1	311-3011	Pulley, 1/5P, 12T	18	1	0411-INS1	Grounding Inst.
5	2	CCSC33/16	3/16 Set Collar	19	1	311-3002B	Axle, Puller
6	1	GG100XL037	Gear Belt	20	1	311-3003A	Puller Drive Axle
7	1	IID012X064	Dowel Pin	21	1	NNH10-32	Hex Hut
8	1	WWFS10	Flat Washer	22	1	AP-22E-105	Drive Motor
9	1	311-3012	Belt Guard	23	3	SSBC98024	Scr, Btn Cp 10-32x3/8
10	1	SSSS85008	Scr,Skt,Set,Knurl	24	AR	311-3009	Hem Blow Tube
11	1	IID012X096	Dowel Pin	25	1	311-3013	Cutter Guard
12	1	CCCL6F	Split Collar	26	1	SSC80016	Scr, So Set 6-32x1/4
13	1	011-069B	Step Motor Mount	27	2	SSSC01112	Socket Cap Screw
14	1	011-070	Plate, Air Cyl Mt	28	4	SSSC90032	Socket Cap Screw

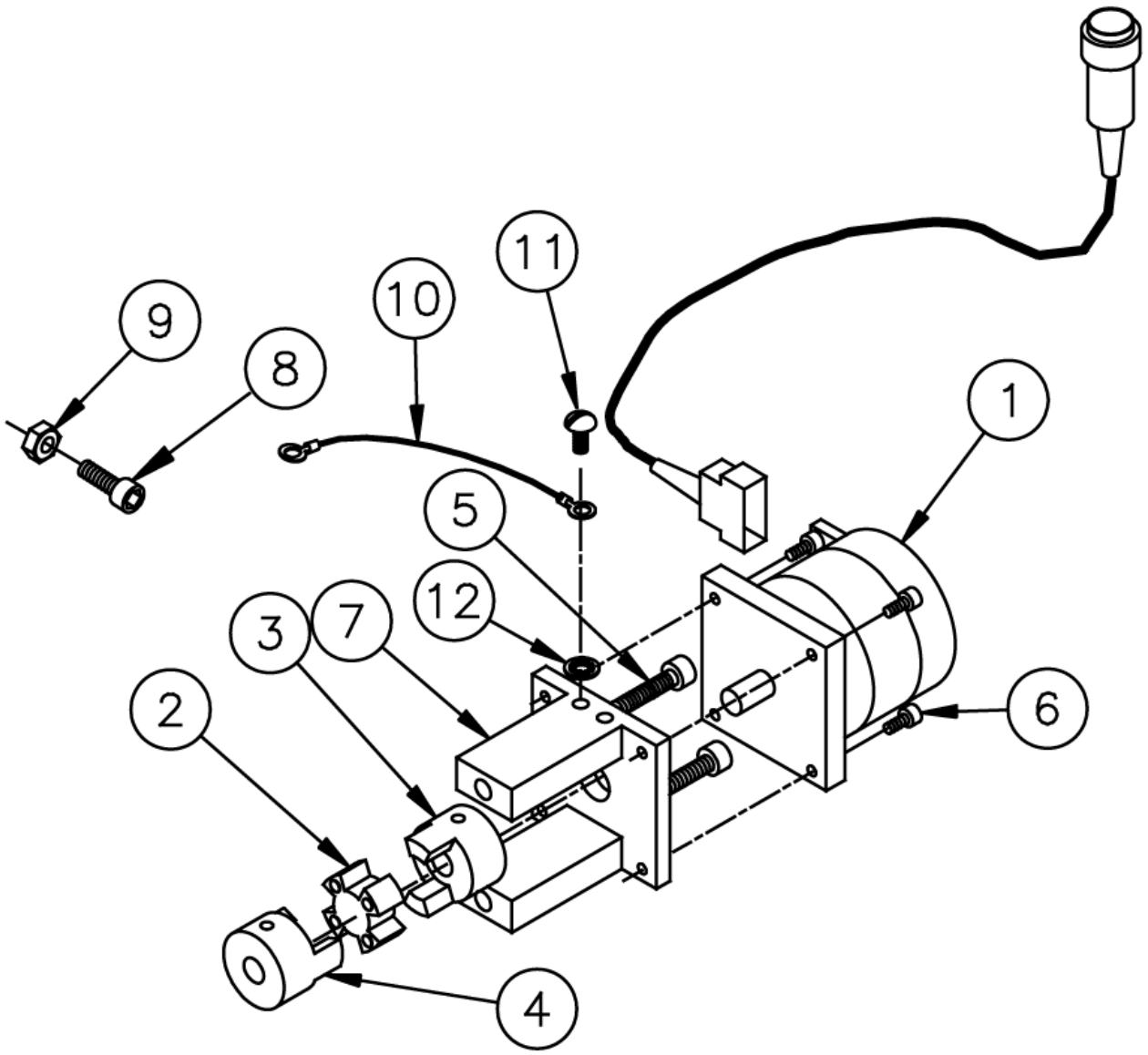
2213009 Chain Puller Assembly

AAC Drawing Number 2213009 Rev 0



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	011-069B	MOUNT, STEPPING MOTOR
2	1	011-070	PLATE,CYLINDER MOUNT
3	1	1975-213	CYLINDER, AIR, DA, 9/16B, 1/2S
4	1	311-3001C	ARM, PULLER PIVOT
5	1	311-3002B	AXLE, LOWER, CHAIN PULLER
6	1	311-3003A	AXLE, UPPER, CHAIN PULLER
7	1	311-3004A	PULLEY,GEAR,1/5 PITCH,16T
8	1	311-3009	MOUNT HEM BLOW DOWN TUBE
9	1	311-3010B	ROLLER, NARROW CHAIN PULLER
10	1	311-3011	PULLEY,1/5 PITCH, 12 TOOT
11	1	311-3012	GUARD, BELT CHAIN PULLER
12	1	311-3013	GUARD, CUTTER
13	3	AAQME-5-10	AIR ELBOW, 10-32 X 5/32

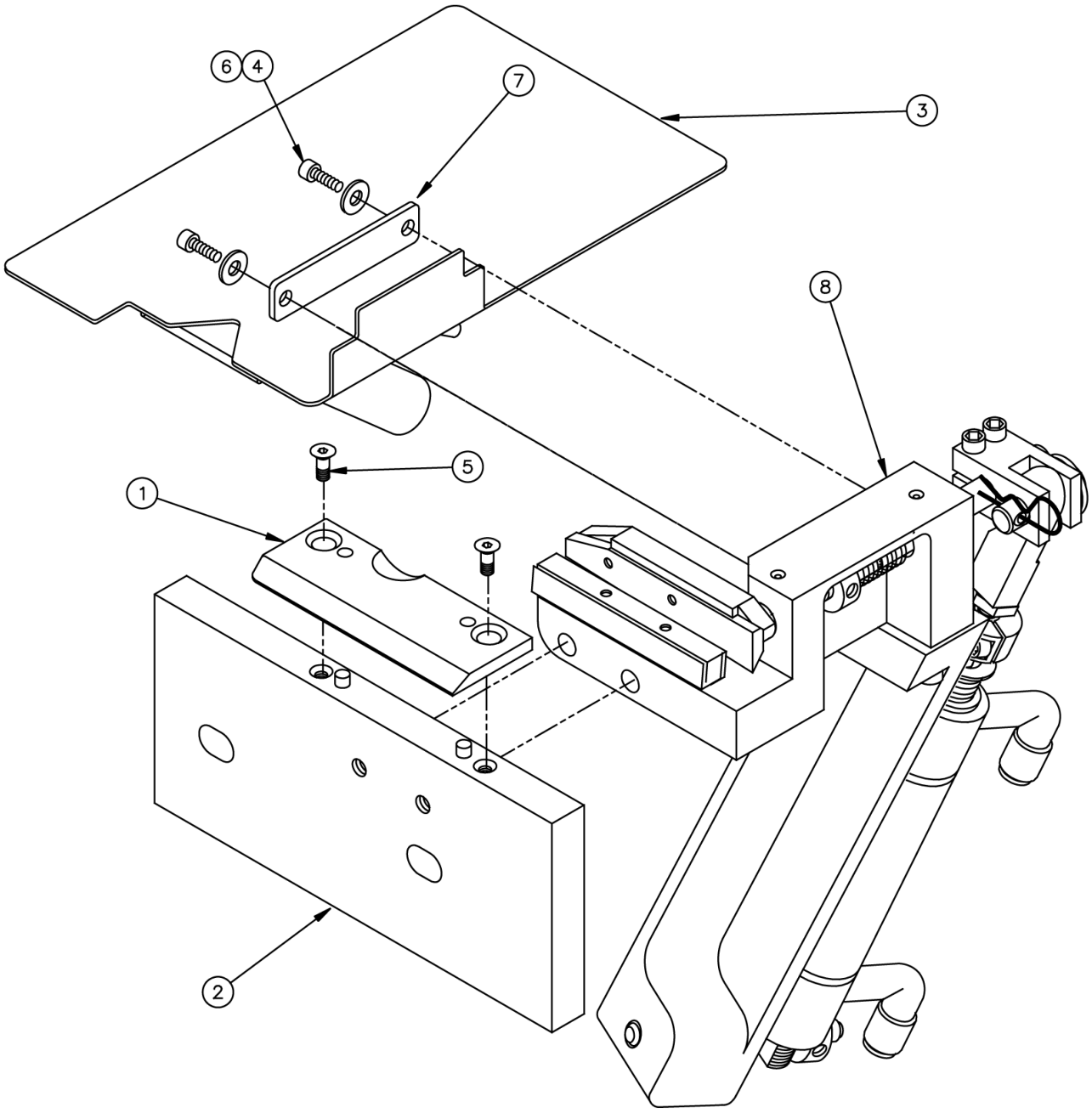
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
14	1	AP-22E-105	DRIVE MOTOR ASSY, 2A
15	1	BBAW-3Z	BRG,ROD END,F, 10-32
16	1	CCCL6F	CLAMP COLLAR- 3/8
17	2	CCSC33/16	COLLAR,SET,3/16"
18	1	GG100XL037	BELT,GEAR,1/5P,3/8W
19	1	IID012X064	DOWEL PIN,3/16 X 1
20	1	IID012X096	DOWEL PIN,3/16 X 1-1/2
21	1	NNH10-32	HEX-NUT 10-32 REG.
22	3	SSBC98024	10-32 X 3/8 BUTTON CAP SC
23	2	SSSC01112	1/4-20 X 1-3/4 SOC CAP
24	2	SSSC80016	6-32 X 1/4 SOC CAP SC
25	1	WWFS10	WASHER, FLAT, #10, SAE



AP-22E-105 Drive Motor Assembly

AAC Drawing Number 190170B Rev 3

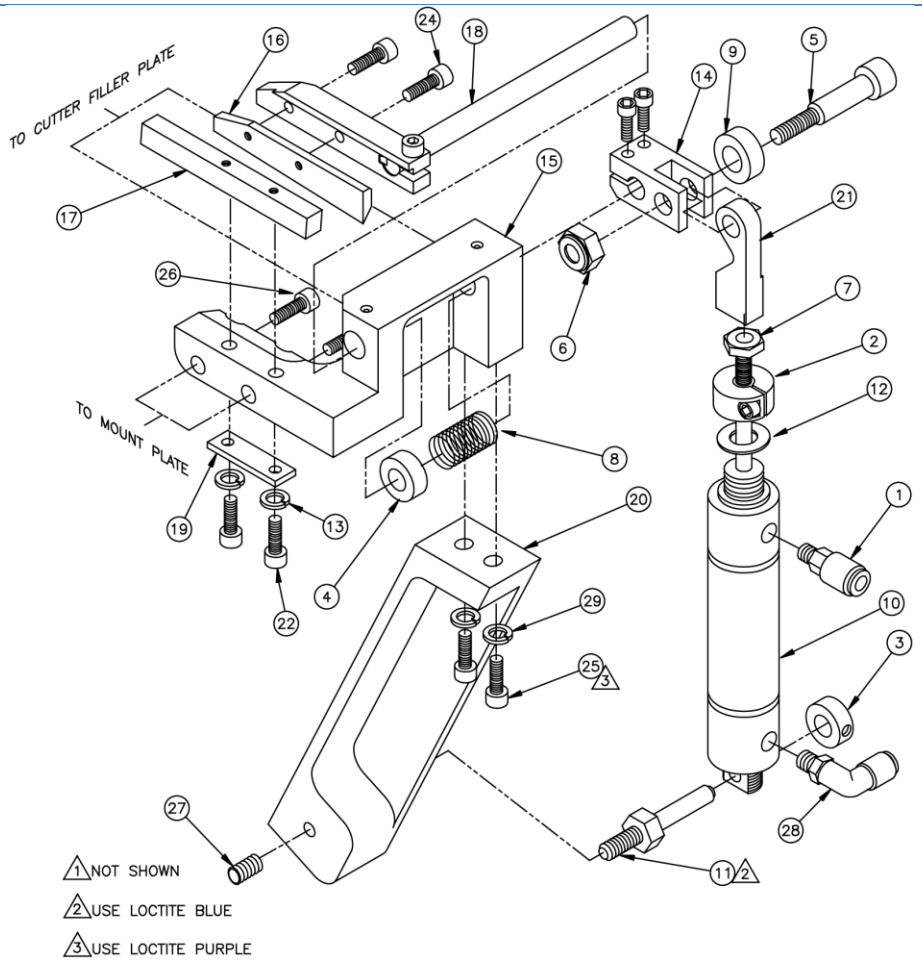
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	AP-22E-103	Step Motor	7	1	AP-22E-101	Bracket. Motor Adaptor
2	1	MML050	Spider	8	1	SSSC90048	Scr, Socket Cap, 8-32x3/4
3	1	MML050-250	Coupling Body	9	1	NNH8-32	#8 Nut
4	1	MML050-375	Coupling Body	10	1	28128A	Ground Strap
5	2	SSSC01128	Scr, Socket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



211-129A Chain Trimmer

AAC Drawing Number 192064C Rev 0

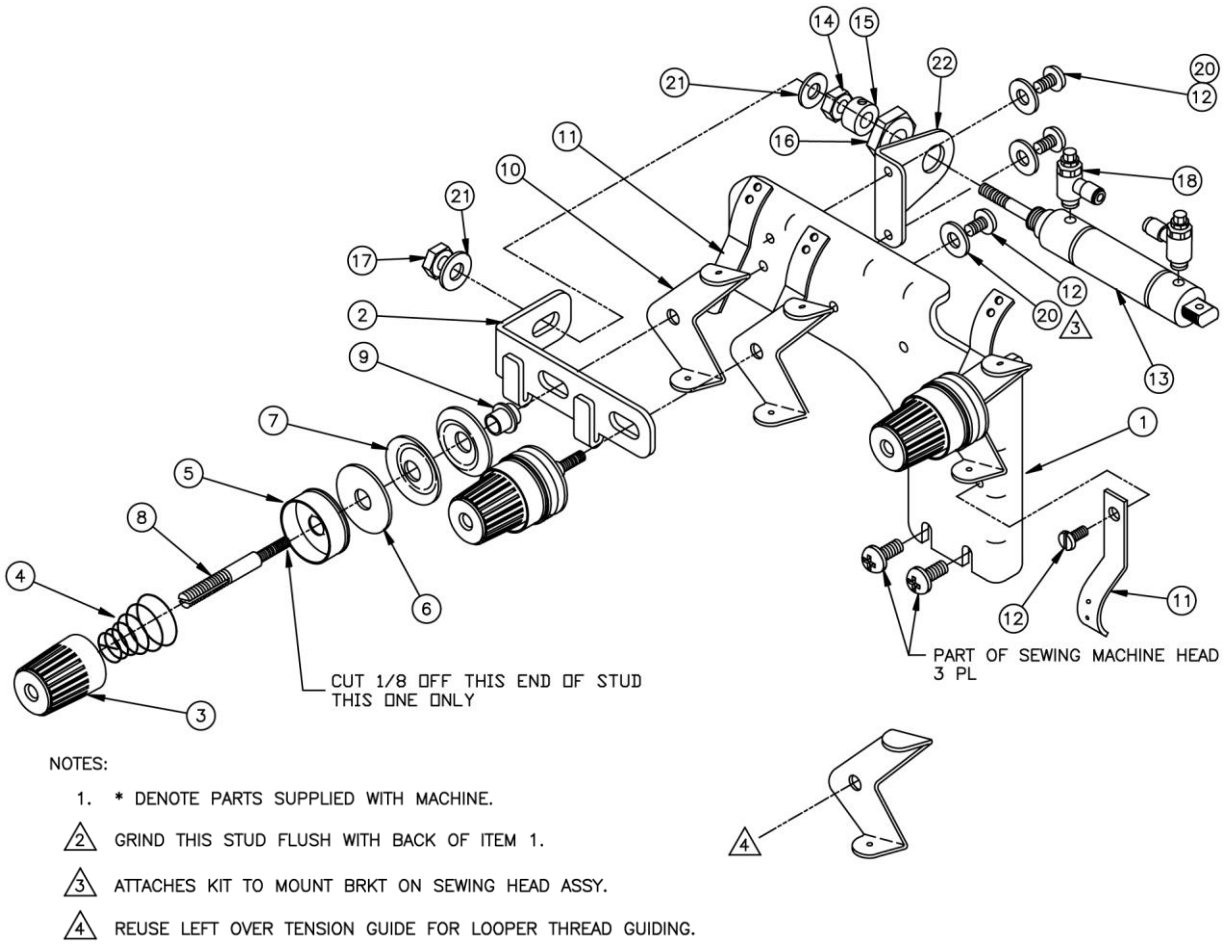
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	311-2002A	Pressure Plate	5	2	SSFC80024	Scr,Fl Al 6-32x3/8
2	1	311-2009F	Plate, Mount	6	2	WWB6S	Washer, Brass
3	1	311-2001A	Venturi Pl. Trimmer	7	1	311-20016	Washer Plate
4	2	SSSC70016	Scr,So Cp 4-40x1/4	8	1	311-2017	Thread Trim Assembly



311-2017 Thread Trim Assembly

AAC Drawing Number 191337C Rev 13

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

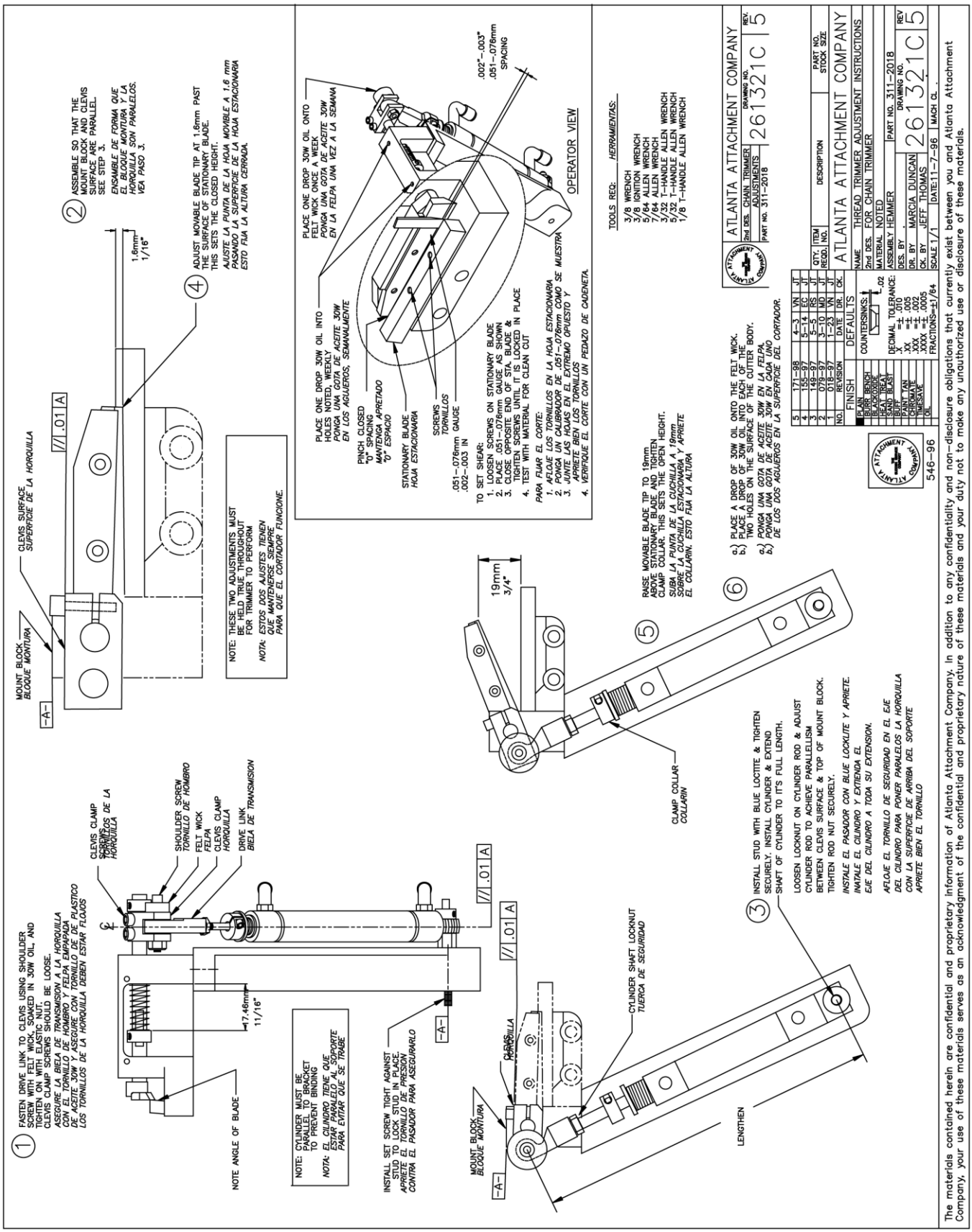


3101760 Thread Handling Assembly

AAC Drawing Number 290600C Rev 8

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

311-2018 Thread Trimmer Adjustment Instructions



Notes

Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

Atlanta Attachment Company warrants manufactured products to be free from defects in material and workmanship for a period of eight hundred (800) hours of operation or one hundred (100) days whichever comes first. Atlanta Attachment Company warrants all electrical components of the Serial Bus System to be free from defects in material or workmanship for a period of thirty six (36) months.

Terms and Conditions:

- AAC Limited Warranty becomes effective on the date of shipment.
- AAC Warranty claims may be made by telephone, letter, fax or e-mail. All verbal claims must be confirmed in writing.
- AAC reserves the right to require the return of all claimed defective parts with a completed warranty claim form.
- AAC will, at its option, repair or replace the defective machine and parts upon return to AAC.
- AAC reserves the right to make the final decision on all warranty coverage questions.
- AAC warranty periods as stated are for eight hundred (800) hours or one hundred (100) days whichever comes first.
- AAC guarantees satisfactory operation of the machines on the basis of generally accepted industry standards, contingent upon proper application, installation and maintenance.
- AAC Limited Warranty may not be changed or modified and is not subject to any other warranty expressed or implied by any other agent, dealer, or distributor unless approved in writing by AAC in advance of any claim being filed.

What Is Covered

- Electrical components that are not included within the Serial Bus System that fail due to defects in material or workmanship, which are manufactured by AAC are covered for a period of eight hundred (800) hours.
- Mechanical parts or components that fail due to defects in material or workmanship, which are manufactured by AAC.
- Purchased items (sewing heads, motors, etc.) will be covered by the manufacturers (OEM) warranty.
- AAC will assist in the procurement and handling of the manufacturers (OEM) claim.

What Is Not Covered

- Parts that fail due to improper usage, lack of proper maintenance, lubrication and/or modification.
- Damages caused by; improper freight handling, accidents, fire and issues resulting from unauthorized service and/or personnel, improper electrical, plumbing connections.
- Normal wear of machine and parts such as Conveyor belts, "O" rings, gauge parts, cutters, needles, etc.
- Machine adjustments related to sewing applications and/or general machine operation.
- Charges for field service.
- Loss of time, potential revenue, and/or profits.
- Personal injury and/or property damage resulting from the operation of this equipment.

Declaración de Garantía

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libres de defectos de 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.

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