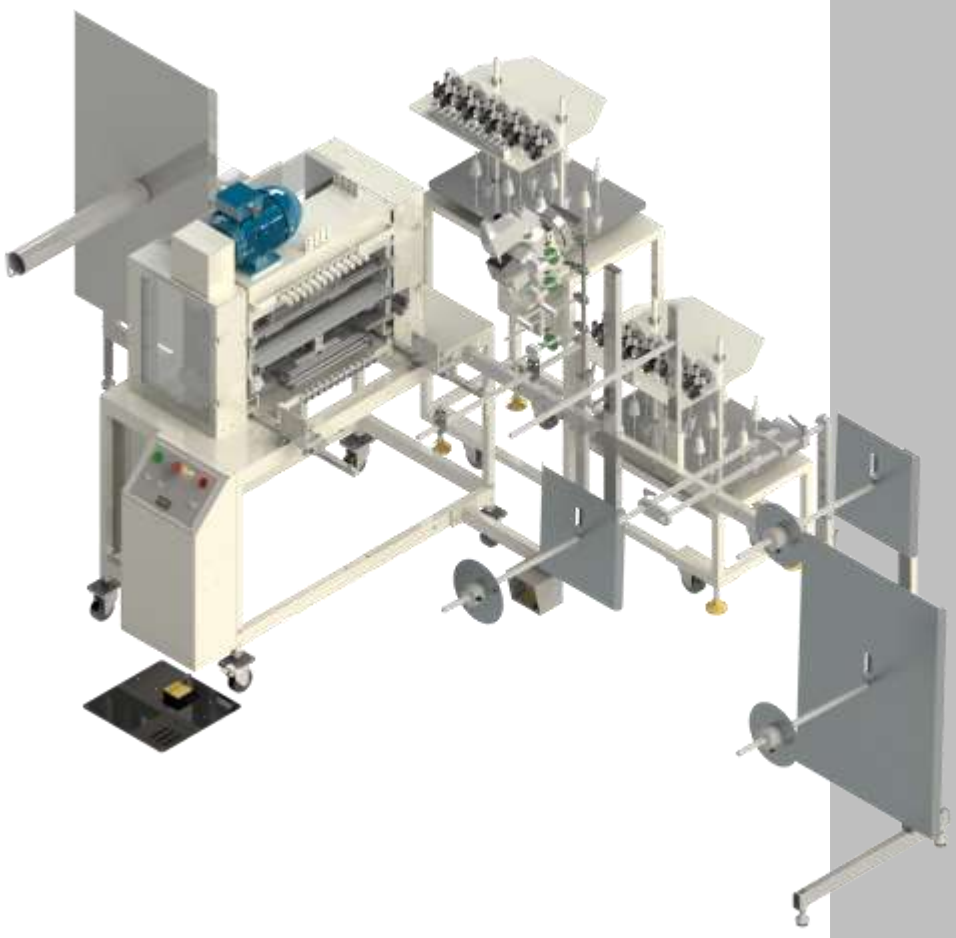
Model

1312N65

Rev 1.5 Updated March 22, 2018

Technical Manual & Parts Lists



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ATLANTA ATTACHMENT COMPANY, INC.

Confidential and Proprietary Information

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

Signal Word! (Characterizes the severity of the danger)
Note (describes the danger and informs how to proceed)

	Hazard warning sign: General Hazard		Hand hazard sign or symbol
	Hazard warning sign: Electrical hazard, electrical hazard		Designates a general, useful note.

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 1312N65, should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include;

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

Intended Use

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

Exclusion of Misuse

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

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

Liability

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

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

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

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

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

Choice and Qualification of Personnel

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

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

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines

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

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

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

Damage

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

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

Faults or Errors

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

Signs on the Machine

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

Protective Eyewear

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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

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

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

Electrical Power Supply

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

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

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

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

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

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

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

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

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

Workplace Environment

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

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

Local Regulations

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

Maintenance

General Safety Instructions

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

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

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

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

Repair

Replacement Parts

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

Repair, Electrical

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

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

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

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

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

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

Ventilation/Hazardous Gases

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

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

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

Multi-needle Quilter

The Multi-needle Quilter is a straight line chain stitch machine. The quilter has a quarter inch needle spacing and adjustable loopers, too allow for a great variety of patterns to be utilized. The maximum material width is 18 inches through the Multi-needle quilter but the sew pattern from the quilter is 10 inches. Material can be fed into the quilter through guide bars, hemmer/folders and/or tape can be applied depending on the border style.

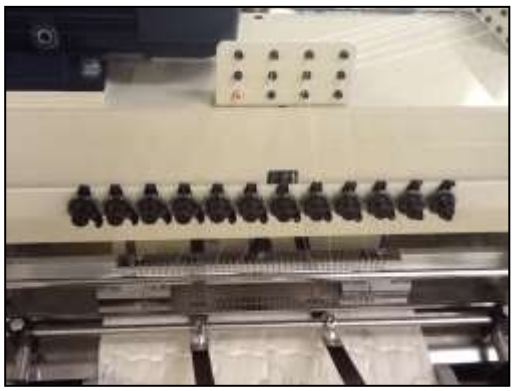
Roll Winder

The Roll Winder wraps the material around a removable tube. This provides a clean place for finished border to accumulate, while not distorting the sewn pattern.

Threading Multi-needle Quilter

Needle threads are located to the right of the Multi-needle Quilter, while the Looper threads are located under the table top. Thread is routed through the sensors and tension disks. The Multi-needle Quilter has a take up bar for both the needle and looper thread and must be utilized to provide quality stitches. The quilter thread is then routed in the usual fashion to the needles and loopers.

Needle Thread

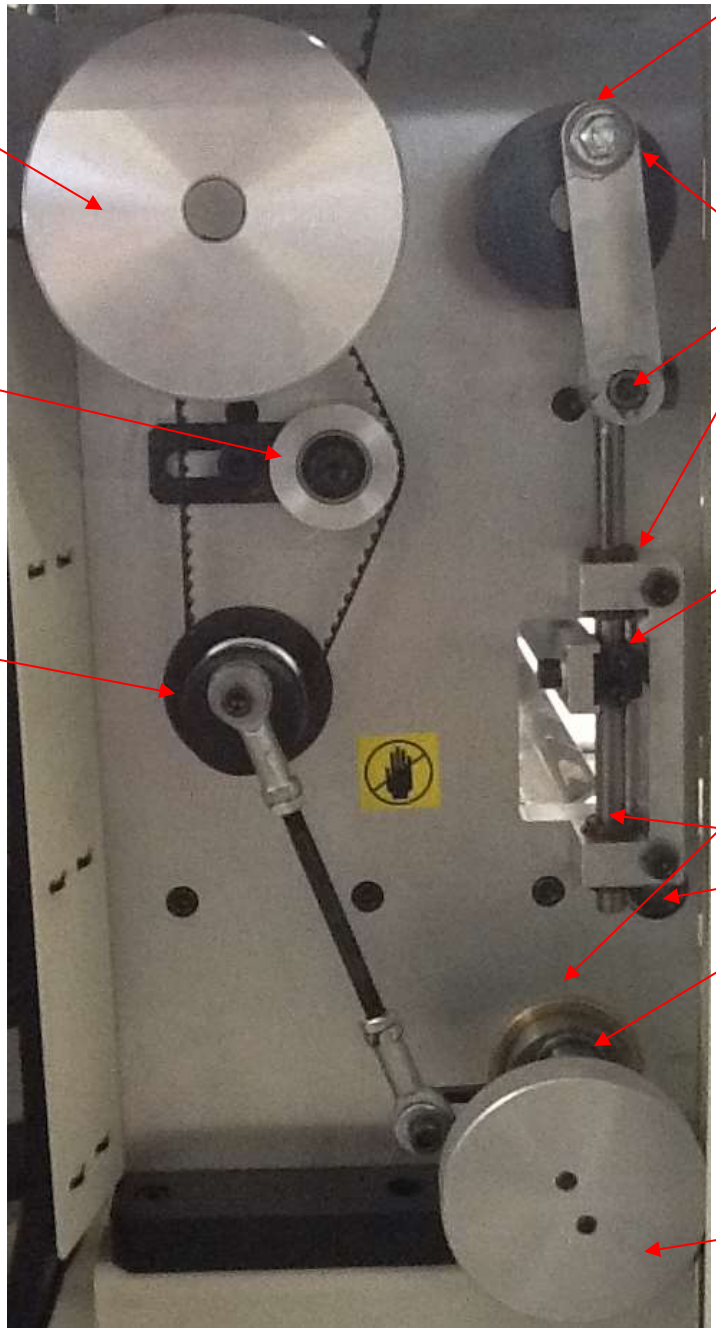


Looper Thread

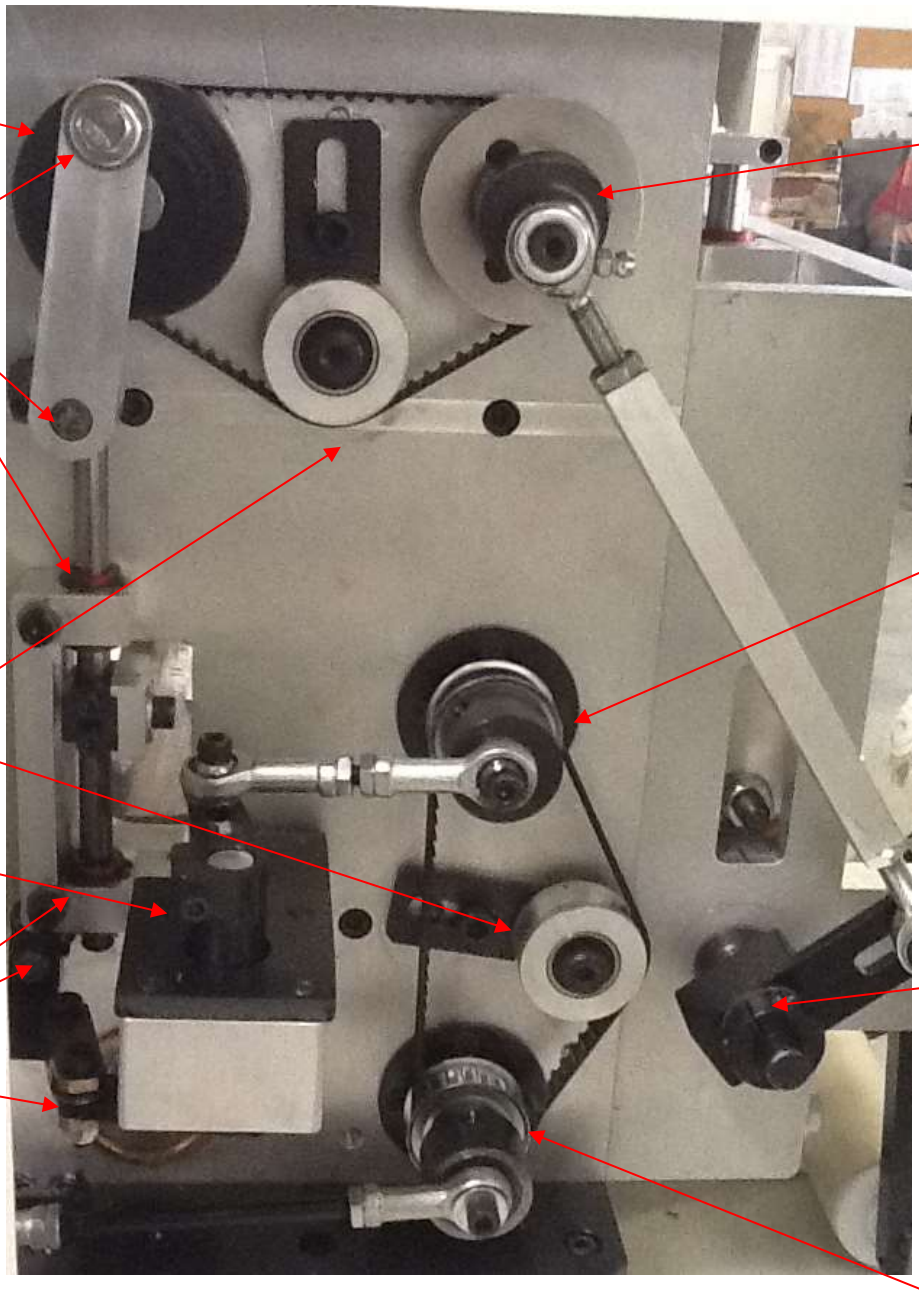
Multi-needle Quilter Layout

The Multi-needle Quilter is a straight line chain stitch machine. The quilter has a quarter inch needle spacing and adjustable loopers, which allows for a variable line pattern across the border. The next few pages are to help familiarize the technician with the mechanical lay out of the quilter.

Right Side



Left Side

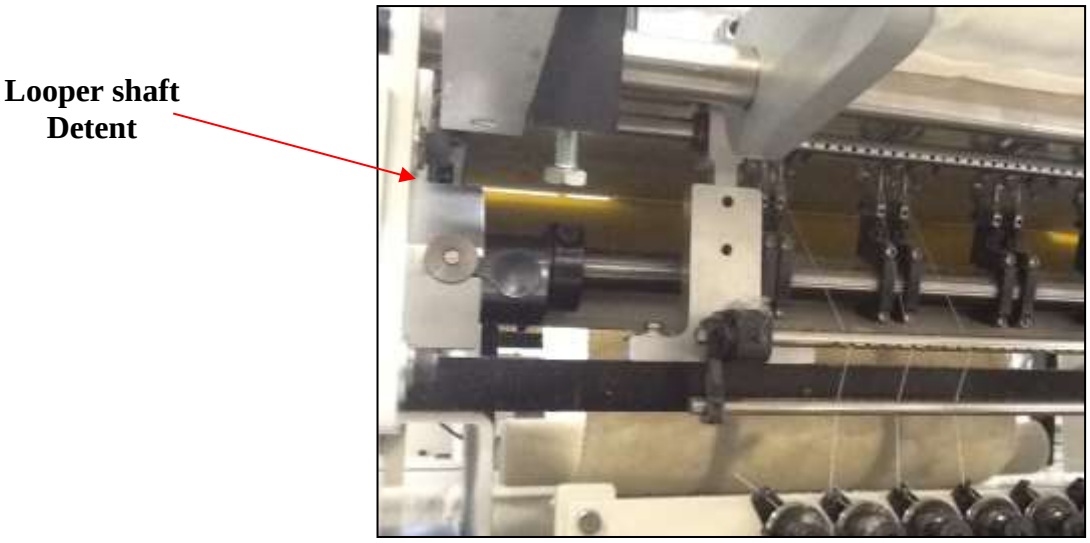

Needle Drive Pulley/Crank
Drive Roller Eccentric
Spreader Bar Eccentric
Belt Tensioner
Spreader Bar Crank Arm
Looper Thread Take-up Drive Pulley/Eccentric
Daily Lubrication needed at these points

a. Looper rocker arm

The Multi-needle Quilter is equipped with a rocker arm on the looper shaft, which enables the technician to rotate the loopers down and forward to ease in looper threading.

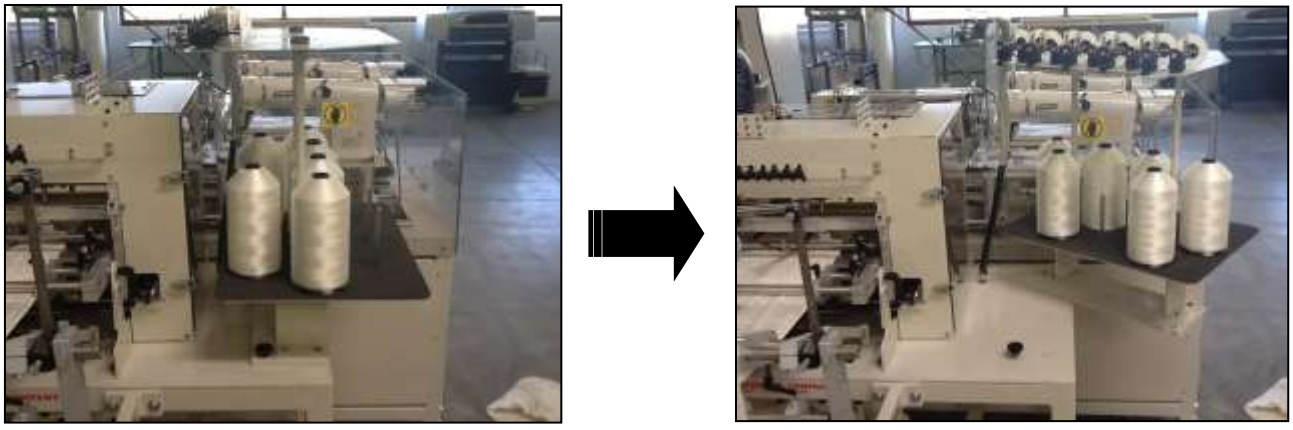
The technician must manually rotate the Multi-needle Quilter to the Needle TDC position; then must pull on the looper shaft detent, located on the front lower left of the quilter, in order to unlock the shaft. Rotating the rocker arm knob located on the left side of the quilter counter clockwise until the detent locks. The loopers are now in a position to thread.

The looper shaft must be rotated back to the original position and locked in the detent in order to sew, this is done by pulling the shaft detent to unlock then rotate the rocker arm knob clockwise until the detent locks. Always check that the detent is secured as this can cause a crash situation.



b.Swing-out Thread stand

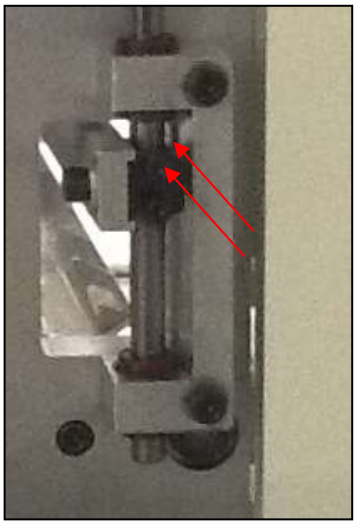
The Multi-needle Quilter is equipped with a swing-out thread stand for the needle threads, which enables the technician to rotate the thread stand out of the way to allow for easy entry to the right side of the Multi-needle Quilter for maintenance.



Multi-needle Quilter Adjustments

Please follow all safety procedures, turning off power is recommended.

a. Adjusting the needle height of the needle bar



Needle System SN328-22: Set the needle bar so that when the needle bar has reached to top dead point, the needle point is approximately 6.8mm (0.267 inches) from the throat plate. The needle bar is adjusted by loosening two Allen bolts on each side of the quilter and tightening them at the proper location.

b. Matching the looper

When the needle is at its lowest point, the looper should be at its far back position. This adjustment is made by loosening the setscrew of the gear pulley located on the left of the quilter.

c. Scooping amount of the looper

When the blade point of the looper has reached the center of the needle, the standard distance between the blade point and the upper end of the needle hole is 1.5 mm (1/16). The returning amount of the looper comes approximately 3.2 mm (1/8) and the relative relationship of the needle hole and the thread hole of the looper

d. Clearance between the looper and the needle

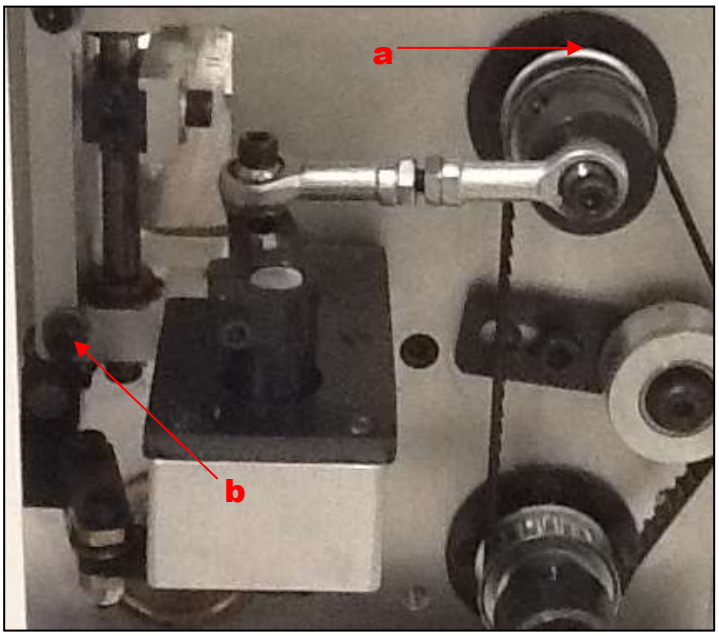
When the looper scoops up the thread the clearance between looper and needle should be as narrow as possible.

e. Thread spreader

Thread spreader is very important to obtain stable stitches without skip-stitching in case of normal feed sewing.

f. The timing of thread spreader against the needle

When the pointed end of the descending needle arrives at the level of upper surface of the looper, adjust such that the inside surface of the thread spreader should be approx. 1mm right of the needle.



Timing of the spreader is adjusted by loosening and adjusting gear pulley (A).

The distance between the spreader and the throat plate should be adjusted as close as possible without rubbing the throat plate.

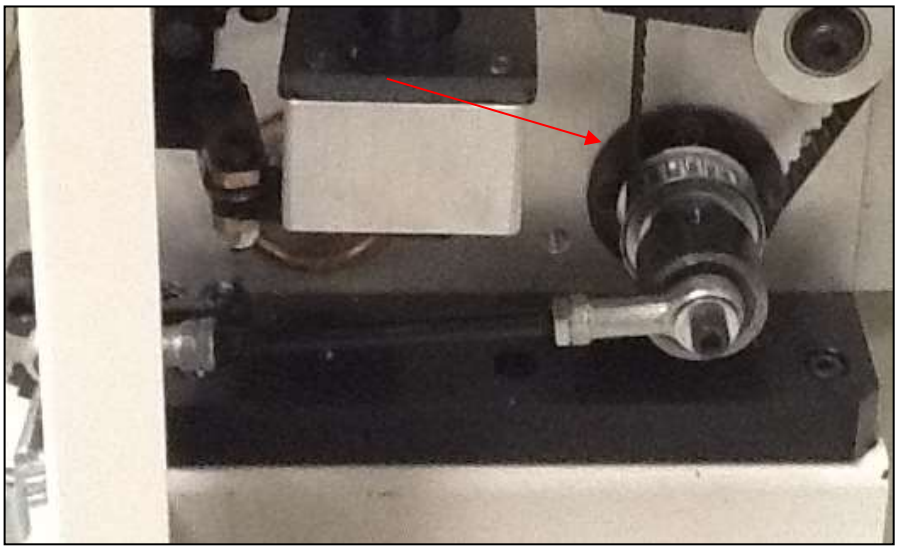
Adjust by loosening set screws and rotating shaft (B).

g. Needle Thread take-up Bars

The needle thread take-up bars, one which moves with the needle bar and one fixed, prevents the needle thread from forming unnecessary loop in the opposite side of the looper when the needle bar goes up to its highest position to form the needle thread loop to be hooked by the looper. By so doing, there is not possibility that the thread loop grows up excessively by drawing in such unnecessary loop through the needle eye (A large loop is undesirable to form uniform stitch).

h. Looper Thread take-up Bars

Looper thread take-up bars help to avoid material puckering; adjust the looper take-up so that the bottom of one bar is aligned with the lower side the other two with a little earlier timing, that way the looper thread will not be drawn too much and a favorable thread tension can be obtained. The looper thread take up timing can be adjusted by loosening the gear pulley.



i. Function of the thread take-up tension discs

The take-up thread tension disc functions especially for preventing the stitches from skipping during reverse stitching and production of chain-off threads.

It is very important to pull in the slack of the needle thread especially when the feed direction is reversed. If a slackened needle thread remains on the cloth, it may be cut by the returning needle or it may form an idle loop which results in stitch skipping. Another function of the take-up thread tension disc is to take in the slack of the needle thread while the needle goes down in order to prevent the chain-off threads from skipping. The needle thread is entirely free from the resistance of the cloth when the chain-off threads are formed. Therefore, when the needle point comes down to pass through a triangular loop formed on the back of the looper, the triangular loop will be deformed or broken to skip if a stitch of the interloping needle thread is slackened.

j. Relation thread take-up tension plate / take-up thread tension disc.

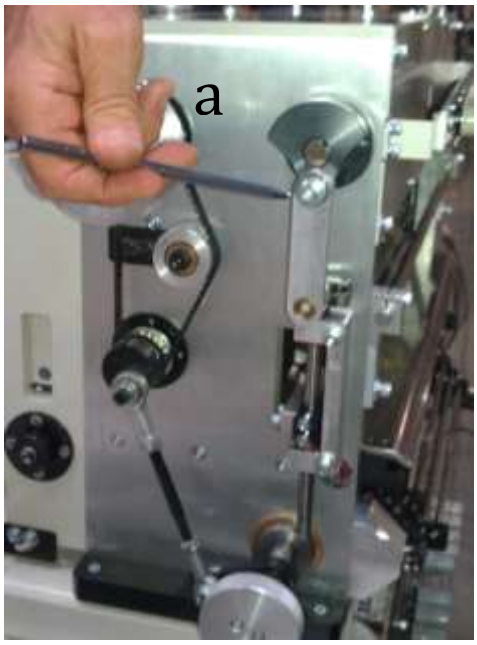
In order for these two thread components to properly function, it is necessary to maintain the tension. The standard ratio is 3 g: 1 g (drawing force required for the cotton thread No.60).

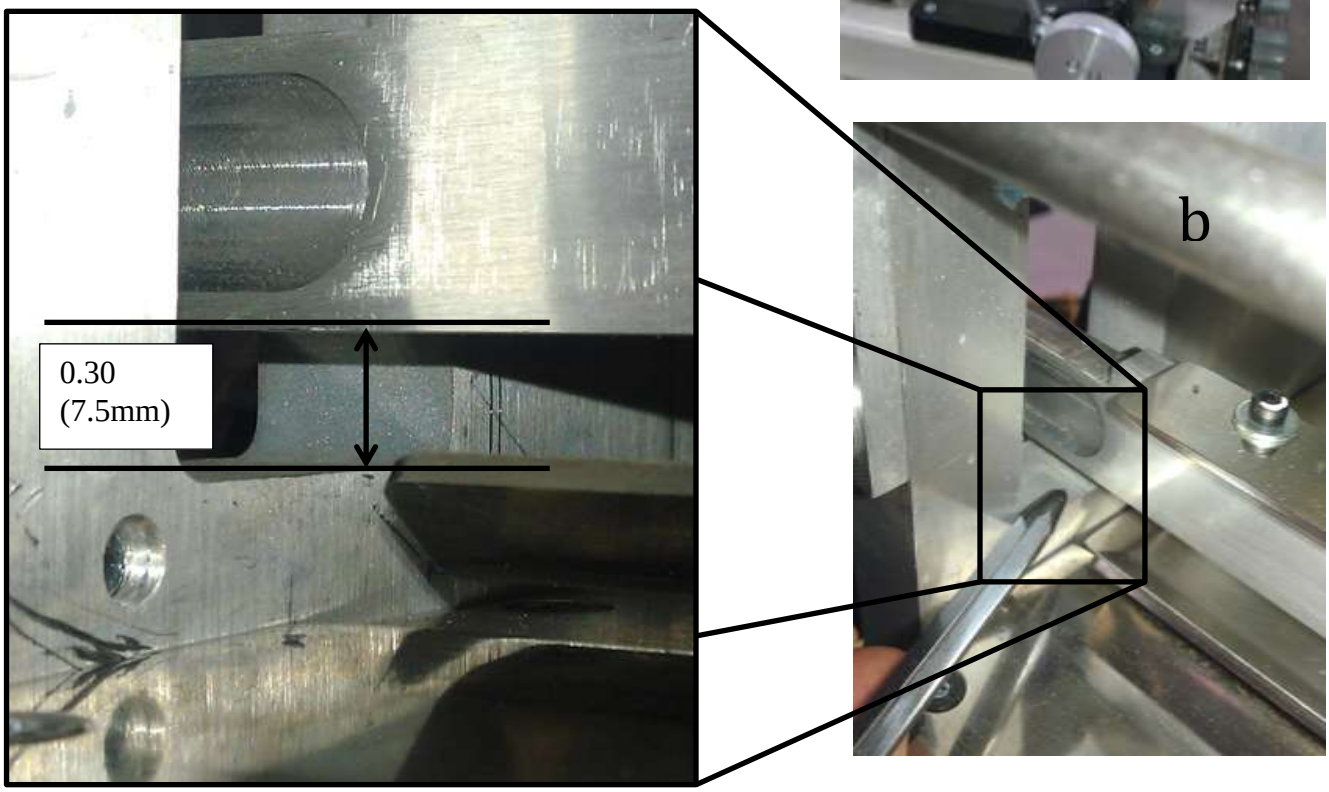
Quilter Timing Setup

Warning: Be sure to follow Lockout/Tagout procedures before attempting any adjustments to the quilter assembly. Follow steps 1 through 7 in order to properly setup the sew operation of the quilter.

1. Needle bar height.

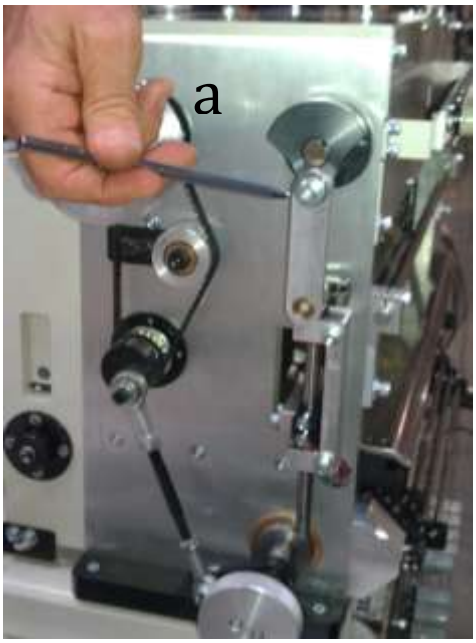
a.-Set machine at needle bar BDC (bottom dead center)
b.-Adjust height to 0.30 (7.5mm) inside the window cutout by the fasteners at each end of the needle bar.

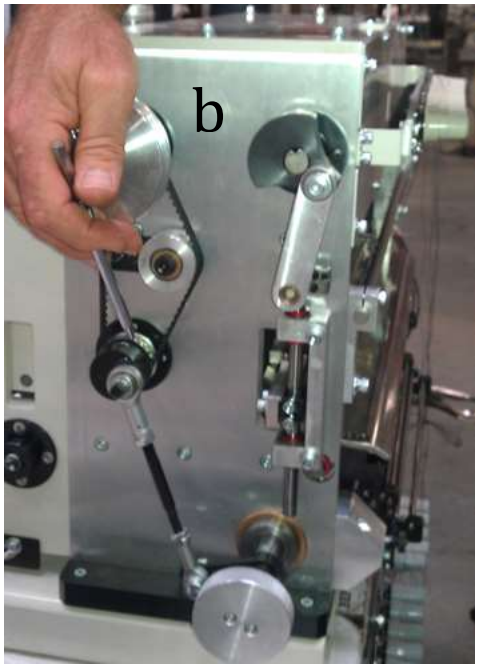




01.2. Synchronizing looper to needle

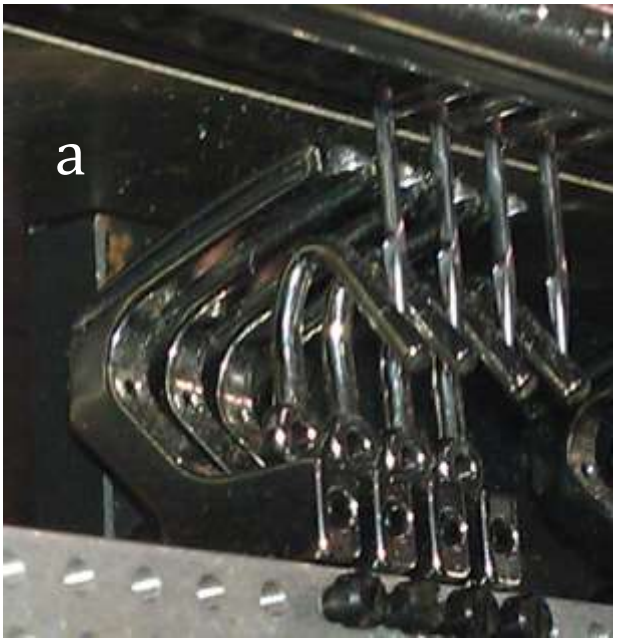
a.-Set machine at needle bar BDC
b.-Adjust looper rear point of reversal by the eccentric marked “L” on the left side of quilter.

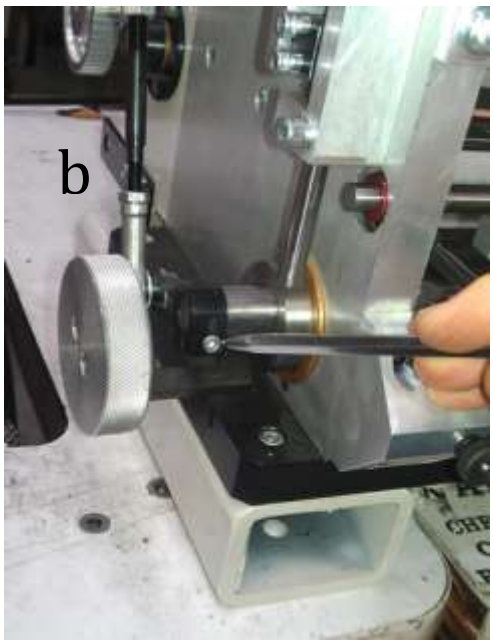


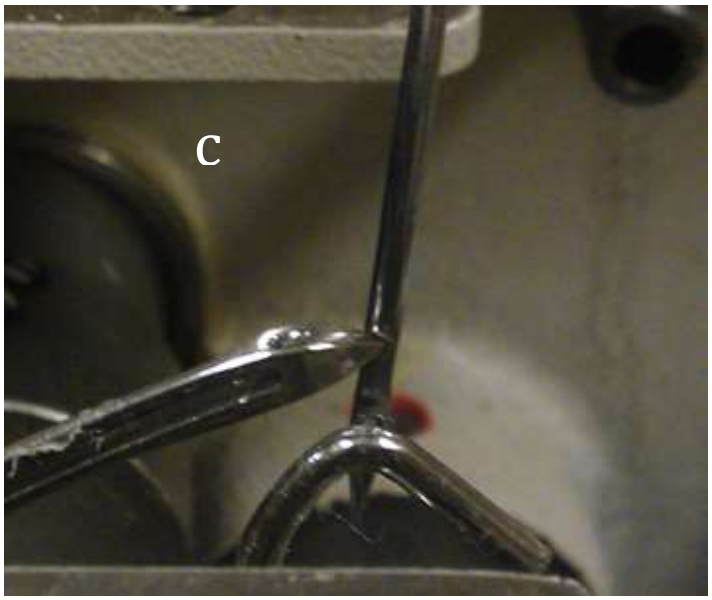


Setting the loop stroke

a.-Set machine at needle bar BDC
b.-With the loopers at rear point of reversal there should be approximately 0.08 (2mm) clearance between the point of looper to the rear edge of needle. To obtain this, loosen the clamping screw on the extreme left end of the looper shaft and position looper.
c. - When looper point is at center of needle, the point should be in the lower third of needle scarf.

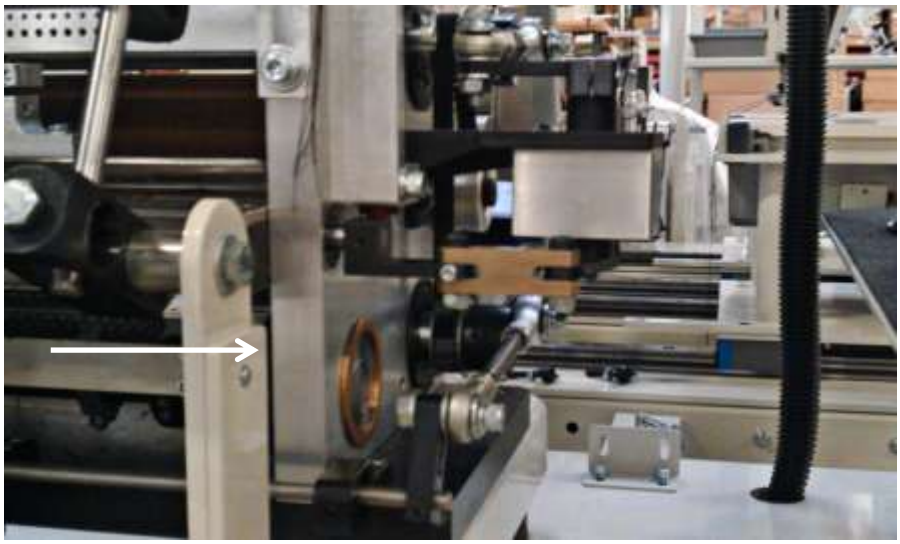


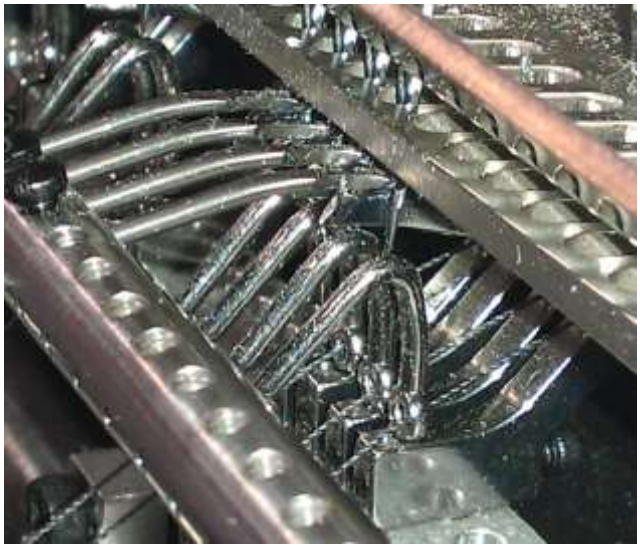




Thread retainer timing

a.-With the descending point of the needle just below and behind the eye of the reversing looper the retainer should be at the extreme right position. Adjust by turning eccentric marked “S”. Located on the right side of quilter.



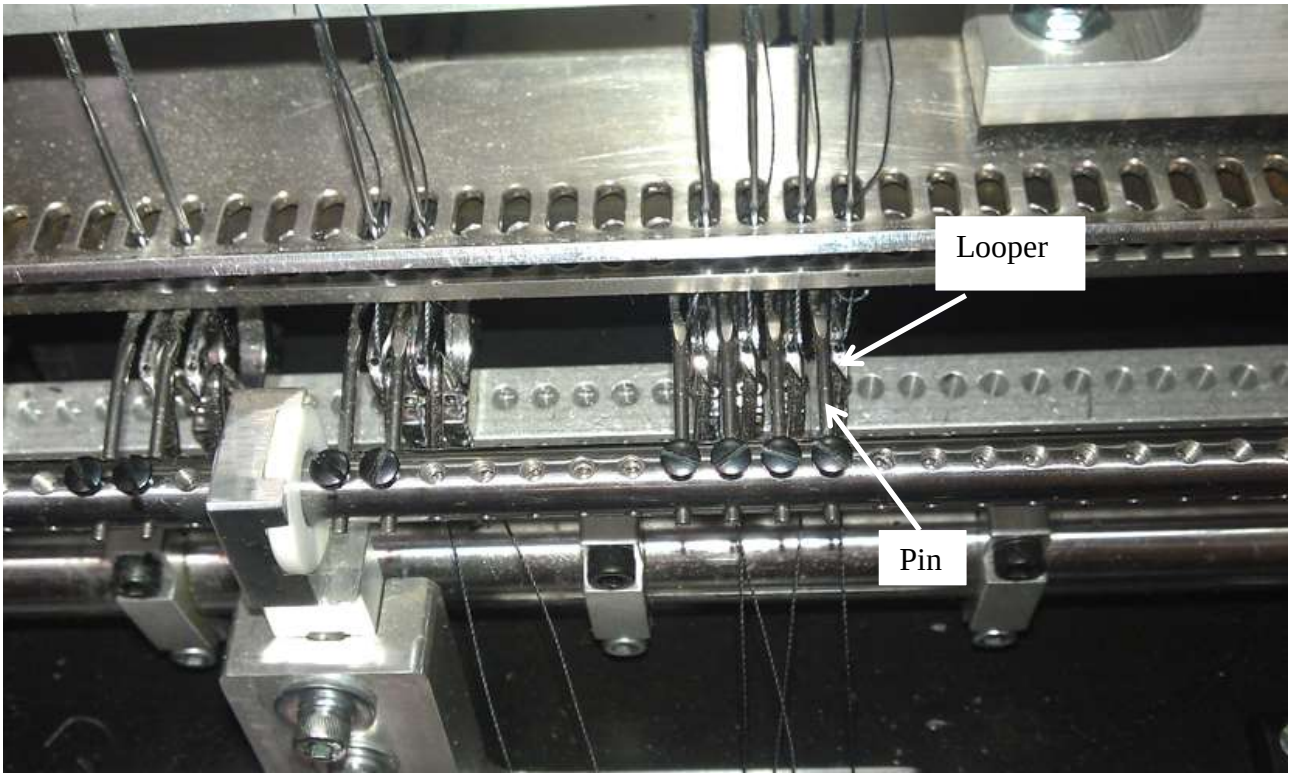


Thread retainer position

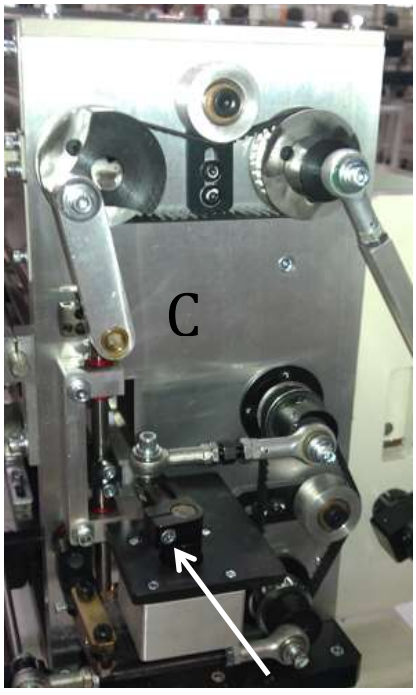
a.-Adjust the thread retainer end to have a clearance of 0.02 (0.5mm) to the needle. At the same time, the flat surface should be parallel to the bottom of the stitch plate. Adjust with the fastening screw.

b-Adjust the clearance of the retainers over the top of the loopers to be approximately the thread thickness. Adjust by rotating the retainer shaft on the right end while keeping that end flush with holder.

Extreme left when pin right edge is aligned with the left edge of the looper.



c.-Adjust the retainers so that when they are extreme left, the right edge of the retainer is even with the left edge of the looper. Adjust with drive lever on the right.

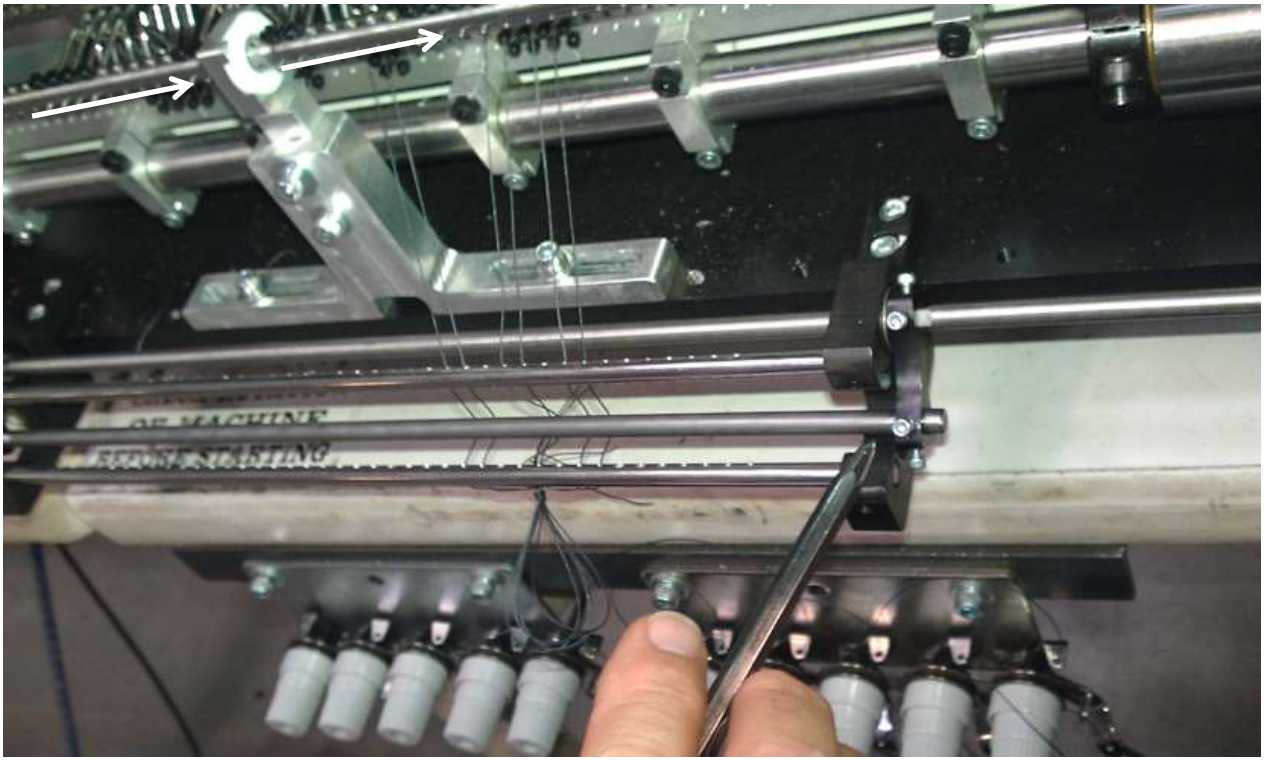


Looper thread take-up timing.

a.-The looper thread should be at max pull off at the same time the retainer reaches extreme right. Adjust with the eccentric marked “T” located in the right side.

Note: ***Amount of pull off should be set is determined by thread type.***

Arrows indicate the bar extreme right position

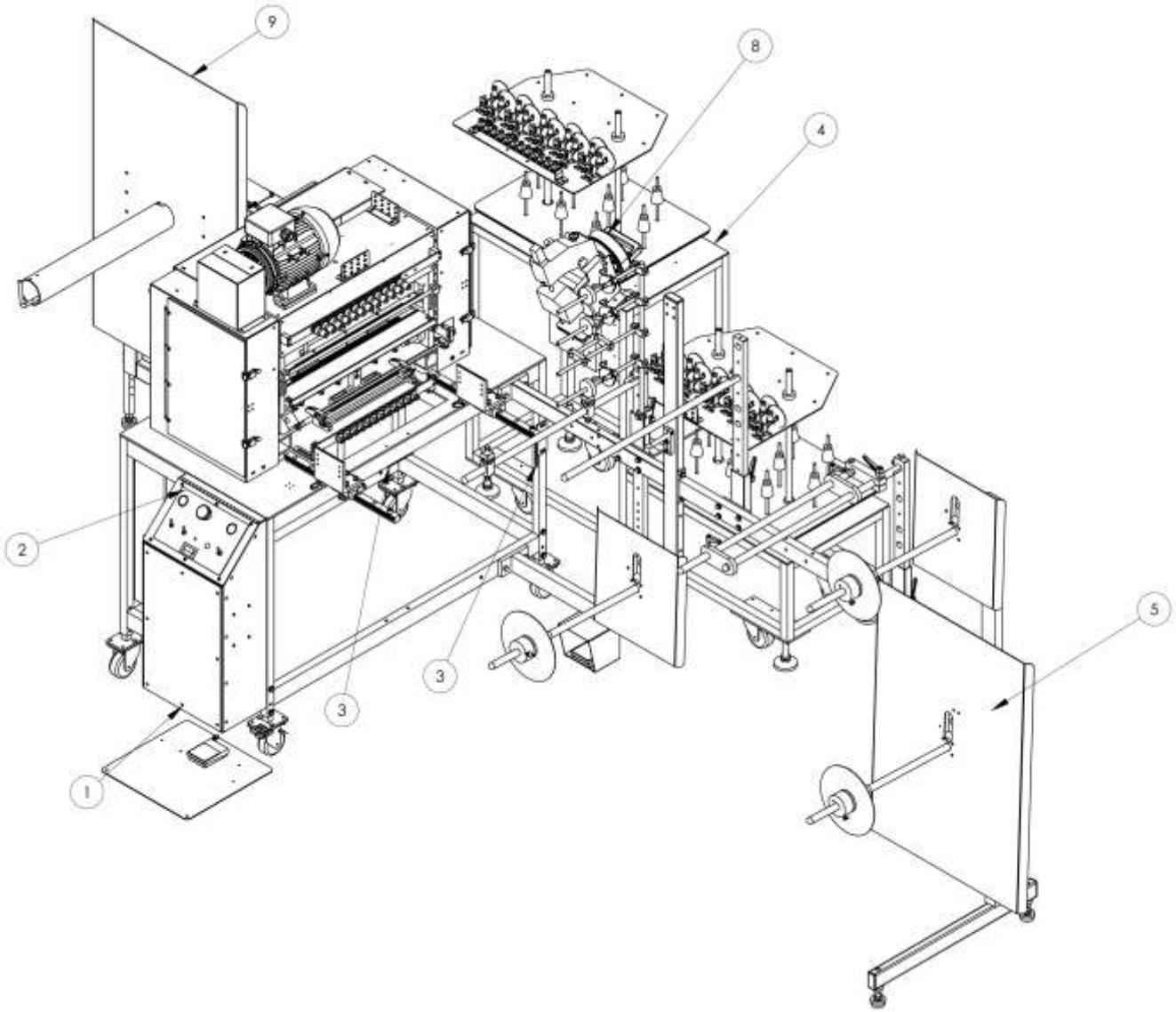


Puller timing.

a.-The puller should be timed so that the puller movement only occurs when the needles are out of the fabric. Adjust with eccentric marked “P” on the right side of the machine.

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.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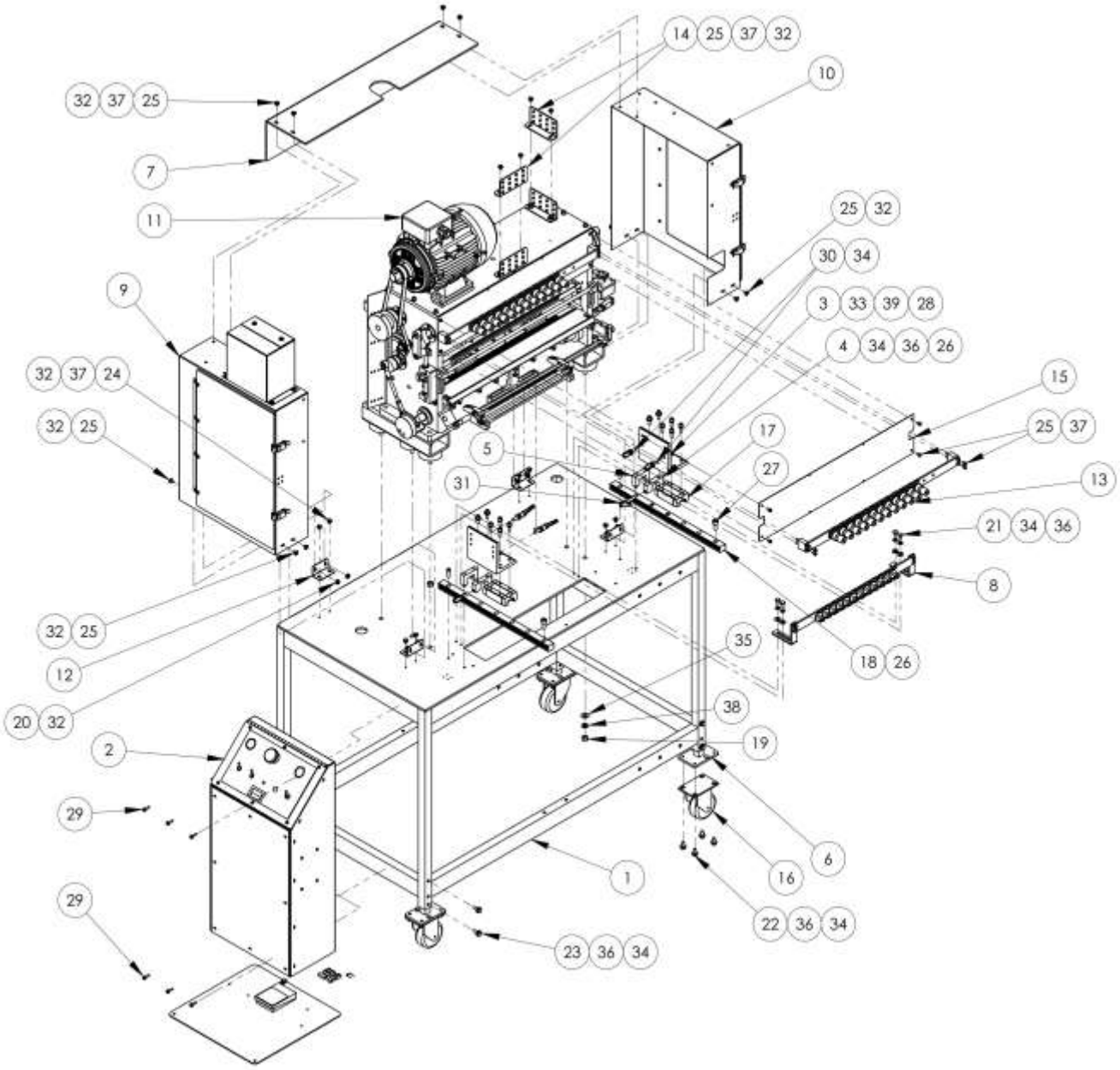
11312N65 DECORATIVE BORDER WORK STATION

AAC Drawing Number 9004957 Rev 0

NO	QTY	PART #	DESCRIPTION
1	1	1312097	MULTI-NEEDLE SEW ASBLY
2	1	1312116	REGULATOR PANEL
3	2	1312121	THREAD GUIDE, NEEDLE THRD
4	1	1312128	THREAD STAND ASSY
5	1	1312141	ROLL HOLDER ASSY.
6	*AR	1312N65-PD	DIAGRAM.PNEUMATIC
7	*AR	1312N65-WD	DIAGRAM,WIRING
8	1	1961-KIT10	BORDER SPLICING ASSY
9	1	4500650	REWINDER, BORDER
10	1	MM9280K33	GROMMET,FLANGE,1.03 ID
11	8	SSHC10144	SCREW,HEX,5/16-18X2-1/4
12	8	WWFS5/16	WASHER,FLAT,SAE,5/16
13	4	WWL5/16	WASHER,LOCK, 5/16
14	4	NNH5/16-18	NUT,HEX, 5/16-18
15	2	WWFS1/4	WASHER,FLAT,SAE,1/4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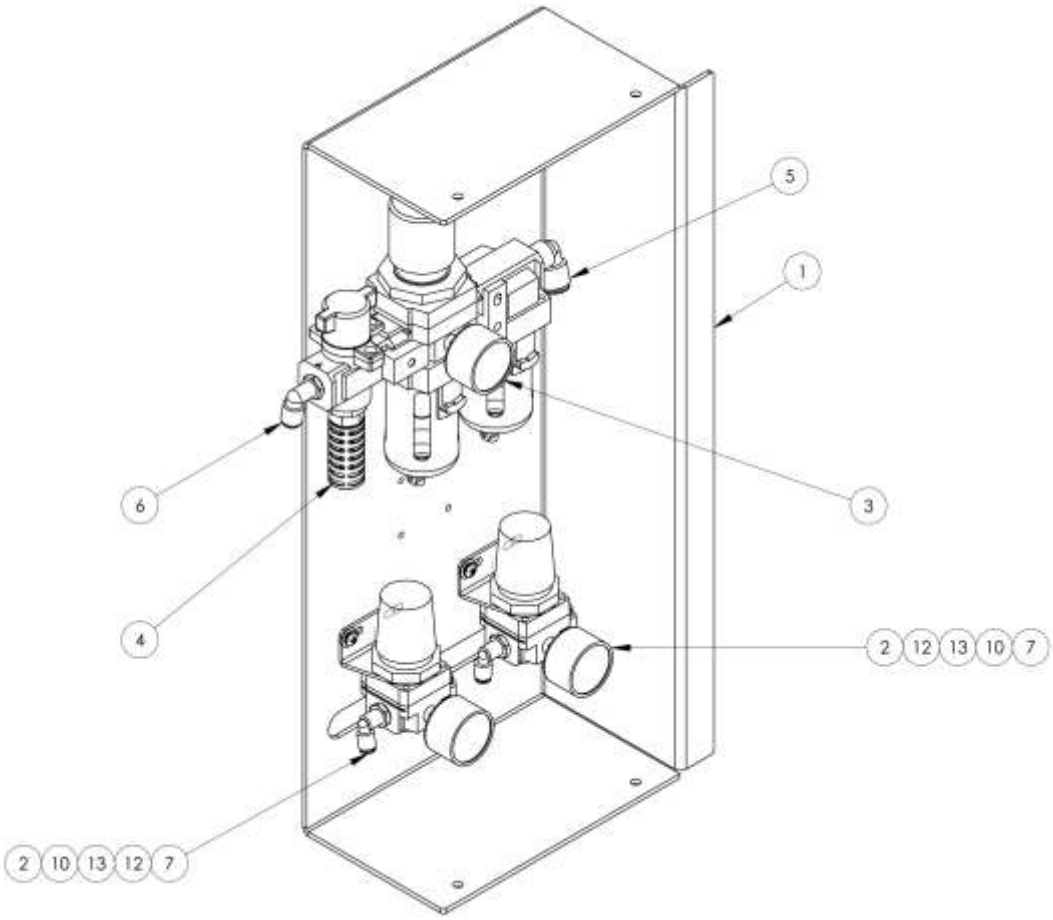
1312097 MULTI-NEEDLE SEW ASSEMBLY

AAC Drawing Number 1312097 Rev 3

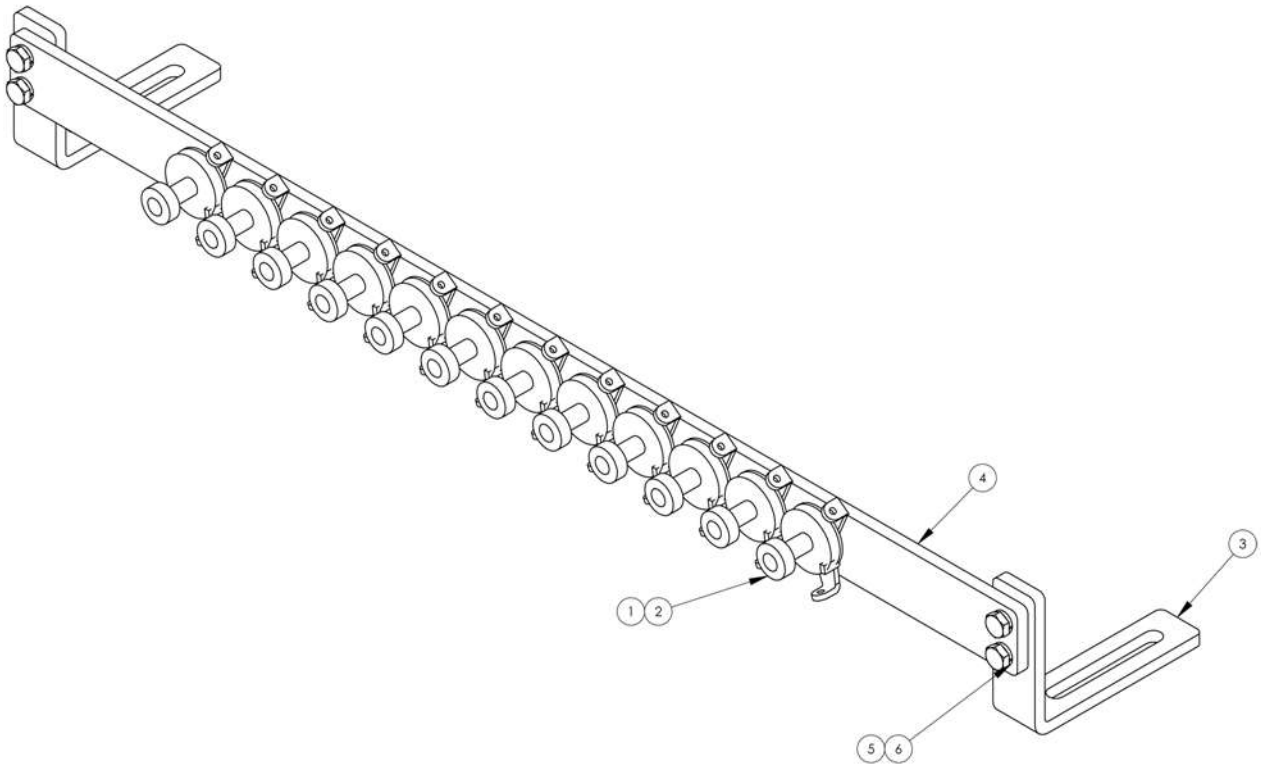
NO	QTY	PART #	DESCRIPTION
1	1	1312108	WELDMENT, FRAME
2	1	1312133	CONTROL BOX
3	2	1334-1005	MOUNT, ANGLE, UPPER
4	2	1334-1006	MOUNT,LOCKING HANDLE
5	2	1335-310	STOP BLOCK,FRONT
6	4	1961-115	LEG WELDMENT
7	1	4500118	GUARD, ROLLER
8	1	4500198	TENSION ASM. LOOPER THRD
9	1	4500230	GUARD, QUILTER LFT SIDE
10	1	4500233	GUARD, QUILTER RT SIDE
11	1	4500500	MULTI-NEEDLE QUILTER
12	4	4500530	BRACKET, ANGLE MOUNT
13	1	4500813	TENSION ASM, NEEDLE THRD
14	2	4500816	THREAD GUIDE, NEEDLE
15	1	4500822	GUARD, FRONT
16	4	MM427-3RB	CASTER,SWIVEL,3"RUBBER
17	2	MMAGH25CAN	LINEAR BEARING
18	2	MMAGR25414M	RAIL,MODIFIED
19	6	NNH3/8-16	NUT,HEX,3/8-16
20	8	NNK10-32	KEP NUT, 10-32
21	4	SSHC01032	1/4-20 X 1/2 HHCS
22	16	SSHC01040	1/4-20 X 5/8 HHCS
23	8	SSHC01048	1/4-20 X 3/4 HEX CAP
24	8	SSHC98024	10-32 X 3/8 HEX CAP
25	24	SSPP98024	10-32 X 3/8 PAN HD PHILIP
26	10	SSSC01048	1/4-20 X 3/4" SOC CAP SC
27	2	SSSC25048	3/8-16X3/4 SOC CAP
28	8	SSSCM6X20	M6 X 20, SOC CAP
29	6	SSZS93048	SCREW, SHT.METAL 10 ZIP
30	4	TTH32415	HANDLE,THDED,1/4-20X7/8
31	2	TTH32416	HANDLE,THRD,1/4-20X1-1/8
32	32	WWF10	WASHER, FLAT, #10, COM
33	8	WWFM6	WASHER, FLAT, M6, SAE
34	36	WWFS1/4	WASHER,FLAT,SAE,1/4
35	6	WWFS3/8	WASHER,FLAT,SAE,3/8
36	32	WWL1/4	WASHER,LOCK, 1/4
37	24	WWL10	WASHER,LOCK,#10
38	6	WWL3/8	WASHER,LOCK, 3/8
39	8	WWLM6	WASHER,LOCK,M6



1312116 REGULATOR PANEL

AAC Drawing Number 1312116 Rev 0

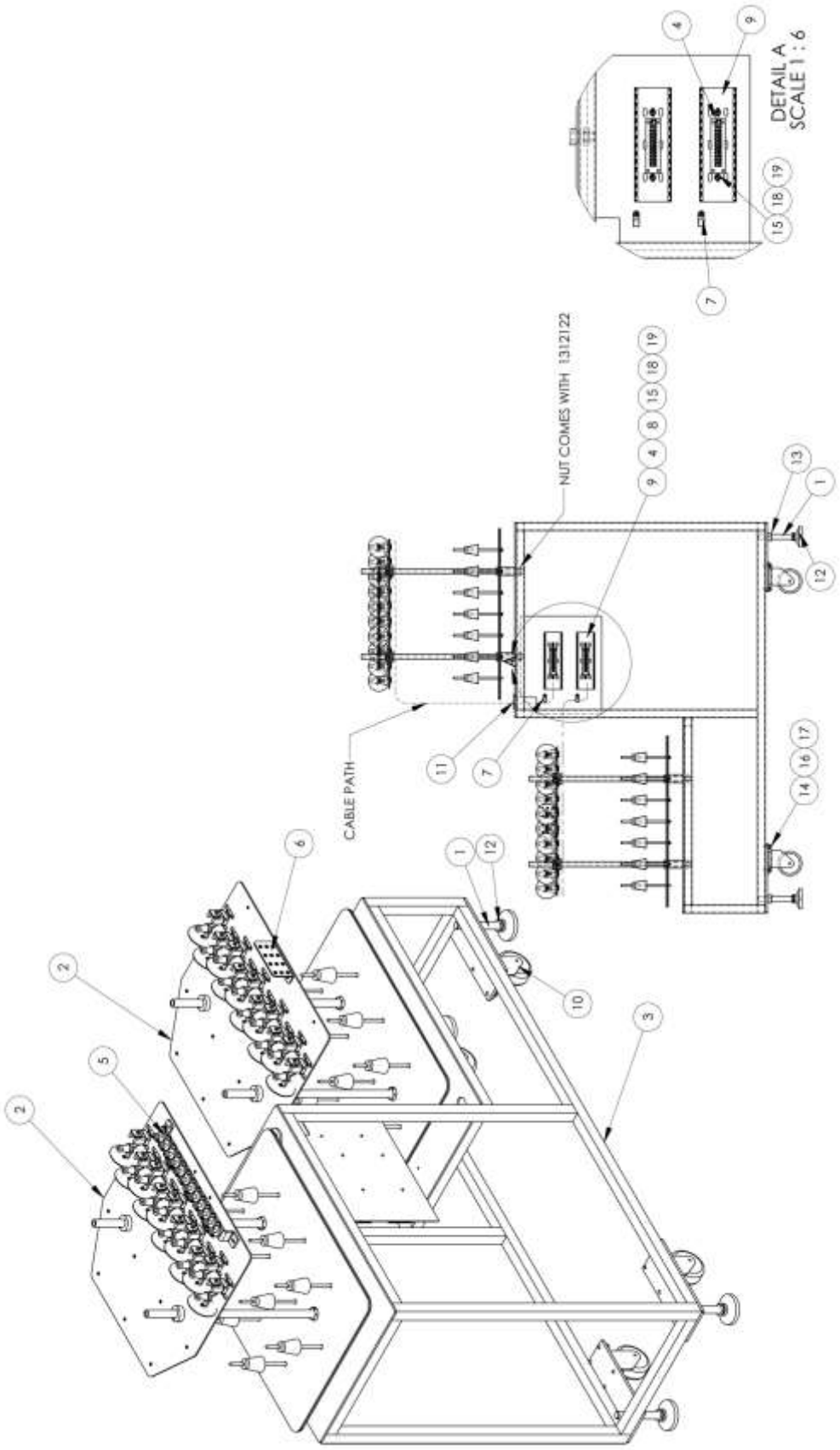
NO	QTY	PART #	DESCRIPTION
1	1	4500256	BRACKET,PNEUMATIC
2	2	AA198-503B	REG,0-30 W/GAUGE& BRKT, R
3	1	AA198-5110	FILTER/REGULATOR/LOCKOUT
4	1	AAFNAN200-02	MUFFLER,1/8 NPT
5	1	AAQME-3-4	MALE ELBOW 3/8OD TUBE
6	1	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT
7	5	AAQME-5-4	ELBOW, MALE 5/32X1/4NPT
8	2	NNK1/4-20	NUT,KEP,1/4-20
9	2	SSHC01048	1/4-20 X 3/4 HEX CAP
10	4	SSPP98024	10-32 X 3/8 PAN HD PHILIP
11	2	WWF1/4	WASHER, FLAT, 1/4", COM
12	4	WWF10	WASHER, FLAT, #10, COM
13	4	WWL10	WASHER,LOCK,#10



4500198 TENSION ASSEMBLY LOOPER THREAD

AAC Drawing Number 4500198 Rev 0

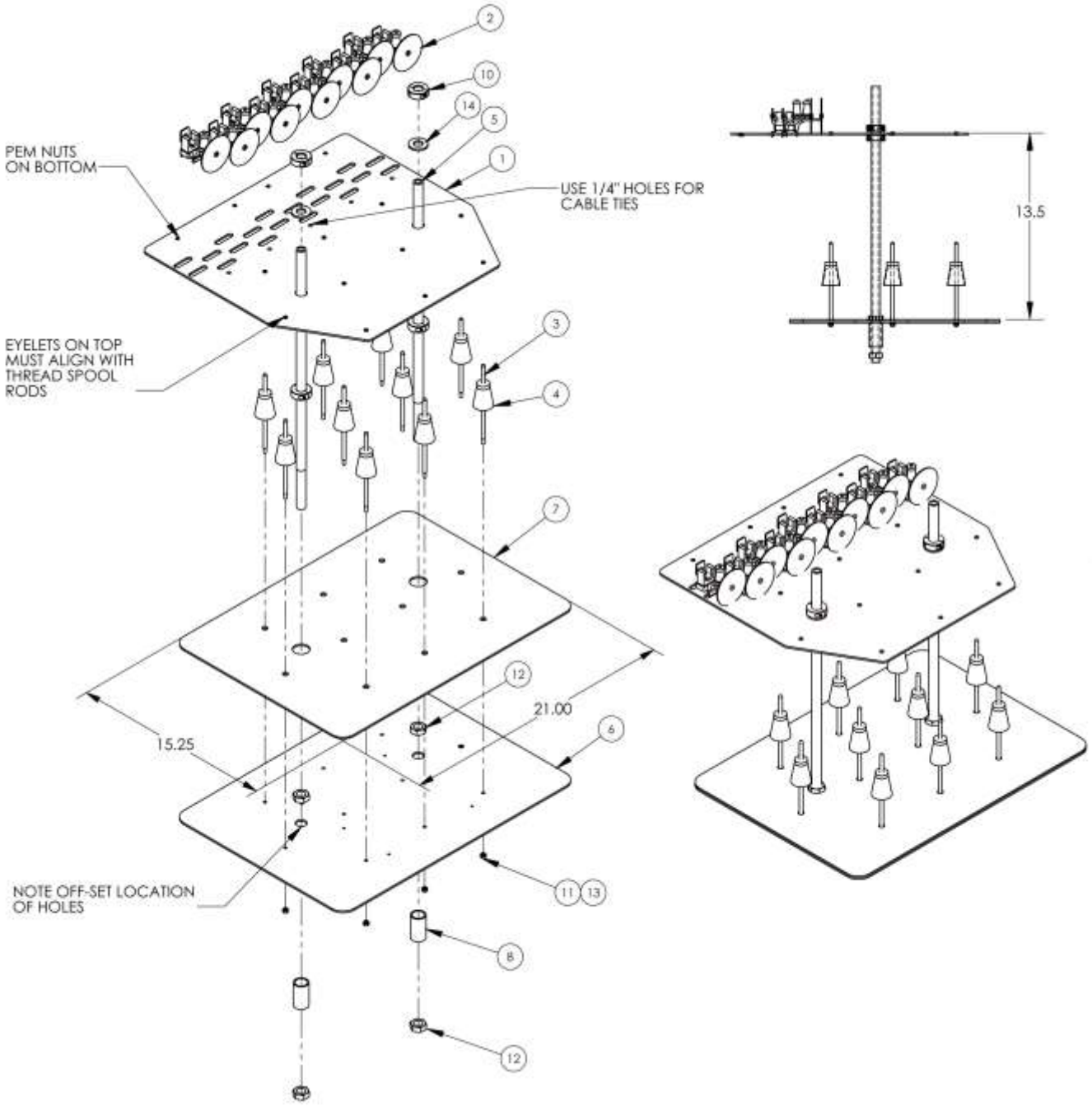
NO	QTY	PART #	DESCRIPTION
1	12	268333	LOOPER THD TENSION GUIDE
2	12	415294	LOOPER THREAD TENSION
3	2	4500197	MOUNT, BRACKET
4	1	4500815	BRKT, THREAD TENS.
5	4	SSHC98032	10-32X1/2 HEX HD
6	4	WWL10	WASHER,LOCK,#10


DETAIL A
SCALE 1 : 6
NUT COMES WITH 1312122
CABLE PATH

1312128 THREAD STAND ASSEMBLY

AAC Drawing Number 1312128 Rev 1

NO	QTY	PART #	DESCRIPTION
1	4	0411-1063	THREADED ROD
2	2	1312122	THREAD STAND, NEEDLES
3	1	1312126	THREAD STAND FRAME ASSY.
4	2	4003-BTSR12	BTSR SENSOR PCB, 12 POS
5	1	4500347	PRE-TENSION ASSY
6	1	4500816	THREAD GUIDE, NEEDLE
7	2	AAF1/4	CLAMP, BLACK PLASTIC
8	2	EEDC2X2	COVER,WIRE DUCT
9	2	EEDF2X2	DUCT,WIRE,2X2, MOD
10	4	MM427-3RB	CASTER,SWIVEL,3"RUBBER
11	1	MM9280K33	GROMMET,FLANGE,1.03 ID
12	4	MML-2	LEVELING PAD, 5/8-11
13	4	NNH5/8-11	NUT,HEX,5/8-11
14	16	SSHC01048	1/4-20 X 3/4 HEX CAP
15	6	SSPP90024	8-32X3/8 PAN PHLPS
16	16	WWFS1/4	WASHER,FLAT,SAE,1/4
17	16	WWL1/4	WASHER,LOCK, 1/4
18	6	WWF8	WASHER, FLAT, #8
19	6	WWL8	WASHER,LOCK,#8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ON BOTTOM
USE 1/4" HOLES FOR
CABLE TIES
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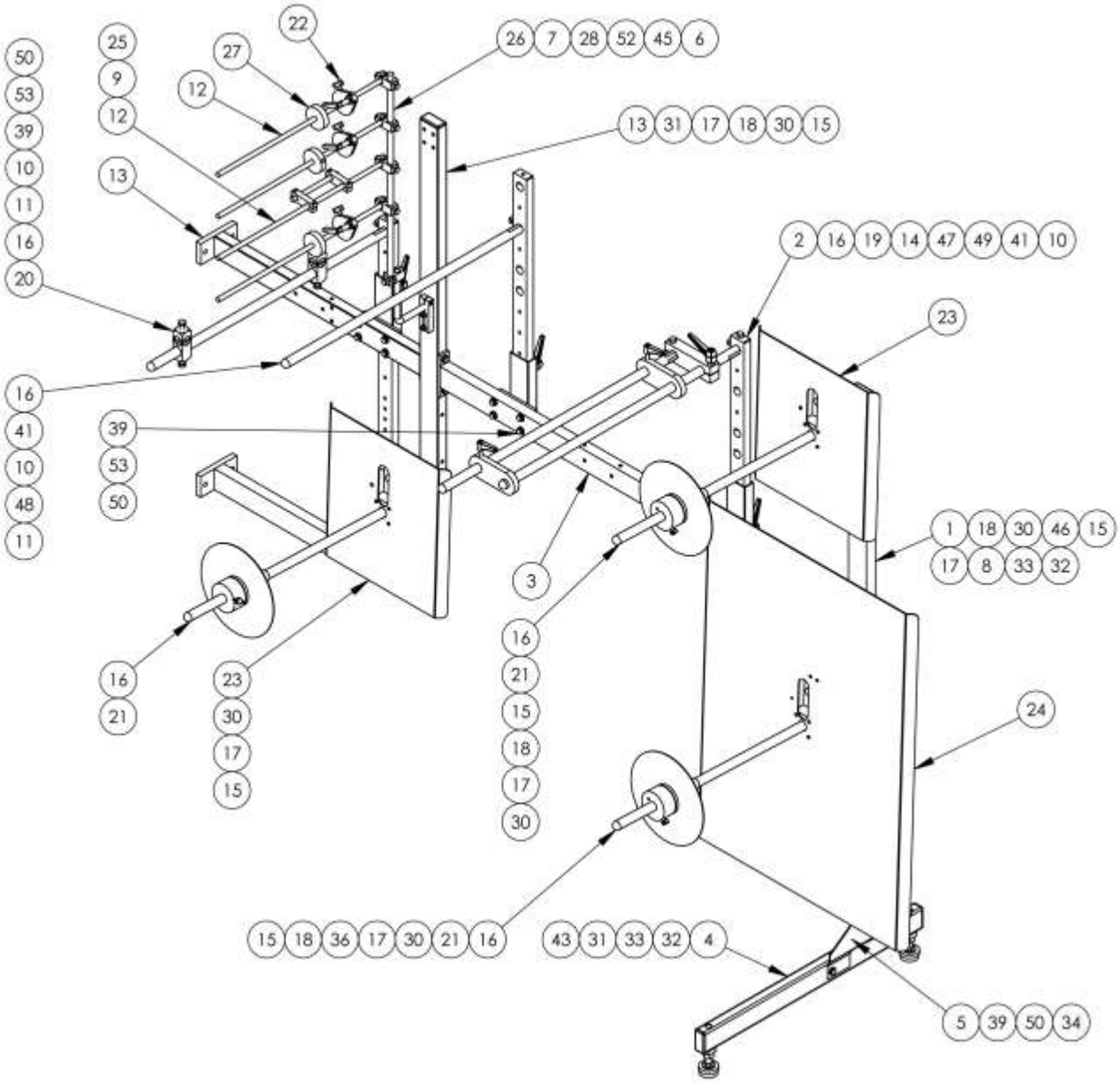
1312122 THREAD STAND, NEEDLES

AAC Drawing Number 1312122 Rev 3

NO	QTY	PART #	DESCRIPTION
1	1	1312143	PLATE, THREAD BREAK
2	10	4003-IS3WT2E	SENSOR,THREAD BRK,,1329
3	10	40085790	ROD, THREAD SPOOL
4	10	40085791	CONE,SPOOL RETAINER
5	2	4500130	POLE, THREAD STAND
6	1	4500133	PLATE, THREAD STAND
7	1	4500185	FOAM, THREAD STAND
8	2	97-2250A	SPACER, THREAD STAND
9	*1	AATPWL3/4	WIRE LOOM,.76"ID,BLK
10	4	CCCSL5/8	SPLIT COLLAR 5/8
11	9	NNHM5X0.8	NUT,HEX,M5-0.8
12	4	NNJ5/8-18	NUT-HEX JAM 5/8-18
13	9	WWL10	WASHER,LOCK,#10
14	2	WWU5/8	WASHER,URETHANE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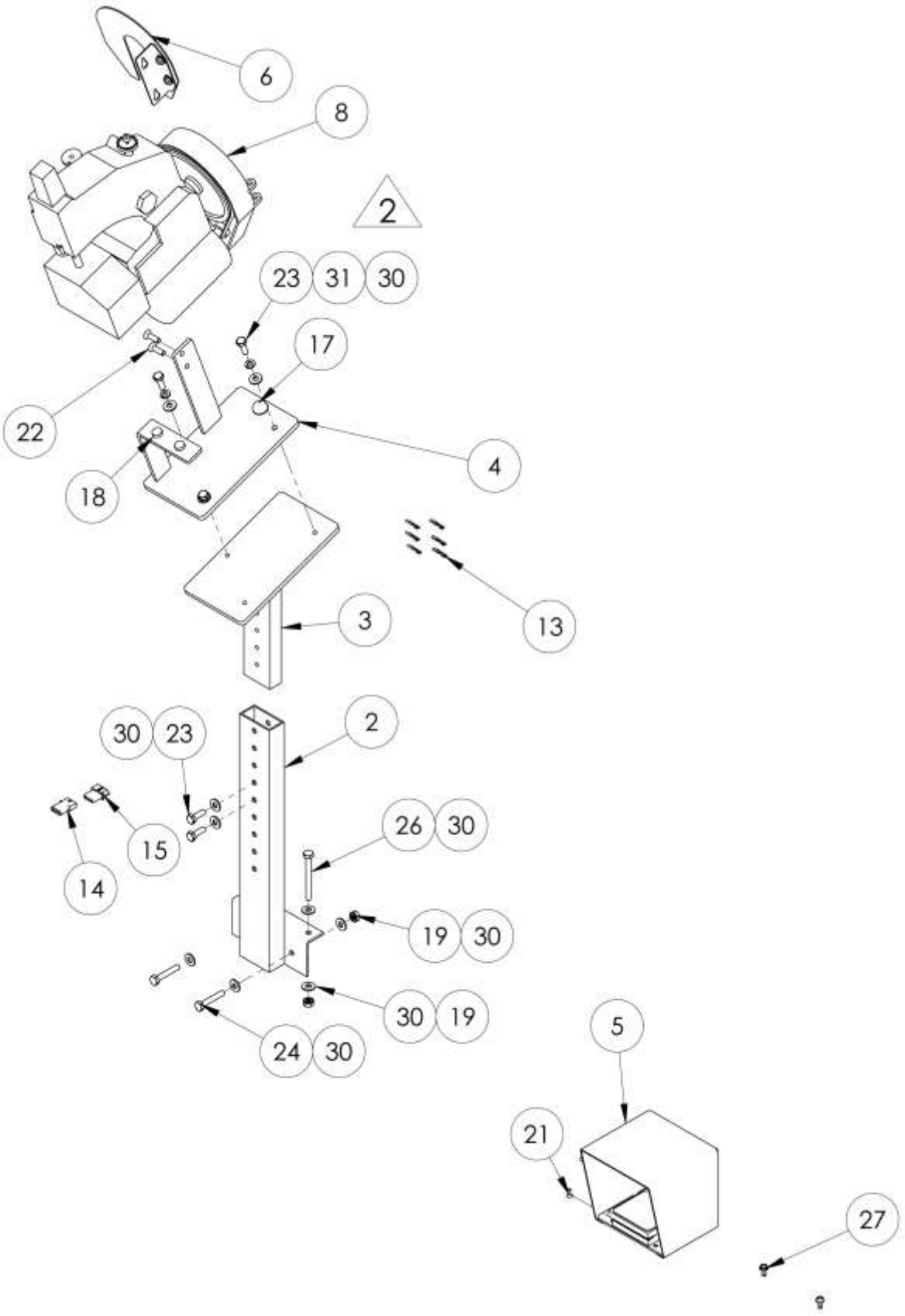
1312141 ROLL HOLDER ASSEMBLY

AAC Drawing Number 1312141 Rev 5

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	1312080	TUBE,F,CRS,1X2X48.38L,D	28	5	A-U	ROD CROSS BLOCK
2	2	1312086	SUPPORT, TENSIONER,DUAL	29	1	FFRK44T4EX3B	CABLE,EXTENSION,3 WAY
3	1	1312087	TUBE,HORIZ W/FLANGE	30	3	FFT18FF100Q	EYE,FIXED FIELD, 4IN
4	1	1312163	TUBE,14 GA, 1X2X24.00	31	4	MM132-1496	PLUG 1 X 2
5	1	1312229	SUPPORT BRACKET, ROLL HOLDER	32	2	MMFB4444	FOOT, RUBBER
6	1	1320724	ROD,BENT,1/2DIA, 2.5X5	33	3	NNH1/2-13	NUT,HEX,1/2-13
7	1	1325-346	HOLDER,ROD,1/2 D,SLOT MNT	34	6	NNK1/4-20	NUT,KEP,1/4-20
8	1	132556-273A	LEG,3/4X1-1/20X8.25L	35	2	NNK10-32	KEP NUT, 10-32
9	2	1335-319	ARM, ROD CLAMP	36	12	SSBC80024	6-32 X 3/8 BUTTON HEAD
10	3	1347093	SUPPORT, TENSIONER	37	4	SSHC01048	1/4-20 X 3/4 HEX CAP
11	1	1347097	SUPPORT, TENSIONER	38	6	SSHC01064	1/4-20 X 1 HHCS
12	4	1347254	ROD, 3/8S/S,18.75L	39	18	SSHC01096	1/4-20 X 1-1/2 HHCS
13	1	13553010	DUAL ROLL HOLDER ASSY	40	4	SSHC01176	1/4-20 X 2-3/4 HHCS
14	2	1961-211	PLATE, EDGE GUIDE	41	5	SSHC10048	5/16-18 X 3/4 HHCS
15	3	1961-251C	HUB, UNWIND SHAFT	42	1	SSHC10096	5/16-18 X 1-1/2 HHCS
16	7	1961-252D	ROD, ROLL, 27" L	43	1	SSSC45064	SCREW,SOC CAP,1/2-13 X 1"
17	3	1961-253A	HUB, UNWIND STAND	44	6	SSSC80024	6-32 X 3/8 SOC CAP SC
18	3	1961-255	BRACKET, SENSOR MTG	45	2	SSSC98112	SCR, SOC CAP 10-32 X 1-3/4
19	1	1962-3201	CLAMP, 3/4 ROD, 3" CTC	46	6	TTH32415	HANDLE,THDED,1/4-20X7/8
20	2	28201	CROSS BLOCK, 3/4 X 3/4	47	2	TTH32416	HANDLE,THRD,1/4-20X1-1/8
21	3	33008708	DISC ASSY,8"	48	3	TTH32425	HANDLE,THRDED,5/16-18X3/4
22	3	4009-1	DISC, MATERIAL CONTROL	49	1	TTH32426	HANDLE,THRD,5/16-18X1-1/4
23	2	784B-1414	PLATE, ALU, 14' X 14"	50	32	WWFS1/4	WASHER,FLAT,SAE,1/4
24	1	784B-2436	PLATE, ALU, 23.75 X 31.75	51	3	WWFS5/16	WASHER,FLAT,SAE,5/16
25	1	8724-0320SS	ROD, 3/8 X 5, S/S	52	4	WWFS10	WASHER, FLAT, #10, SAE
26	1	8732-1280	ROD, STRAIGHT, 1018	53	16	WWL1/4	WASHER,LOCK, 1/4
27	3	A-4-024	EDGE GUIDE, 2" DIA, 3/8B				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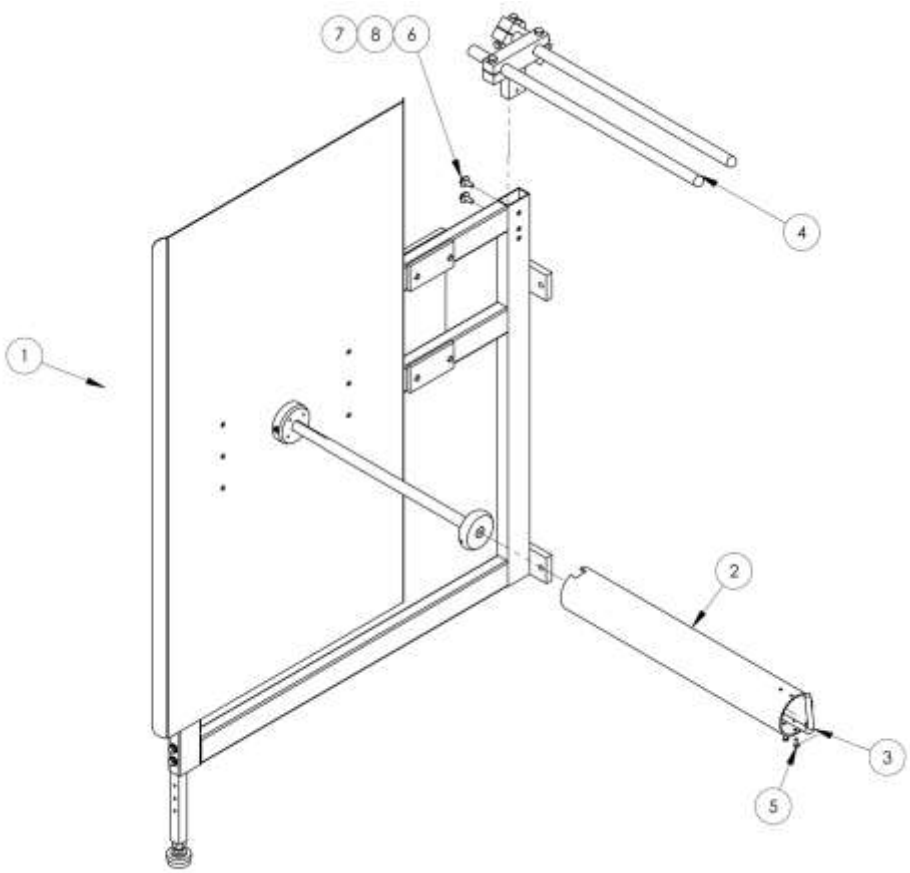
1961-KIT 10 BORDER SPLICING ASSEMBLY

AAC Drawing Number 9002027 Rev 9

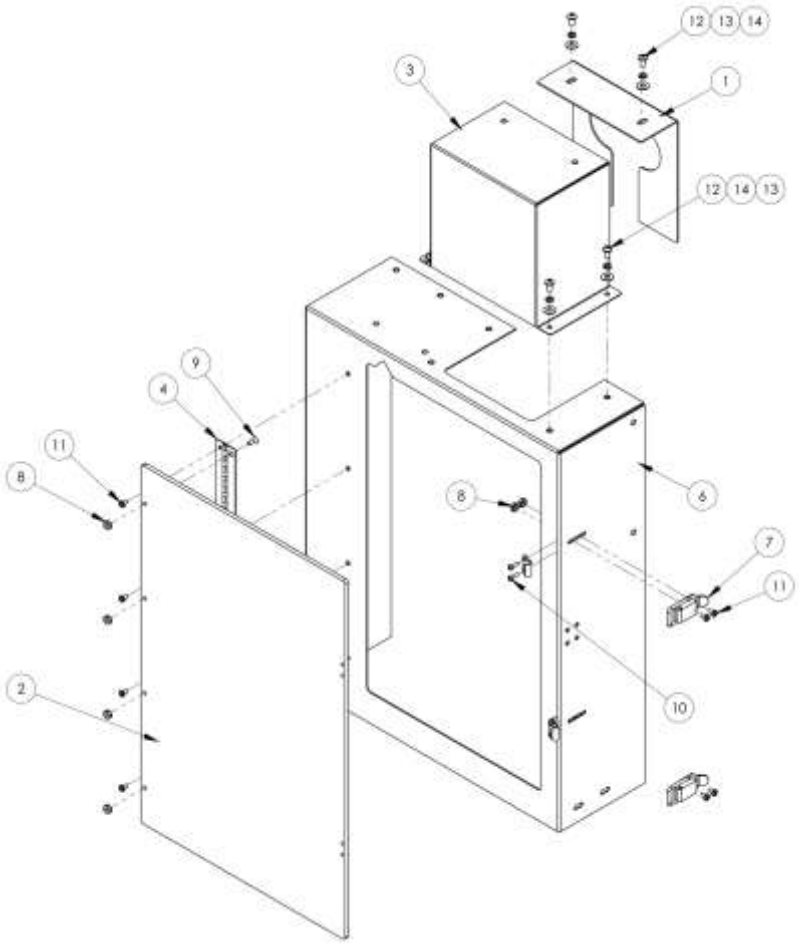
NO	QTY	PART #	DESCRIPTION
1	1	1278-6161	FOOT SWITCH MODIFICATION
2	1	1961-005	BASE,MNT,BAG CLOSER
3	1	1961-008	RISER,BAG CLOSER
4	1	1961-014	MTG BRKT,BAG CLOSER
5	1	1961171	PEDAL MOUNT PLATE,W/GUARD
6	1	1961175	GUARD ASSY, BC-1
7	6	AAF3/16	CLAMP, BLACK PLASTIC
8	1	BC-1	BORDER CLOSER MACHINE
9	1	BC-1LAB	LABEL
10	12	EE6X752	TIE WRAP - Small.
11	10'	EE18-2	BLACK TWO COND. CABLE
12	3	FF31F1022	PIN, MALE .093
13	3	FF31F1023	PIN, FEMALE .093
14	1	FF59F1798	CONNECTOR,FEMALE,3 PIN
15	1	FF59F1803	3 PIN MALE CONN
16	10'	FF19509	CABLE,3 COND,18 AWG,SJTOW
17	1	MMSJ5017	BUMPER,3M SJ5017
18	2	MMSLD-ECH	1/2" DIA RUBBER BUMPER
19	4	NNK1/4-20	NUT,KEP,1/4-20
20	10	SNDX1X25	NEEDLE
21	2	SSFC80024	6-32 X 3/8 FLAT CAP
22	2	SSFCM6X20	M6 X 20 FLAT ALLEN
23	5	SSHC01048	1/4-20 X 3/4 HEX CAP
24	2	SSHC01096	1/4-20 X 1-1/2 HHCS
25	2	SSHC01112	HEX HEAD BOLT 1/4-20X1.75
26	2	SSHC01160	1/4-20 X 2-1/2 HHCS
27	2	SSZS93032	SCREW, SHT.METAL 10 ZIP
28	2	TTAA5267	TERMINAL, FE,INS,18-22
29	1	W1061-3	NUT, WIRE
30	14	WWFS1/4	WASHER,FLAT,SAE,1/4
31	7	WWL1/4	WASHER,LOCK, 1/4



4500650 REWINDER BORDER

AAC Drawing Number 4500650 Rev 1

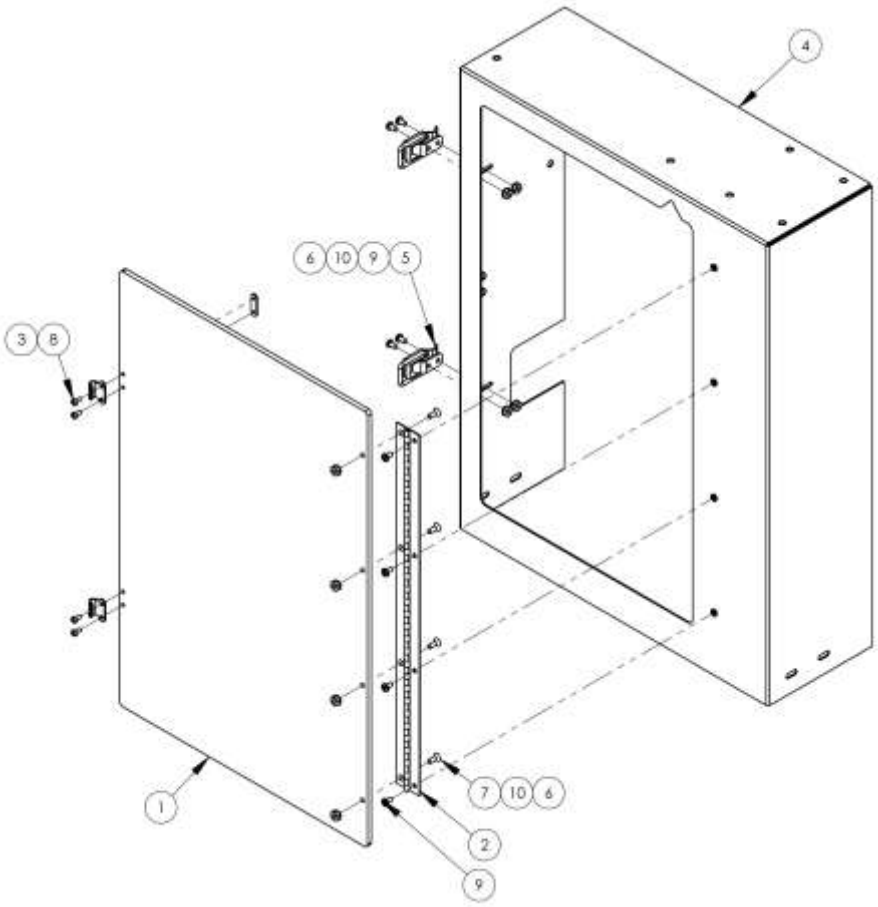
NO	QTY	PART #	DESCRIPTION
1	1	1961-320M	REWIND ASSY W/0 SLEEVE
2	1	1961-372	SLEEVE, REWIND, 18" CAP
3	1	1961-374A	HANDLE, SLEEVE
4	1	4500106	TENSION ROD ASSY
5	2	SSBC98032	10-32 X 1/2 BUTTON CAP SC
6	2	SSHC01048	1/4-20 X 3/4 HEX CAP
7	2	WWF1/4	WASHER, FLAT, 1/4", COM
8	2	WWL1/4	WASHER,LOCK, 1/4



4500230 GUARD, QUILTER LEFT SIDE

AAC Drawing Number 4500230 Rev 0

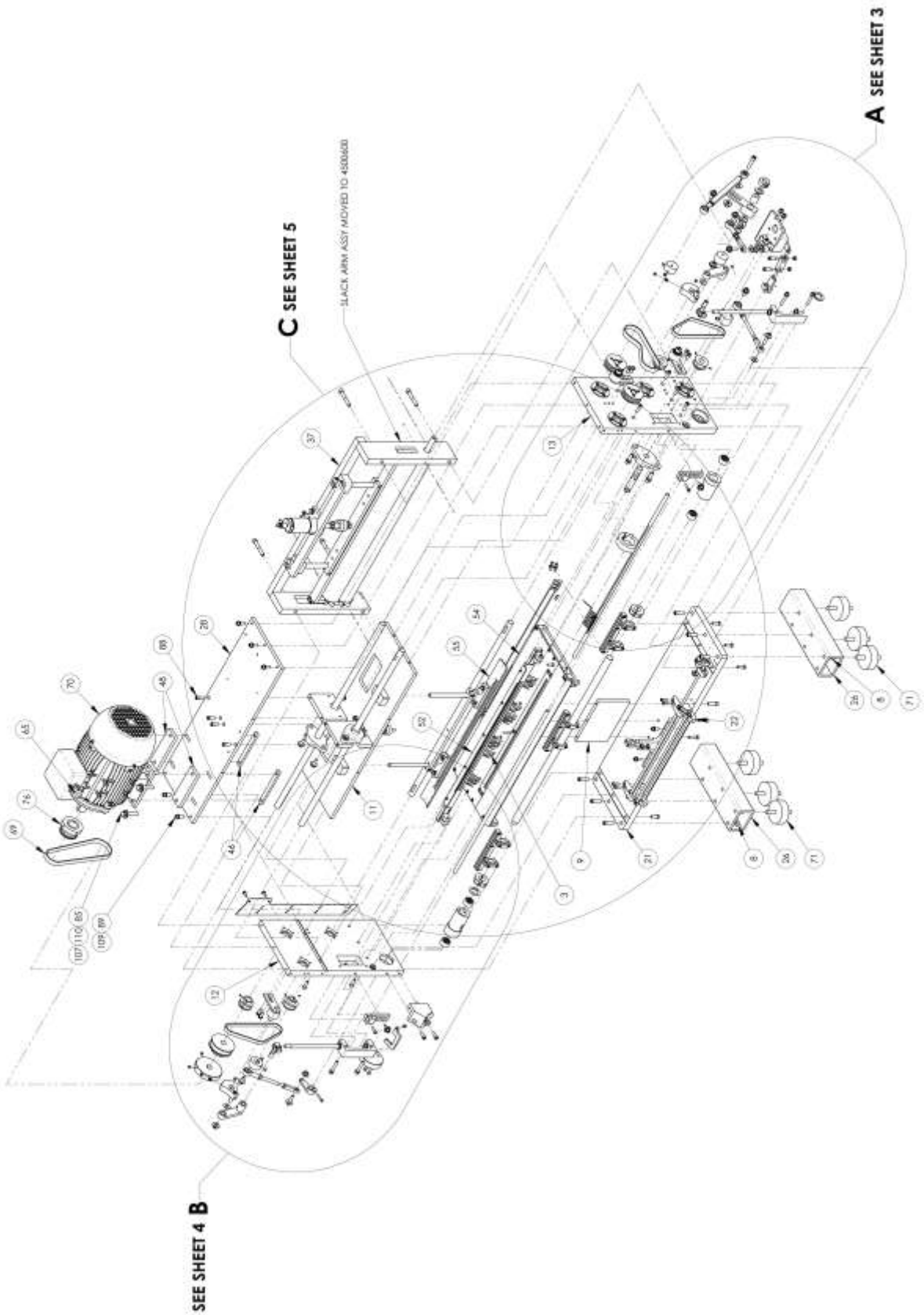
NO	QTY	PART #	DESCRIPTION
1	1	4500058	GUARD, BELT
2	1	4500124	GUARD, WINDOW
3	1	4500129	GUARD, MOTOR
4	1	4500229	HINGE,PIANO,S/S,1.06 OPEN
5	2	4500231	PLATE,NUT,4-40@.531CTC
6	1	4500832	GUARD, LT SIDE
7	2	MM1590A13	LATCH, DRAW PULL
8	8	NNK6-32	KEP NUT, 6-32
9	4	SSFC80024	6-32 X 3/8 FLAT CAP
10	4	SSPP70024	4-40 X 3/8 PAN HD PHIL
11	8	SSPP80016	#6-32X1/4 PAN PHILLIPS
12	6	SSPP98024	10-32 X 3/8 PAN HD PHILIP
13	6	WWF10	WASHER, FLAT, #10, COM
14	6	WWL10	WASHER,LOCK,#10

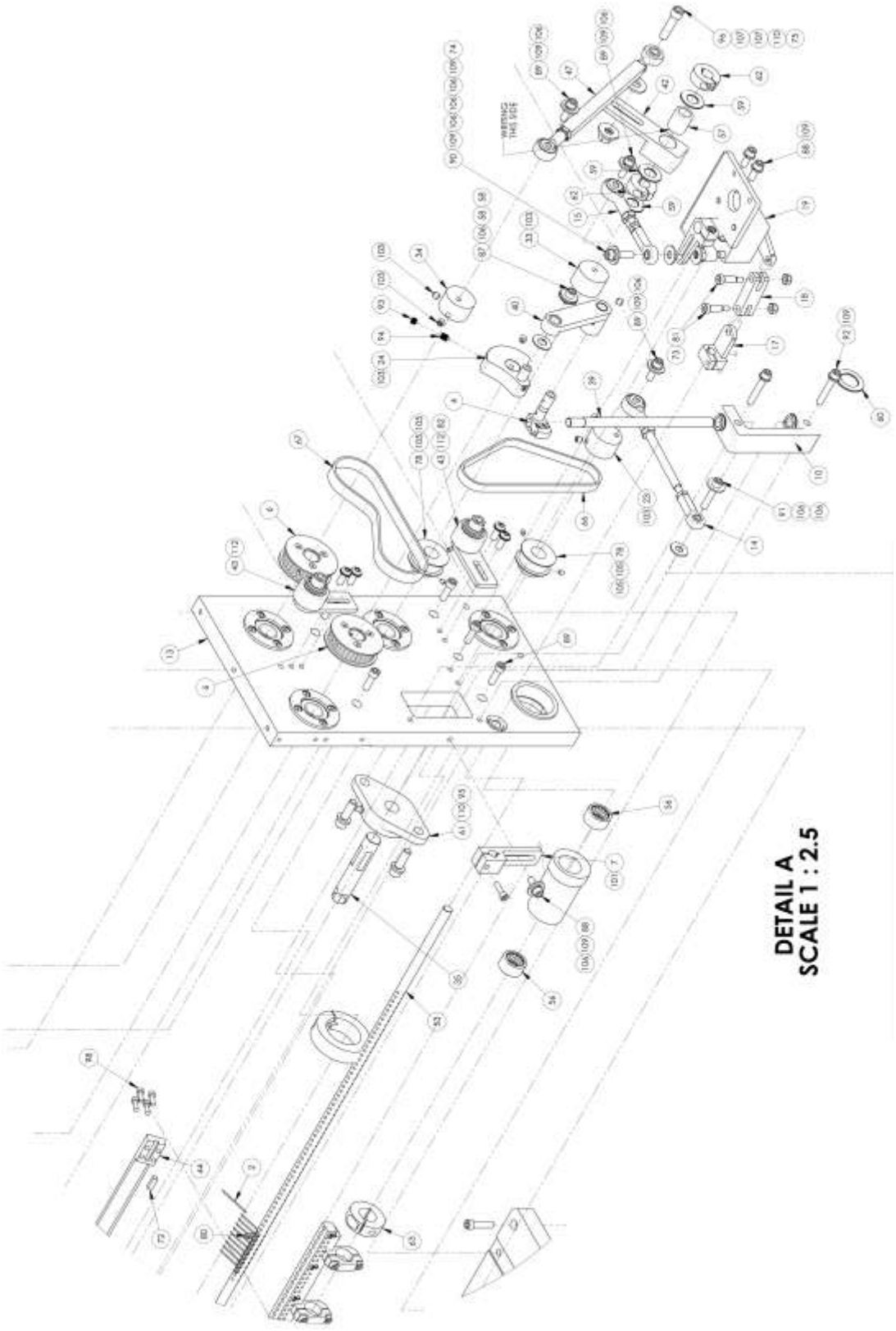


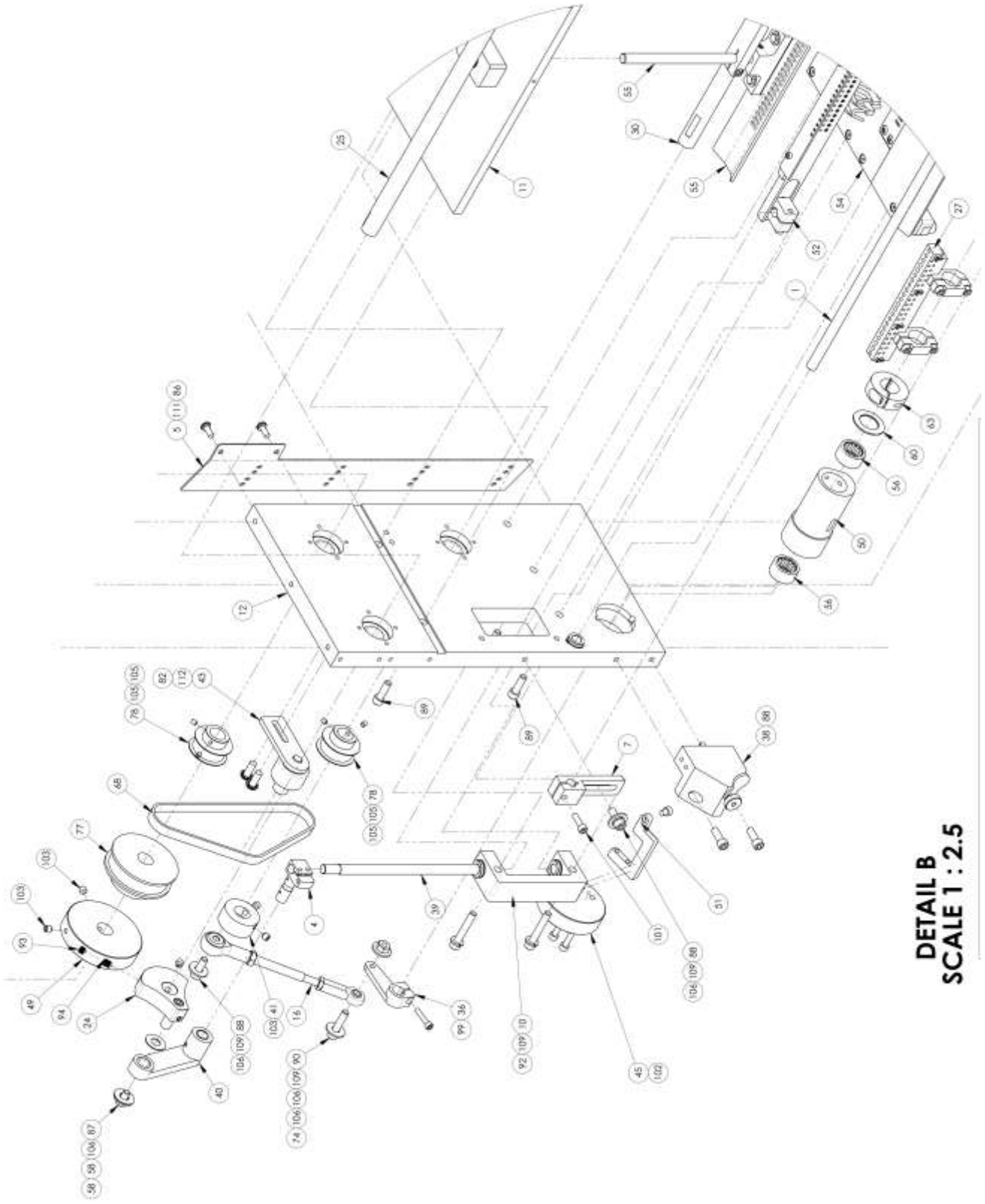
4500233 GUARD, QUILTER RIGHT SIDE

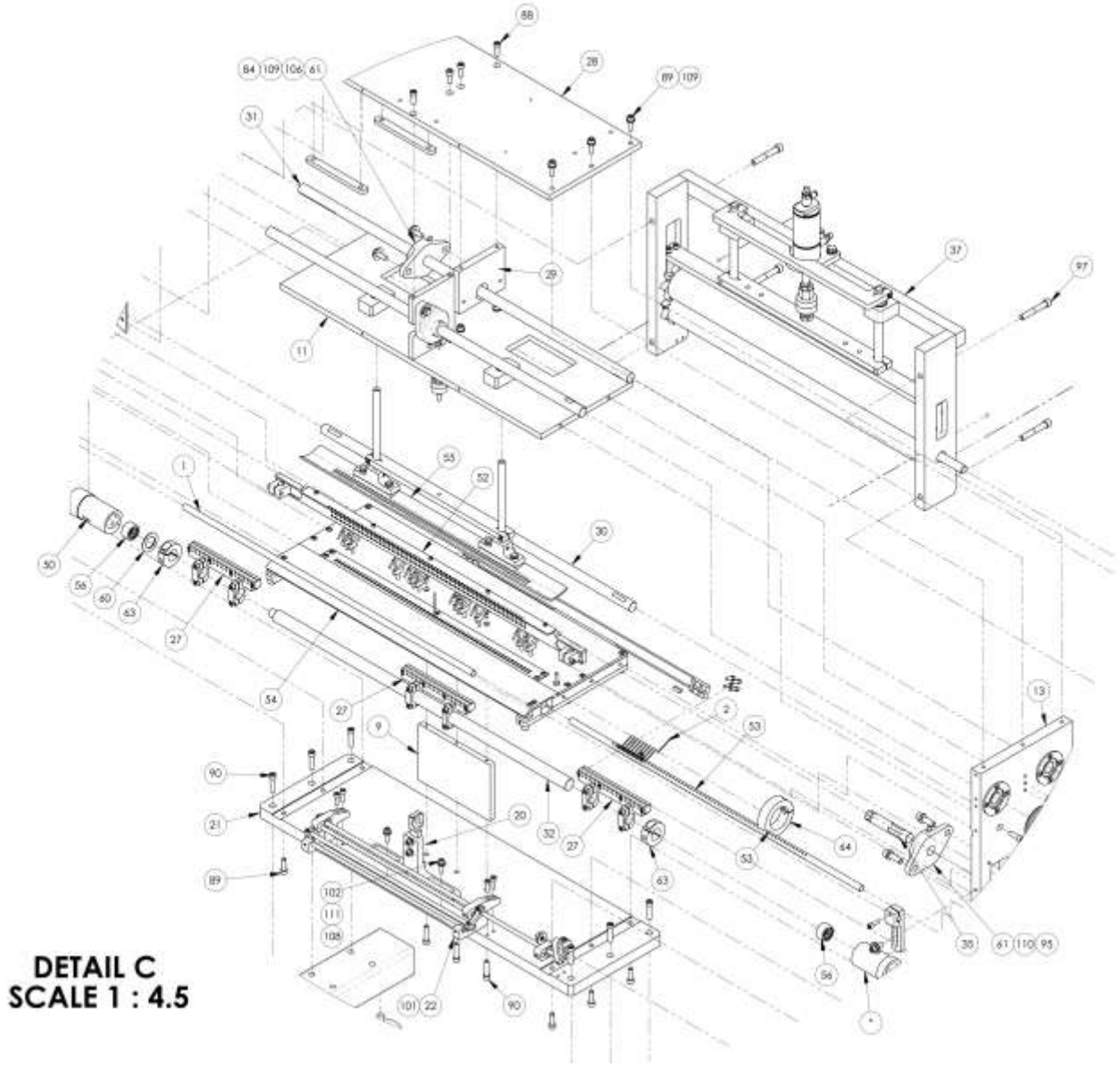
AAC Drawing Number 4500233 Rev 0

NO	QTY	PART #	DESCRIPTION
1	1	4500124	GUARD, WINDOW
2	1	4500229	HINGE,PIANO,S/S,1.06
3	2	4500231	PLATE,NUT,4-40@.531CTC
4	1	4500833	GUARD, RT SIDE
5	2	MM1590A1	LATCH, DRAW PULL
6	8	NNK6-32	KEP NUT, 6-32
7	4	SSFC80024	6-32 X 3/8 FLAT CAP
8	4	SSPP70016	4-40 X 1/4 PAN HD PHILLIP
9	8	SSPP80016	#6-32X1/4 PAN PHILLIPS
10	8	WWFS6	WASHER, FLAT, #6
11	4	WWL6	WASHER,LOCK,#6


A SEE SHEET 3
C SEE SHEET 5
SLACK ARM ASSY MOVED TO 4500600
SEE SHEET 4 B


DETAIL A
SCALE 1 : 2.5

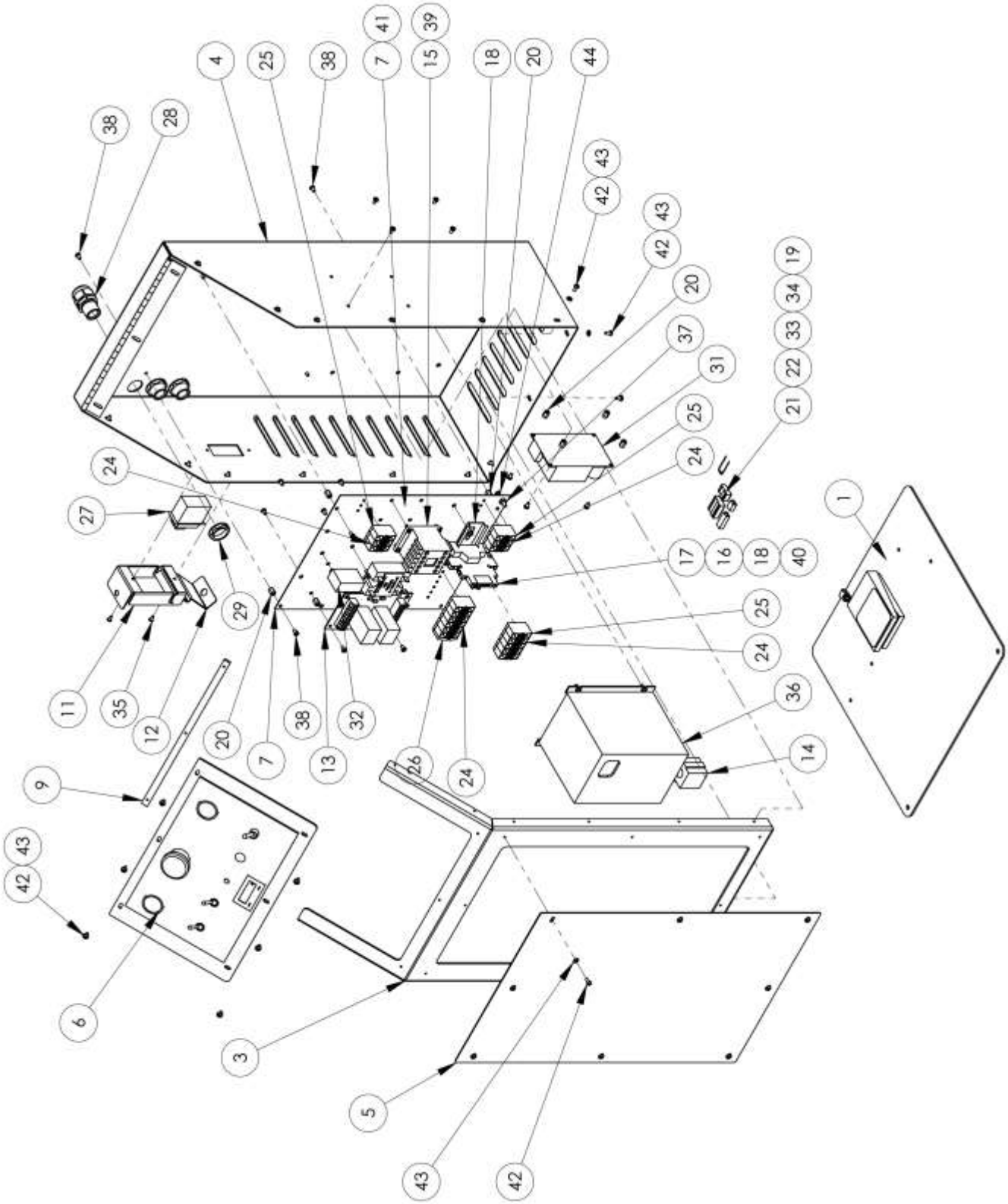

DETAIL B
SCALE 1 : 2.5


DETAIL C
SCALE 1 : 4.5

4500500 MULTI-NEEDLE QUILTER

AAC Drawing Number 4500500 Rev 10

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	1335Q-130A	ROD, SS 3/8 X 24	57	1	BBRCB081214	BEARING,NEEDLE,.500B,CLUTCH
2	10	66621	THREAD RETAINER	58	4	BBTRA613	WASHER,THRUST,STL, .375B
3	10	281208	LOOPER,300U SINGER	59	3	BBTT1001	WASHER,THRUST,BRONZE
4	2	415053	STUD,NEEDLE BAR	60	2	bbtt5906k517	BEARING,THRUST .75IDX1.25ODX.062
5	1	4500142	PLATE, CABLE GUIDE	61	2	BBVF2S-110	BRG,FLG BLK,5/8 B,2 BLT
6	2	4500190	GEAR PULLEY W / FLANGES	62	2	CCCL8F	CLAMP COLLAR- 1/2
7	2	4500227	CLAMP,ROD,3/8,ADJ	63	2	CCCL12F	CLAMP COLLAR- 3/4
8	2	4500255	PLATE, NUT	64	1	CCCL24F	COLLAR,CLAMP,1.5 BORE
9	1	4500267	MIDDLE SUPPORT BLOCK	65	1	EEPG16	CORD GRIP,CABLE ENTRY
10	2	4500275	NEEDLE BAR GUIDE ASSY	66	1	GG150XL037	BELT,GEAR,1/5P,3/8W
11	1	4500276	MIDDLE SUPPORT ASSY	67	1	GG154XL050	BELT,GEAR,1/5P,12W ,77T
12	1	4500277	LEFT SIDE PLATE ASSY	68	1	GG160XL037	BELT,GEAR,1/5P,3/8W
13	1	4500278	RIGHT SIDE PLATE ASSY	69	1	GG202L050	BELT,GEAR,3/8P,1/2W ,53T
14	1	4500279	LOOPER T/U ROD ASSY	70	1	MM90S11B3	MOTOR,1.1KW ,IEC,B3,1.5HP
15	1	4500280	SPREADER DRIVE ROD ASSY	71	6	MM9376K54	RUBBER ISOLATOR
16	1	4500281	LOOPER DRIVE ROD ASSY	72	2 @ .5"LG	MMKEY3/16	KEYSTOCK,3/16 SQ.
17	1	4500502	BLOCK, CLAMP	73	2	NNE10-24	NUT,ELASTIC LOCK
18	1	4500503	LINK, CONNECTOR	74	3	NNH1/4-20	NUT,HEX,1/4-20
19	1	4500508	ROCKER ASM, SPREADER BAR	75	1	NNH5/16-18	NUT,HEX, 5/16-18
20	1	4500509	SUPPORT, SPREADER BAR	76	1	PP15LF050M2	PULLEY,MOD
21	1	4500511	BASE, QUILTER	77	1	PP20LB050M6	PULLEY, 5/8 BORE MOD
22	1	4500518	LOOPER TAKE-UP ASM.	78	4	PP20XLB037M6	PULLEY 1/5P, 20T
23	1	4500521	TAKE-UP ECCENTRIC	79	1	SN328-22	NEEDLE 328,SIZE 22
24	2	4500522	CRANK,NEEDLE BAR	80	10	SS7080520SP	SCREW ,1/8-44X4.9MM
25	1	4500523	SHAFT, UPPER	81	2	SSAS016040	SHOULDER BOLT #10 X .375L
26	2	4500527	SPACER,BASE THREE ISO	82	6	SSBC01040	1/4-20 X 3/4 BUT CAP SC
27	3	4500534	LOOPER HOLDER ASSY	83	3	SSFC90024	8-32 X 3/8 FL ALN CAP
28	1	4500704	PLATE, TOP	84	2	SSHC01048	1/4-20 X 3/4 HEX CAP
29	1	4500720	PLATE, BEARING MOUNT	85	4	SSHC10112	SCREW ,HEX,5/16-18X1-3/4
30	1	4500729	SHAFT, MIDDLE	86	2	SSPP98032	10-32 X 1/2 PAN PHIL
31	1	4500730	SHAFT, UPPER	87	2	SSSC01024	1/4-20 X 3/8 SOC CAP SC
32	1	4500732	SHAFT,BOTTOM	88	11	SSSC01040	1/4-20 X 5/8" SOC CAP SC
33	1	4500734	SPREADER ECCENTRIC	89	25	SSSC01048	1/4-20 X 3/4" SOC CAP SC
34	1	4500735	PULLER ECCENTRIC	90	11	SSSC01064	1/4-20 X 1 SOC CAP
35	1	4500736	SHAFT, LOWER	91	1	SSSC01080	1/4-20 X 1-1/4 SOC CAP
36	1	4500743	DRIVE ARM, LOOPER	92	4	SSSC01096	1/4-20 X 1-1/2 SOC CAP
37	1	4500750	PULLER ASM, QUILTER	93	2	SSSC05016C	SCREW ,SOCKET SET,CONE PT
38	1	4500769	RETAINER, LOOPER ROCKER	94	2	SSSC05024C	SCREW ,SOCKET SET,CONE PT
39	2	4500772	SHAFT, NEEDLE BAR	95	2	SSSC10064	5/16-18 X 1 SOCKET CAP
40	2	4500774	CONNECTING ROD ASSY	96	1	SSSC10080	5/16-18 X 1-1/4 SOC CAP
41	1	4500776	LOOPER ECCENTRIC	97	4	SSSC10128	SCREW , SOCKET CAP
42	1	4500777	ARM, ROLLER DRIVER	98	8	SSSC90032	#8-32 X 1/2 SOC CAP SC
43	3	4500783	TENSION ASM, BELT	99	1	SSSC90048	#8-32 X 3/4 SOC CAP SC
44	1	4500786	BAR, CONNECTING	100	1	SSSC98016	10-32 X 1/4 SOC CAP
45	1	4500788	KNOB, LOOPER	101	9	SSSC98040	10-32 X 5/8 SOC CAP
46	2	4500799	PLATE, NUT	102	4	SSSC98048	10-32 X 3/4 SOC CAP
47	1	4500800	PITMAN ROD, 9"	103	12	SSSS01016	1/4-20 X 1/4 KNURL PT
48	2	4500834	SPACER	104	2	SSSS05016	1/4-28 X 1/4 SOC SET SC
49	1	4500839	HAND WHEEL, MINI-QUILTER	105	8	SSSS90012	8-32 X 3/16 SOC SET SC
50	1	4500845	BEARING, ECCENTRIC	106	18	WWF1/4	WASHER, FLAT, 1/4", COM
51	1	4500846	ARM, LOOPER ADJ.	107	6	WWF5/16	WASHER,FLAT,5/16
52	1	4500850	NEEDLE BAR ASSY	108	2	WWF10	WASHER, FLAT, #10, COM
53	1	4500854	ROD, SPREADER, 16"	109	24	WWL1/4	WASHER,LOCK, 1/4
54	1	4500855	MATERIAL PLATE, 16"	110	7	WWL5/16	WASHER,LOCK, 5/16
55	1	4500859	FOOT ASSY, 1/4GA X 16"	111	4	WWL10	WASHER,LOCK,#10
56	4	BBB-128	BEARING, NEEDLE	112	6	WWSI1/4	WASHER,INTERNAL TOOTH,1/4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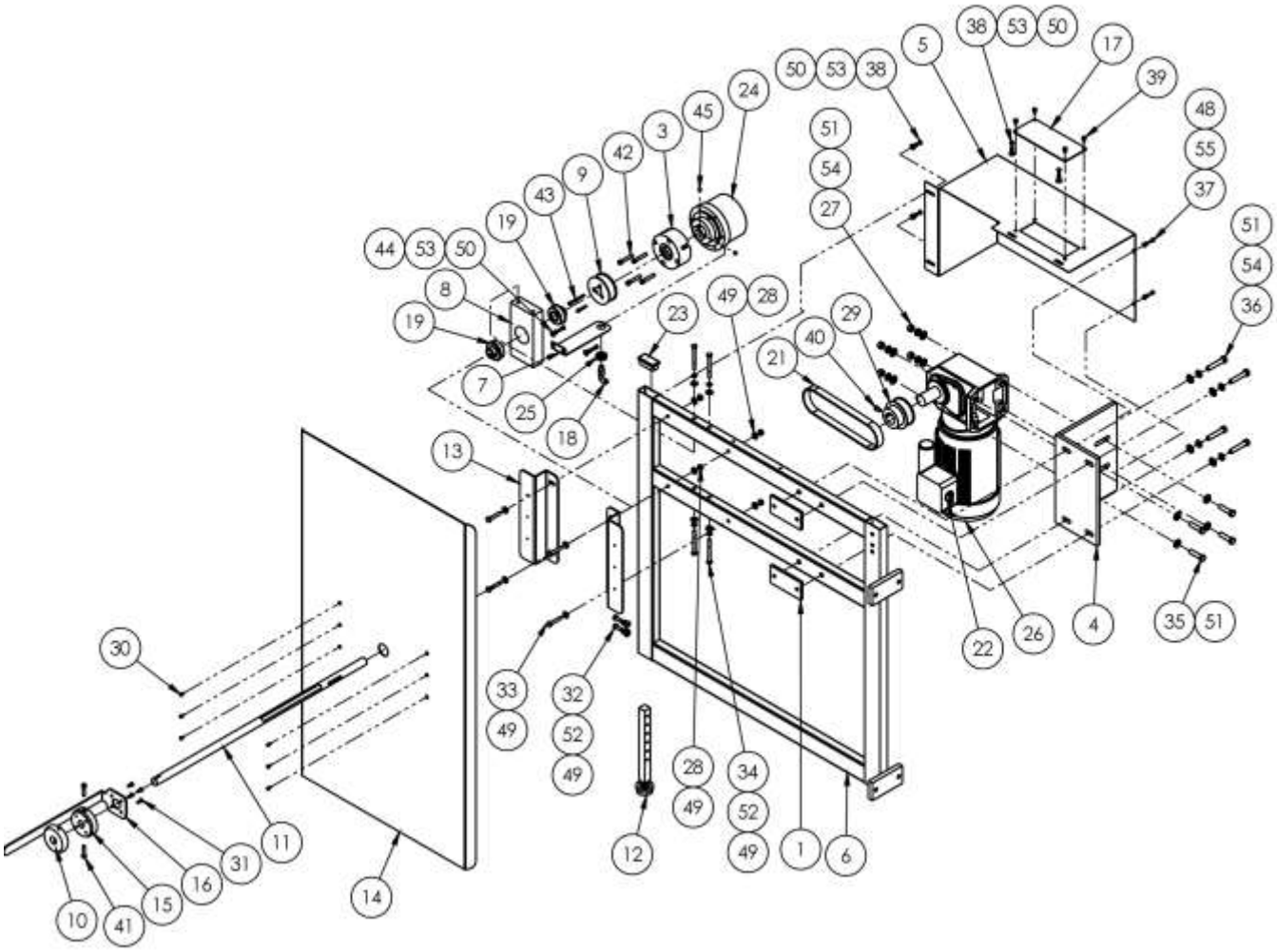
1312133 CONTROL BOX

AAC Drawing Number 1312133 Rev 4

NO	QTY	PART#	DESCRIPTION
1	1	1278-6160M	FOOT PEDAL ASSY, 1 PEDAL
3	1	1312N65-WD	DIAGRAM,WIRING
3	1	1312130	CONTROL PANEL,FRONT
4	1	1312132	CONTROL BOX,BACK
5	1	1312135	COVER,CONTROL BOX
6	1	1312144	CONTROL BUTTON PANEL
7	1	1312145	SUB PANEL
8	*1	1312149	CABLE.PACKAGE
9	1	1312155	NUT PLATE, 6-32 X 3
10	*1	1961-909A	CABLE, FOOT PRDAL
11	1	40-322	BOTTOM, AC POWER LOCKOUT
12	1	40-323	TOP, AC POWER LOCKOUT
13	1	4000D-02	PC BOARD, RELAY
14	1	EE64151B	FERRITE CORE,SPLIT,CABLE
15	1	EECA491024	CONTACTOR, MINI, 240V
16	2	EECLIPFIX	ANCHOR,DIN RAIL
17	1	EEPIR6W1P24	RELAY,INTERFACE,24VDC
18	3 IN	EETS35X7.5A	DIN RAIL-AMERICAN
19	1	FF1N4937	DIODE,FAST 200NS,1A
20	12	FF67F4078	SPACER,THREADED 3/8 L
21	1	FF156F1803	CONN,18GA,3P,ORN
22	1	FF156F1806A	CONN,18GA, 6P,ORN
23	*1	FF156F1806H	CONN IDC, 1X6, .156,
24	14	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
25	3	FF264-347	TERMBLK,WAGO,TOP,DUAL,GRN
26	1	FF264-371	TERMBLK,WAGO,TOP,END
27	1	FF3120L420A	CIRCUIT BREAKER, THERMAL
28	9	FF3200	STRAIN RELIEF,1/2NPT
29	9	FF8463	NUT,LOCK,1/2NPT,NYLON,BLK
30	1	FFD2425F	RELAY,SSR,24VAC,25A
31	1	FFNFS40	POWER SUPPLY,SWITCHING
32	1	FFRAV781BW	MODULE, TVS, 240 VAC
33	1	FFSC15603	COVER, STRAIN RELIEF
34	1	FFSC15606	COVER, STRAIN RELIEF
35	2	MM4X641	1/8" RIVET ALUM
36	1	MMSM220S	DRIVE, VARIABLE FREQ.
37	1	NNH8-32	HEX-NUT 8-32 REG.
38	24	SSPP80016	#6-32X1/4 PAN PHILLIPS
39	4	SSPP80024	#6-32X3/8 PAN PHILLIPS
40	6	SSPP90020	SCREW,PHP #8-32X5/16
41	3	SSPP90024	8-32X3/8 PAN PHLPS
42	29	SSPS80020	#6-32 X 5/16 LG PAN HD
43	29	WWFS6	WASHER, FLAT, #6
44	1	WWSI8	WASHER,INT. TOOTH,8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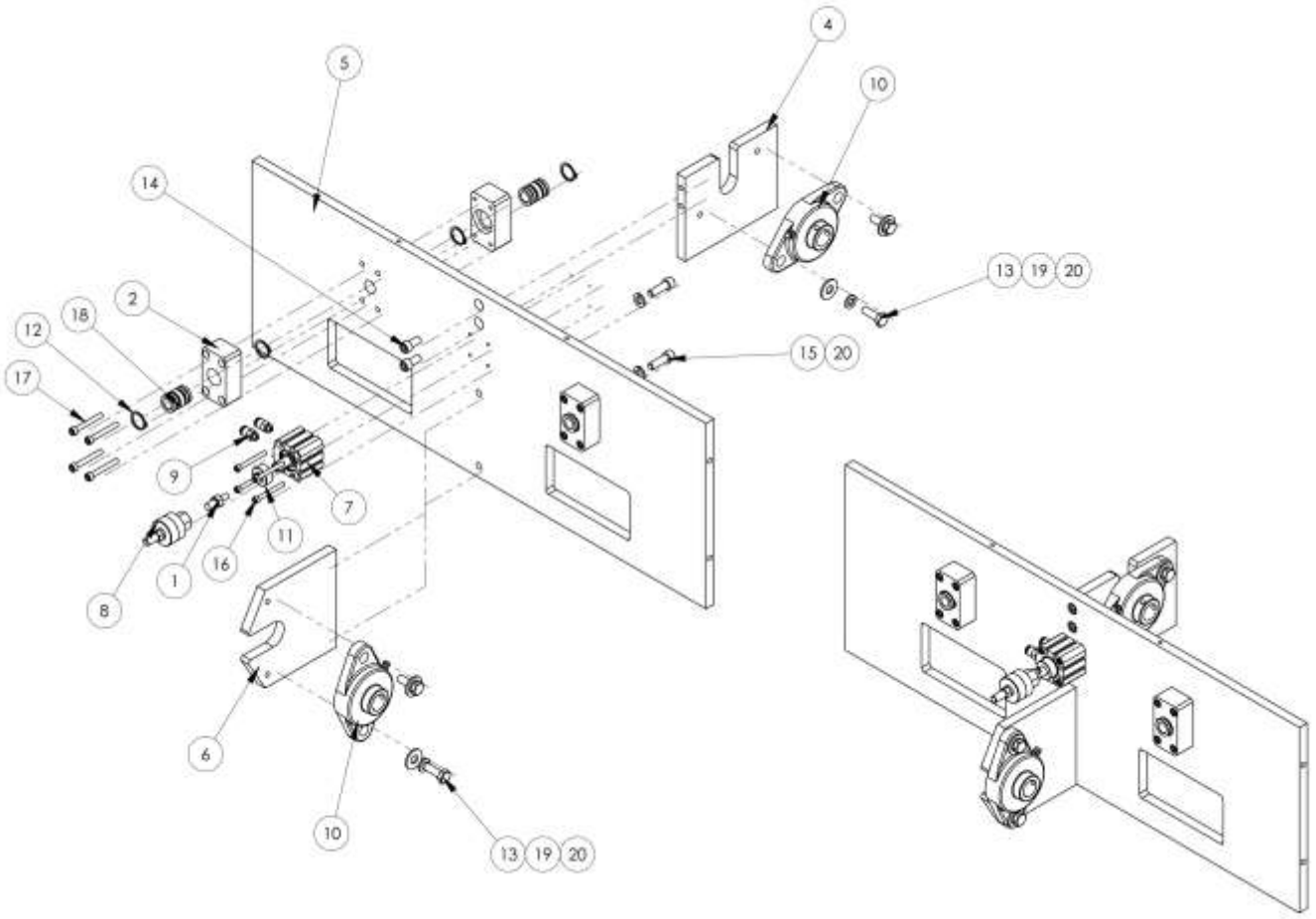
1961-320M REWIND ASSEMBLY W/O SLEEVE

AAC Drawing Number 9001619 Rev 5

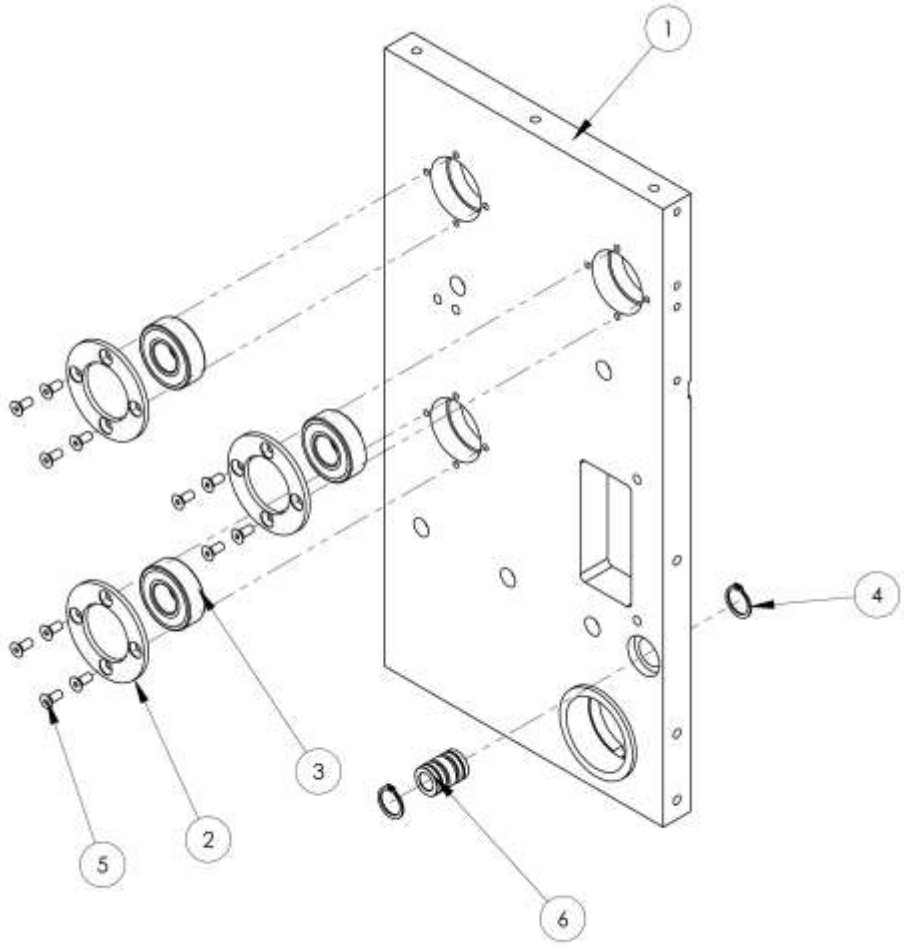
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	2	1961-319	PLATE,NUT,3/8-16@3.00 CTC	28	2	SSHC01048	1/4-20 X 3/4 HEX CAP
2	*AR	1961-320SWD	WIRING DIAGRAM,1/2HP MTR	29	4	SSHC01096	1/4-20 X 1-1/2 HHCS
3	1	1961-321	PLATE, ADAPTOR, AIR CLUTC	30	4	SSHC01160	1/4-20 X 2-1/2 HHCS
4	1	1961-331	MOUNT,MOTOR	31	4	SSHC25096	3/8-16 X 1 1/2 HHCS
5	1	1961-332	COVER,MOTOR	32	4	SSHC25128	3/8-16 X 2 HEX CAP
6	1	1961-335	FRAME, PREFEED & REWIND A	33	2	SSPP90024	8-32X3/8 PAN PHLPS
7	1	1961-354B	SUPPORT, AIR CLUTCH	34	4	SSPP98032	10-32 X 1/2 PAN PHIL
8	1	1961-365B	BLOCK, BEARING MOUNT	35	4	SSPS95024	#10-24 X 1/4 PAN HD SLTD
9	1	1961-366A	PULLEY,CLUTCH,22 TH,3/8 P	36	1	SSSC01024	1/4-20 X 3/8 SOC CAP SC
10	1	1961-379	SUPPORT,REWIND SLEEVE	37	2	SSSC01064	1/4-20 X 1 SOC CAP
11	1	1962-375	SHAFT, AIR CLUTCH, MM8028	38	4	SSSC01096	1/4-20 X 1-1/2 SOC CAP
12	1	26238	LEG SUB-ASSEMBLY	39	3	SSSC90064	#8-32 X 1 SOC CAP SC
13	1	1334376	PLATE, REWIND,24 X 40	40	2	SSSC98032	10-32X1/2, SOC CAP
14	1	1334388	HUB, TAKEUP SPINDLE	41	2	SSSS01016	1/4-20 X 1/4 KNURL PT
15	1	1961104	COVER, INSPECTION	42	1	TT5802	TERMINAL RING, #10 STUD
16	1	AAQMEL-5-8	QUICK MALE ELBOW,LONG	43	3	W1061-3	NUT, WIRE
17	2	BBS8703-88	BEARING,BALL,.75IDX1.75OD	44	2	WWF8	WASHER, FLAT, #8
18	*12 FT	EE16-4	CABLE,4 COND,16 AWG, SJO	45	14	WWFS1/4	WASHER,FLAT,SAE,1/4
19	1	K-235A	CONNECTOR,ROMEX,3/4"	46	6	WWFS10	WASHER, FLAT, #10, SAE
20	1	MM132-1496	PLUG 1 X 2	47	12	WWFS3/8	WASHER,FLAT,SAE,3/8
21	1	MM802860	CLUTCH,AIR,3/4 BORE,4.5"D	48	6	WWL1/4	WASHER,LOCK, 1/4
22	1	MM9600K21	GROMMET,RUBBER,9/16 ID	49	6	WWL10	WASHER,LOCK,#10
23	1	MMBH2LM22R	MOTOR,GEAR,R/A,220V	50	8	WWL3/8	WASHER,LOCK, 3/8
24	4	NNH3/8-16	NUT,HEX,3/8-16	51	2	WWL8	WASHER,LOCK,#8
25	4	NNK1/4-20	NUT,KEP,1/4-20	52	1	GG225L075	BELT, 3/8P, 60T, 3/4W
26	1	PP22LB075-1-1/8	PULLEY, GEAR, 3/8P, 22T	53	2	1334326	MOUNT, FLANGE
27	6	SSFC80024	6-32 X 3/8 FLAT CAP				



4500276 MIDDLE SUPPORT ASSEMBLY

AAC Drawing Number 4500276 Rev 0

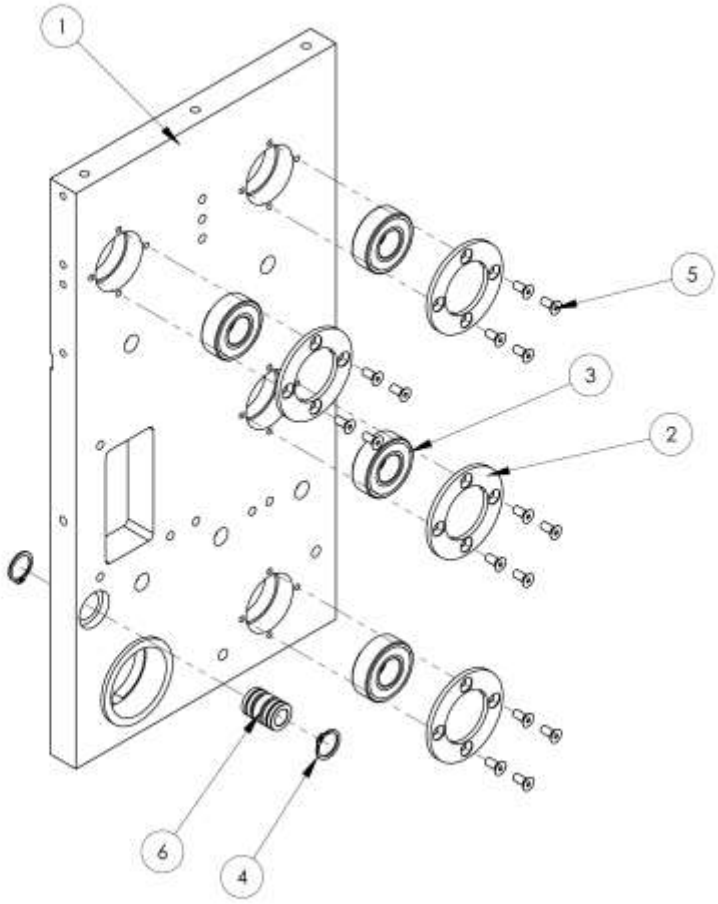
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	4500010	BOLT, ADAPTER	11	1	CCCL5F	CLAMP COLLAR,5/16" BORE
2	2	4500016	GUIDE, FOOT ROD	12	8	MMSH-59	RING,SNAP,EXTERNAL
3	2	4500516	GUIDE, FOOT ROD	13	4	SSHC01048	1/4-20 X 3/4 HEX CAP
4	1	4500525	BEARING MNT, TOP FRONT	14	2	SSSC01032	1/4-20X1/2 SOC CAP
5	1	4500526	PLATE, MIDDLE SUPPORT	15	2	SSSC01048	1/4-20 X 3/4" SOC CAP SC
6	1	4500719	PLATE, CENTER BEARING	16	4	SSSC80080	6-32 X 1-1/4 SOC CAP SC
7	1	AACF040.5	CYLINDER,AIR,FLAT	17	8	SSSC90080	#8-32 X 1-1/4 SOC CAP SC
8	1	AAF250	COUPLING,ALIGNMENT	18	4	UUFL06	BEARING, LINEAR, 3/8ID
9	2	AAQMC-5-10	QUICK MALE, 5/32 X 10-32	19	4	WWF1/4	WASHER, FLAT, 1/4", COM
10	2	BBVF2S-110	BRG,FLG BLK,5/8 B,2 BLT	20	6	WWL1/4	WASHER,LOCK, 1/4



4500277 LEFT SIDE PLATE ASSEMBLY

AAC Drawing Number 4500277 Rev 0

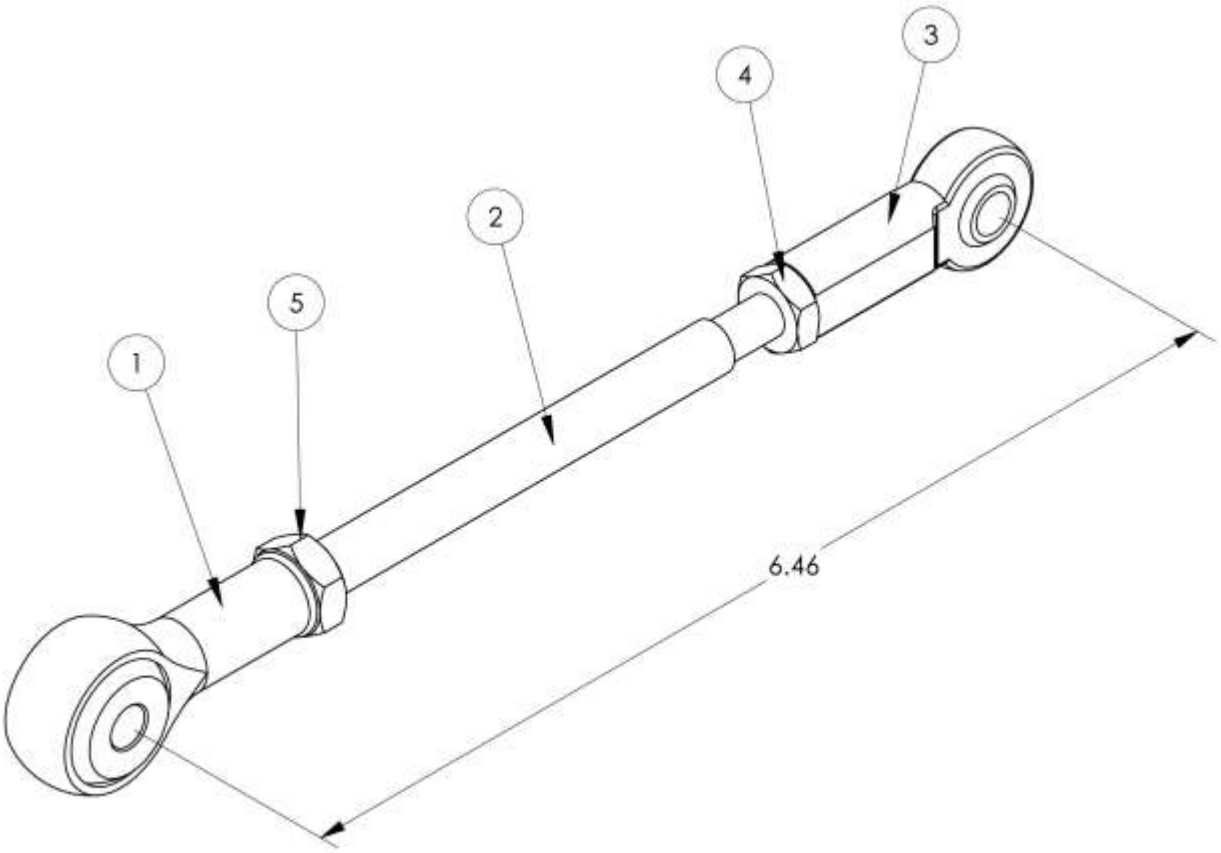
NO	QTY	PART #	DESCRIPTION
1	1	4500520	PLATE, LEFT SIDE
2	3	4500706	RETAINER, BEARING
3	3	BB1623DCTN	BEARING, BALL,.625B
4	2	MMSH-59	RING,SNAP,EXTERNAL
5	12	SSFC90024	8-32 X 3/8 FL ALN CAP
6	1	UUFL06	BEARING, LINEAR, 3/8ID



4500278 RIGHT SIDE PLATE ASSEMBLY

AAC Drawing Number 4500278 Rev 0

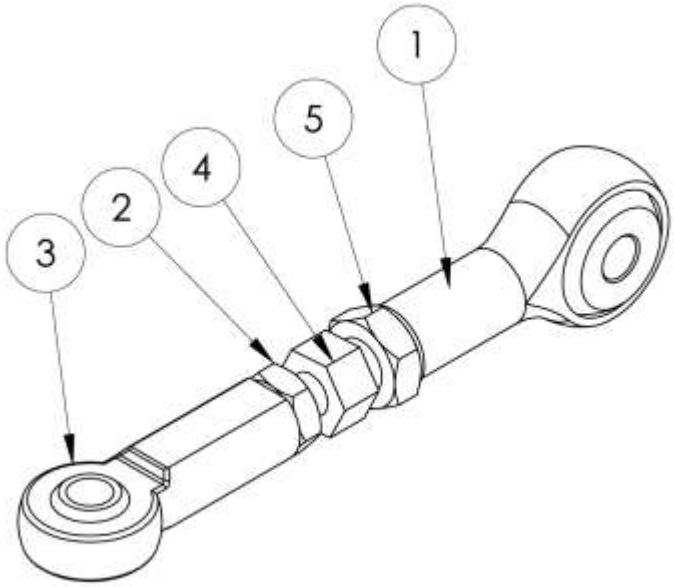
NO	QTY	PART #	DESCRIPTION
1	1	4500519	PLATE, RIGHT SIDE
2	4	4500706	RETAINER, BEARING
3	4	BB1623DCTN	BEARING, BALL,.625B
4	2	MMSH-59	RING,SNAP,EXTERNAL
5	16	SSFC90024	8-32 X 3/8 FL ALN CAP
6	1	UUFL06	BEARING, LINEAR, 3/8ID



4500279 LOOPER T/U ROD ASSEMBLY

AAC Drawing Number 4500279 Rev 0

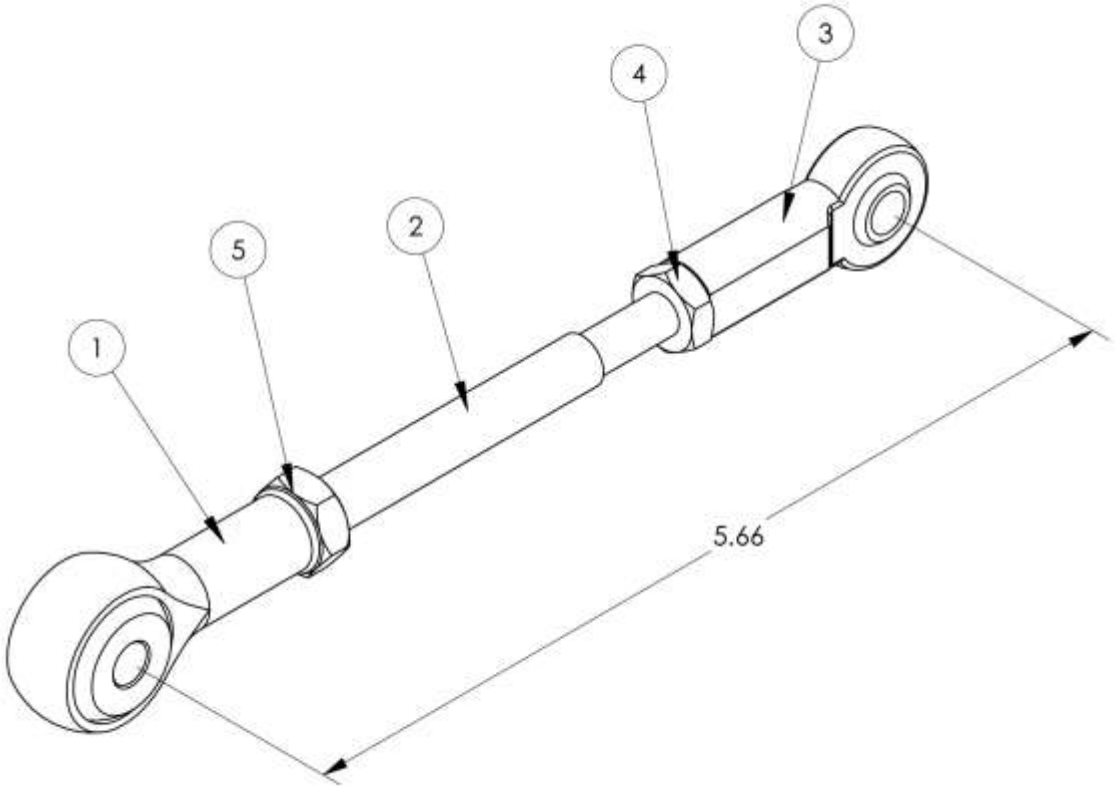
NO	QTY	PART #	DESCRIPTION
1	1	1325-12	ROD END, BB
2	1	4500261	ROD, ADJUSTMENT
3	1	BBAW-4	BEARING,ROD END,FEMALE
4	1	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
5	1	NNJ5/16-24	NUT,JAM,5/16-24



4500280 SPREADER DRIVE ROD ASSEMBLY

AAC Drawing Number 4500280 Rev 0

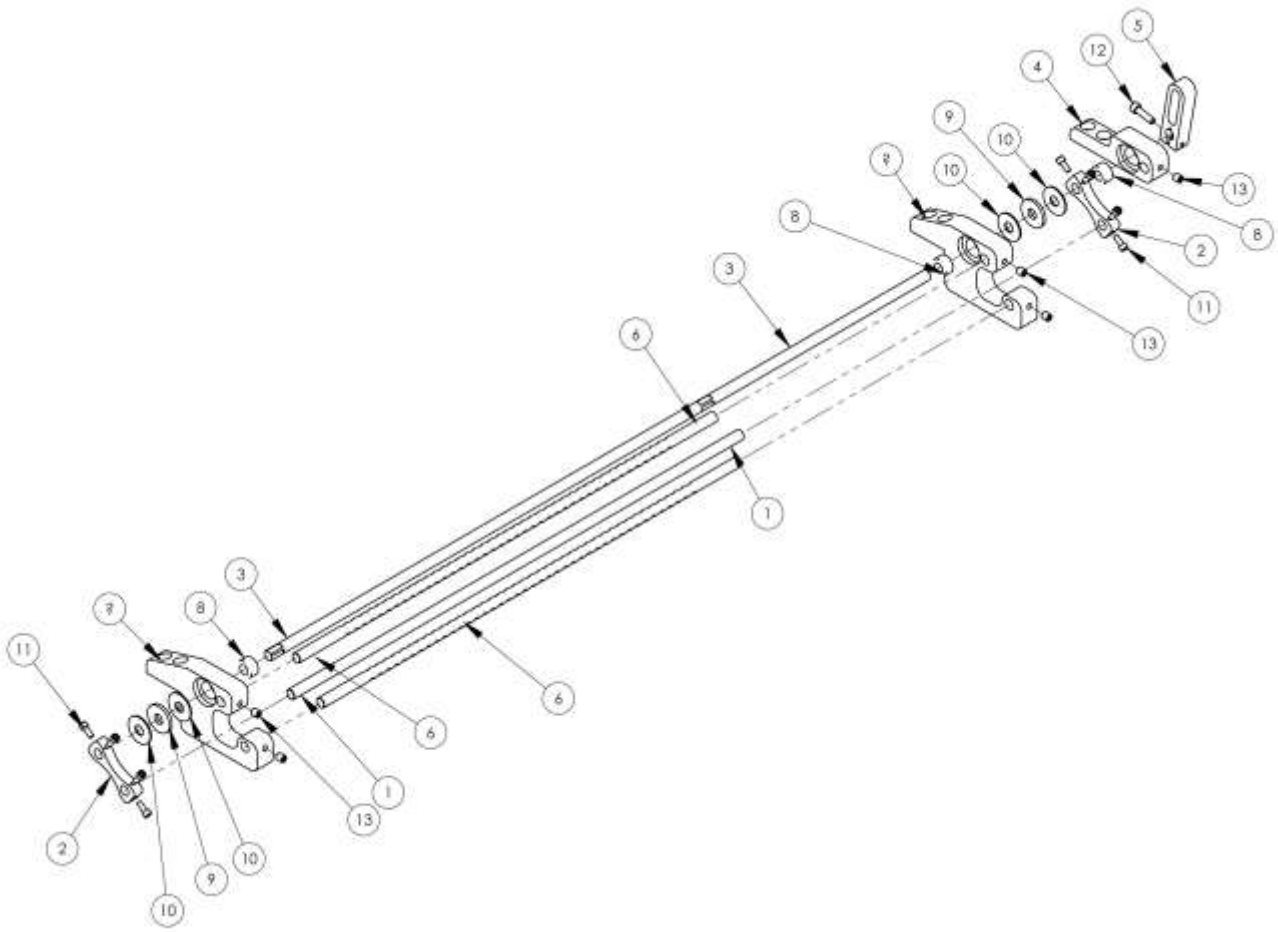
NO	QTY	PART #	DESCRIPTION
1	1	1325-12	ROD END, BB
2	1	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
3	1	BBAW-4	BEARING,ROD END,FEMALE
4	1	4500260	ROD, ADJUSTMENT
5	1	NNJ5/16-24	NUT,JAM,5/16-24



4500281 LOOPER DRIVE ROD ASSEMBLY

AAC Drawing Number 4500281 Rev 0

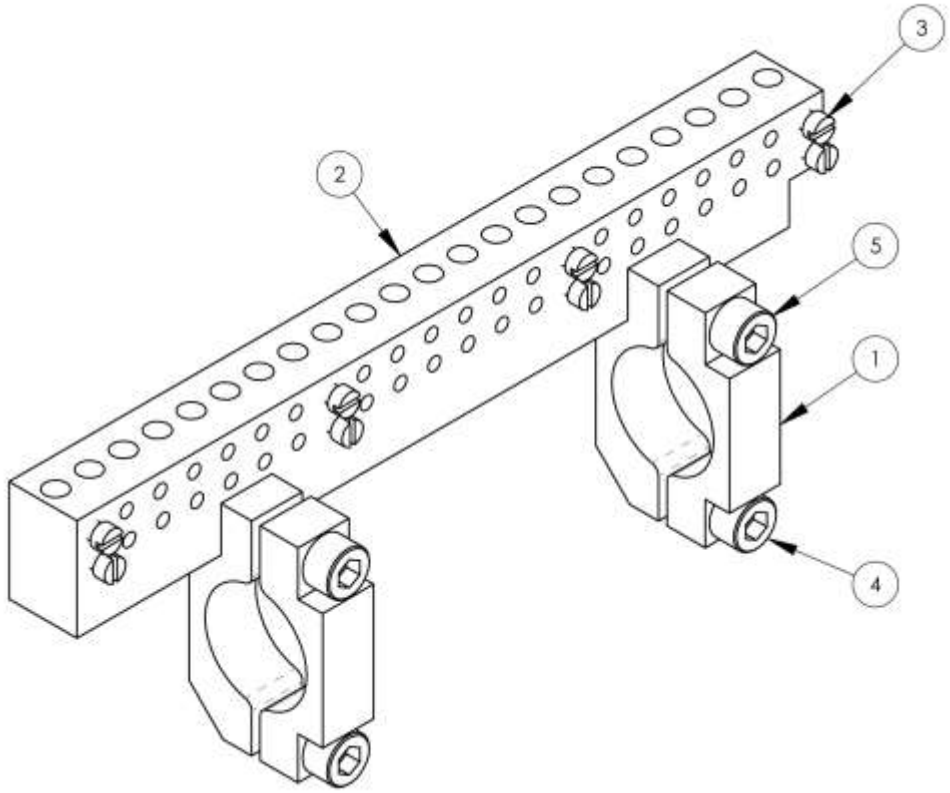
NO	QTY	PART #	DESCRIPTION
1	1	1325-12	ROD END, BB
2	1	4500265	ROD, ADJUSTMENT
3	1	BBAW-4	BEARING,ROD END,FEMALE
4	1	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
5	1	NNJ5/16-24	NUT,JAM,5/16-24



4500518 LOOPER TAKE-UP ASSEMBLY

AAC Drawing Number 4500518 Rev 0

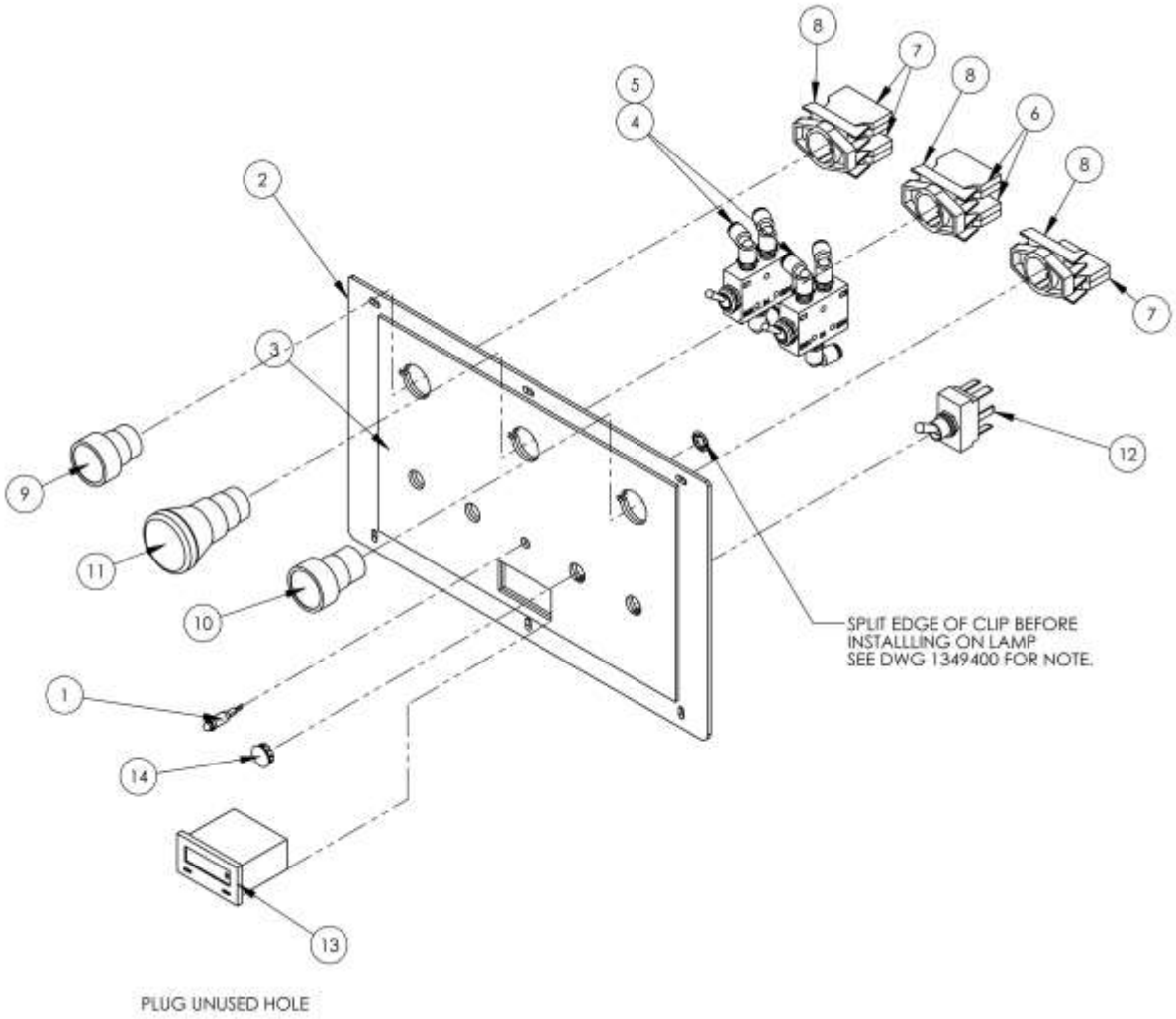
NO	QTY	PART #	DESCRIPTION
1	1	4500524	GUIDE ROD
2	2	4500807	ARM, SWING
3	1	4500809	ROD, DRIVER
4	1	4500810	BLOCK, BEARING
5	1	4500811	ARM, LINK
6	2	4500812	FIXED ROD
7	2	4500840	BLOCK, BEARING,DUAL ROD
8	3	BBB-44	BEARING,NEEDLE,.250B
9	2	BBNTA411	BEARING,THRUST,.250B
10	4	BBTRA411	WASHER,THRUST,STEEL
11	8	SSSC70016	4-40 X 1/4 SOCKET CAP
12	1	SSSC80032	6-32 X 1/2 SOC CAP SC
13	5	SSSS90012	8-32 X 3/16 SOC SET SC



4500534 LOOPER HOLDER ASSEMBLY

AAC Drawing Number 4500534 Rev 1

NO	QTY	PART #	DESCRIPTION
1	2	4500532	LOOPER HOLDER CLAMP
2	1	4500533	LOOPER HOLDER, 22 POS
3	8	SSM350478	FILISTER,7/64-48, 17/64L
4	2	SSSC98048	10-32 X 3/4 SOC CAP
5	2	SSSC98064	10-32 X 1 SOC CAP

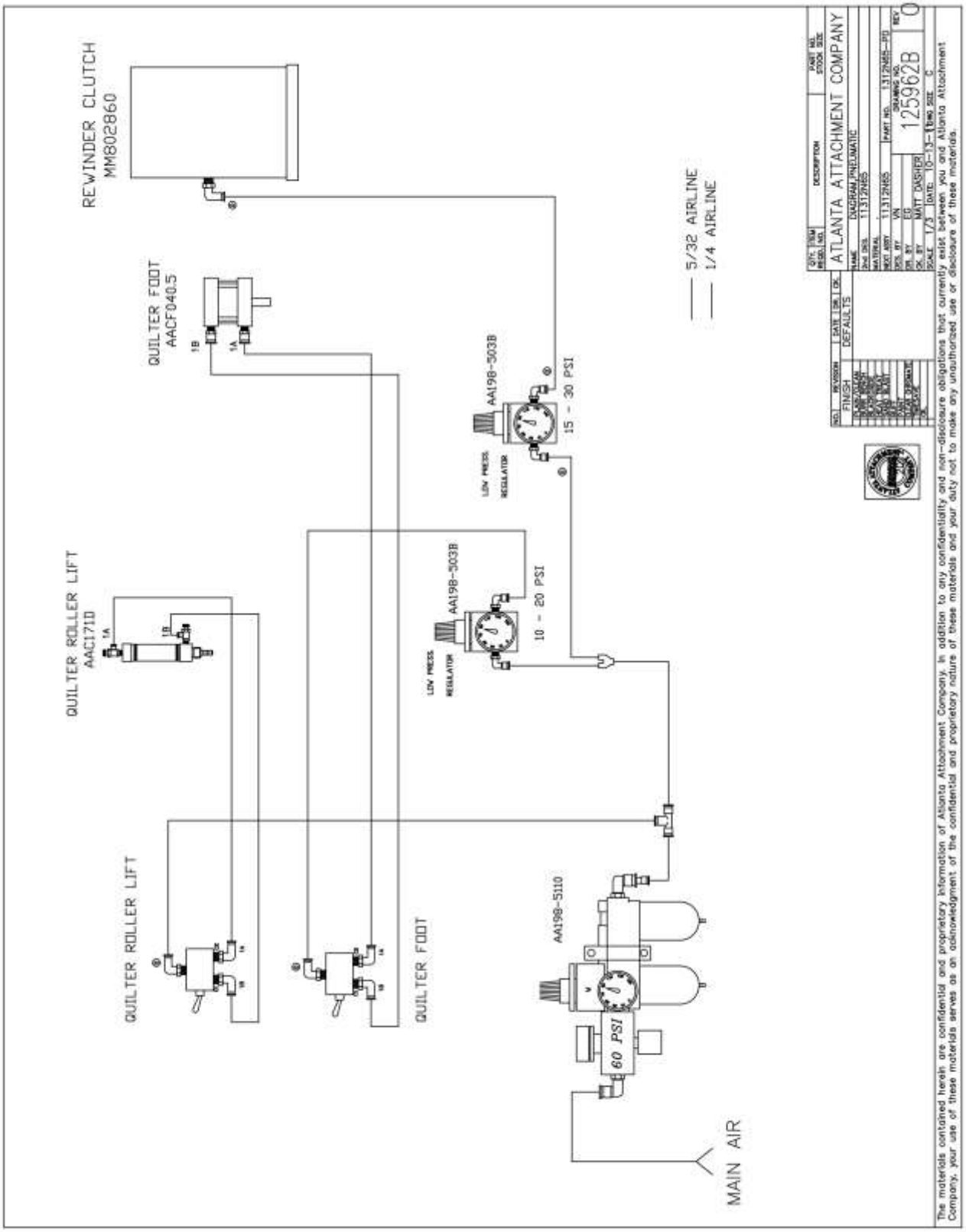


1312144 Control Button Panel

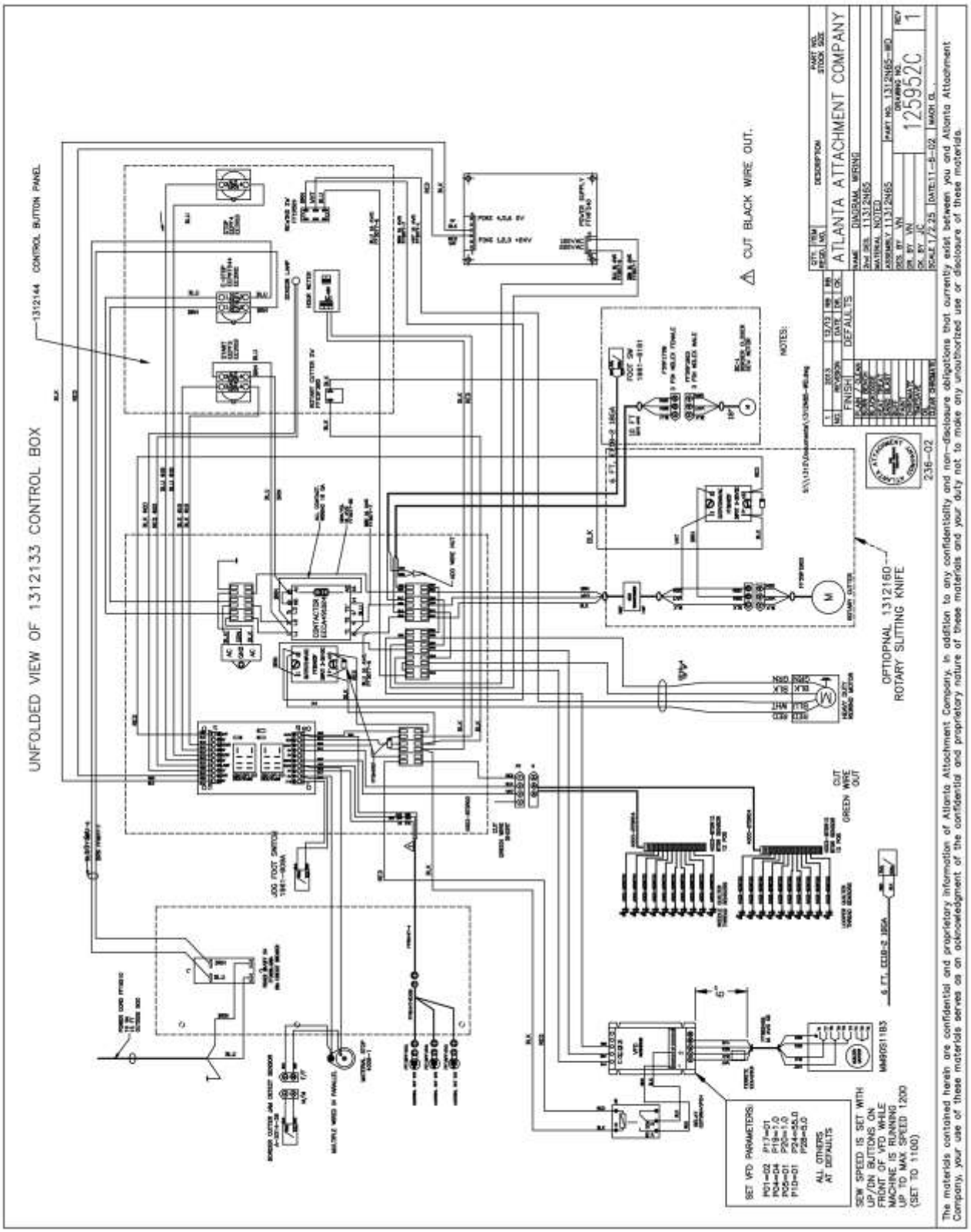
AAC Drawing Number 1312144 Rev 3

NO	QTY	PART #	DESCRIPTION
1	1	0411-1950C	CABLE,LED,YELLOW,24VDC
2	1	1312134	CONTROL BUTTON PANEL
3	*1	1312N65-LAB	LABEL, CONT. PANEL
4	6	AAQME-5-8	QUICK MALE ELBOW
5	2	AAV41V	VALVE,TOGGLE
6	2	EE3X01	BLOCK,P.B. CONTACT, N.C.
7	3	EE3X10	BLOCK,P.B. CONTACT, N.O.
8	3	EEA3L	LATCH,PUSH BUTTON
9	1	EEPF3	BUTTON, PUSH 22MM, GREEN MO
10	1	EEPF4	BUTTON, PUSH 22MM, RED
11	1	EEPMTS44	E-STOP BUTTON, TWIST REL.
12	1	FF34576Q	SW, TOGGLE DPDT 20A
13	1	FF79998861	HOUR METER, 8 DIGIT LCD
14	1	MM9563K43	PLUG, 1/2" HOLE
15	1	MM98430A120	EXT SELF-LOCKING RET RING

1312N65-PD PNEUMATIC DIAGRAM



1312N65-WD WIRING DIAGRAM



Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libres de defectos de material y de mano de obra durante un período 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 se reserva el derecho de exigir el retorno de cada pieza defectuosa con un formulario de reclamo de garantía.
- AAC va, según su criterio, a reparar o reemplazar las máquinas o piezas defectuosas devueltas a AAC.
- AAC se reserva el derecho para tomar la decisión final sobre toda cuestión de garantía.
- Las garantías de AAC tiene una validez de ochocientas (800) horas o cien (100) días, cual llega primero.
- AAC garantiza la operación satisfactoria de sus máquinas en base de las normas aceptadas de la industria siempre y cuando se instale use y mantenga de forma apropiada.
- La garantía de AAC no puede ser cambiada o modificada y no está sujeto a cualquier otra garantía implicada por otro agente o distribuida al menos que sea autorizado por AAC antes de cualquier reclamo.

Lo Que Está Garantizado

- Componentes eléctricos que no están incluidos dentro del sistema Serial Bus que fallen por defectos de materiales o de fabricación que hayan sido manufacturados por AAC, son garantizados por un período de ochocientas (800) horas.
- Componentes mecánicos que fallen por defectos de materiales o de fabricación que hayan sido manufacturados por AAC, son garantizados por un período de ochocientas (800) horas.
- Componentes comprados (Motores, Cabezales) son protegidos debajo de la garantía del fabricante.
- AAC asistirá con el manejo de todo reclamo de garantía bajo la garantía del fabricante.

Lo Que No Está Garantizado

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

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