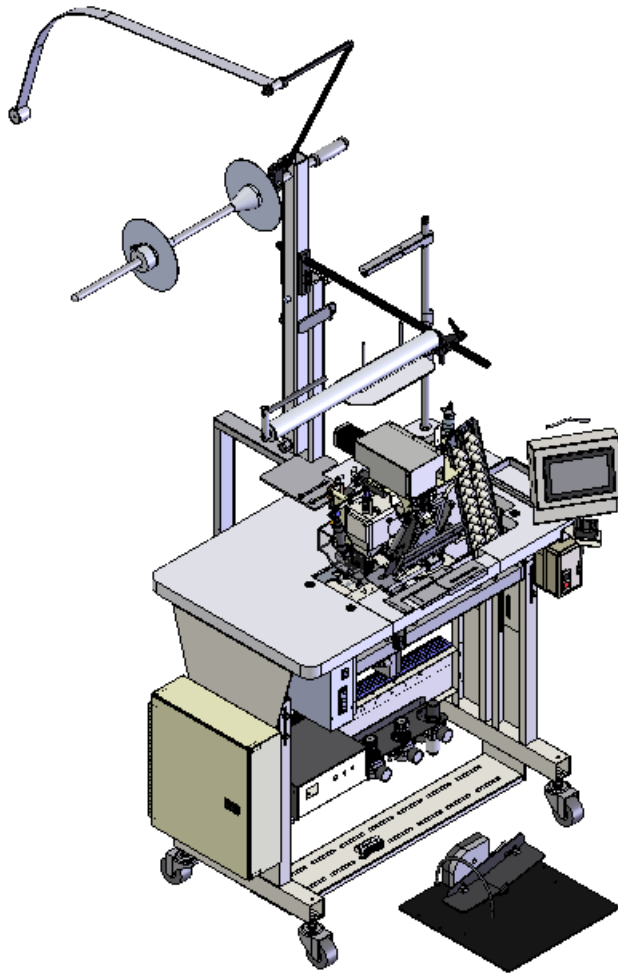




Modelo **1335ETA**
Revision 2.1 June 2023 (wr)

Technical Manual & Part Lists



Atlanta Attachment Co.

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Atlanta Attachment Company, Inc.

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The sale of this product does not sell or otherwise transfer any license or other rights under any US patent or other corresponding foreign patent. This equipment is protected by one or more of the following patents:

Patents US:4,038,933; 4,280,421; 4,432,294; 4,466,367; 4,644,883; 4,886,005; 5,134,947; 5,159,889; 5,203,270; 5,307,750; 5,373,798; 5,437,238; 5,522,332; 5,524,563; 5,562,060; 5,634,418; 5,647,293; 5,657,711; 5,743,202; 5,865,135; 5,899,159; 5,915,319; 5,918,560; 5,924,376; 5,979,345, 6,035,794

Foreign patents - 2, 084,055; 2, 076,379; 2, 177,389; 2, 210,569; 4-504,742; 8-511,916; 9-520,472; 0,537,323; 92,905,522.6; 95,935,082.8; 96,936,922.2; 5,159,889; 5,203,270.

Otras U.S. y patentes extranjeras pendientes.



IMPORTANT

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

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Important Safety Instructions



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 1337HEJ28 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.

Installation

ATTENTION: It is important that the machine technician read this manual and be familiar with all functions and safety concerns of the unit before installing and operating. Maintenance should only be performed by trained and qualified personnel.

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

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

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

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

Choice and Qualification of Personnel

Ensure that work on the machine is only carried out by reliable persons who have been appropriately trained for such work - either within the company, by our field staff or at our office - and who have not only been duly appointed and authorized but are also fully familiar with the local regulations.

Work on the machine should only be carried out by skilled personnel, under the management and supervision of a duly qualified engineer. This not only applies when the machine is used for production, but also for special work associated with its operation (start-up and maintenance), especially when it concerns work on the hydraulic or electrical systems, as well as on the software/serial bus system.

Training

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

Responsibilities

Clearly define exactly who is responsible for operating, setting-up, servicing and repairing the machine. Define the responsibilities of the machine operator and authorize him to refuse any instructions by third parties if they run contrary to the machine's safety. This applies directly to 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.

Installation

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS

Safety Equipment on the Machines



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

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

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

Damage

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

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 displayed, visible and always legible to read.

Clothing, Jewelry, Protective Equipment

Long loose hair, loose-fitting clothes, gloves, and jewelry, including rings, should be avoided to prevent injuries due to being caught, drawn in and wound up inside the machine.

Installation

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

Check the safety regulations for the product you are using.

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.

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 about reporting fires and the emergency exits. Make sure you know exactly where the fire extinguishers and sprinkler systems are located and how they are operated. Pass on the corresponding information to the firemen when they arrive.

Ensure there are enough signs to avoid fire hazards.

The following fire extinguishers may be used:

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

Installation

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

A qualified person should be consulted to repair the damage after a fire.

Electrical Power Supply



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

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

Installation

Interim Storage

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

Installation

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill, and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.

Remove any oil, grease, dirt, and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.

Retighten all screw connections that must be loosened for the maintenance and repair work. Any safety mechanisms that must be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustments

The activities and intervals specified in the Instruction Manual to carry out the adjustments, maintenance and inspections must be observed, and some parts replaced as specified. All hydraulic and pneumatic lines must be examined for leaks, loose connections, friction, and damage at the time the machine is being serviced. Any defect found must be repaired 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.

Installation

voltage release in the event of an emergency. The working area should be cordoned off and marked by a warning sign. Only use electrically insulated tools.

Ventilation/Hazardous Gases

It is the end user's responsibility to ensure adequate ventilation is provided to exhaust 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.

Comenzando a Mover la Máquina

Lea el manual de Instrucciones cuidadosamente para establecer que botones y funciones hacen que la máquina comience a moverse.

A Word to the End User

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

Installation

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 mechanical stands, blocks or a hoist and blocks.
- NEVER touch hot parts of machine

Installation

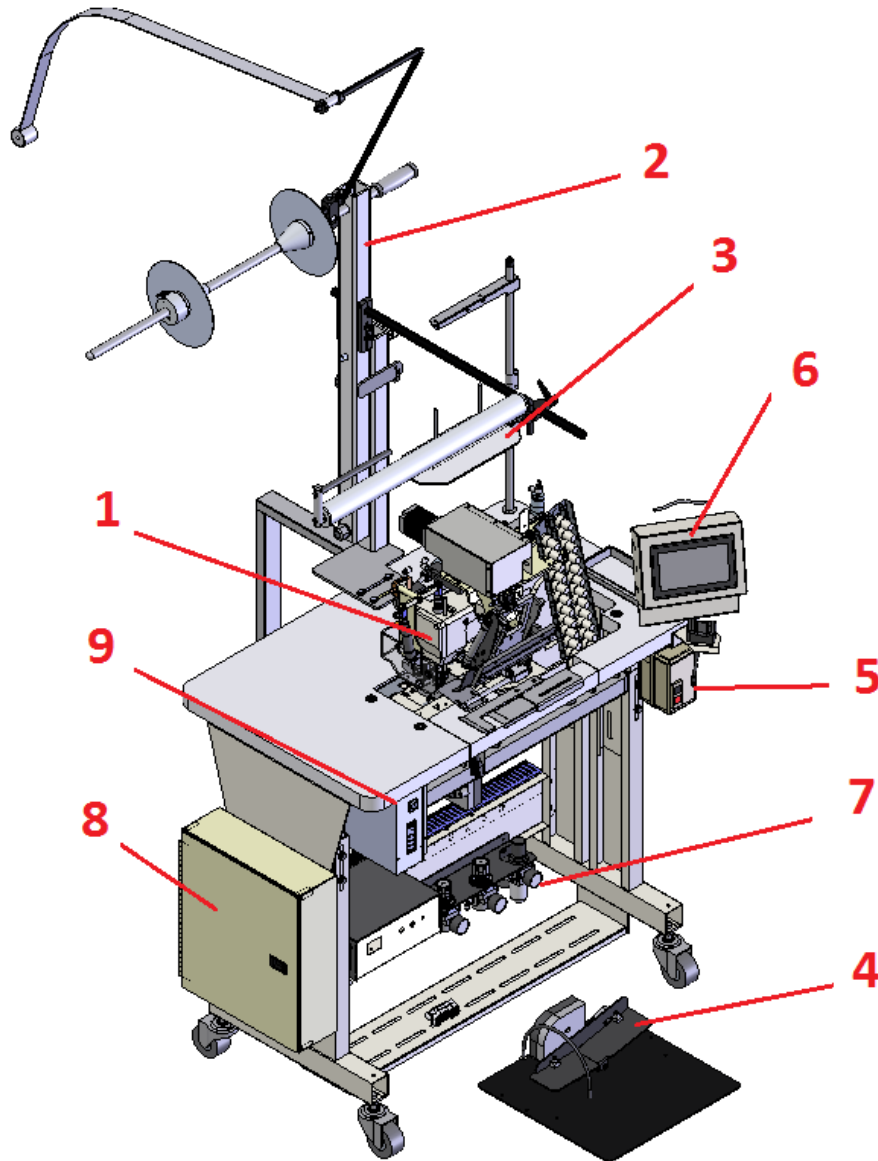
1.INSTALATION

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

Maintenance should only be carried out by trained and qualified personnel.

It is important that the operator of the machine read this manual and be familiar with all the functions and safety concerns of the unit before operating.

1.1. Parts & Components



1.- Sewing Head	6.- Digital Screen	8.-Electric Components Box
2.- Roll Support Border/Gusset	4.- Sewing Pedal	9.- Efsa Sewing Motor
3.- Thread Holder	7.- Air Regulator	

Installation

1.2. Technical Data

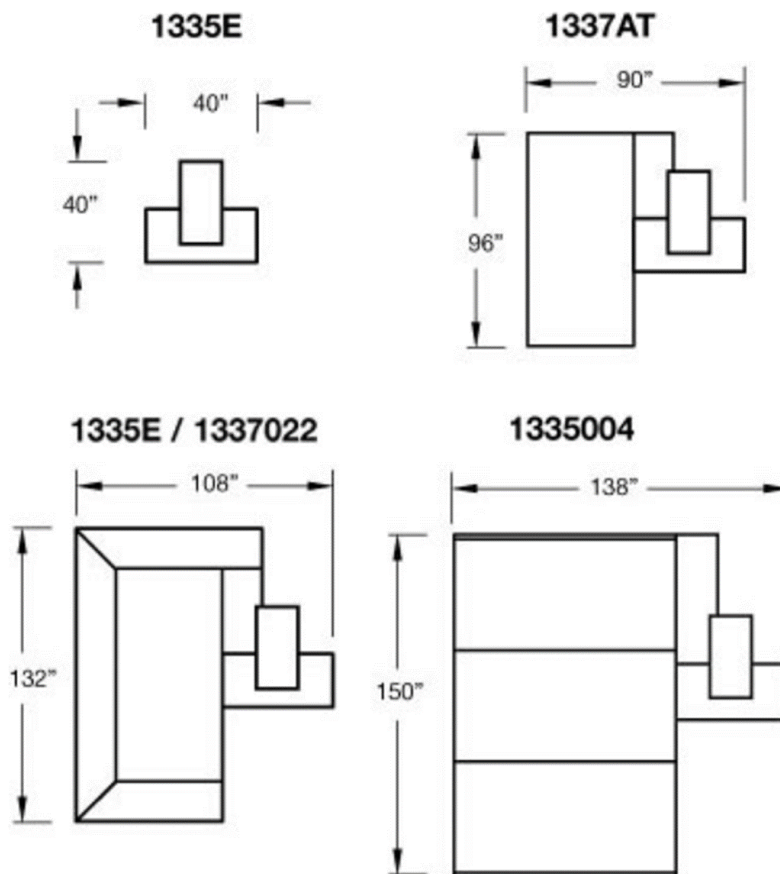
Max sewing speed (rpm)	4000
Factory preset speed (rpm)	3000
Max stitch length (spi)	6
Needle system	SN62X5721
Needle size	21/130
Weight of material	LIGHT / MEDIUM
Voltage (v/ph/hz)	220V 1PH 60HZ
Current (amps)	5
Motor type	EFKA DC
Air pressure (psi)	80
Air consumption (cfm)	2
Shipping weight (lbs)	850
Shipping dimensions (w/l/h, inch)	60 x 48 x 65



1.3. Top View

The top view of the machine will depend on the accessories shipped. Next, graph of different configurations

Leave enough free space around to be able to open all the doors and have access for Maintenance.



Installation

1.4. Machine Identification Tag

The identification of the machine is located at the top of the table behind the sewing head. Its content is the machine class and the Serial Number.

Ex: 218427031707

The serial number is divided as follows:

The first number identifies the order number, 218427

The next number of the month of manufacture, (03)

The next number of the year of manufacture, (17)

Following a correlative number, 07

1.5. Accessories

1337AT - Pneumatic flotation table	
1337022 - 18 "Extension for flotation table (3 parts)	
1335004 - Triple flotation table	
1337ATE - Double flotation table	
1334S-02 – Flange automatic module	
1337580 – Table extension	

Installation

1.6. Types of Machines & Subclasses



Atlanta Attachment Rufflers

Model	1335E	1335MD	1335MF	1335MG	1335MH
Picture					
Description	Multi-Purpose Ruffler Workstation Pillow-top Gusset Ruffler Euro-top Ruffler Continental Foundation Ruffler Bottom Capping Ruffler	Multi-Purpose Ruffler Workstation Pillow-top Gusset Ruffler Euro-top Ruffler Continental Foundation Ruffler Bottom Capping Ruffler	Multi-Purpose Ruffler Workstation Pillow-top Gusset Ruffler Euro-top Ruffler Continental Foundation Ruffler Bottom Capping Ruffler	Multi-Purpose Ruffler Workstation Pillow-top Gusset Ruffler Euro-top Ruffler Continental Foundation Ruffler Bottom Capping Ruffler	Multi-Purpose Ruffler Workstation Pillow-top Gusset Ruffler Euro-top Ruffler Continental Foundation Ruffler Bottom Capping Ruffler
Type of Material	Light Weight	Light Weight	Medium Weight	Medium Weight (FR)	Heavy Weight (FR)
Production	20 to 25 pieces per Hour	20 to 25 pieces per Hour	25 - 30 pieces per hour	25 - 30 pieces per hour	20 to 25 pieces per Hour
Sewing Head	Consew 326S	Mitubishi 2210	Yamato 1804	Yamato 2002	Singer 300UX6
Feeding / Stitch type	 401 Constantine	 301	 401 Constantine	 401 Constantine	 401 Constantine
Puller	Zero-Max external puller 	Electronic servo drive puller 	Internal mechanically driven adjustable puller 	Internal mechanically driven adjustable puller 	Electronic servo drive puller
Sewing Motor	Electronic servo drive motor with needle positioner (no synchronizer required).	Electronic servo drive motor with needle positioner (no synchronizer required).	Electronic servo drive motor with needle positioner (no synchronizer required).	Electronic servo drive motor with needle positioner (no synchronizer required).	Electronic servo drive motor with needle positioner (no synchronizer required).

Installation

1.7. Assembly

Remove all shipping belts from the machine.

Inspect the machine for any damage that may have occurred during shipment. If damage is found, report this immediately to your supervisor. Document the damage and provide details and photographs.

Place the machine in the desired location on a reasonably level and stable floor.

Make sure there is sufficient lighting on the machine. Remove all packing material.

Raise and level the machine at operating height.

Apply a light coat of oil to all metal parts with a clean towel to prevent future corrosion.

The wheels of the machine have an interlocking system to avoid the movement of the machine. Press the lever of the wheel down to block the movement.

1. Lubrication of the Sewing Head

Follow the lubrication procedures of the sewing head. (ISO Viscosity Grade 22 part #SO). Turn the handwheel of the head manually and check the freedom of movement.

2. Roll Support of Border or Gusset

Install the Roll Support of Border or Gusset to the machine structure. Make sure that the leg of it contacts the ground.



Installation

3. Sewing Pedal

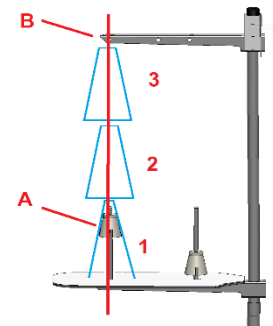
Connect the sewing pedal cable to the Efka motor cable.



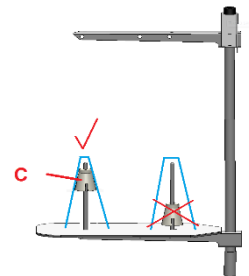
4. Thread Cone Stand

Assemble the thread cone stand and adjust as follows.

El centro del cono de hilos “A” debe encontrarse en línea con el punto de enhebrado “B” y a una altura de 3 conos de hilos.



The guide cup of the cone must come into full contact with the cone, thus preventing it from vibrating or changing position during the sewing process.



1.8. Power Connection

1. Electrical

This unit needs to be grounded for several reasons. In equipment powered by the network, exposed metal parts are connected to ground to prevent user contact with dangerous voltage when electrical insulation fails. In power distribution systems, a protective earth conductor is an essential part of the Earthing safety system. The ground connection also limits the accumulation of static electricity.

The machine should only be connected to the power grid of the plant by a qualified electrician who is aware of the local regulations. Before turning ON the main switch, verify that all connections are secure. An isolation transformer can be convenient depending on the state of the power supply. Power requirements: 208-230 Vac, single phase. 5 Amp

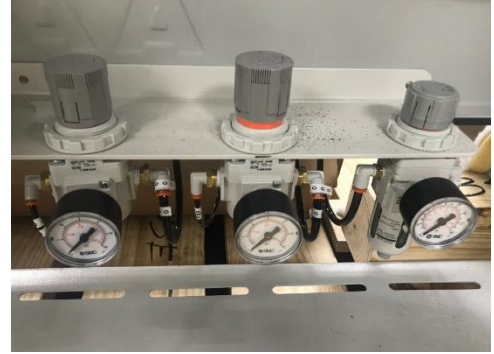


Installation

2. . Pneumatic

WARNING: Some moving parts can be activated when opening the valve.

Only compressed, dry and filtered air should be used. Make sure that the air pressure always stays within the specified ranges, otherwise, faults can occur. Feed a minimum 3/8-inch diameter pipe to the air inlet connector with a pressure greater than 80 psi (6 bars) and a minimum flow of 2 SCFM per minute. The 80-pound pressure must be maintained throughout the automatic cycle.



1.9. Power On

Press the black power button located on the lower right side of the machine. The machine will start and start the power cycle.

Make sure that the main switch of the "Efka motor" is in the On position.

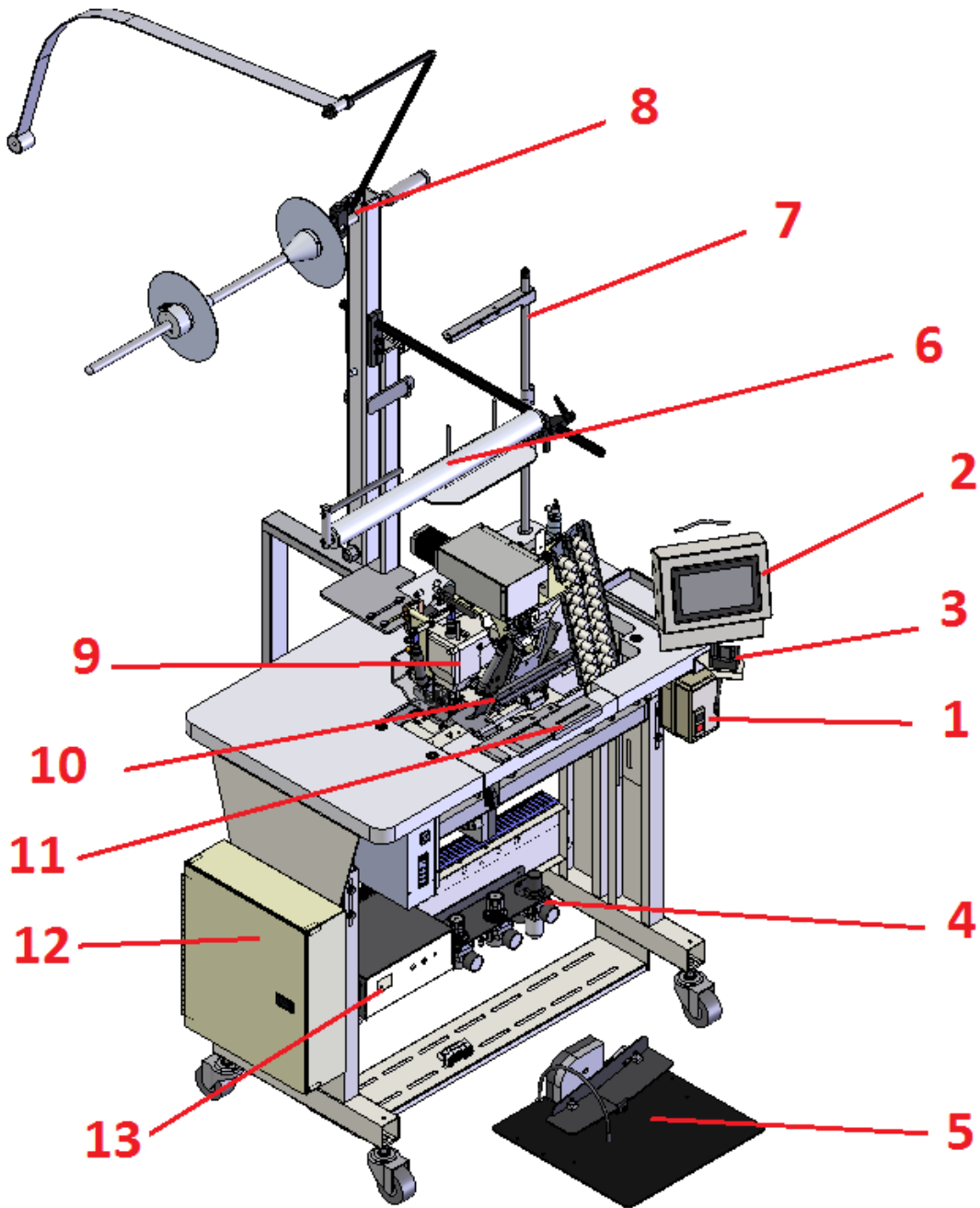


1.10. Interim Storage

If the machine is to be stored temporarily, it should be oiled or greased and stored in a dry place where it is protected from the weather to prevent damage. A corrosion inhibitor coating should be applied if the machine is to be stored for a longer period of time and additional precautions must be taken to prevent corrosion. The tabletop does not require any type of coating on the wood or Formica surfaces.

2. Operation

2.1. Parts and Components



1.- Main switch	6.- Material Tensión roller	11.- Fabric Guide
2.- Touch screen	7. Thread Stand and guider	12.- Control box
3.- Touch sensor	8.- Edge or bellows roll holder	13.- Step Motor Drive Box
4.- Air Regulators	9.- Sewing head	
5.- Sewing Foot Pedal	10.- Roll Guide	

Operation

1. Main Switch

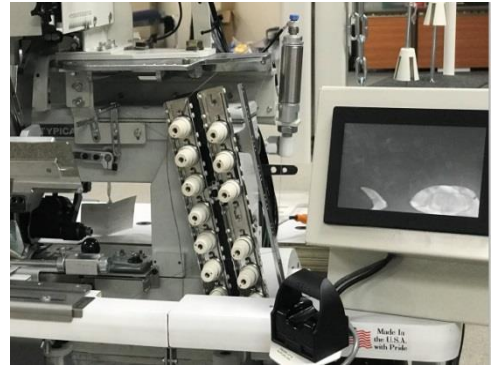
Located at the bottom left of the machine table. It has a lock out latch to prevent activation when maintenance work is carried out.

The black button starts the machine and the red one stops it.



2. Touch Screen

Located on the right side of the machine. It lights up when the main switch is actuated. It will stay lit as long as the machine is on.



3. Touch sensor

Its function is to raise or lower the material guide. It is activated when detecting the presence of the finger.



4. Air Regulators

They are located under the sewing machine.

There are three regulators:

- Foot pressure during pleats, 15 PSI
- Non-woven material brake 15 PSI
- General pressure of the machine. 70PSI



Operation

5. Sewing Foot Pedal

It controls the sewing speed. By pressing it on the right side the sewing machine is activated and starts sewing. The more you press, the high the sewing speed is reached. If the Left side is pressed, the sewing foot will raise.



6. Material support roller

Located in front of the machine. Its function is to facilitate the entry of the edge into the material / border guide.



7. Thread holder and guides.

It is installed on the left side of the machine. Pay attention that during the sewing cycle, all threads paths are clear of any obstacles that would capture or tangle the threads causing breakage or sewing problems.



8. Roll Holder

Its function is to hold / store material and maintain the edge alignment during the sewing operation.



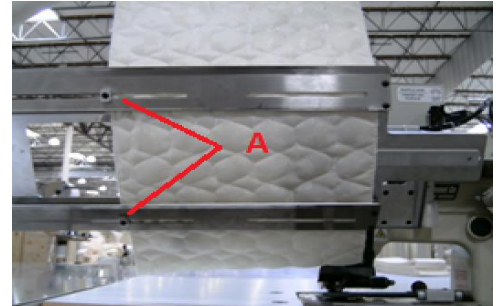
9. Sewing head

The 1335ETA model is normally delivered with the Typical brand 401 two-thread chainstitch sewing head. With Puller drive roller behind the foot.



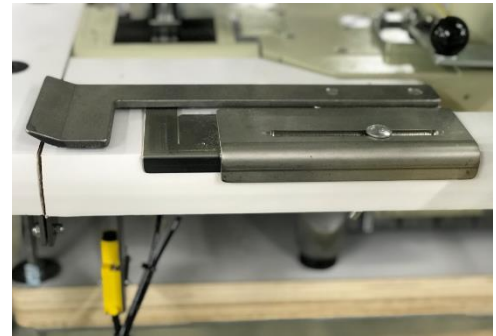
10. Material Guide

The right side of the edge guide has fixed guides for the right edge of the border. The left side has movable guides, there are thumb screws “A” on the back of the border guide, loosen the screws and slide the guides left or right until they touch the left side of the border material. The material must be free in its movement but guided by the two stops.



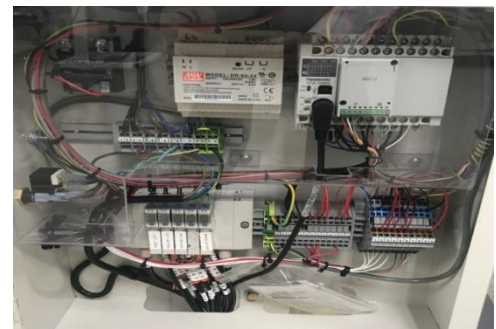
11. Non-woven Panel Guide

Located in front of the machine, its function is to guide the non-woven panel during the sewing cycle. Also serves as a fabric brake during straight stitching.



12. Electrical Components Box

The computer of the machine is located. It is protected by plastic panels to avoid contact with electrical cables. Its access is exclusive to the technician.



13. Stepper Motor Control Box

Responsible for the speed / movement of the stepping motor that performs the folds.

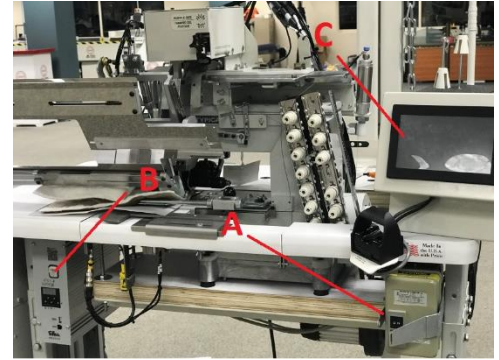


Operation

2.2. Power Up Sequence

Press the power button “A” and the display “C” will illuminate proceeding to the power cycle.

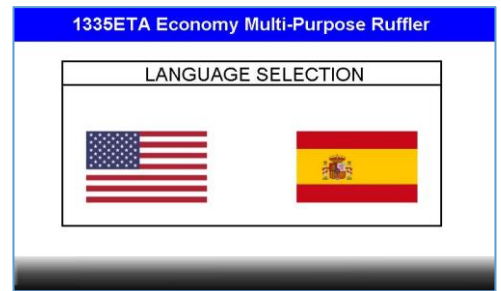
NOTE: The power button of the Efka box must be in the on position and the internal light of the button must always be on.



First, a screen with the Atlanta Attachment logo appears on monitor “C”. Then automatically switch to the Language screen.



On this screen, select the language you are going to use by clicking on the corresponding flag. When pressed, the machine changes to the home screen.



Home screen appears and system stops waiting for operator selection.



2.3. Description of Screens



Operation

1. Starting Screen

From this screen you can select,

- Manual mode
- Automatic mode
- Round corners
- Square Corners
- System information
- Pages of Inputs and Outputs
- Ruffler Parameter Settings
- Language Page



2. Manual Mode

Its function is to use the sewing machine in manual mode. In this mode, the Ruffler system will not work, and the sewing head will work like a regular sewing machine.

Indicators such as **Needle Up** and **Sewing Motor Running**: Will turn on and off according to the movement of the head.

Stitch Count: It will move according to the movement of the machine.

Machine Ready: It will be lit green if the conditions of seams are present.

Navigation Buttons: They are at the bottom of the screen and allow the operator to move to other screens.



3. Auto Mode

It is the main operation screen. It will be on during the entire sewing process.

a. Single Step Ruffler.

Pressing it makes a single complete cycle of Ruffle. Used in case of repairs or verification of the functioning of the Ruffler System.

b. Cycle Ruffler.

When pressed, it executes a sequence of Ruffle according to the programmed values.

c. Indicator Buttons

Ruffler Mode Indicators, Sewing Mode activated, needle up and Sewing engine running will turn on and off according to the sewing sequence.

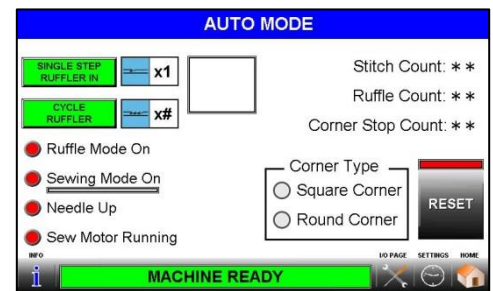
d. Program Indicators.

It shows the three main values of the ruffle program to be executed.

e. Corner Type.

Square. For the sewing sequence that stops in the middle of the ruffle cycle.

Round. For the continuous sewing sequence during the ruffle cycle



Operation

f. Machine Ready

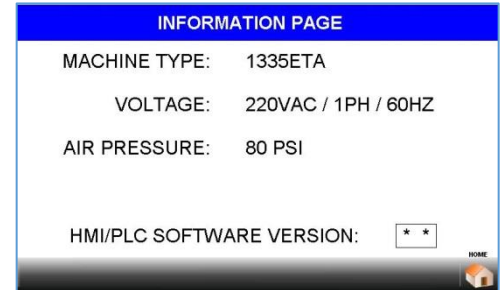
It will be lit green if the seams conditions are present.

g. Navigations Buttons:

They are at the bottom of the screen and allow the operator to move to other screens.


4. System Information

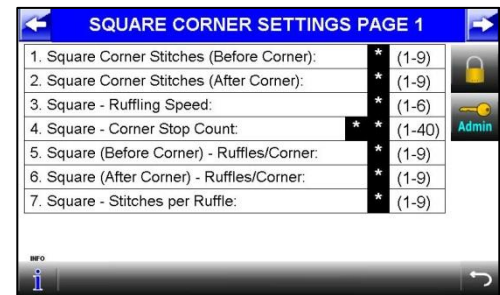
It shows the data of the machine model, the voltage, the air pressure, and the version of the program. It is only for reference and the values cannot be altered.



5. Square Corner Settings, Page 1.

It shows the programmed values for the operation in Automatic Mode of the square corners. The change of these values is protected by a key and is reserved for technicians.

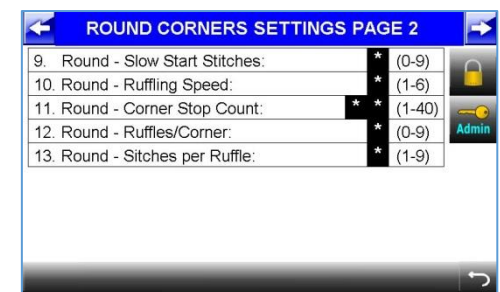
By pressing the upper arrow  you can switch to the rounded corners screen.



6. Round Corner Settings, Page 2

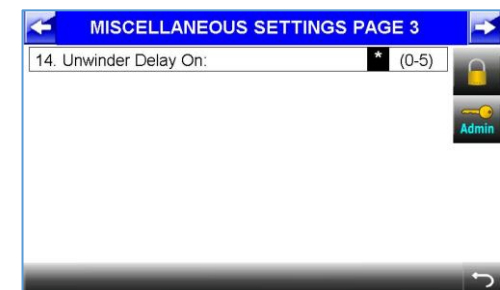
It shows the programmed values for the operation in Automatic Mode of the Round corners. The change of these values is protected by a key and is reserved for technicians.

By pressing the upper arrow  you can switch screens.



7. Miscellaneous Settings, Page 3

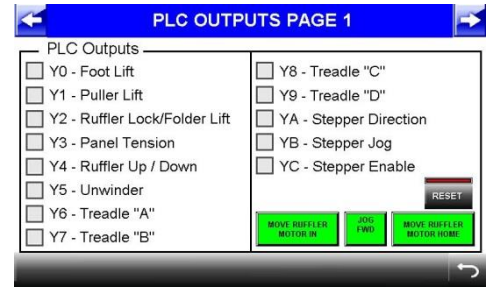
It shows the reaction time of the roll feeder motor in reference to the pressing of the sewing pedal. The change of these values is protected by a key and is reserved for technicians.



Operation

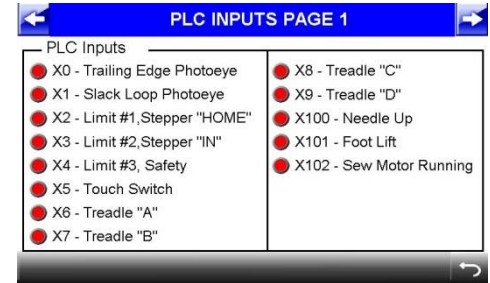
8. PLC Outputs Page 1

They show the status of all the outputs of the microprocessor. This area is usually reserved for technicians.



9. PLC Inputs Page 1

They show the status of all microprocessor inputs. This area is used reserved for technicians.



10. Language Selection

Shows the available languages. When pressing any of the flags the language change to the corresponding flag

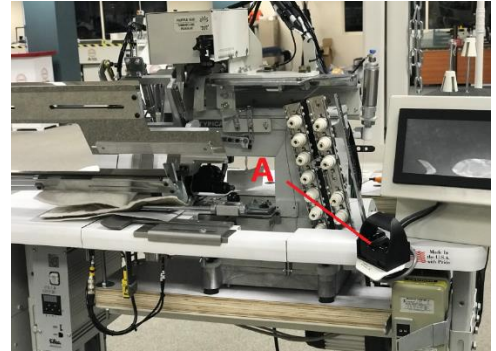


2.4. Preparation for Sewing

1. Threading the Sewing Head

With the machine on, press the touch sensor, remove the cloth guide.

Follow the threading instructions in the sewing head manual.



2. Loading Edge Roll or Bellows

Remove the safety pin from the roll support arm and extend it out.



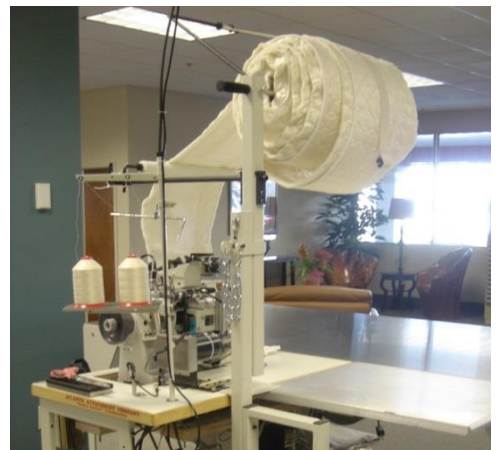
Loosen the thumb screw and remove the disc.
Place the edging or roll on the support bar.
For single-sided box springs or mattresses, position so that the fabric side is facing down when feeding from the border roll.

For flanging the top should face up when feeding from the roll of bellows

Replace the disc and tighten the thumb screw.



Move the roll support assembly back into position and secure with the safety pin. Move the material on the upper bar towards the roll guide.



Operation

3. Adjusting the Media Roll Guide

Insert the roll tab through the top of the media roll guide.

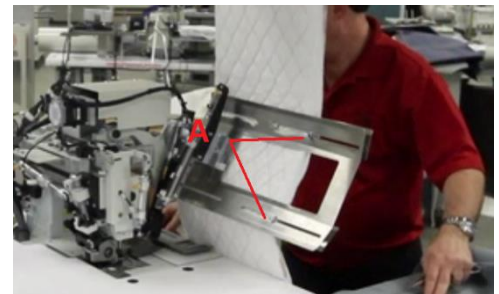


Continue feeding the roll through the second sheet of the media roll guide.



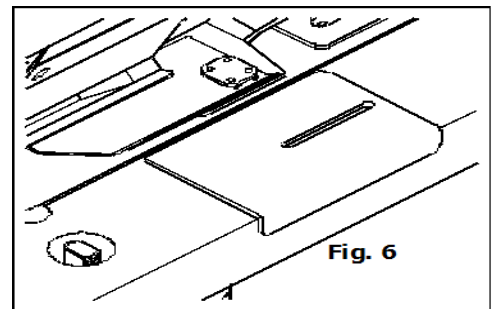
Adjust the left guides "A" to make a tight fit to the width of the tab.

Adjust the roll media guide. left or right as necessary to set the desired stitch allowance.



3. Adjusting the Panel Edge Guide

The edge guide located on the front of the table must be adjusted in such a way that its left edge aligns with the right edge of the flange. This is the guide for the right edge of the non-woven panel.



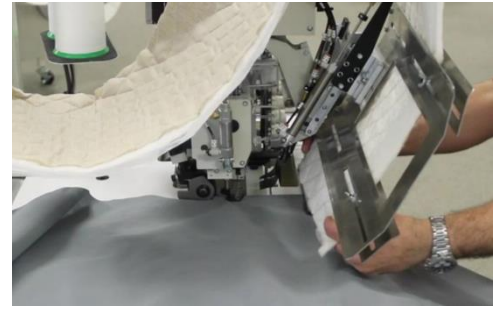
2.5. Sewing Cycle

Raise and place the non-woven panel under the Fabric / Tension guide.

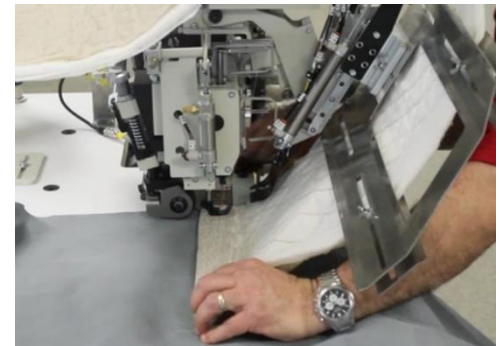


Operation

Lower the Fabric guide securing the non-woven and then pull border material towards the presser foot.



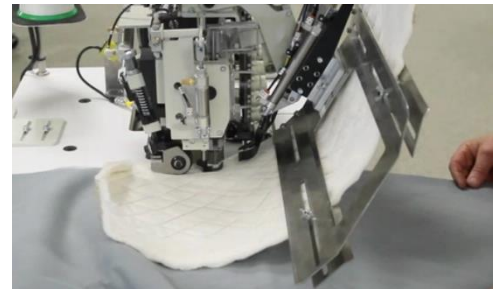
Position the beginning of the roll pass the needle.



Press the finger/touch sensor to lower the material guide.



Press the sewing pedal and start the sewing cycle.

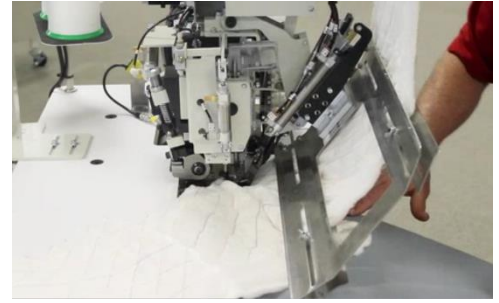


Continue sewing until the lower sensor detects the corner.



Operation

Depending on the selected program, make the corner folds and repeat the cycle until the last corner.



Continue sewing, stopping just short of the lower material guide.



Press the touch sensor and raise the roll guide.
Remove the beginning of the border material from the shirring guide



Remove the non-woven from the guide.



Continue sewing until about 2 inches from the needle.



Operation

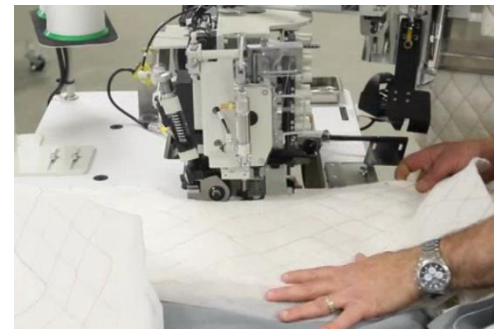
Remove some edge of the roll guide.



Cut the edge at the height of the roll guide.



Raise and Swing-out the border material guide by pressing the touch sensor and proceed to final edge stitching.



Operation

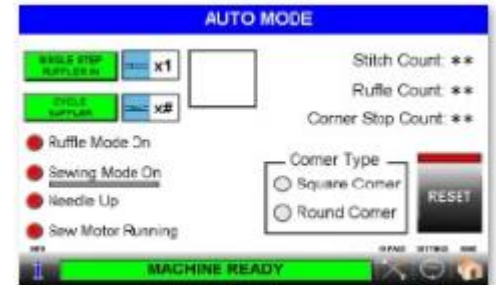
1 Operation with Rounded Corners

Automatic Mode selection on the Main screen



The Automatic mode operation screen is displayed.

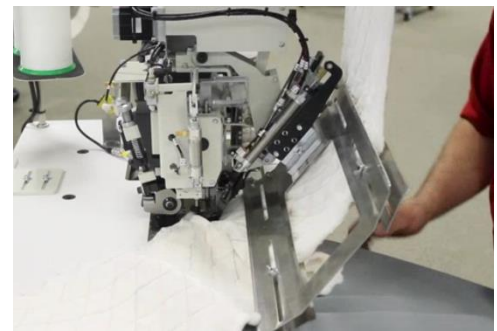
Selection "Round Corner".



Sew the non-woven panel to the corner making sure that your hands are not in the way of the electric eye which is mounted under the table and that you should "see" the edge of the non-woven panel as it approaches the foot of the presser foot. The machine automatically stops at the corner.



Put the sewing pedal in neutral while you position your hands to turn.
Place your right hand on the non-woven panel near the foot of the presser foot and your left hand about a foot to the left of the non-woven panel.
Press the sewing pedal forward and allow the machine to make the first fold by sewing in a straight line.
Begin rotating the nonwoven panel as the rest of the fold forms.



Try to move equal amounts with each fold like this when the fold is complete the nonwoven panel will have rotated 90 degrees and the right edge of the nonwoven panel is resting against the left edge of the edge guide.
Pleats can be made one at a time by using the sewing pedal in neutral between each pleat.

Complete all four corners.

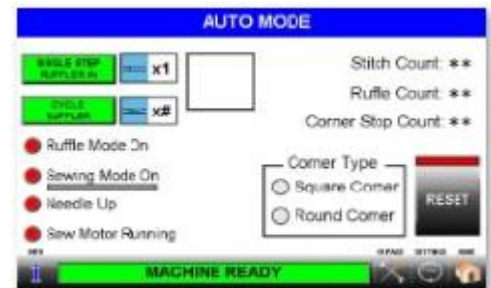


2 Operation with Square Corners

Automatic Mode selection on the Main screen



The Automatic mode operation screen is displayed. Select “Square Corner” .



Sew the non-woven panel in the corner making sure that your hands are not in the way of the electric eye which is mounted under the table and that you should “see” the edge of the non-woven panel as it approaches the foot of the presser foot.

The machine will stop momentarily while the Ruffler engages and then continue to sew in a straight line while making the ruffles.



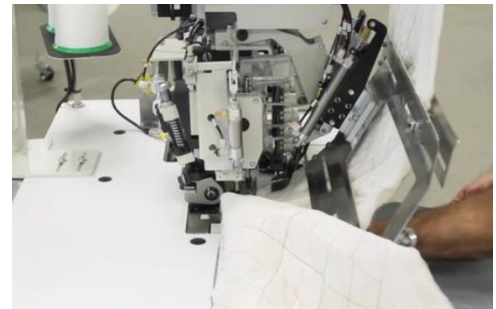
After the last fold is finished on the first side of the corner the machine will continue to sew at slow stitches based on the amount programmed.

After the slow stitches the machine will stop with the presser foot raised.

Rotate the non-woven panel 90 degrees.

Release and press the stitch pedal.

The foot will lower, and the machine will again start sewing with slow stitches based on the pre-programmed setting and then begin to make the pleats on the second side of the corner.



NOTE: When the pleats are complete the machine will resume sewing at the speed of the sewing pedal. Adjust the number of folds per stop as necessary to achieve the desired finish in the corner.

2.6. Preventive Maintenance 8 Hours



Preventative Maintenance

Modelo:	11335ETA	Required Material
Serial:		
Operation:	Pleating / Ruffling Machine	
Sewing head:		
Serial:		
Needle:	SN62x5924 22-180	oiler sewing machine oil clean rags compressed air

Daily (8 Hrs)	Before starting the working day "With the Machine Off "	
	.Wipe with a clean cloth Remove any accumulated dirt or debri	
	.- check for wáter or oil residue and remove it from the air filer bowl	
	.- check the oil level in the machine and add oil as required to maintain the correct level or as indicated by the gauge	
	.- Add 2 drops of oil to the needle bar, lower looper bar, cam and feed dog drive	
	At the end of the working day "With the Machine Off "	
	.Open the covers, blow out any debri inside the machine Check for and remove thread buildup in the internal moving parts.	
	Blow off outside of machine,wipe with a clean rag, remove any debri or tangled threads	
	At the end of the day, cover the machine and notify the supervisor of any unusual noises or operational issues.	

3. SERVICE

3.1. Lockout/Tagout Program



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

Equipment Energy Control Procedure Lockout/Tagout Program			
Description:	Ruffling Machine	Model:	1335ETA
Manufacturer:	Atlanta Attachment Co.	Location:	
Energy	Location	Magnitude	Control Method
Electrical:	Disconnect/Ctrl Box	220V--3 PH	Lockout & Tag
Pneumatic :	Main Regulator	90 PSI	Lockout & Tag
Gravity:	Presser Foot, Folder Assembly, Roller Holders, ETC..		
Remember to Release All Stored Energy!			
Shutdown Procedure:			
<ol style="list-style-type: none"> 1. Inform all affected personnel that the machine will be in Lockout status. 2. Turn the power and pneumatic disconnects to the OFF position. 3. Fill out the tag with necessary information of the Lockout. 4. Install the Lockout device. 5. Verify all stored electrical energy has been released by pressing the power on button. <p>. Also, use meter to test circuits in the electrical panel to insure stored energy is released there as well. Perform necessary maintenance, services and/or repairs.</p>			
Startup Procedure:			
<ol style="list-style-type: none"> 1. Inform all affected personnel that the Lockout of this machine is being removed. 2. Replace any guards or safety devices which may have been removed during maintenance. 3. Remove the Lockout device and tag. 4. Turn the power and pneumatic disconnects to the ON position. 5. Push the green button on the back of the control panel to turn the machine on. 6. Inform all affected personnel that the Lockout has been removed and that the machine is ready for normal production operation. 			

Approved By: _____ Date: _____

3.2. Important Information

It is important that the machine technician read this manual and be familiar with all functions and safety concerns of the unit before installing and operating. Maintenance should only be performed by trained and qualified personnel.

3.3. Mechanical Adjustment

For more detailed adjustments, refer to the individual manufacturers' manuals of the components enclosed in the accessories box, such as sewing head and motors.

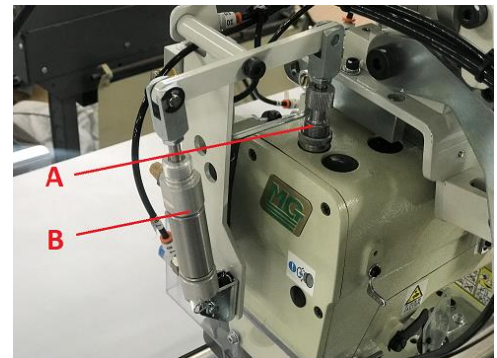
1. Synchronization of the Sewing Head.

See sewing machine manuals for normal hook settings and basic sewing head times.

2. Pressure of the Cloth Presser.

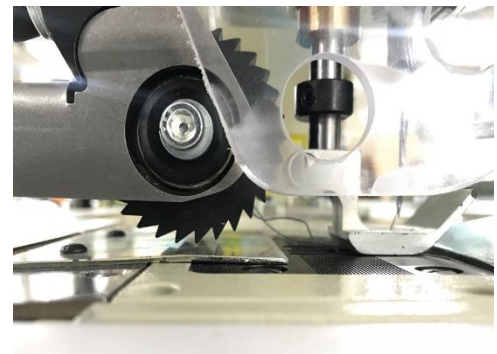
The presser foot pressure should be set very light so that the crimped ruffle blade can feed the material under the foot when ruffling is done. Use adjusting nut “A”

The auxiliary pressure cylinder “B” must be adjusted to add pressure to the foot when sewing in a straight line. If there is too much pressure, the sheet to make the pleats will get stuck under the fabric presser. In case of having very little, the folds will undo when the sheet returns and may cause skipped stitches.



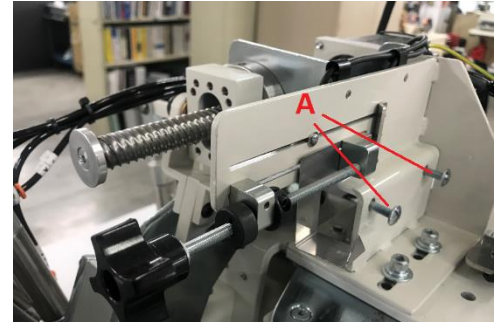
3. Pinch Roller

Adjust the position of the pinch roller as low as possible without touching the fabric plate. The pinch roller must be centered with the needle. Adjust the pinch roller air pressure as needed in order to provide a positive feed preventing roller stalling when sewing at high speed.

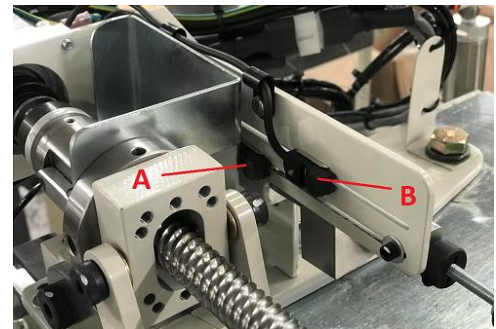


4. Calibration and Position of Ruffling Blade

Loosen the two screws on the cover of the stepper motor assembly. Remove the cover by lifting.

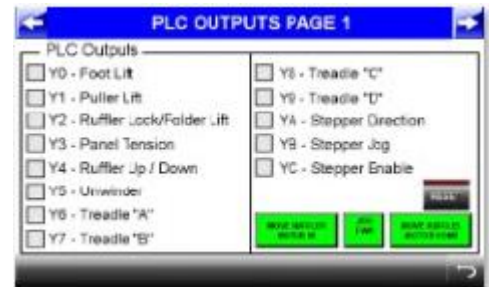


Locate the two proximity switches to the right of the ball screw. The rear sensor "A" is the start sensor, and the front sensor "B" is the chipping sensor.

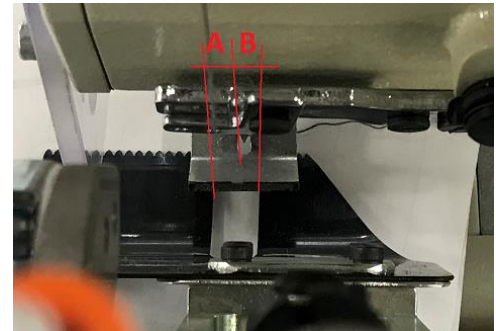


Select the option of inputs and outputs in the control panel.

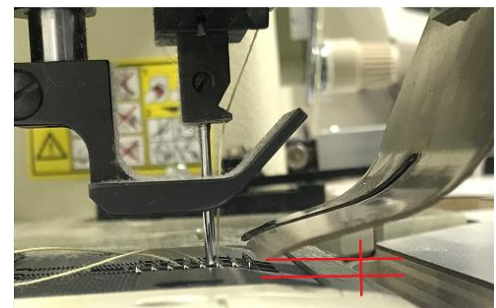
Press the move folder button.



The groove of the ruffler's corrugated sheet should be aligned with the sewing needle. Loosen the 4 screws on the blade and adjust it to the left or right to meet the standard.

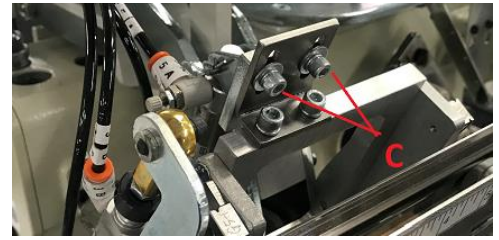


Maintaining the same position, adjust the height of the blade so that you have a gap of about 3/16 between the blade and the machine plate.

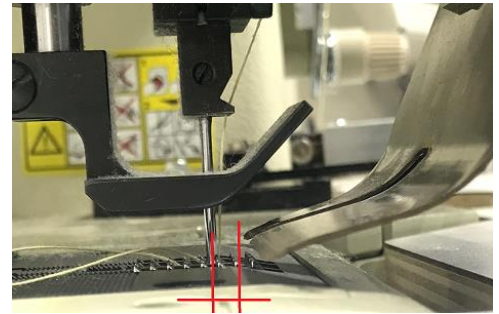


Service

Adjust this height through the “C” screws at the base of the cylinder.



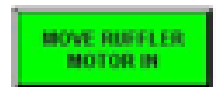
In the same position adjust the depth so that the front edge of the blade is slightly in front of the needle.



To make this adjustment it is necessary to modify the position of the front sensor “B” located inside the step motor compartment. Loosen screw “D” and reposition the sensor. Press Reset on the control panel and press the ruffle move button again.



Press the Move Folder Button to repeat the cycle and verify the adjustment.



5. Fold Size

To adjust the size of the fold, turn the adjustment knob located on the front of the stepper motor assembly. Turning the knob clockwise will decrease the crease, turning the knob counterclockwise will increase the crease.

There is a scale located on the right-hand side of the stepper motor assembly. The pointer will move as the knurled nut is turned, the smaller the number the smaller the crease, the larger the number the larger the crease.



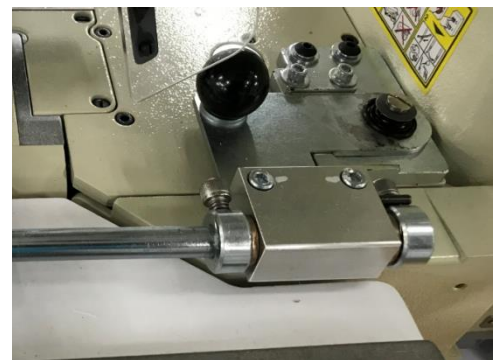
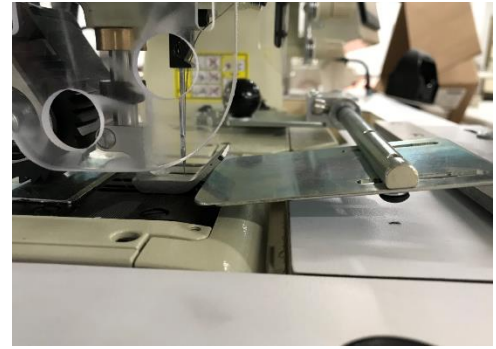
6. Separator Sheet

The spacer blade is part of the corrugated assembly and is mounted to the bed plate of the sewing head on its own oscillation bracket. The spacer sheet allows the corrugated sheet to pinch the edge material between it and the spacer sheet and push the material under the foot without folding the nonwoven panel. To adjust proceed as follows:

Position the front edge of the separator sheet so that it is as close as possible to the presser foot and allow the separator sheet to sway.

To adjust the lead-in distance of the front edge of the retractor blade, loosen the two button head screws located on the underside of the retractor blade support rod. Slide the sheet in or out as needed and tighten the two screws.

Set the height of the separator blade high enough so that it does not pinch the nonwoven panel between it and the sewing head when the ruffler's corrugated blade is lowered. Adjust the height of the spacer sheet by loosening the screws that rest on the pegs on the mounting block. Move the sheet up or down as necessary, rotate the collars until the screws are seated in the pins, and tighten the screws.

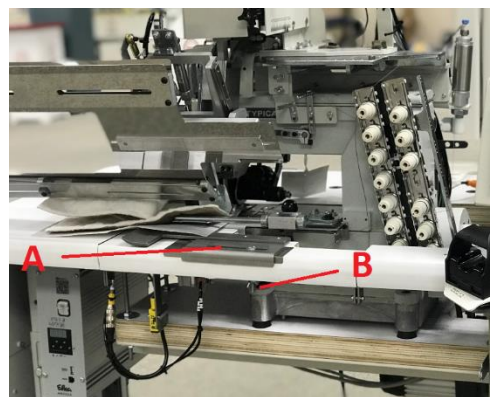


7. Non-woven Panel Guide

The nonwoven panel tension/edge guide assembly is located in front of the sewing head on the fold-down portion of the table. The edge guide is used to guide the right edge of the nonwoven panel.

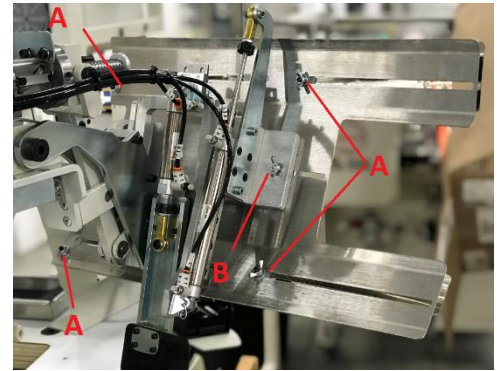
It is adjusted by loosening the wing nut located under the table and sliding the fence to the left or right.

This setting is based on the required seam allowance.



8. Folder or Border Material Guide

The function of the guide is to keep the fabric aligned with the sewing machine during the sewing cycle. It has a series of spacers "A" to separate the top and bottom of the guide and thus allow the material to move freely. These spacers can be moved left or right to secure the material inside the guide.



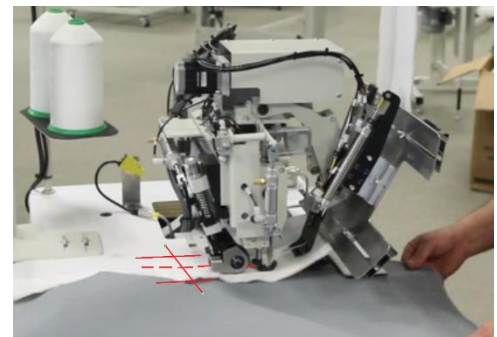
All spacers should be sized as required to allow clearance within the metal guide. Extra spacers can be ordered to fit any thickness of material, from 1/8" to 9/16".

NOTE: Refer to the table below for the different guides and measurements of the spacers.

Once the material is secured, the entire assembly can be run left or right to align the seam where required by loosening the two thumb screws "B".



For the manufacture of bed bases, the distance from the seam to the edge is close to 3/4 inches. There are special roll guides for this operation.



To sew Pillow Top the seam in the gusset will be centered with reference to the ear of fabric.

There are special roll guides for this operation.

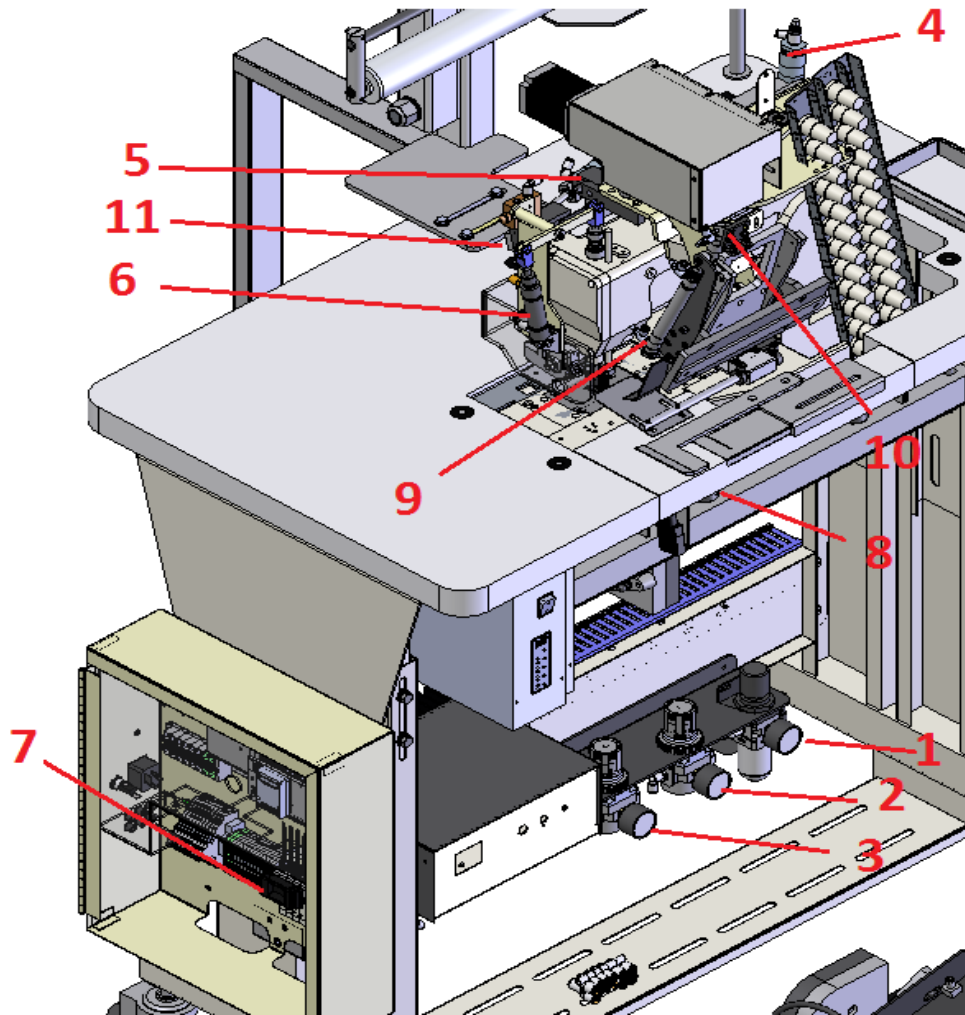
9. Reference Table for Material Thickness / Folder Spacers

QUANTITY	ASBLY#	DESC.	PREFLANGED, OFFSETTABLE, 6"								PREFLANGED, OFFSETTABLE, 9"								CONTINENTAL BORDER, 18"								DWG#
			CAPACITY A-2216K								CAPACITY A-2216L								CAPACITY A-2216M								
PART#			1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4			
1	A-2216D40	L. GUIDE, 1/8, KEYED, ALU	2											2											298720C		
2	A-2216D32	L. GUIDE, 3/16, KEYED, ALU	2											2											298600B		
3	A-2216D33	L. GUIDE, 1/4, KEYED, ALU		2											2										298706B		
4	A-2216D34	L. GUIDE, 5/16, KEYED, ALU			2											2									298765A		
5	A-2216D35	L. GUIDE, 3/8, KEYED, ALU				2										2									298707B		
6	A-2216D37	L. GUIDE, 7/16, KEYED, ALU					2										2								298863B		
7	A-2216D38	L. GUIDE, 1/2, KEYED, ALU						2										2							298864B		
8	A-2216D39	L. GUIDE, 9/16, KEYED, ALU							2																298719C		
9	A-2216D59	L. GUIDE, 5/8, KEYED, ALU								2															298831C		
10	A-2216D60	L. GUIDE, 11/16, KEYED, ALU									2														298832C		
11	A-2216D61	L. GUIDE, 3/4, KEYED, ALU																							298833C		
1	A-2216D58	R. GUIDE, 1/16, KEYED, THDED	2											2											298724C		
2	A-2216D51	R. GUIDE, 1/8, KEYED, THDED		2											2										298602B		
3	A-2216D52	R. GUIDE, 3/16, KEYED, THDED			2											2									298747C		
4	A-2216D53	R. GUIDE, 1/4, KEYED, THDED				2											2								298820A		
5	A-2216D54	R. GUIDE, 5/16, KEYED, ALU					2											2							298710B		
6	A-2216D55	R. GUIDE, 3/8, KEYED, ALU						2																	298721C		
7	A-2216D56	R. GUIDE, 7/16, KEYED, ALU							2																298722C		
8	A-2216D57	R. GUIDE, 1/2, KEYED, ALU								2															298723C		
9	A-2216D62	R. GUIDE, 9/16, KEYED, ALU									2														298834C		
10	A-2216D63	R. GUIDE, 5/8, KEYED, ALU										2													298835C		
11	A-2216D64	R. GUIDE, 11/16, KEYED, ALU																							298836C		
1	A-2216G14	SPACER, 1/16(2 HOLE)																							298759A		
2	A-2216G24	SPACER, 1/8(2 HOLE)																							298767A		
3	A-2216G32	SPACER, 3/16(2 HOLE)																							298716C		
4	A-2216G33	SPACER, 1/4(2 HOLE)																							298717C		
5	A-2216G29	SPACER, 5/16(2 HOLE)																							298808A		
6	A-2216G21	SPACER, 3/8(2 HOLE)																							298764A		
7	A-2216G30	SPACER, 7/16(2 HOLE)																							298809A		
8	A-2216G31	SPACER, 1/2(2 HOLE)																							298810A		
9	A-2216G34	SPACER, 9/16(2 HOLE)																							298718C		
10	A-2216G41	SPACER, 5/8(2 HOLE)																							298837C		
11	A-2216G42	SPACER, 11/16(2 HOLE)																							298838C		
12	A-2216G43	SPACER, 3/4(2 HOLE)																							298839C		
	SSBC98024	SCREW, 10-32 X 3/8																									
	SSBC98032	SCREW, 10-32 X 1/2																									
	SSBC98040	SCREW, 10-32 X 5/8	4	4																							
	SSBC98048	SCREW, 10-32 X 3/4			4	4																					
	SSBC98056	SCREW, 10-32 X 7/8					4	4																			
	SSBC98064	SCREW, 10-32 X 1							4	4																	
	SSBC98072	SCREW, 10-32 X 1-1/8																									
	SSBC98096	SCREW, 10-32 X 1-1/2																									

3.4. Pneumatic Adjustments

For more detailed adjustments refer to the pneumatic diagram at the end of this manual as well as to the individual manuals of the manufacturers of the components attached to the accessory box, such as sewing head and motors.

The main pneumatic components of the machine are the following:



1. Main pressure regulator	5. Piston of the roll guide block	9. Edge guide lifting piston
2. Non-woven panel tension regulator	6. Pressure piston of the presser foot	10. Piston lifter of the ruffled sheet
3. Presser Foot pressure regulator	7. Valve block	11. Piston lifter of the puller
4. Piston presser foot lifter	8. Tension piston of the non-woven panel	

Service

1. Main Pressure Regulator

Located on the right side of the regulators. It is responsible for the general pressure of the machine. During the sewing cycle, you should not lower the pressure on the pressure gauge. Factory Pressure 70 PSI

The pneumatic maintenance units are composed of three elements:

a. Air Regulator

Maintains the working pressure as constant as possible regardless of the variations of the network pressure.

b. Gauge

Indicates the pressure resulting from the adjustment of the pressure regulator.

c. Filters: Liquid and Solid Impurities.

Extract liquid waste and moisture from the air before they are fed to the machine. These must be cleaned regularly, and the water must never exceed the marking lines in the reservoir tank.

1. Cleaning Impurities and solid or oil deposit

1. Turn the regulator until there is no pressure in the line.
2. Depressurize the machine by closing the main inlet key and verify that the pressure gauge indicates that there is no air pressure.
3. Remove the deposit of solid impurities and clean it.
4. Place the deposit back in its receptacle.
5. Open the main air valve
6. Open the pressure regulator until the required pressure is obtained.

2. Tension Regulator for the Non-Woven Panel

Located in the center of the regulators. It is responsible for the non-woven brake. It is adjusted so that it replaces the tension applied by the operator's hand. The correct adjustment of the non-woven material should remain smooth after sewing. In case of too much tension the stitch can be very small and, in some cases, wrinkle the edge. In case of very little tension the material will be gathered after sewing.

Factory setting 15 PSI



3. Presser Foot Pressure Regulator

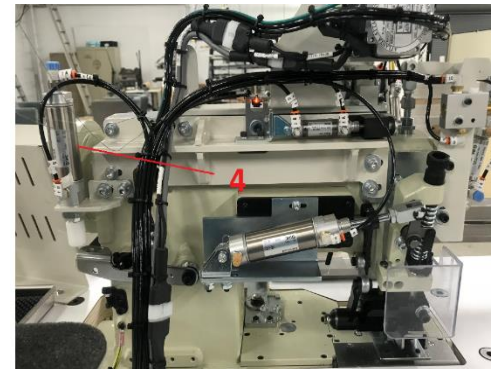
Located on the left side of the regulators. It is responsible for the pressure of the presser foot when sewing. During the sewing cycle it is activated until the cycle of the ruffles is started. If you have too much pressure you may have problems in dragging woven. If it is too few, stitch jumps may occur during the sewing path.

Factory setting 15 PSI



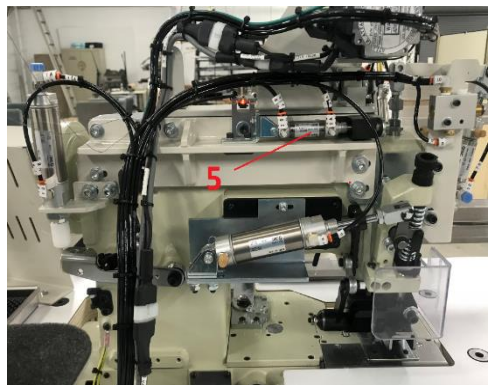
4. Presser Foot Lift Piston

Responsible for raising the presser foot during the sewing cycle. It has a flow regulator to limit the speed of the output movement of the shaft. This must be harmonic without hitting at the end of the stroke.



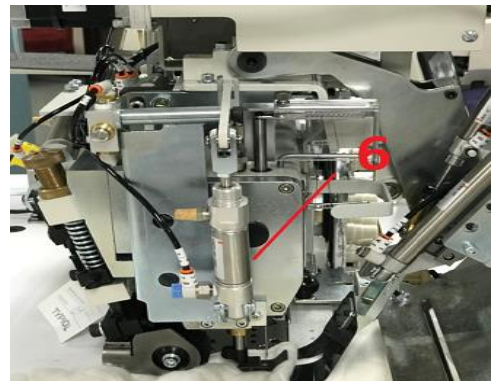
5. Piston Blocker of the Rolls Holder Guide.

Its function is to activate the safety pin. This locks the rotary holder in place when the material roll guide is facing down. Works in conjunction with the roller guide lift cylinder and is activated by valve # 3



6. Pressure Piston of the Presser Foot.

While sewing in a straight line the cylinder applies extra tension to the presser bar. The pressure of the cylinder is controlled by the pressure regulator of the presser foot. It has a flow regulator to limit the speed of the output movement of the shaft. This must be harmonic without hitting at the end of the stroke. Works in parallel with the panel tensioner. It is activated by solenoid valve # 4



7. Valve Block.

Responsible for activating the cylinders of the machine. It is located on the inside of the control box.

The solenoid valves are electrically activated (24 VDC) and can be mechanically activated directly on the valve body by pressing the manual blue actuators.

The electric activation of the valves is carried out through signals from the motor control box and the PLC.

Refer to the connection diagram at the end of this manual for the location and operation of the valves.



8. Non Woven Panel Tension Piston

The tension finger of the non-woven panel is used to add tension to the panel while it is being sewn. The air cylinder located under the table pushes the tension finger of the panel upwards until it contacts the lower part of the upper plate. The amount of pressure is determined by the pressure regulator in the regulator assembly and is adjusted according to the composition of the non-woven material.



9. Edge Guide Lifting Piston

Responsible for raising and lowering the entire roll guide. It is activated through the finger presence sensor. It has two flow regulators to limit the speed of movement. This must be harmonic without hitting the end of the stroke.



10. Ruffled Sheet Lifting Piston

Responsible for raising and lowering the ruffled sheet. It has pressure adjustment controlled by one of the pressure regulators.

It must be adjusted so that it has the lowest possible pressure but that it achieves the entire formation path of the ruffle.

It has two flow regulators to limit the speed of movement. This must be harmonic without hitting the end of the stroke.



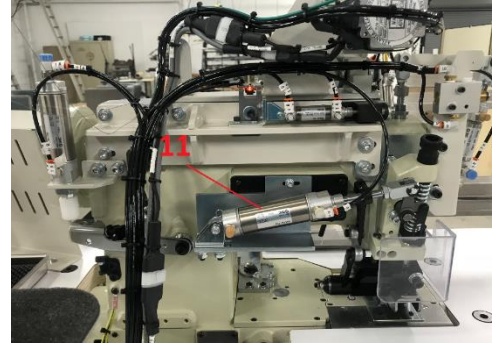
11. Puller Lifting Piston

Responsible for lifting the fabric.

It has two flow regulators to limit the speed of movement.

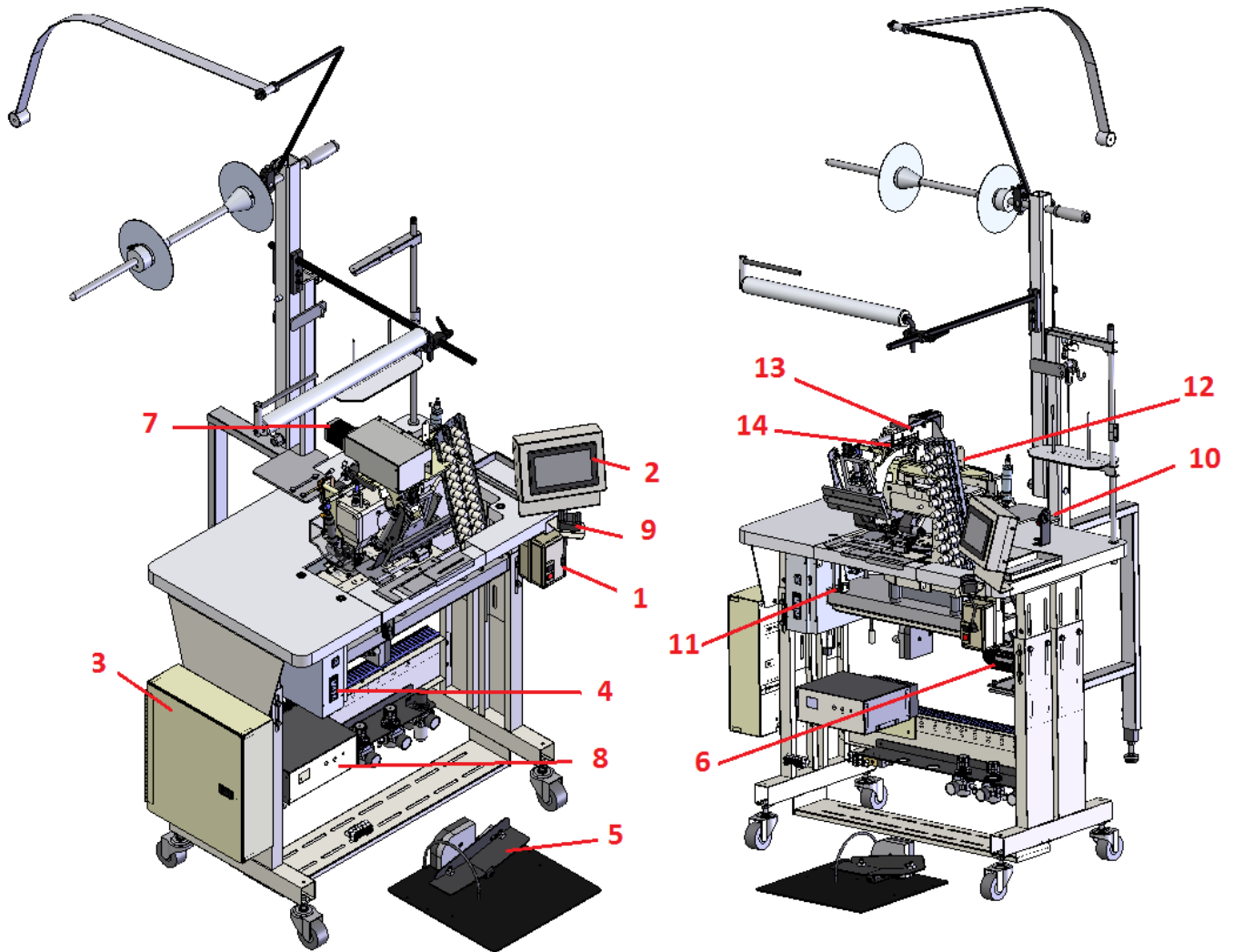
This must be harmonic without hitting the end of the stroke.

Apart from the electric command also has a pneumatic valve for manual activation of the same.



3.5. Electrical Adjustments / Settings

The main electrical components of the machine are the following:



1.-Main Switch.	6.- Efka Sewing Motor	11.-Material Optical Sensor
2.-Touch Screen	7.-Step Motor	12.-Guide Position Sensor
3.-Control Box	8.-Control Box Step Motor	13.-Sensor Limit Switch
4.-Control Box Efka Motor	9.- Touch Activator	14.- Sensor Limit Switch
5.-Sewing Pedal	10.- Optical Sensor Positioned	

Service

1. Main Switch

Located in the lower left part of the machine table. It has a safety foil to prevent ignition when maintenance work is performed.

The black button turns on the machine and the red button stops it. In case of power loss the switch is automatically deactivated. Internally it has a screw where the amperage value can be increased or decreased. It is not recommended to alter that factory value.



2. Control Panel with Touch Screen

From here the operator can control the entire operation of the machine. Most functions are blocked which does not allow them access to programming changes. There is an unlock code that allows the technician to unlock the parameter adjustment functions.

Technician Level: 2222

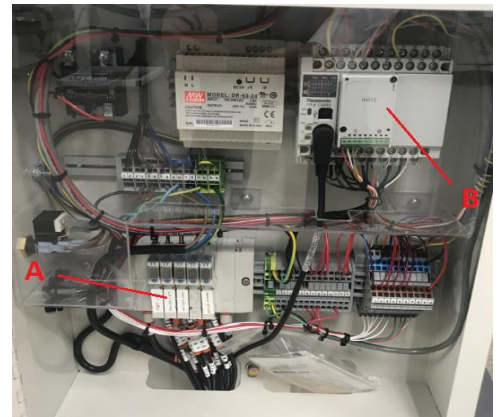
Advance Level: 3333



3. Electrical Components Box

Box where most of the pneumatic and electronic components of the machine are located. It is the one that controls all the cycles of operation and logic of the machine. In the lower left part is the air valve block "A" responsible for the activation of the air cylinders.

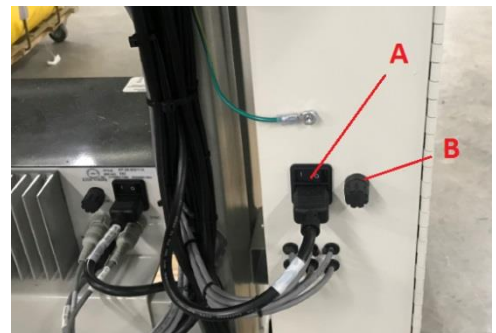
On the top right is the PLC "B" responsible for all the programming of the machine. .



The left back of the control box is the power cord and a switch to turn "A" on and off. Make sure this switch is always on.

CAUTION: Always disconnect the main power cable when servicing the control box.

Fuse Holder "B" acts for the entire machine. Replace the fuse with a slow-acting 5A 250V, when necessary.



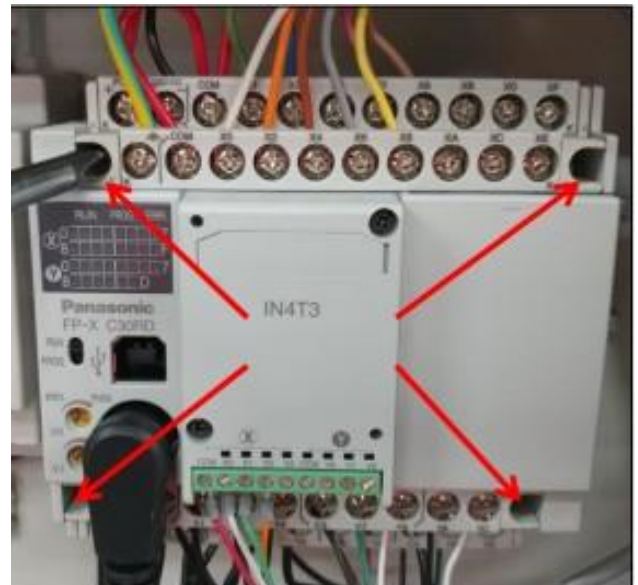
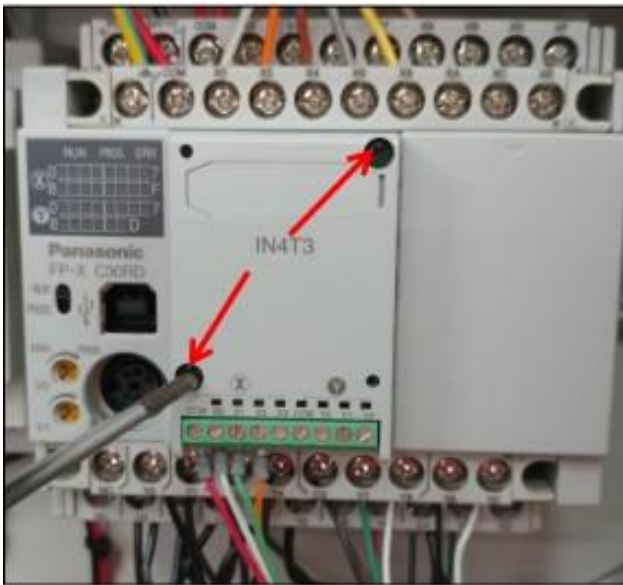
4. PLC Replacement

HOW TO CHANGE PLC IN 1335MGCA-SU OR 1335ETA:

- 1) VERY IMPORTANT: Record any machine settings on the settings pages (3 pages total)
- 2) Remove power from the machine a) Turn off power to machine b) Disconnect power plug at power source
- 3) Remove right angle connector for the touchscreen communications (see picture below)



- 4) Remove the two screws with small Philips screwdriver in the I/O cassette. (See left side picture below) PLEASE TAKE CARE NOT TO LOSE THE SMALL SCREWS



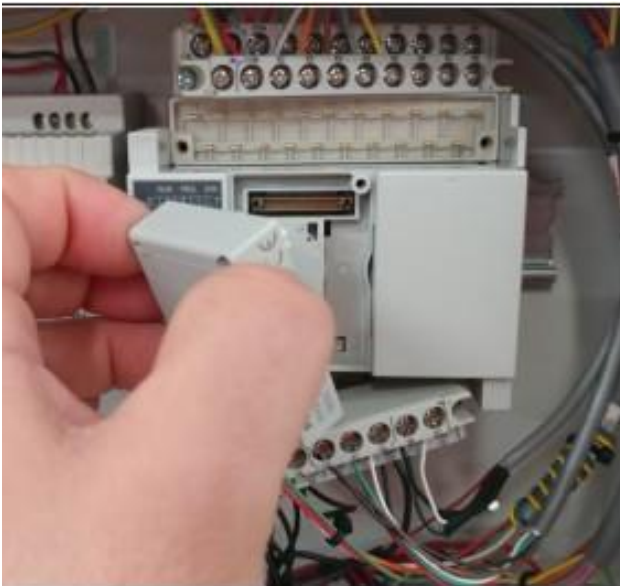
- 5) Loosen the two captive screws in the top terminal block on the PLC and then repeat for the bottom terminal block on the PLC. Note these are captive screws. (See right side picture above)

Service

6) Carefully remove the top terminal block from the PLC base and then remove the bottom terminal block from the PLC base. (See pictures below)



7) Carefully remove cassette from PLC base (see left side picture below)



8) Pull down on the blue clip on the bottom side of the PLC base until it clicks. Raise up on the bottom side of the PLC base and pull outward away from the din rail.

9) Install the new PLC on the din rail and repeat steps 8 thru 1 in reverse order to reinstall the cassette and I/O terminals onto the PLC. Replace the right-angle HMI communications cable into the round port below the USB socket. Make sure the RUN – PROG switch is in the RUN position.

10) Turn on the main power to the machine and go to the settings page to make sure the settings data has not changed. If the values are different, re-enter the values that were recorded before changing the PLC.

5. Efka Motor control Box

The Efka control has been programmed to operate the sewing head in conjunction with the folder. The maximum sewing speed has been programmed for 3,500. The maximum sewing speed can be temporarily reduced by keeping the button pressed.

"-" on the front of the control box while it is being sewn. To reset the maximum speed, use the "+" button. Refer to the appendix for the full Efka programming parameters on the next page.

6. Parameter List of Efka Motor Box

See Next Page.

Use Programming code "5913" to change the following set of parameters			
PARAMETER	RANGE	VALUE	DESCRIPTION
290		5	Mode of operation. MUST SET THIS PARAMETER FIRST!!!
026	0-26	0	Treadle config for EB301
111	0-999	3500	Maximum speed when "129" is 0, 1, or 2
161	0-1	1-CCW	Motor rotation (0 = CW, 1= CCW)
180	0-360 (175)	--	Degrees of reverse rotation to get to needle up
181	0-999 (10)	--	Delay until reverse rotation starts after trim
182	0-1 (0)	0	Enable reverse rotation after trim to move to "true" needle up
202	0-500	500	Sew delay after foot lift off
219	1-55	--	Breaking power at stop
250	0-359	--	Thread trimmer activation angle
270	0-6	1	External Handwheel Sensor Configuration (Position 2)
271	0-255	165	Ref. angle for Position 1 (Trim) from Position 2
272	0015-9999	1000	Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111.
362	0-1	1	Photocell power: 0 = 5V , 1 = 15v
436	0-1	0	Use code "5913". This disables an input that was causing box to reset itself.
401	0-1	1	Immediate save of parameters. MUST BE DONE LAST!!!
Front panel LED's:		Programming Instructions:	
LED 1: Off		1. Power on holding down the "P" button till "COD" is displayed.	
LED 2: Off		2. Press ">>" once and enter the number "5913"	
LED 3: Off		3. Press "E" once and "4.0.0." is displayed this is a parameter	
LED 4: Off		4. Proceed to the parameter to be changed and press "E"	
LED 5: Off		5. The value now shows in the screen, adjust to desired value.	
LED 6: Off		6. Press "E" to enter value and continue with parameter setting.	
LED 7: Off, Stop at needle down		7. Repeat for other parameters, press "P" once when complete.	
LED 8: On, Stop at needle up		8. Run sewing head to save parameters before powering down	
****Perform a Master Reset of Parameters (See Below)****			
To Perform Master Reset of Parameters:			
1. Power on holding down the "P" button till "COD" is displayed.			
2. Press ">>" once and enter the number "5913"			
3. Press "E" twice and "093" is displayed.			
4. Press "+" once, "094" is displayed.			
5. Press "P" to exit programming mode with all default values.			

7. Sewing Pedal

It controls the sewing speed. When pressed to the right side the sewing machine is activated and starts sewing. The more you push the more speed you reach. If pressed to the left side the presser and the roller pull up.



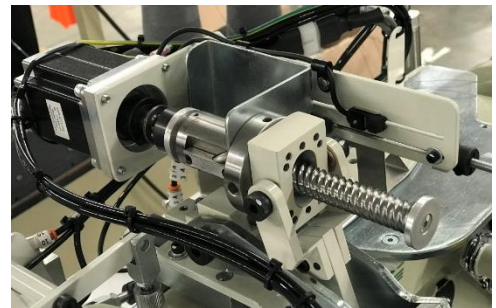
8. Efka Sewing Motor

This equipment uses an Efka model direct current DC1500 motor. It is connected directly to the sewing head. It has an external sensor that determines the position of the needles, speed etc. sewing head. It is responsible for moving the sewing head which in turn gives movement of the feed dog of the machine.



9. Step Motor

Responsible for the movement of the sheet to produce the ruffles. It stays energized while the machine is on. It is usually kept warm.

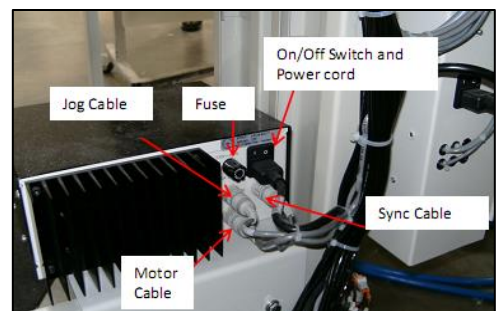


10. Step Motor Control Box

The Ruffler box is located under the table and has three casters on the front arranged to synchronize the Ruffler with the head. The number is proportional to the stitch length and does not affect the sewing speed. The 10-step potentiometer is used to set the speed of the corrugated sheet of the Ruffler during feeding to make the ruffles and the passage to the next ruffle. It is configured based on the thickness and type of material being used, if the ruffle sheet stops while it is fed in or out, you will need to decrease the settings in this control. To adjust unlock the selector and turn it counterclockwise to reduce the speed; turn it clockwise to increase it.



The box has an on / off switch on the back where it connects to the electric current. Leave this switch on all the time. Always turn off the electricity when you are servicing the box. It comes well-adjusted from the factory with the value of 80 on the left dials and 60 on the right button



Service

1. Small Switches (SW1)

Internally the control box contains small switches which should be in the following position. This adjustment comes from the factory, but in case of replacement of the box you should check.

Switch 1: Controls the motor rotations. CW: Clockwise. CCW: Against the direction of the clock. For the motor of the Ruffler, 2 AMPS adjust it to the Open (CW) position.

Switch 2: No Function.

Switch 3: No Function.

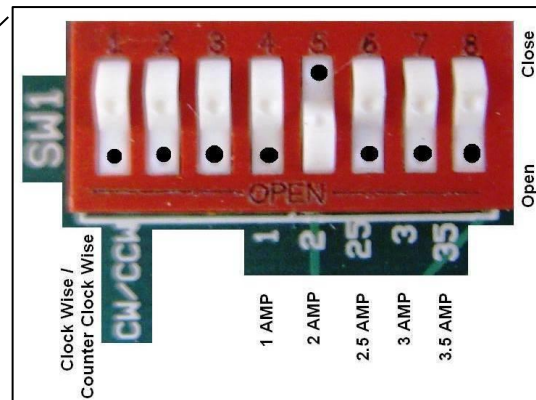
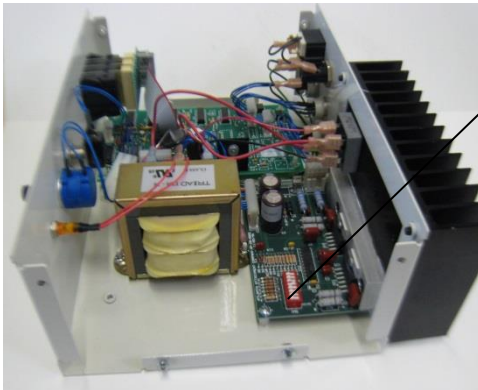
Switch 4: For Motors of 1 Amps. For motors of the Ruffler, 1335 of 2 AMPS adjust it to the Open position.

Switch 5: For 2 Amps Motors. For motors of the Ruffler, 1335 of 2 AMPS adjust it to the closed position.

Switch 6: For 2.5 Amps Motors. For motors of the Ruffler, 1335 of 2 AMPS adjust it to the Open position.

Switch 7: For 3 Amps Motors. For motors of the Ruffler 1335 of 2 AMPS adjust it to the Open position.

Switch 8: For 3.5 Amps Motors. For motors of the Ruffler, 1335 of 2 AMPS adjust it to the Open position.



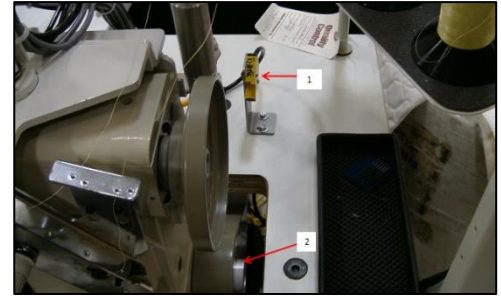
11. Touch Sensor

Located on the left side of the machine, its function is to raise or lower the guide of the edge roll or bellows. It is activated when detecting the presence of the finger.



12. Hand Wheel Sensor

The hand wheel sensor (1) is mounted on the top of the table, behind and to the right of the sewing head. The hand wheel sensor (1) reads a piece of the reflective tape located on the pulley disk (2). The hand wheel sensor is responsible for reporting to the Efka engine that the sewing head is sewing at the set RPM, stitch counting for all counters, and for the position of the needle when it stops.



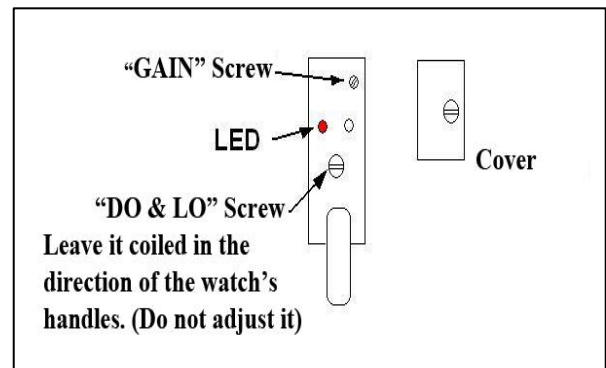
13. Non Woven Panel End Sensor

This sensor is located under the top of the table, part of the folding access. This sensor looks for the end of the nonwoven panel. When the end of the non-woven panel passes through it, it sends a signal to the control box of the folder to start counting stitches for the stop count, selectors 3 and 4.



14. Adjustment of the Electric Sensor Eye

To adjust the sensor, first remove the clear plastic cover from the end of the sensor. There are two adjustment screws under this cover. One is marked "GAIN" and is used to adjust the sensitivity of the sensor. The other screw is marked "DO & LO" and must always be set fully clockwise. With the end of the sensor pointing to the center of the reflective tape, turn the "GAIN" screw against the clock until the red LED indicator goes off. Then turn the "GAIN" screw in the clockwise direction until the LED indicator lights. Continue turning the screw in that direction until the end. The LED should be flashing slowly. Cover the eye in such a way that the sensor cannot see the reflective tape and the LED indicator should go out

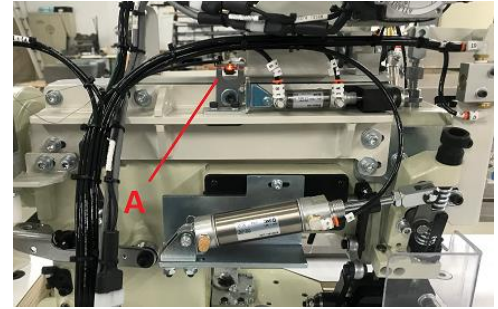


15. Maintenance of the Reflective Tape

Use a soft cloth for cleaning.
Do not use chemicals or abrasives to clean it.
Avoid contact with oils and liquids.
Do not touch the tape with your bare fingers.
If the tape is dirty or opaque, the sensor eye will not work properly.

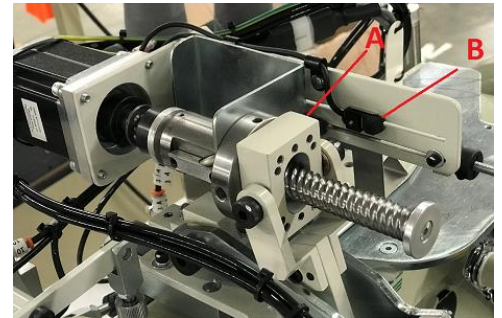
16. Edge Guide Position Sensor

It is activated when the edge guide is anchored in its working position. If this sensor is not activated, seam ruffles will not be produced.



17. Adjustable Stroke Sensor of the Stepper Motor Shaft

The stroke sensor "A" limits the stroke of the step motor. This sensor moves position through the size adjustment cam of the ruffle.



When moved, the knurled nut increases or decreases the motor travel, producing a change in the size of the ruffle.



18. Fixed Stroke Sensor of the Stepper Motor Shaft

The stroke sensor "B" when activated changes the direction of rotation of the motor returning the corrugated sheet of the Ruffler to its initial position. Its position is fixed through screw "C". It must be adjusted so that the ruffles sheet stops just in front of the needle before performing the ruffle seam cycle. For adjustment, refer to the mechanical adjustment chapter of this manual.



3.6. Programming

1 Input and Output Elements

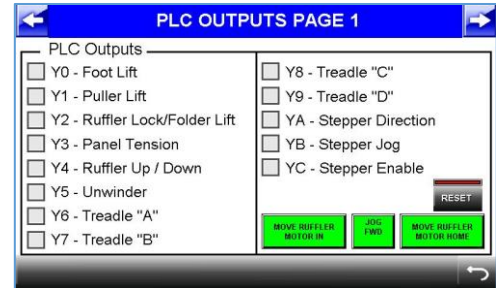
Pressing the key gives access to the input and output elements.
to.

a. Output Screen Page 1

They show the status of all the outputs of the microprocessor.

By pressing the white squares some of them will be able to activate the valves

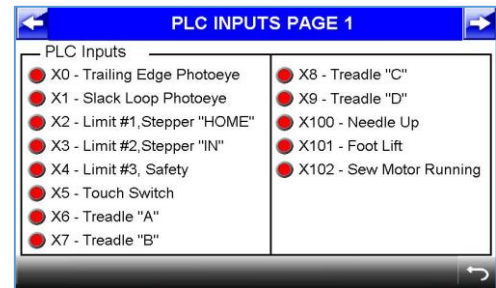
When pressing the sewing pedal or performing any sewing operation, the squares will be activated showing their operation. Green fields activate the stepping motor to make mechanical adjustments to the pleat system.



b. Input Screen Page 1

They show the status of all the inputs of the microprocessor.

Pressing the sewing pedal or performing any sewing operation and the red dots will turn green when activated



c. Various Settings Page 3

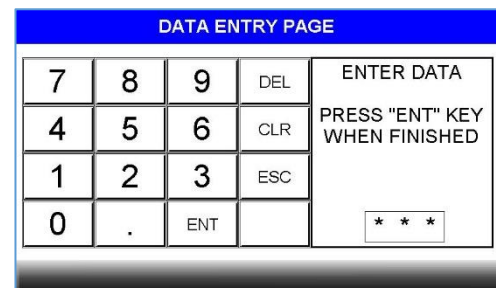
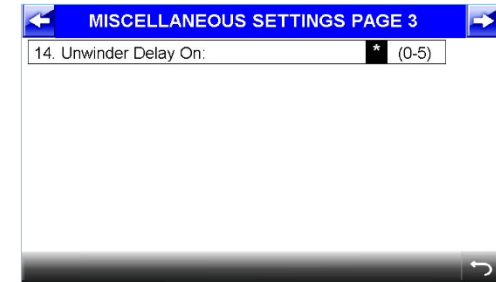
Shows the reaction time of the roll feed motor in reference to pressing the sewing pedal.

To change the value, click on the field with the dark number.

The access code request will be displayed.
Enter the access code: 2222.

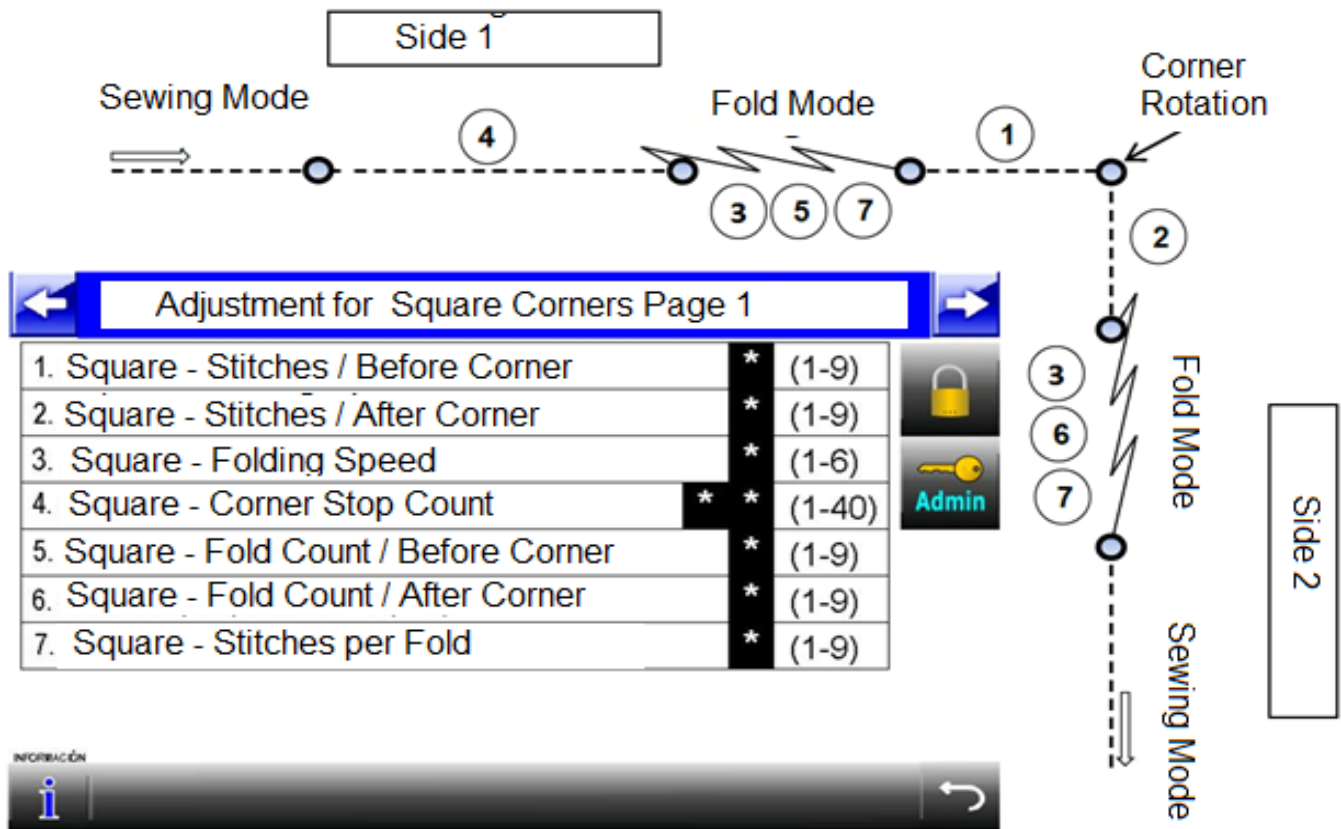
It will return to the various adjustment screen.
Click again on the black field you want to change.

The value input screen will be displayed...
Change the value with the desired value.



e. Programming a Square Corner.

Details of each of the steps correspond to the settings during the sewing cycle.



This is the stitch count (1-9 stitches) from the end of the first set of ruffles until the needle stops to rotate the material. This should be adjusted to stop the nonwoven panel so that when the corner is completed the right edge of the nonwoven panel is flush against the edge guide.

This is the stitch count (1-9 stitches) from when the material is rotated until the second set of ruffles is started. This should be set so that the gap between the first set of ruffles and the second set is symmetrical.

Controls the sewing speed of the head during folding. Each increment is approximately 100 rpm. The normal position is "6".

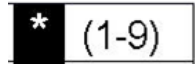
Stop Count for the corners. This is the stitch count (00-99 stitches) from when the front sensor is exposed until the seam stops at the corner to start the folding cycle. This should be adjusted to stop the nonwoven panel so that when the corner is completed the right edge of the nonwoven panel is flush against the edge guide. If, after turning the corner, the right edge of the nonwoven panel is to the right of the edge guide, increase the stitch count to stop the nonwoven panel closer to the presser foot.

Ruffler will sew towards the corner and will make the number of folds programmed in this field; then the ruffler will stop; the presser foot and pinch roller will rise. The operator must keep the sewing pedal depressed while the nonwoven panel is rotated 90 degrees without sewing. After step 5 when the sewing pedal is released and pressed again the ruffler will make the number of ruffles programmed in this field and start sewing at the regular speed.

Service

Sets the number of stitches sewn in each pleat and is adjusted according to the size of the pleat. There should be enough stitches to sew the folded edge of each pleat.

To change the values, press the dark field in the column of numbers the value you want to change.



Screen will appear.

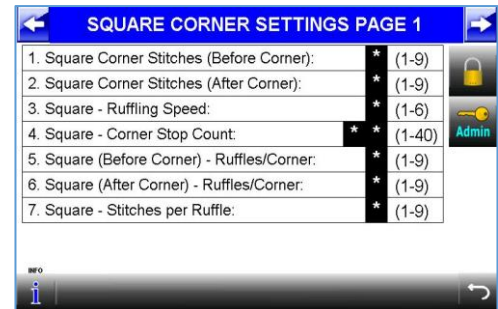
Type the Keys
Supervisor Level: 2222
Technical Level: 3333



Press ENTER

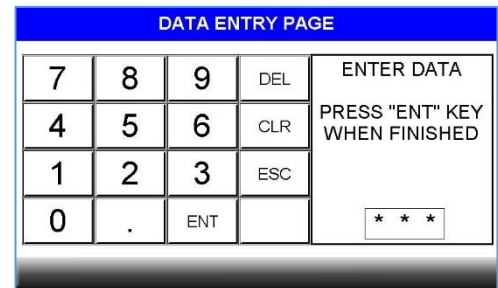


The screen appears with a padlock on the right a key in case of technical service level.



Press again the value you want to change

The data entry screen appears. Press the values you want to update.



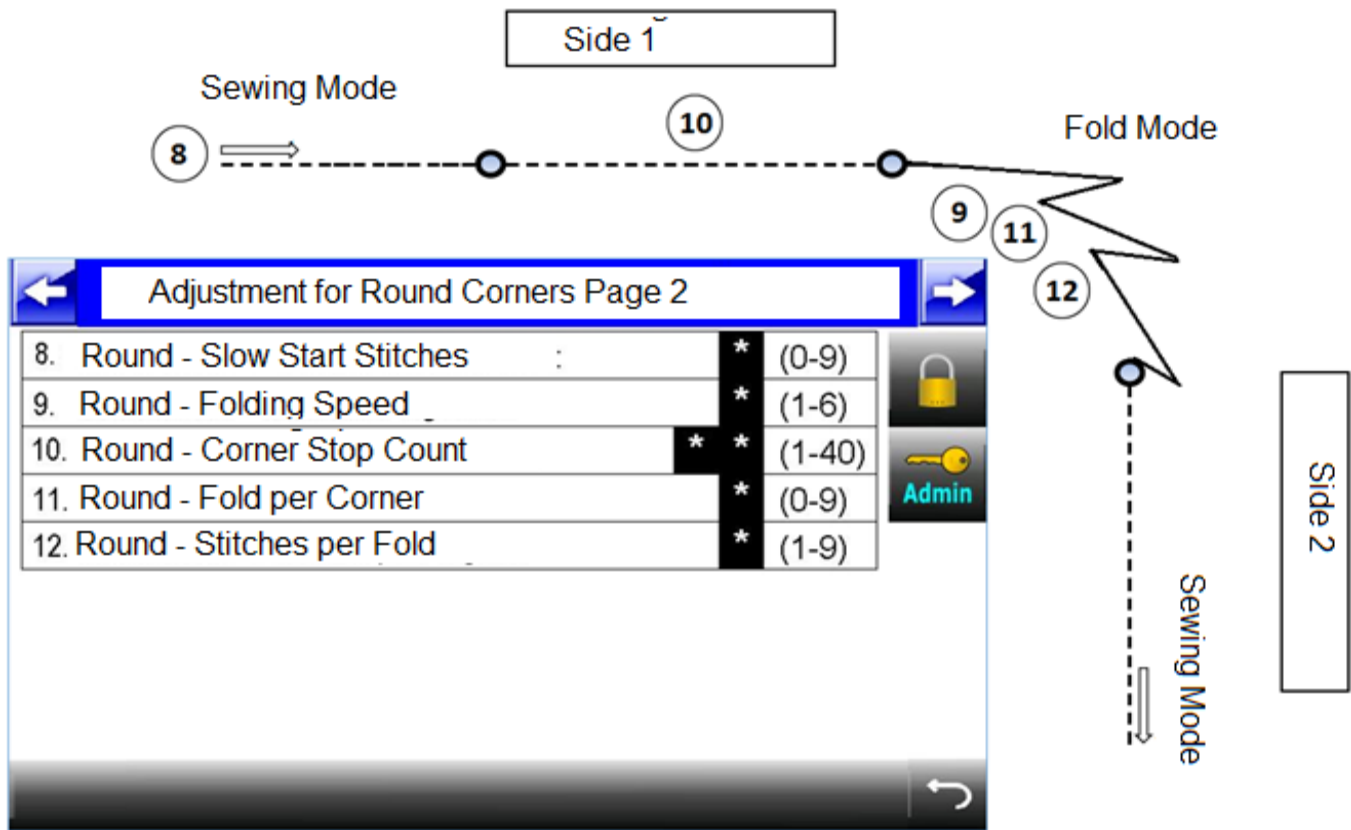
Press ENTER. value is accepted.



At the end of the change of numbers press  and it will take you to the initial screen.

f. Programming a Round Corner.

Details of each of the steps correspond to the settings during the sewing cycle.



Sets the stitch count for the Slow Start function after the last fold. This reduces the sewing speed for a few stitches to help feed the material to the pinch roller before the machine goes to high speed. The stitch count is equal to twice the number displayed by the dial. This function can be turned off by placing the selector on "0"

Controls the sewing speed of the head during folding. Each increment is approximately 100 rpm. The normal position is "6".

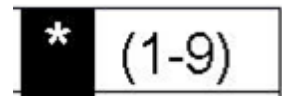
Stop Count for the corners. This is the stitch count (00-99 stitches) from when the front sensor is exposed until the seam stops at the corner to start the folding cycle. This should be adjusted to stop the nonwoven panel so that when the corner is completed the right edge of the nonwoven panel is flush against the edge guide. If, after turning the corner, the right edge of the nonwoven panel is to the right of the edge guide, increase the stitch count to stop the nonwoven panel closer to the presser foot.

Ruffler will sew towards the corner and will make the number of folds programmed in this field; The non-woven panel should be turned while folding to form a rounded corner, then the folder will stop; When the sewing pedal is released and pressed again the machine will start sewing at the regular speed.

Stitches Per Pleat: Sets the number of stitches sewn in each pleat and is adjusted according to the size of the pleat. There should be enough stitches to sew the folded edge of each pleat

Service

To change the values, press the dark field in the column of numbers the value you want to change.



Screen will appear.

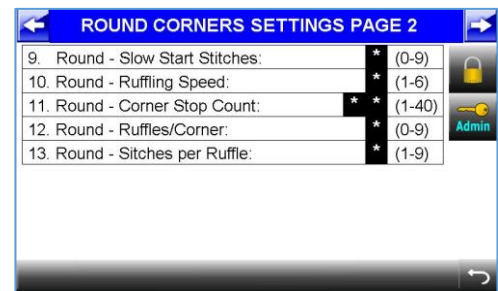
Type the Key
Supervisor Level: 2222
Technical Level: 3333



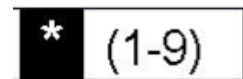
Press ENTER



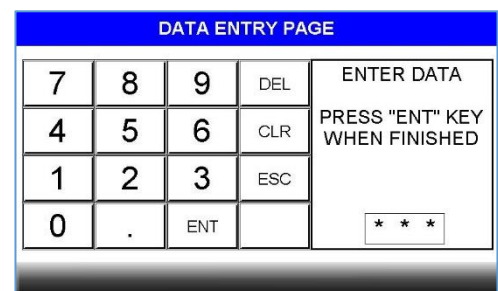
The screen appears with a padlock on the right a key in case of technical service level.



Press again the value you want to change.



The data entry screen appears. Press the values you want to update.



Press ENTER. value is accepted.



At the end of the change of numbers press  and it will take you to the initial screen.

3.7. Maintenance

It is important that the machine technician read this manual and be familiar with all features and safety concerns of the unit before installing and operating.

Maintenance should only be performed by trained and qualified personnel.

1. General Safety Instructions

Maintenance should only be performed by trained and qualified personnel. Before carrying out any maintenance or repair work, turn off the electrical, pneumatic, etc. of the machine at the main source and secure it with a padlock so that it cannot be turned on again without authorization. See Lockout/Tagout Procedures

Always wear the proper safety equipment when operating or performing maintenance on any equipment.

All recommended maintenance is for a single shift schedule; adjust as necessary for a multi-shift operation.

The equipment must not be used for purposes other than those designed or specified.

The machine must be switched off, stopped, and secured so that it cannot be inadvertently restarted before starting any maintenance work.

Use proper lockout/tagout procedures to secure the machine against inadvertent starting.

Remove any oil, grease, dirt and debris from the machine, especially from connections and bolts, when starting maintenance and/or repair work

Do not use corrosive cleaning agents.

Use lint-free cloths.

Retighten all screw connections that must be loosened for maintenance and repair work.

All safety mechanisms that must be removed for installation, maintenance or repair purposes must be repaired and checked immediately after completing the work.

2. Preparation

Turn off the machine

Open all covers of the machine.

3.8. Faults

Problema	Causa:	Acción Correctiva
Machine does not turn on	Electrical fault	Check that the main switch and that of the Efka motor box are working.
Skip Stitch	Thread Tensions Looper Adjustment Needle position. Air pressure Material thickness	Check the threading of the threads and the correct tension of the same. Check all settings of the crimper and openers. Use the manual as a reference. Check the condition of the needle and check its position. If the air pressure of the cloth presser is too low, skipped stitches may occur. Try thinner material
Sstep motor, not working	• Adjustment of box values	Make sure the amber light is on on the box Make sure that the shirring values on the control panel are close to 80. In case this value is too low the rotation of the stepper motor will be too low which will cause it to stop suddenly If the value is much above 80 it will move very fast and may collapse Reduce the air pressure of the cloth presser. Check the connection of the stepper motor to the control box.

3.9. High Mortality Parts Kit

The machine is offered as an option with a set of high mortality parts recommended for the natural consumption of the machine. The content of the kit is as follows:

Part Number: SP1335ET

Item	Part Number	Description	Qty
1	022400015	Feed tooth screw 11 / 64-40 x 10 s	4
2	028770001	Oil filter	2
3	110400023	Screw	4
4	1278-7055D	Prox switch with plug, 12" 10-30v	1
5	1335M-2002E	Shirring sheet, 2.25wx12tpi 3.	1
6	197400023	Spreader	2
7	197480010	needle guard	2
8	197480011	Looper	2
9	197480012	Looper Screw, 9/64-40 x 7 Slot	4
10	197480013	Looper bracket screw 9 / 64-40 x	4
11	197480014	Needle guard screw 1/8-44 x 6	4
12	EEFE-RR2	Tape, reflective, 1" wide	12
13	FFSM312LVQ	Photocell, 10-30vdc with 4 pin	1
14	S150220041	Presser foot screw m4 x	4
15	SN62X5722	Needle, 62x57, size 22/140	100
16	SSSSM3X3	Screw, m3-.5x3	4

3.10. Training

Actividad	Tiempo
Security instructions	5 min
Use of the Manual	5 min
FACILITY	2 hr.
ON / Off Switch Control Panel	20 min
PREPARATION Threading of machine Material roll position and adjustment Tension adjustment. Roll and panel guide adjustments. Folder Calibration	1 hr.
SEWING square corners round corners Adjustment of Measurements	4 hr
Preventative Maintenance 8hrs	15 min
SERVICE Lockout Tagout Program	15 min
MECHANICAL ADJUSTMENTS folding sheet looper time Pinch roller time	3 hr
PNEUMATIC ADJUSTMENTS Pressure regulators Cylinder regulation	1 hr
Electrical Adjustments Main Switch Sensors Programming Motors and Drive Boxes	3 hr.
MAINTENANCE Lubrication Preventive Maintenance 8hrs Preventive Maintenance 40 hours Preventive Maintenance 160 hours	1 hr
Problems and Solutions	2 hr
Total:	18:00

Participants:

Instructor: _____

Date: _____

Drawings and Parts Lists

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One-Stop Shopping

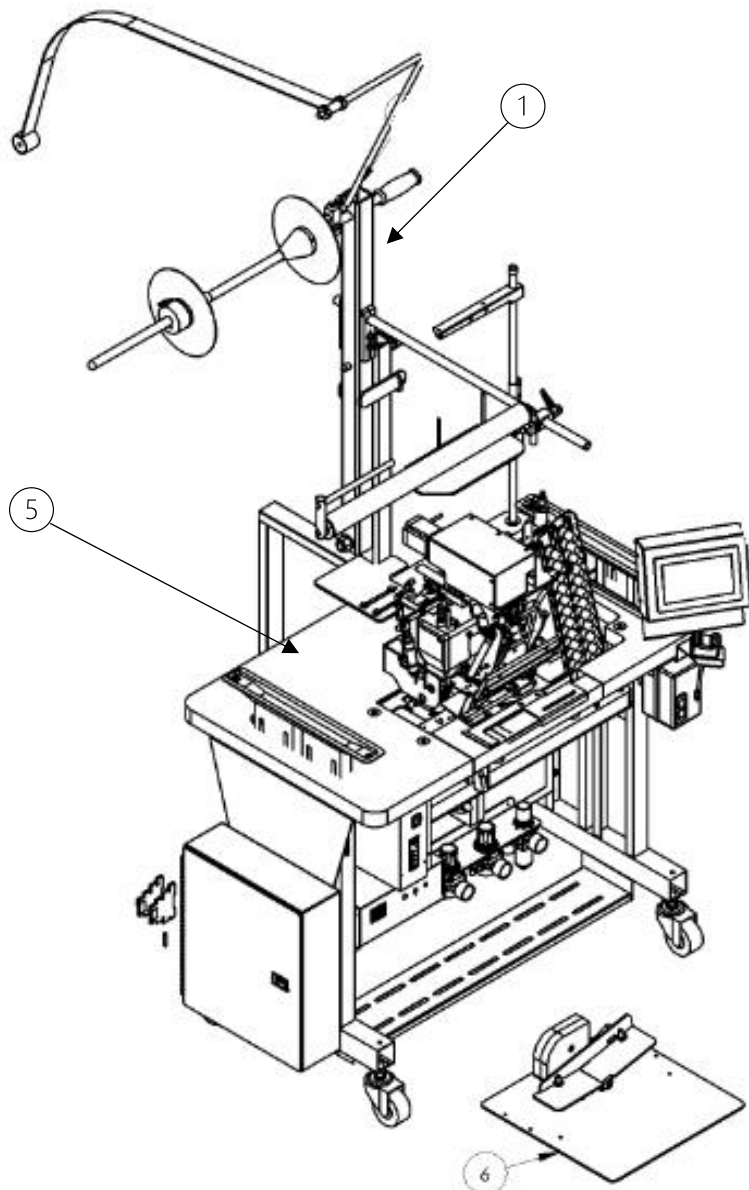
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11335ETA Ruffler, Workstation, Economy, PLC

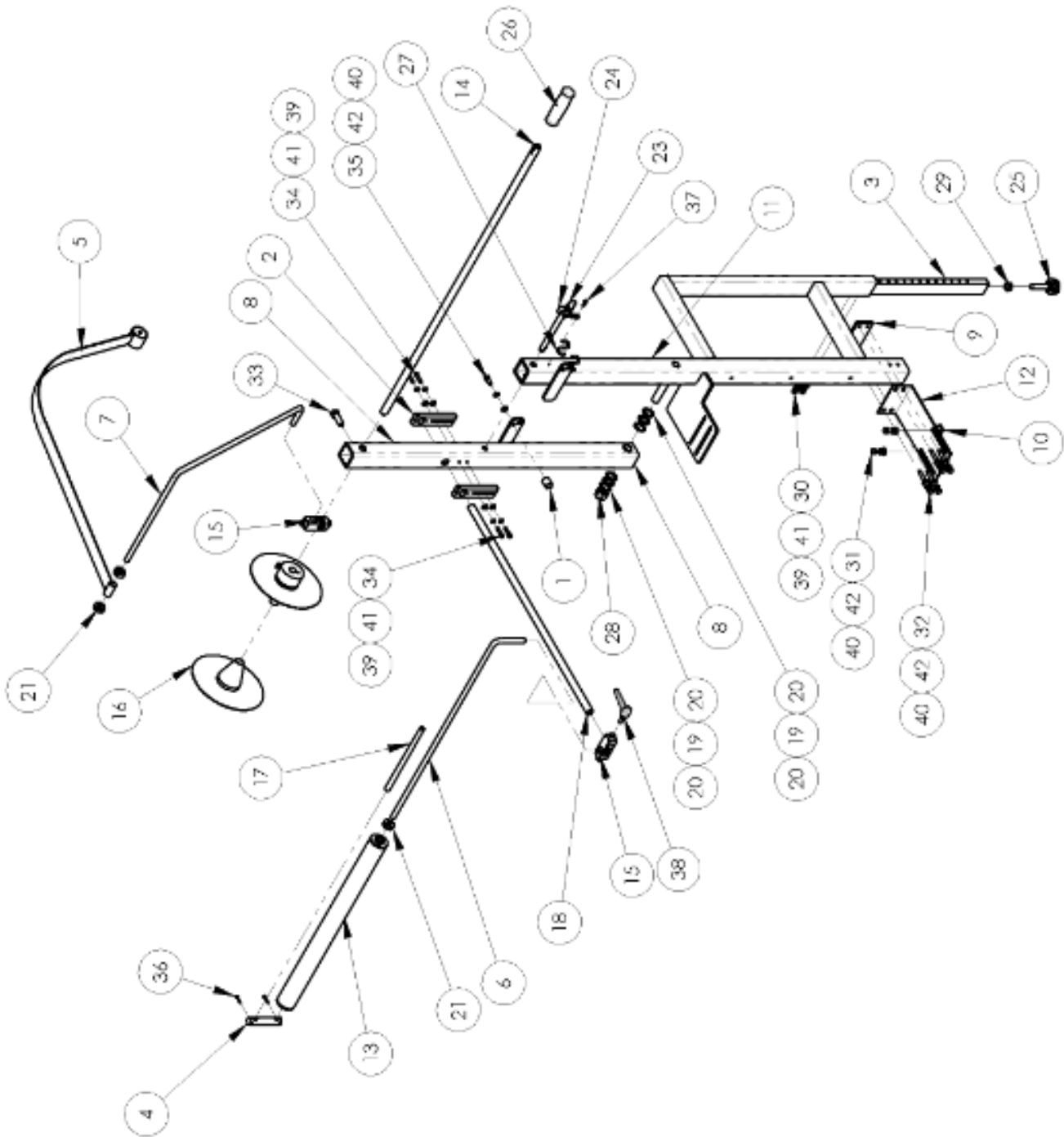
AAC Drawing Number 9007760 Rev 0



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1335930	ROLLHOLDER ASSY,OVERHEAD
2	1	1335MF-PD	DIAGRAM, PNEUMATIC
3	1	1335MPLC-WD2	WIRING DIA., POWER
4	1	1335MPLC-WD1	WIRING DIA., PLC
5	1	1336004	BASE CONSOLE,TYPICAL,PLC
6	1	4059-FP301D	FOOT PEDAL ASSY,EFGA

1335930 Roll Holder Assembly, Overhead

AAC Drawing Number 1335930 Rev 4

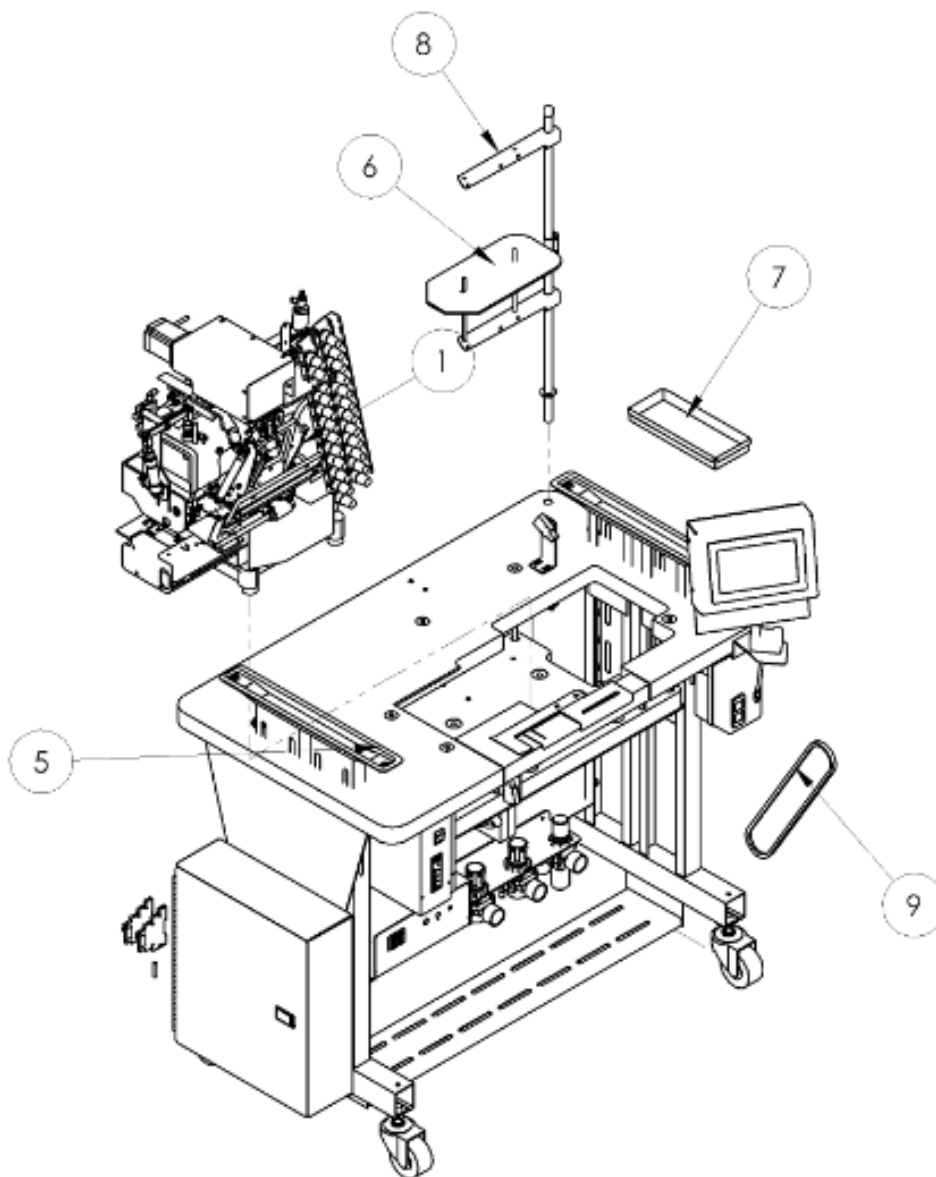


1335930 parts list

ITEM	QTY	PART NUMBER	DESCRIPTION	ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	11200A	BUMPER 5/16-24	22	2 FT	K-3594T47	CHAIN, .190, .34W
2	2	1325-346A	HOLDER, ROD, 3/4", SLOT	23	1	MM30345T21	LANYARD,6"LONG
3	1	132556-273	LEG, 3/4 X 1-1/2 X 15 LG	24	1	MM98320A525	QUICK RELEASE PIN,1/2"DIA
4	1	1335-319B	ARM, 1/2" ROD CLAMP	25	1	MMFB4444	FOOT, RUBBER, 1/2-13 STUD
5	1	1335-825	DRAG TENSION ASSEMBLY	26	1	MMGP-105	GRIP HANDLE-FOAM 3/4 ID
6	1	1335-835A	ROD,1/2 DIA, 90 DEG	27	2	MMS096	HOOK,S,3/16 X 1-1/2"
7	1	1335179	ROD,BENT,CRS,1/2 OD	28	1	NNE.75-16	NUT,ELASTIC LOCK,3/4-16
8	1	1335664	PIVOT,SWING ARM,UNWINDER	29	1	NNH1/2-13	NUT,HEX,1/2-13
9	1	1335667	NUT,PLATE,5/16-18 4X	30	2	SSHC01064	1/4-20 X 1 HHCS
10	1	1335794	NUT,PLATE,5/16-18,2@3.0	31	2	SSHC10064	5/16-18 X 1 HHCS
11	1	1335931	MAIN SUPPORT,UNWINDER	32	4	SSHC10176	5/16-18 X 2.75 HHCS
12	1	1335932	STABILIZER,UNWINDER,1335E	33	1	SSHC45096	1/2-13X1-1/2 HEX CAP
13	1	1771-205	ROLLER,2.0ODX.5IDX23.38L	34	4	SSSC01064	1/4-20 X 1 SOC CAP
14	1	1961-252E	ROD,ROLL,,SST,3/4X39 W/RAD	35	1	SSSC10048	5/16-18X3/4 SOC CAP
15	2	28201	CROSS BLOCK, 3/4 X 3/4	36	2	SSSC90048	#8-32 X 3/4 SOC CAP SC
16	2	33008708	DISC ASSY,8"	37	1	SSSC98032	10-32X1/2, SOC CAP
17	1	8732-0576	ROD, STRAIGHT, SS, 1/2 X	38	1	TTH32425	HANDLE,THRDED,5/16-18X3/4
18	1	97-1711	TUBE, 3/4 X 30 X 1/8 WALL	39	6	WWFS1/4	WASHER,FLAT,SAE,1/4
19	2	BBNTA1220	BEARING,THRUST,.750B	40	7	WWFS5/16	WASHER,FLAT,SAE,5/16
20	4	BBTRA1220	WASHER,THRUST,STEEL	41	6	WWL1/4	WASHER,LOCK, 1/4
21	3	CCCL8F	CLAMP COLLAR- 1/2	42	7	WWL5/16	WASHER,LOCK, 5/16

1336004 Console Base, PLC

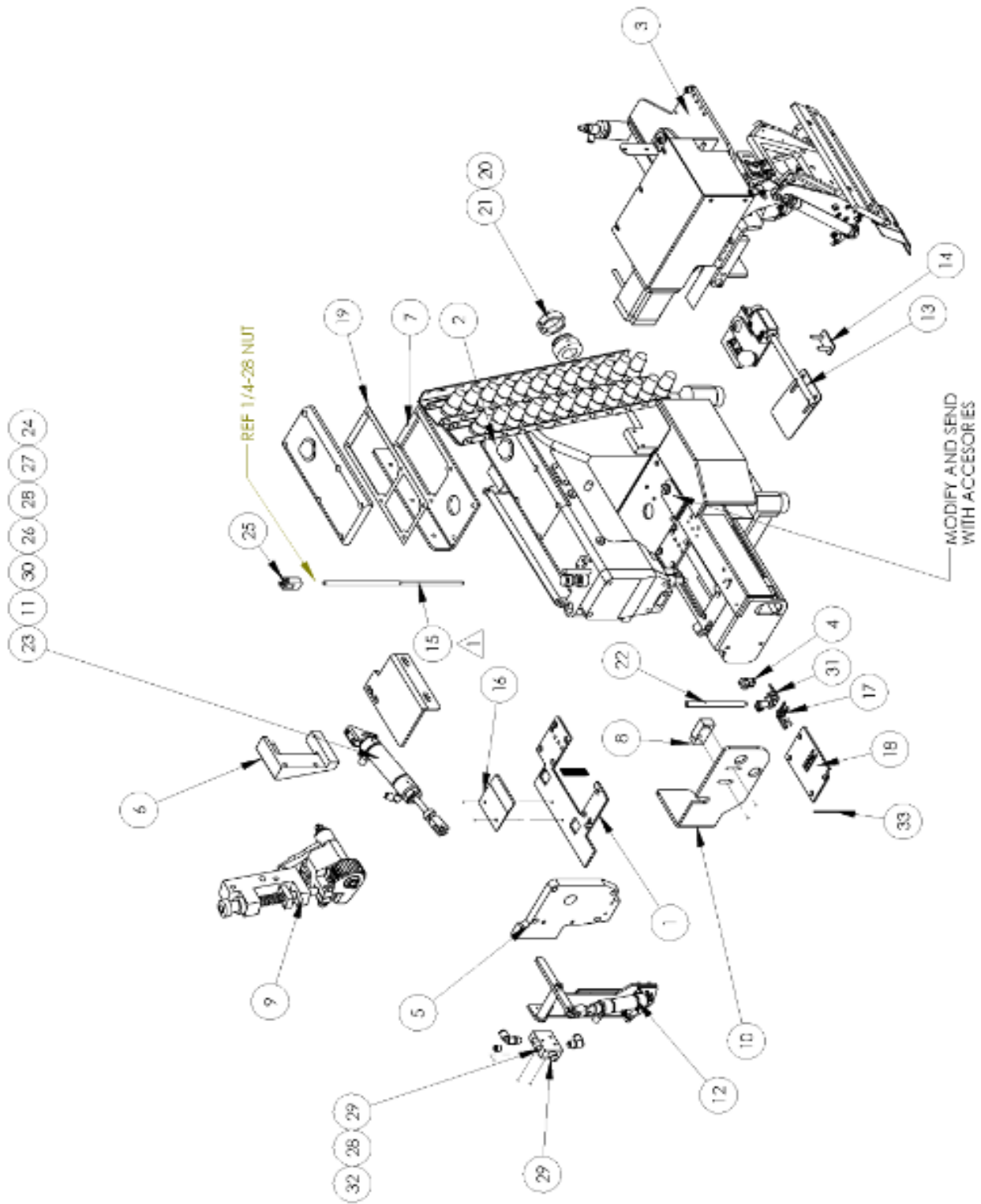
AAC Drawing Number 1336004 Rev 0



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1325144	SEW HEAD SUBASSEMBLY
2	1	1335MF-PD	DIAGRAM, PNEUMATIC
3	1	1335MPLC-WD1	WIRING DIA., PLC
4	1	1335MPLC-WD2	WIRING DIA., POWER
5	1	1336012	STAND / MOTOR ASSY- TYP GK-321
6	1	1959-112	2 POS THREAD PLATE ASSY
7	1	26151	TOOL TRAY, 1X3.5X9
8	1	D-2	THREAD STAND, 2 THREAD
9	1	ZX3833	V-BELT, 3/8 X 33
10	1	4059-DC1500	EFKA DC1500/AB220A

1325144 Sew Head Assembly

AAC Drawing Number 1325144 Rev 1

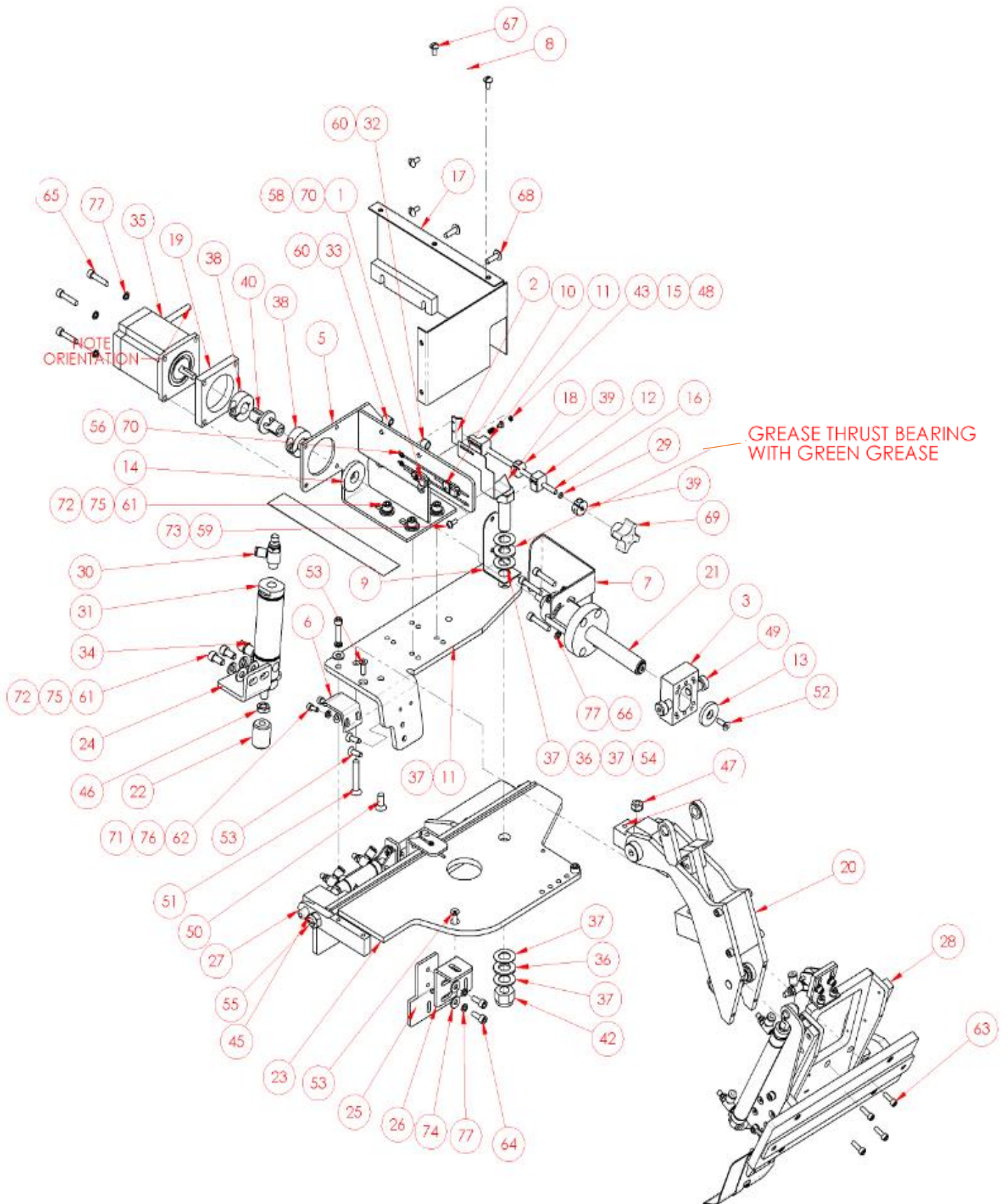


1325144 parts list

ITEM NO.	QTY	PART NUMBER	DESCRIPTION	ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1325146	SEW HEAD PLATE	18	1	1889N13000	THROAT PLATE, 1 NDL
2	1	1325147	SEWING HEAD, MODIFIED	19	1	197100005	HEAD GASKET
3	1	1325148	RUFFLER ASSEMBLY, TYP	20	1	311-128	HUB, HANDWHEEL, TAPE MOUN
4	1	1325151	NEEDLE CHUCK, 1IN TYP	21	1	311-129	SLEEVE TAPE MOUNT ADJUST
5	1	1325152	FACE PLATE, TYP	22	1	3300015	PRESSER BER, 1804 YAMATO
6	1	1325153	BRKT, PULLER MOUNT, TYP	23	1	AAC6DP-1.5	CYLINDER, AIR, DA, PIVOT
7	1	1325154	RUFFLER MOUNTING BKT, TYP	24	1	AAFBP-11C	BRKT, PIVOT, 1/4 BORE
8	1	1325159	SPACER, GUARD, TYPICAL	25	1	AAFCT-7	HUMPHREY CLEVIS
9	1	1325160	PULLER SUB-ASSY	26	1	AAFCT-11	CLEVIS, CYL, 5/16-24, 1/4
10	1	1325163	PULLER GUARD-HD	27	1	AAFP18	MUFFLER, 1/8 NPT, BRONZ
11	1	1325166	BRACKET PULLER LIFT-HD	28	3	AAQME-5-8	QUICK MALE ELBOW
12	1	1325173	FOOT PRESSURE ASSY	29	1	AAV41-P	HUMPHREY VALVE, 4 WAY
13	1	1325175	STRIPPER BLADE ASSY	30	1	CCCL5F	CLAMP COLLAR, 5/16" BORE
14	1	1325177	PLATE, 10-32 PEM STUD	31	1	M1V67-016	FOOT, 1IN, RUFFLER
15	1	1335209	FOOT LIFT PIN	32	1	MM4554K11	PLUG, 1/8" PIPE
16	1	1335418	PULLER WEAR PLATE	33	10	SN62X5721	NEEDLE, SIZE 130/21
17	1	1888N12S01	FEED DOG 1N				

1325148 Ruffler Assembly, TYP

AAC Drawing Number 1325148 Rev 0



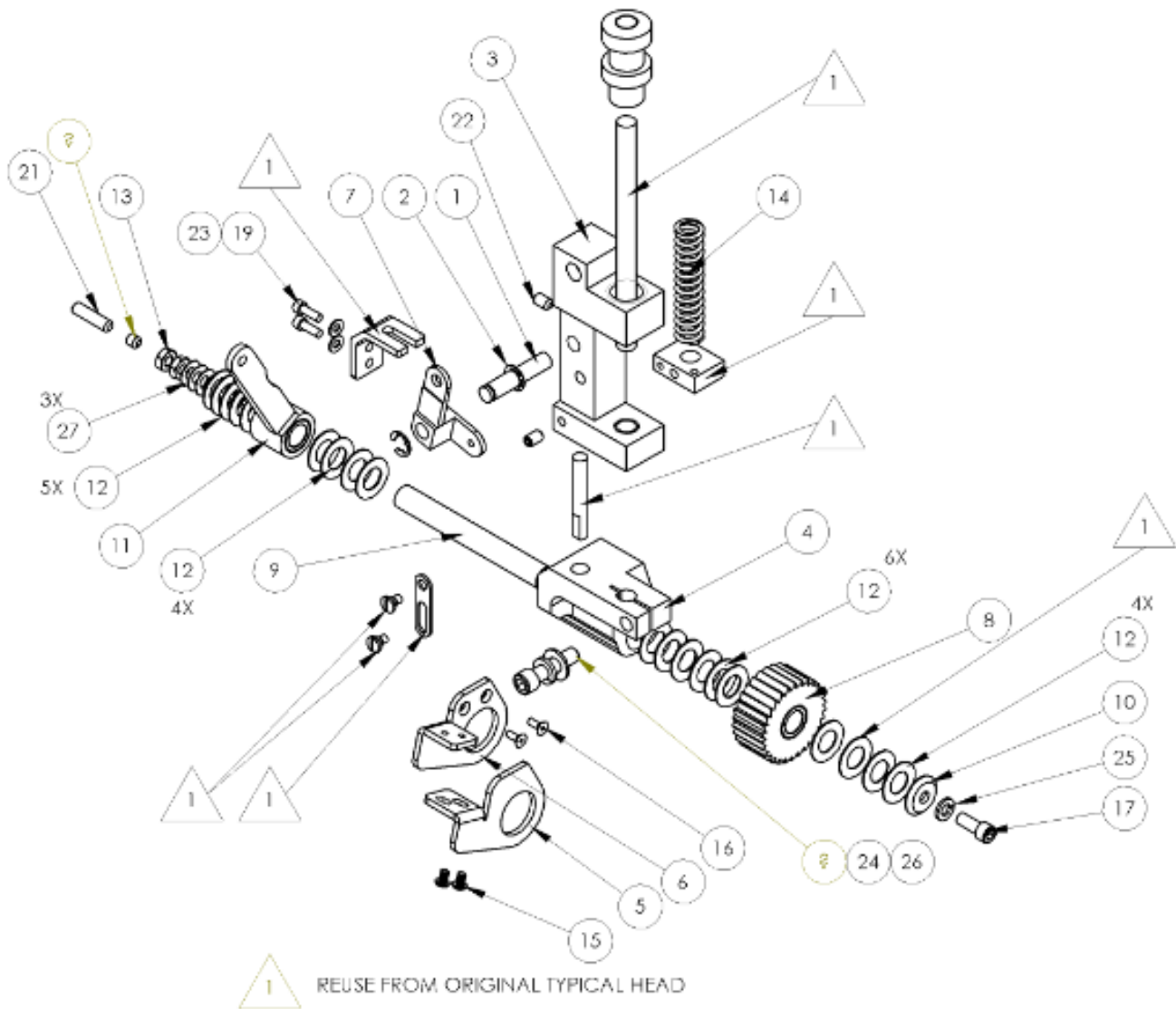


1325148 parts list

ITEM NO.	QTY	PART NUMBER	DESCRIPTION	ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	2	1278-7055B	PROX. SWITCH W/ PLUG 12" LG	40	1	MM8FM	JOINT,UNIVERSAL,MOD
2	1	1335M-001	BRACKET, STOP, PRX SWITCH	41	11*	MM130-10A1	TAPE, UHMW, 1" W X .01 TK
3	1	1335M-2006	BLOCK, NUT TRUNION	42	1	NNE1/2-13	NUT, ELASTIC 1/2-13
11	1	1335M-2008	PIVOT PLATE	43	1	NNH2-56	NUT,HEX,2-56
5	1	1335M-2016	WELDMENT,MOTOR BRKT	44	1	NNH10-32	HEX-NUT 10-32 REG.
6	1	1335M-2020	HLD DWN BRKT	45	1	NNJ3/8-16	3/8-16 JAM NUT
7	1	1335M-2021	VANE, SWITCH ACTUATING	46	1	NNJ5/16-24	NUT,JAM,5/16-24
8	1	1335M-2030	MOTOR COVER, CLEAR	47	1	NNK1/4-20	KEP NUT, 1/4-20
9	1	1335M-2031	PIVOT BRKT AIR LINE	48	1	RRLC026B1	SPRING,COMP .026X.18X.25
10	1	1335M-2034	PLATE, NUT #2-56	49	2	SSAS024024M	3/8 X 3/4 X 5/16-18
11	1	1335M-2035	ADJUSTMENT NUT, 10-32	50	1	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
12	1	1335M-2036	SUPPORT BLOCK	51	1	SSFC01096	1/4-20 X 1-1/2 FLAT CAP
13	1	1335M-2037	WASHER, STOP	52	1	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
14	1	1335M-2038	STOP WASHER	53	4	SSFC98040	#10-32 X 5/8 FLAT ALLEN
15	1	1335M-2039	NUT,SPRING RETAINER	54	1	SSHC45096	1/2-13X1-1/2 HEX CAP
16	1	1335M-2040	SCREW, ADJUSTMENT	55	1	SSMB58N	PLUNGER,BALL,3/8-16X5/8L
17	1	1335M-2042	COVER	56	2	SSPS50020	2-56 X 5/16 PAN HD SC
18	1	1335M-2047	POINTER, RUFFLE SIZE	57	1	SSPS50032	SCREW,2-56 x 1/2
19	1	1335M-2049	SPACER, MOTOR, 3/8	58	1	SSPS50048	SCREW,2-56 x 3/4
20	1	1335M-2300B	PIVOT ASSY	59	1	SSPS80024	#6-32 X 3/8 LG PAN HD
21	1	1335M-2400	BALL SCREW AND NUT	60	2	SSPS90024	SCREW, #8-32 X 3/8 LG PAN HD
22	1	11200A	BUMPER 5/16-24	61	6	SSSC01032	1/4-20X1/2 SOC CAP
23	1	1325149	RUFFLER MNT ASSY, TYP	62	2	SSSC90024	8-32 X 3/8 SOC CAP SC
24	1	1325156	FOOT LIFT BRKT	63	4	SSSC90032	#8-32 X 1/2 SOC CAP SC
25	1	1325170	SUPPORT BRKT-RUFFLER	64	2	SSSC98032	10-32X1/2, SOC CAP
26	1	1335218	ADJ ANGLE-RUFFLER SUPP	65	5	SSSC98056	10-32 X 7/8 SOC CAP
27	1	1335324	LOCKING LEVER	66	4	SSSC98064	10-32 X 1 SOC CAP
28	1	1335332	RUFFLER CYL LIFT ASSY	67	5	SSTS90024	#8-32 X 3/8 TRUSS HD
29	1	AA198-7006	O RING, 1/8 ID, 1/4 OD	68	2	SSTS98040	10-32 X 5/8,TRUSS HD
30	1	AA198RR508	FLOW CONTROL,5/32 X 1/8"	69	1	TTCL1APPK1	PLASTIC KNOB, #10-32
31	1	AAC6D-1.5	CYL, AIR, DA 1-1/16 B,1.5 S	70	4	WWF2	WASHER, FLAT, #2
32	1	AAF1/8	CLAMP,PLASTIC 1/8	71	2	WWF8	WASHER, FLAT, #8
33	1	AAF3/16	CLAMP, BLACK PLASTIC, 3/16 DIA	72	6	WWFS1/4	WASHER,FLAT,SAE,1/4
34	1	AAQME-5-8	ELBOW MALE,Q,5/32 TUBE, 1/8NPT	73	1	WWFS6	WASHER, FLAT, #6
35	1	AP-22E-103	STEP MOTOR, 2 AMP	74	4	WWFS10	WASHER, FLAT, #10, SAE
36	2	BBNTA815	BEARING,THRUST,1/2BORE	75	6	WWL1/4	WASHER,LOCK, 1/4
37	4	BBTRA815	WASHER,THRUST,STEEL 1/2	76	2	WWL8	WASHER,LOCK,#8
38	2	CCCL8F	CLAMP COLLAR- 1/2	77	12	WWL10	WASHER,LOCK,#10
39	2	CCCL10T	CLAMP COLLAR TRD, 10-32				

1325160 Puller Sub-Assembly

AAC Drawing Number 1325160 Rev 2



Notes:

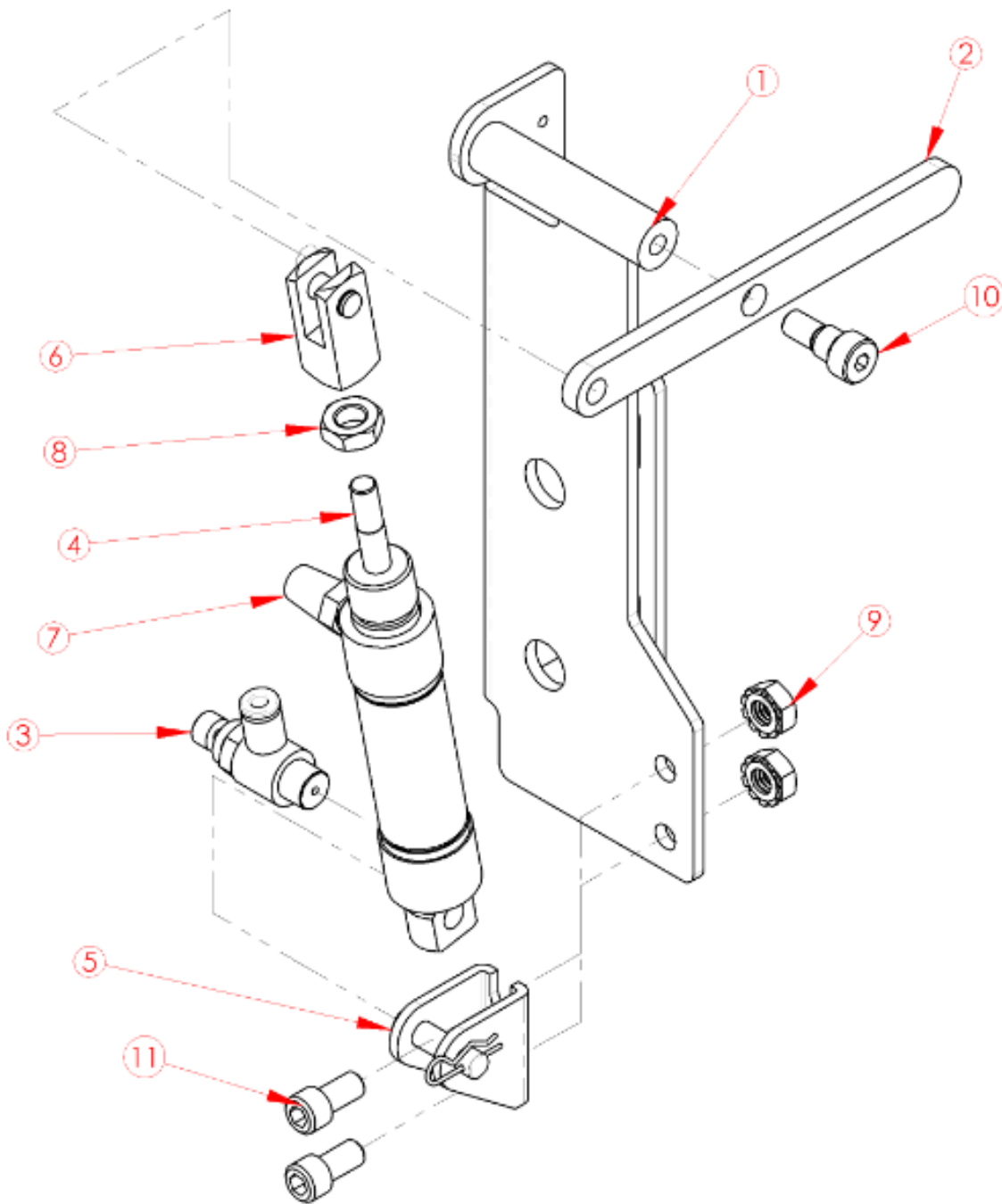
- 1 Arrange the components as shown (apply Teflon based grease to the bearings and a small amount to all mating thrust washer surfaces).
- 2 Screw in the small set screw to leave about $3/8$ " of threads in the axle on the right side.
- 3 Install and tighten the large set screw (21) against the small set screw to form a stud
- 4 Install and tighten the socket cap screw and the lock washer on the left side.
- 5 Preload the assembly using the inside jam nut until the roller has drag on it to prevent the puller roller from over-spinning.
- 6 Tighten the outside jam nut to stabilize or lock in the preload setting.

1325160 parts list

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	65375	UPPER ROLLER LIFT PIN
2	2	95027	RING,RETAINING,YAMATO
3	1	1325157	PULLER BRACKET
4	1	1325158	YOKE, PULLER-HD
5	1	1325161	STRIPPER PLATE, EXTENDED
6	1	1325162	STRIPPER PLATE,EXTENDED
7	1	1334056	PULLER LIFT LINK,11-64-40
8	1	1335397	PULLER ROLLER, HD, 2002MG
9	1	1335399	SHAFT, PULLER, HD
10	2	1335400	WASHER, HUB CAP, 1/4
11	1	1335414	DRIVE ARM, PULLER,1/2" ID
12	19	BBTRA815	WASHER,THRUST,STEEL 1/2
13	2	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
14	1	RRLC092H11M	SPRING,COMP, .092X.60X2.75
15	2	SSBC90016	8-32 X 1/4 BUTTON CAP
16	2	SSFC80024	6-32 X 3/8 FLAT CAP
17	1	SSSC05040	1/4-28 X 5/8, SOC CAP
18	1	SSSC20080	5/16-24X1-1/4, SOC SAP
19	2	SSSC90032	#8-32 X 1/2 SOC CAP SC
20	1	SSSS05016	1/4-28 X 1/4 SOC SET SC
21	1	SSSS05064	SET SCREW1/4-28X1
22	2	SSSSM6X10	M6 SET SCREW, 10MM L
23	2	WWB5/32	WASHER, FLAT, 5/32", BRAS
24	1	WWFS5/16	WASHER,FLAT,SAE,5/16
25	1	WWL1/4	WASHER,LOCK, 1/4
26	1	WWL5/16	WASHER,LOCK, 5/16
27	3	WWS307-1	WASHER,SPRING,BELVEL

1325173 Foot Pressure Assembly

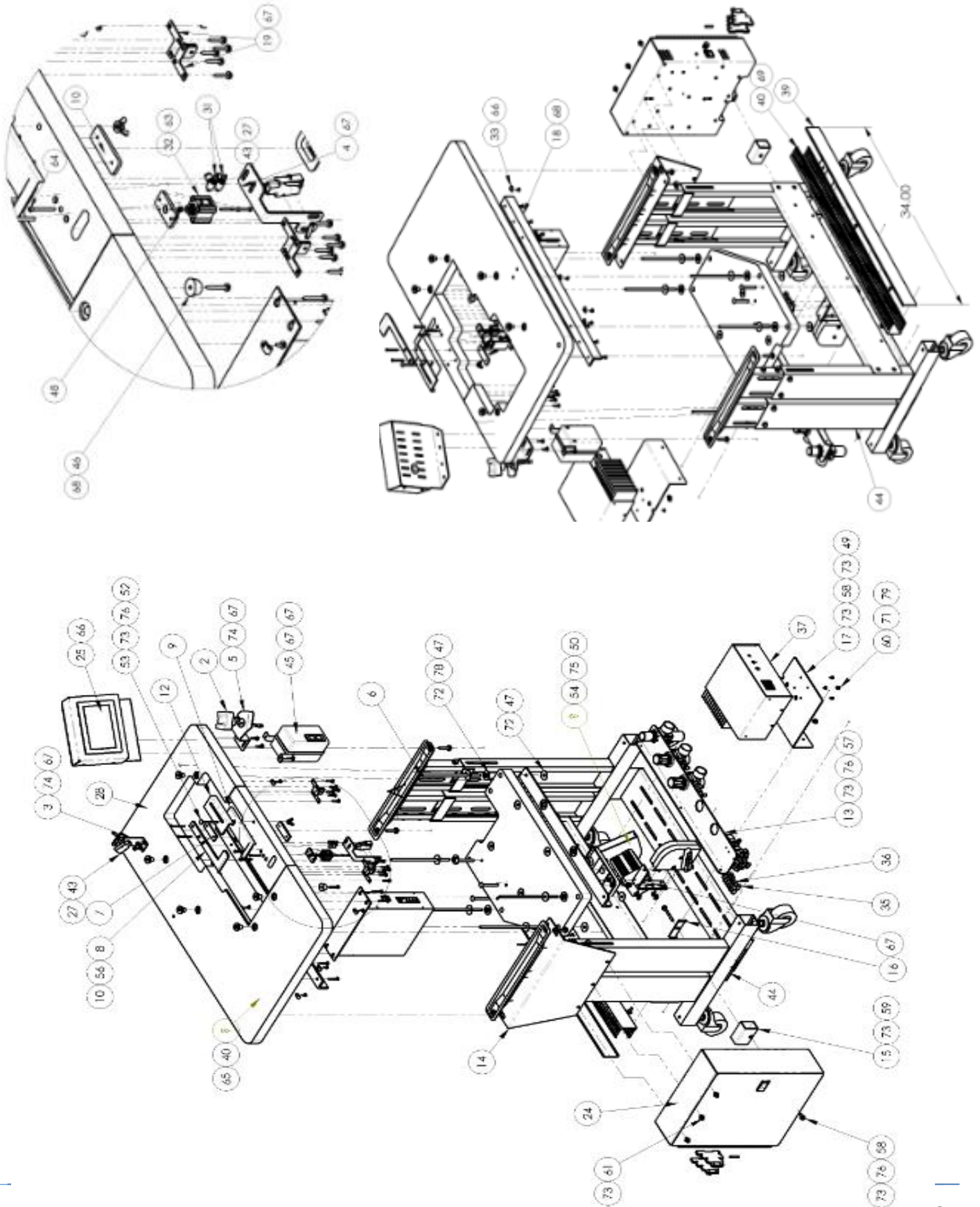
AAC Drawing Number 1325173 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION	ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1325171	MTG BRKT, FOOT LIFT	7	1	AAFP18	MUFFLER,1/8 NPT, BRONZ
2	1	1335M-108	LEVER,FOOT PRESSURE	8	1	NNJ5/16-24	NUT,JAM,5/16-24
3	1	AA198RR508	FLOW CONTROL,5/32 X 1/8"	9	2	NNK1/4-20	NUT,KEP,1/4-20
4	1	AAC7DP-.5	CYLINDER,AIR,DA	10	1	SSAS020016	SHOULDER BOLT 1/4 X 1/4L
5	1	AAFBP-11C	BRKT,PIVOT,1/4 BORE	11	2	SSSC01032	1/4-20X1/2 SOC CAP
6	1	AAFCT-7	HUMPHREY CLEVIS				

1336012 Stand and Motor Assembly, TYP GK-321

AAC Drawing Number 1336012 Rev 1

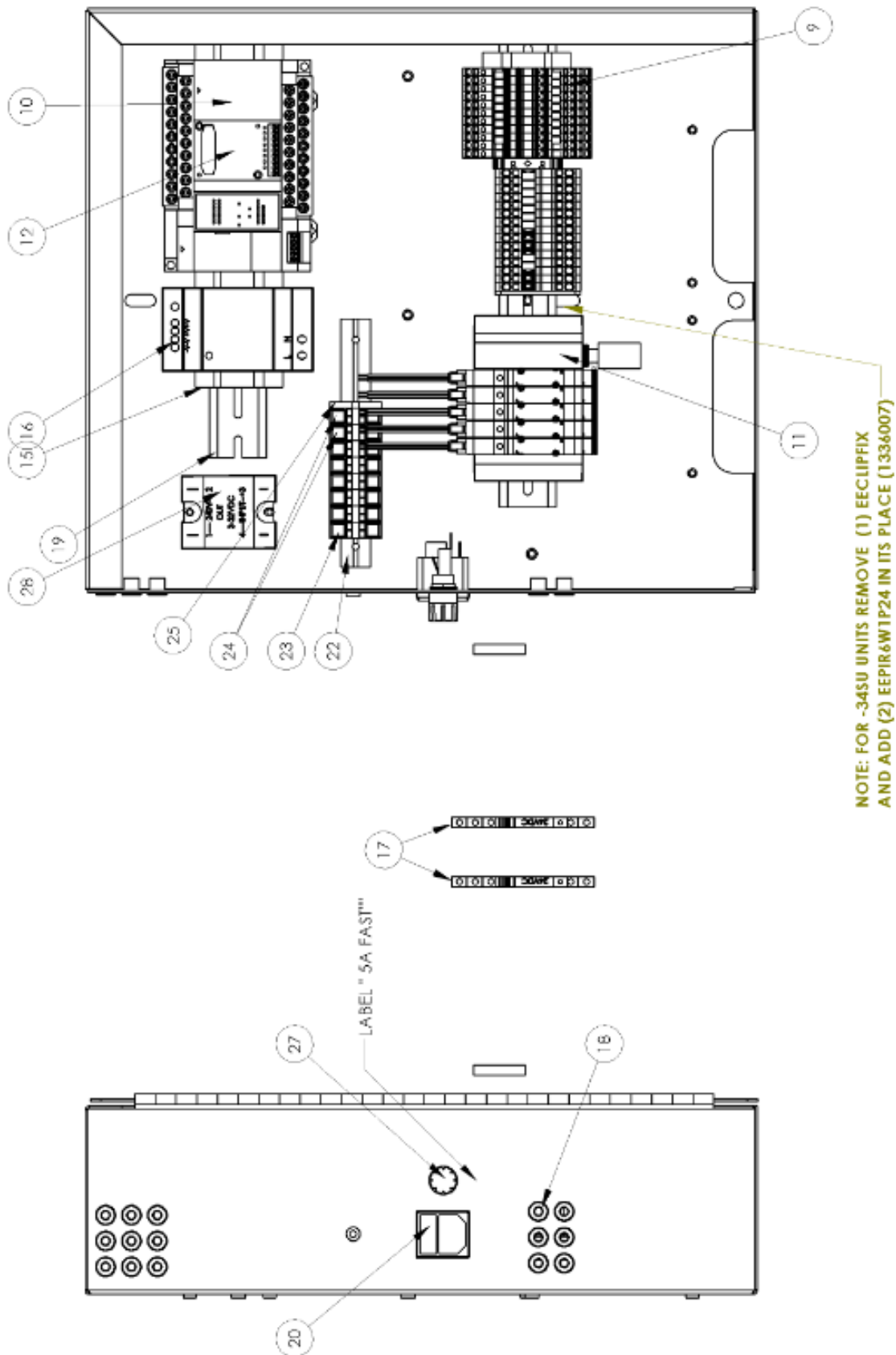


1336012 parts list

ITEM NO.	QTY	PART NUMBER	DESCRIPTION	ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	0211-702A	CABLE,POS. SENSOR,6'	41	1	FFHBL4579C	RECEPTACLE,3 POLE,3W
2	1	1278-6602A	TOUCH SWITCH ASSEMBLY	42	1	FFRK4413P5	CABLE,EURO-3P MOEX,5'
3	1	1278-6689B	BRACKET, EYE MOUNT	43	2	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
4	1	1278-6689D	TABLE EYE MOUNT	44	1	K-4D	
5	1	1278-6718A	BRKT,OPTO TOUCH SWITCH	45	1	K-CB600	MOTOR STARTER,ELEC
6	5	1335244	ROD THRD,5/16-18 X 8.75	46	1	MM9540K61	BUMPER,RUBBER 1" DIA
7	1	1335274	WASHER PLATE - PANEL TENS	47	16	NNH5/16-18	NUT,HEX, 5/16-18
8	1	1335275	TOP PLATE- PANEL TENSION	48	1	NNHM4X0.7	NUT,HEX,M4-0.7
9	1	1335278	PANEL TENSION FINGER	49	2	NINK1/4-20	NUT,KEP,1/4-20
10	1	1335280	NUT PLATE - PANEL TENSION	50	3	NINK5/16-18	NUT,KEP,5/16-18
11	1	1335281	NUT PLATE - PANEL TENSION	51	5	NNM103	NUT,RECESSED,5/16-18
12	1	1335284	EDGE GUIDE	52	1	NNW1/4-20	NUT, WING, 1/4-20
13	1	1335716	PNEUMATIC, SHELF	53	1	SSBK01160	BOLT, CRGE, 1/4-20X2-1/2
14	1	1335784	BRKT,ANGLE,CONTROL BOX	54	3	SSBK10160	BOLT, CARRAGE, 5/16X2.5
15	1	1335785	SPACER BLOCK	55	2	SSFS90048	#8-32 X 3/4 FLAT SLOT
16	1	1335786	SPACER HOLDER	56	2	SSFS90048	#8-32 X 3/4 FLAT SLOT
17	1	1335936	BRKT,MINT,STEP BOX	57	3	SSHC01024	1/4-20 X 3/8 HHCS
18	1	1335M-05	SUPPORT,TABLE,1335M	58	3	SSHC01048	1/4-20 X 3/4 HEX CAP
19	4	1335M-114	HINGE BRACKET	59	1	SSHC01160	1/4-20 X 2-1/2 HHCS
20	*	1335M-LAB	LABELS	60	4	SSPP80024	#6-32X3/8 PAN PHILLIPS
21	1	1335MF-PD	DIAGRAM, PNEUMATIC	61	3	SSSC01032	1/4-20X1/2 SOC CAP
22	1	1335MPLC-WD1	WIRING DIA., PLC	62	4	SSSC98032	10-32X1/2, SOC CAP
23	1	1335MPLC-WD2	WIRING DIA., POWER	63	2	SSSCM3X30	SCREW,SOC CAP,M3 X 30MM
24	1	1336002	CONTROL BOX ASSY, PLC	64	1	SSSCM4X40	SCREW,SOC CAP,M4-0.7X40
25	1	1336010	PLC SCREEN ASSY	65	4	SSZH#01096	SCREW,HEX SHEET METAL
26	1	1347683	LOWER TABLE SUPPORT ANG.	66	9	SSZH#10032	SCREW,SHT.METAL HEX 10
27	2	1975-412A	PLATE,NUT,4-40,.95CTC	67	23	SSZH#10064	SCREW,SHT.METAL HEX 10
28	1	4048-GK321FR	TABLE TOP,MAIN,W/SUPPORT	68	12	SSZH#10096	SCREW,SHT.METAL HEX 10, 1
29	1	4059-DC1500	EFGA DC1500/AB220A	69	3	SSZSP3032	SCREW, SHT.METAL 10 ZIP
30	1	4080-4508B	CABLE,STEP MOTOR,4 AMP,7'	70	4	WWF1/4	WASHER, FLAT, 1/4", COM
31	2	AA198RA510	FL CONT,5/32X10-32	71	4	WWF6S	WASHER, FLAT, #6
32	1	AAGNCQ2B16-10D	COMPACT, 16MM BORE, 10MM	72	16	WWFE020	WASHER,FENDER,5/16
33	9	AAF3/16	CLAMP, BLACK PLASTIC, 3/16 DIA	73	13	WWFS1/4	WASHER,FLAT,SAE,1/4
34	2	AAQUY-4-4	Y UNION, 1/4X1/4	74	10	WWFS10	WASHER, FLAT, #10, SAE
35	1	AAQUY-5-4	Y UNION, 5/32X1/4	75	3	WWFS5/16	WASHER,FLAT,SAE,5/16
36	3	AAQUY-5-5	QUICK UNION Y, 5/32	76	9	WWL1/4	WASHER,LOCK, 1/4
37	1	AP-28-800Y1A	BOX,STEPPER,H.S. (X5),2A.,J,D,E	77	4	WWL10	WASHER,LOCK,#10
38	1	EE37F3312	CEE POWER CORD, 9'	78	5	WWL5/16	WASHER,LOCK, 5/16
39	2.8	EEDC2X2	COVER,WIRE DUCT	79	4	WWL6	WASHER,LOCK,#6
40	2.8	EEDF2X2	DUCT,WIRE,2X2, MOD				

1336002 Control Box

AAC Drawing Number 1336002 Rev 4

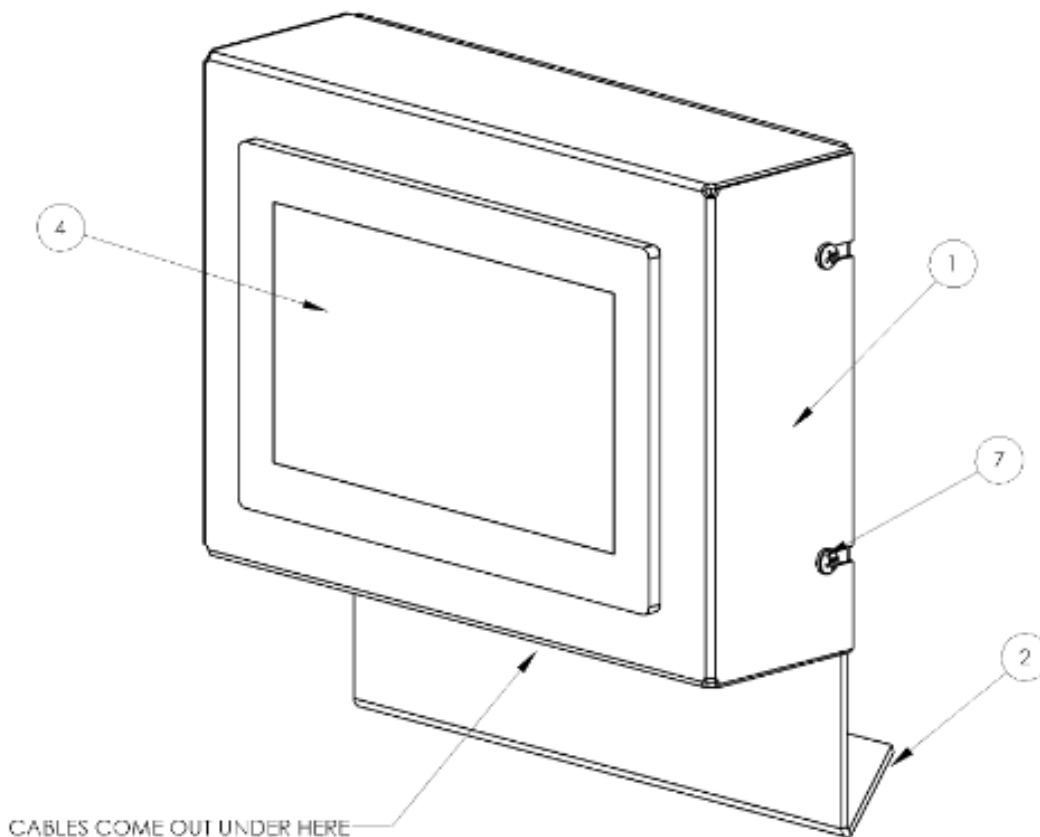


1336002 parts list

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	0211-705C	CABLE,TREADLE,6 FT	16	1	EEDR6024	POWER SUP ,SWITCHER,24V
2	1	0211-705D	CABLE,TREADLE,12 FT	17	2 AR	EEPIR6W1P24	RELAY,INTERFACE,24VDC
3	3	0411-1906B	CABLE,THREAD BREAK, 3 FT	18	15	EESB-375-3	HEYCO BUSHING 3/16" ID
4	2	1335-022	CABLE,3PIN FM MOLEX,7'L	19	10	EETS35X7.5A	DIN RAIL-AMERICAN
5	1	1335MPLC-WD1	WIRING DIA., PLC	20	1	FF10ESB1C	CONNECTOR,POWER ENTRY
6	1	1335MPLC-WD2	WIRING DIA., POWER	21	2	FF36F1089W	CABLE, 12 COND, 20GA
7	1	1336005	CONTROL BOX, PLC	22	1	FF264-3BKT6	MOUNT, WAGO, 11 DBLS
8	1	1336006	COVER, CNTL BOX, LEXAN	23	6	FF264-341	TERMBLK,WAGO,TOP,DUAL,G RY
9	1	1336007	WAGO TERMINAL ASSEMBLY	24	2	FF264-347	TERMBLK,WAGO,TOP,DUAL,G RN
10	1	AAAFPXHC30RD	CONTROLLER, PLC, 30 I/O	25	1	FF264-371	TERMBLK,WAGO,TOP,END
11	1	AAE1335-5	V ALVE BANK ASSY. 5 @ 5/32	26	1	FF270-1278	FUSE, 5A, FAST
12	1	AAFPXIN4T3	CASSETTE, PLC, 4IN, 3OUT, NPN	27	1	FF342838A	FUSE HOLDER, PANEL MOUNT
13	1	AP-28-610U	CABLE,JOG/DIR/ENBL	28	1	FFD2425F	RELAY,SSR,24VAC,25A
14	1	AP-28-612RB	CABLE, SYNC, FL, N/D, MR	29	1	MM40450010	FASTENER,SLIDE LOCK
15	3	EECLIPFIX	ANCHOR,DIN RAIL				

1336010 PLC Touch Screen

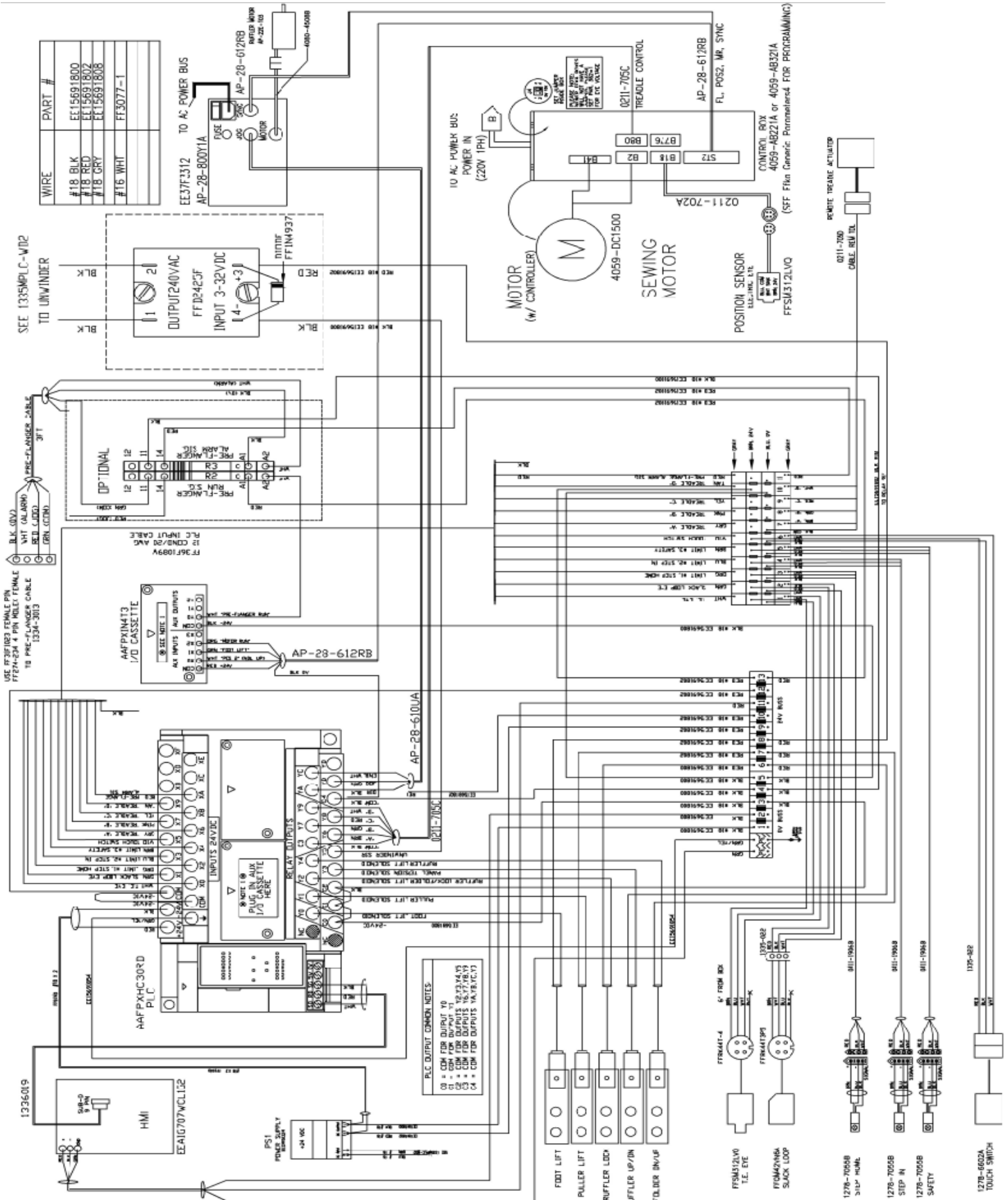
AAC Drawing Number 1336010 Rev 1



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1336008	PLC SCREEN PANEL
2	1	1336009	PLC SCREEN BACK/MOUNT
3	1	1336019	CABLE, PANA, PLC-HMI
4	1	EEAIG707WCL1G2	TOUCHSCREEN, 7.0" COLOR, RS232C
5	10 FT	FF36F1086W	CABLE, 4 CON, 20GA (R, BLK, G, W),
6	1	MM9307K69	GROMMET, 5/8, 1.125, 125GV
7	3	SSPP90024	8-32X3/8 PAN PHLPS

1335MPLC-WD1 Wiring Diagram

AAC Drawing Number 125469D Rev 3





Atlanta Attachment Company (AAC) Statement of Warranty

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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



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