

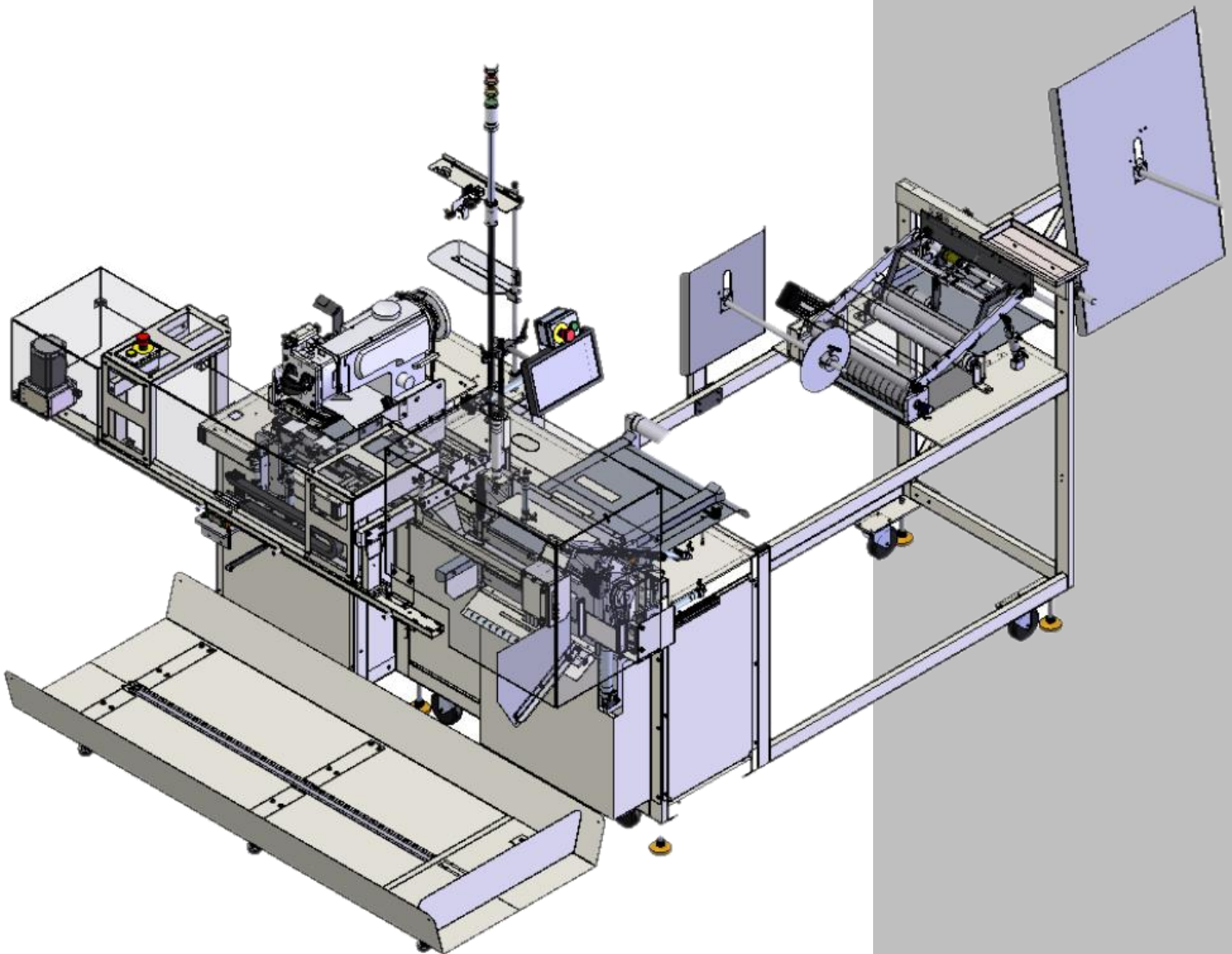


Model **3200PCA-SH**

Model **3200PCA**

Revision 0 Preliminary Copy June 15, 2023 (wr)

Technical Manual & Parts Lists



Atlanta Attachment Company

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ATLANTA ATTACHMENT COMPANY, INC.

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This equipment is manufactured under one or more of the following patents:

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

Foreign Patents: 9-520,472 • 0,537,323 • 92,905,522.6 • 96,936,922.2 • 2,076,379 • 2,084,055

Other U.S. and Foreign Patents Pending.

IMPORTANT





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

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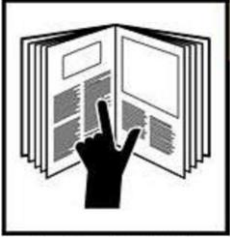
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	<p>General Information Symbol</p>
	<p>Hazard warning sign: General Hazard</p>
	<p>Hazard warning sign: Electrical hazard, electrical hazard</p>
	<p>Hazard warning sign: Beware of damage to hands.</p>

Important Safety Instruction



This part of the Instruction Material is provided for the safe use of your equipment. It contains important information to help work safely with the unit and describes the dangers inherent in machinery. Some of these dangers are obvious, while others are less evident.

Mandatory Information

All persons operating and/or working on the 3200PC Auto border W/ Label INS. should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include.

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

Intended Use

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

Exclusion of Misuse



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

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

Liability

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

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

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

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

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

Choice and Qualification of Personnel

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

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

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines



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

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

If safety equipment must be dismantled for setting-up, maintenance or repair work, such safety equipment shall be replaced and checked immediately upon completing the maintenance or repair work.

All protective mechanisms shall be fitted and fully operational whenever the machine is at a standstill or if it has been shut down for a longer period.

Damage

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

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

Faults or Errors

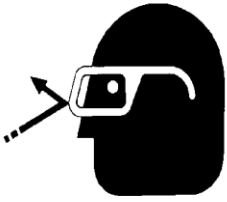
The machine must be switched off and all moving or rotating parts allowed to come to a standstill and secured against accidental restart before starting to remedy any faults or errors.

Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly posted, visible and legible to everyone.

Clothing, Jewelry, Protective Equipment, long loose hair, loose-fitting clothes, gloves and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

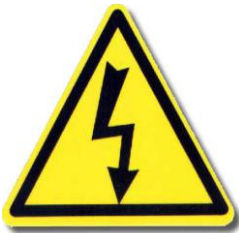
Read the instructions posted in the factory about reporting fires and the emergency exits. Make sure you know exactly where the fire extinguishers and sprinkler systems are located and how they are operated. Pass on the corresponding information to the firemen when they arrive. Ensure there are enough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

The following fire extinguishers may be used:

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

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

Electrical Power Supply



Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.

In practice, this may mean that the technician, electrician, and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.

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

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

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

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

- Kinetic energy - Note that some motors or spindles, for example, may continue to run or coast run on after being switched off.
- Potential energy - Individual assemblies may need to be secured if necessary for repair work.

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.

All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.

Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.

Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.

Protect against unauthorized access.

Ensure that the machine and accessories are set up in a stable position.

Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Local Regulations

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

Maintenance

General Safety Instructions

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

Remove any oil, grease, dirt, and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags. Retighten all screw connections that must be loosened for the maintenance and repair work. Any safety mechanisms that must be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

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

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

Repair

Replacement Parts

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

Repair, Electrical

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

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

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

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

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

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

Ventilation/Hazardous Gases

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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.

General Machine Data

Electrical / Pneumatic Setup

Electrical:	220 VAC, 15amp, 50/60 Hz Single Phase	
Pneumatic:	80 PSI, 5 SCFM avg.	Set the low-pressure switch to 60 PSI.
Sewing Heads:	Juki Lockstitch DNU1541-7	Set RPM: 1800

Installation:

Initial Machine Setup

Position the machine in a desired location on a sound and reasonably level floor.

Make sure that there is sufficient lighting over the machine.

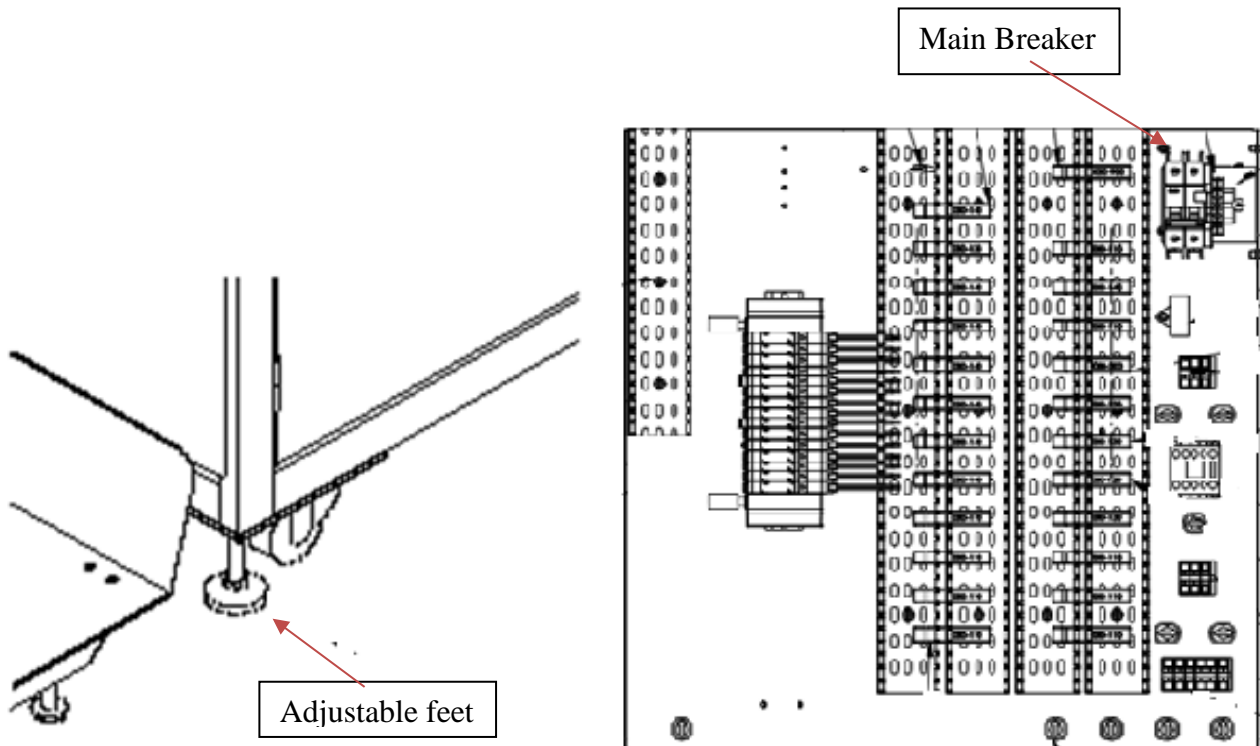
Remove all packing material.

Adjust the jack screws so that the casters are about 1/8" off the floor.

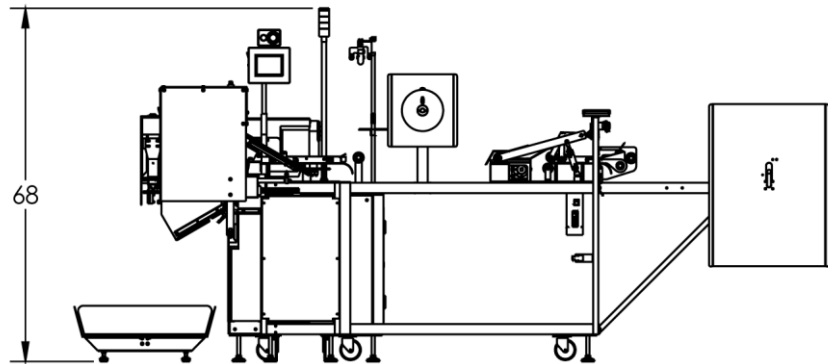
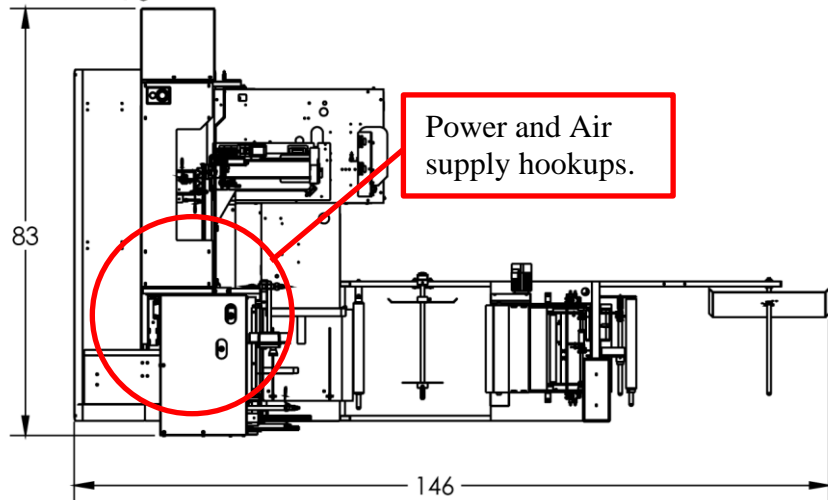
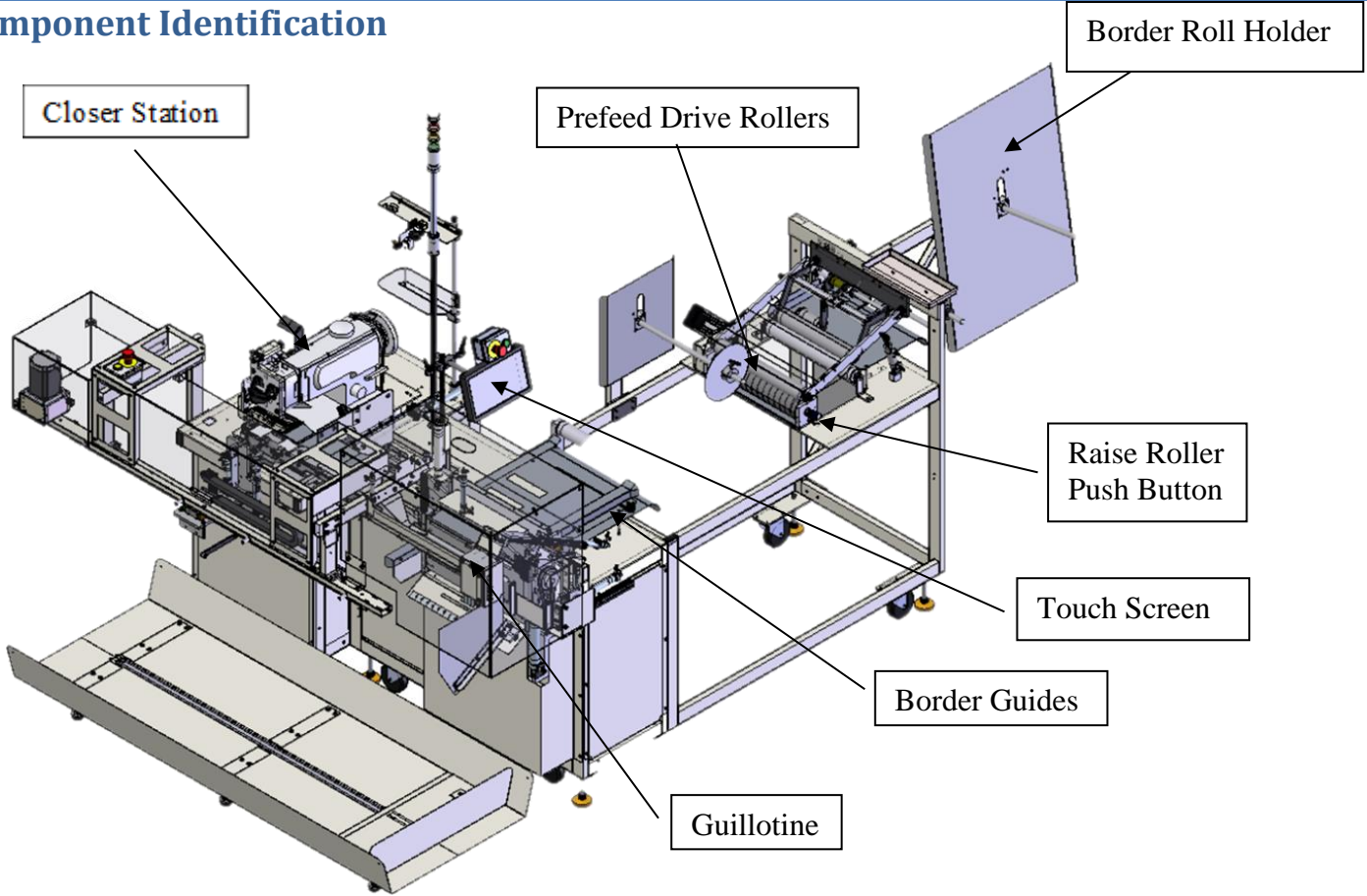
Connect electrical power and compressed air as specified above and in accordance with local codes.

Open the main control box door in front of the machine. Turn on the ON/OFF circuit breaker located in the top right corner by pressing the green button. The green light inside the button should illuminate.

Turn the main air lock-out valve (red knob before the main pressure regulator) to the ON position.



Component Identification



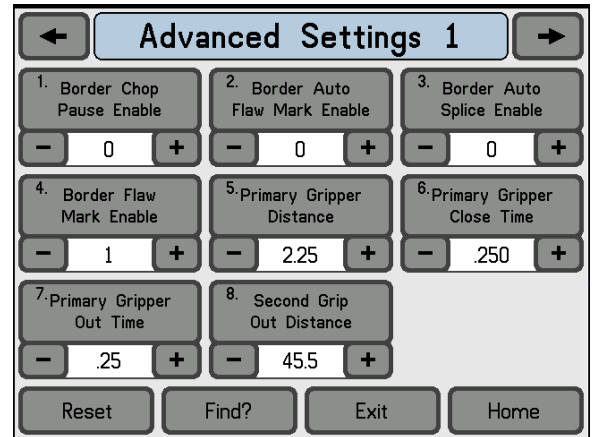
General Operation:

Touch Screen Operation

The graphic images presented on the touch screen show “3-dimensional” buttons, which may be pressed to access other screens, change counters and timers, or actuate hardware. Areas lacking the “3 dimensional” border contain information only.

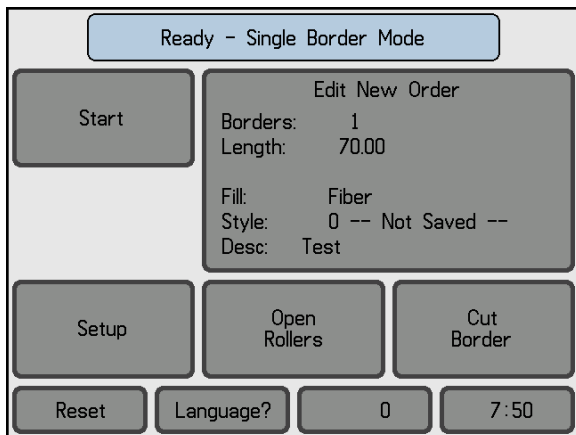
Counters are identified with the “+” and “-” buttons in the corners. These counters may be adjusted by pressing the “+” and “-” boxes. Pressing Reset from any screen clears all machine functions and returns to the main

Note: Security Level must be set to Mechanic or above to access these types of settings screens.



Ready Page. Normal operation of the machine is controlled from the main Ready menu. From here you can start the Auto Cycle. Operators will have only access to normal operational screens and Maintenance Personnel will have access to the setup and adjustment feature of the machines. Raise or lower Security levels as required.

Single Border enabled view of screen

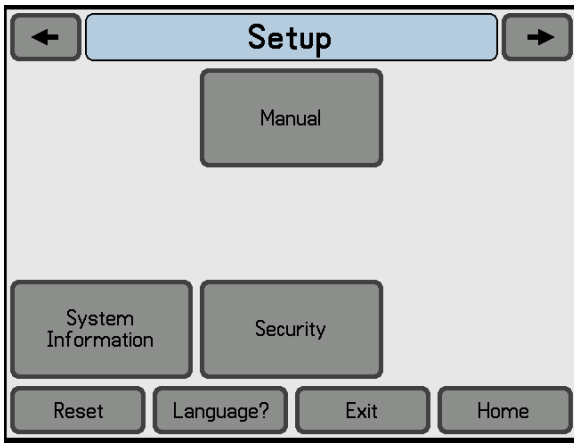


Single Border disabled view of screen.

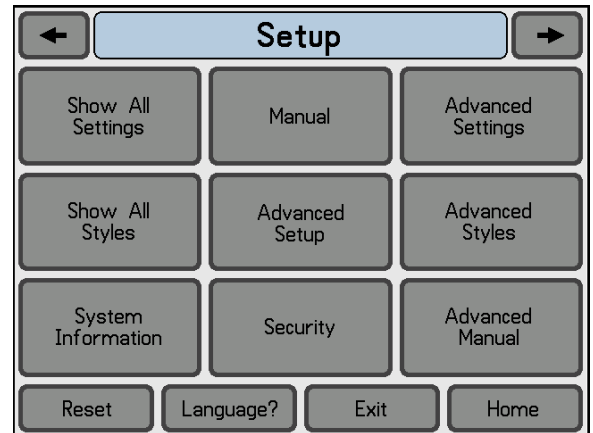


Setup Screen Information

Operator Level view



Mechanic level or higher view.



Show All Settings: Displays all the values for the different settings in a table format.

Show All Styles: Displays all border styles entered in a table format.

System Information: Users can view the machine version and serial number, the software revision and controller serial number, and the total piece count.

Manual: Manually active assemblies and individual pneumatic, hydraulic, or electrical components

Advanced Setup: User can Compensate Border Lengths for accuracy and Cycle test Closer Module

Security: Allows the user to raise or lower their security clearance with a 5-digit security code.

Advanced Settings: Allows access to screens and adjustments that can be made. Pressing the upper portion of button on one of the screens will explain what the adjustment is and allow the adjustment to be made.

Advanced Styles: Allows access to screens for entering all the specifications of a border and label the style for easy access later by the operator.

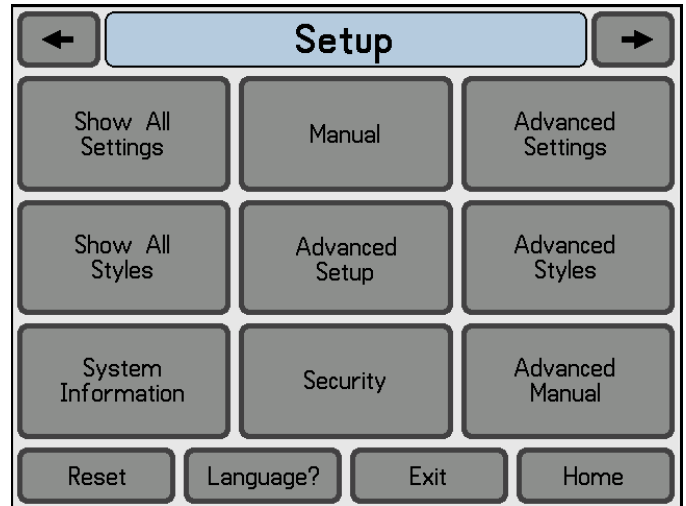
Advanced Manual: Allows access to screens to manually activate different border feed functions of the machine and review I/O signals related to sensors and encoders. It also allows the operator to turn on/off a border marker function if equipped and review the light tower functions.

Border Compensation

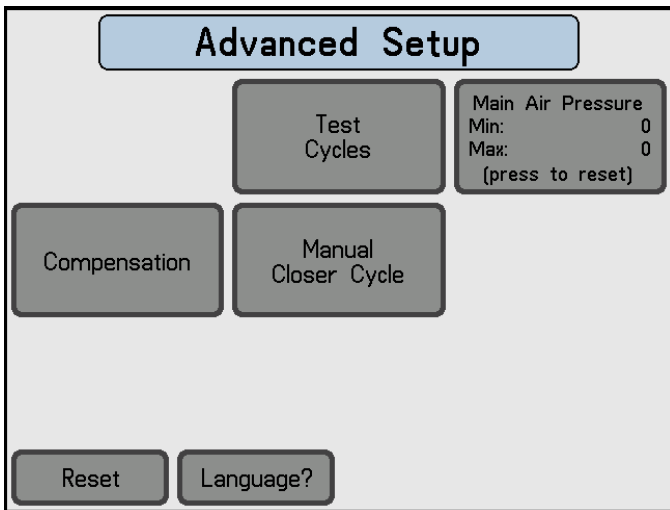
Security Level – Set to Mechanic or above.



Press "SETUP"



Press "ADVANCE SETUP"



Press "COMPENSATION"

Take a border and mark 2 lines 300" apart.

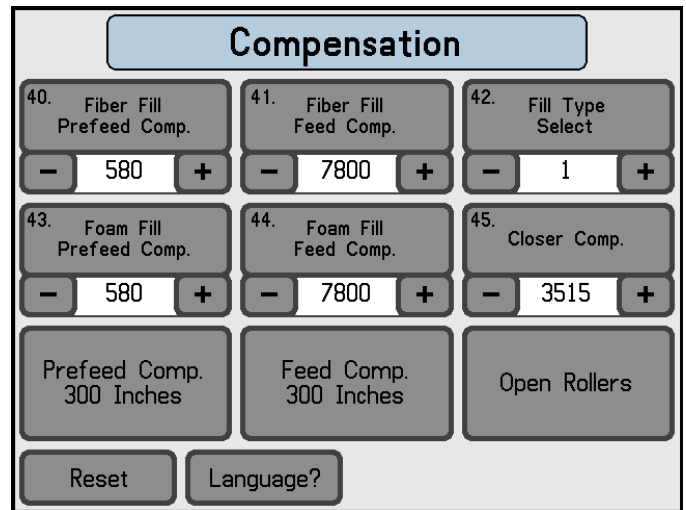
Insert the border and line up the first mark with knife.

Press "FEED COMP. 300 INCHES"

If the second line is not stopping at the knife, change the number for "FEED COMP."

Run 300" test again until it stops at the 2nd mark.

(If "FILL TYPE SELECT" is 1 use "FIBER FILL" if "FILL TYPE SELECT" is 2 use "FOAMFILL")

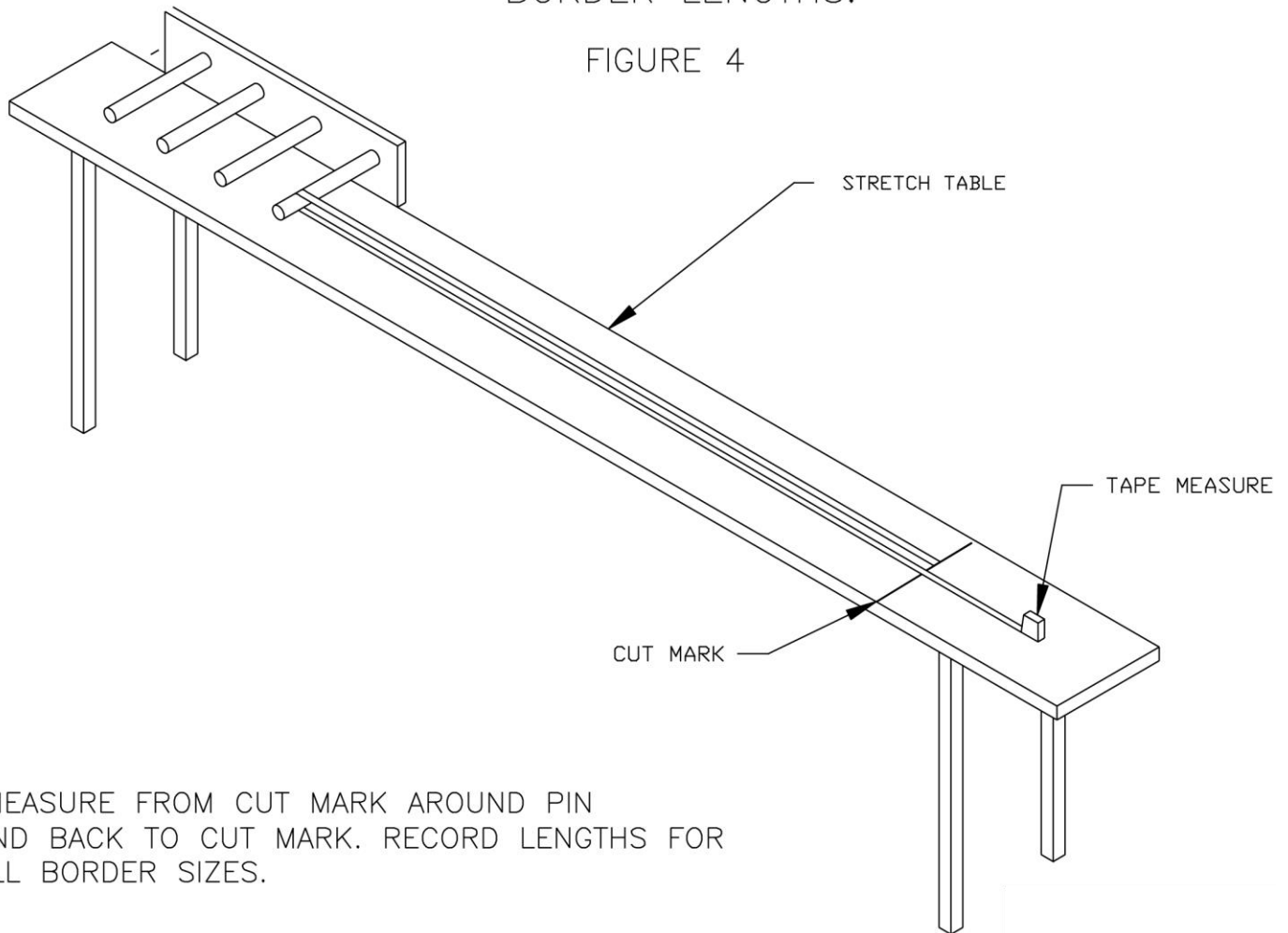


Using Border Stretch Table to Obtain Current Border Lengths

AAC Drawing Number 261446A Rev 0

USING BORDER STRETCH TABLE TO OBTAIN CURRENT
BORDER LENGTHS.

FIGURE 4



MEASURE FROM CUT MARK AROUND PIN
AND BACK TO CUT MARK. RECORD LENGTHS FOR
ALL BORDER SIZES.

Machine Operation, Operator

Turn on the power and select the desired language (if other than English) and wait until the touch screen displays the Ready – New Order screen.

Initial Border Loading Procedure

Press the Open Rollers button, the Prefeed Roller and the Main Roller lift.

Open the Material Guides wider than the expected border width to be loaded.

Load a roll of border material on the Border Roll Holder. If the leading edge of the border is not of good quality, or it is not square, cut off the bad part and square off the leading edge. This will make the border loading process much easier.

Feed the border between the 2" roller and the 3/4" rod, across the prefeed table, and between the prefeed drive rollers. Then feed over the upper rollers, through the guillotine and stop with the end of the border protruding slightly beyond the knife blades. Adjust the guides to fit the border size using the adhesive rulers provided. Hold the border in place and press the Close Rollers button. Be sure not to cover the Border Prefeed Slack Eye.

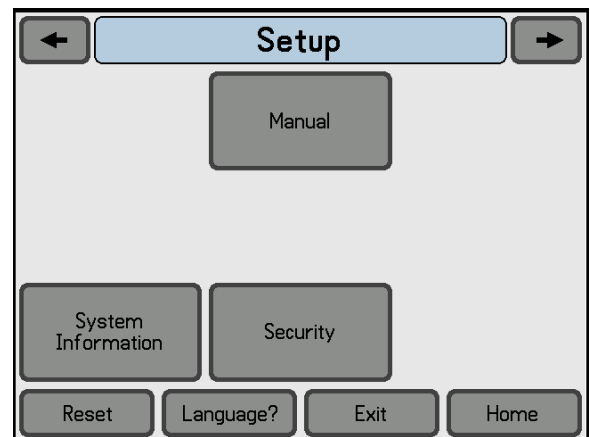
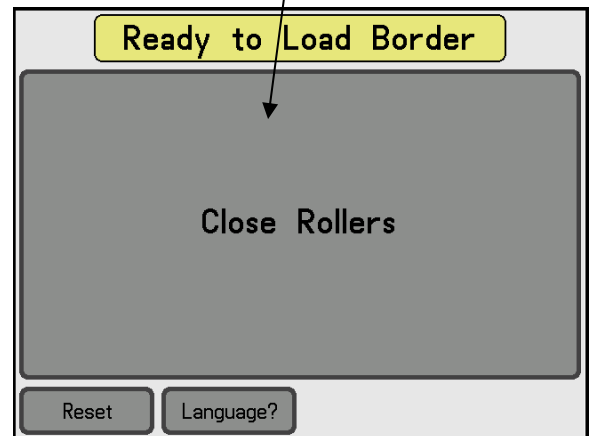
Select Style and quantity of border required from Edit New Order Menu and press Start Button to begin.

Use Cut Border function to cut leading edge of border if required.

Note: If you get a message “Border Slack Warning” on the screen, walk over to prefeed part of the machine and press the Raise Roller push button mounted on the cover of the prefeed roller, pull the slack out, and press the button again to lower the prefeed roller. If the message “Border Slack Warning” comes up again with no slack present, most likely the slack eye is not adjusted properly to see the reflective tape on the side panel of the machine, or the eye is not working properly and needs to be checked.

Use Setup Screen to Access Machine Information and Security

Operator Level Setup Screen
Raise Level in Security



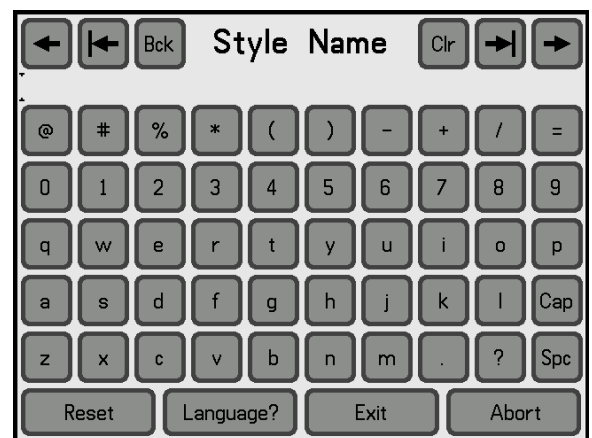
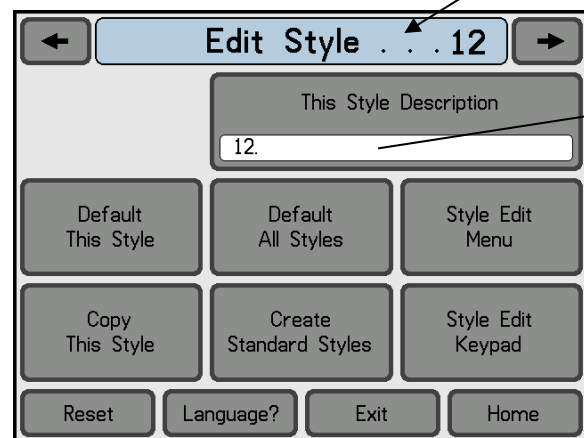
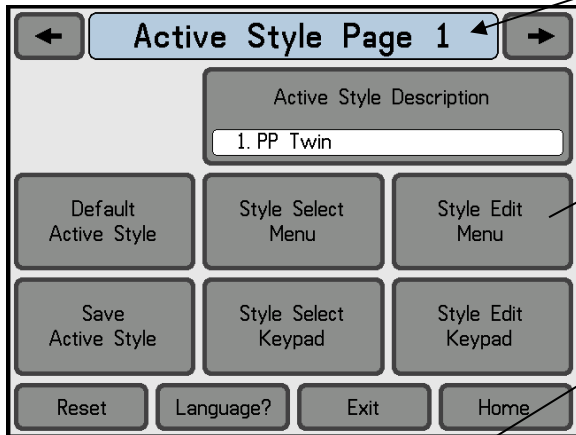
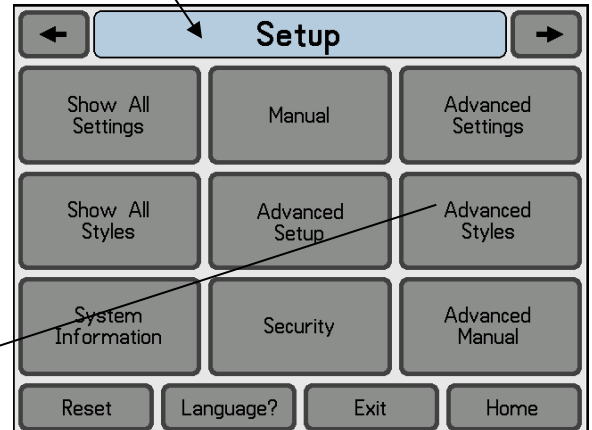
Styles

When installing the Model 3200PCA border machine, it is necessary to first obtain new default border lengths for all mattress sizes. To obtain these lengths determine which border-making table will be used to check the borders coming off the 3200PB1E machine. Using this table, a measurement of every border size needs to be made by wrapping a measuring tape around the arm and measuring to the cut mark for each border size.

Entering New Styles

Security Level – set to Mechanic or above.

After all the default border lengths have been recorded, they must be stored in the controller of the 3200PCA machine. To store the default border lengths into a new style, press Setup button on Ready Screen and then press Advanced Styles button. Following this step, press the Style Edit Menu which takes you to the Edit Styles Menu screen where you will locate and press a blank style number. After entering a description in the white box, press the top right arrow button and enter the numerical style information.



Edit Styles Option 1

Security Level – set to Mechanic or above for access.

There are several ways or paths to access the Edit Styles Menu.

Option 1:

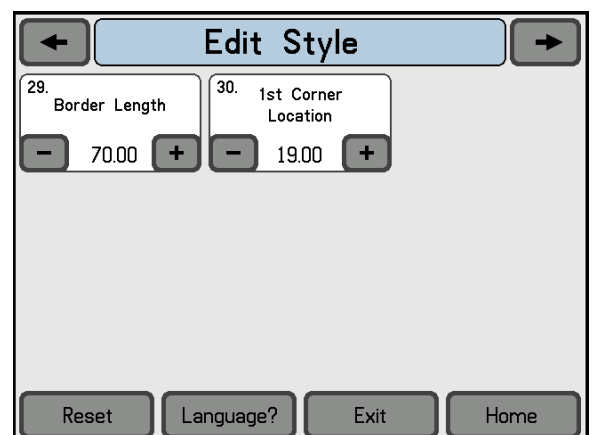
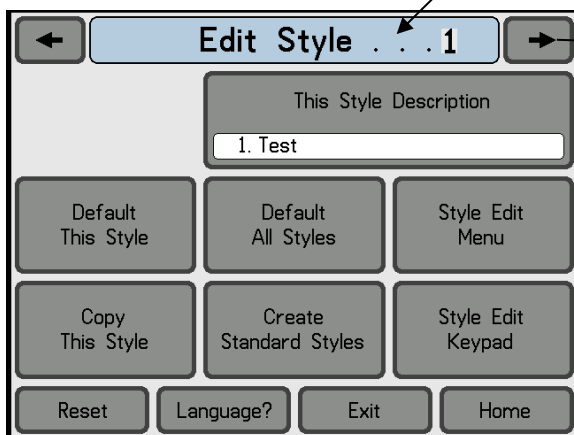
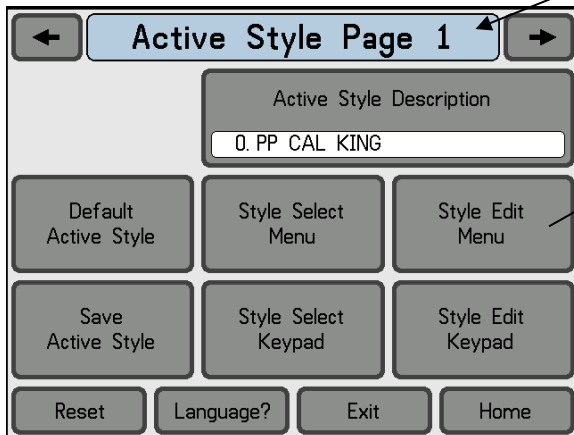
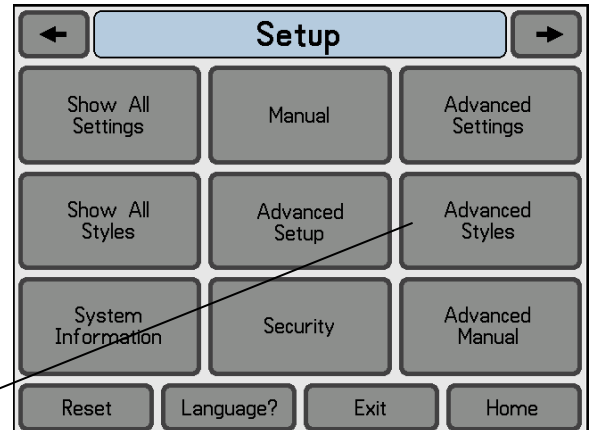
On the Setup page, press Advanced Styles button to access the Active Style Page screens.

On the Active Style, page press the Style Edit Menu button to access the Edit Styles Menu screen and locate the style number to be changed such as #1

After pressing the style number, the Edit Style 1 page will open with the Style shown in the white box at the top.

Press the right top arrow button and enter the changes on the next Page shown as Edit Style.

Press Exit or Home when finished.



Edit Styles Option 2

Security Level –set to Mechanic or above for access.

There are several ways or paths to access the Edit Styles Menu

Option 2:

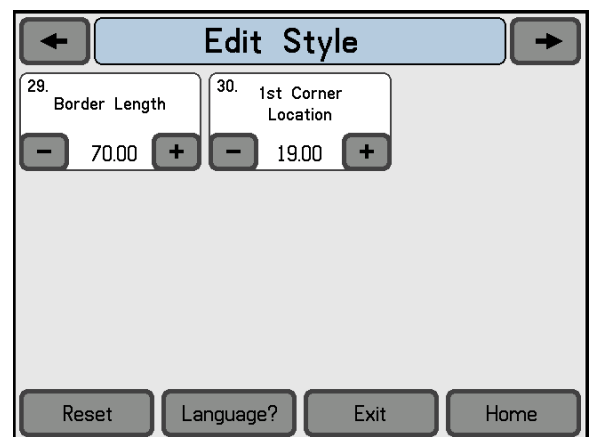
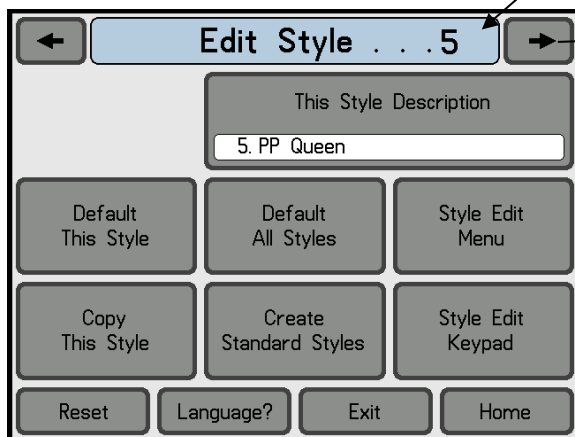
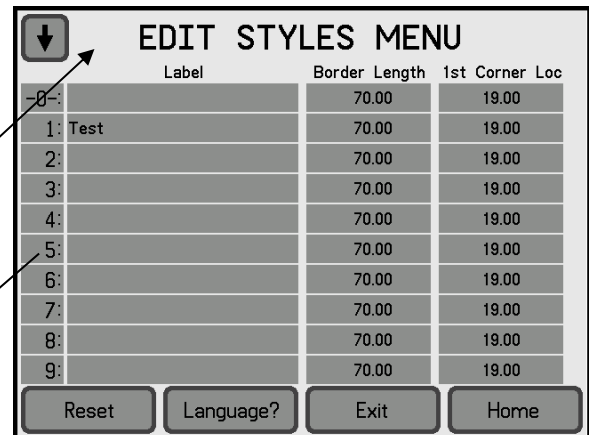
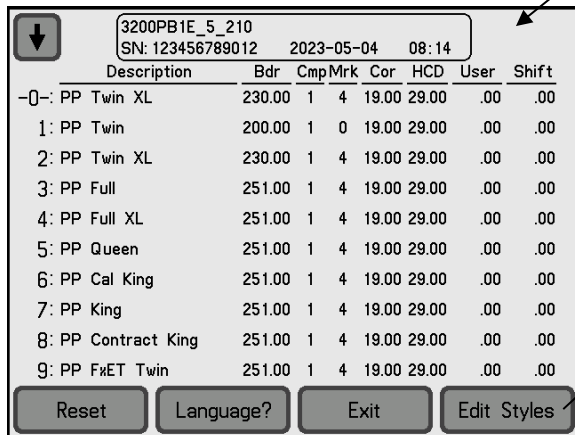
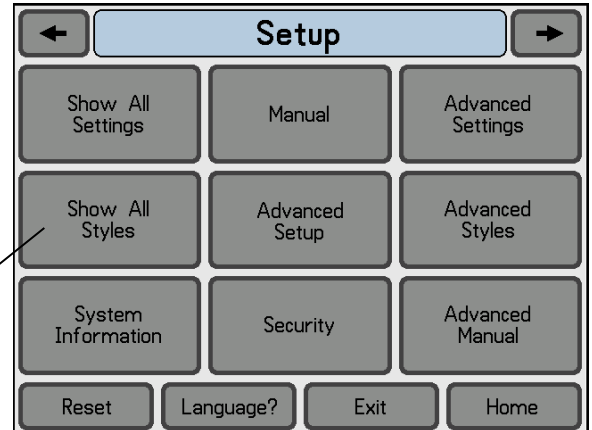
On the Setup Page, press Show All Styles button to access the List of Styles.

At the bottom right of this page press the Edit Styles button to access the Edit Styles Menu screen and locate the number to be changes such as # 5.

After pressing the style number, the Edit Style 5 page will open with the Style shown in the white box at the top.

Press the right top arrow button and enter the changes on the next Page shown as Edit Style.

Press Exit or Home when finished.



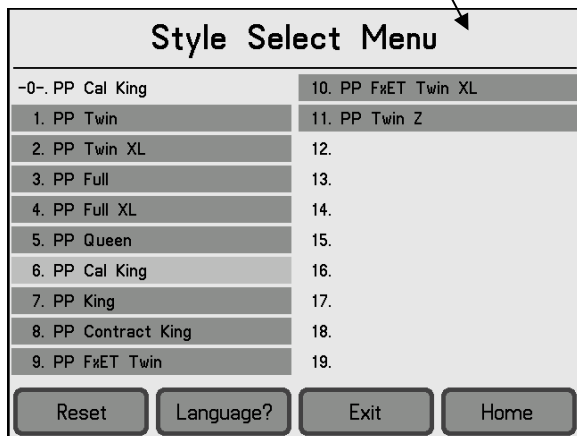
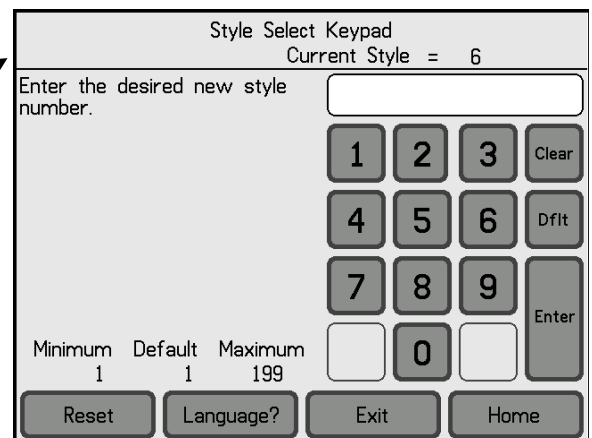
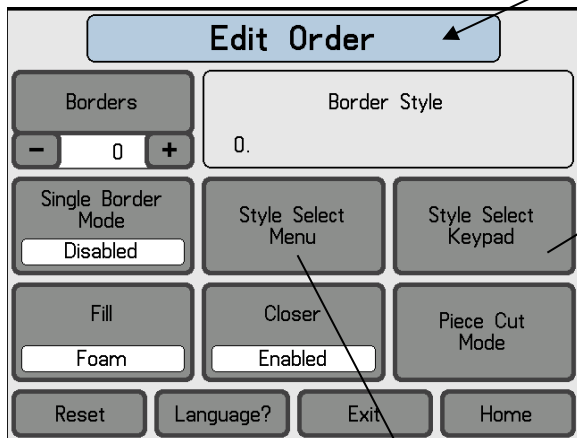
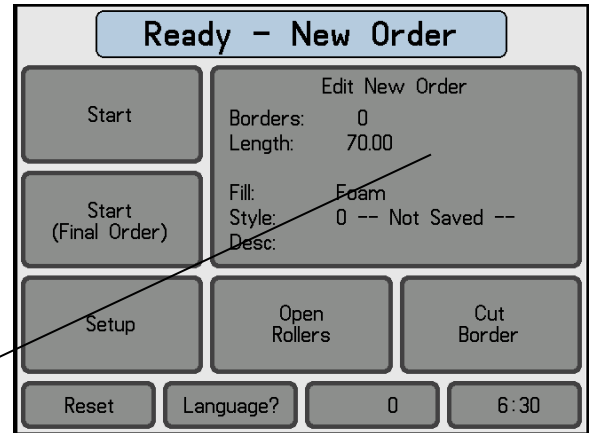
Selecting Styles

Security Level – Operator and all levels above

To setup the machine to make the desired borders go to the main Ready – New Order screen and press the large Edit Order button.

The new screen Edit Order displays all available options: the style and quantity of borders.

Press the Style Select Menu button to select the desired combination from the list or press the Style Select Keypad and enter a number from the list to select the style. When finished, press **Exit** button to get back to the main Ready – New Order screen. You are now ready to make borders.



Border Splicing Method

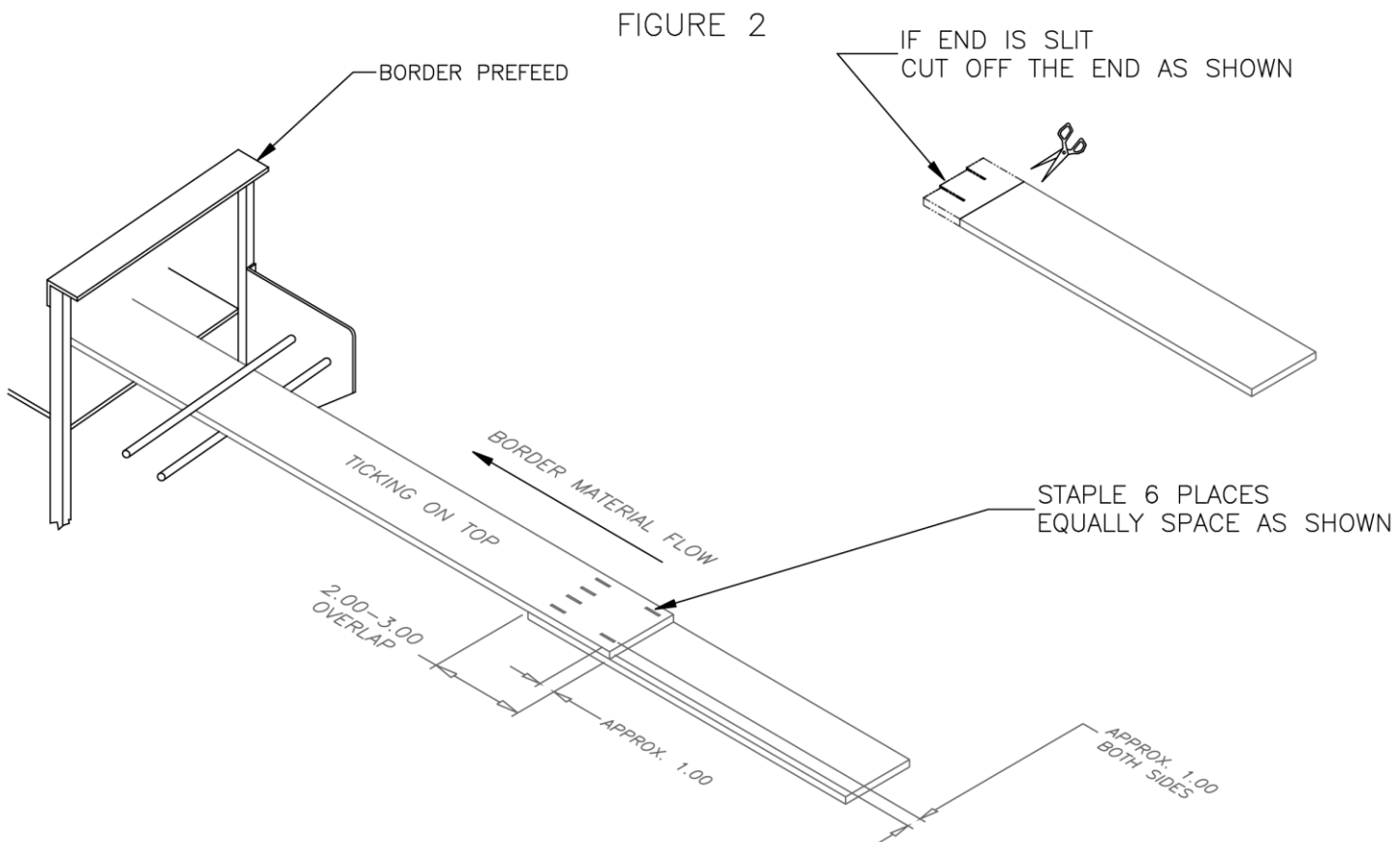
When the machine runs out of border material, it stops and automatically back feeds about 10 inches to make the border splicing easier. The screen displays an “Out of Border Material” message. Load the next border roll on the pin and staple its leading edge to the trailing edge of the border currently in the machine.

Also, to make the operation of the machine more efficient, the border splicing on the Sewing Station must be performed correctly.

Border Splicing Method for 3200 Units

AAC Drawing Number 261444A Rev 0

BORDER SPLICING METHODS FOR MODEL 3300 HANDLE INSERTING MACHINE



Bobbin Handling Method

The machine comes with two bobbin cases to allow the operator to optimize his/her performance. One full bobbin should always be in a case ready to be loaded. Therefore, when the machine pauses its automatic operation and posts a message on the screen that it is time to change the bobbin, the operator must pull the nearly empty bobbin and replace it with the new bobbin already in the case. Then press the New Bobbin button to resume the automatic operation. Once the machine resumes its automatic operation, the operator can prepare the next bobbin and load it in the empty case.

This bobbin changing method results in optimum performance and minimal machine downtime. Always change the bobbin when the machine displays the “Bobbin Warning” message. If there is consistently too much thread left on the old bobbin, or the bobbin runs out of thread at times, change the bobbin counter to optimize bobbin usage. To adjust the bobbin counter/monitor go to the main screen, press the Setup button, and press the Bobbin Monitor button and adjust the Time Per Bobbin count using + or – buttons.

Light Tower Function

The purpose of the 3200PCA light tower is to indicate the operational status of the machine at some distance away from the machine. This makes it easy to see machine status at a glance. Definitions for the different light states currently available on the 3200 are included below.

Light Status	Definition
Green Steady	Normal, machine producing borders
Green Flashing	Machine producing borders but will stop soon for bobbin change.
Yellow Steady	Normal, machine powered but idling between borders.
Yellow Flashing	Machine stopped in middle of order and needs operator activity before continuing.
Red	Not currently utilized. Available for future use.

Factory Pre-set Machine Adjustments

The following adjustments will have already been made before the unit is shipped from the factory.
 Adjust the spring screw on the guillotine to make sure the blade cuts the material.
 Adjust the roller down cylinder so that the rollers touch with little or no pressure.
 Adjust the cylinders on the prefeed rollers the same.
 Adjust the counterbalance springs on the prefeed seam detector rollers to counterbalance 70% of the weight.
 Step motor speed

Prefeed		Feed	
Slow	135 RPM	Slow	28 RPM
Fast	163 RPM	Fast	151 RPM

Operational Path of Screens

Security Level – set to Mechanic or above for access

Ready Screens



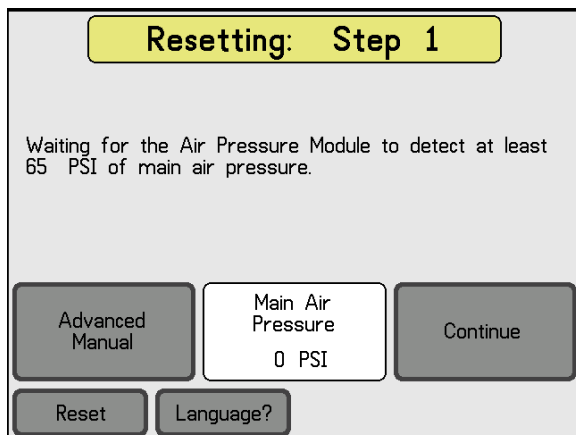
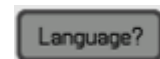
Start to Making Borders Screen



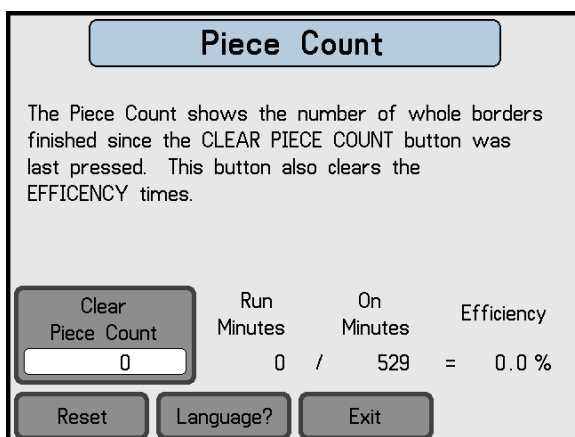
Reset Screen



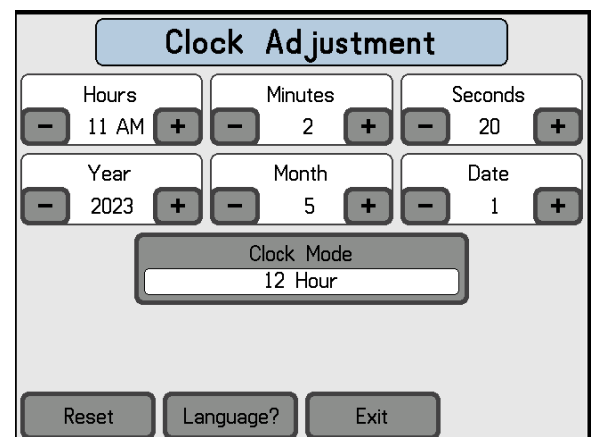
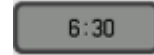
Language Screen



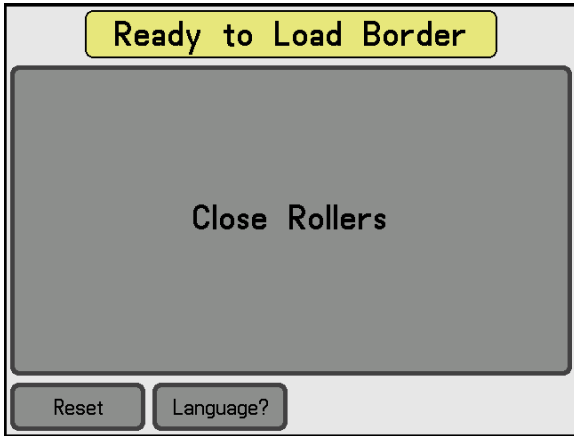
Piece Count



Clock Screen



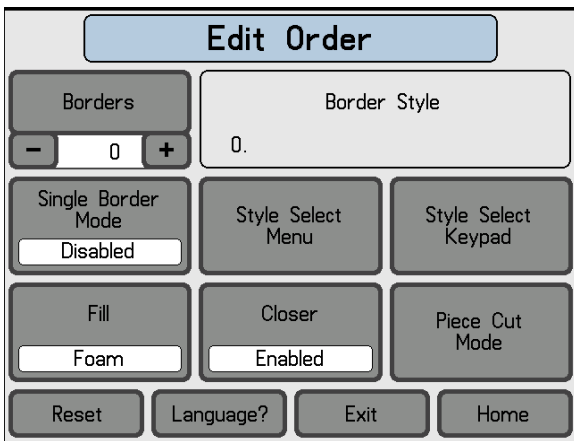
Ready Screen to Open / Close Rollers



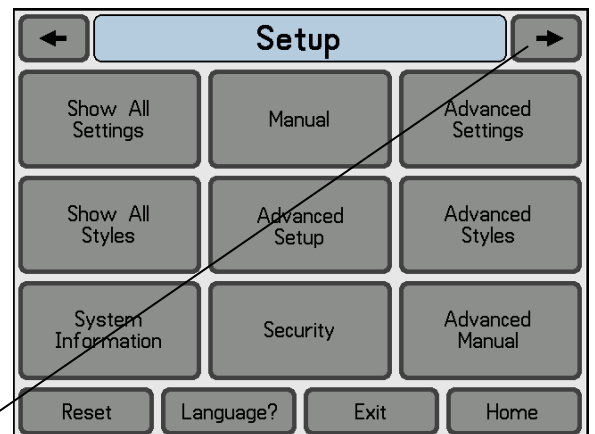
Ready Screen to Cut Border Screen



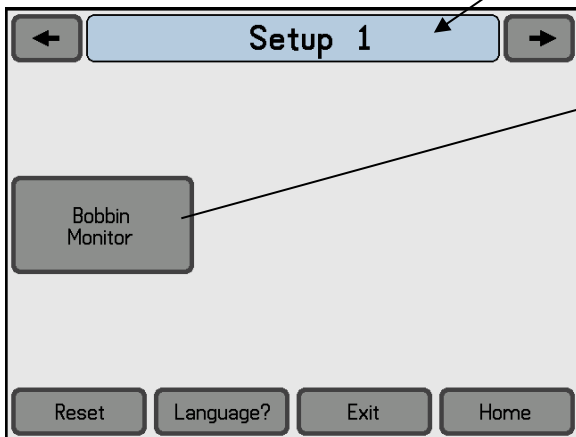
Ready Screen – Edit New Order Button



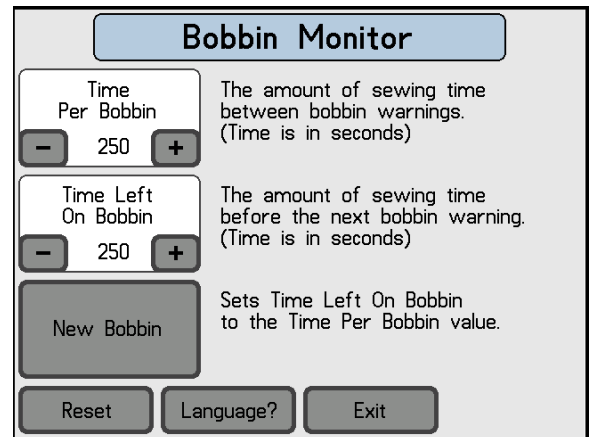
Ready Screen to Setup



Setup Page 1



Setup Page 1 to Bobbin Monitor



Edit Order Menus

Edit Order			
Borders		Border Style	
-	0	+	0.
Single Border Mode	Style Select Menu	Style Select Keypad	
Disabled			
Fill	Closer	Piece Cut Mode	
Foam	Enabled		
Reset	Language?	Exit	Home

Single Border Disabled

Single Border Mode
Disabled

Enter Quantity Required.

Single Border Enabled

Single Border Mode
Enabled

Enter Quantity Required

33.	Borders Ordered = 1			
Enter the number of borders for this order.	<input type="text"/>			
	1	2	3	Clear
	4	5	6	Drft
	7	8	9	Enter
Minimum		0		
Default		0		
Maximum		999		
Reset	Language?	Exit	Home	

Edit Order 1			
Borders		Border Style	
1		1. Test	
Single Border Mode	Style Select Menu	Style Select Keypad	
Enabled			
Fill	Closer	Piece Cut Mode	
Foam	Disabled		
Reset	Language?	Exit	Home

Border Fill Type Settings

Foam

Fiber

Fill
Foam

Fill
Fiber

Closer Head Activation

Enabled

Disabled

Closer
Enabled

Closer
Disabled

Edit Order Screen to Style Select Menu

Style Select Menu

-0-	10.
1. Test	11.
2.	12.
3.	13.
4.	14.
5.	15.
6.	16.
7.	17.
8.	18.
9.	19.

Reset Language? Exit Home

Edit Order Screen to Style Select Keypad

Style Select Keypad
Current Style = 6

Enter the desired new style number.

1 2 3 Clear
4 5 6 Dflt
7 8 9 Enter
0

Minimum Default Maximum
1 1 199

Reset Language? Exit Home

Edit Order Screen to Piece Cut Setup

Piece Cut Setup

Piece Quantity	Piece Length
- 0 +	- 70.00 +

Start

Reset Language?

Piece Quantity

- 1 +

Piece Cut to Piece Quantity Setting

33. Borders Ordered = 1

Enter the number of borders for this order.

1 2 3 Clear
4 5 6 Dflt
7 8 9 Enter
0

Minimum Default Maximum
0 0 999

Reset Language? Exit Home

Piece Cut Process - Start Button

Start

Piece Length

- 70.00 +

Piece Cut to Piece Length Setting

31. Piece Cut Length = 70.00

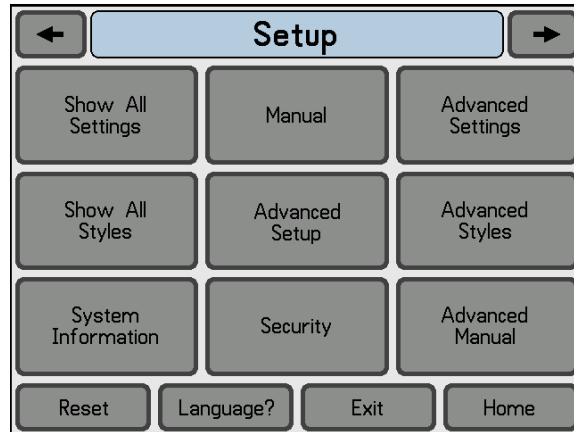
Enter the length of the piece for this order.
Units are inches.

1 2 3 Clear
4 5 6 Dflt
7 8 9 Enter
0 .

Minimum Default Maximum
.50 70.00 500.00

Reset Language? Exit Home

Setup Menus



Setup Screen to Show All Settings

3200PCA_5_110 SN: 123456789012 2023-05-24 06:39										
0	1	2	3	4	5	6	7	8	9	
0	0	0	0	1	2.25	.250	.25	45.5	—	
10	1	1.20	1	.100	.05	.35	6.20	.5	.50	0
20	.15	—	250	0	0	—	—	—	65	70.00
30	19.00	70.00	0	0	—	—	—	—	—	—
40	580	7800	1	580	7800	3515	0	1.5	—	—
50	—	—	—	—	0	1.24	29.00	13.75	—	—
60	—	—	—	—	0	.50	6.0	—	—	—
70	—	—	—	0	—	—	23.50	9.45	—	—
80	—	—	0	0	0	1.00	—	—	—	—
90	—	450	—	—	—	—	—	—	—	0

Buttons: Reset, Find?, Exit, Edit Sets



Edit Sets

EDIT SETTINGS										
0	1	2	3	4	5	6	7	8	9	
0	0	0	0	1	2.25	.250	.25	45.5	—	
10	1	1.20	1	.100	.05	.35	6.20	.5	.50	0
20	.15	—	250	1	0	—	—	—	0	70.00
30	19.00	70.00	0	1	—	—	—	—	—	—
40	580	7800	0	580	7800	3515	0	1.5	—	—
50	—	—	—	—	0	1.24	29.00	13.75	—	—
60	—	—	—	—	0	.50	6.0	—	—	—
70	—	—	—	0	—	—	23.50	9.45	—	—
80	—	—	0	0	0	1.00	—	—	—	—
90	—	0	—	—	—	—	—	—	—	1

Buttons: Reset, Find?, Exit, Home

Setup Screen to Show All Styles

3200PCA_5_110 SN: 123456789012 2023-05-24 06:40			
-0-	Label	Border Length	1st Corner Loc
-0-		70.00	19.00
1:	Test	70.00	19.00
2:		70.00	19.00
3:		70.00	19.00
4:		70.00	19.00
5:		70.00	19.00
6:		70.00	19.00
7:		70.00	19.00
8:		70.00	19.00
9:		70.00	19.00

Buttons: Reset, Language?, Exit, Edit Styles



Edit Styles Menu

EDIT STYLES MENU			
-0-	Label	Border Length	1st Corner Loc
-0-		70.00	19.00
1:	Test	70.00	19.00
2:		70.00	19.00
3:		70.00	19.00
4:		70.00	19.00
5:		70.00	19.00
6:		70.00	19.00
7:		70.00	19.00
8:		70.00	19.00
9:		70.00	19.00

Buttons: Reset, Language?, Exit, Home

Setup to System Information

System Information
 2023-05-24 06:42

Machine
 Model: 3200PCA
 Description: Border Workstation with Closer
 Serial Number: 123456789012
 Total Pieces: 0000000000
 Options:

Software
 Name: 3200PCA_5
 Version: 110

Atlanta Attachment Company Service Department (USA)
 Phone: +1 (770) 963-7369 Fax: +1 (770) 963-7641
 Email: techsupport@atlatt.com

Reset
Language?
Exit
Retries

Setup Screen to Manual

Manual

Cortar Borde

Manual Avanzado

Rodillos Alimentadores

Cabezal a posición de Coser en Manual

Carro de la Cerradora a Posición Inicial

Abrir/Cerrar RODILLOS

Cerrado Manual Del Borde

Recomenzar
Lenguaje?

Setup Screen to Advanced Setup

Advanced Setup

Test Cycles

Main Air Pressure
 Min: 0
 Max: 0
 (press to reset)

Compensation

Manual Closer Cycle

Reset
Language?

Advanced Setup to Test Cycles

Cycle Test

Remove foot and needles from both Sewing Heads.
 Remove border material.

This test will do 360 cycle (about 2 hours) and shut down automatically.

Start Cycle

Cycle Count
0

Reset Counter

Reset
Language?

7:21

Advanced Setup to Compensation

Compensation

40. Fiber Fill Prefeed Comp.	41. Fiber Fill Feed Comp.	42. Fill Type Select
- 580 +	- 7800 +	- 1 +
43. Foam Fill Prefeed Comp.	44. Foam Fill Feed Comp.	45. Closer Comp.
- 580 +	- 7800 +	- 3515 +

Prefeed Comp.
300 Inches

Feed Comp.
300 Inches

Open Rollers

Reset
Language?

Manual Air Pressure Settings

Main Air Pressure
 Min: 0
 Max: 0
 (press to reset)

Manual Closer Cycle

Manual Closer Cycle

Setup to Security

Engineer			
To lower your security clearance, enter the 5 digit security code and press ENTER.			
<input type="text"/>			
<input type="button" value="1"/> <input type="button" value="2"/> <input type="button" value="3"/> <input type="button" value="Clear"/>			
<input type="button" value="4"/> <input type="button" value="5"/> <input type="button" value="6"/> <input type="button" value=""/>			
<input type="button" value="7"/> <input type="button" value="8"/> <input type="button" value="9"/> <input type="button" value="Enter"/>			
<input type="button" value="0"/> <input type="button" value=""/> <input type="button" value="Enter"/>			
<input type="button" value="Lower Security Clearance"/>			
<input type="button" value="Security Code"/>			
<input type="text" value="Bypassed"/>			
<input type="button" value="Reset"/> <input type="button" value="Language?"/> <input type="button" value="Exit"/> <input type="button" value="Home"/>			

Raise or Lower Security Level

Lower Security Clearance

Setup to Advanced Settings Page 1

Advanced Settings 1			
1. Border Chop Pause Enable	2. Border Auto Flaw Mark Enable	3. Border Auto Splice Enable	
- 0 +	- 0 +	- 0 +	
4. Border Flaw Mark Enable	5. Primary Gripper Distance	6. Primary Gripper Close Time	
- 1 +	- 2.25 +	- .250 +	
7. Primary Gripper Out Time	8. Second Grip Out Distance		
- 25 +	- 45.5 +		
<input type="button" value="Reset"/> <input type="button" value="Find?"/> <input type="button" value="Exit"/> <input type="button" value="Home"/>			

Advanced Settings Page 2

Advanced Settings 2			
10. Closer Enable	11. Closer Needle Ramp Time	12. Closer Thread Detect Enable	
- 1 +	- 1.20 +	- 1 +	
13. Closer Sew Start Time	14. Closer To Leading Edge Time	15. Closer To Trailing Edge Time	
- .100 +	- .05 +	- .35 +	
16. Unload Distance	17. Unload Time	18. Deflector Down Delay	
- 6.20 +	- .5 +	- .50 +	
<input type="button" value="Reset"/> <input type="button" value="Find?"/> <input type="button" value="Exit"/> <input type="button" value="Home"/>			

Advanced Settings Page 3

Advanced Settings 3			
19. Manual Label Insertion	20. Closer Carriage Sync Delay		
- 0 +	- .15 +		
22. Time Per Bobbin	23. Single Border Mode	24. Metric Units	
- 250 +	- 0 +	- 0 +	
<input type="button" value="Reset"/> <input type="button" value="Find?"/> <input type="button" value="Exit"/> <input type="button" value="Home"/>			

Advanced Settings Page 4

Advanced Settings 4			
28. Main Air Pressure Target	29. Border Length	30. 1st Corner Location	
- 0 +	- 70.00 +	- 19.00 +	
31. Piece Length	32. Borders Done	33. Borders Ordered	
- 70.00 +	- 0 +	- 1 +	
<input type="button" value="Reset"/> <input type="button" value="Find?"/> <input type="button" value="Exit"/> <input type="button" value="Home"/>			

Advanced Settings Page 5

← Advanced Settings 5 →			
40. Fiber Fill Prefeed Comp.	41. Fiber Fill Feed Comp.	42. Fill Type Select	
- 580 +	- 7800 +	- 1 +	
43. Foam Fill Prefeed Comp.	44. Foam Fill Feed Comp.	45. Closer Comp.	
- 580 +	- 7800 +	- 3515 +	
Reset	Find?	Exit	Home

Advanced Settings Page 10

← Advanced Settings 10 →			
82. Serger Option	83. Marker Option	84. Label Option	
- 0 +	- 0 +	- 0 +	
85. Closer Margin			
- 1.00 +			
Reset	Find?	Exit	Home

Setup Continued

← Setup →			
Show All Settings	Manual	Advanced Settings	
Show All Styles	Advanced Setup	Advanced Styles	
System Information	Security	Advanced Manual	
Reset	Language?	Exit	Home

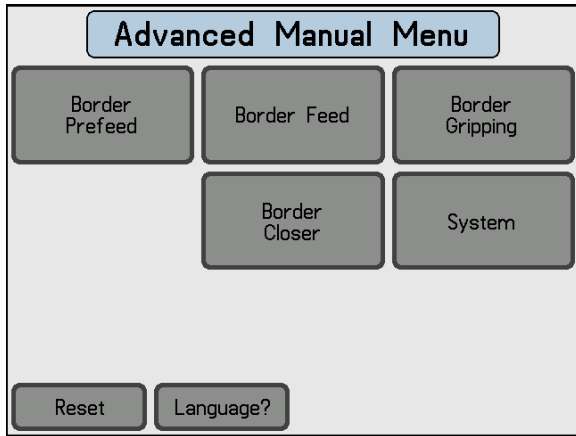
Setup to Advanced / Active Styles Page 1

← Active Style Page 1 →			
Active Style Description			
0.			
Default Active Style	Style Select Menu	Style Edit Menu	
Save Active Style	Style Select Keypad	Style Edit Keypad	
Reset	Language?	Exit	Home

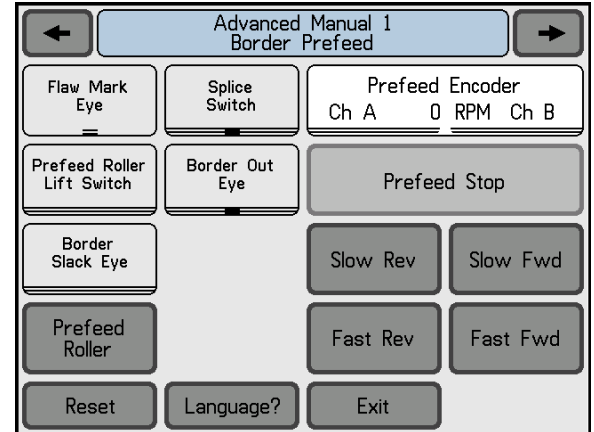
Advanced / Active Style Page 2

← Active Style Page 2 →			
29. Border Length	30. 1st Corner Location		
- 70.00 +	- 19.00 +		
Reset	Language?	Exit	Home

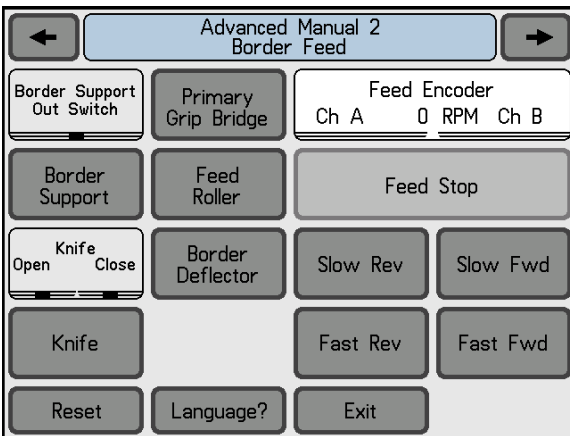
Setup Screen to Advanced Manual Menu



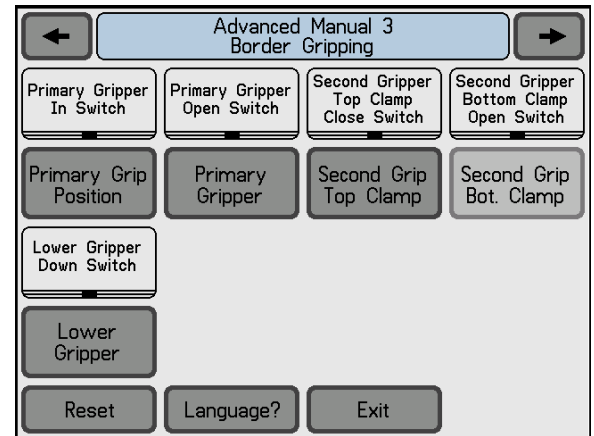
Border Prefeed



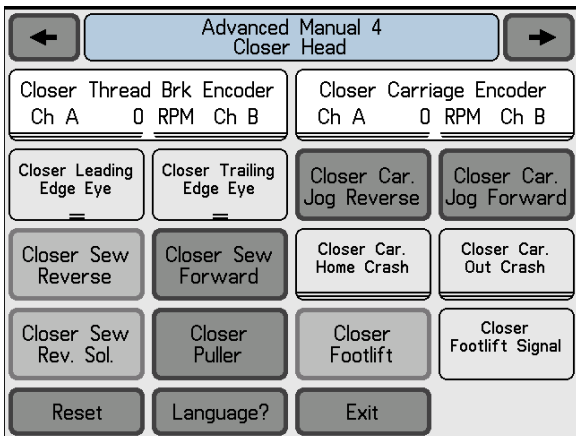
Border Feed



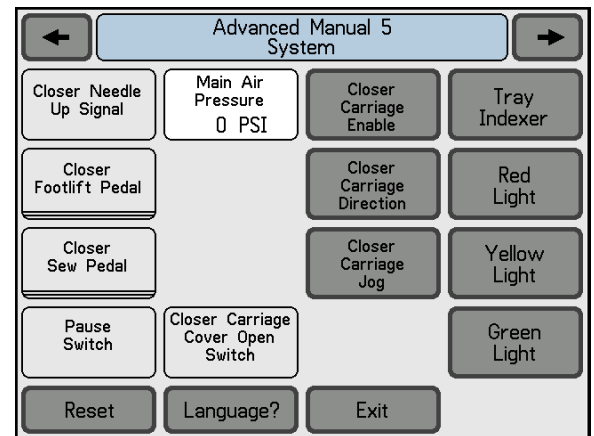
Border Gripping



Closer Head

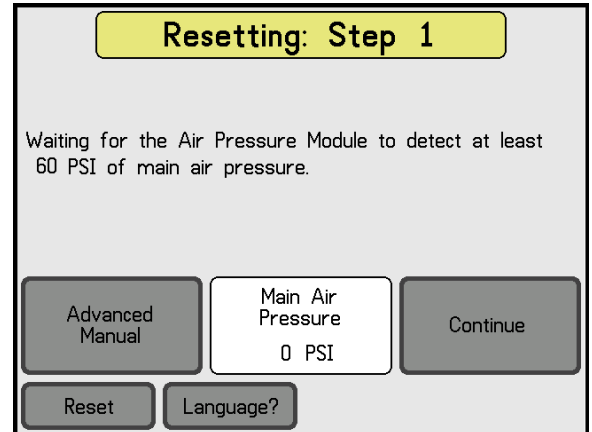


System



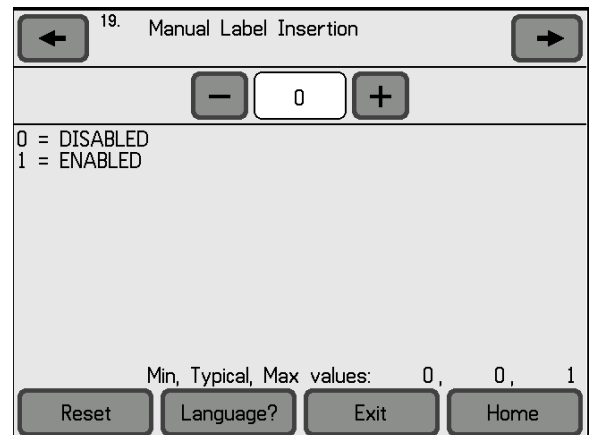
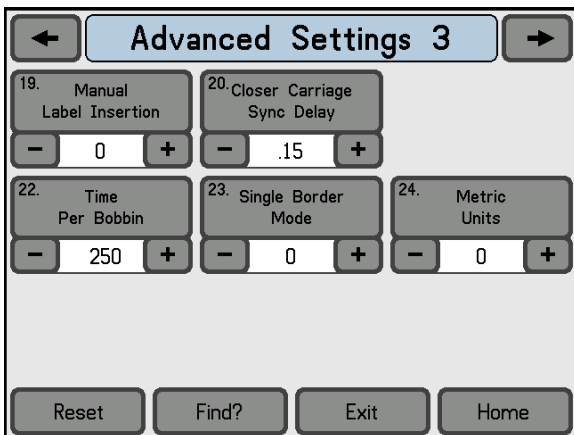
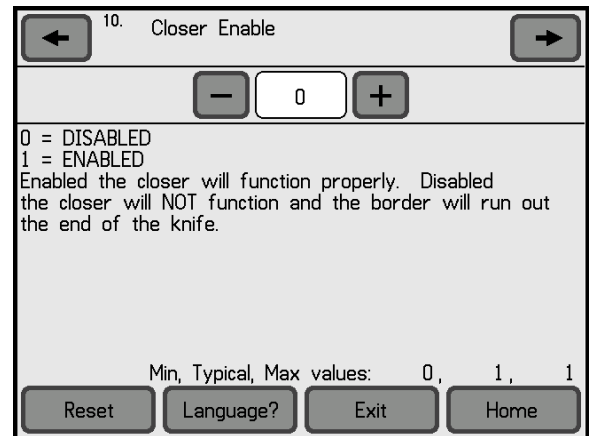
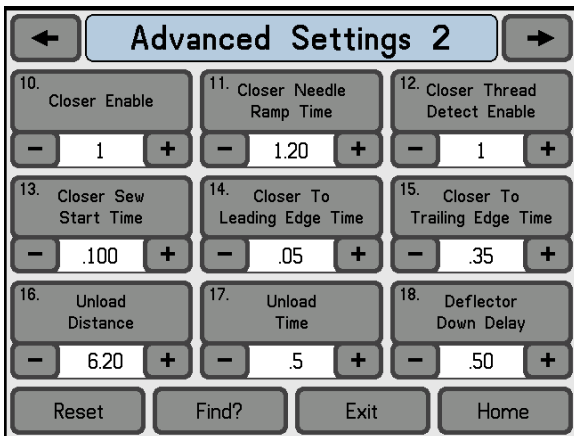
On-Board Diagnostics

Typical Example of Error / Warning Pages



Help Screens.

Accessible by pushing at the top-middle section of a Button. (Examples below)



Service:

Prefeed Motor

Before Programming, Perform a Master Reset of Parameters (See Below)

PARAMETER	RANGE	VALUE	DESCRIPTION
290		0	Mode of operation. MUST SET THIS PARAMETER FIRST!
111	0-999	090	Maximum speed when "129" is 0, 1, or 2.
119	1-3	1	Linear acceleration
153	0-50	0	Braking power at standstill
161	0-1	1-CCW	Motor rotation
207	1-55	1	Braking
220	1-55	1	Acceleration
240	0-56	55	Enable reverse run of motor with input 1
270	0-5	5	No handwheel sensor
272	020-255	100	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.
436		0	Use code "5913". This disables an input that was causing box to reset itself.

Front panel LED's:

- LED 1: Off
- LED 2: Off
- LED 3: Off
- LED 4: Off
- LED 5: Off
- LED 6: Off
- LED 7: Off, Stop at needle down.
- LED 8: Off

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "311"
3. Press "E" once and "2.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E"
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
8. Run sewing head to save parameters before powering down

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 "591"
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.

Speed	RPM	Treadle/Low
Fast	163	C
Slow	135	A, C

Feed Motor

Before Programming, Perform a Master Reset of Parameters (See Below)

PARAMETER	RANGE	VALUE	DESCRIPTION
290		0	Mode of operation. MUST SET THIS PARAMETER FIRST!
110	70-390	70	Positioning speed = 700 rpm
111	0-999	120	Maximum speed = 1200 rpm.
119	1-3	1	Linear acceleration
153	0-50	35	Braking power at standstill
161	0-1	1-CCW	Motor rotation
207	1-55	35	Braking
220	1-55	1	Acceleration
240	0-56	55	Enable reverse run of motor with input 1
270	0-5	5	No handwheel sensor
272	020-255	100	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.
436		0	Use code "5913". This disables an input that was causing box to reset itself.
401	0-1	1	Immediate save all parameters before turning off power

Front panel LED's:

- LED 1: Off
- LED 2: Off
- LED 3: Off
- LED 4: Off
- LED 5: Off
- LED 6: Off
- LED 7: Off, Stop at needle down.
- LED 8: Off

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "311"
3. Press "E" once and "2.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E"
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
8. Run sewing head to save parameters before powering down

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 "591"
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.

Speed	RPM	Treadle/Low
Fast	151	C
Slow	28	B&C

3200PCA Closer Motor Parameter Settings (Juki)

PARAMETER	RANGE (default)	3 DIGIT VALUE	4 DIGIT VALUE	DESCRIPTION
290	0-24 (5)	20	20	Mode of operation. MUST SET THIS PARAMETER FIRST!
026	0-5	0	0	EB301 Treadle Mode (5131F and later pgms only)
100	0-254 (2)	2	2	Number of soft start stitches
110	70-390(200)	200	200	Positioning speed
111	200-9900 rpm	180	1800	Maximum speed (1800 rpm)
115	70-1500 (500)	500	500	Soft start speed (500 rpm)
116	70-500(200)	180	180	Trimming speed
117	400-9900 (1000)	180	1800	Speed n10 (1800 rpm)
122	400-9900 (1000)	180	1800	Speed n9 (1800 rpm)
123	400-9900 (2000)	180	1800	Speed n11 (1800 rpm)
134	0-1 (1)	1	1	Soft start On/Off (0 = off, 1 = on)
135	0-1 (1)	0	0	Ornamental backtack On/Off (0 = off, 1 = on)
153	0-50 (4)	25	25	Braking power at standstill
161	0-1 (1)	1=CCW	1=CCW	Motor rotation
180	0-360 (70)	60	60	Reverse run angle after trim. Adjust parameter until needle stops at Top Dead Center.
181	0-999 (10)	50	50	Delay till reverse run starts after trim
182	0-1 (1)	1	1	Reverse run after trim for needle up On/Off (0 = off, 1 = on)
197	0-720 (50)	0	0	Stop angle after needle up for trimming (Default)
202	0-500 (50)	500	500	Start sew delay after footlift turns off
204	1-100% (40)	100	100	Footlift solenoid holding power (100% max)
213	1-100% (40)	100	100	Backtack solenoid holding power (100% max)
219	0-55 (10)	35	35	Braking power at stop of drive
224	0-1 (1)	0	0	Speed Gate 2 On/Off (0 = off, 1 = on)
240	0-66 (14)	16	16	Backtack input for In1 (reverse sewing)
242	0-66 (31)	31	31	Speed limitation "0" (walking foot stepping height knob)
243	0-66 (32)	32	32	Speed limitation "1" (walking foot stepping height knob)
250	0-359 (180)	180	180	Thread trimmer activation angle
251	0-990 (50)	50	50	Switch-Off delay of thread tension release
252	0-359 (0)	0	0	Switch-On delay angle of thread tension release
253	0-500	70	70	Stop tim for trimmer.
254	1-100% (100)	100	100	Upper limit for parameter 204
255	1-100% (100)	100	100	Upper limit for parameter 213
270	0-5 (0)	1	1	External handwheel sensor configuration.
271	0-255	105	105	Needle down/trim position
272	015-255 (100)	100	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. (For Yamato and Pegasus, setting should be 100; for Rimoldi, setting should be 124)
436		0	0	This disables an input that was causing box to reset itself.
401	0-1	1	1	Immediate save all parameters before turning off power

NOTE: SET PARAMETER 182 = 0. THEN, ADJUST TAPE DISC ON HANDWHEEL SO THE SEWING HEAD STOPS IN SEAM WITH THE DOT ON THE CASTING BETWEEN THE TWO WHITE DOTS ON THE HANDWHEEL (NORMEL NEEDLE-UP POSITION, EYE ON TAPE). NOW, SET 182 = 1.

Front panel LED's:

- LED 1: Off
- LED 2: Off
- LED 3: Off
- LED 4: Off
- LED 5: Off
- LED 6: Off
- LED 7: Off
- LED 8: On, Stop at needle up.

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "591" or "5913"
3. Press "E" once and "4.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E".
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
- 8. Run sewing head to save parameters before powering down**

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 "591" or "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.

To read program info go to Par 179, press "E", display shows Sr5=, press >>, display shows program # (example 5131), press "E", display shows version # (example "E"), continue to press "E" to see date codes and/or go back to beginning, press "P" to exit.

Machine Maintenance

Regularly scheduled maintenance of the 3200PCA unit reduces possible problems and downtime. Proper care will also ensure a longer life and better performance of the machine.

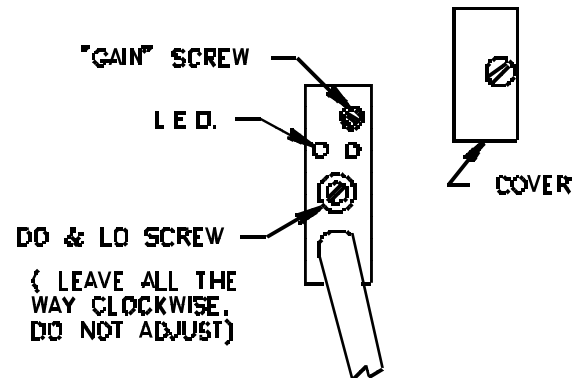
Perform the following procedures to properly maintain the machine.

1. Clean the machine daily at the end of every shift.
 - A. Wipe all photo eye lenses with a clean, nonabrasive, dry cloth.
 - B. Use blow-off hose to get rid of excess lint, thread, and other clippings.
2. Check air filters weekly; replace filter elements once every six months.
3. Lubricate the bearing block on the guillotine knife once every three months using standard sewing head oil. The oiling hole is located on the top face of the bearing block, and it is indicated by a red paint mark.
4. Apply Accrolube™ grease to the recessed cavity on the back side of the top blade side plate of the guillotine knife. This will improve performance and extend the life of the blade.

Electric Eye Sensor Adjustment

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

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



Reflective Tape Maintenance

Use a soft cloth for cleaning.

Do not use chemicals or abrasives to clean it.

Avoid any contact with oils and liquids.

Do not touch the tape with bare fingers.

If tape is dirty or opaque, the eye may not function correctly.

Assembly Drawings & Parts Lists:

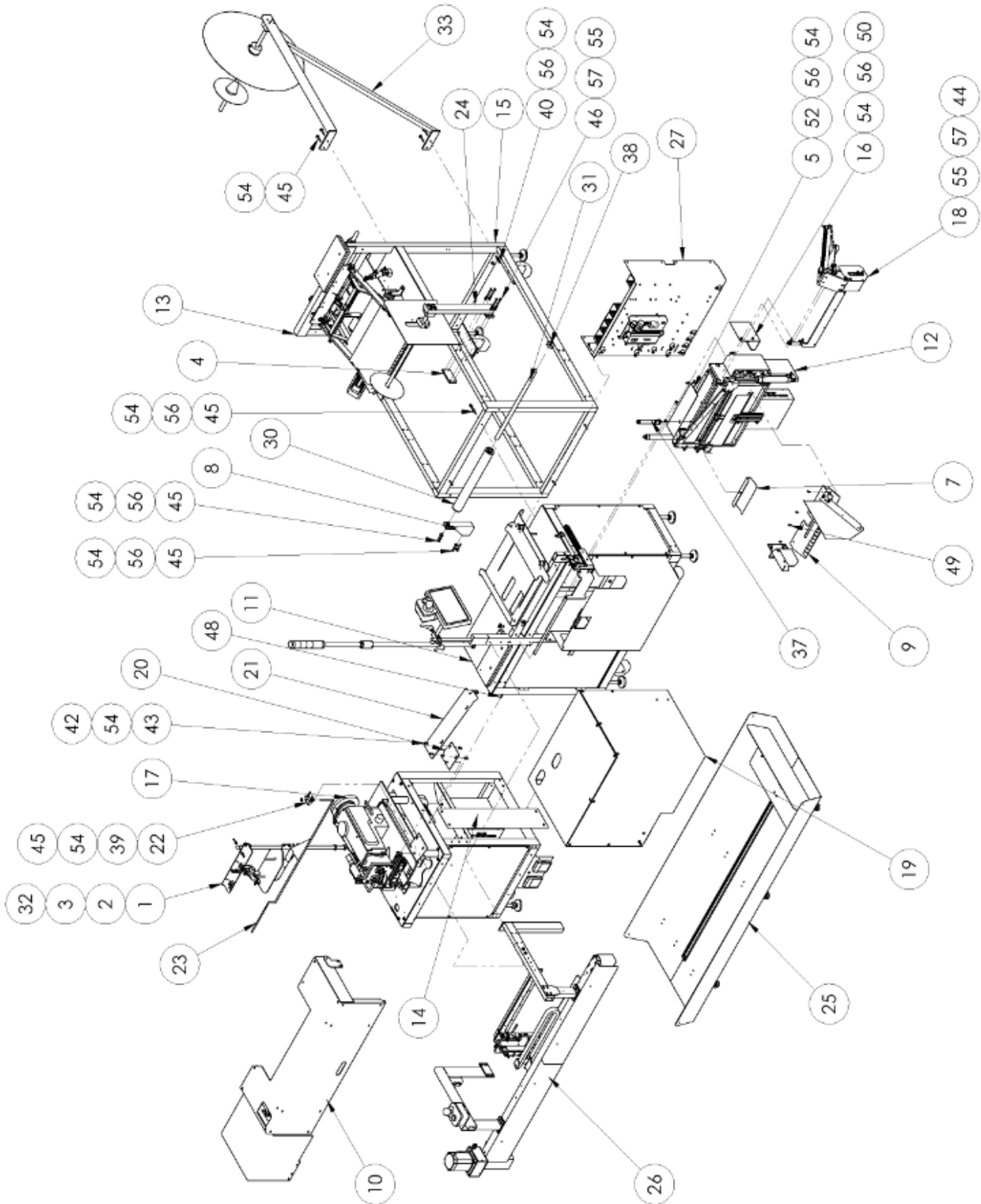
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33200PCA-SH Auto Border...Narrow Frame Model

AAC Drawing Number 90071747 Rev 0

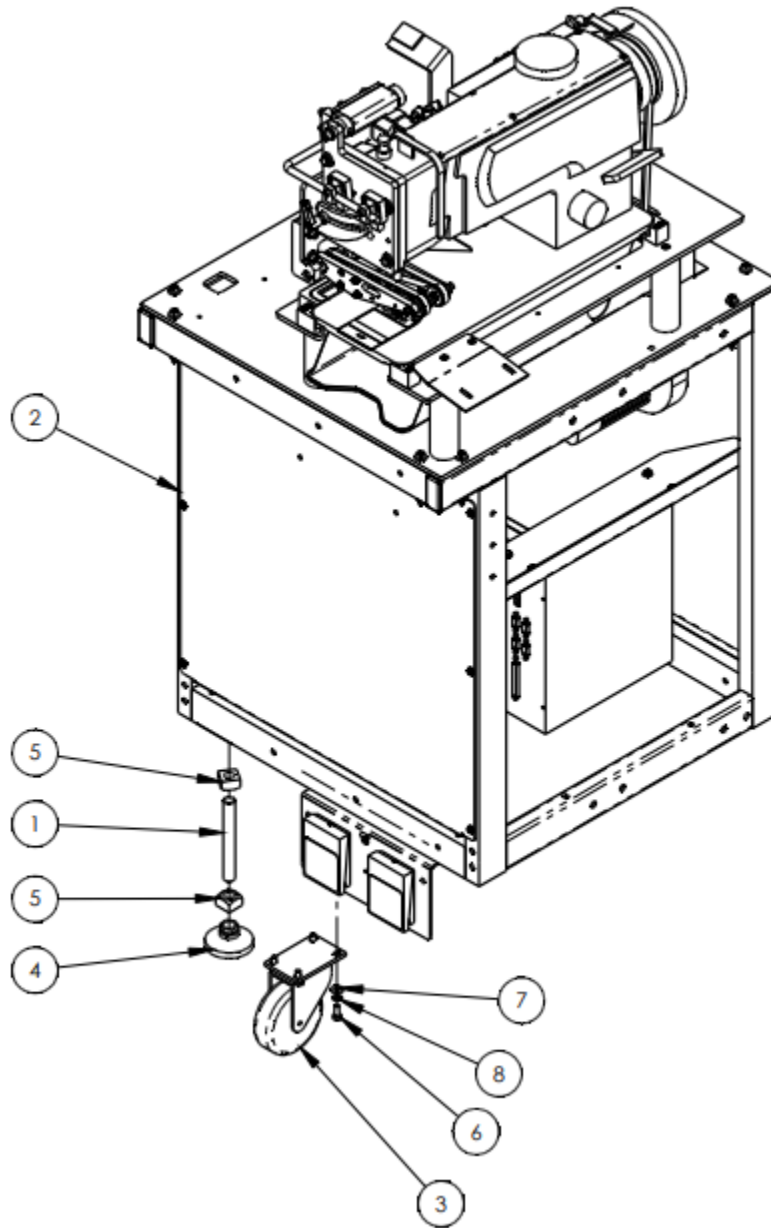


33200PCA-SH parts

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	0411-069D	BRKT, THREAD BRK DETECTIO	30	1	33005689C	ROLLER,17.25L,2 OD.,75 ID
2	1	0411-070	CLAMP, SENSOR BRACKET	31	1	33008202	ROD,ROLL,SST,3/4X21 W/RAD
3	1	1959-112	2 POS THREAD PLATE ASSY	32	1	4003-500B	THREAD BREAK SENSOR ASSY
4	1	1961-182	PLATE,NUT,1/4-20,4 PL	33	1	4300615	ROLL HOLDER ASSY, LH
5	1	3200076	BREACKT, GUARD MOUNT	34	1	4300637	BRACKET, FRONT GUARD, EXTENDED
6	1	3200078	BRACKET, FRONT GUARD	35	1	84-2015	SPACER,THREAD STAND
7	1	3200079	DEFLECTOR, BORDER	36	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"
8	1	3200093	MOUNT,IDLER ROLL	37	1	AACNRM043D	CYLINDER,AIR,DA,NR,MAGNET
9	1	3200114	EDGE GUIDE ASSY.	38	1	CCCL12F	CLAMP COLLAR- 3/4
10	1	3200190	COVERS, CLOSER CARRIAGE	39	2	CCCL4F	COLLAR,1/4,CLAMP
11	1	32003000PC	MAIN FRAME ASSEMBLY	40	12	NNH1/4-20	1/4-20 HEX NUT
12	1	32004000PB	GUILLOTINE ASSEMBLY	41	3	NNH1/4-20	NUT,HEX,1/4-20
13	1	32005000PA	PREFEED ROLLER ASSY.	42	10	NNH10-32	# 10-32 HEX NUT
14	1	32005025	COVER, CLOSER	43	4	SSFC90032	# 8-32 X 1/2 FLAT ALLEN
15	1	32005500PM	FRAME ASSY 3200P, MOD	44	2	SSHC01064	1/4-20 X 1 HHCS
16	1	3200645	BRACKET,SIDE GUARD	45	19	SSHC01112	1/4-20 X 1-3/4 HEX HEAD
17	1	3200647	CLOSER STATION, 3200	46	4	SSHC01112	1/4-20 X 1-3/4 HHCS
18	1	3200649	PRIMARY GRIPPER ASSY	47	2	SSHC01160	1/4-20 X 2-1/2 HHCS
19	1	3200650	COVER, GUILLOTINE, EXTENDED	48	1	SSHC01224	1/4-20 X 3-1/2 HEX CAP
20	1	32006513A	SUPPORT, MATERIAL	49	4	SSHC98032	10-32X1/2 HEX HD
21	1	32006515A	GUIDE, MATERIAL	50	12	SSPP98032	# 10-32 X 1/2 PAN HD PHIL
22	1	32006519	HOLDER, EDGE GUIDE ROD	51	2	SSSC98024	10-32 X 3/8 SOC CAP
23	1	32006520D	EDGE GUIDE WELDMENT	52	3	SSSC98032S	10-32 X 1/2 SOC CAP, SS
24	1	3200664	SMALL ROLL HOLDER ASSY	53	4	SSZH# 10032	SCREW,SHT,METAL HEX 10
25	1	32007300	INDEXING TRAY ASSY	54	58	WWFS1/4	WASHER FLAT, 1/4
26	1	32007600P	SECONDARY CLAMP/TRANSPORT	55	12	WWFS1/4	WASHER,FLAT,SAE,1/4
27	1	32009000PCA	CONTROL PANEL	56	36	WWL1/4	1/4 LW
28	1	3200PC-PD	PNEUMATIC DIAGRAM	57	9	WWL1/4	WASHER,LOCK, 1/4
29	1	3200PCA-WD	WIRING DIAGRAM	58	4	WWL10	WASHER,LOCK,# 10

3200647 Closer Station

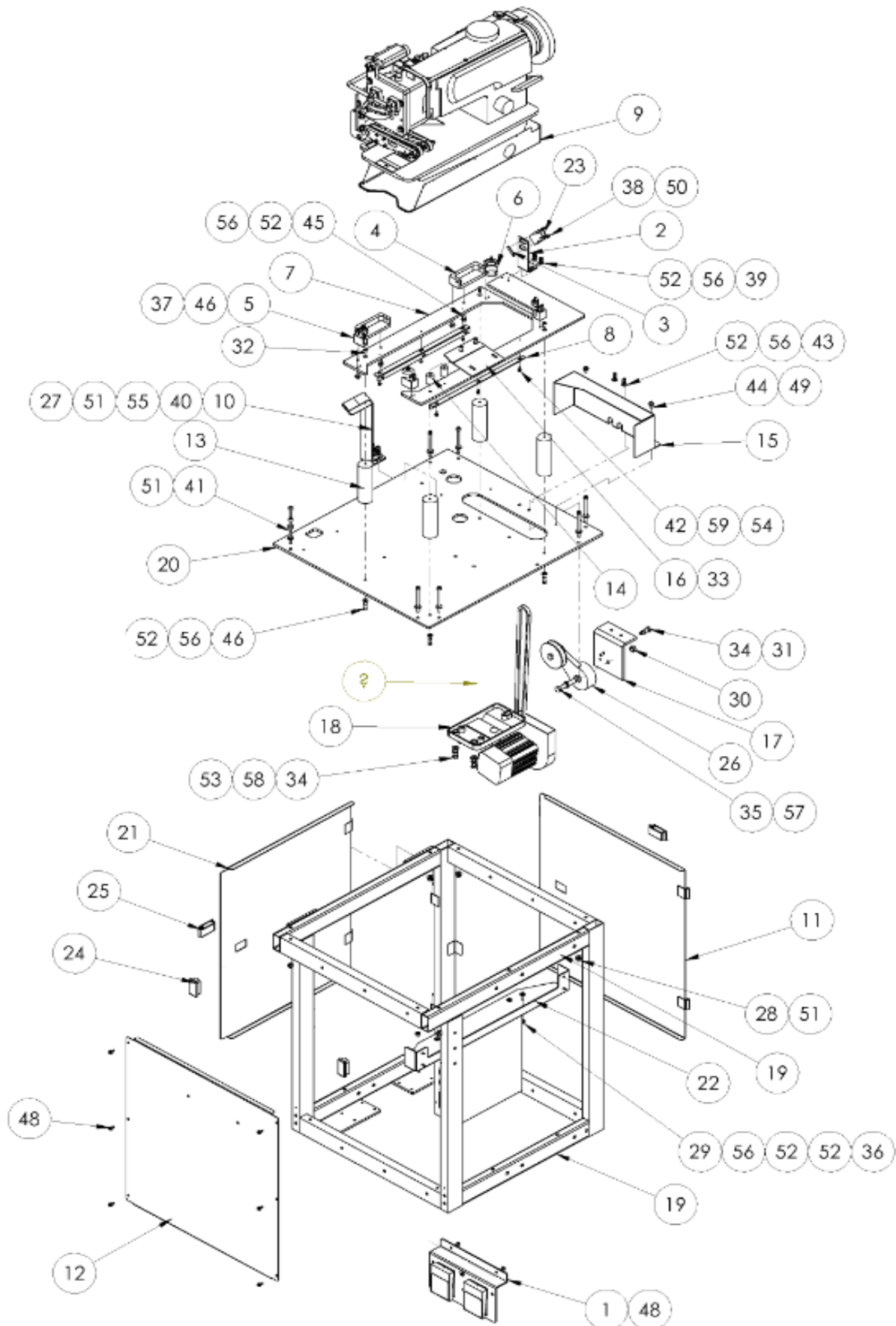
AAC Drawing 3200647 Rev 0



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	2	0411-1063	ROD, THREADED, 5/8-11 X 5
2	1	4300601	CLOSER STATION GENERIC
3	2	MM431-4	CASTER,4", SWIVEL, W/LOCKS,
4	2	MML-2	LEVELING PAD, 5/8-11
5	4	NNSH5/8-11	NUT, SQUARE, 5/8-11
6	8	SSHCO1040	1/4-20 X 5/8 HHCS
7	8	WWFS1/4	WASHER,FLAT,SAE,1/4
8	8	WWL1/4	WASHER,LOCK, 1/4

4300601 Closer Station Generic

AAC Drawing Number 4300601 Rev 1

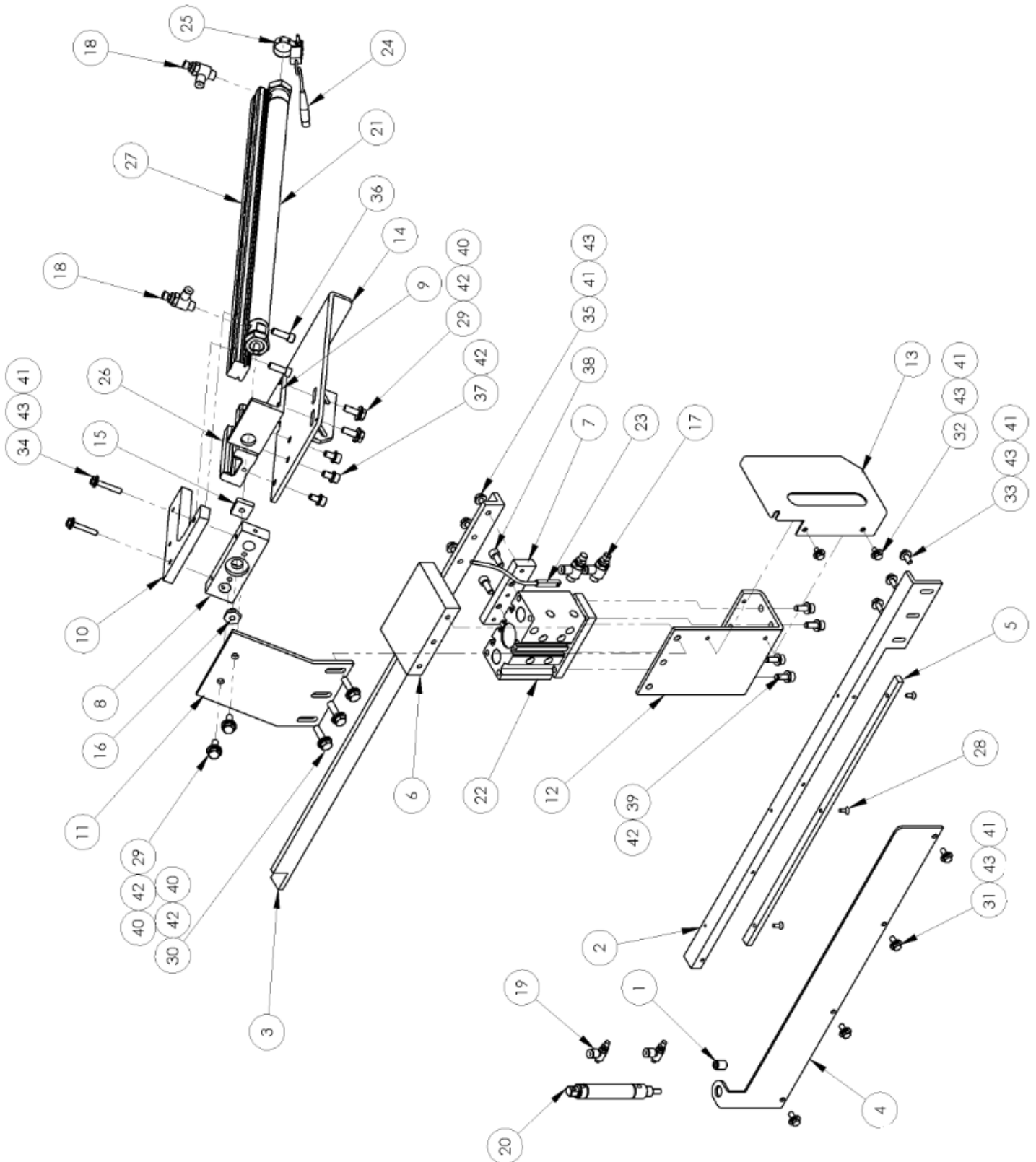


4300601 parts list

ITEM	QTY	PART NUMBER	DESCRIPTION	ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1278-6160C	DUAL FOOT PEDAL ASSY	31	1	NNJ1/4-20	NUT, HEX, JAM, 1/4-20
2	1	1278-6689B	BRACKET, EYE MOUNT	32	3	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
3	1	1975-412A	PLATE,NUT,4-40,.95CTC	33	2	SSFS98112	#8-32 X 3/4 FLAT SLOT
4	2	3200194	HINGE MNT, SEWING HEAD	34	4	SSHC10064	5/16-18 X 1 HHCS
5	2	3200196	MOUNT, MACHINE	35	1	SSHC25144	3/8-16X2-1/4 HEX CAP SC
6	2	3200197	MOUNT, MACHINE	36	4	SSHC98048	SCREW, HEX CAP #10-32X.75
7	1	3200198	PLATE, TOP	37	4	SSPS50032	SCREW,2-56 x 1/2
8	2	3200199	MOUNT, OIL PAN	38	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
9	1	3200200	SEWING HEAD ASSEMBLY	39	2	SSPS98032	10-32X1/2 PAN HD SLOT
10	1	3200208	BRACKET, TILT SUPPORT	40	2	SSSC01032	1/4-20X1/2 SOC CAP
11	1	32006021	DOOR, RIGHT	41	8	SSSC01192	1/4-20 X 3 SOC CAP
12	1	32006022	PANEL	42	6	SSSC80024	6-32 X 3/8 SOC CAP SC
13	4	32006501	STAND-OFF, SUB-TABLE	43	2	SSSC98024	10-32 X 3/8 SOC CAP
14	2	32006504	SPACER, 3/4 OD X 1/4 ID	44	2	SSSC98032	10-32X1/2, SOC CAP
15	1	32006512	COVER, BELT	45	4	SSSC98048	10-32 X 3/4 SOC CAP
16	1	32006513	SUPPORT, MATERIAL	46	12	SSSC98064	10-32 X 1 SOC CAP
17	1	32006521	BRKT, IDLER PULLEY	47	4	SSZH#10032	SCREW,SHT.METAL HEX 10
18	1	4059-DC1500	EFKA DC1500/AB220A	48	8	SSZS93032	SCREW, SHT.METAL 10 ZIP
19	1	4300602	FRAME ASSY	49	2	WWF10	WASHER, FLAT, #10, COM
20	1	4300609	PLATE, CLOSER STATION TOP	50	2	WWF4	WASHER, FLAT, #4
21	1	4300611	DOOR, REAR, LEFT	51	18	WWFS1/4	WASHER,FLAT,SAE,1/4
22	1	4300633	EFKA CONTROLLER MOUNT	52	20	WWFS10	WASHER, FLAT, #10, SAE
23	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	53	3	WWFS5/16	WASHER,FLAT,SAE,5/16
24	2	MM132-1496	PLUG 1 X 2	54	6	WWFS6	WASHER, FLAT, #6
25	2	MM40450010	FASTENER,SLIDE LOCK	55	2	WWL1/4	WASHER,LOCK, 1/4
26	1	MMFS0127	TENSIONER,V-BELT	56	16	WWL10	WASHER,LOCK,#10
27	2	MMLSSBB01210	FOAM, URETHANE, 1/8X1	57	1	WWL3/8	WASHER,LOCK, 3/8
28	8	NINE1/4-20	NUT,ELASTIC LOCK,1/4-20	58	3	WWL5/16	WASHER,LOCK, 5/16
29	4	NINH10-32	HEX-NUT 10-32 REG.	59	6	WWL6	WASHER,LOCK,#6
30	1	NINH3/8-16	NUT,HEX,3/8-16	60	1	ZX3850	V-BELT,3/8 X 50"

3200649 Primary Gripper Assembly

AAC Drawing Number 3200649 Rev 0

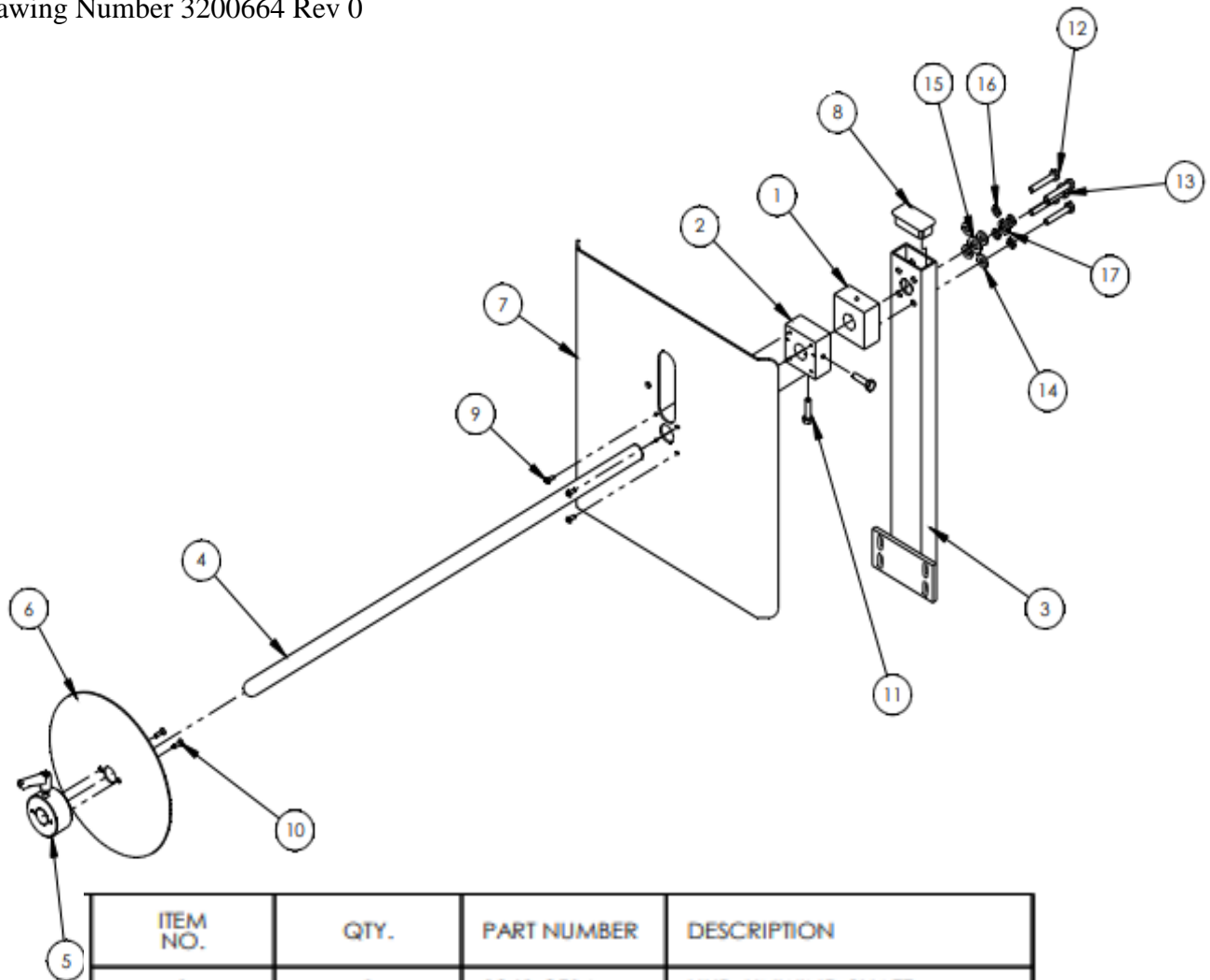


3200649 parts list

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1510-09	BUMPER	23	1	AAEDY59A-3M	SENSOR W/ PLUG
2	1	32004101	CLAMP, PRIM GRIPPER,LOWER	24	1	AAEHKQ	SWITCH,HALL EFFECT(SMC)
3	1	32004106	CLAMP, PRIM GRIPPER,LOWER	25	1	AAFD35000	BAND, UNIVERSAL, AAHSHKQ
4	1	32004107	GRIPPER PLATE, END	26	1	MMEGH25CA	LINEAR BEARING
5	1	32004112	SPACER,PRIMARY GRIPPER	27	1	MMEGR25R0480C	RAIL,LINEAR,AG SERIES
6	1	32004113	BLOCK, ADAPTOR	28	3	SSFC80024	6-32 X 3/8 FLAT CAP
7	1	32004114	MOUNT, PRIM GRIP. UPPER	29	4	SSHC01048	1/4-20 X 3/4 HEX CAP
8	1	32007224	PLATE,SUPPORT,ROD	30	3	SSHC01064	1/4-20 X 1 HHCS
9	1	4300331	MOUNT, CYLINDER	31	4	SSHC95032	10-24 X .5, HEX CAP
10	1	4300333	BRACKET, SLIDE ADAPTOR	32	2	SSHC98024	10-32 X 3/8 HEX CAP
11	1	4300628	MOUNT, PRIMARY GRIPPER	33	3	SSHC98032	10-32X1/2 HEX HD
12	1	4300629	MOUNT, PRIMARY GRIP. CYL.	34	2	SSHC98080	10-32 X 1-1/4 HEX CAP
13	1	4300630	GUARD, PRIMARY GRIPPER	35	3	SSPS95040	#10-24 X 5/8 PAN HD SLTD
14	1	4300631	BRKT. SIDE MOUNTING	36	2	SSSC01048	1/4-20 X 3/4" SOC CAP SC
15	1	97-6282	NUT,FLOATING COUPLING	37	3	SSSCM6X12	M6X12 SOC CAP SCREW
16	1	97-6290	NUT,LOCK,5/8 HEX,1/4-28	38	2	SSSCM6X15	M6X15 SOC CAP SCREW
17	2	AA198-2201	FLOW CONTROL,1/8PTX5/32	39	4	SSSCM6X16	M6 X 16, SOC CAP
18	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"	40	7	WWFS1/4	WASHER,FLAT,SAE,1/4
19	2	AA198RA510	FL CONT,5/32X10-32	41	14	WWFS10	WASHER, FLAT, #10, SAE
20	1	AAC8DP-1.5	CYL, AIR, DA, 9/16B, 2S	42	14	WWL1/4	WASHER,LOCK, 1/4
21	1	AACM0413.75DXP	CYLINDER, AIR, 3/4 BORE 13.75" STROKE	43	14	WWL10	WASHER,LOCK,#10
22	1	AACMGPM2530	CYLINDER,AIR,DUAL ROD				

3200664 Small Roll Holder Assembly

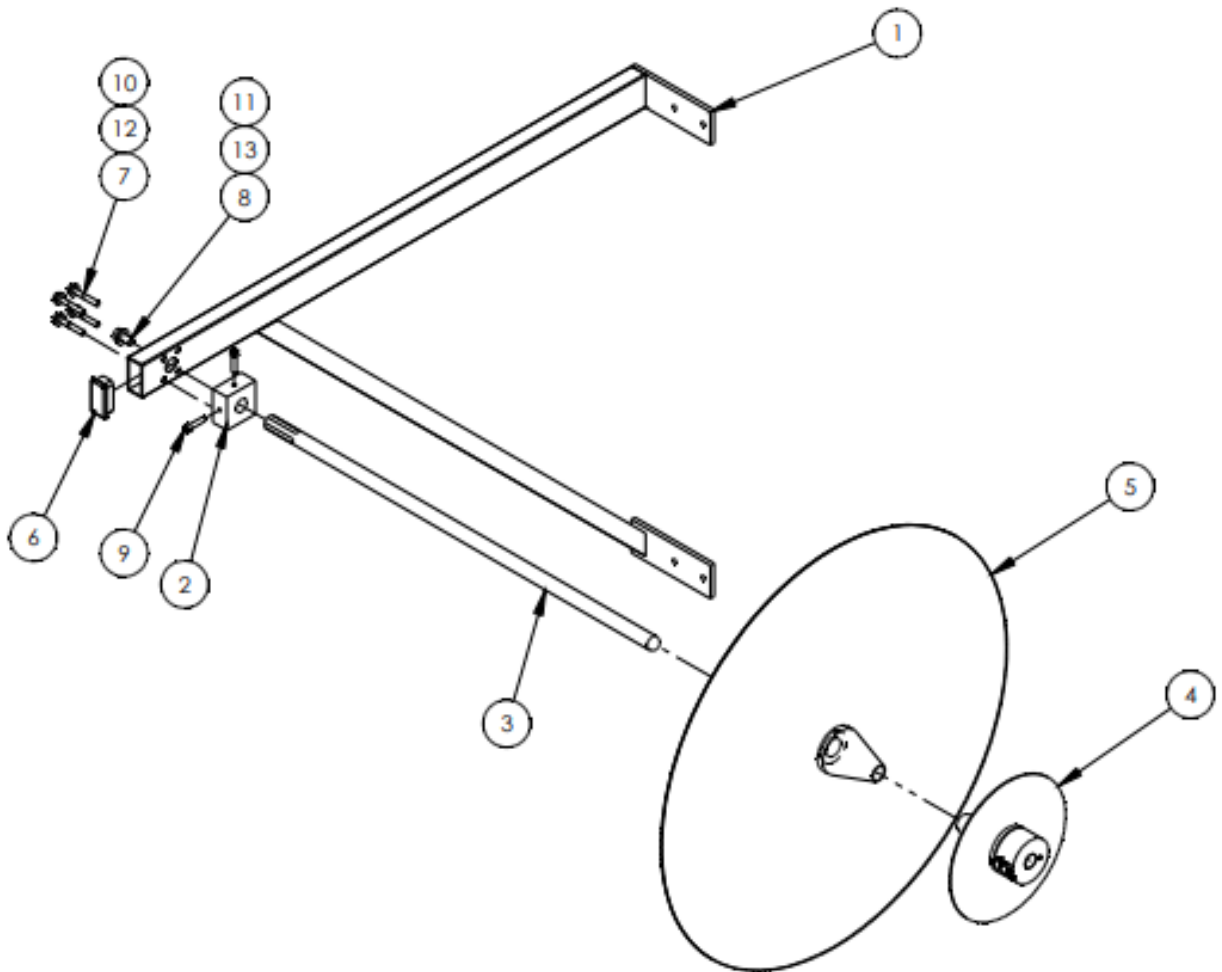
AAC Drawing Number 3200664 Rev 0



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1961-251A	HUB, UNWIND SHAFT
2	1	1961-253A	HUB, UNWIND STAND
3	1	3200092	WELDMENT,MID ROD MOUNT
4	1	32005016	ROD,SS,3/4 X 26.0L
5	1	360-116	HUB, LOCKING
6	1	784-08-050	DISC,BB,SP,8" DIA
7	1	784B-1414	PLATE, ALU, 14" X 14"
8	1	MM132-1496	PLUG 1 X 2
9	4	SSBC80024	6-32 X 3/8 BUTTON HEAD
10	2	SSFC80032	6-32 X 1/2 FLAT CAP
11	2	SSHC01064	1/4-20 X 1 HEX HEAD
12	4	SSHC01096	1/4-20 X 1-1/2 HHCS
13	1	SSHC25064	3/8-16 X 1,HEX CAP
14	4	WWFS1/4	WASHER,FLAT,SAE,1/4
15	1	WWFS3/8	WASHER,FLAT,SAE,3/8
16	4	WWL1/4	WASHER,LOCK, 1/4
17	1	WWL3/8	WASHER,LOCK, 3/8

3200615 Roll Holder Assembly, Left

AAC Drawing Number 3200615 Rev 0

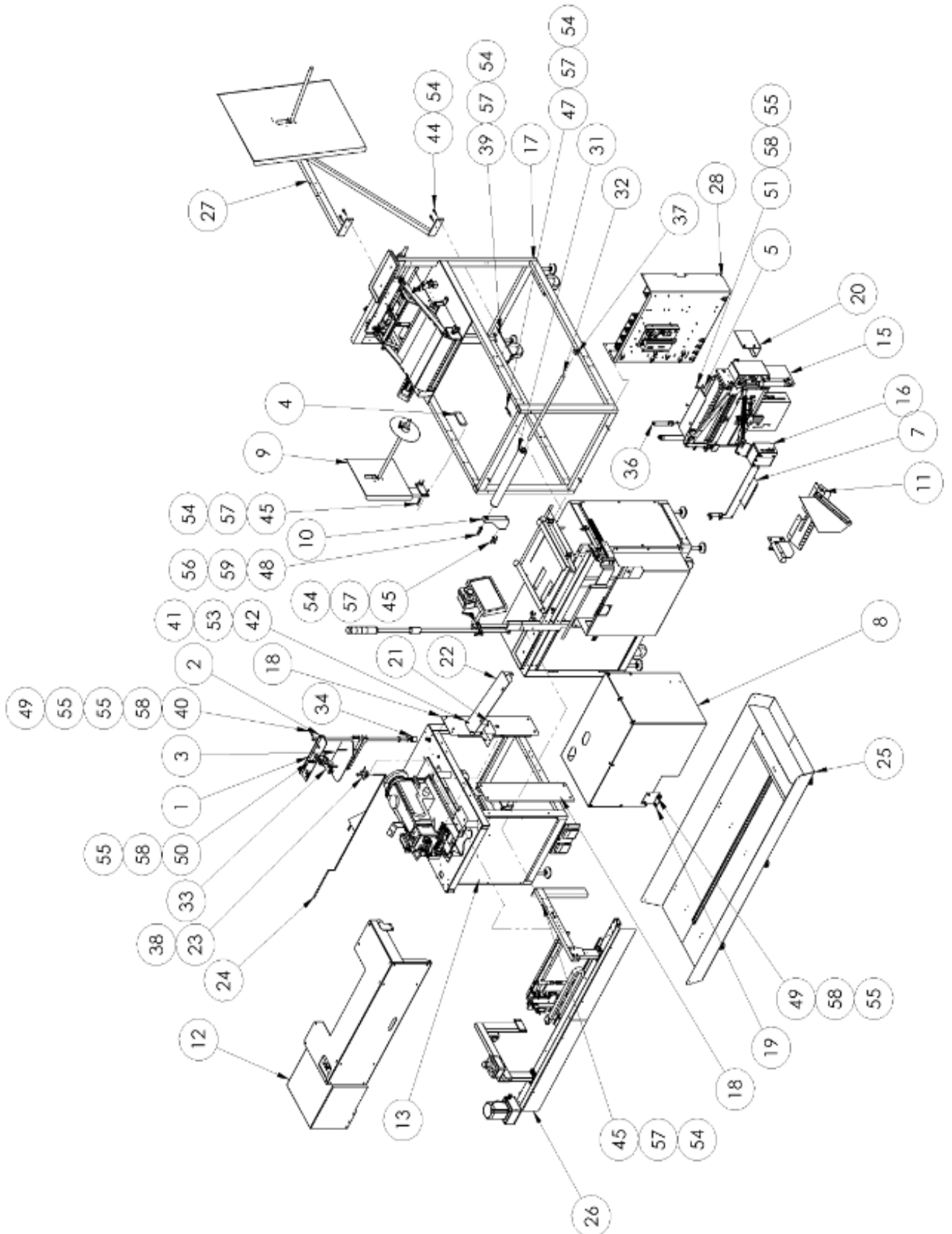


ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1369021	FRAME,ROLL HOLDER ASSY.
2	1	1961-251A	HUB, UNWIND SHAFT
3	1	1961-252D	ROD, ROLL, ,SST,3/4X27 W/RAD
4	1	33008708	DISC ASSY,8"
5	1	33008724	BALL BEARING DISC ASSY
6	1	MM132-1496	PLUG 1 X 2
7	4	SSHC01112	1/4-20 X 1-3/4 HHCS
8	1	SSHC25048	3/8-16X3/4,HEX CAP
9	2	SSSC01064	1/4-20 X 1 SOC CAP
10	4	WWFS1/4	WASHER,FLAT,SAE,1/4
11	1	WWFS3/8	WASHER,FLAT,SAE,3/8
12	4	WWL1/4	WASHER,LOCK, 1/4
13	1	WWL3/8	WASHER,LOCK, 3/8

Notes:

33200PCA Auto Border...Measure, Cut and Close

AAC Drawing Number 90071467 Rev 0

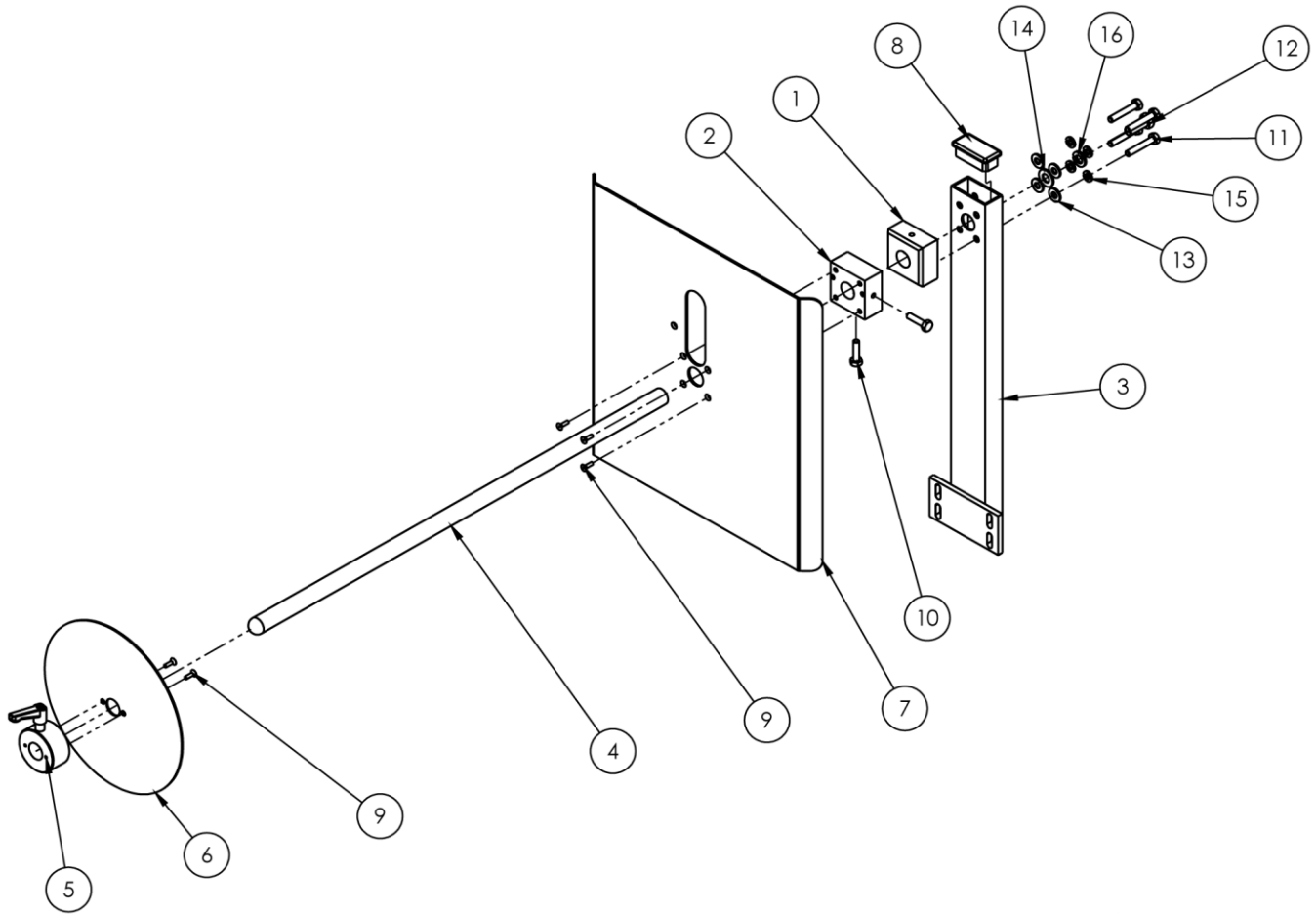


33200PCA parts list

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	0411-069D	BRKT, THREAD BRK DETECTIO	31	1	33005689C	ROLLER,17.25L,2 OD.,75 ID
2	1	0411-070	CLAMP, SENSOR BRACKET	32	1	33008202	ROD,ROLL,SST,3/4X21 W/RAD
3	1	1959-112	2 POS THREAD PLATE ASSY	33	1	4003-500B	THREAD BREAK SENSOR ASSY
4	1	1961-182	PLATE,NUT,1/4-20,4 PL	34	1	84-2015	SPACER,THREAD STAND
5	1	3200076	BREACKT, GUARD MOUNT	35	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"
6	1	3200078	BRACKET, FRONT GUARD	36	1	AAACNRM043D	CYLINDER,AIR,DA,NR,MAGNET
7	1	3200079	DEFLECTOR, BORDER	37	1	CCCL12F	CLAMP COLLAR- 3/4
8	1	3200081	COVER, GUILLOTINE	38	2	CCCL4F	COLLAR,1/4,CLAMP
9	1	3200085	SMALL ROLL HOLDER ASSY	39	12	NNH1/4-20	1/4-20 HEX NUT
10	1	3200093	MOUNT,IDLER ROLL	40	8	NNH10-32	# 10-32 HEX NUT
11	1	3200114	EDGE GUIDE ASSY.	41	2	NNH8-32	# 8-32 HEX NUT
12	1	3200190	COVERS, CLOSER CARRIAGE	42	4	SSFC90032	# 8-32 X 1/2 FLAT ALLEN
13	1	3200210	CLOSER STATION	43	4	SSHC01064	1/4-20 X 1 HEX HEAD
14	1	32003000PC	MAIN FRAME ASSEMBLY	44	4	SSHC01096	1/4-20 X 1-1/2 HEX HEAD
15	1	32004000PB	GUILLOTINE ASSEMBLY	45	8	SSHC01112	1/4-20 X 1-3/4 HEX HEAD
16	1	32004100PC	PRIMARY GRIPPER ASSY	46	2	SSHC01144	1/4-20 X 2-1/4 HEX HEAD
17	1	32005000PA	PREFEED ROLLER ASSY.	47	4	SSHC01160	1/4-20 X 2-1/2 HEX HEAD
18	2	32005025	COVER, CLOSER	48	1	SSHC25128	3/8-16 X 2 HEX HEAD
19	1	3200644	BRACKET, FRONT GUARD	49	12	SSPP98032	# 10-32 X 1/2 PAN HD PHIL
20	1	3200645	BRACKET,SIDE GUARD	50	2	SSSC98024	10-32 X 3/8 SOC CAP
21	1	32006513A	SUPPORT, MATERIAL	51	3	SSSC98032S	10-32 X 1/2 SOC CAP, SS
22	1	32006515A	GUIDE, MATERIAL	52	8	SSZH#10032	SCREW,SHT,METAL HEX 10
23	1	32006519	HOLDER, EDGE GUIDE ROD	53	2	WWF8	WASHER, FLAT #8
24	1	32006520D	EDGE GUIDE WELDMENT	54	34	WWF51/4	WASHER FLAT, 1/4
25	1	32007300	INDEXING TRAY ASSY	55	25	WWF510	WASHER, FLAT #10
26	1	32007600P	SECONDARY CLAMP/TRANSPORT	56	1	WWF53/8	WASHER, FLAT, 3/8
27	1	32007700P	ROLL HOLDER ASSY	57	22	WWL1/4	1/4 LW
28	1	32009000PCA	CONTROL PANEL	58	17	WWL10	# 10 LW
29	*1	3200PC-PD	PNEUMATIC DIAGRAM	59	1	WWL3/8	3/8 LW
30	*1	3200PCA-WD	WIRING DIAGRAM				

3200085 Small Roll Swing Rod Assembly

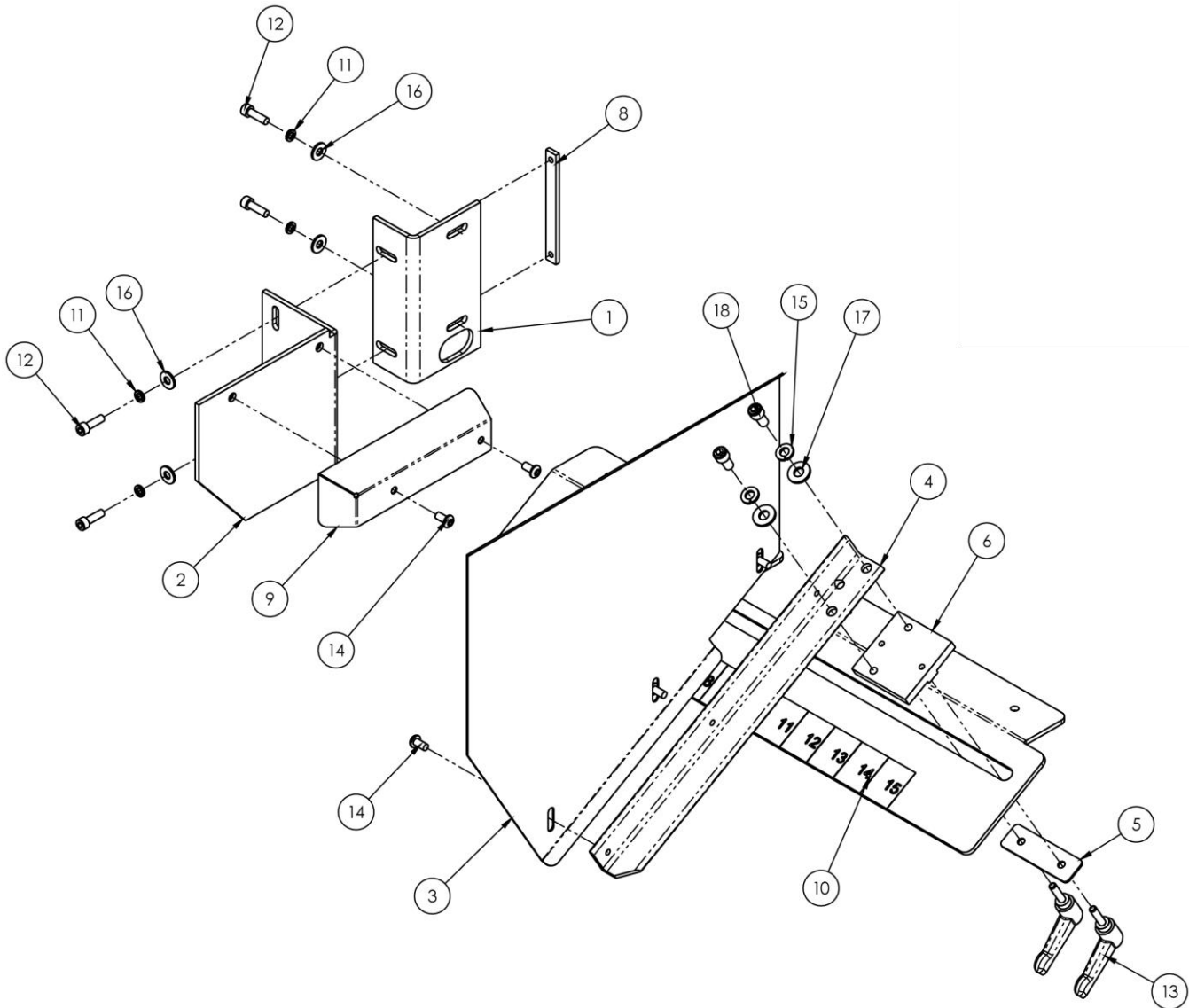
AAC Drawing Number 3200085 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	1	1961-251A	HUB, UNWIND SHAFT
2	1	1961-253A	HUB, UNWIND STAND
3	1	3200092	WELDMENT, MID ROD MOUNT
4	1	32005004	ROD, SS, 3/4 X 24.0L
5	1	360-116	HUB, LOCKING
6	1	784-08-050	DISC, BB, SP, 8" DIA
7	1	784B-1414	PLATE, ALU, 14' X 14"
8	1	MM132-1496	PLUG 1 X 2
9	6	SSFC80032	#6-32 X 1/2 FLAT ALLEN
10	2	SSHC01064	1/4-20 X 1 HEX HEAD
11	4	SSHC01096	1/4-20 X 1-1/2 HEX HEAD
12	1	SSHC25064	3/8-16 X 1 HEX HEAD
13	4	WWFS1/4	WASHER FLAT, 1/4
14	1	WWFS3/8	WASHER, FLAT, 3/8
15	4	WWL1/4	1/4 LW
16	1	WWL3/8	3/8 LW

3200114 Edge Guide Assembly

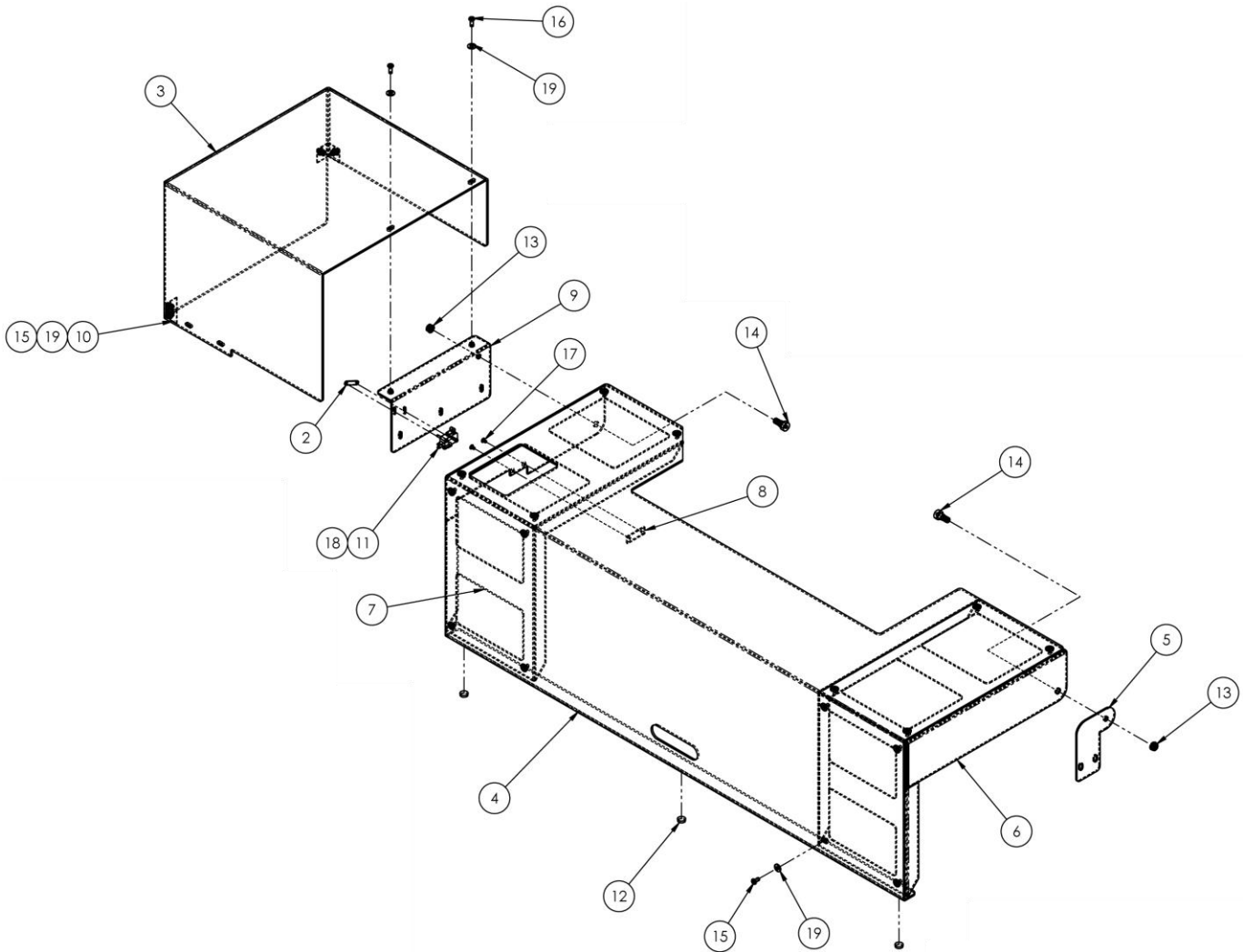
AAC Drawing Number 3200114 Rev 0



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	3200105	SUPPORT, FIXED GUIDE	10	1	MM1910A43M	RULER,SILVER MYLAR 36"
2	1	3200107	MOUNT, FIXED GUIDE	11	4	WWL10	WASHER,LOCK,#10
3	1	3200108	GUIDE, MOVEABLE	12	4	SSSC98040	10-32 X 5/8 SOC CAP
4	1	3200109	MOUNT, MOVEABLE GUIDE	13	2	TTH34311	HANDLE,THREADED,10-24X3/4
5	1	3200110	PLATE,WASHER (2) .203 DIA	14	5	SSBC98024	10-32 X 3/8 BUTTON CAP SC
6	1	3200113	BLOCK, SUPPORT	15	2	WWL1/4	WASHER,LOCK,1/4
7	1	3200115	PLATE, GUIDE BASE	16	4	WWFS10	WASHER, FLAT, #10, SAE
8	1	32003016	PLATE,NUT	17	2	WWFS1/4	WASHER,FLAT,SAE,1/4
9	1	32007506	GUIDE, FIXED EDGE	18	2	SSSC01032	1/4-20X1/2 SOC CAP

3200190 Closer Carriage Covers

AAC Drawing Number 3200190 Rev 1

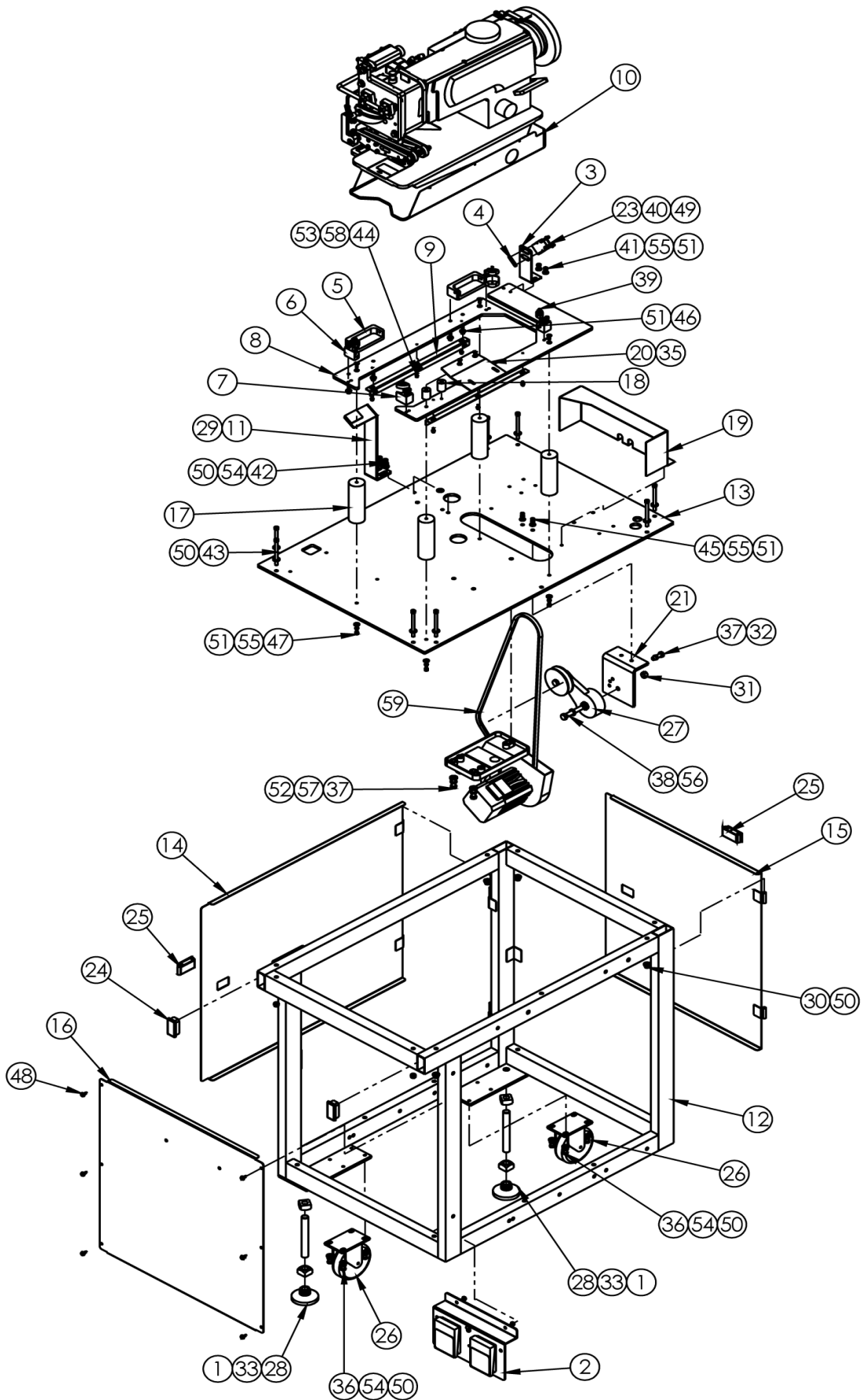


NO.	QTY	PART #	DESCRIPTION
1	1	12788-503G	CABLE, 16' LONG, 2 COND.
2	1	1975-412A	PLATE,NUT,4-40,.95CTC
3	1	3200181	GUARD, CARRIAGE MOTOR
4	1	3200182	GUARD, CLOSER CARRIAGE
5	1	3200184	BRACKET, COVER PIVOT
6	1	3200204	BRACE, COVER, RIGHT
7	1	3200205	BRACE, COVER, LEFT
8	1	3200206	PLATE, SWITCH
9	1	3200207	MOUNT, CARRIAGE COVER
10	2	98-6819A	CORNER BKT

NO.	QTY	PART #	DESCRIPTION
11	1	A-2014-39	MICRO SWITCH MODIFIED
12	3	MMSLD-ECH	1/2" DIA RUBBER BUMPER
13	2	NNK5/16-18	NUT,HEX,KEP,5/16/18 ,W/LOCK
14	2	SSAS024016	SHOULDER BOLT,3/8, 1/4, 5
15	20	SSBC98024	10-32 X 3/8 BUTTON CAP SC
16	2	SSBC98032	10-32 X 1/2 BUTTON CAP SC
17	2	SSFC80016	6-32 X 1/4 FLAT SOC CAP
18	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
19	22	WWFS10	WASHER, FLAT, #10, SAE

3200210 Closer Station

AAC Drawing Number 3200210 Rev 1



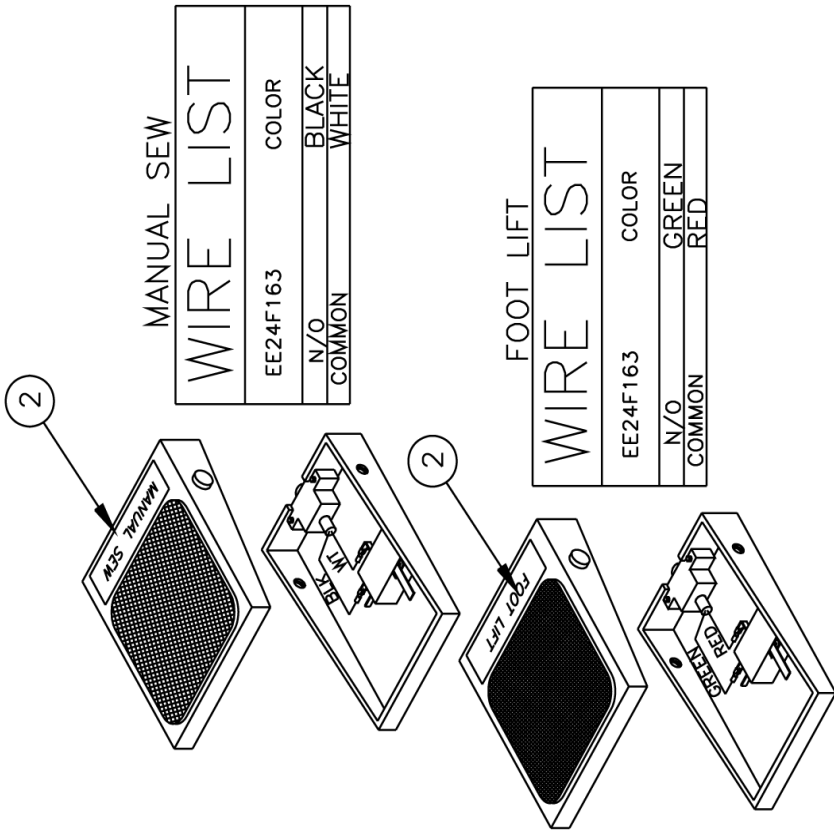
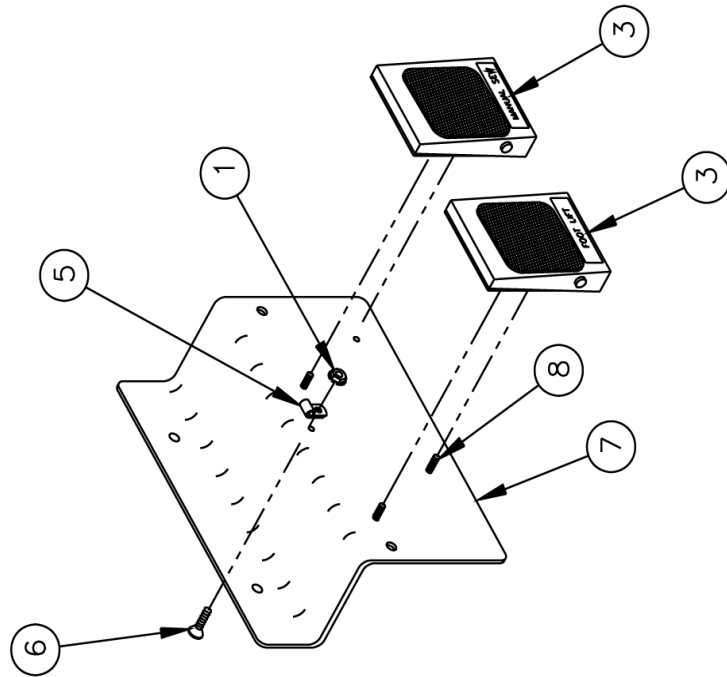
3200210 parts list

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	0411-1063	ROD, THREADED, 5/8-11 X 5	31	1	NNH3/8-16	NUT,HEX,3/8-16
2	1	1278-6160C	DUAL FOOT PEDAL ASSY	32	1	NNJ1/4-20	NUT, HEX, JAM, 1/4-20
3	1	1278-6689B	BRACKET, EYE MOUNT	33	4	NNSH5/8-11	NUT, SQUARE, 5/8-11
4	1	1975-412A	PLATE,NUT,4-40,.95CTC	34	3	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
5	2	3200194	HINGE MNT, SEWING HEAD	35	2	SSFS90048	#8-32 X 3/4 FLAT SLOT
6	2	3200196	MOUNT, MACHINE	36	8	SSHC01048	1/4-20 X 3/4 HEX CAP
7	2	3200197	MOUNT, MACHINE	37	4	SSHC10064	5/16-18 X 1 HHCS
8	1	3200198	PLATE, TOP	38	1	SSHC25144	3/8-16X2-1/4 HEX CAP SC
9	2	3200199	MOUNT, OIL PAN	39	4	SSPS50032	SCREW,2-56 x 1/2
10	1	3200200	SEWING HEAD ASSEMBLY	40	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
11	1	3200208	BRACKET, TILT SUPPORT	41	2	SSPS98032	10-32X1/2 PAN HD SLOT
12	1	32006000	FRAME ASSY	42	2	SSSC01032	1/4-20X1/2 SOCCAP
13	1	32006005	PLATE, CLOSER STATION TOP	43	8	SSSC01192	1/4-20 X 3 SOCCAP
14	1	32006020	DOOR, REAR, LEFT	44	6	SSSC80024	6-32 X 3/8 SOCCAP SC
15	1	32006021	DOOR, RIGHT	45	2	SSSC98024	10-32 X 3/8 SOCCAP
16	1	32006022	PANEL	46	4	SSSC98048	10-32 X 3/4 SOCCAP
17	4	32006501	STAND-OFF, SUB-TABLE	47	12	SSSC98064	10-32 X 1 SOCCAP
18	2	32006504	SPACER, 3/4 OD X 1/4 ID	48	8	SSZS93032	SCREW, SHT.METAL 10ZIP
19	1	32006512	COVER, BELT	49	2	WWWF4	WASHER, FLAT, #4
20	1	32006513	SUPPORT, MATERIAL	50	26	WWFS1/4	WASHER,FLAT,SAE,1/4
21	1	32006521	BRKT, IDLER PULLEY	51	12	WWFS10	WASHER, FLAT, #10, SAE
22	1	4059-DC1500	MOTOR,DC WITH CONTROLLER	52	3	WWFS5/16	WASHER,FLAT,SAE,5/16
23	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	53	6	WWFS6	WASHER, FLAT, #6
24	2	MM132-1496	PLUG 1 X 2	54	10	WWL1/4	WASHER,LOCK,1/4
25	2	MM40450010	FASTENER,SLIDE LOCK	55	12	WWL10	WASHER,LOCK,#10
26	2	MM431-4	CASTER,4", W/LOCKS	56	1	WWL3/8	WASHER, LOCK, 3/8
27	1	MMFS0127	TENSIONER,V-BELT	57	3	WWL5/16	WASHER, LOCK, 5/16
28	2	MML-2	LEVELING PAD, 5/8-11	58	6	WWL6	WASHER,LOCK,#6
29	1	MMLSSBB01210	FOAM, URETHANE, 1/8X1	59	1	ZX3851	V BELT,3/8 X 51"
30	8	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20				

1278-6160C Dual Foot Pedal Assembly

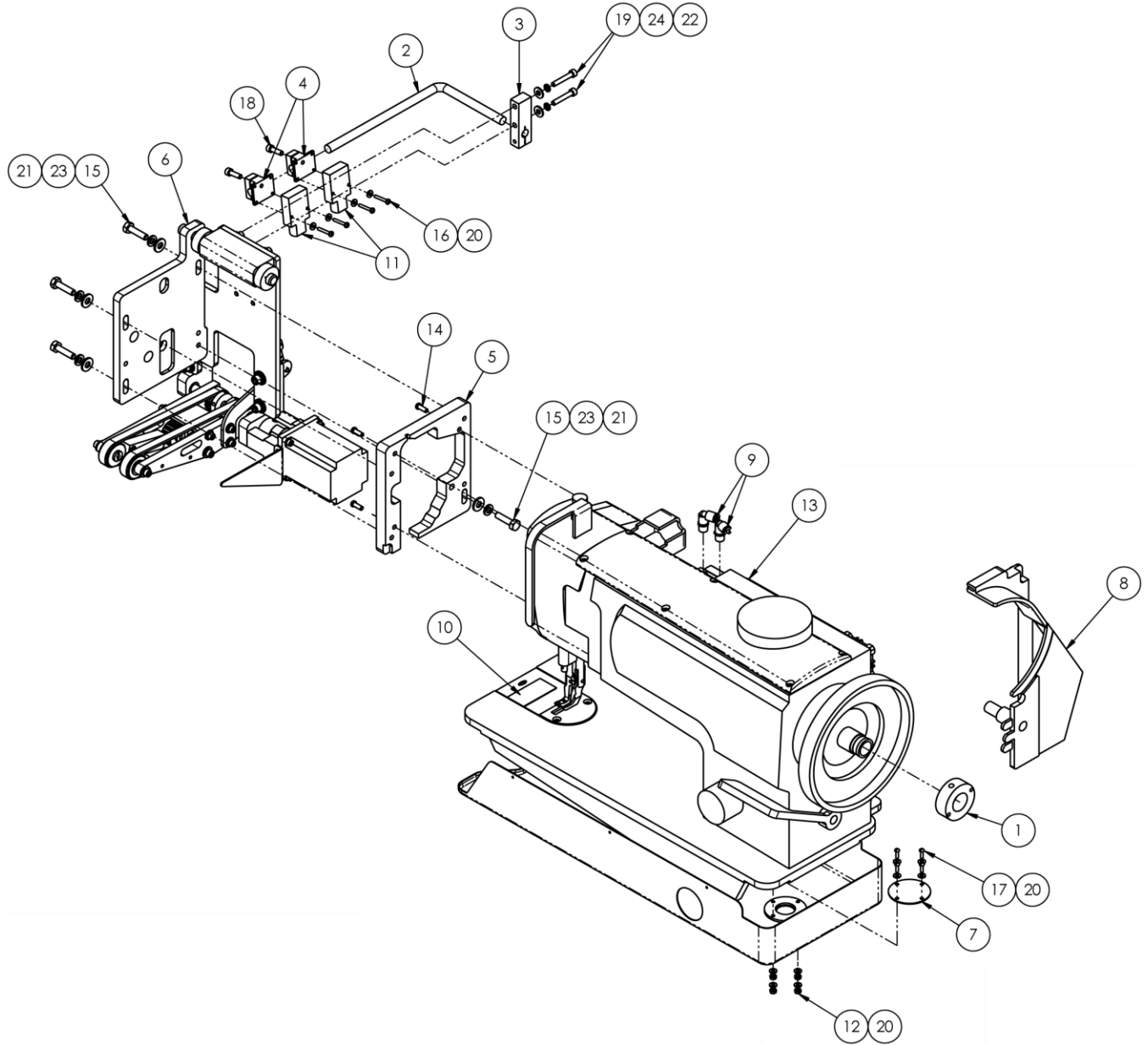
AAC Drawing Number 191152B Rev 6

NO.	QTY	PART #	DESCRIPTION
1	1	NNK6-32	Kep Nut
2	1	1278-5275	Label
3	2	1278-6161	Foot Switch
4	1	12788-502A	Cable
5	1	AAF1/8	Clamp
6	1	SSFC80024	Screw, Flat Allen
7	1	1278-5051A	Foot Pedal Plate
8	4	SSFC80016	Screw, Flat Allen



3200200 Sewing Head Assembly

AAC Drawing Number 3200200 Rev 0

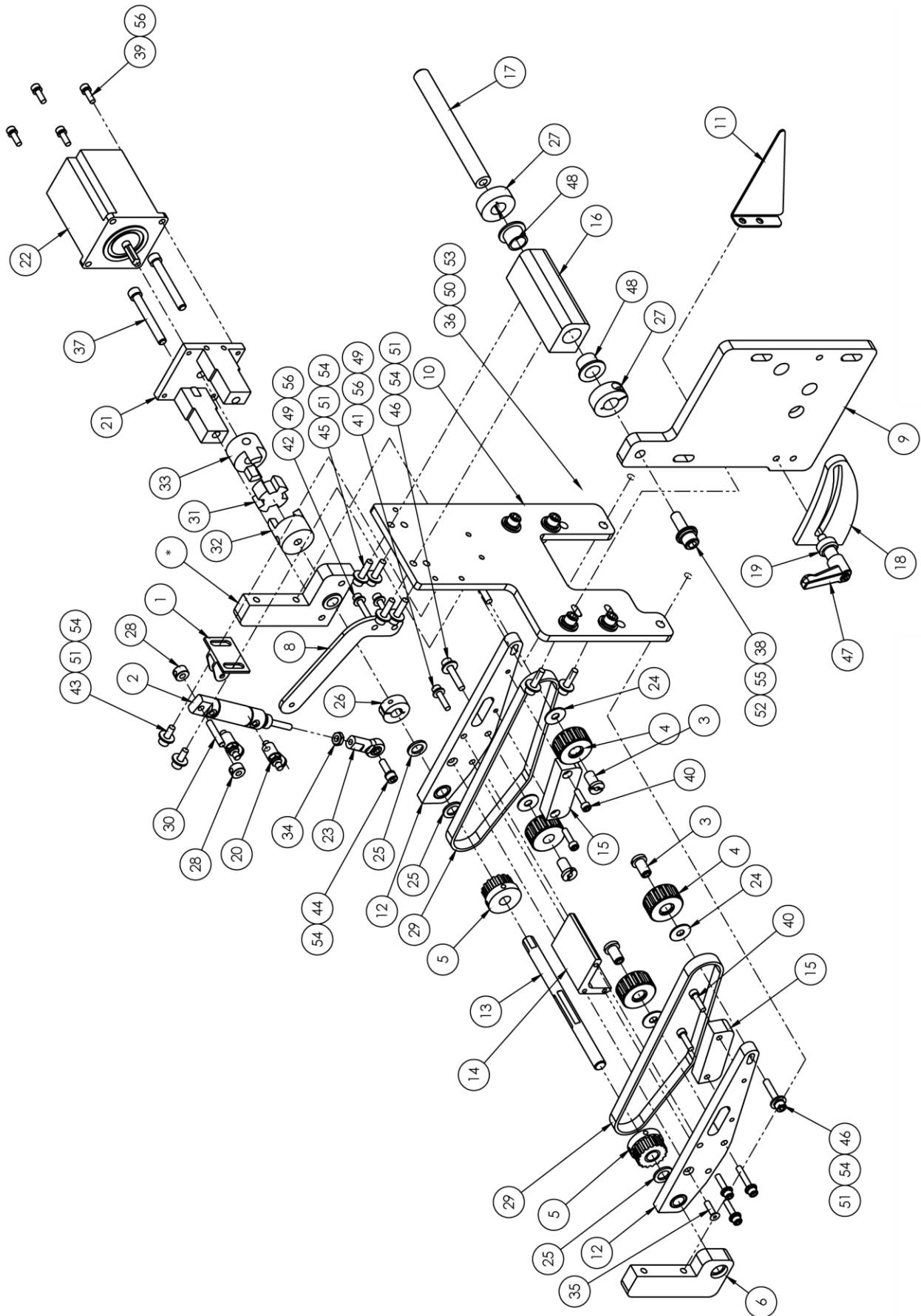


NO.	QTY	PART #	DESCRIPTION
1	1	1278-6364	DISC, TAPE MOUNTING
2	1	1335-316	ROD, SS, "L", 3/8, 4.0 X
3	1	23080	BLOCK, CLAMP, EYE
4	2	23132A	HOLDER, EYE
5	1	3200187	SPACER, FACE PLATE
6	1	3200195	FEED CONVEYOR ASSEMBLY
7	1	3200201	PLUG, OIL PAN
8	1	3200209	BELT GUARD MOD.
9	3	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
10	1	EEFE-RR2	TAPE, REFLECTIVE, 1" WIDE
11	2	FFSM312LVQ	EYE, ELECTRIC, 10-30VDC
12	4	NNK4-40	NUT, HEX, 4-40 KEPLOCK

NO.	QTY	PART #	DESCRIPTION
13	1	SJUKI-1541-7	SEWING HEAD, SN, LS, UF, UT
14	1	SS4111215SP	SCREW, 11/64-40 X 12MM
15	4	SSHC01064	1/4-20 X 1 HHCS
16	4	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
17	4	SSRS70024	4-40 X 3/8 RHS
18	2	SSSC98040	10-32 X 5/8 SOC CAP
19	2	SSSC98072	10-32 X 1-1/8 SOC CAP
20	12	WWF4	WASHER, FLAT, #4
21	4	WWF1/4	WASHER, FLAT, 1/4", COM
22	2	WWFS10	WASHER, FLAT, #10, SAE
23	4	WWL1/4	WASHER, LOCK, 1/4
24	2	WWL10	WASHER, LOCK, #10

3200195 Feed Conveyor Assembly

AAC Drawing Number 3200195 Rev 3

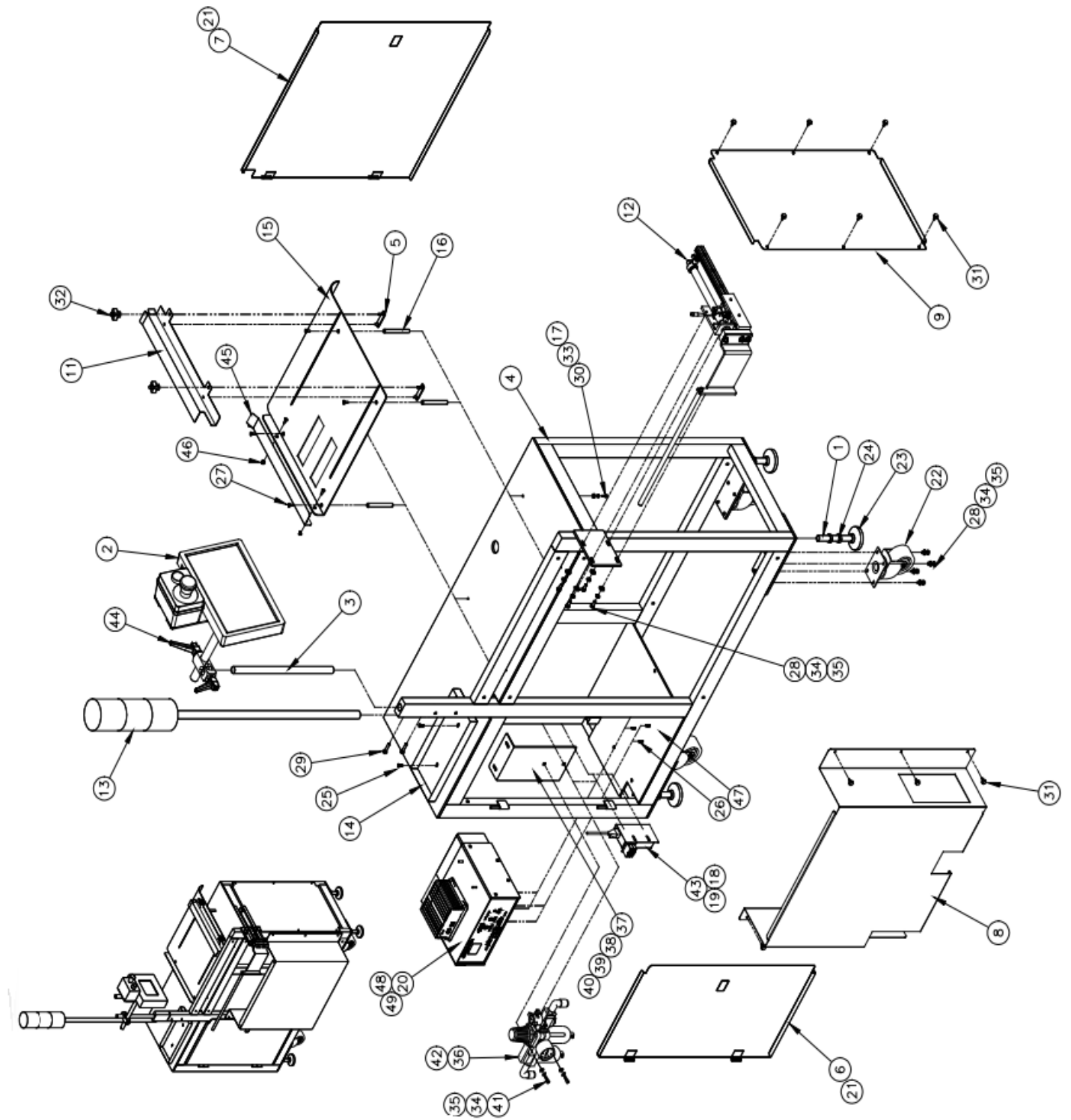


3200195 parts list

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	011-070	PLATE,CYLINDER MOUNT	29	2	GGD160XL37	BELT,GEAR,DBL.
2	1	1975-213	CYLINDER,AIR,DA,9/16B,1/2S	30	1	IID012X064	DOWEL PIN,3/16 X 1
3	4	26179	BUSHING,IDLER,PULLEY	31	1	MML050	SPIDER, COUPLING
4	4	26183	PULLEY MOD, 18XLB037	32	1	MML050-250	COUPLING,1/4 BORE
5	2	311-3004A	PULLEY,GEAR,1/5 PITCH,16T	33	1	MML050-375	COUPLING,3/8 BORE
6	1	3200188	SUPPORT,PULLER, LH	34	1	NNJ10-32	NUT,JAM,THIN #10-32
7	1	3200189	SUPPORT,PULLER, RH	35	1	SSFC90040	8-32 x 2 FLAT ALLEN
8	1	3200191	LINK,PULLER PIVOT	36	4	SSSC01048	1/4-20 X 3/4" SOC CAP SC
9	1	3200192	PLATE, PIVOT, CONVEYOR	37	2	SSSC01128	1/4-20 X 2 SOC CAP
10	1	3200193	MOUNTING PLATE, CONVEYOR	38	1	SSSC10064	5/16-18X1 SOCKET CAP
11	1	3206024	GUIDE, LABEL	39	4	SSSC90032	#8-32 X 1/2 SOC CAP SC
12	2	32006555	ARM,PULLER	40	4	SSSC90040	8-32 X 5/8 SOC CAP SC
13	1	32006556	AXLE, UPPER BELT PULLER	41	3	SSSC90048	#8-32 X 3/4 SOC CAP SC
14	1	32006557	SPACER,ANGLE,ALUM	42	3	SSSC90064	#8-32 X 1 SOC CAP SC
15	2	32006558	SUPPORT,BELT	43	2	SSSC98032	10-32X1/2, SOC CAP
16	1	32007833	PIVOT BLOCK	44	1	SSSC98040	10-32 X 5/8 SOC CAP
17	1	32007834	PIVOT SHAFT	45	6	SSSC98048	10-32 X 3/4 SOC CAP
18	1	32007836	PIVOT LOCK PLATE	46	3	SSSC98064	10-32 X 1 SOC CAP
19	1	32007838	SPACER-PIVOT LOCK	47	1	TTH32415	HANDLE,THREADED,1/4-20X7/
20	2	AA198RA510	FLOW CONTROL,5/32X10-32	48	2	UUFF620-01	BRG,BRONZE,.502ID
21	1	AP-22E-101	MOTOR BRACKET	49	6	WWF8	WASHER, FLAT, #8
22	1	AP-22E-103	STEP MOTOR,MODIFIED	50	4	WWFS1/4	WASHER,FLAT,SAE,1/4
23	1	BBAW-3Z	BRG,ROD END,F, 10-32	51	11	WWFS10	WASHER, FLAT, #10, SAE
24	4	BBTRA411	WASHER,THRUST,STEEL	52	1	WWFS5/16	WASHER,FLAT,SAE,5/16
25	3	BBTT604	BEARING,BRONZE,.385ID	53	4	WWL1/4	WASHER,LOCK,1/4
26	1	CCCL6F	CLAMP COLLAR- 3/8	54	12	WWL10	WASHER,LOCK,#10
27	2	CCCL8F	CLAMP COLLAR- 1/2	55	1	WWL5/16	WASHER, LOCK, 5/16
28	2	CCSC33/16	COLLAR,SET,3/16"	56	10	WWL8	WASHER,LOCK,#8

32003000PC Main Frame Assembly

AAC Drawing Number 192166A Rev 2



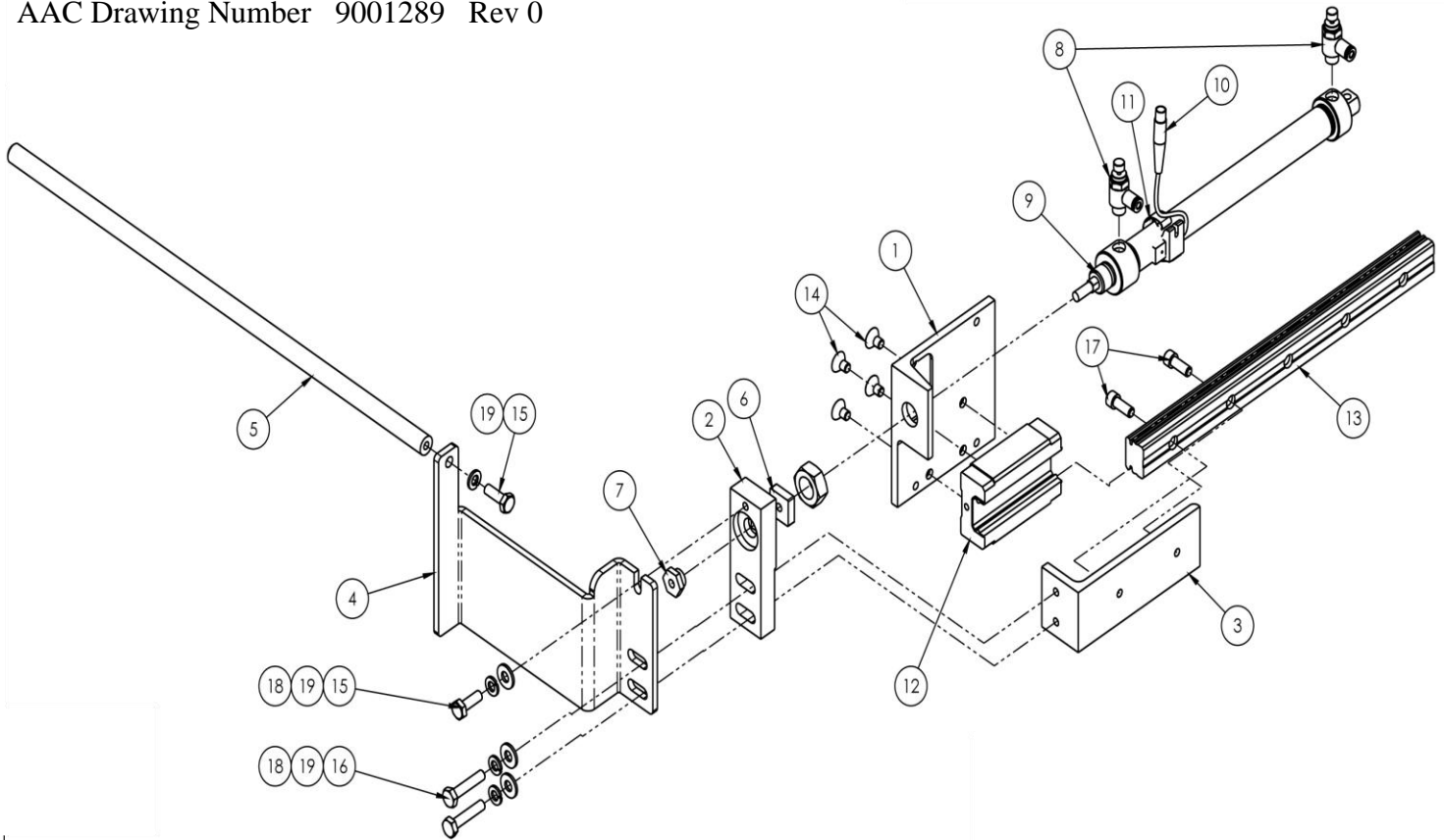
32003000PC parts list

QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	25	SCREW, BUTTON CAP 10-32 x 3/8	SSBC98024
8	24	SQUARE NUT	NNSH5/8-11
4	23	LEVELING PAD	MML-2
4	22	CASTER	MM431-4
2	21	SLIDE LOCK	MM40450010
1	20	STEPPER BOX	AP-28-800WD
2	19	TREMBLK, WAGO, TOP, DUAL, GRAY SNAO-IN GRAY	FF264-341
1	18	TERMBLK, WAGO, TOP, END GRAY	FF264-371
4	17	LOCK WASHER	WWL8
4	16	STANDOFF	33005623
1	15	CLOTH PLATE	33005605A
1	14	TOOL TRAY	33005534
1	13	LIGHT TOWER	33001130
1	12	PANEL SUP. ASSY	32007200PC
1	11	GUIDE	32005526
1	10	PANEL	32005027
1	9	PANEL	32005015
1	8	PANEL	3200137
1	7	REAR DOOR	32005012
1	6	FRONT DOOR	32005011
2	5	NUT PLATE	32004035A
1	4	FRAME ASSY	32003500P
1	3	STRAIGHT ROD	28203
1	2	HMI POLE MOUNT	4082006
4	1	THEADED ROD	0411-1063

QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	49	PC MOUNT AP-28-803H	4082011
1	48	PC GATEWAY	EEJBC375CG
1	47	MOUNT, CNTRL BX	3200643
2	46	KEP NUT	NNK8-32
1	45	GUIDE	3200090
2	44	THEADED HANDLE	TTH32426
1	43	PC POWER BLOCK BRACKET	4082004
2	42	MALE ELBOW	AAQME-3-4
2	41	SCREW, SOCKET CAP 1/4-20 x 3/4	SSSC01048
2	40	FLAT WASHER	WWFS10
2	39	LOCK WASHER	WWL10
2	38	SCREW, SOCKET CAP 10-32 x 3/8	SSSC98024
1	37	MOUNT BRKT	32003033
1	36	REGULATOR	AA198-5110
22	35	LOCK WASHER	WWL1/4
22	34	FLAT WASHER	WWFS1/4
4	33	FLAT WASHER	WWF8
2	32	KNOB	TTCL1APPK1
12	31	SCREW, SHEET METAL 10-16 x 1/2, SELF DRILL	SSZS93032
4	30	SCREW, SOCKET CAP 8-32 x 1/2	SSSC90032
2	29	SCREW, HEX CAP 1/4-20 x 1	SSHC01064
20	28	SCREW, HEX CAP 1/4-20 x 5/8	SSHC01040
6	27	SCREW, FLAT ALLEN 8-32 x 3/8	SSFC90024
4	26	SCREW, FLAT ALLEN 6-32 x 1/2	SSFC80032

32007200PC Border Support Assembly

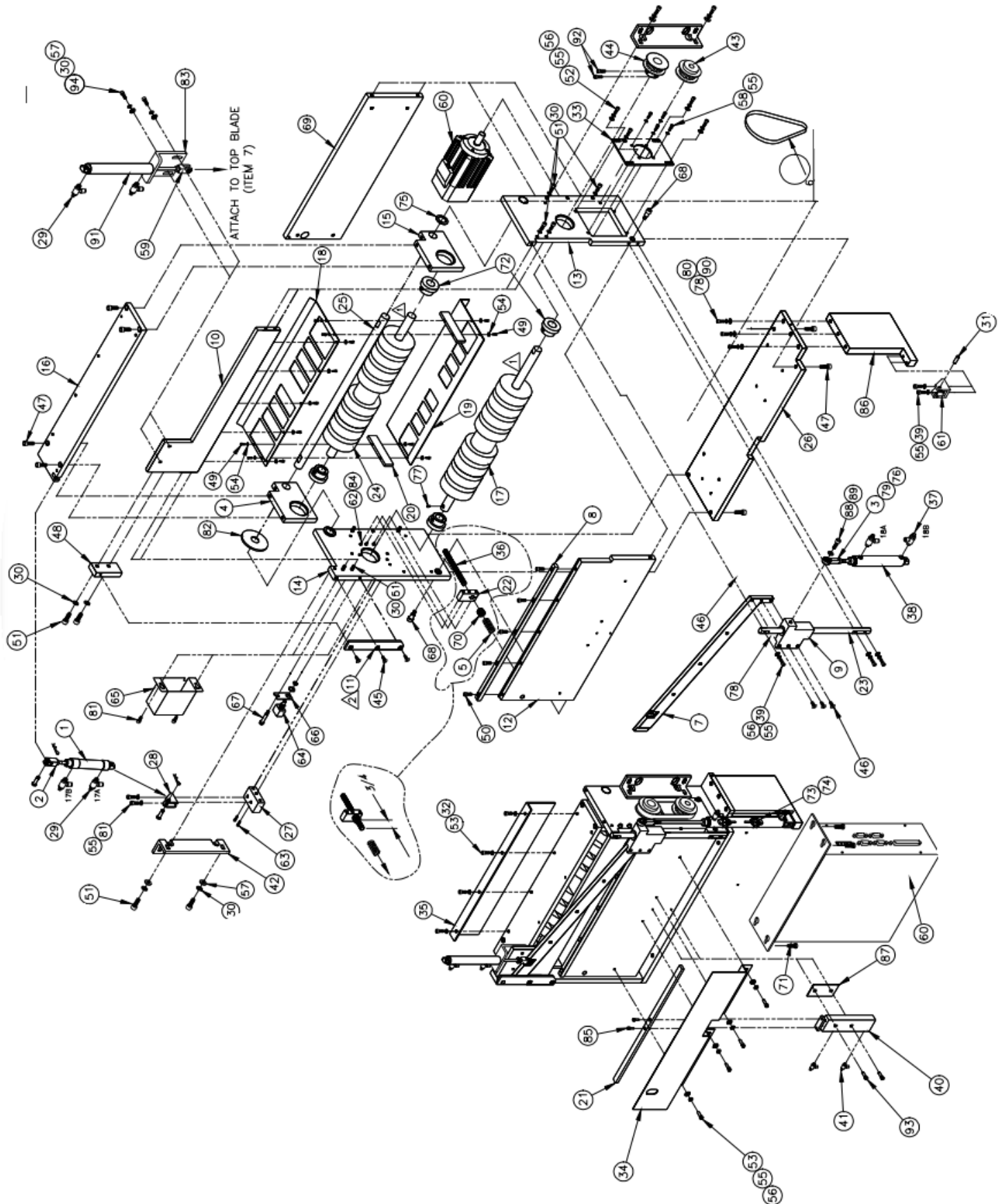
AAC Drawing Number 9001289 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	1	3300087	BODY,SLIDE
2	1	3300088	PLATE,SUPPORT,ROD
3	1	3300089	BODY,SLIDE
4	1	3300097	MOUNT, BORDER SUPPORT
5	1	32005019	ROD, .50 DIA X 17.0 L
6	1	97-6282	NUT,FLOATING COUPLING
7	1	97-6290	NUT,LOCK,5/8 HEX,1/4-28
8	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"
9	1	AACMRS046DXPB	CYLINDER,AIR W/BUMPERS
10	1	AAEHSKQ	SWITCH,HALL EFFECT BIMBA
11	1	AAFD35456-6	BAND,04 CYLINDER,HSKQ
12	1	MMAGH25CAN	LINEAR BEARING
13	1	MMAGR25303N	RAIL,LINEAR,AG SERIES
14	4	SSFCM6X12	SCREW,FLAT ALLEN CAP
15	2	SSHCO1048	1/4-20 X 3/4 HEX CAP
16	2	SSHCO1080	1/4-20 X 1-1/4 HHCS
17	2	SSSCO1040	1/4-20 X 5/8" SOC CAP SC
18	3	WWFS1/4	WASHER,FLAT,SAE,1/4
19	4	WWL1/4	WASHER,LOCK,1/4

3200400PB Guillotine Assembly

AAC Drawing Number 192111A Rev 4

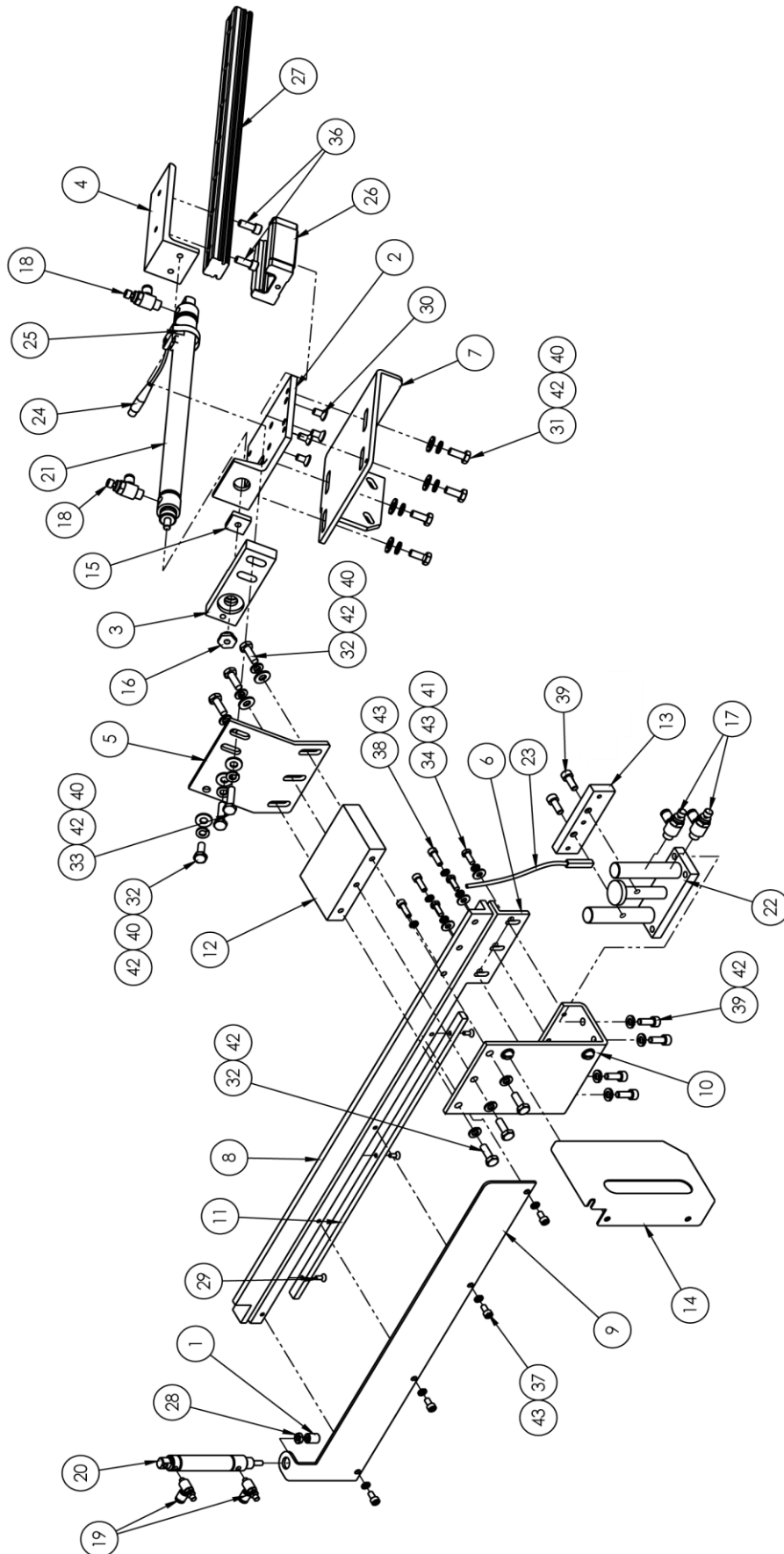


32004000PB parts list

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	AAC7DP-1	AIR CYLINDER	48	1	3200129	BLOCK, PLATE RUB MNTG
2	1	AAFCT-7	CLEVIS, AIR CYL.	49	13	SSBC70016	BUTTON CAP SCREW
3	1	BBAW-7	ROD END BEARING	50	5	SSSC98040	SOCKET CAP SCREW
4	1	33004014	TOP RIGHT ARM	51	14	SSHC01064	HEX CAP SCREW
5	1	RRLC092H6	SPRING	52	4	SSSC95048	SOCKET CAP SCREW
6	1	GG150L050	GEAR BELT	53	8	SSHC98032	HEX CAP SCREW
7	1	3200133	TOP BLADE	54	13	WWSI4	INTERNAL TOOTH WASHER
8	1	33004002A	BOTTOM BLADE	55	19	WWL10	LOCK WASHER
9	1	3200082	BLOCK, GUIDE, TOP BLADE	56	11	WWFS10	FLAT WASHER SAE
10	1	3200123	BAR, TIE	57	6	WWFS1/4	FLAT WASHER SAE
11	1	3200130	PLATE, RUB	58	4	SSSCM5X14	SOCKET CAP SCREW
12	1	33004006A	HINGE PLATE	59	1	AAFCT-11	AIR CYLINDER CLEVIS
13	1	3200121	FRONT SIDE PLATE	60	1	4059-DC1500A	MOTOR AND CONTROLLER
14	1	33004008	REAR SIDE PLATE	61	1	3200083	PIVOT BRKT
15	1	33004009	TOP LEFT ARM	62	1	SSSC98080	SOCKET CAP SCREW
16	1	33004010	BACK PLATE	63	2	SSSC95096	SOCKET CAP SCREW
17	1	33004020	PROLLER, DRIVE, BOTTOM	64	1	EENC256	ENCODER
18	1	33004012	TOP ROLLER GUARD	65	1	33004061	ENCODER COVER
19	1	33004013	BOTTOM ROLLER GUARD	66	1	33004080	ENCODER SUPPORT BRKT
20	2	33004015	MATERIAL INTERNAL GUIDE	67	1	SSAS016064	ALLEN SHOULDER SCREW
21	1	3200134	BRIDGE	68	2	SSAS024040	ALLEN SHOULDER SCREW
22	1	33004017	SPRING BLOCK	69	1	33004062	PLATE, MAIN MTG.
23	1	3200124	TOP BLADE SHAFT	70	2	NNJ3/8-24	JAM NUT
24	1	33004011	TOP IDLER ROLLER	71	4	SSPS98032	PAN HD SLOTTED SCREW
25	1	33004021	HINGE SHAFT	72	4	BBS8703-88	BALL BEARING
26	1	3200127	GUILLOTINE BASE PLATE	73	2	AAEHSKQ	SWITCH, HALL EFFECT
27	1	32004063	REAR CYLINDER MOUNT	74	2	AAFD35875-11	BAND FOR AAHSKQ
28	1	AAFB-11C	PIVOT BRKT	75	1	33004063	SPACER
29	4	AA198RA508	FLOW CONTROL	76	1	273-4-503A	LEATHER WASHER
30	16	WWL1/4	LOCK WASHER	77	1	SSSS98012B	SOCKET SCREW, BRASS TIP
31	1	IID016X064	DOWEL PIN	78	3	SSHC10080	HEX CAP SCREW
32	4	WWSI10	INTERNAL TOOTH WASHER	79	1	NNJ7/16-20	JAM NUT
33	1	33004027A	PLATE, MTG,STEP,MTR	80	3	WWFS5/16	FLAT WASHER
34	1	3200135	BORDER TRANS SUPP.	81	2	SSSC95032	SOCKET CAP SCREW
35	1	33004050	GUILLOTINE TOP GUARD	82	1	BBTRA1220	WASHER, THRUST, STEEL
36	1	33004031	BLADE PRESSURE ADJ SCREW	83	1	3200102	CYLINDER MNT.
37	2	AA198RA408	FLOW CONTROL	84	2	SSSC98064	SOCKET CAP SCREW
38	1	AACM125DP	AIR CYLINDER	85	2	SSSCM4X16	SOCKET CAP SCREW
39	5	SSSC95064	SOCKET CAP SCREW	86	1	3200128	PIVOT BRKT MNT.
40	1	AACTB12110	AIR CYLINDER	87	1	3200138	SPACER
41	2	AA198RA510	FLOW CONTROL	88	1	SSSC40080	SOCKET CAP SCREW
42	2	33004058A	BRACKET	89	1	WWL7/16	LOCK WASHER
43	1	PP24LB050M3	GEAR PULLEY	90	3	WWL5/16	LOCK WASHER
44	1	PP10LF050M3	GEAR PULLEY	91	1	AAC095DP	AIR CYLINDER
45	3	SSFC95032	FLAT ALLEN CAP SCREW	92	2	SSSC01064	SOCKET CAP SCREW
46	3	SSFC98040	FLAT ALLEN CAP SCREW	93	2	SSSC80064	SOCKET CAP SCREW
47	8	SSSC01048	SOCKET CAP SCREW	94	2	SSHC01048	HEX CAP SCREW

32004100PC Primary Gripper Assembly

AAC Drawing Number 9001290 Rev 1



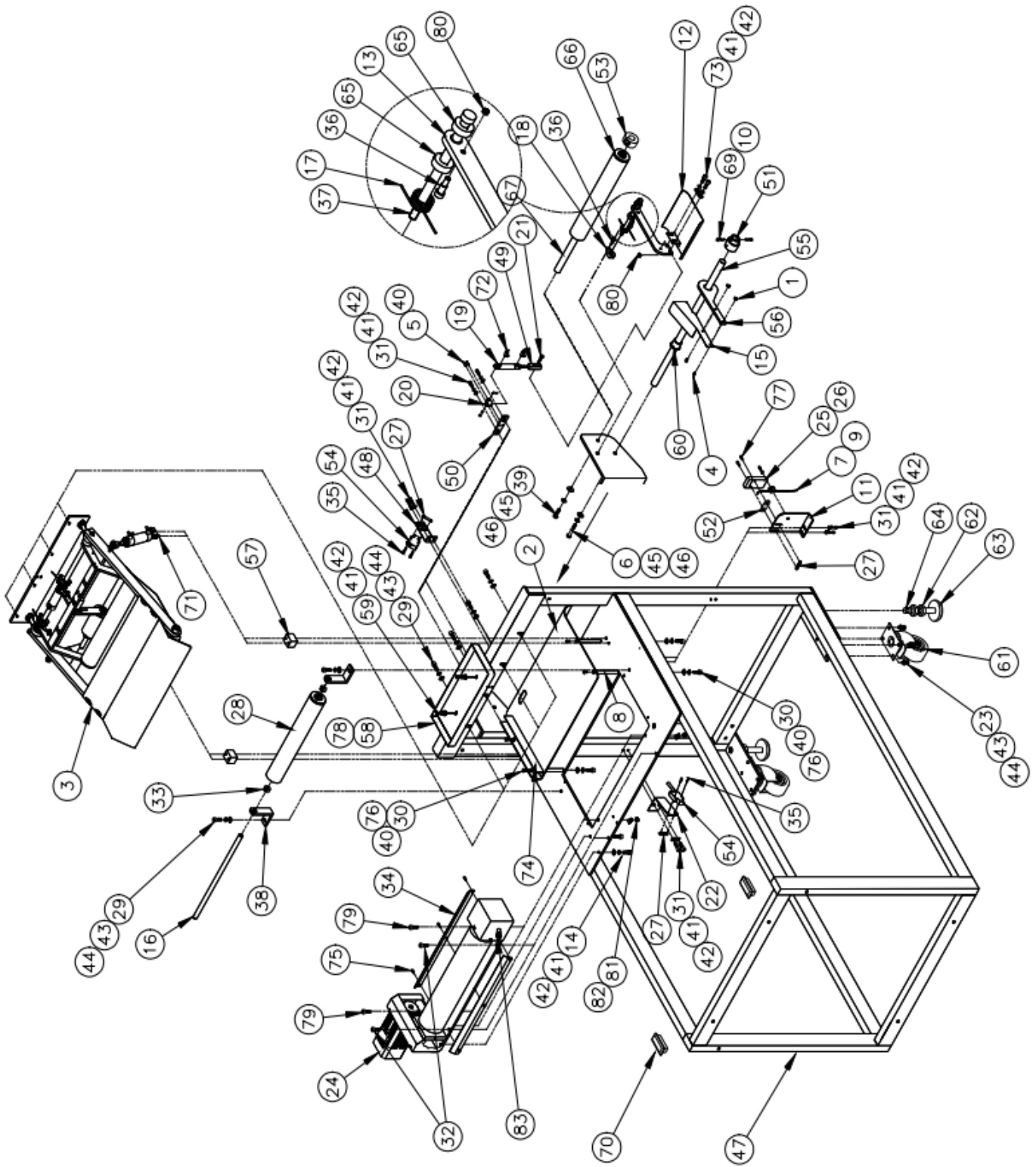
32004100PC parts list

NO.	QTY	PART #	DESCRIPTION
1	1	1510-09	BUMPER
2	1	3300087	BODY,SLIDE
3	1	3300088	PLATE,SUPPORT,ROD
4	1	3300089	BODY,SLIDE
5	1	3300096	MOUNT, PRIMARY GRIPPER
6	1	32004101	CLAMP, PRIM GRIPPER,LOWER
7	1	32004105	BRKT. SIDE MOUNTING
8	1	32004106	CLAMP, PRIM GRIPPER,LOWER
9	1	32004107	GRIPPER PLATE, END
10	1	32004109	MOUNT, PRIMARY GRIP. CYL
11	1	32004112	SPACER, PRIMARY GRIPPER
12	1	32004113	BLOCK, ADAPTOR
13	1	32004114	MOUNT, PRIM GRIP. UPPER
14	1	32004115	GUARD, PRIMARY GRIPPER
15	1	97-6282	NUT,FLOATING COUPLING
16	1	97-6290	NUT, LOCK, 5/8 HEX, 1/4-28
17	2	AA198-2201	FLOW CONTROL, 1/8PTX5/32
18	2	AA198RA508	FLOW CONTROL, 5/32 X 1/8"
19	2	AA198RA510	FLOW CONTROL, 5/32X10-32
20	1	AAC8DP-1.5	CYL, AIR, DA, 9/16B, 2S
21	1	AACM0410DXP	CYLINDER,AIR,3/4 BORE
22	1	AACMGPM2530	CYLINDER,AIR,DUAL ROD

NO.	QTY	PART #	DESCRIPTION
23	1	AAEDY59A-10	SENSOR W/PLUG, SMC
24	1	AAEHSKQ	SWITCH,HALL EFFECT BIMBA
25	1	AAFD35456-6	BAND,04 CYLINDER,HSKQ
26	1	MMAGH25CAN	LINEAR BEARING
27	1	MMAGR25414N	RAIL, LINEAR AG SERIES
28	1	NNH10-32	#10-32 HEX NUT
29	3	SSFC80024	#6-32 X 3/8 FLAT ALLEN
30	4	SSFCM6X12	M6-1.0 X 12 FLAT ALLEN
31	4	SSHC01040	1/4-20 X 5/8 HHCS
32	7	SSHC01048	1/4-20 X 3/4 HEX CAP
33	2	SSHC01080	1/4-20 X 1-1/4 HHCS
34	3	SSHC98032	10-32X1/2 HEX HD
35	2	SSPS98024	10-32X3/8 PAN HD SLOT
36	2	SSSC01040	1/4-20 X 5/8 SOCCAP
37	4	SSSC95024	#10-24 X 3/8 SOCCAP
38	3	SSSC95040	#10-24 5/8 SOCCAP
39	6	SSSCM6X16	M6-1.0 X 16 SOCCAP
40	10	WWFS1/4	WASHER FLAT, 1/4
41	5	WWFS10	WASHER, FLAT, #10, SAE
42	17	WWL1/4	1/4 LW
43	10	WWL10	#10 LW

32005000PA Prefeed Roller Assembly

AAC Drawing Number 192086A Rev 6

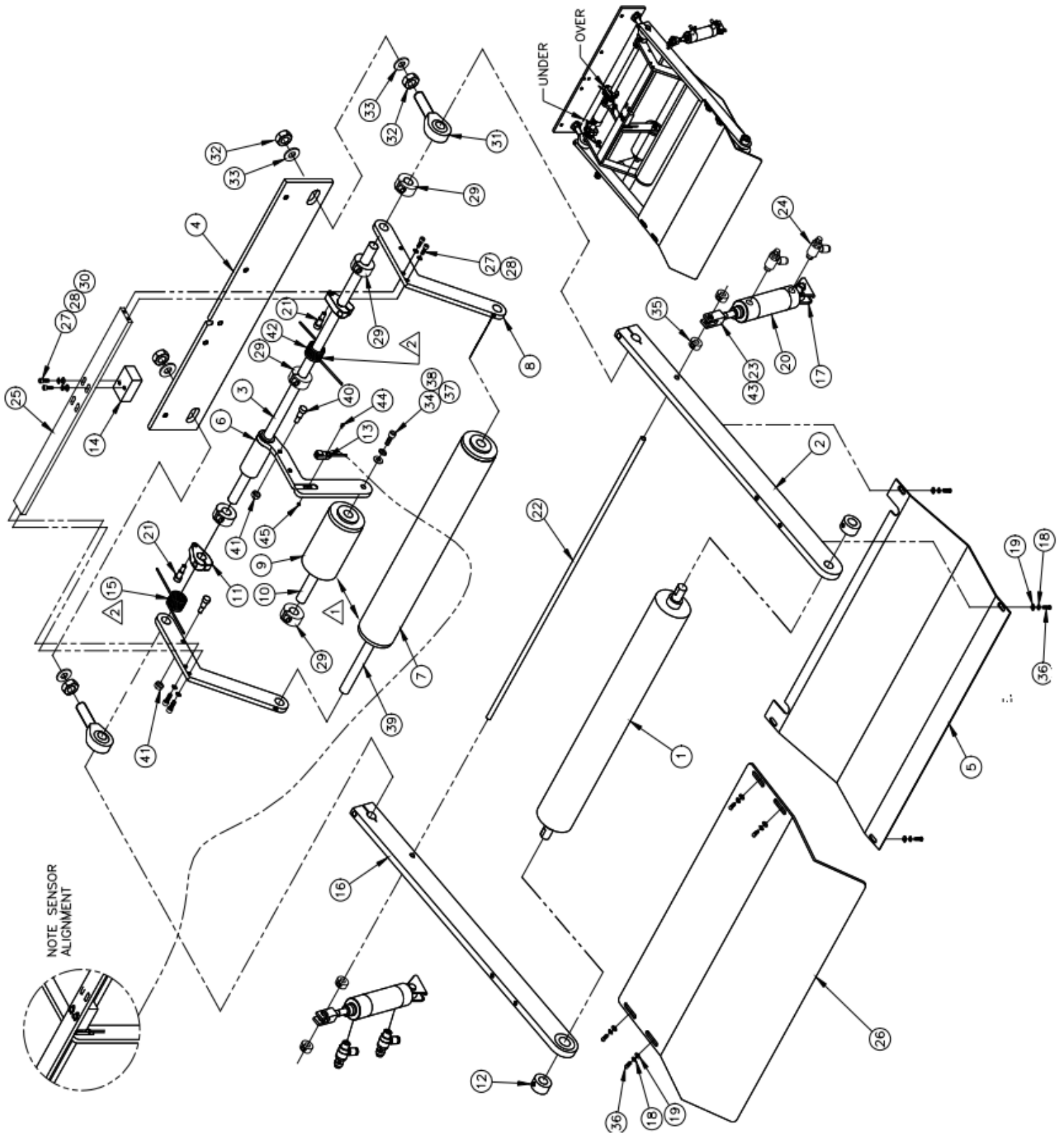


32005000PA parts list

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	2	NNK6-32	NUT, KEP, 6-32, W/L/W	41	14	WWL10	LOCK WASHER
2	1	33005605	PLATE, CLOTH	42	14	WWFS10	SAE FLAT WASHER
3	1	33005600	PREFEED ROLLER ASSY.	43	14	WWL1/4	LOCK WASHER
4	2	SSBC80032	SCREW, BUTTON CAP 6-32 X 1/2	44	14	WWFS1/4	SAE LOCK WASHER
5	2	SSSC90024	SCREW SOCKET CAP 8-32 X 3/8	45	2	WWL3/8	WASHER, LOCK
6	1	SSHC25192	SCREW HEX CAP 3/8-16 X 3.0	46	2	WWF3/8	WASHER, FLAT
7	1	1278-7154A	CLAMP TUBE	47	1	32005500P	F FRAME ASSY
8	4	33005623	STAND OFF	48	1	33005664	BRKT, EYE
9	1	40-609B	UNCURLING TUBE	49	1	33005686	CLEVIS, SKI LIFT
10	2	NINE 10-32	ELASTIC NUT	50	1	33005687	MTG. PLATE
11	1	33005639	BRKT, MARK EYE	51	1	33005656	SLEEVE, CLOTH GUARD
12	1	33005661	SKID PLATE ASSY.	52	1	WW25DW	WASHER PLATE
13	1	33005662	ARM, SKID PLATE	53	1	CCCL12F	CLAMP COLLAR
14	2	SSSC98048	SCREW, SOCKET CAP 10-32 X 3/4	54	2	FFSM312LVQ	ELECTRIC EYE
15	1	33005699	GUIDE, RH	56	1	33005657A	EDGE GUIDE ARM
16	1	33005690	ROD, 1/2 X 17.5L	57	2	33005670	SPACER
17	1	RRLT085N4R	SPRING, TORSION	58	1	33005534	TOOL TRAY
18	1	33005667	CLAMP, SPRING	59	2	SSBC98024	SCREW, BUTTON CAP 10-32 X 3/8
19	1	AAC8DP-1	AIR CYLINDER	60	1	33005679	BUSHING, EDGE GUIDE
20	1	AAFBP-8C	BRKT, PIVOT	61	2	MM431-4	CASTER
21	1	SSAS016040	SCREW, ALLEN SHOULDER 1/4 X 5/8, 10-24	62	4	NNSH5/8-11	5/8-11 NUT
22	1	98202010	EYE BRKT	63	2	MML-2	LEVELING PAD
23	8	SSHC01048	SCREW, HEX CAP 1/4-20 X 3/4	64	2	0411-1063	ROD. HEM FOOT
24	1	33005650A	BOTTOM PULLER ROLLER ASSY.	65	2	CCCL6F	COLLAR, CLAMP 3/8
25	1	V8	LENS	66	1	33005689C	ROLLER
26	1	FFSE3WLC	SMART EYE	67	2	33008202	ROD, 3/4 X 21
27	3	1975-412A	NUT PLATE	69	2	SMSSBNK-2	PLUNGER, BALL
28	1	33005689	ROLLER	70	2	MM132-1496	RECT. END CAP
29	6	SSSC01048	SCREW, SOCKET CAP 1/4-20 X 3/4	71	4	SSS C98096	SCREW, SOCKET CAP 10-32 X 1-1/2
30	6	SSSC90032	SCREW, SOCKET CAP 8-32 X 1/2	72	2	AA198RA510	FLOW CONTROL
31	8	SSSC98032	SCREW, SOCKET CAP 10-32 X 1/2	73	2	SSS C95032	SCREW, SOCKET CAP 10-24 X 1/2
32	2	SSSC98024	SCREW, SOCKET CAP 10-32 X 3/8	74	1	33005683	BORDER GUIDE
33	2	CCCL8F	CLAMP COLLAR	75	6	SSBC90024	SCREW, BOTTOM CAP 8-32 X 3/8
34	2	33005673	BRKT GUARD	76	8	WWF8	FLAT WASHER
35	6	SSPS70048	SCREW, PAN HD SLOTTED 4-40 X 3/4	77	2	SSPS70064	SCREW, PAN HEAD 4-40 X 1
36	2	SSAS016032	SCREW, ALLEN SHOULDER 1/4 X 1/2, 10-24	79	2	SSS C98040	SCREW, SOCKET CAP 10-32 X 5/8
37	1	SSAS024256	SCREW, ALLEN SHOULDER 3/8 X 4, 5/16-19	80	2	NNH10-24	HEX NUT
38	2	33005688	BRACKET	81	2	AAF3/16	PLASTIC CLAMP
39	1	SSHC25064	SCREW, HEX HEAD 3/8-16 X 1	82	2	NNK10-32	KEP NUT
40	8	WWL8	LOCK WASHER	83	1	EE49111AS	SWITCH

3300560 Prefeed Roller Assembly

AAC Drawing Number 192155C Rev 8



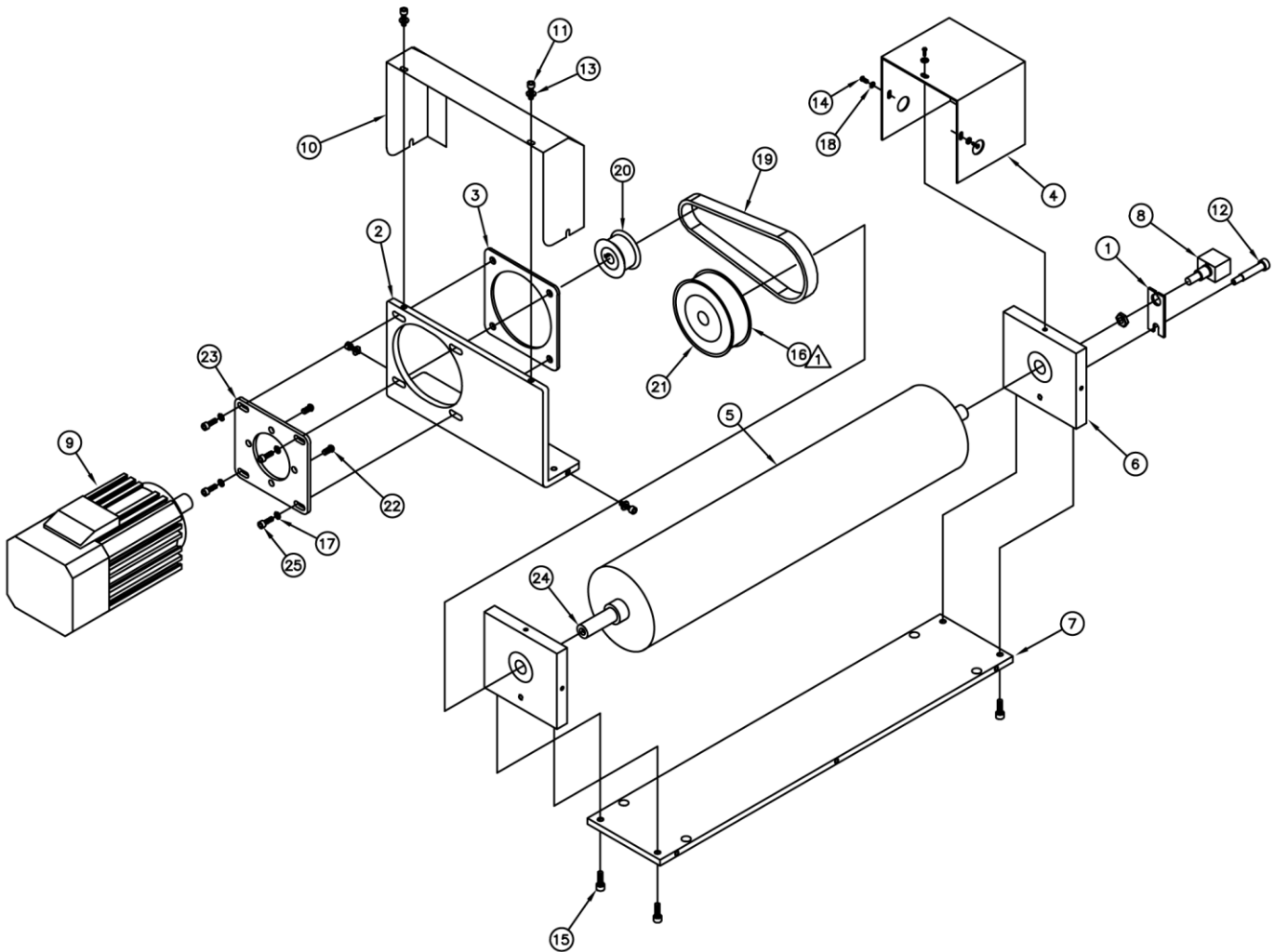
33005600 parts list

NO	QTY	PART #	DESCRIPTION
1	1	33005652	PULLER, ROLLER
2	1	33005610	PULLER, LEFT ARM
3	1	33005611	ROD
4	1	33005617	BAR, PIVOT MTG
5	1	33005622	BRACE, PREFEED
6	1	33005675	ROLLER ARM ASSY
7	1	33005632	ROLLER
8	2	33005653	ARM, SEAM DETECT
9	1	33005671	ROLLER
10	1	33005672	ROD, ROLLER
11	2	33005678	CLAMP SPRING
12	2	33005676	SET COLLAR
13	1	1278-5075D	PROX SWITCH
14	1	33005669	TARGET BLOCK
15	1	RRLT085R4L	SPRING, TORSION LEFT
16	1	33005628	PULLER, RIGHT ARM
17	2	AAFBP-11C	BRKT, PIVOT
18	8	WWL10	LOCK WASHER
19	8	WWFS10	SAE FLAT WASHER
20	2	AA66DP-1	AIR CYLINDER
21	3	SSASO16024	SCREW ALLEN SHOULDER 1/4 X 3/8, 10-24
22	1	33005677	ROD
23	2	AAFCT-11	CLEVIS

NO	QTY	PART #	DESCRIPTION
24	4	AA198RA508	FLOW CONTROL
25	1	33005654	BRACE, TARGET ADJ.
26	1	33005633	COVER
27	6	SSSC90040	SCREW, SOCKET CAP 8-32 X 5/8
28	6	WWL8	LOCK WASHER
29	5	CCCL8F	CLAMP COLLAR
30	2	WWF8	FLAT WASHER
31	2	1325-11	BEARING, ROD END
32	4	NNJ1/2-20	JAM NUT
33	4	WWF1/2	FLAT WASHER
34	1	SSSC01048	SCREW, SOCKET CAP 1/4-20 X 3/4
35	4	CCCL4F	COLLAR, CLAMP
36	8	SSHC95032	SCREW, HEX CAP 10-24 X 1/2
37	1	WWFS1/4	SAE FLAT WASHER
38	1	WWL14	LOCK WASHER
39	1	33005655	ROD
40	1	SSASO16040	SCREW, ALLEN SHOULDER 1/4 X 5/8, 10-24
41	2	NNH10-24	NUT, HEX 10-24
42	1	PRLT085M4R	SPRING, TORSION RIGHT
43	1	NNJ5/16-24	NUT, JAM, 5/16-24
44	1	SSPS50032	SCREW, PAN HD SLOTTED 2-56X1/2
45	1	NNH2-56	NUT, HEX, 2-56

33005650A Bottom Puller Roller Assembly

AAC Drawing Number 192913B Rev 3

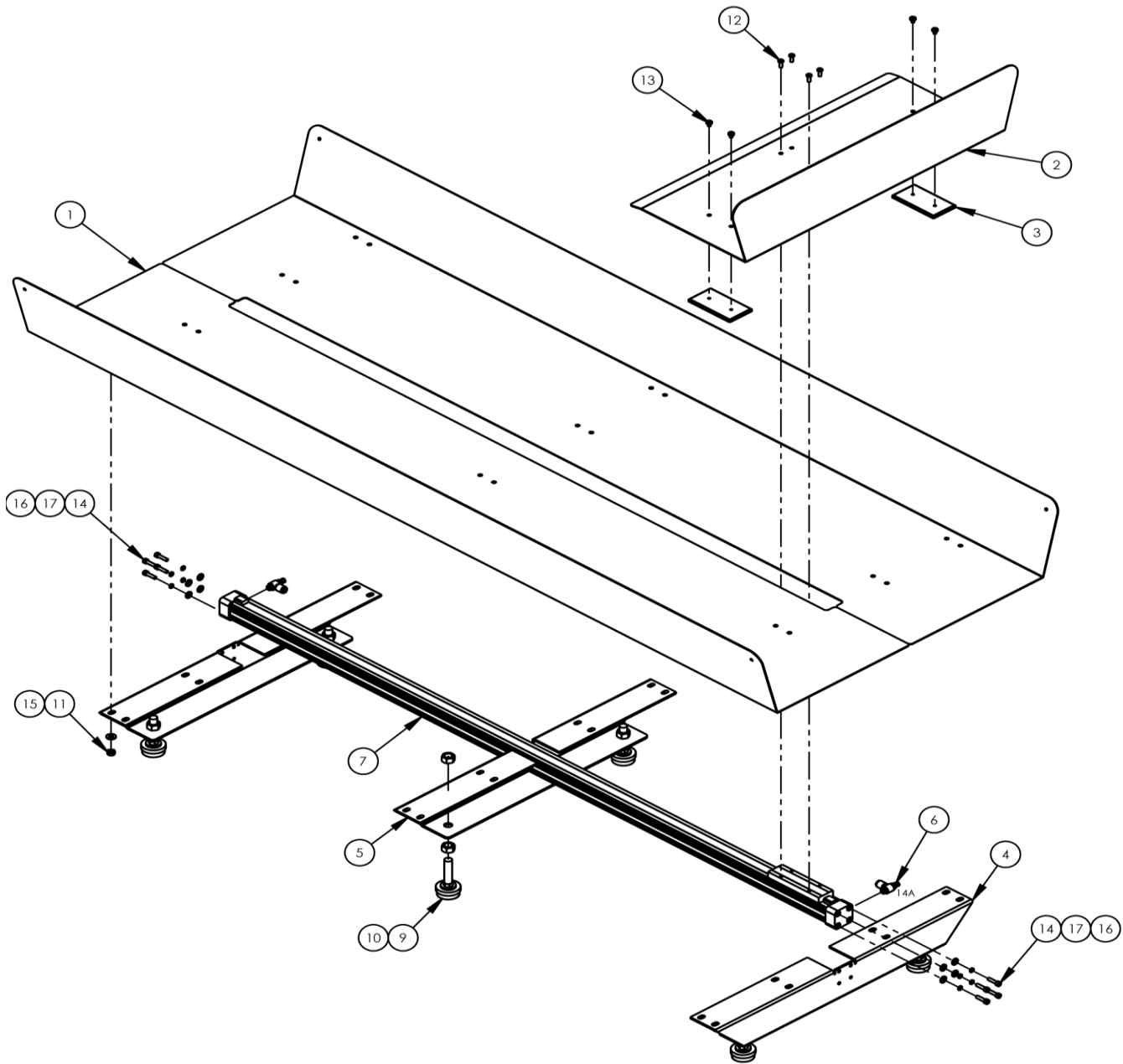


NO	QTY	PART #	DESCRIPTION
1	1	33004080	BRKT, ENCODER SUPPORT
2	1	33005674	BRKT, MOTOR MOUNTING
3	1	0411-016	NUT PLATE
4	1	33005681	GUARD, ENCODER
5	1	33005603C	PULLER ROLLER
6	2	33005608	BLOCK BEARING
7	1	33005609	PATE, BEARING MTG
8	1	EENC256	ENCODER
9	1	4059-DC1500A	STEPPER MOTOR
10	1	33005692	BELT GUARD
11	4	SSSC70024	SCREW, SOCKET CAP 4-40 X 3/8
12	1	SSASO16064	SCREW, ALLEN SHOULDER 1/4 X 1, 10-24
13	4	WWF4	WASHER, FLAT

NO	QTY	PART #	DESCRIPTION
14	3	SSBC80024	SCREW BUTTON CAP 6-32 X 3/8
15	4	SSSC98032	SCREW, SOCKET CAP 10-32 X 1/2
16	2	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1
17	4	WWFS10	WASHER FLAT
18	3	WWFS6	SAE FLAT WASHER
19	1	GG142L050	BELT
20	1	PP10LF050M3	PULLEY, 10T
21	1	PP24LB050M1	PULLEY, 24T
22	4	SSSCM5X14	SCREW, SOCKET CAP M5-08 X 14
23	1	4059-3200	PLATE, CONVERSION
24	1	330056003C2	SHAFT, ROLLER
25	4	SSSC98040	SCREW, SOCKET CAP 10-32 X 5/8

32007300 Indexing Tray Assembly

AAC Drawing Number 9002178 Rev 5

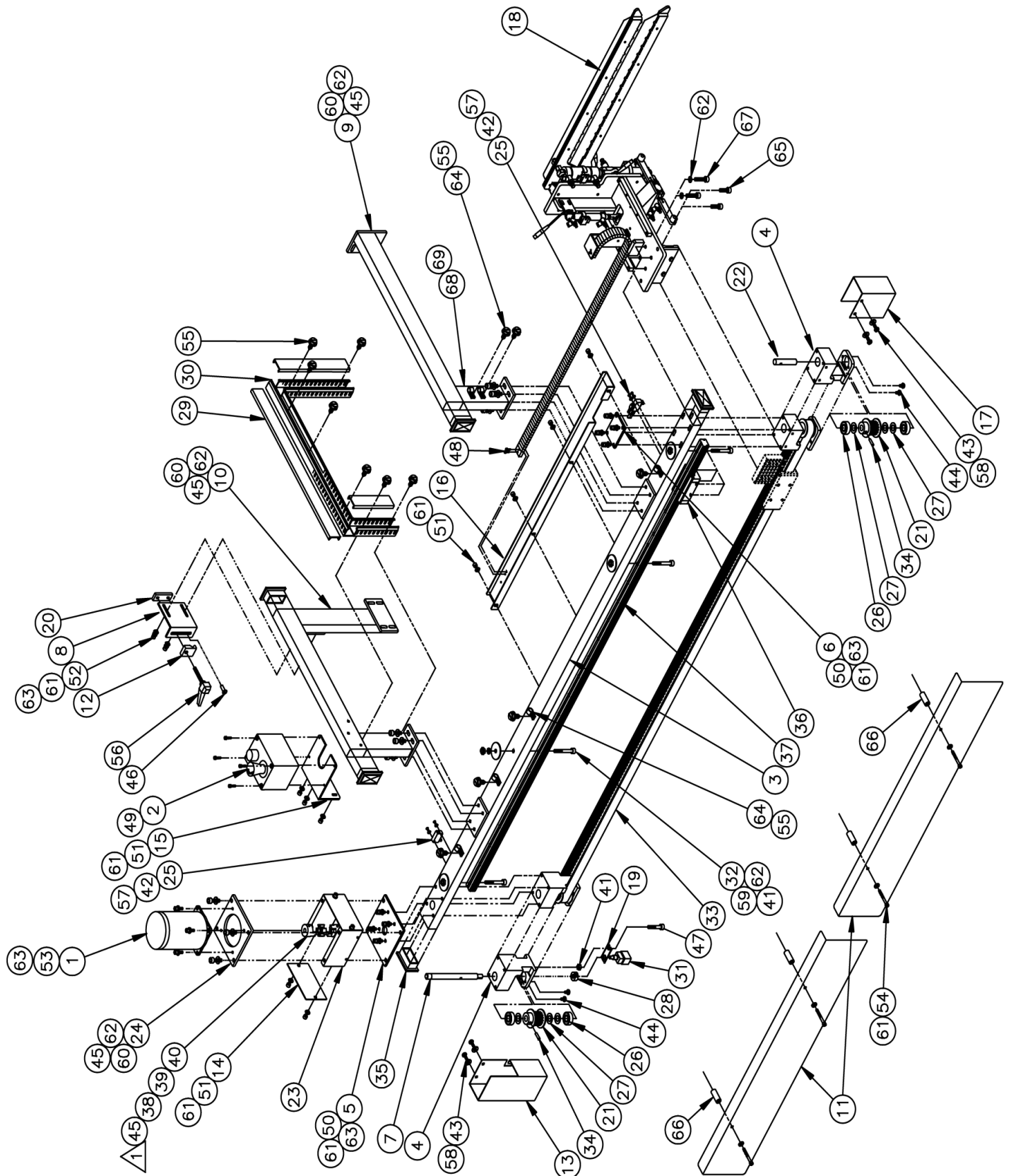


NO.	QTY	PART#	DESCRIPTION
1	2	32007301	TRAY, INDEXING
2	1	32007302	PUSHER, INDEXER
3	2	32007303	WEAR PAD
4	2	32007306	MOUNT, END, FOOT
5	1	32007307	MOUNT, CENTER, FOOT
6	2	AA198RA408U	FLOW CONTROL, RC 1/8X1/4
7	1	AACSRLM048	CYLINDER, AIR, RODLESS, 48ST
8	*18 FT	MM100-1/8	DOOR TRIM - BLACK
9	6	MMFB4444	FOOT, RUBBER

NO.	QTY	PART#	DESCRIPTION
10	12	NNH1/2-13	NUT, HEX, 1/2-13
11	24	NNK1/4-20	NUT, HEX, KEP, 1/4-20, W/LOCK
12	4	SSBC98032	10-32 X 1/2 BUTTON CAP SC
13	4	SSPS95016	10-24 X 1/4, SLOT CAP SCREW
14	8	SSSCM5X20	M5-0.8X20, SCREW, SOCKET CA
15	24	WWFS1/4	WASHER, FLAT, SAE, 1/4
16	8	WWFS10	WASHER, FLAT, #10, SAE
17	8	WWL10	WASHER, LOCK, #10

32007600P Transport Assembly

AAC Drawing Number 192087A Rev 6



32007600P parts list

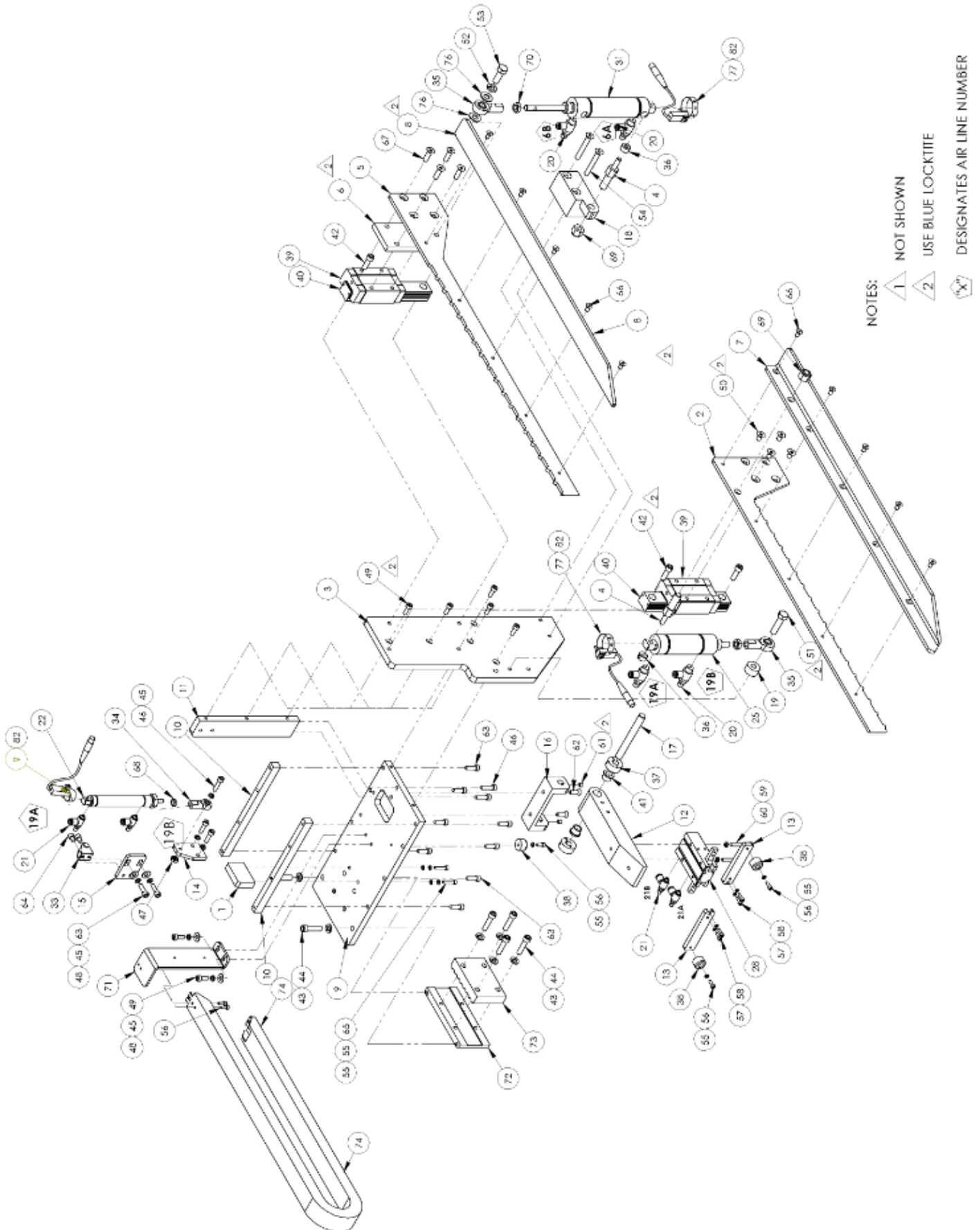
NO.	QTY	PART #	DESCRIPTION
1	1	011-020	Stepper Motor
2	1	1278-6010A	Start/Stop Button
3	1	32007602	Rail Mount Weldment
4	2	32007605	Pulley Brkt
5	1	32007607	Motor Mnt Brkt
6	1	32007610	Backing Plate
7	1	32007615	Drive Shaft
8	1	32006518	Edge Guide Clamp
9	1	4300342	Carriage Mount
10	1	32007628A	Carriage Mount
11	2	32007660	Belt Guard
12	1	32006534	Edge Guide Clamp
13	1	32007645	Encoder Cover
14	2	32007646	Coupling Cover
15	1	32007654	Start/Stop Button Mnt
16	1	32007656	Cable Track Tray
17	1	32007658	Pulley Cover
18	1	32007800A	Secondary Clamp
19	1	33004080	Encoder Support Brkt
20	1	84-4005	Nut Plate
21	2	98203012	Pulley
22	1	98203013	Idler Pulley Shaft
23	2	98203015A	Motor Mount

NO.	QTY	PART #	DESCRIPTION
24	1	98203024	Motor Mount Plate
25	2	A-2014-39	Micro Switch
26	4	BB1L005	Ball Bearing
27	6	BBTRA815	Thrust Washer
28	1	CCCL6F	Clamp Collar
29	3'	EEDC1LG	Wire Duct Cover
30	3'	EEDF1X1	Wire Duct
31	1	EENC256	Encoder
32	4	SSSC01112	1/4-20X 1-3/4
33	1	GG1252L100ST	Gear Belt
34	2	IIS012X064	Spring Pin
35	5	MM132-1496	End Cap
36	1	MMAGH25CAN	Bearing Block
37	1	MMAGR251430N	Linear Rail
38	1	MML050	Spider
39	1	MML050-375	Coupling, 3/8
40	1	MML050-500	Coupling, 1/2
41	5	NNH1/4-20	Hex Nut
42	4	SSPS70048	Screw, Pan Head
43	4	SSPS90024	Screw, Pan Head
44	4	SSPS95016	Screw, Pan Head
45	16	SSSC01048	Screw, Socket Cap
46	1	SSBC01032	Screw, Button Cap

NO.	QTY	PART #	DESCRIPTION
47	1	SSSC01096	Screw, Socket Cap
48	2	SSSC80024	Screw, Socket Cap
49	4	SSSC90040	Screw, Socket Cap
50	8	SSSC95112	Screw, Socket Cap
51	11	SSSC98024	Screw, Socket Cap
52	2	SSSC98032	Screw, Socket Cap
53	4	SSSC98048	Screw, Socket Cap
54	4	SSSC98112	Screw, Socket Cap
55	13	SSZS93032	Screw, Sheet Metal
56	1	TTH32415	Threaded Handle
57	4	WWF4	Flat Washer
58	4	WWF8	Flat Washer
59	4	WWFE016	Fender Washer
60	12	WWFS1/4	Flat Washer
61	25	WWFS10	Flat Washer
62	16	WWL1/4	Lock Washer
63	14	WWL10	Lock Washer
64	6	AAF3/16	Plastic Clamp
65	2	SSFCM6X10	Screw, Flat Allen
66	4	32007661	Spacer
67	2	SSSCM6X20	Screw, Socket Cap
68	1	3200101	Carriage Mount Weldment
69	1	3200095	Nut Plate

32007800A Secondary Gripper Assembly

AAC Drawing Number 9002088 Rev 5



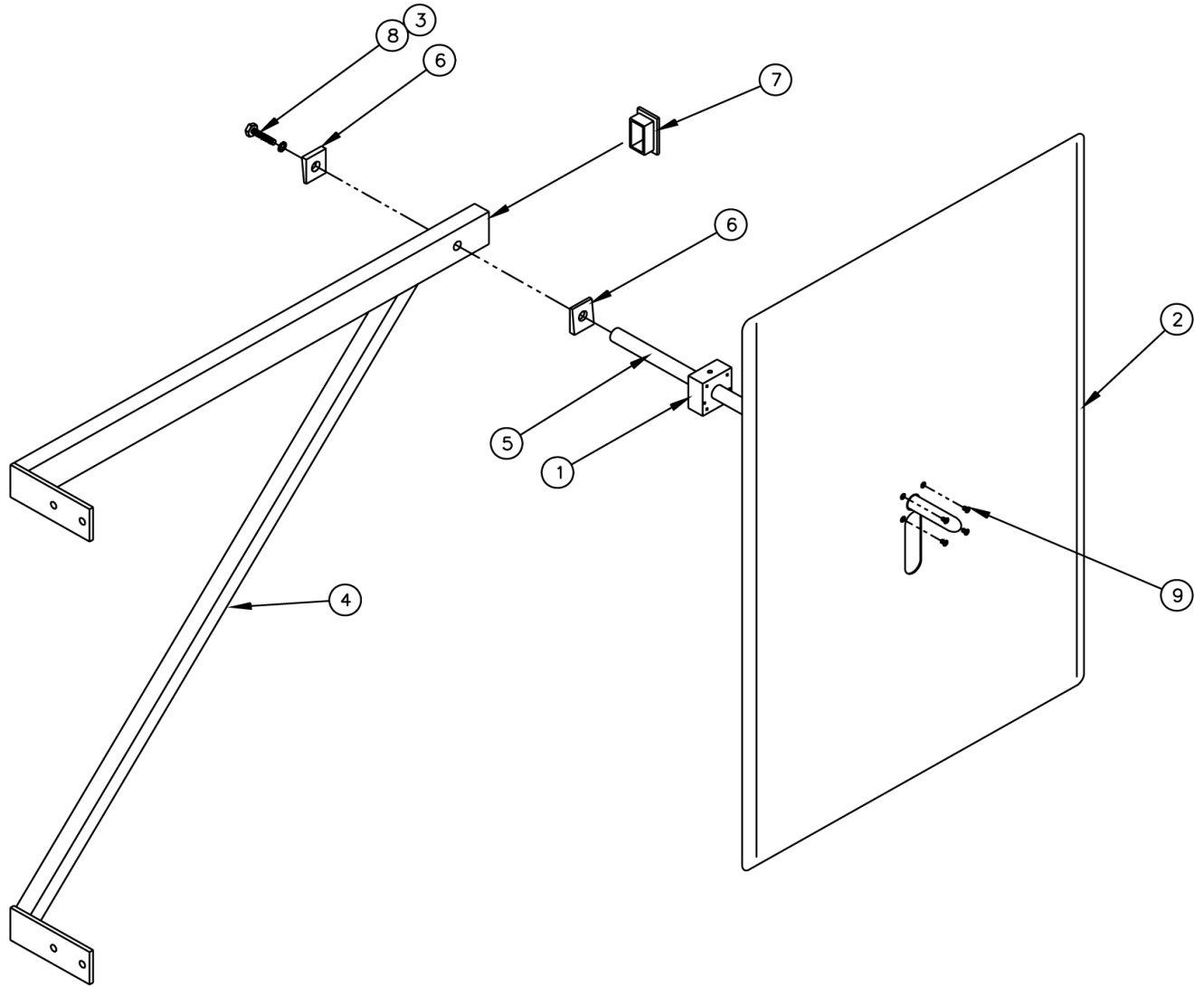
- NOTES:
- △ 1 NOT SHOWN
 - △ 2 USE BLUE LOCKTITE
 - ⊗ DESIGNATES AIR LINE NUMBER

32007800A parts list

ITEM NO.	QTY	PART NUMBER	DESCRIPTION	ITEM NO.	QTY	PART NUMBER	DESCRIPTION	ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	32007611	BELT HOLDER	25	1	AACM091DX	CYLINDER, 1 1/16B, 1"S, DXM	49	4	SSFCM6X20	M6 X 20 FLAT ALLEN
2	1	32007622	FLAG, CRASH SWITCH	26	1	AACM092DX	CYLINDER, 1 1/16B, 2"S, D	50	1	SSHC10080	HEX HEAD, 5/16-18 X 1-1/4
3	1	32007657	MOUNT, CABLE TRACK	27	1	AACMHY-16D	GRIPPER CYL, 180DEG, 16MM	51	1	SSHC20056	5/16-24 X 7/8 HEX CAP
4	1	32007801	TOP CLAMP MTG PLT.	28	3	AAEHSKQ	SWITCH, HALL EFFECT(SMC)	52	4	SSSC01048	1/4-20 X 3/4" SOC CAP SC
5	1	32007802	MAIN MTG PLATE	29	1	AAFBP-8C	BRKT, PIVOT, 5/32 BORE	53	6	SSSC01064	1/4-20 X 1 SOC CAP
6	2	32007804	STUD, CLAMP CYLINDER	30	3	AAFD35000	BAND, UNIVERSAL, AAHHSKQ	54	5	SSSC80024	6-32 X 3/8 SOC CAP SC
7	1	32007805	BOTTOM CLAMP MTG PLT.	31	1	BBAW-3Z	BRG, ROD END, F, 10-32	55	2	SSSC80048	6-32 X 3/4 SOC CAP SC
8	1	32007806	SPACER BOTTOM CLAMP	32	2	BBAW-5Z	ROD END, SPHERICAL .5/16ID	56	2	SSSC90080	#8-32 X 1-1/4 SOC CAP SC
9	1	32007807	CLAMP, UPPER PRIMARY	33	2	CCCL6F	CLAMP COLLAR- 3/8	57	2	SSSC98016	10-32 X 1/4 SOC CAP
10	1	32007808	CLAMP, LOWER PRIMARY	34	2	CCSC41/4	COLLAR, SET 1/4"	58	7	SSSC98032	10-32X1/2, SOC CAP
11	1	32007810	BASE PLATE, CLAMP ASSY	35	1	MM18222844	DUCT, WIRE MICROTRAK	59	12	SSSC98040	10-32 X 5/8 SOC CAP
12	2	32007811	RAIL, PLATE STIFFNER	36	3	MM9540K53	BUMPER, 3/4 DIA	60	3	SSSC98048	10-32 X 3/4 SOC CAP
13	1	32007812	GUSSET, MTG PLATE	37	2	MMEGH25CA	LINEAR BEARING	61	4	SSSCM3X10	M3-0.5X10, SOCKET CAP
14	1	32007815	GRIPPER PIVOT PLT	38	2	MMEGR25R0139C	RAIL LINEAR AG	62	2	SSSS98016	SCREW, SKT SET, FLAT POINT
15	2	32007816	GRIPPER JAW	39	1	MMCPL100	BELT CLAMP	63	2	UUFF520-10	BRG, BRONZE, .3765ID
16	1	32007819	CLAMP PIVOT CYL, ROD PLT	40	*24"	MMLSSB01210	FOAM, URETHANE, 1/8X1	64	4	WWF10	WASHER, FLAT, #10, COM
17	1	32007820	PIVOT CYL, MTG PLT	41	2	NEE3/8-16	NUT, ELASTIC 3/8-16	65	2	WWF55/16	WASHER, FLAT, SAE, 5/16
18	1	32007821	PIVOT YOKE	42	1	NNJ10-32	NUT, JAM, THIN #10-32	66	6	WWL1/4	WASHER, LOCK, 1/4
19	1	32007822	PIVOT SHAFT	43	2	NNJ5/16-24	NUT, JAM, 5/16-24	67	9	WWL10	WASHER, LOCK, #10
20	1	32007828	BOTTOM CLAMP CYL, MTG, PL	44	1	NNK10-32	KEP NUT, 10-32	68	4	WWL4	WASHER, LOCK, #4
21	1	32007829	SPACER, CYL MNT	45	2	SSFC01112	1/4-20 X 1-3/4 FLAT CAP	69	1	WWL5/16	WASHER, LOCK, 5/16
22	4	AA198RA508	FLOW CONTROL, 5/32 X 1/8"	46	10	SSFC98024	#10-32 X .375 FLAT CAP	70	7	WWL6	WASHER, LOCK, #6
23	4	AA198RA510	FL CONT, 5/32X10-32	47	2	SSFC98040	#10-32 X 5/8 FLAT ALLEN	71	2	WWL8	WASHER, LOCK, #8
24	1	AACM022DXP	CYLINDER, 9/16B, 2S, MAGNETIC	48	4	SSFCM6X10	SCREW, FLAT ALLEN CAP				

32007700P Roll Holder Assembly

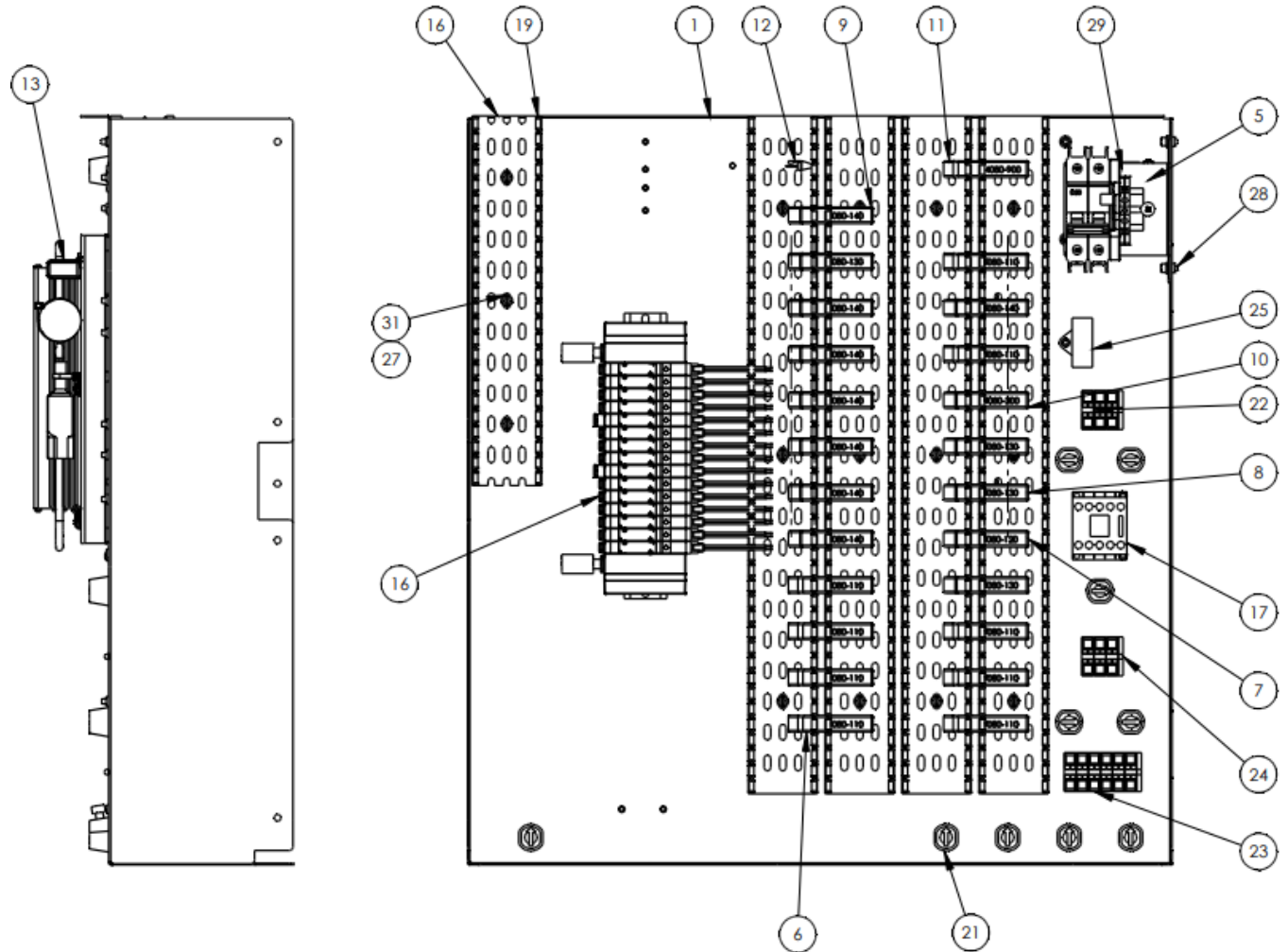
AAC Drawing Number 192088A Rev 1



NO.	QTY	PART #	DESCRIPTION
1	1	1961-253A	Unwind Hub
2	1	784B-2436	Alu Plate
3	1	WWL3/8	Lock Washer
4	1	32007704	Frame
5	1	33008202	Rod, 3/4 x 21
6	2	WWSQ080B	Square Washer
7	1	MM132-1496	End Cap
8	1	SSH25160	Screw, Hex Cap
9	4	SSFC80032	Screw, Flat Allen

32009000PCA Control System

AAC Drawing Number 90071466 Rev 1

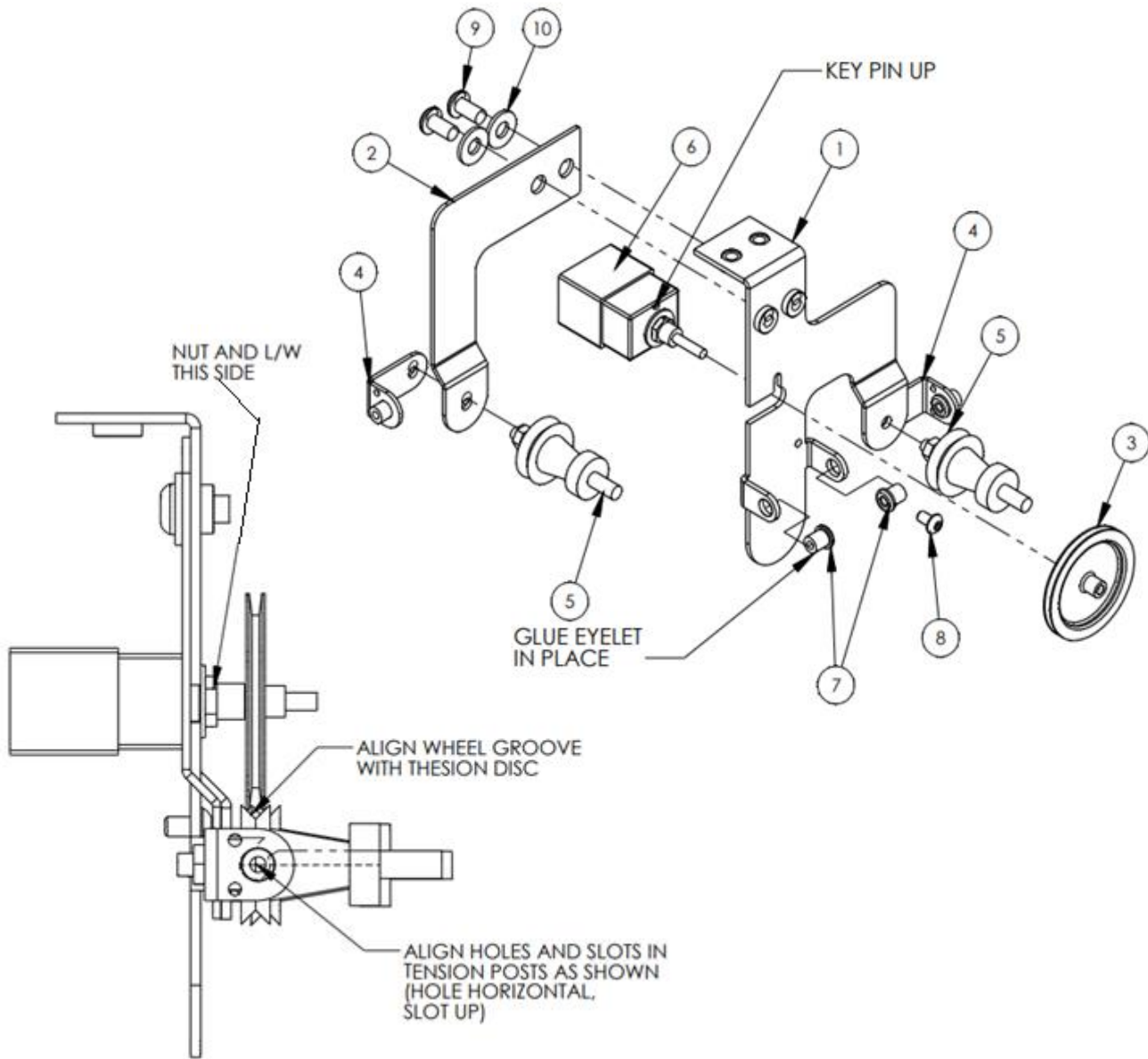


TEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	32009001A	PANEL,CONTROL
2	1	32009100PCA	CABLE PACKAGE
3	1	3200PC-PD	PNEUMATIC DIAGRAM
4	1	3200PCA-WD	WIRING DIAGRAM
5	1	40-320	BREAKER, MAIN PWR, 2P, 20A, WITH
6	9	4080-110	MODULE,QUAD INPUT
7	1	4080-120	MODULE,SBUS, DUAL OPTO-ISO, INPT
8	4	4080-130	MODULE,QUAD OPTO-ISO
9	8	4080-140	MODULE,QUAD OUTPUT
10	1	4080-200	MODULE,AIR PRESSURE
11	1	4080-900	SBUS MODULE, USB GATEWAY, INTERFACE
12	1	4080-940	MODULE,TERMINATOR
13	1	4080-990R	POWER SUPPLY,SBUS,CLASS 2
14	1	4082000-24	CABLE, SPLITTER, EXTENSION, 2P FM
15	1	4082001-84	CABLE, EXTENSION, 2P FM, 2P M, 7'
16	1	AAE3200P-15	SOLENOID ASSY,14 STATION

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
17	1	EECA491024	CONTACTOR, MINI, 240V
18	9'	EEDC2X2	COVER,WIRE DUCT
19	9'	EEDF2X2	DUCT,WIRE,2X2, MOD
20	1	EEUSBAMUSBCM6	USB-A M TO USB-C CABLE M, 6'
21	11	FF1724	STRAIN RELIEF
22	8	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
23	4	FF264-347	TERMBLK,WAGO,TOP,DUAL,GRN
24	3	FF264-371	TERMBLK,WAGO,TOP,END
25	1	FFRAV781BW	MODULE, TVS, 240 VAC
26	1	NNK8-32	NUT,KEP,8-32
27	18	SSPS90024	SCREW, #8-32 X 3/8 LG PAN HD
28	7	SSSC90024S	#8-32 X 3/8 SOC CAP SC
29	1	TT5811	TERMINAL,RING,#10 STUD
30	2	TTAA5267	TERMINAL, FE,INS,18-22
31	21	WWF8	WASHER, FLAT, #8

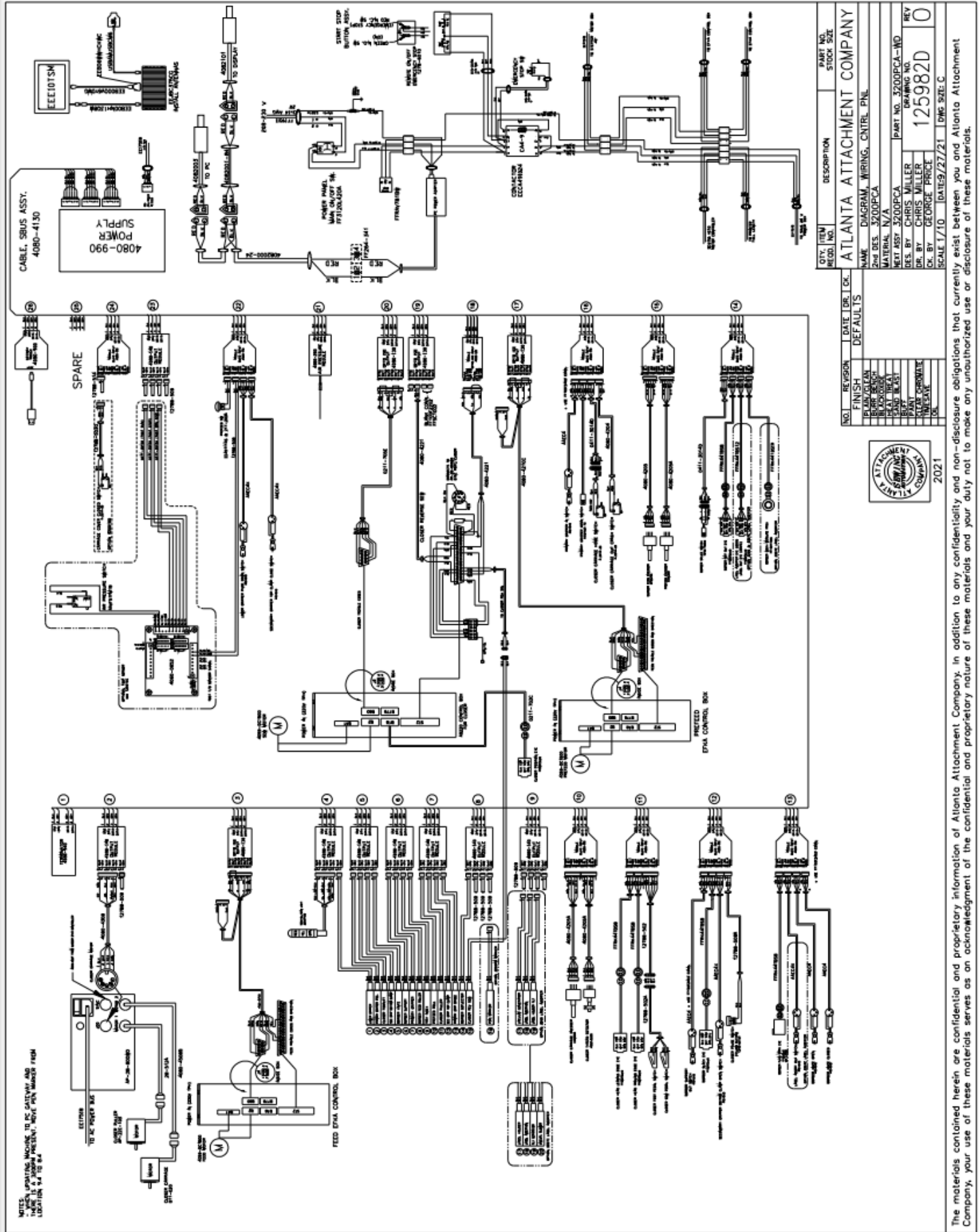
4003-500B Thread Break Sensor Assembly

AAC Drawing Number 9002422 Rev 4



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	4003-501A	BRACKET,ENCODER MOUNT
2	1	4003-501B	BRKT,AUX TENSION SPRING
3	1	4003-502A	WHEEL,THREAD SENSOR
4	2	4003-504	THREAD GUIDE, IN/OUT
5	2	4003-BYW2	THREAD TENSION, EYELET
6	1	EENC025	ENCODER,SBUS,025,1/8
7	2	MMKC34	CERAMIC EYELET FOR THREAD
8	1	SSBC80012	BHCS #6-32X..25L
9	2	SSBC98024	10-32 X 3/8 BUTTON CAP SC
10	2	WWFS10	WASHER, FLAT, #10, SAE

3200PCA-WD Wiring Diagram, Control Panel.



QTY.	ITEM NO.	DESCRIPTION	PART NO.	STOCK SIZE
		ATLANTA ATTACHMENT COMPANY		
		NAME: DIAGRAM, WIRING, CNTRL. PNL.		
		2nd DES. 3200PCA		
		MATERIAL: N/A		
		NEXT ASSY: 3200PCA		
		DES. BY: CHRIS MILLER		
		DR. BY: CHRIS MILLER		
		CHK. BY: GEORGE PRICE		
		SCALE: 1/10		
		DATE: 9/27/21		
		DWS: SIZE: C		
		PART NO. 3200PCA-WD		
		DRAWING NO. 125982D		
		REV. 0		

NO.	REVISION	DATE	DR.	CHK.
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Notes:

Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libres de defectos de material y de mano de obra durante un periodo de ochocientos (800) horas de operación o cien (100) días cual llegue primero. Atlanta Attachment Company garantiza que todos los componentes del Serial bus son libres de defectos de material y de mano de obra durante un periodo de treinta y seis (36) meses.

Términos y Condiciones:

- La Garantía Limitada de AAC entra en efecto el día de transporte.
- Reclamos de la Garantía de AAC pueden ser realizados por teléfono, carta, fax o correo electrónico. Todo reclamo verbal tiene que ser confirmado vía escrito.
- AAC reserva el derecho para exigir el retorno de cada pieza defectuosa con un formulario de reclamo de garantía.
- AAC va, según su criterio, reparar o reemplazar las máquinas o piezas defectuosas devueltas para AAC.
- AAC reserva el derecho para tomar la decisión final sobre toda cuestión de garantía.
- Las garantías de AAC tiene una validez de ochocientas (800) horas o cien (100) días cual llega primero.
- AAC garantiza la operación satisfactoria de sus máquinas en base de las normas aceptadas de la industria siempre y cuando se instale use y mantenga de forma apropiada.
- La garantía de AAC no puede ser cambiado o modificado y no está sujeto a cualquier otra garantía implicado por otro agente o distribuidor menos al menos que sea autorizado por AAC antes de cualquier reclamo.

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

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



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