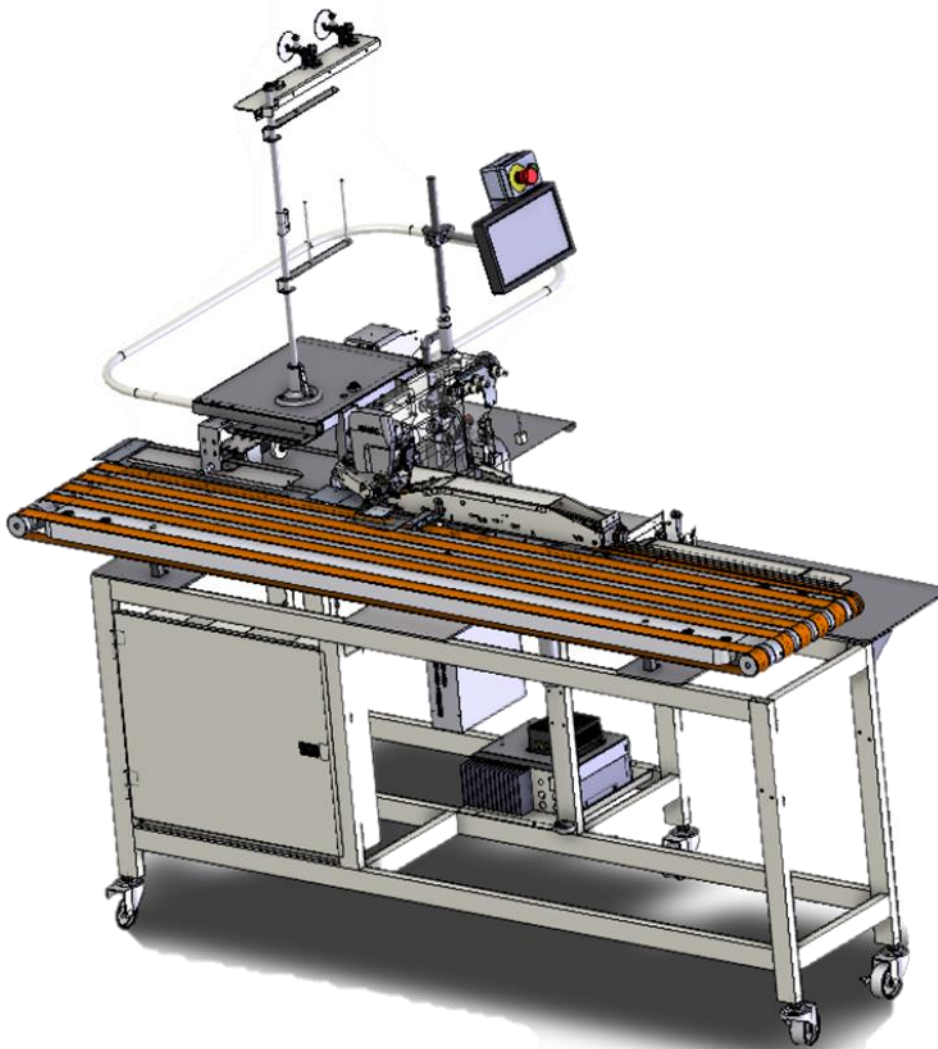




Model **211-ESE**

Rev 2.2 Updated February 13, 2024(wr)

Parts Manual



Atlanta Attachment Company

362 Industrial Park Drive

Lawrenceville, GA 30046

770-963-7369 • www.atlatt.com

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IMPORTANT

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

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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 211ESE Hemmer 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 Parts Material comprises:
- Safety information
- Electrical and Pneumatic diagrams

And may also include.

- A list of recommended spare parts

Intended Use

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

Exclusion of Misuse



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

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

Liability

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

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

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

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

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

Choice and Qualification of Personnel

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

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

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines



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

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

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

Damage

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

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

Faults or Errors

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

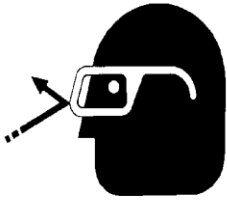
Signs on the Machine

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

Clothing, Jewelry, Protective Equipment

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

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

The following fire extinguishers may be used:

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

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

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

Electrical Power Supply



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

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

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

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

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.
- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected, and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise, the machine may execute uncontrolled movements.

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

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

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

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

Workplace Environment

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

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

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

Protect against unauthorized access.

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

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

Local Regulations

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

Maintenance

General Safety Instructions

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

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

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

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

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

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

Repair

Replacement Parts

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

Repair, Electrical

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

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

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

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

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

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

Ventilation/Hazardous Gases

It is the end 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 to these regulations and/or the EC Directive on the safety of machines.

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

Safety Precautions

Safety should be a constant concern for everyone. Always be careful when working with this equipment. While normal safety precautions were taken in the design and manufacture of this equipment, there are some potential safety hazards.

Everyone involved with the operation and maintenance of this equipment should read and follow the instructions in this manual.

Operate the equipment only as stated in this manual. Incorrect use could cause damage to the equipment or personal injury.

It is the owner's responsibility to make certain that the operator reads and understands this manual before operating this equipment. It is also the owner's responsibility to make certain that the operator is a qualified and physically able individual, properly trained in the operation of this equipment.

Specific safety warning decals are located on the equipment near the immediate areas of potential hazards. These decals should not be removed or obliterated. Replace them if they become non-readable.

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

Description

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

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

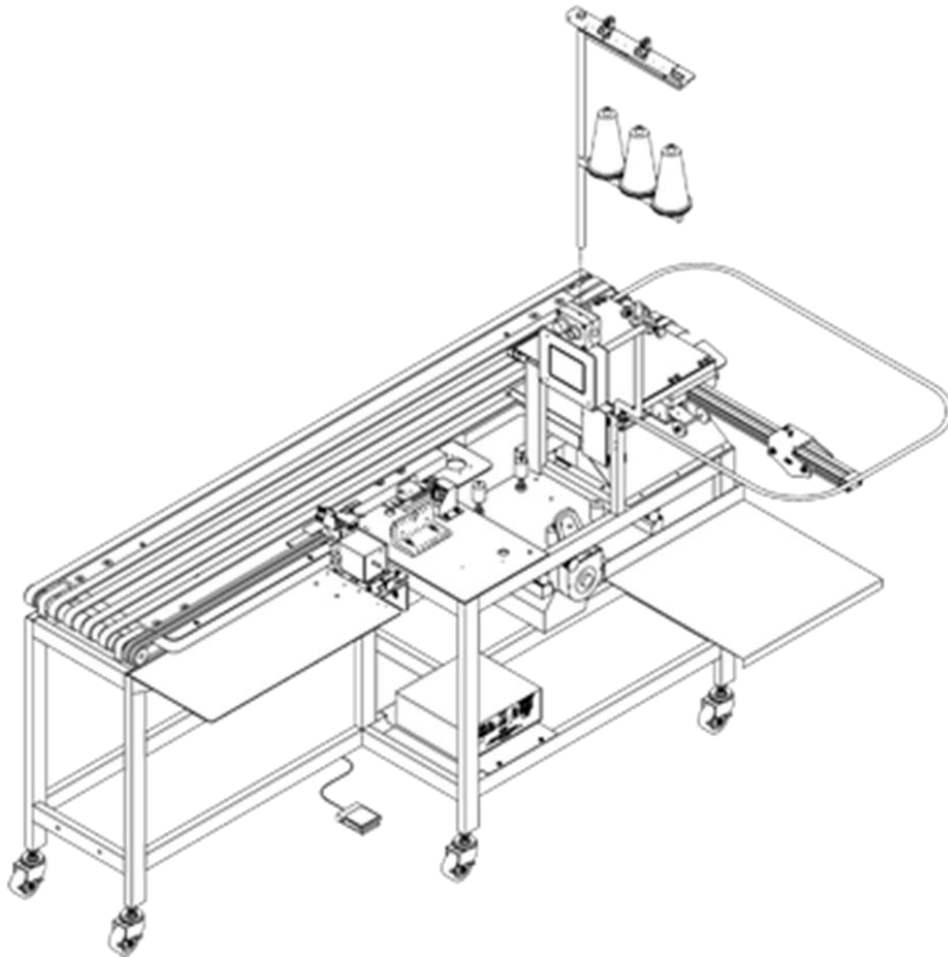
The modular design of AAC's Two Needle Hemmer allows the flexibility of picking the combination of components to design a custom system best suited to the need.

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

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

CAUTION:

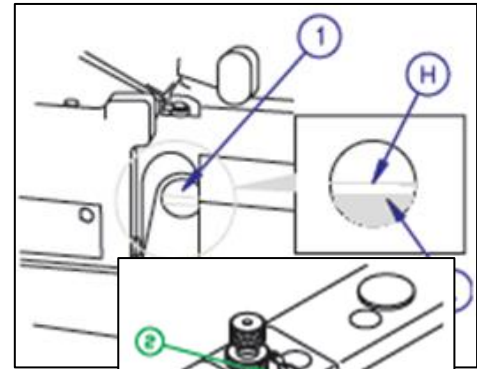
There are cloth and thread trimming knives on this piece of equipment. These knives cut automatically. **DO NOT** put fingers or hands in or around these knives. All adjustments made to the Sewing machine head or knives should be made with power "OFF".



Sewing Head Maintenance

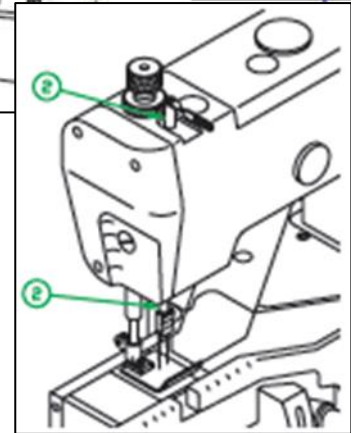
1. Oil Level

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



2. Manual Oiling

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



3. Oil Change

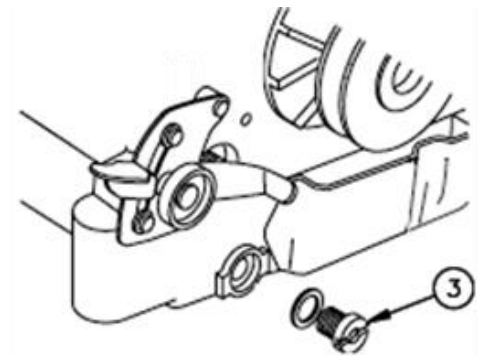
Change oil after the first month in operation. After that, change oil every 6 months.

Note:

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

4. To Drain Oil

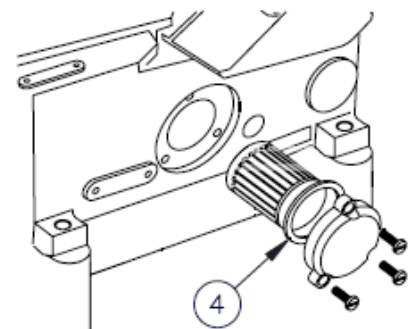
Take out drain plug (item 3) and drain oil from here.



5. Checking and Replacing Oil Filter

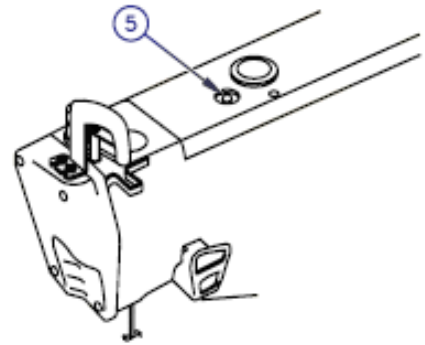
If oil filter (item 4) is clogged, normal lubrication cannot occur.

Check and clean it every 6 months at the time of the regular oil change.



Note:

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



Preventative Maintenance Schedule

1. Daily Maintenance:

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

2. Weekly Maintenance:

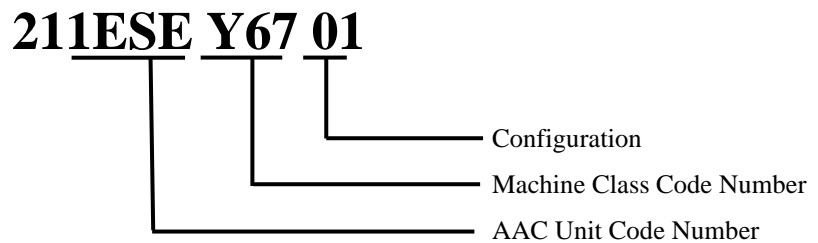
- A. Use low-pressure air blower gun to clean inside of sewing head, remove throat plate to gain access.
- B. Check sharpness of edge trimming and thread chopping knives; sharpen as needed to maintain keen edge.
- C. Check level of thread lubricant reservoirs; fill with silicone oil as necessary (if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

3. Monthly Maintenance:

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

Configuration

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



Sewing Machine Codes

G67	PEGASUS 5.6mm
R67	IMOLDI 4.5mm
R68	RIMOLDI 6.00mm
S67	SINGER 5.6mm
Y66	YAMATO 4.8mm
Y64	YAMATO 5.6mm
Y67	YAMATO VC2700-156M 5.6 mm
Y68	YAMATO 6.4mm

Assembly Drawings & Parts Lists

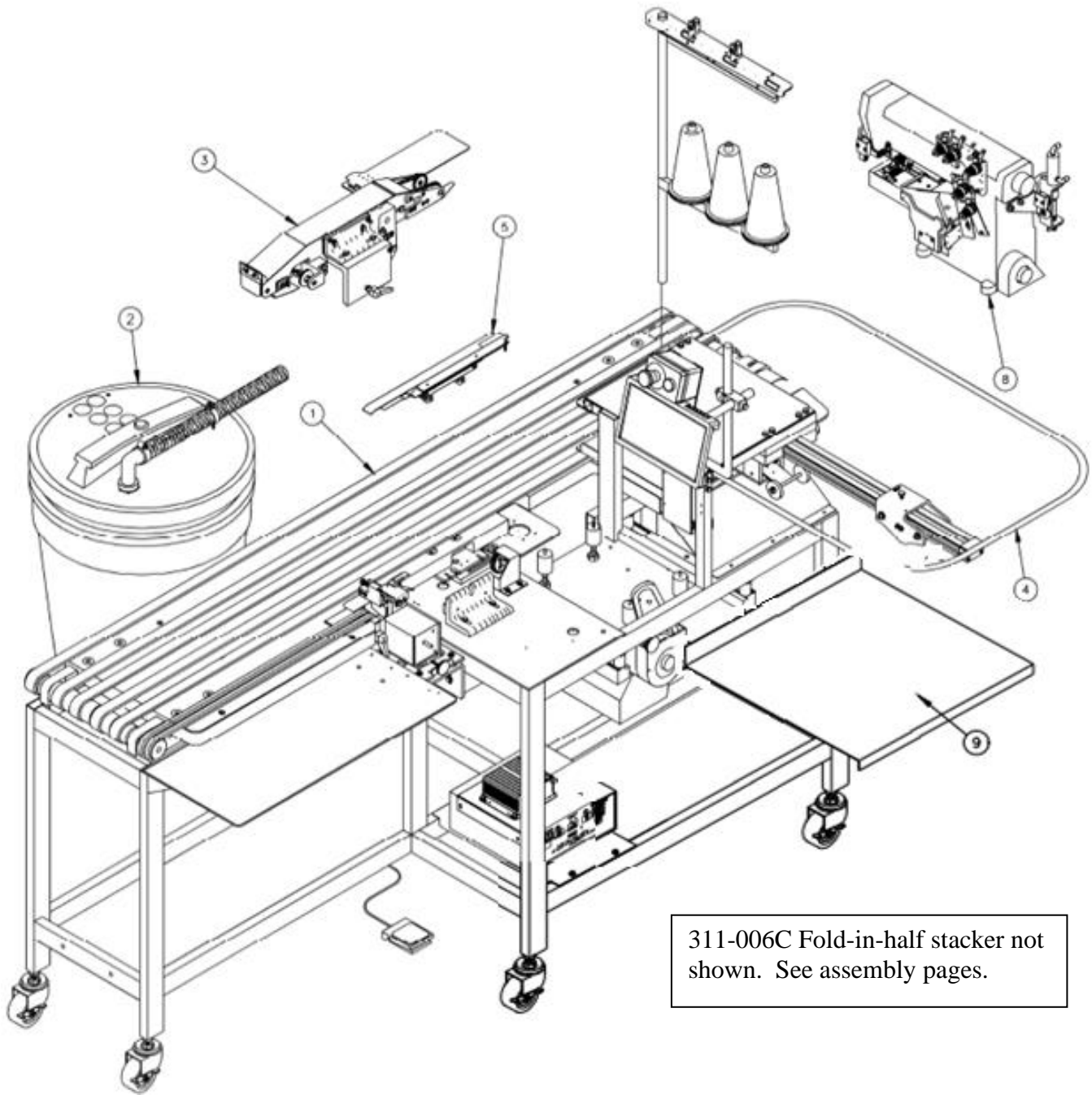
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One-Stop Shopping
For Expendable Replacement Parts for AAC & Other Bedding Equipment Suppliers
Toll Free: **1-866-885-5100**
www.atlantapartsdepot.com • sales@atlantapartsdepot.com

2211ESEY6408 Auto Hemmer, Yamato 5.6mm With Gateway & Efka

AAC Drawing Number

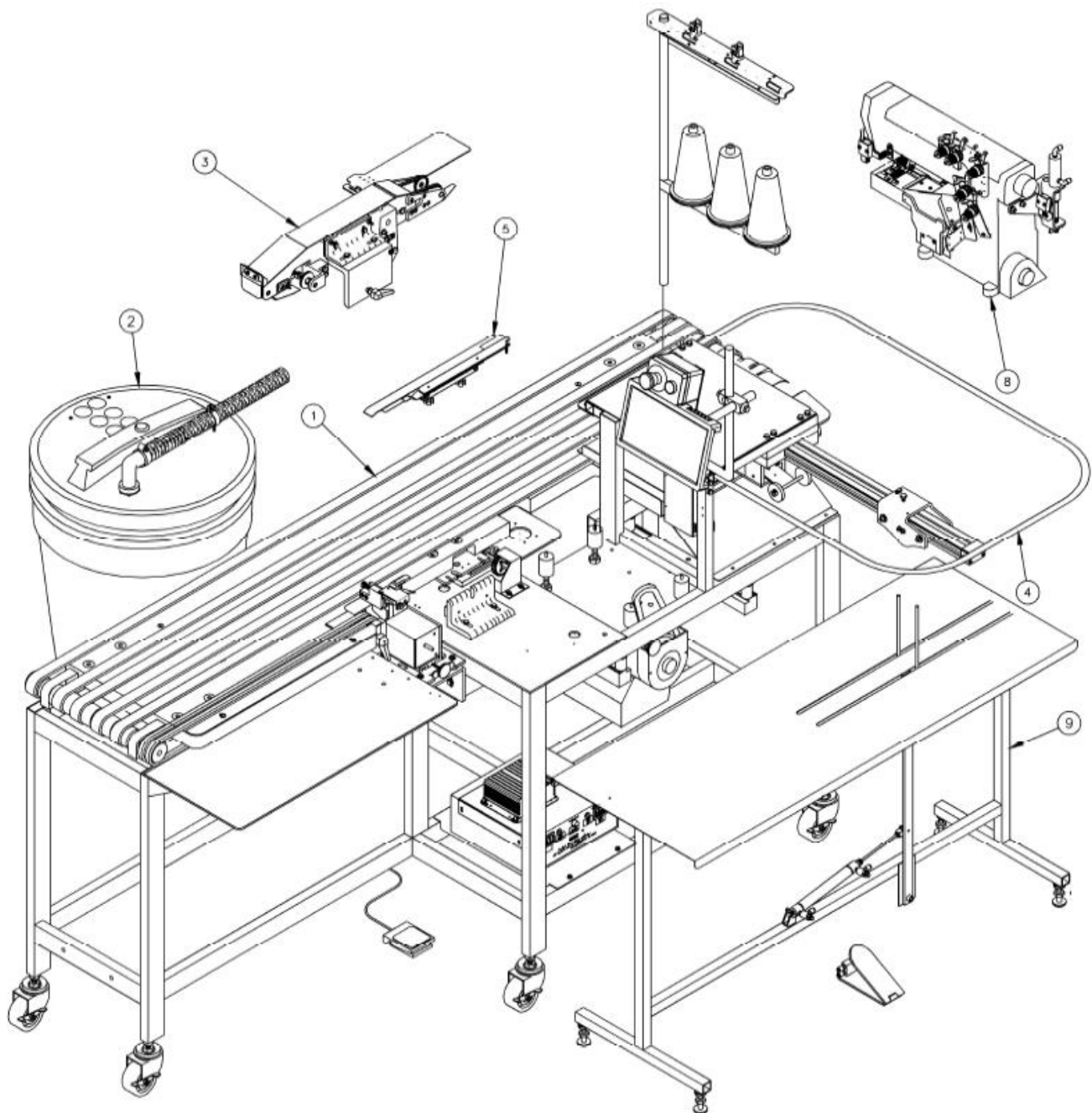


311-006C Fold-in-half stacker not shown. See assembly pages.

QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE	QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	10	Folding Stacker	311-006C	1	5	HEMMING FOLDER	211-G6606C
1	9	TABLE, BUNDLE	211-141	1	4	STACKER	211-151A
1	8.1	SEWING HEAD,YAMATO	SYAM-2700J	1	3	TOP CONVEYOR	211-134
1	8	HEMMER SEAMER HEAD	211-127B	1	2	WASTE SYSTEM	0411-1300
1	7	DIAGRAM,WIRING,SBUS,EFKA	211ES-WD2	1	1	TABLE ASSEMBLY	211-126E
1	6	PNEUMATIC DIAGRAM	211ES-PD1				

2211ESEG6702 Auto Hemmer, Pegasus 5.6mm, With Gateway & Efka

AAC Drawing Number 192188B Rev 1



QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE	QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	10	MANUAL	ZZ211ES	1	5	HEMMING FOLDER	211-G6606C
1	9	INDEXING TABLE	211-162	1	4	STACKER	211-151A
1	8	HEMMER SEWING HEAD	211-2R	1	3	TOP CONVEYOR	211-134
1	7	SCHEMATIC DIAGRAM	211ES-WD2	1	2	WASTE SYSTEM	0411-1300
1	6	PNEUMATIC DIAGRAM	211ES-PD1	1	1	TABLE ASSEMBLY	211-126E

Sewing Head Details

for 2211ES Two Needle Hemmer

Gauge Parts

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

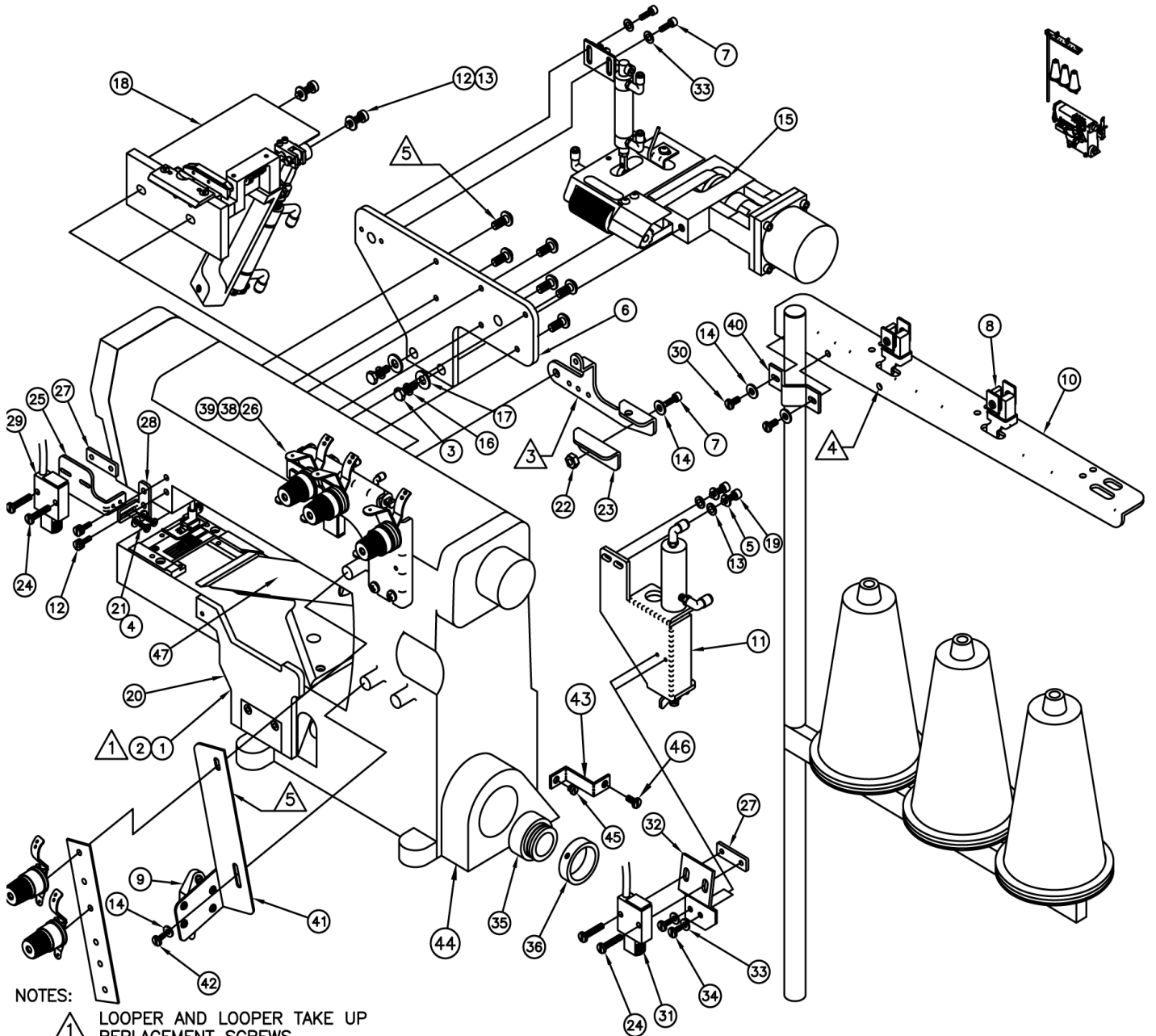
211-2R parts list

1	26	THREAD KIT	3101760
1	25	EYE MOUNT, FRONT	211-153
4	24	SCREW, PAN SLOTTED 8-48 x 3/4	SSPS70048
1	23	ARM, MANUAL FOOTLIFT	211-158A
1	22	NUT, KEP	NNK10-32
2	21	SCREW, PAN SLOTTED 8-32 x 1/4	SSPS80016
1	20	RIGHT LOOPER COVER, MOD.	O10-072
1	19	THREAD GUIDE ASSY	211-114
1	18	CHAIN TRIMMER	211-164
2	17	WASHER, FLAT	WWF5/16
2	16	WASHER, LOCK	WWL5/16
1	15	CHAIN PULLER	2213009
4	14	WASHER, FLAT	WWF10
2	13	1/4 WASHER	WWF6
4	12	SCREW, CHEESE HEAD #6 x 10mm	SSCM6X15
1	11	FOOT LIFT SUB-ASY	211-122B
1	10	BRKT, THREAD BRK	O411-069C
1	9	THREAD STOP	O11-132A
2	8	SENSOR	4003-IS3WT2
2	7	SCREW, SOCKET CAP 8-32 x 3/8	SSCC98024
1	6	PULLER ASSY MOUNT	O11-075
1	5	THREAD GUIDE	211-116
4	4	WASHER, FLAT	WWB6S
2	3	SCREW, HEX CAP 5/16-18 x 1.0	SSHC10064
2	2	SCREW, SOCKET SET 8-32 x 1/8	SSSS98008
1	1	SEWING MACHINE SCREW	SSM7145
QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE

1	51	NOL. PLATE MODIFICATION PEGASUS 5.60A	211-061F
1	50	SEWING HEAD, 3/4 4.8 GA 2H HEMNER	SW&G66408C
1	49	SEWING HEAD ASSY 3/4 4.8 GA PEGASUS	211-180A
1	48	FEED DOG MODIFICATION PEGASUS 5.6 GA	211-063F
1	47	FOOT MODIFICATION PEGASUS 5.6 GA	211-062F
1	46	CABLE, POST, SENSOR, 6' EPRA DCL500, FFMS312LVQ	O211-702A
1	45	EYELET, LOOPER	O11-061
2	44	WASHER, LOCK, 10	WWL10
2	43	SCREW, CHEESE HEAD #6-08 x 10mm	SSCM5X10
2	42	SCREW, BUTTON CAP 10-38 x 1/2	SSBC98032
1	41	BRKT, 1 THREAD STOP	40-233B
1	40	CLAMP, SENSOR BRKT	O411-070
1	39	MOUNT, THREAD TENSION	311-096
1	38	POST	3101760C
10	37	NEEDLE, SCHMETZ 128 CASE/1032 BX/100	SN128CAS80
1	36	TAPE MOUNTING	311-129
1	35	TAPE MOUNTING	311-128
1	34		
1	33	TOP LOOPER COVER	211-067
1	32	BRKT, POS SENSOR MNT	311-120
1	31	ELECTRIC EYE	FFSM312LVQ
2	30	SCREW, PAN HD SLOTTED 10-32 x 3/4	SSPS98048
1	29	ELECTRIC EYE	FFSM312LVQ
1	28	EYE BRKT, REAR	211-154
2	27	NUT PLATE	1975-412A
QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE

211-127B Sewing Head Assembly, Hemmer Model:2211ESEY6408

AAC Drawing Number 192063C Rev 7



NOTES:

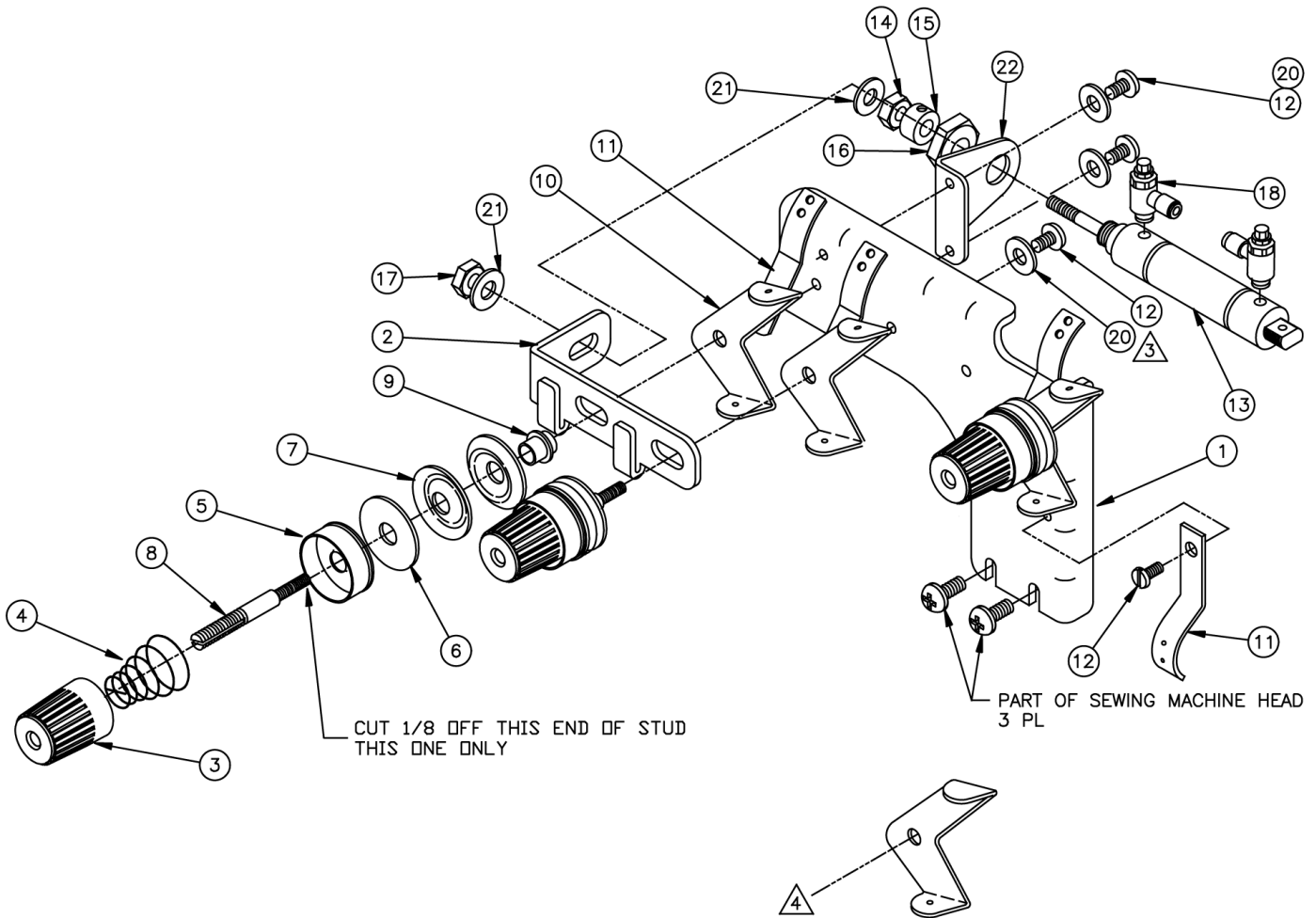
- △ 1 LOOPER AND LOOPER TAKE UP REPLACEMENT SCREWS
- △ 2 NOT SHOWN
- △ 3 EXISTING BRACKET FROM SEWING HEAD.
- △ 4 RE-USE EYELET FROM EXISTING THREAD STAND FOR LOOPER THREAD.
- △ 5 RE-USE EXISTING SCREWS, TENSION BASE BRACKET & 2 TENSIONS.

211-127B parts list

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

3101760 Thread Handling Assembly

AAC Drawing Number 290600C Rev 8



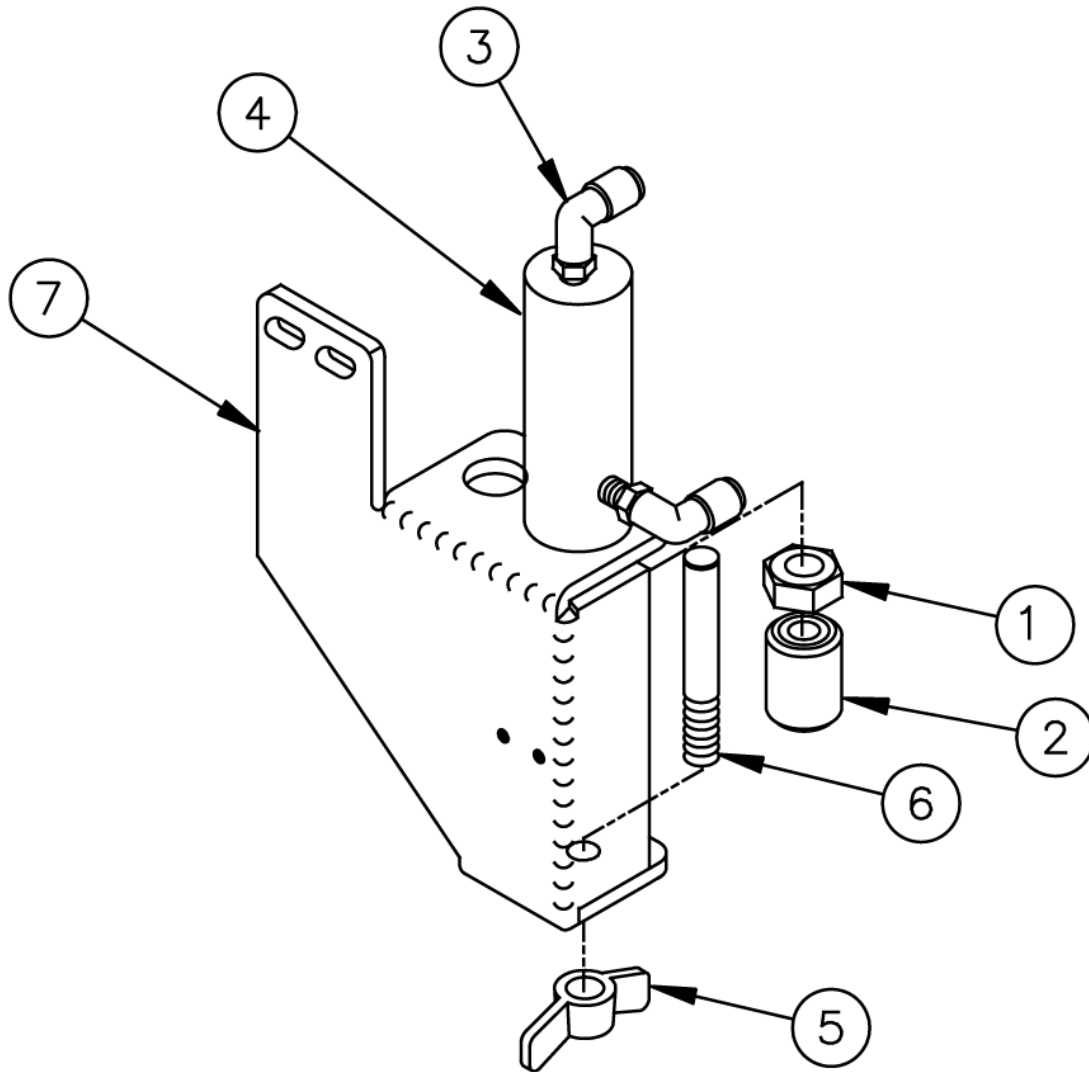
NOTES:

- 1. * DENOTE PARTS SUPPLIED WITH MACHINE.
- △2 GRIND THIS STUD FLUSH WITH BACK OF ITEM 1.
- △3 ATTACHES KIT TO MOUNT BRKT ON SEWING HEAD ASSY.
- △4 REUSE LEFT OVER TENSION GUIDE FOR LOOPER THREAD GUIDING.

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

211-122D Foot lift Sub-Assembly, Yamato 2700

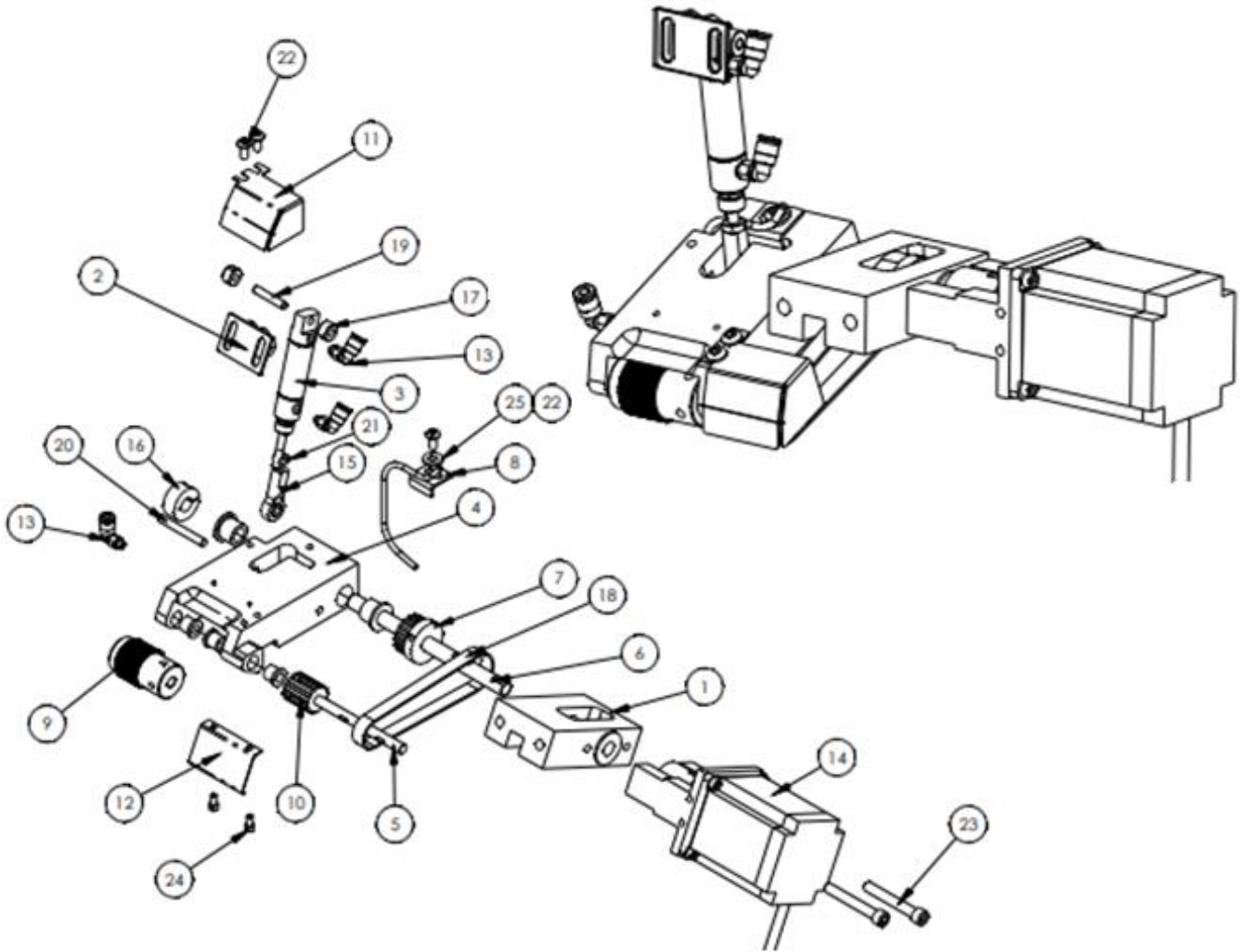
AAC Drawing Number 192003B Rev 0



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

2213009 Chain Puller Assembly

AAC Drawing Number 2213009 Rev 0

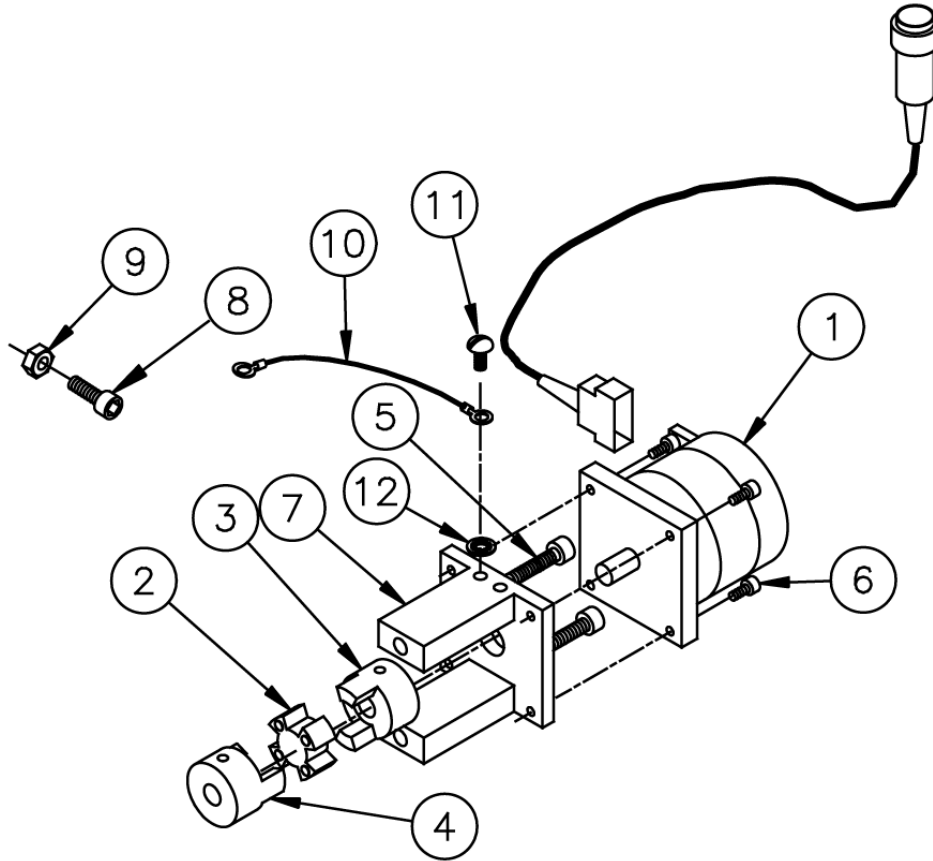


ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	011-069B	MOUNT, STEPPING MOTOR
2	1	011-070	PLATE,CYLINDER MOUNT
3	1	1975-213	CYLINDER, AIR, DA, 9/16B, 1/2S
4	1	311-3001C	ARM, PULLER PIVOT
5	1	311-3002B	AXLE, LOWER, CHAIN PULLER
6	1	311-3003A	AXLE, UPPER, CHAIN PULLER
7	1	311-3004A	PULLEY,GEAR,1/5 PITCH,16T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

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

AP-22E-105 Drive Motor Assembly

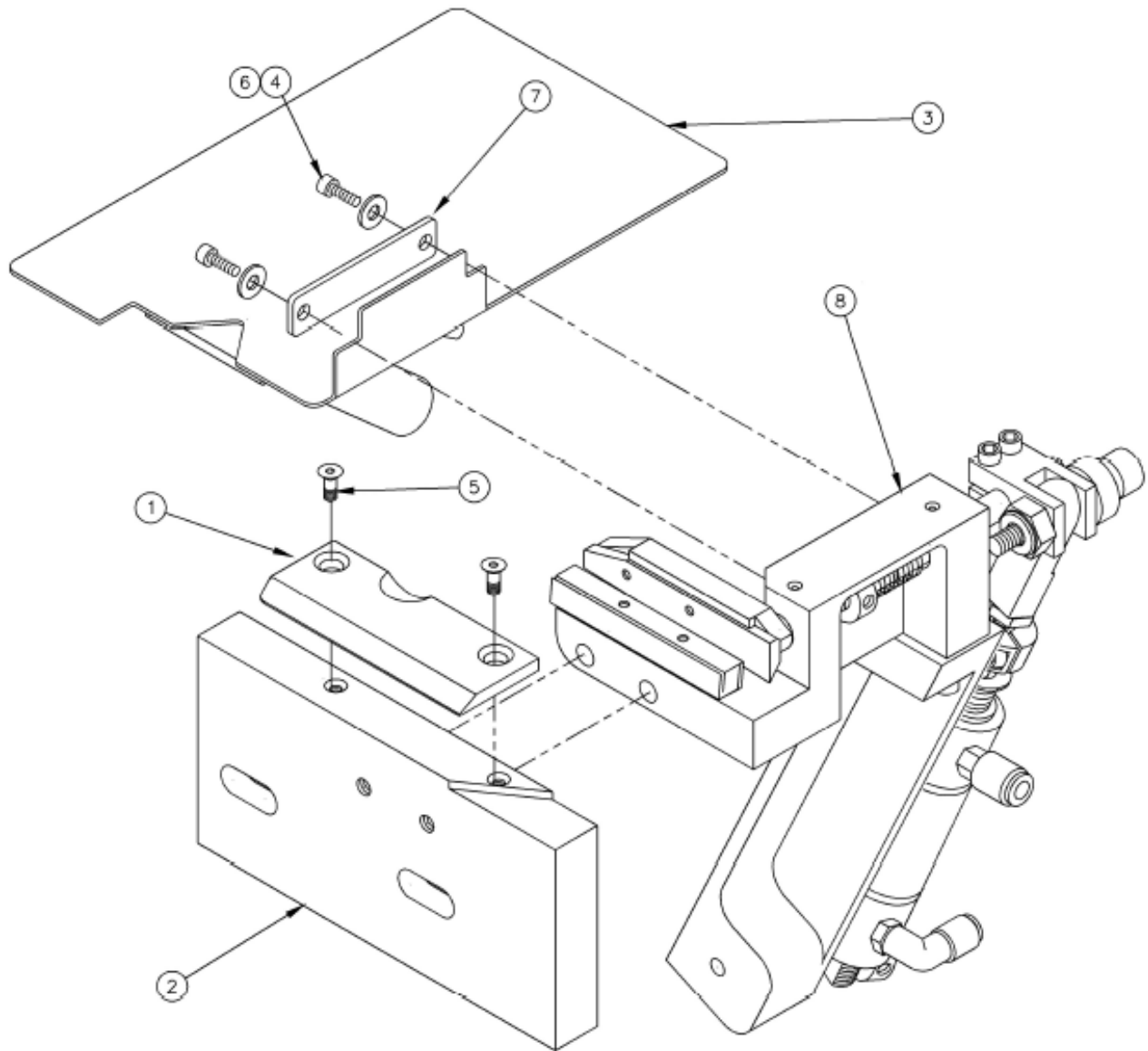
AAC Drawing Number 190170B Rev 3



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	AP-22E-103	Step Motor	7	1	AP-22E-101	Bracket. Motor Adaptor
2	1	MML050	Spider	8	1	SSSC90048	Scr, Socket Cap, 8-32x3/4
3	1	MML050-250	Coupling Body	9	1	NNH8-32	#8 Nut
4	1	MML050-375	Coupling Body	10	1	28128A	Ground Strap
5	2	SSSC01128	Scr, Socket Cap, 1/4-20x2	11	1	SPPS98016	Scr, Pan Head, 10-32 x 1/4
6	4	SSSC90032	Scr, Socket Cap, 8-32x1/2	12	1	WWSI10	Internal Star Washer

211-164 Chain Trimmer, Pegasus W664

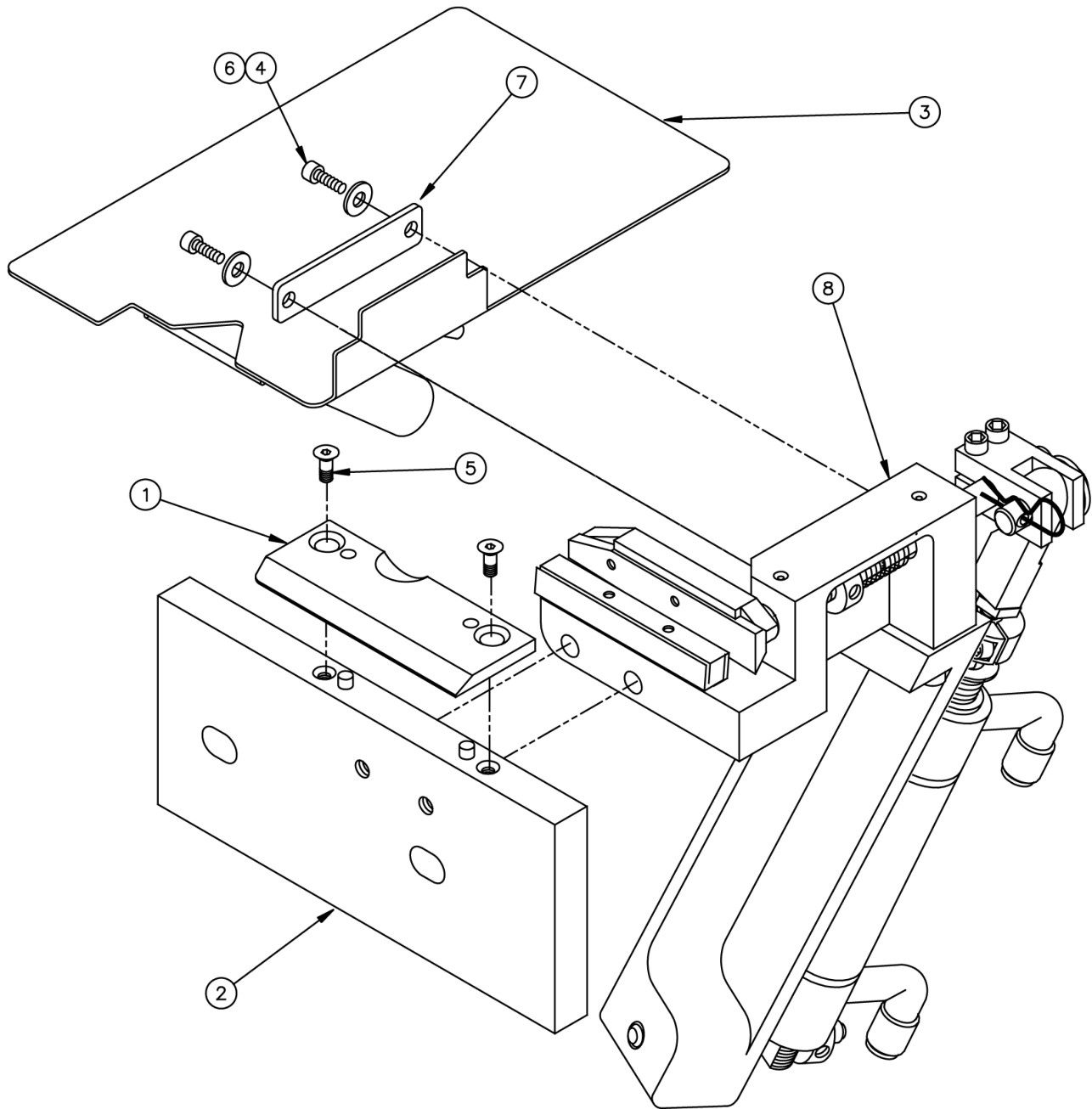
AAC Drawing Number 191353C Rev 3



QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	8	THREAD TRIM ASSY.	311-2017
1	7	WASHER PLATE	311-20016
2	6	WASHER, BRASS	WWB6S
2	5	SCREW, FLAT ALLEN 6-32 x 3/8	SSFC80024
2	4	SCREW, SOCKET CAP 4-40 x 1/4	SSSC70016
1	3	CUTTER FILLER PLATE	311-2001A
1	2	PLATE, MOUNT	311-2009B
1	1	PRESSURE PLATE	311-2002A

211-129A Chain Trimmer, Yamato 2700

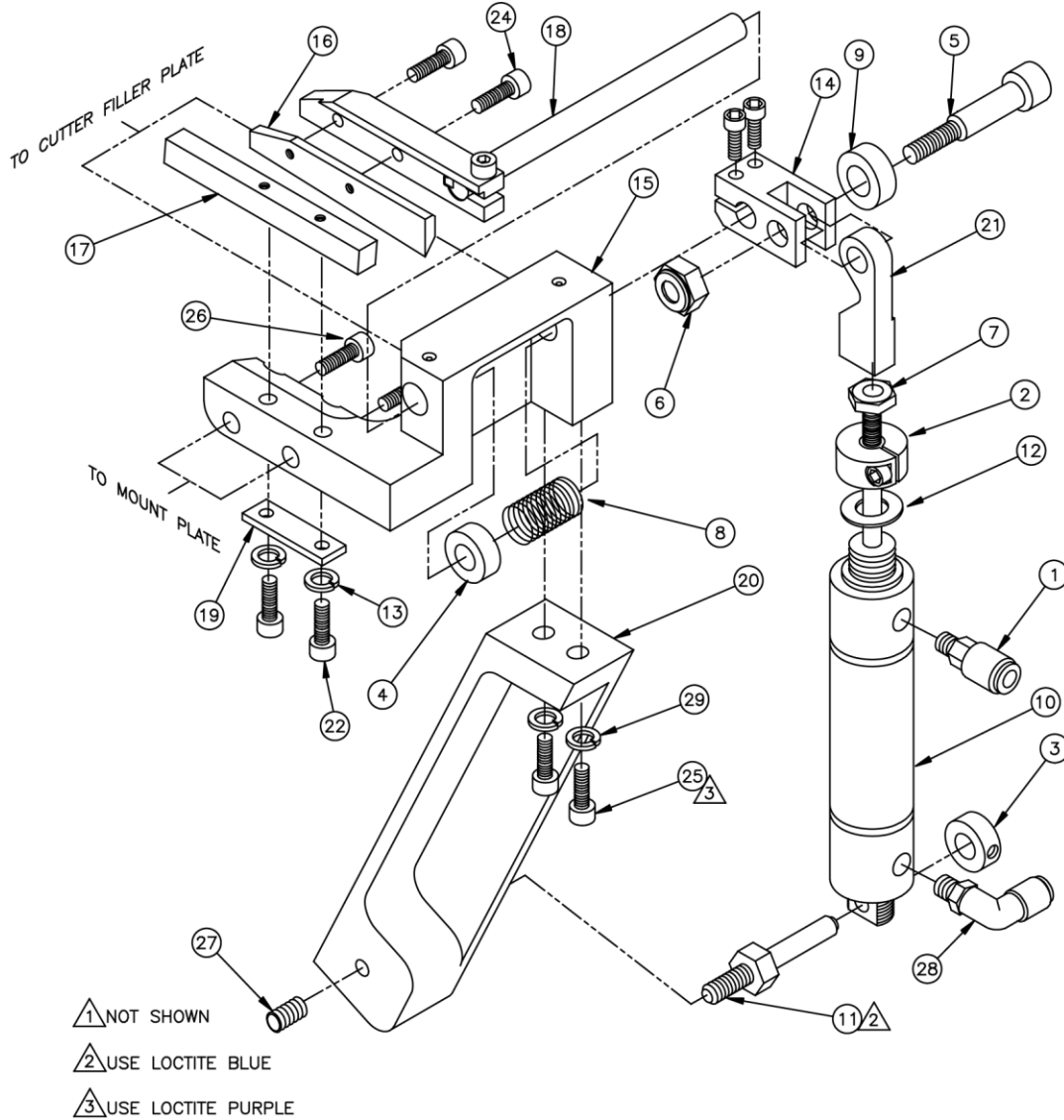
AAC Drawing Number 192064C Rev 0



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

311-2017 Thread Trim Assembly

AAC Drawing Number 191337C Rev 13



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

311-2018 Thread Trimmer Adjustment Instructions

1 FASTEN DRIVE LINK TO CLEVIS USING SHOULDER SCREW WITH FELT WICK, SOAKED IN 30W OIL AND TIGHTEN ON WITH ELASTIC NUT. CLEVIS SCREWS MUST BE LOOSE. CLEVIS CLAMP MUST BE TIGHTENED TO PREVENT BINDING. ASEGURE EL UNO DEL BREGO DE TRANSMISION LA HORQUILLA CON EL TORNILLO DE HOMBRO Y FELPA EMPAPADA DE ACEITE 30W Y ASEGURE CON TORNILLO DE PLASTICO LOS TORNILLOS DE LA HORQUILLA DEBEN ESTAR FLOJOS

NOTE: CYLINDER MUST BE PARALLEL TO BRACKET TO PREVENT BINDING.
 NOTA: EL CILINDRO TIENE QUE SER PARALELO AL PASADOR PARA EVITAR QUE SE TRABE.

INSTALL SET SCREW TIGHT AGAINST STUD TO LOCK STUD IN PLACE. ASEGURE EL PASADOR CONTRA EL PASADOR PARA ASEGURARLO

2 ASSEMBLE SO THAT THE MOUNT BLOCK AND CLEVIS ARE PARALLEL.
 ENSAMBLE DE FORMA QUE EL BLOQUE MONTURA Y LA HORQUILLA SON PARALELOS. VEA PASO 3.

4 ADJUST MOVABLE BLADE TIP AT 1.6mm PAST THE SURFACE OF STATIONARY BLADE. THIS SETS THE CLOSED HEIGHT. AJUSTE LA PUNTA DE LA HOJA MOVIBLE A 1.6 mm PASANDO LA SUPERFICIE DE LA HOJA ESTACIONARIA ESTO FIA LA ALTURA CERRADA.

NOTE: THESE TWO ADJUSTMENTS MUST BE HELD TRUE THROUGHOUT FOR TRIMMER TO PERFORM CORRECTLY.
 NOTA: ESTOS DOS AJUSTES TIENEN QUE MANTENERSE SIEMPRE PARA QUE EL CORTADOR FUNCIONE.

3 INSTALL STUD WITH BLUE LOCITITE & TIGHTEN SECURELY. INSTALL CYLINDER & EXTEND SHAFT OF CYLINDER TO IT'S FULL LENGTH. LOOSEN LOCKNUT ON CYLINDER ROD & ADJUST CYLINDER ROD TO ACHIEVE PARALLELISM BETWEEN CLEVIS SURFACE & TOP OF MOUNT BLOCK. TIGHTEN ROD NUT SECURELY. INSTALE EL PASADOR CON BLUE LOCKLITE Y APRIETE. AJUSTE EL CILINDRO A TODA SU EXTENSION. AJEGUE EL TORNILLO DE SEGURIDAD EN EL EJE DEL CILINDRO PARA PONER PARALELO LA HORQUILLA CON LA SUPERFICIE DE ARRIBA DEL SOPORTE APRIETE BIEN EL TORNILLO

CLAMP COLLAR
 COLLARIN

5 BASE MOVABLE BLADE TIP TO 19mm ABOVE STATIONARY BLADE AND TIGHTEN CLAMP COLLAR. THIS SETS THE OPEN HEIGHT. SUBA LA PUNTA DE LA CUCHILLA A 19mm POR ENCIMA DE LA ESTACIONARIA Y APRIETE EL COLLARIN. ESTO FIA LA ALTURA

6 PLACE A DROP OF 30W OIL ONTO THE FELT WICK. TWO HOLES ON THE SURFACE OF THE CUTTER BODY. DE LOS DOS AGUEROS EN LA SUPERFICIE DEL CORTADOR.

OPERATOR VIEW

TOOLS REQ. - HERRAMIENTAS:
 3/8 WRENCH
 3/8 INTON WRENCH
 7/64 ALLEN WRENCH
 3/32 T-HANDLE ALLEN WRENCH
 5/32 T-HANDLE ALLEN WRENCH
 1/8 T-HANDLE ALLEN WRENCH

ATLANTA ATTACHMENT COMPANY
 2nd DES. CHAIN TRIMMER
 PART NO. 311-2018
 DRAWING NO. 261321C | 5

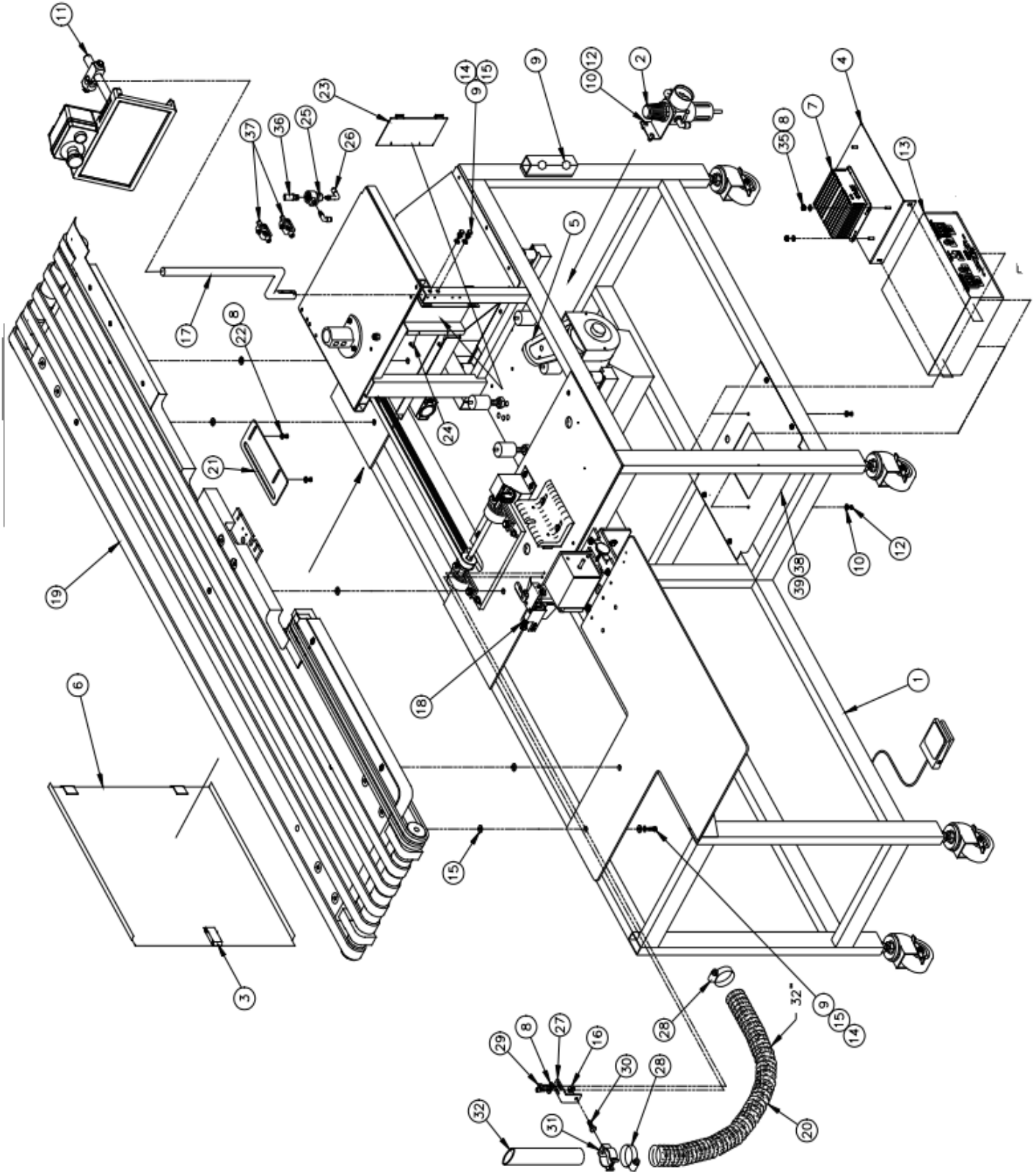
ATLANTA ATTACHMENT COMPANY
 NAME: THREAD TRIMMER ADJUSTMENT INSTRUCTIONS
 MATERIAL NOTED
 2nd DES. FOR CHAIN TRIMMER
 PART NO. 311-2018
 DRAWING NO. 261321C | 5
 DES. BY: MARGIA DUNCAN
 CK. BY: JEFF THOMAS
 SCALE: 1/1 | DATE: 11-7-96 | IMG: G. .

REV.	DATE	DESCRIPTION	BY	CHK.
1	11-7-96	REVISED	MD	JT
2	11-7-96	REVISED	MD	JT
3	11-7-96	REVISED	MD	JT
4	11-7-96	REVISED	MD	JT
5	11-7-96	REVISED	MD	JT
6	11-7-96	REVISED	MD	JT
7	11-7-96	REVISED	MD	JT
8	11-7-96	REVISED	MD	JT
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28	11-7-96	REVISED	MD	JT
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Workstation Details

211-126E Table Assembly

AAC Drawing Number 191075A Rev 2

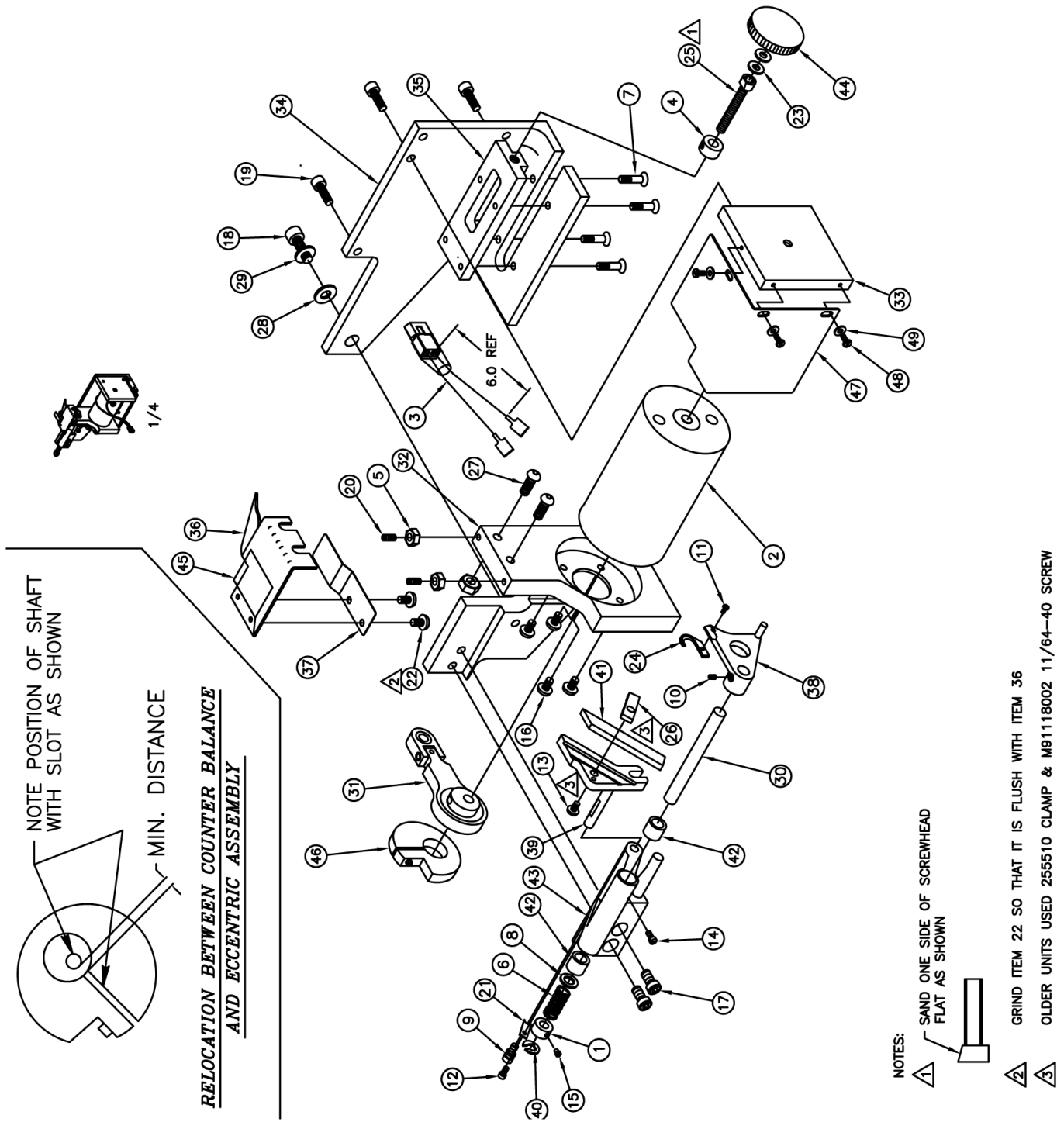


211-126E parts list

QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE	QTY. RECD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
1	40	DIAGRAM, PNEUMATIC	211ES-PD1	2.7ft	20	HOSE, FLEX	MMFH150
4	39	SCREW, HEX SHEET METAL #10x1/2	SSZH#10032	1	19	LWR. CONVEYOR	211-128
1	38	MOUNT, CONTROL BOX AP-28-800N ON 211ES	211-208	1	18	EDGE TRIMMER	211-121A
2	37	IN-LINE FLOW CONTROL	AA2000F-03	1	17	CONTR. BOX SUPP.	211-126-2
1	36	PAPER MUFFLER, 1/4"	MMU002A	1	16	1/4-20 KEP NUT	NNK1/4-20
1	35	NUT, KEP, 10-32	NNK10-32	12	15	FLAT WASHER	WWF1/4
1	34	DIAG., WIRING, EFKA, POCKET	211PS-WD2	7	14	1/4 LOCK WASHER	WWL1/4
1	33	DIAG., WIRING, EFKA	211ES-WD2	1	13	CONTROL BOX, STEPPER	AP-28-800NN
1	32	TUBE, WASTE	211-157	6	12	SCREW, PAN, HD SLOTTED 8-32 x 1/2	SSPS90032
1	31	CLAMP, TUBE	MM16300	1	11	HMI FLOE MOUNT WITH BEND UP WITH E-STOP AND START	4082006
1	30	SCREW, HEX CAP 1/4-20 x 1/2	SSHC01032	6	10	FLAT WASHER	WWF8
2	29	SCREW, SOCKET CAP 10-32 x 1/2	SSSC98032	9	9	SCREW, HEX CAP 1/4-20 x 3/4	SSHC01048
2	28	CLAMP, HOSE	MM5415K16	4	8	FLAT WASHER	WWFS10
1	27	MOUNT, WASTE TUBE	211-156	1	7	PC GATEWAY	EEJBC375CG
2	26	QUICK MALE EL	AAQME-5-8	1	6	DOOR, ELEC. BOX	010-122
1	25	QUICK EXHAUST VALVE	AAVSQE1	1	5	V BELT	ZX3840
2	24	ROUND SLOTTED 6-40 x 1/4	SSRS85016	1	4	PC GATEWAY MOUNT AP-28-800	4082007
1	23	WIRE COND. COVER	011-084	1	3	SLIDE LATCH	MM40450010
2	22	SCREW, PAN, SLOTTED 10-32 x 1/2	SSPS98032	1	2	REG. W/GA. & NUT	AA198-5102
1	21	EYE MOUNT	211-152	1	1	TABLE ASSEMBLY	211-125E

211-121A Edge Trimmer Assembly, SBUS

AAC Drawing Number 192051C Rev 5



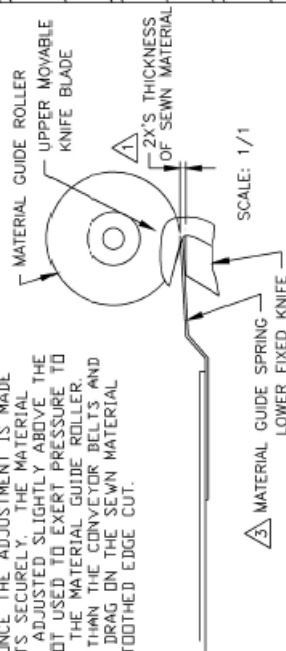
211-121A parts list

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	CC192024	COLLAR	26	1	255510-PEG	CLAMP
2	1	EEMS221005C	MOTOR	27	2	SSBC01032	SCREW, BUTTON CAP 1/4-20 X 1/2
3	1	211-172	CABLE	28	1	WWFS1/4	SAE WASHER
4	1	CCSC41/4	1/4 SET COLLAR	29	1	WWL1/4	LOCK WASHER
5	2	NNH8-32	HEX NUT	30	1	255508-2	SHAFT
6	1	RR306105	SPRING	31	1	010-027	ECCENTRIC ASSY
7	4	SSFC90032	SCREW, FLAT ALLEN CAP 8-32 X 1/2	32	1	010-029A1	DC MOTOR MOUNT
8	1	SSM207045	WASHER	33	1	010-029B1	DC MOTOR MOUNT
9	1	SSM255513	SCREW 11/64-40 X 7/32	34	1	010-031	MOUNT, MOTOR
10	1	SSM4547	SCREW, SOCKET SET M6 X .75 X 5	35	1	010-032	BLOCK, MOTOR ADJ.
11	1	SSM5109	SCREW 1/8-44 X 13/64	36	1	010-036A	PLATE,CUTTER GUARD
12	1	SSM7010	SCREW M3 X .5 X 6mm	37	1	010-042	PLATE,SPRING,CUTTER
13	1	SSSCM5X10	SCREW M5 X 10 SOC CAP	38	1	255507-91	HOLDER, UPPER CUTTER
14	1	SSM7036	SCREW M4 X .7 X 6mm	39	1	255509	HOLDER,LOWER CUTTER
15	1	SSM22570	SCREW, FILLISTER, 182-40 X 3/16	40	1	202522	RING
16	4	SSPS80032	SCREW, PAN HD SLOTTED 6-32 X 1/2	41	1	204351	CUTTER, LOWER
17	2	SSSC01040	SCREW, SOCKET CAP 1/4-20 X 5/8	42	2	240099	NEEDLE BEARING
18	1	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1	43	1	255506	BRACKET, CUTTER
19	4	SSSC95040	SCREW, SOCKET CAP 10-24 X 5/8	44	1	TTK32315	TORQUE KNOB
20	2	SSSS90032	SCREW, SOCKET SET 8-32 X 1/2	45	1	MMFELT	1 X 1.25 FELT PAD
21	1	255511-PEG	GUIDE	46	1	010-037A	COUNTER BALANCE
22	2	SST585008	SCREW, TRUSS SLOTTED 6-40 X 1/8	47	1	211-137	COVER
23	2	SST585008	5/32 BRASS WASHER	48	3	SSPS80024	SCREW, PAN SLOTTED 6-32 X 3/8
24	1	306394	CUTTER, UPPER	49	3	WWFS6	WASHER, FLAT, SAE
25	1	SSSC05128F	SCREW, SOCKET CAP 1/4-28 X 2	50	0	010-042A	PLATE,SPRING,CUTTER

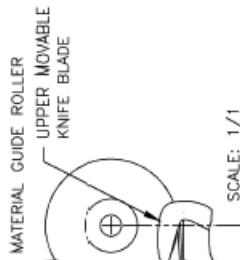
011-INST1 Material Adjustment

THE MATERIAL GUIDE ROLLER SHOULD BE ADJUSTED IN THREE DIMENSIONS:

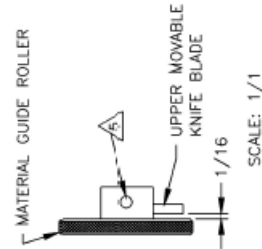
1. THE MATERIAL GUIDE ROLLER SHOULD BE LOCATED VERTICALLY AT A HEIGHT OF 2X'S THE THICKNESS OF THE SEWN MATERIAL ABOVE THE LOWER FIXED KNIFE. THIS IS ACCOMPLISHED BY LOOSENING THE TWO 1/4"-20 BOLTS Δ ATTACHING THE MATERIAL GUIDE ROLLER SUPPORT BLOCK TO THE FRAME OF THE UPPER CONVEYOR CASE SHOULD BE TAKEN TO KEEP THE SUPPORT BLOCK MOVED TO THE RIGHT AT IT IS ALSO USED TO TENSION THE DRIVE BELT. ONCE THE ADJUSTMENT IS MADE TIGHTEN THE TWO 1/4"-20 BOLTS SECURELY. THE MATERIAL GUIDE SPRING Δ SHOULD BE ADJUSTED SLIGHTLY ABOVE THE LOWER FIXED KNIFE. IT IS NOT USED TO EXERT PRESSURE TO HOLD THE MATERIAL AGAINST THE MATERIAL GUIDE ROLLER. THE ROLLER MOVES SLOWER THAN THE CONVEYOR BELTS AND ANY PRESSURE WILL CREATE DRAG ON THE SEWN MATERIAL CAUSING A RAUGHED OR SAW-TOOTHED EDGE CUT.



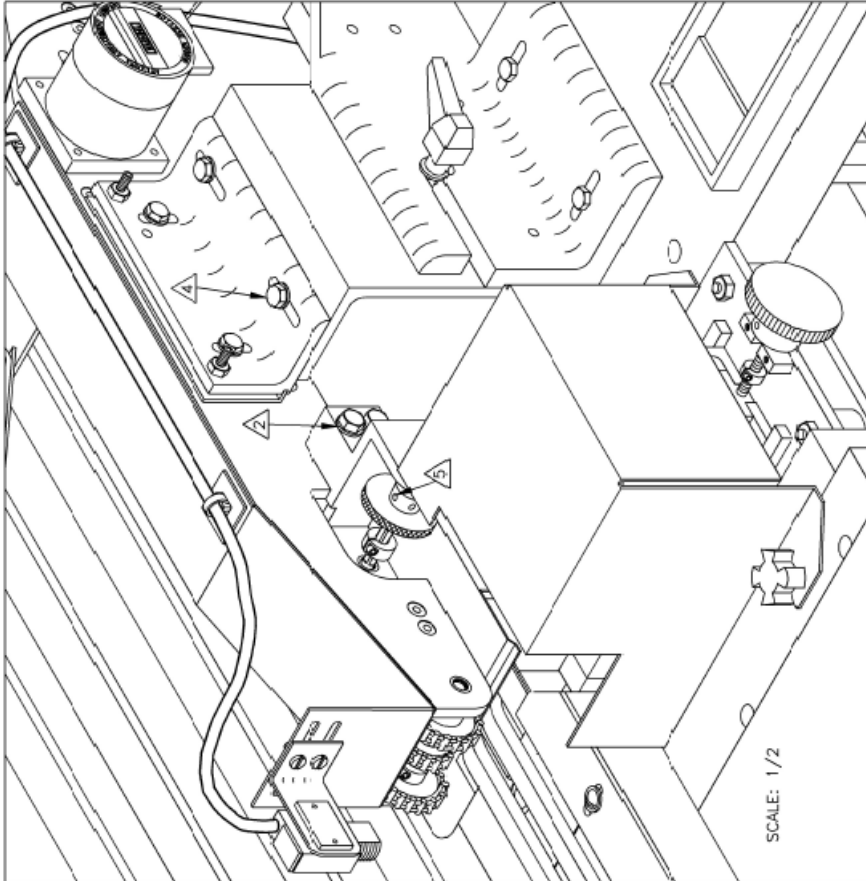
2. THE MATERIAL GUIDE ROLLER SHOULD BE ADJUSTED ALONG THE SEWING PLANE SO AS TO BE CENTERED AT THE RIGHT 1/3 OF THE CUTTING EDGE OF THE UPPER MOVABLE KNIFE BLADE. THIS IS ACCOMPLISHED BY LOOSENING THE TWO 1/4"-20 BOLTS Δ LOCATED IN THE SLOTTED HOLES OF THE UPPER CONVEYOR MOUNTING BRACKET. AFTER LOCATING THE MATERIAL GUIDE ROLLER PROPERLY, TIGHTEN THE TWO 1/4"-20 BOLTS SECURELY.



3. THE MATERIAL GUIDE ROLLER SHOULD BE ADJUSTED ALONG THE DRIVE SHAFT TO LEAVE 1/16" CLEARANCE BETWEEN THE ROLLER AND THE UPPER MOVABLE KNIFE BLADE. THIS IS ACCOMPLISHED BY LOOSENING THE SET SCREWS Δ IN THE MATERIAL GUIDE ROLLER AND MOVING THE ROLLER ALONG THE SHAFT UNTIL THE DESIRED 1/16" CLEARANCE IS REACHED. TIGHTEN THE SET SCREWS



NOTE: THIS ADJUSTMENT WILL HAVE TO BE REPEATED EVERY TIME THE MATERIAL TRIMMING KNIFE IS ADJUSTED FOR THE AMOUNT OF TRIM OFF.



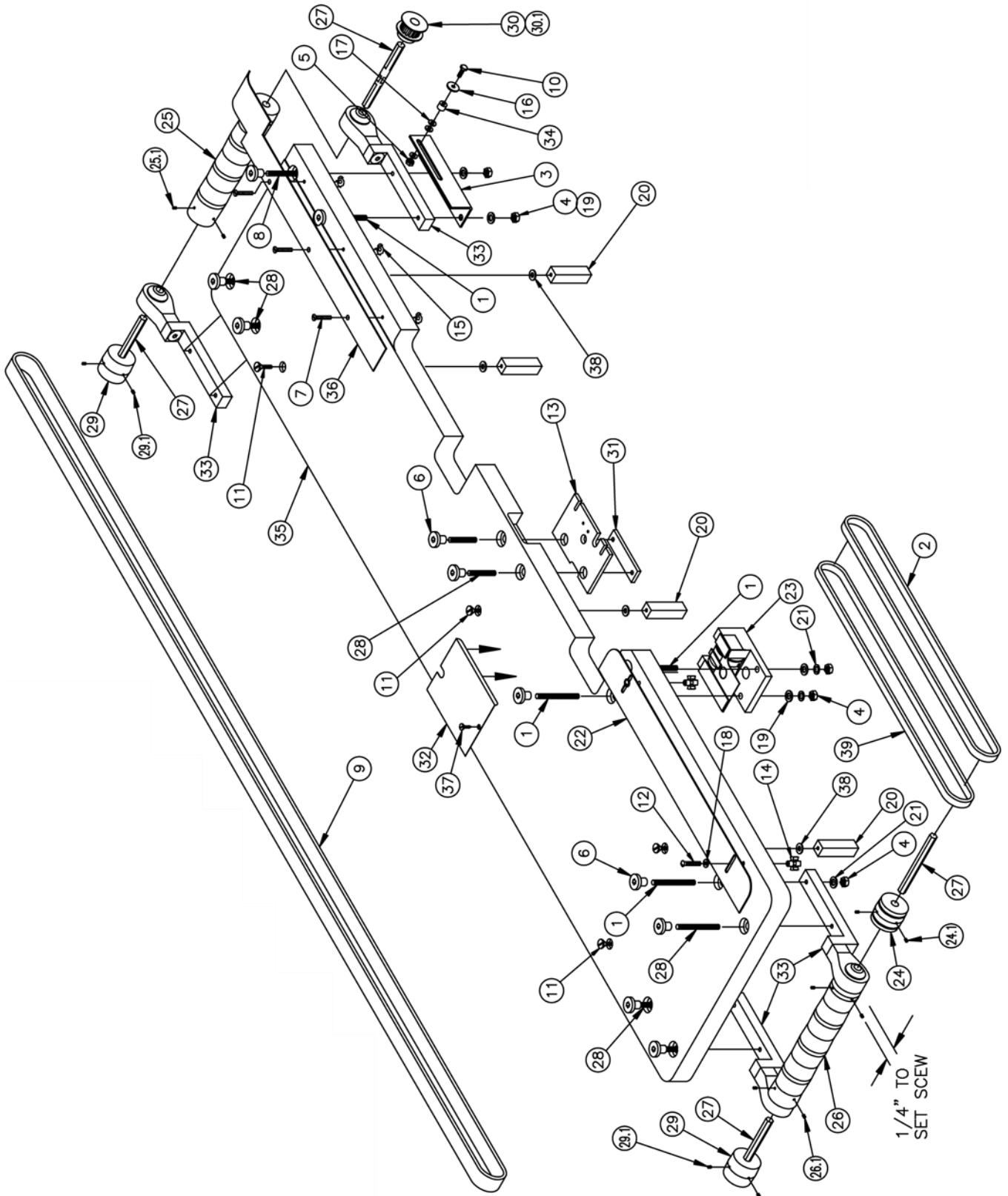
		ATLANTA ATTACHMENT COMPANY DRAWING NO. 290035C REV. 0	
2nd DES. MATERIAL ADJ. GUIDE ROLLER		PART NO. 011-INST1	
QTY. ITEM RECD. NO.		DESCRIPTION	
NAME ADJUSTMENT- MATERIAL		ATLANTA ATTACHMENT COMPANY	
MATERIAL NOTED		ASSEMBLY 011-06607	
DECIMAL TOLERANCE: .X = ±.010 .XX = ±.002 .XXX = ±.0005 FRACTIONS = ±1/64		DATE: 12/11/93 MACH. C.	
FINISH		DATE DR. I. OK.	
BURN BRONZE		PART NO. STOCK SIZE	
PLATE TREAT		NAME ADJUSTMENT- MATERIAL	
SHIP BLAST		MATERIAL NOTED	
PAINT TAN		PART NO. 011-INST1	
POLYESTER		DRAWING NO. 290035C	
IN.		DES. BY DAVID BRAUNER CK. BY DANNY MURPHY	

433-93

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211-128 Lower Conveyor Assembly

AAC Drawing Number 190012D Rev 8

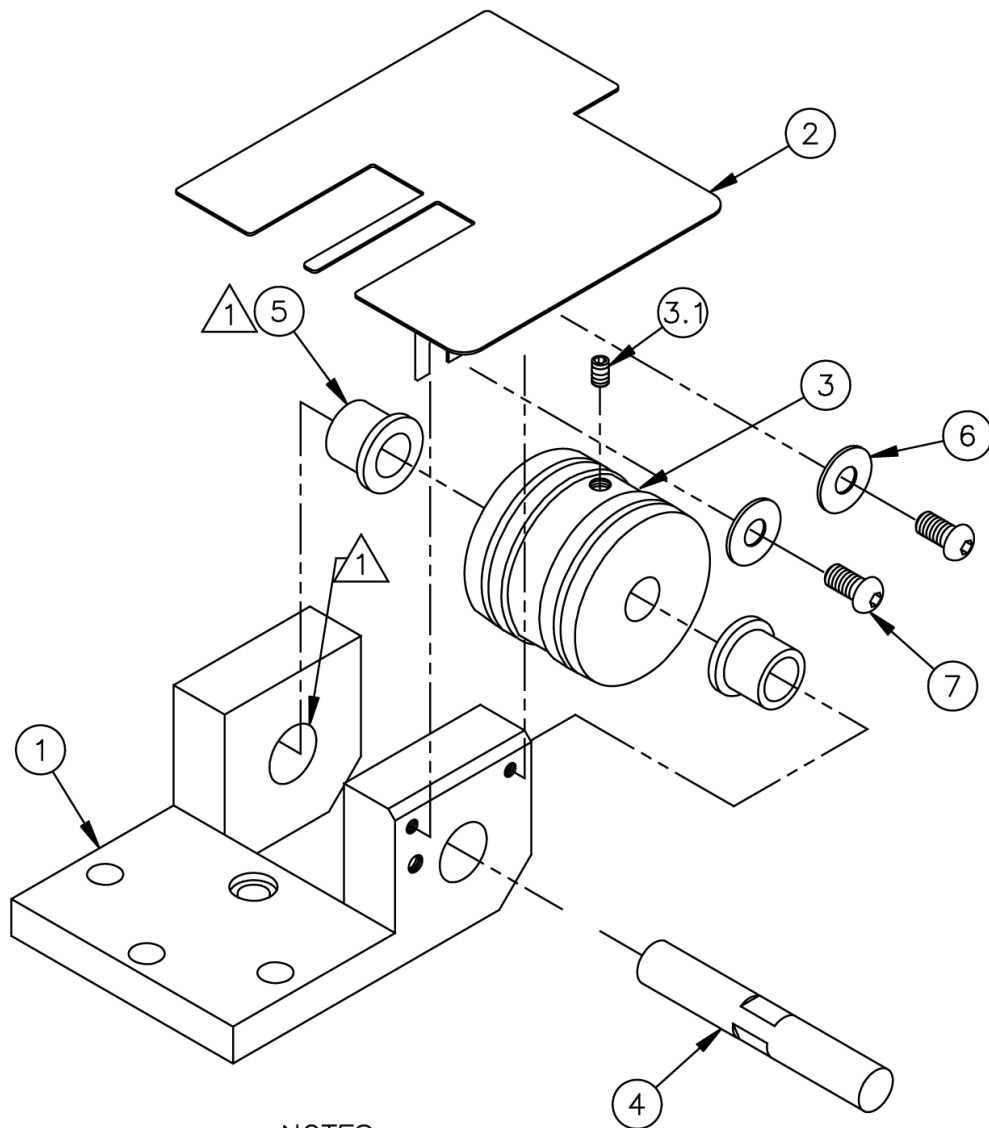


211-128 parts list

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	4	K-102-21	Threaded Rod 2/12	23	1	211-123	Belt Idler, Narrow
2	1	211-101	Belt, Urethane	24	1	010-049	Roller, Aluminum
3	1	211-004A	Mount, Tensioner	24.1	2	SSSS01032	Scr,So St 1/4-20x1/2
4	5	NNH5/16-18	NUT HEX, 5/16-18	25	1	010-050	Roller, Aluminum
5	1	NNK1/4-20	Nut, Kep, 1/4-20	25.1	4	SSSS01032	Wcr,So St 1/4-20x1/2
6	12	NNM103	Nut, 5/16-18	26	1	010-051	Roller, Aluminum
7	3	SSFS90128	Scr,Fl Sl 8-32x2.0	26.1	4	SSSS01032	Scr,So St 1/4-20x1/2
8	1	350254A	Rod, Threaded 2-1/4	27	4	010-052	Shaft, Plain
9	5	211-102	Belt, Urethane	28	7	350254	Rod, Threaded
10	1	SSHCO1064	Scr,Hx Cp 1/4-20x1	29	2	23055	Roller, Aluminum
11	5	SSFS01160	Scr, Fl Sl 1/4-20x 2/12	29.1	4	SSSS01024	Scr,So St 1/4-20x3/8
12	2	SSTS95160	Scr,Tr Sl 10-24x2 1/2	30	1	211-055	Gear Pulley
13	1	211-036	Folder Mount Plate	30.1	2	SSSS01024	Scr,So St 1/4-20x3/8
14	2	TTCL1BPPK1	Knob, Plastic	31	1	211-038	Nut Pl Folder Mt
15	3	TTIW8-32	Threaded Insert	32	1	211-099	Cutter Plate
16	1	WWFE016	1/4 Fender Washer	33	4	010-145	Rod End Bracket
17	3	WWFS1/4	Washer, Flat SAE	34	1	A-2014-7	Cam Follower
18	2	WWFS10	No. 10 SAE Washer	35	1	211-035	Table Top, Lwr Conv
19	4	WWFS5/16	Washer, Flat SAE 5/16	36	1	011-008A	Plate Sleeve Support
20	5	0411-1608	Standoff, Medium	37	1	SSWFP06080	Scr,Fl Wd Ph No.6x1 1/4
21	2	WWL5/16	Washer, Lock, 5/16	38	5	WWF1/4	Washer, Flat
22	1	0411-1605	Edge Guide	39	1	211-101A	Belt, Urethane

211-123 Narrow Belt Idler Assembly

AAC Drawing Number 190701B Rev 3



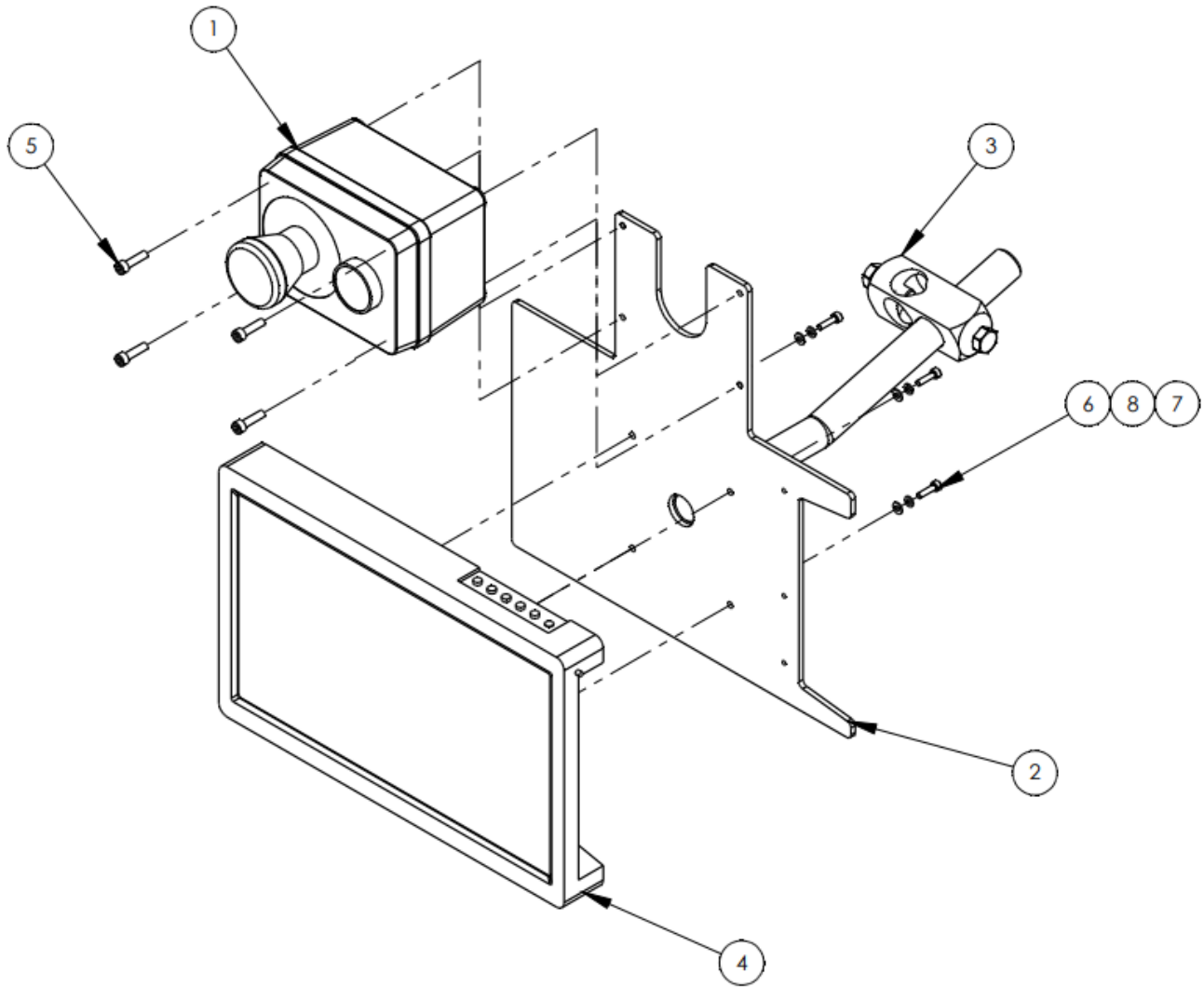
NOTES:

- △ 1. INSERT ITEM 5 FROM INSIDE, 2 PL. CHECK FOR FREE TURN OF ROLLER AFTER COMPLETION OF ASSEMBLY.

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

4082006 HMI Touch Screen Assembly

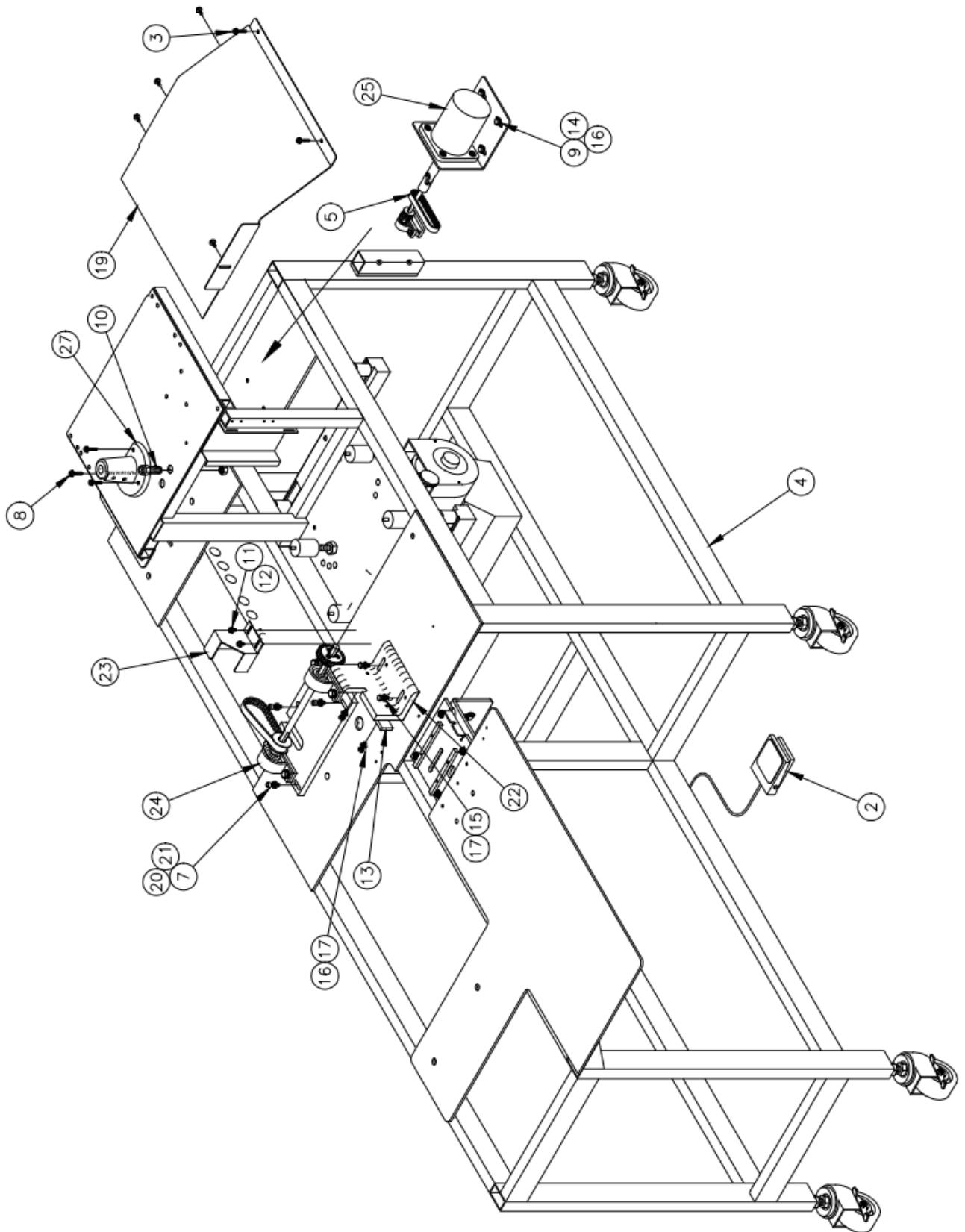
AAC Drawing Number 4082006 Rev 0



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

211-125E Table Sub-Assembly

AAC Drawing Number 191074A Rev 2

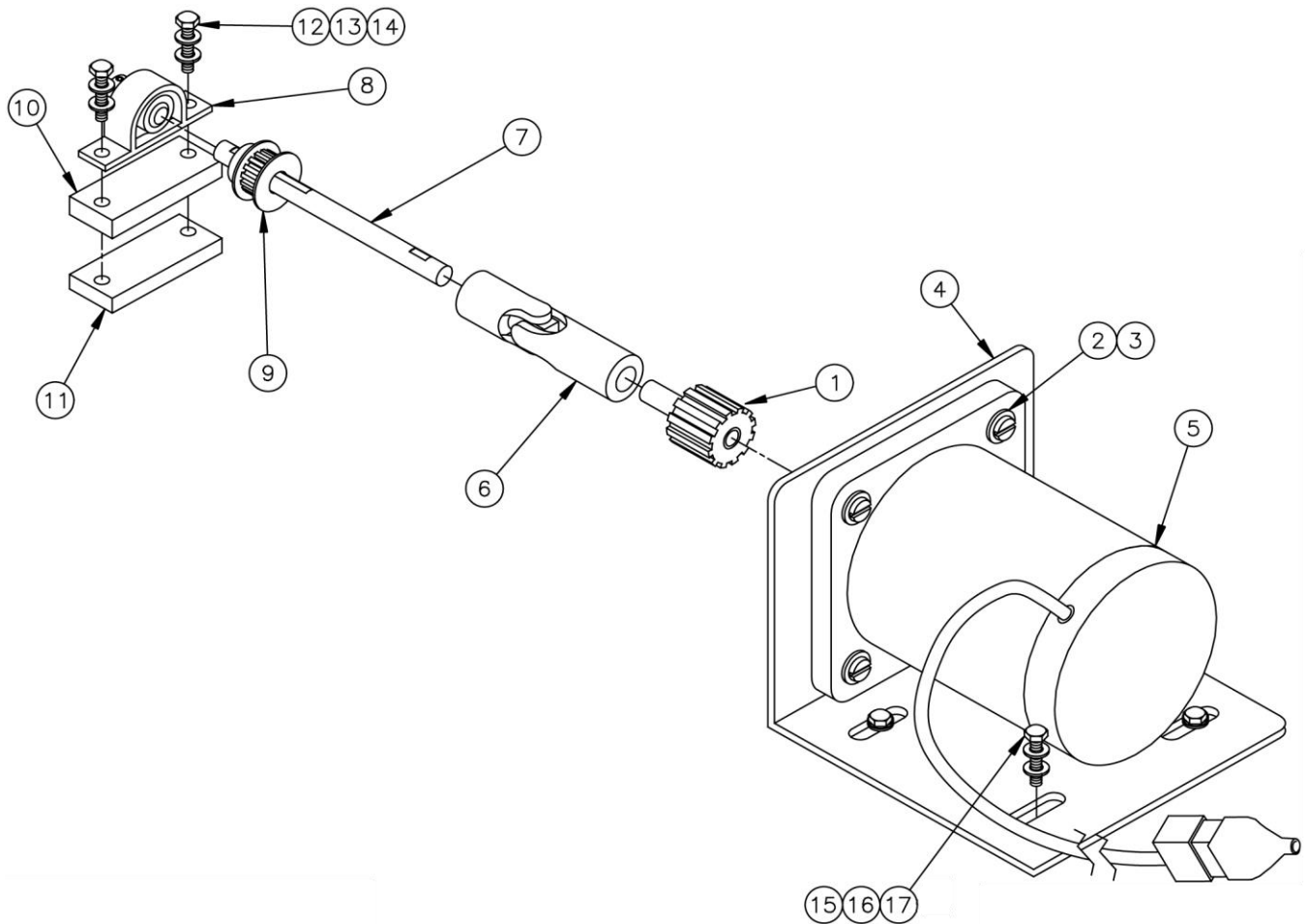


211-125E parts

QTY. REOD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE	QTY. REOD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
4	14	1/4 LOCK WASHER	WWL1/4	1	27	BASE STAND	265157
1	13	SHIM, CONV. MOUNT	011-054		26		
2	12	FLAT WASHER	WWF8	1	25	DRIVE MOTOR	211-G6602
2	11	8-32X3/8	SSPP90024	1	24	TRANSFER DR. ASSY.	211-034
1	10	BULKHEAD	AAQBU-3-3	1	23	TOP COVER, CONV. DR.	211-030
4	9	SCREW, HEX CAP 1/4-20 X 5/8	SSHC01040	1	22	TOP CONVEYOR MT	211-029
3	8	SCREW, FLAT CAP ALLEN 1/4-20 X 3/4	SSFC01048	3	21	5/16 LOCK WASHER	WWL5/16
3	7	SCREW, HEX CAP 5/16-24 X 1	SSHC20064	3	20	FLAT WASHER	WWF5/16
	6			1	19	PULLER COVER	011-006A
1	5	GEAR BELT	GG285L050	1	18	DIAGRAM, PNEUMATIC	211ES-PD
1	4	BOTTOM SIDE ASSY	211-124E	4	17	SCREW, HEX CAP 1/4-20 X 7/8	SSHC01056
5	3	SCREW, HEX SHEET METAL 10-16 X 1/2	SSZS93032	6	16	1/4 SAE WASHER	WWFS1/4
1	2	DIAGRAM, WIRING, SBUS, EFKA	211PS-WD2	2	15	FLAT WASHER	WWF1/4
1	1	DIAGRAM, WIRING, SBUS, EFKA	211ES-WD2				

211-G6602 Drive Train Assembly

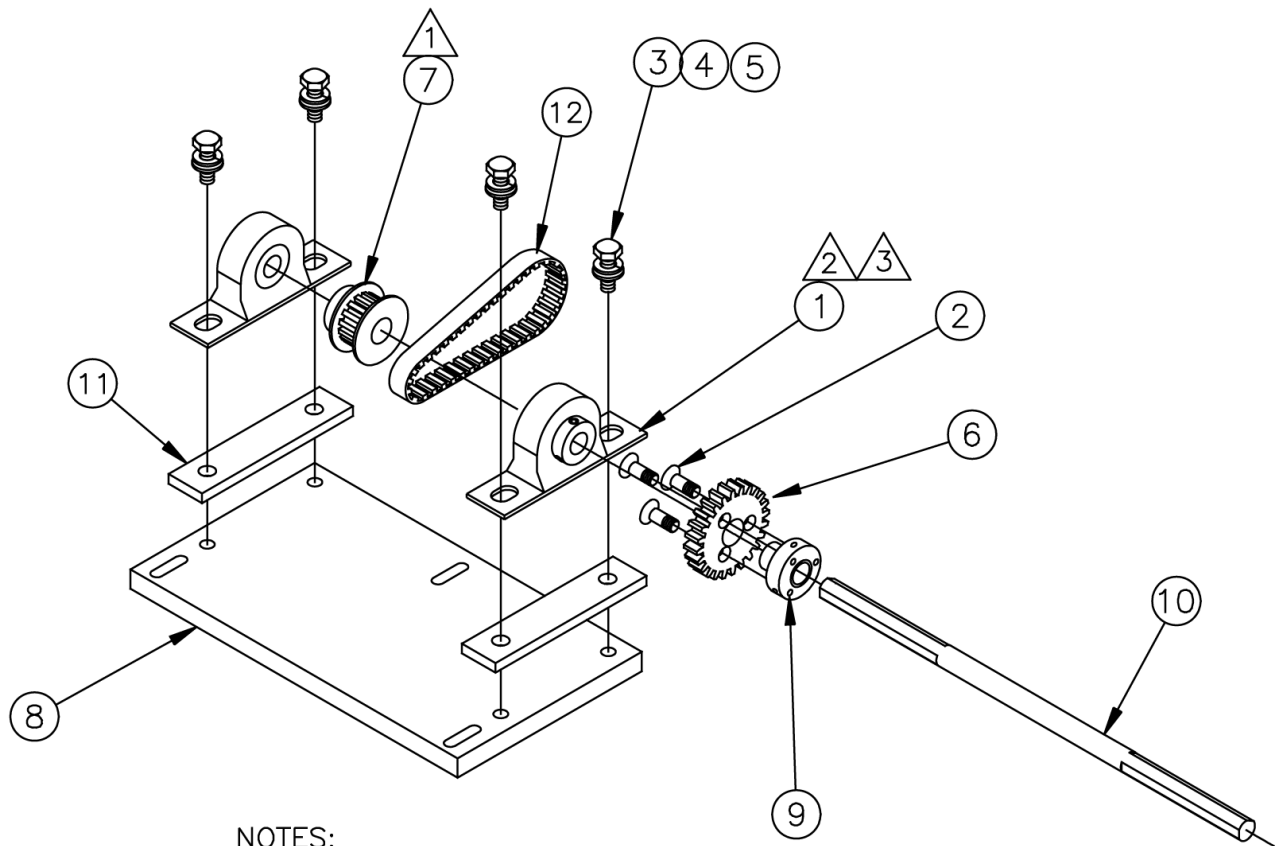
AAC Drawing Number 190182B Rev 5



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

211-034 Transfer Drive Assembly

AAC Drawing Number 290131B Rev 8



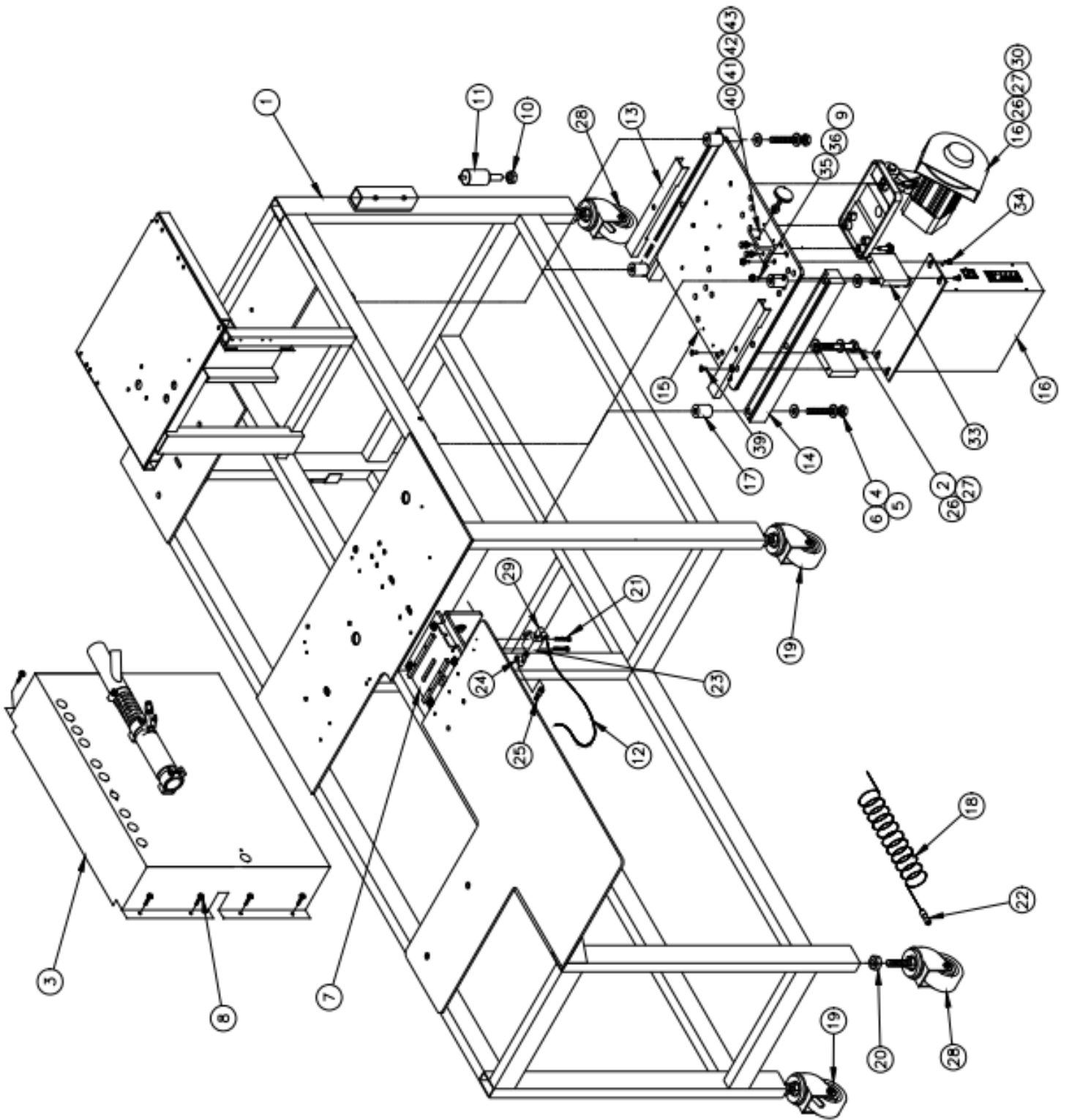
NOTES:

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

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

211-124E Table Sub-Assembly

AAC Drawing Number 191073A4 Rev 2

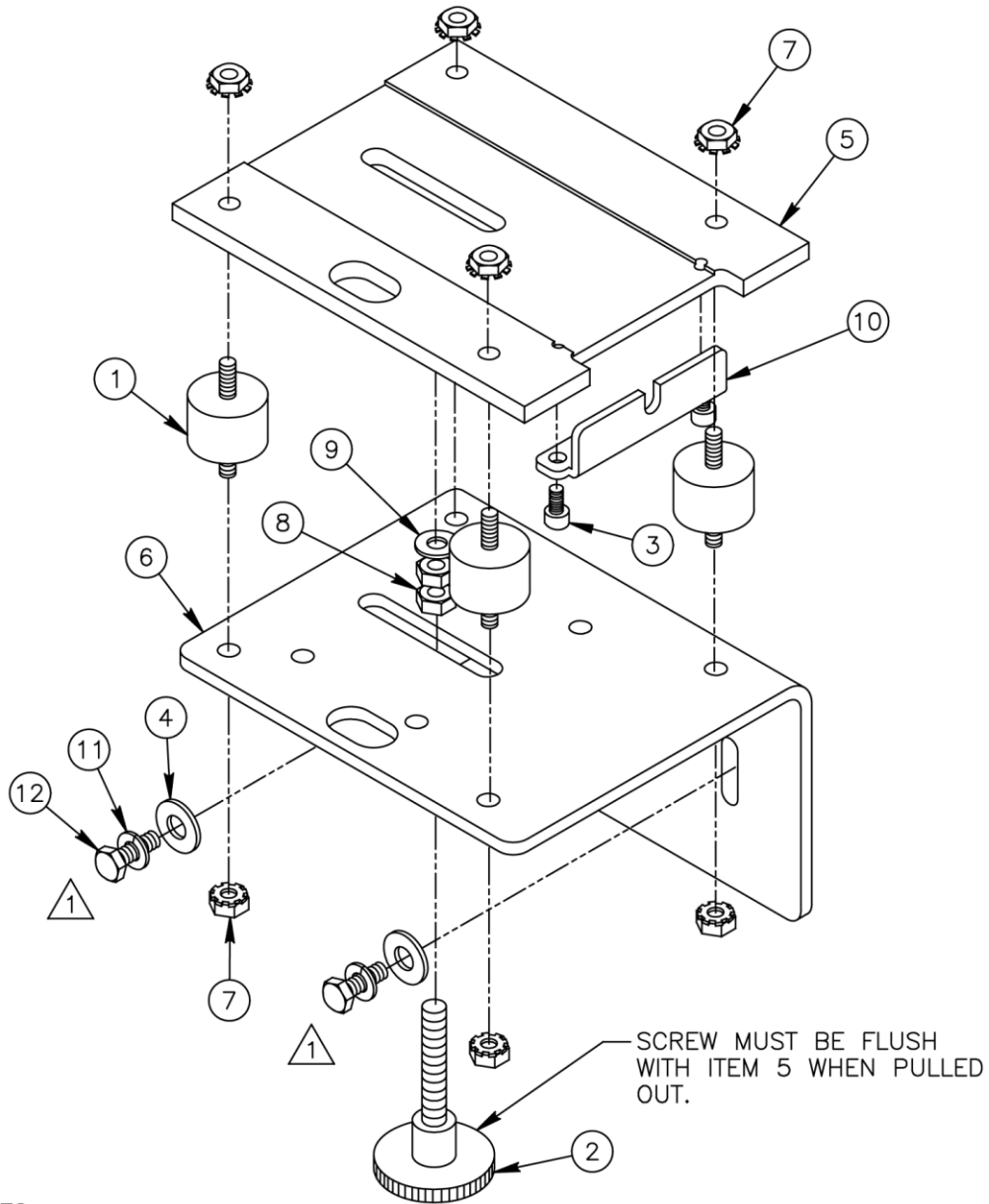


211-124E parts list

QTY. RECD. NO.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE
2	43	LOCK WASHER, 1/4"	WWL1/4
2	42	SCREW, HEX CAP 1/4-20X1/2	SSHC01032
1	41	TORQUE KNOB ASSEMBLY	011-117
1	40	ANGLE BLOCK	011-100
2	39	SCR,FLAT HD,10-32X1/2	SSFC98032
1	38	MOTOR CABLE,SYNC	0211-703A
1	37	MOTOR CABLE,TRDL	010-127D
2	36	FLATWASHER,#10	WWFS10
2	35	SCR,HWX CAP,10-32X1	SSHC98040
4	34	SCR,PAN HEAD, 10-32X3/8	SSPS98024
2	33	SPACER,EFGA BOX	0411-3928
1	32	DIAGRAM,WIRING,SBUS,EFGA	211ES-WD2
1	31	DIAGRAM, PNEUMATIC	211ES-PD
3	30	SCREW, HEX CAP 5/16-18 x 1.0	SSHC10064
1	29	QUICK ELBOW	AAQME-4-8
3	28	CASTER, RUBBER	MM503022LB
5	27	WASHER, FLAT	WWF5/16
5	26	WASHER, LOCK	WWL5/16
1	25	QUICK REDUCER	AAQPR-5-4
1	24	QUICK RUN T	AAQMT-4-8
1	23	SWITCH	AAVMB32
1	22	QUICK UNION	AAQSU-5-5
2	21	SCREW, PAN, HD SLOTTED 6-32 x 1 1/2	SSPS80096
5	20	1/2-13 NUT	NNH1/2-13
2	19	RUBBER CASTER	MMTP113LPS
1	18	COIL HOSE	AAVBG35B
4	17	SPACER	211-140
1	16	EFGA MOTOR	4059-DC1500
1	15	MOTOR HD MT PLATE	013-091
2	14	HEAD/MOTOR SLIDE RAIL	011-098
2	13	CLAMP BRACKET	011-099
3	12	AIRLINE	AATP4-1
4	11	ISOLATOR POST	211-124A
4	10	1/2-20 JAM NUT	NNJ1/2-20
2	9	LOCKWASHER,#10	WWL10
8	8	SCREW, HEX SHEET METAL #10 x 1 1/2	SSZH#10032
1	7	EDGE TRIMMER MT	211-120
4	6	3/8 LOCK WASHER	WWL3/8
4	5	3/8 FLAT WASHER	WWF3/8
4	4	SCREW, HEX CAP 3/8-16 x 3	SSHC25192
1	3	ELECTRONIC ASSEMBLY	211-209
2	2	SCREW, HEX CAP 5/16-18 x 1 3/4	SSHC10112
1	1	WELDMENT FRAME	211-119

211-120 Edge Trimmer Mount Assembly

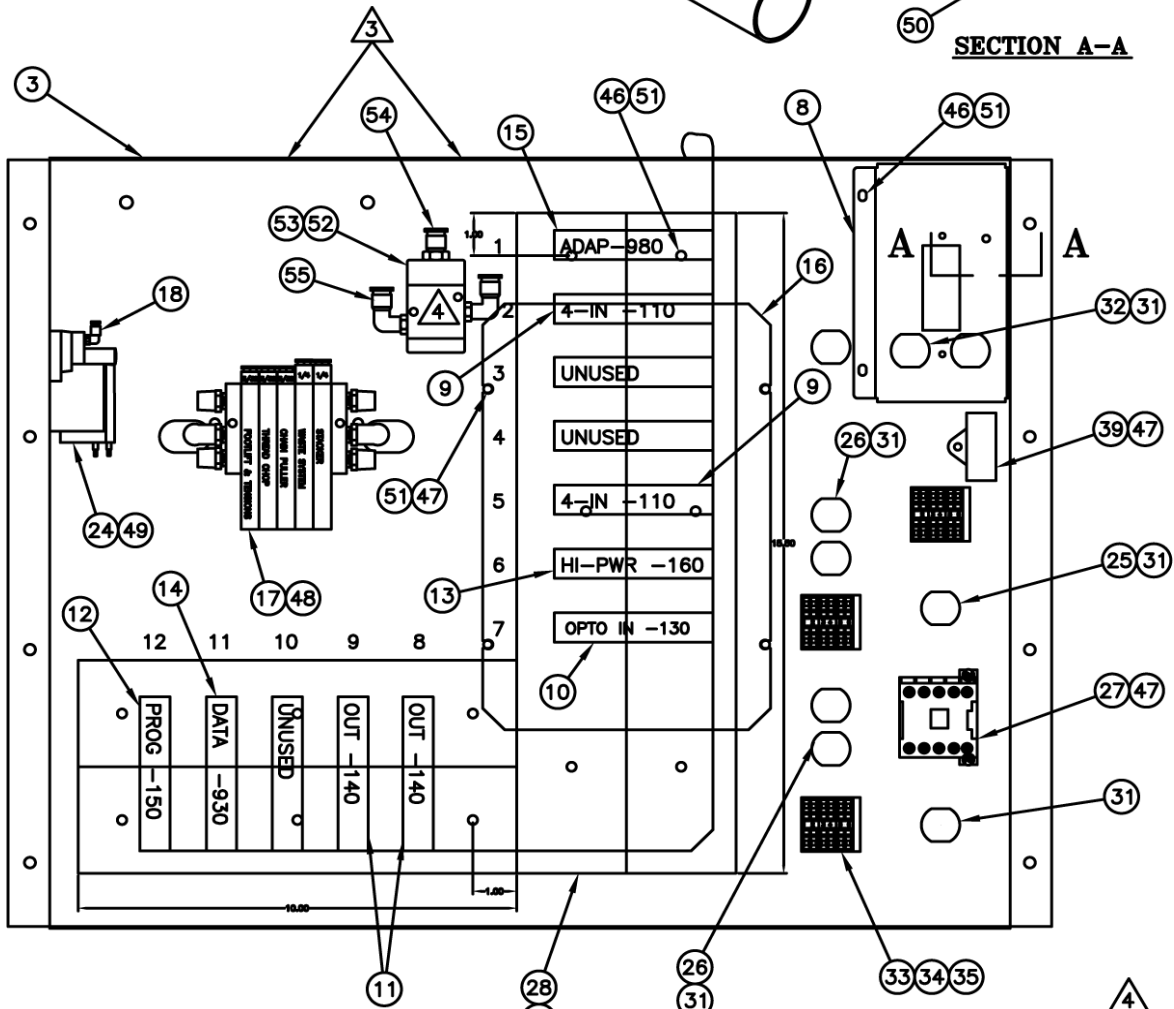
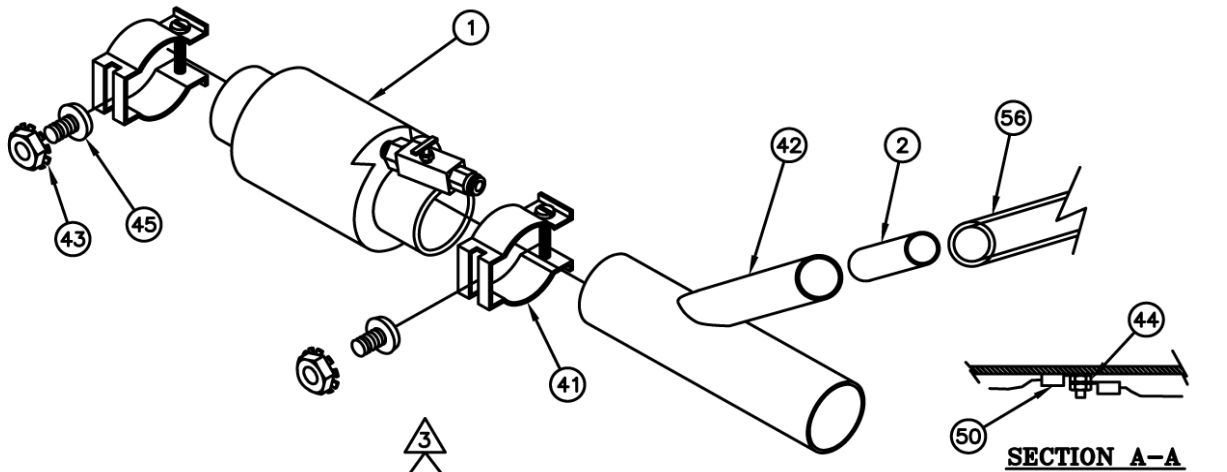
AAC Drawing Number 191009B Rev 7



NOTES:

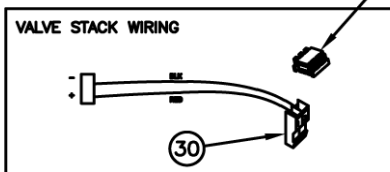
 THESE PARTS ARE FOR MOUNTING TO FRAME.

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	4	MMB6002	Mount, Vibration, Motor	7	8	NNK1/4-20	Nut, Kep, 1/4-20
2	1	TTK32309	TorK Knob-Stub	8	2	NNJ5/16-18	Nut, Jam
3	2	SSSC98024	Scr, So Cp 10-32x3/8	9	1	WWFS5/16	Washer, SAE
4	2	WWFS1/4	1/4 SAE Washer	10	1	211-160	Adjustment Brkt
5	1	010-039A	Plate, Motor Mounting	11	2	WWL1/4	Lock Washer
6	1	0411-1801	Angle, Motor Support	12	2	SSHCO1040	Scr, Hx Cp 1/4-20x5/8



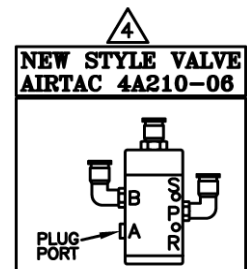
NOTES:

- ▲ NOT SHOWN
- ▲ SEE WIRING DIAGRAM
- ▲ USE DOOR TRIM TO LINE CUTOUTS ON TOP.



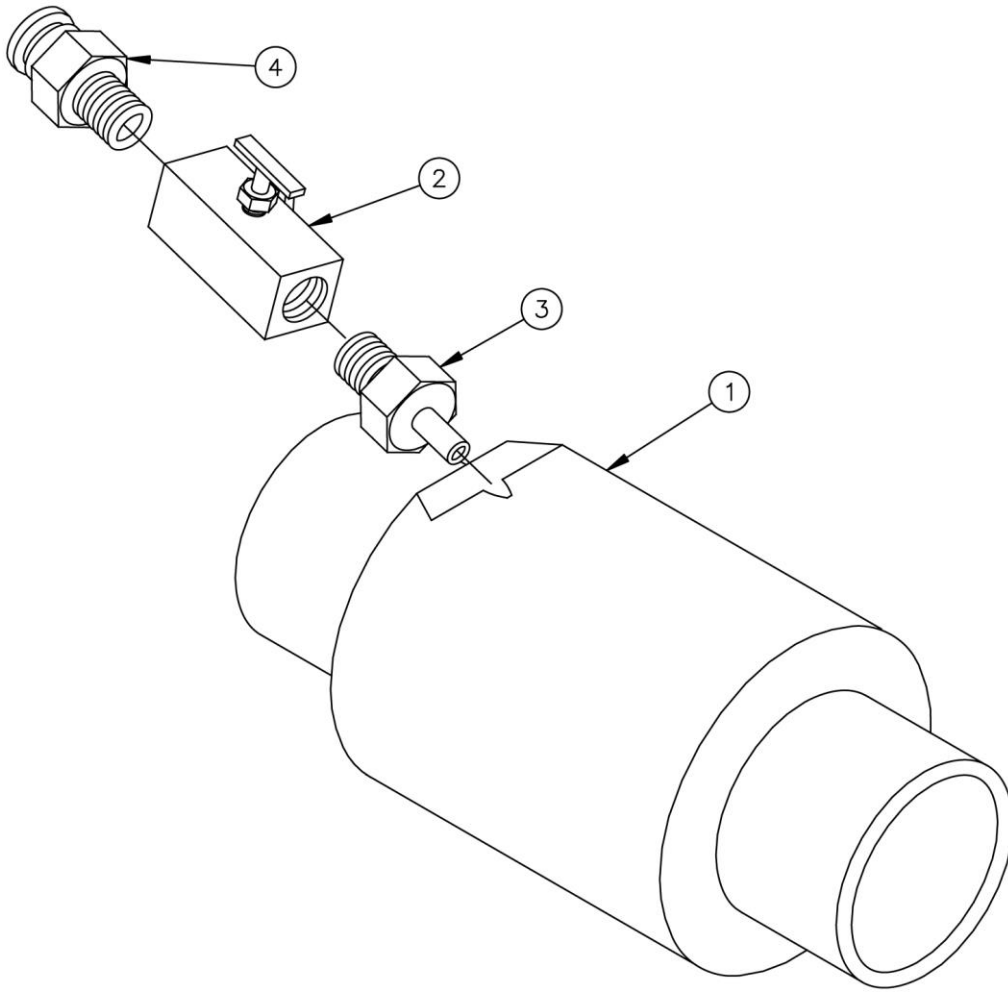
22 AWG, BLK MIN. LENGTH

MODULE #	PNB #
9	1-2, 3-4



211-209 parts list

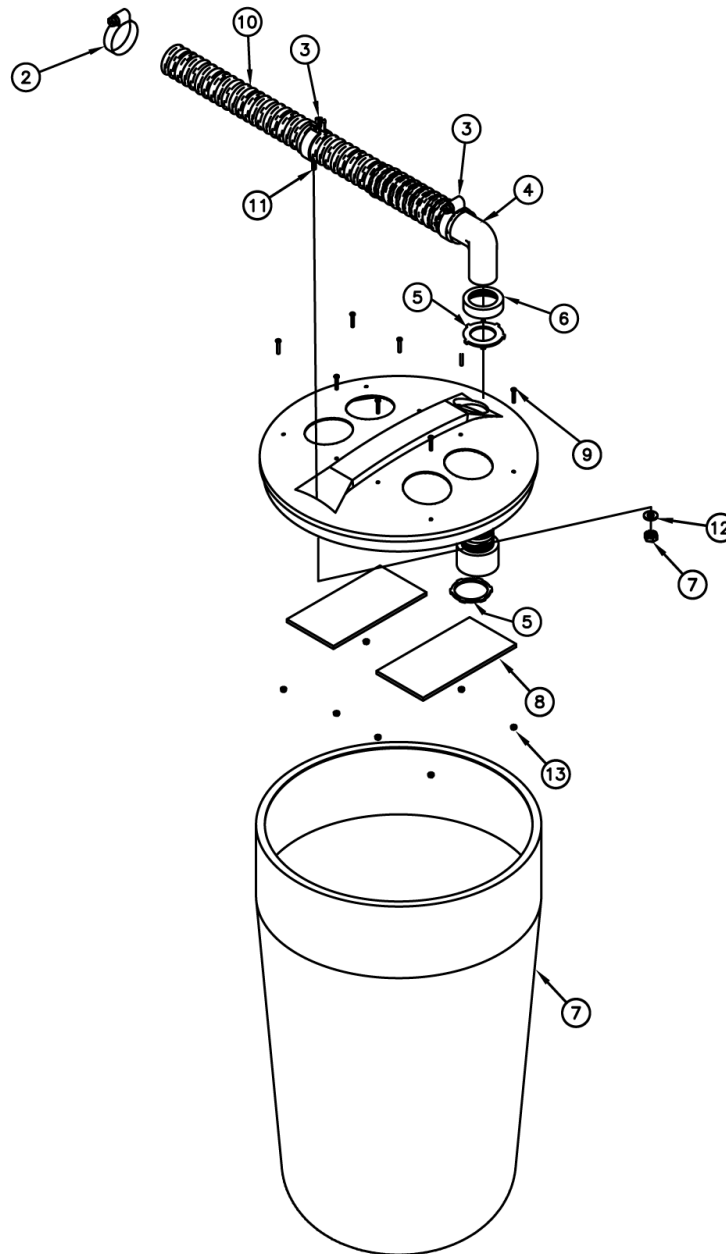
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	0411-1057	WASTE ASSEMBLY	30	6	FF100F2202	CONNECTOR, 2 PIN
2	1	211-132A	TUBE, ADAPTOR	31	9	FF1724	STRAIN RELIEF
3	1	211-204	PANEL, ELECTRICAL	32	20'	FF19510	CABLE, 3 COND.
4	1	211-207	CABLE PACKAGE	33	9	FF264-341	TERMINAL BLOCK
5	1	211ES-LAB1	LABEL,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



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

0411-1300 Waste Container Assembly

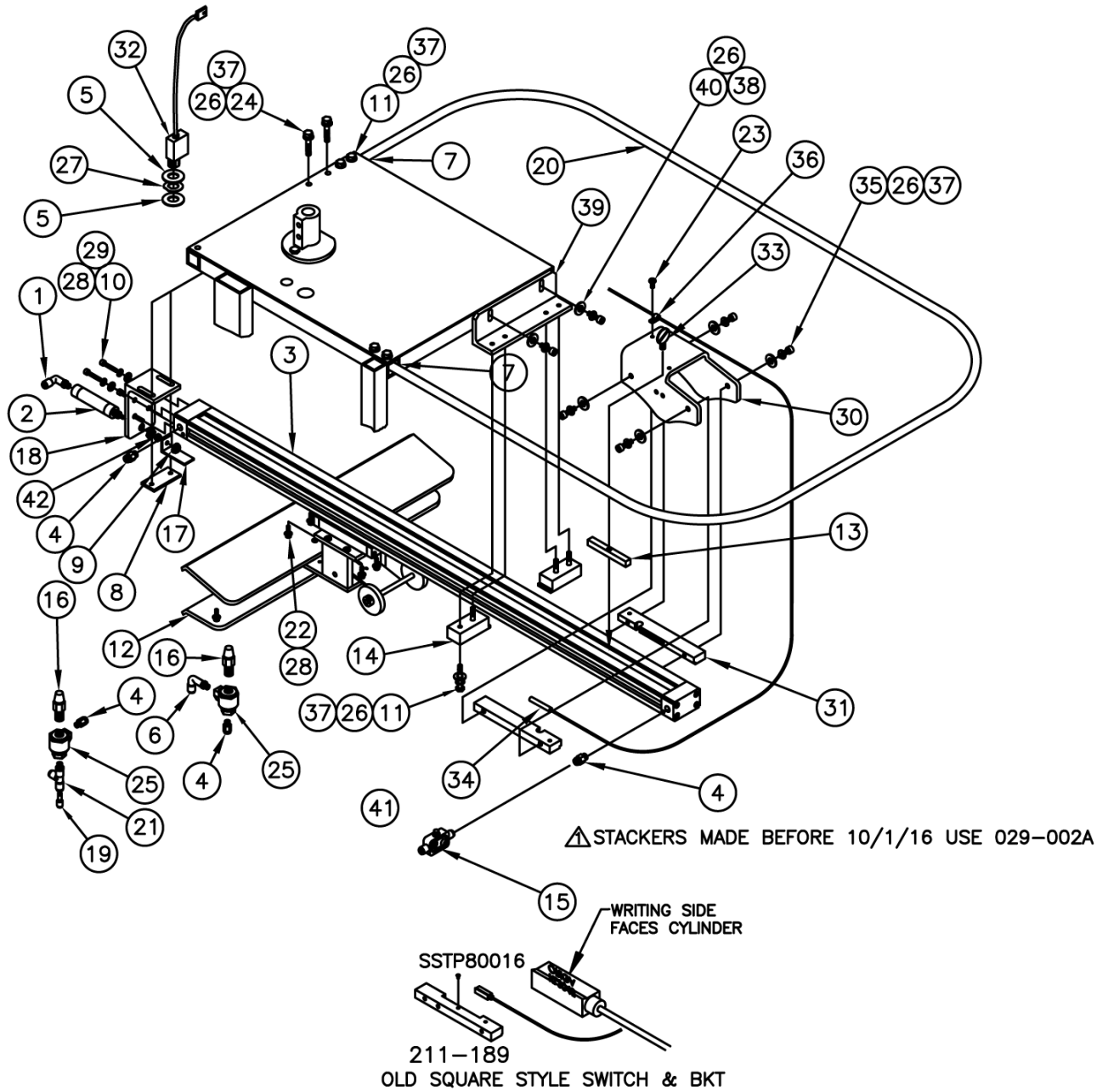
AAC Drawing Number 191225C Rev 10



NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	MMTC32GTAN	CONTAINER, WASTE	8	2	26285A	FILTER, WASTE SYS
2	2	MM5415K16	HOSE CLAMP	9	8	SSPS90064	SCREW, PAN HD SLOTTED 8-32 X 1
3	1	MM16300	TUBE CLAMP	10	6'	MMFH150	FLEX HOSE
4	1	MMRPL150	PLAIN ELBOW	11	1	SSHCO1032	SCREW, HEX CAP 1/4-20 X 1/2
5	2	MMTC32GLN	1 1/2 CONDUIT LOCK NUT	12	1	WWF1/4	WASHER, FLAT
6	1	MMTC32GR	REDUCER	13	8	NNK8-32	8-32 KEP NUT
7	1	NNK1/4-20	NUT	14			

211-151A Stacker, Pick and Stack

AAC Drawing Number 191055B Rev 13

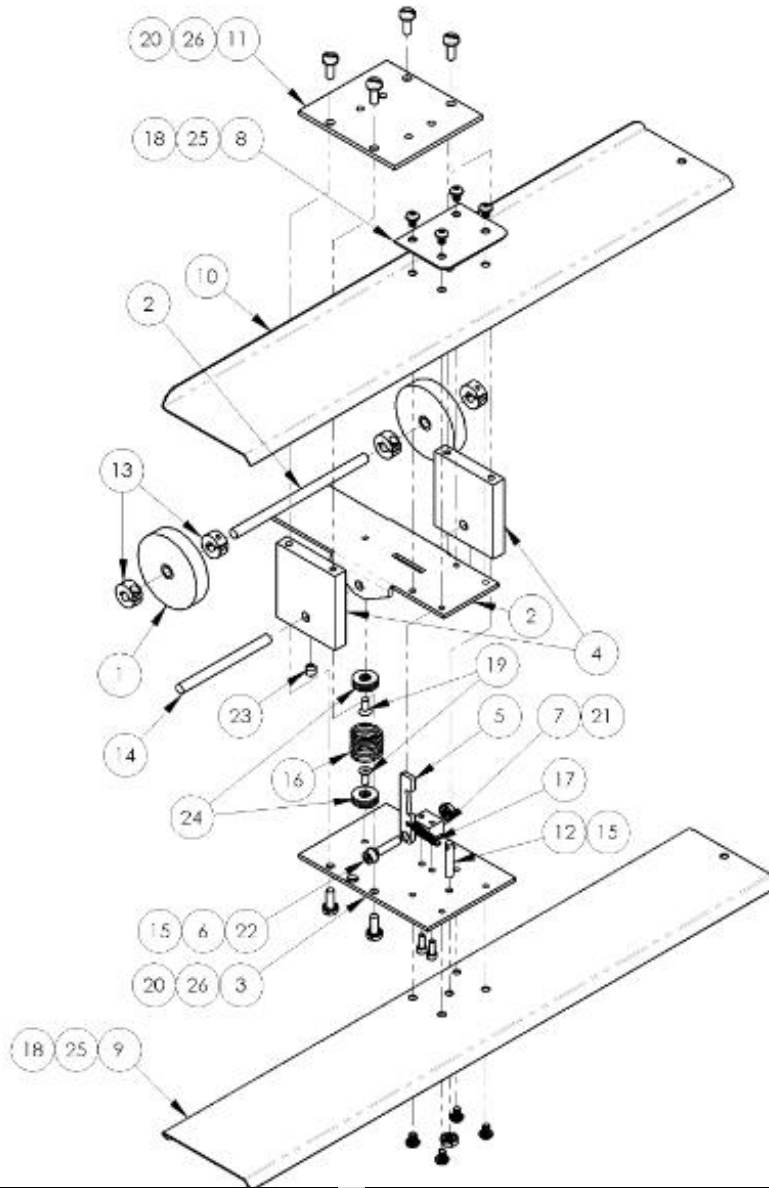


211-151A parts list

NO	QTY	PART #	DESCRIPTION
1	1	AAQME-5-10	QUICK MALE ELBOW
2	1	AAC8SH-.5A	CYLINDER, AIR
3	1	AACR25813	CYLINDER, RODLESS
4	4	AAQMC-4-8	QUICK MALE CONNECTOR
5	2	MM3088A434	SHIM
6	1	AAQME-4-8	QUICK MALE ELBOW
7	2	029-017	ROD, TAPPED
8	1	029-003A	NUT PLATE
9	1	NNE10-32	NUT, ELASTIC,10-32
10	4	SSSCM5X20	SCREW, SOCKET CAP M5-0.8 X 20
11	8	SSHCO1080	SCREW, HEX CAP 1/4 X 1-1/4
12	1	016-014A	CLAMP, MATERIAL, ASSY
13	1	211-145A	PLATE, PRESSURE
14	2	211-186	MOUNT, AIR CYL, REAR
15	1	AA3000F-07	FLOW CONTROL
16	2	MMU002A	MUFFLER
17	1	029-002C	PUSHER, CLAMP CLOSER
18	1	211-185	BRACKET, PUSHER CYL.
19	1	AAQPR-5-4	PLUG IN REDUCER
20	1	029-005	GUARD, STACKER
21	1	AAQMT-4-8	MALE RUN TEE
22	4	SSSCM5X14	SCREW, SOCKET, CAP M5-0.8 X 14
23	1	SSPS98024	SCREW, PAN SLOTTED 10-32 X 3/8
24	2	SSHCO1112	SCREW, HEX , CAP 1/8-20 X 1-3/4
25	2	AAVSQE1	EXHAUST VALVE
26	16	WWFS1/4	WASHER, FLAT, 1/4
27	1	WWSW3/4	WASHER, SPRING
28	8	WWFM5	WASHER,FLAT,M5
29	4	WWLM5	WASHER,LOCK,M5
30	1	211-188	OPENER, CLAMP
31	2	2211097	MOUNT, RAIL OPENER
32	1	FFSM312LVQ	EYE,W/PLUG,STACK
33	1	SSTO01048	SCREW, THUMB 1/4-20 X 3/4
34	1	AACR25813R	SWITCH, REED
35	4	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1
36	4	AAF1/8	1/8" PLASTIC CLAMP
37	16	WWL1/4	LOCK WASHER
38	2	SSSC01096	SCREW, SOCKET CAP 1/4-20 X 1-1/2
39	1	215-5016	MOUNT ANGLE
40	2	NNH1/4-20	HEX NUT,1/4-20
41	1	SSTP80016	SCREW, TRUSS HD PHILLIPS 6-32 X 1/4
42	1	NNJ10-32	NUT,JAM,THIN,10-32

016-014E Material Clamp Assembly

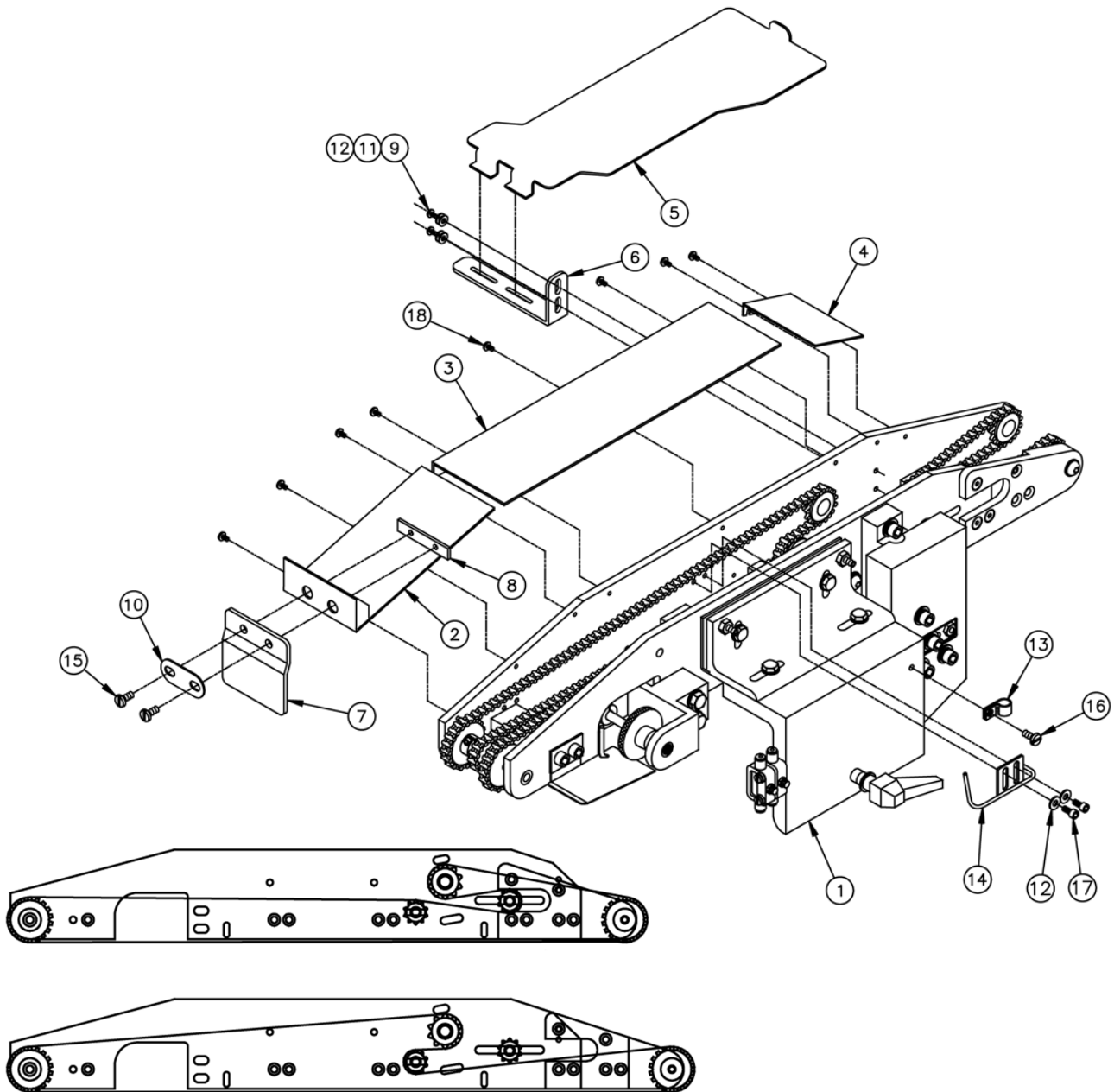
AAC Drawing Number 90071658 Rev 13



ITEM	QTY.	PART NUMBER	DESCRIPTION	ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	013-040	ROLLER,CLAMP OPENER	14	1	IID016X192	DOWEL PIN,1/4 X 3"
2	1	016-015	ASSEMBLY,BRACKET,CLAMP	15	2	NNK10-32	KEP NUT, 10-32
3	1	016-017	BRACKET,BOTTOM,CLAMP JAW	16	1	RRLC055J-7	SPRING,COMP .026X.36X.50
4	2	016-018	SUPPORT,SIDE	17	1	RRLE024B-6	SPRING, EXT, .024X.19X.94 MXLOAD-3.4,
5	1	016-020B	LEVER,TRIP	18	8	SSBC90016	8-32 X 1/4 BUTTON CAP
6	1	016-020B1	BUSHING,16-020B	19	2	SSFC90024	8-32 X 3/8 FL ALN CAP
7	1	016-021	MOUNT,TRIP LEVER	20	8	SSPS98032	10-32X1/2 PAN HD SLOT
8	1	016-022A	STIFFENER FOR CLAMP JAW	21	2	SSSC80024	6-32 X 3/8 SOC CAP SC
9	1	016-022B	CLAMP JAW BOTTOM	22	1	SSSC98056	10-32 X 7/8 SOC CAP
10	1	016-022C	CLAMP JAW TOP	23	2	SSSP01016	SCREW,SKT SET,NYLOCK
11	1	016-068	BASE PLATE,CLAMP JAW	24	6	WWFS1/4	WASHER,FLAT,SAE,1/4
12	1	A-2206A	ROD,TH,10-32,1.0L	25	8	WWSI8	WASHER,INT. TOOTH, #8
13	4	CCCL4F	COLLAR,1/4,CLAMP	26	8	WWSI10	WASHER,INTERNAL TOOTH,10

211-134 Top Conveyor, 2 Belt

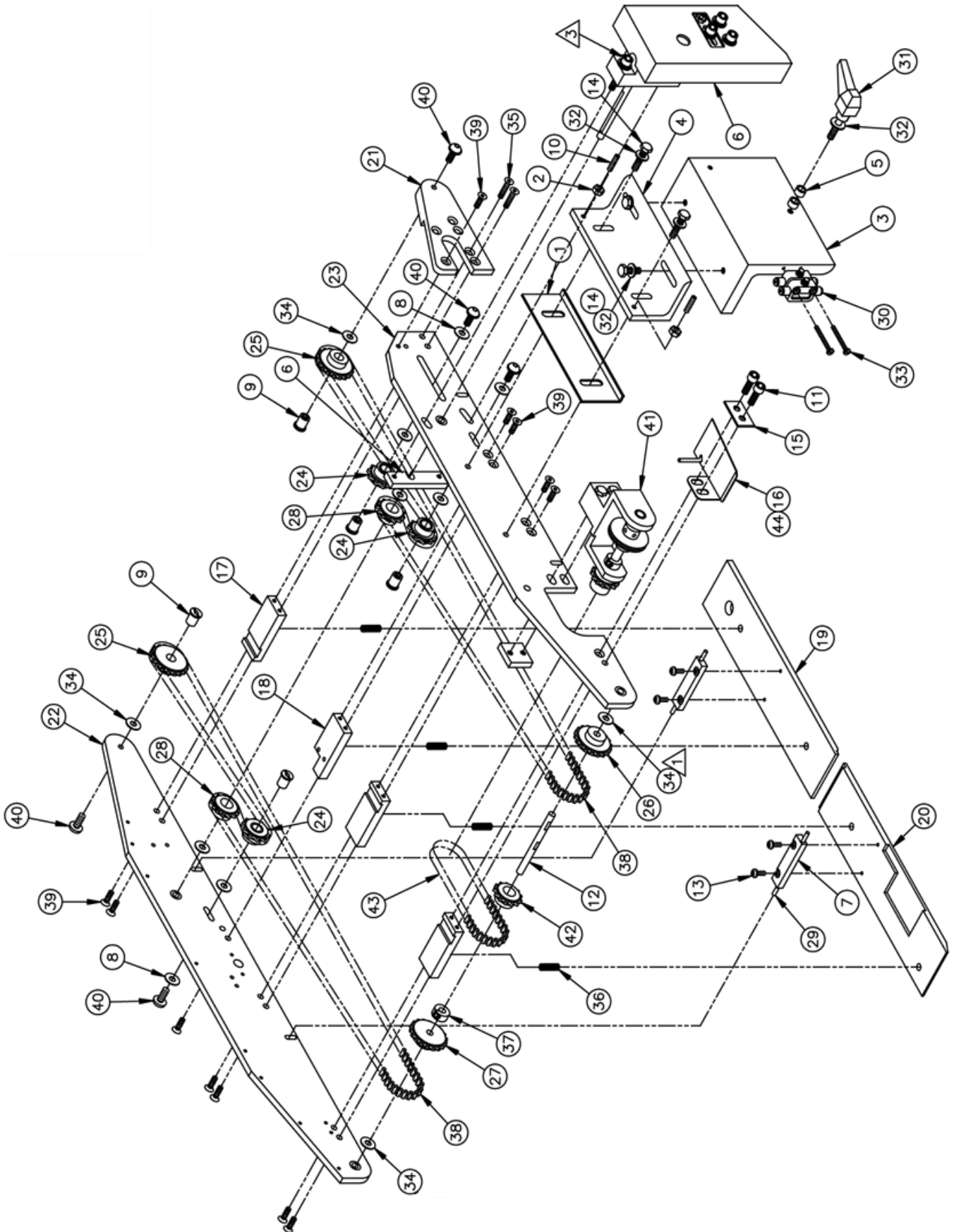
AAC Drawing Number 191307C Rev 12



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

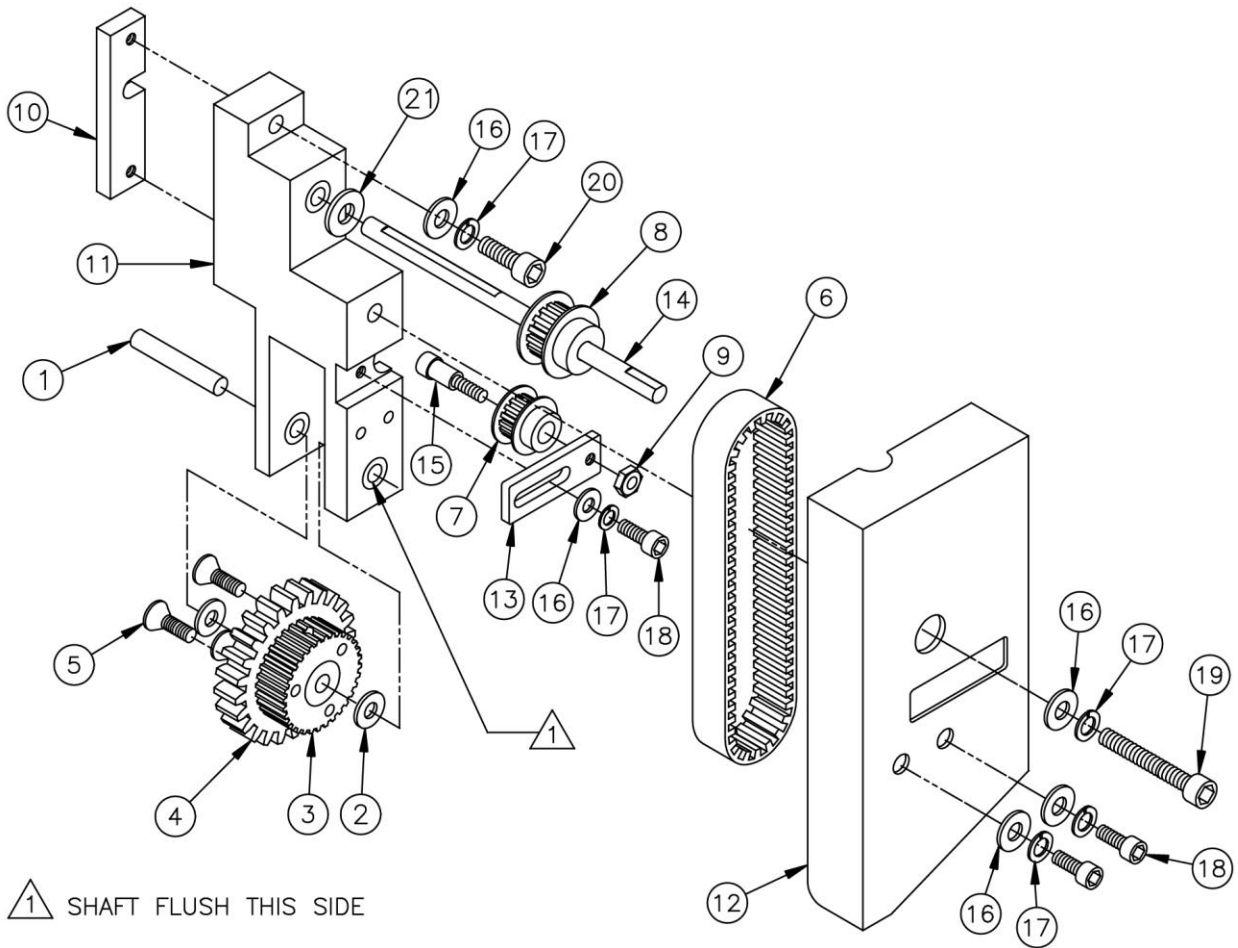
211-171 Top Conveyor Internal Components

AAC Drawing Number 191359C Rev 5



211-171 parts list

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	011-050	BracKet, Adjustment	23	1	211-003	Plate, Right Side
2	2	NNH10-32	Nut, Hex	24	3	211-049	SprocKet, Idler, 10T
3	1	011-052	Top Conv Mount	25	2	011-037	SprocKet, Idler, 18T
4	1	011-051	BrKt, Top Conv Mount	26	1	011-039	SprocKet, Drive, 18T
5	2	011-049	Spacer	27	1	011-040	SprocKer, Idler, 18T
6	1	311-002	Main Drive	28	2	MM66A-13	Sprocket, Drive, 13T
7	2	211-008	Pin Plate	29	4	IIS008x048	Spring Pin
8	3	WWFS10	Washer, Flat, SAE	30	2	AA2000F-03	Flow Control
9	5	011-041	Stud, Idler Sprocket	31	1	TTH32416	Threaded Handle
10	2	SSSS98048H	Scr,So St 10-32x3/4	32	5	WWF1/4	Washer, Flat
11	2	SSSC98048	Scr,So Cp 10-32x3/4	33	2	SSPS80096	Scr,Pn SI 6-32x1 1/2
12	1	211-005	Axle, Front Drive	34	9	BBTRA411	Thrust Washer
13	4	SSPP80024	Scr,Pn Ph 6-32x3/8	35	2	SSFC98048	Scr,Fl Cp 10-32x3/4
14	4	SSHCO1056	Scr,Hx Cp 1/4-20x7/8	36	4	RRLC024C10	Spring
15	1	WWP032	Washer Plate	37	1	CCCL4F	Clamp Collar
16	1	011-154	Material Edge Uncurler	38	2	MM25CCF210	Chain, 52.5 L
17	3	011-032A	Spacer	39	12	SSFC98032	Scr,Fl Cp 10-32x1/2
18	1	011-032B	Spacer, Notched	40	5	SSBC98048	Scr,But Cp 10-32x3/4
19	1	211-007	Plate, Belt Pressure	41	1	311-001A	Feed Wheel Assy
20	1	211-006	Plate, Belt Pressure	42	1	MM66A-10	Sprocket, 10T
21	1	211-004	Nose Piece	43	1	MM25CCF040	Chain, 10.0 Long
22	1	211-002	Plate, Left Side	44	0.85	AATP5/32	Airline, 5/32



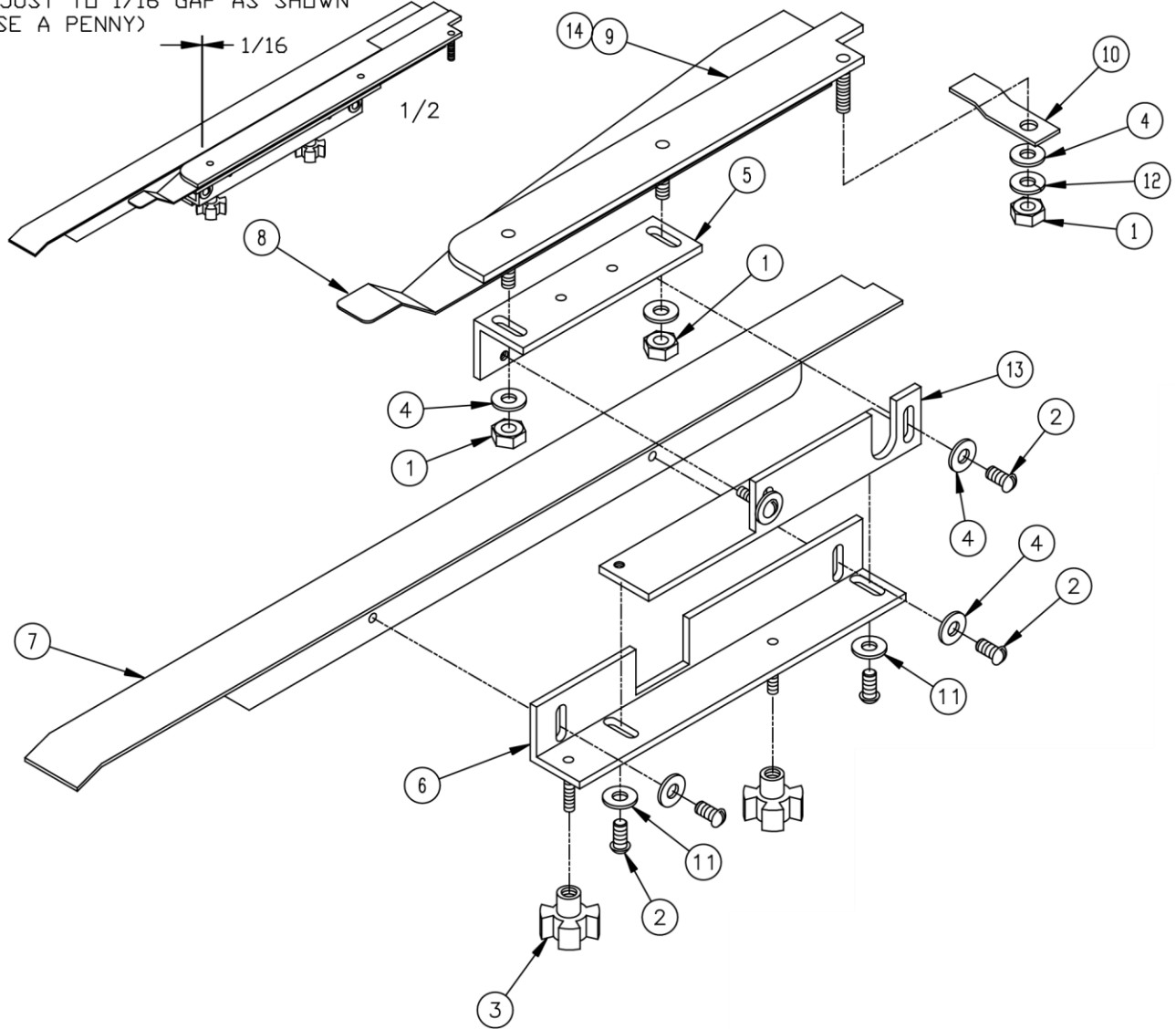
△ 1 SHAFT FLUSH THIS SIDE

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

211-G6606C Hemming Folder Assembly

AAC Drawing Number 190185B Rev 6

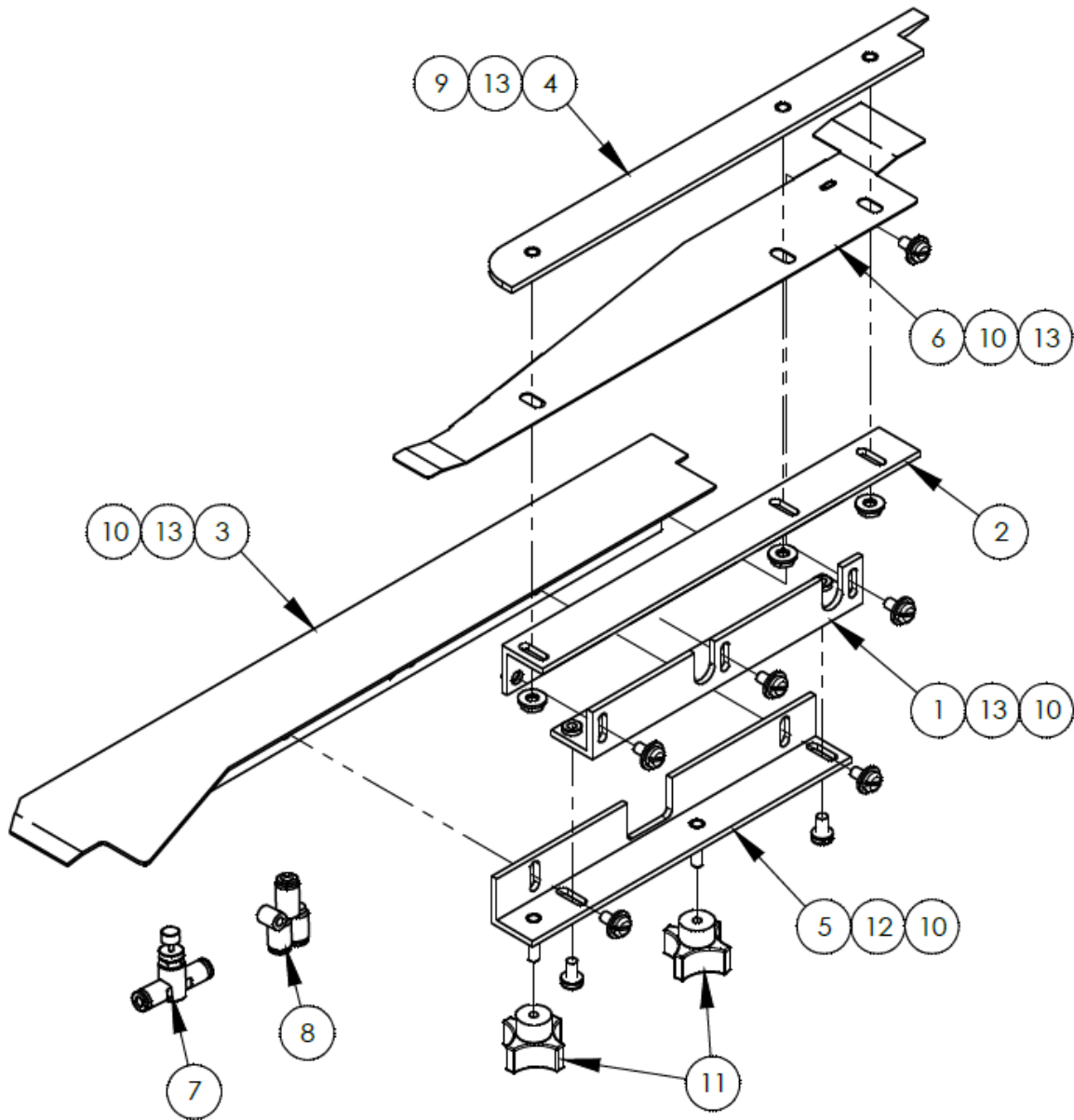
BETWEEN EDGES OF ITEM 7 AND 9
ADJUST TO 1/16" GAP AS SHOWN
(USE A PENNY)



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

211-G66006K48L Hemming Folder Assembly, Long Transition

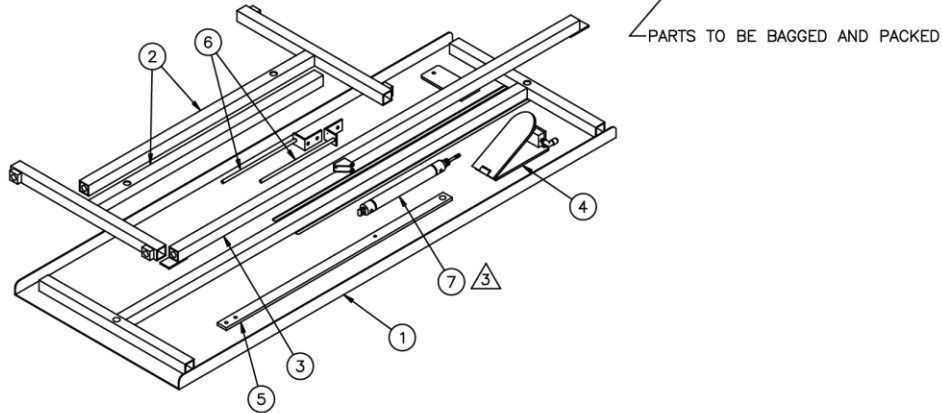
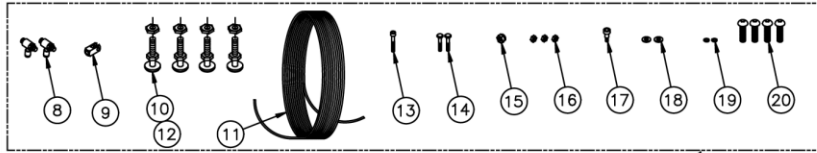
AAC Drawing Number 90081080 Rev 0



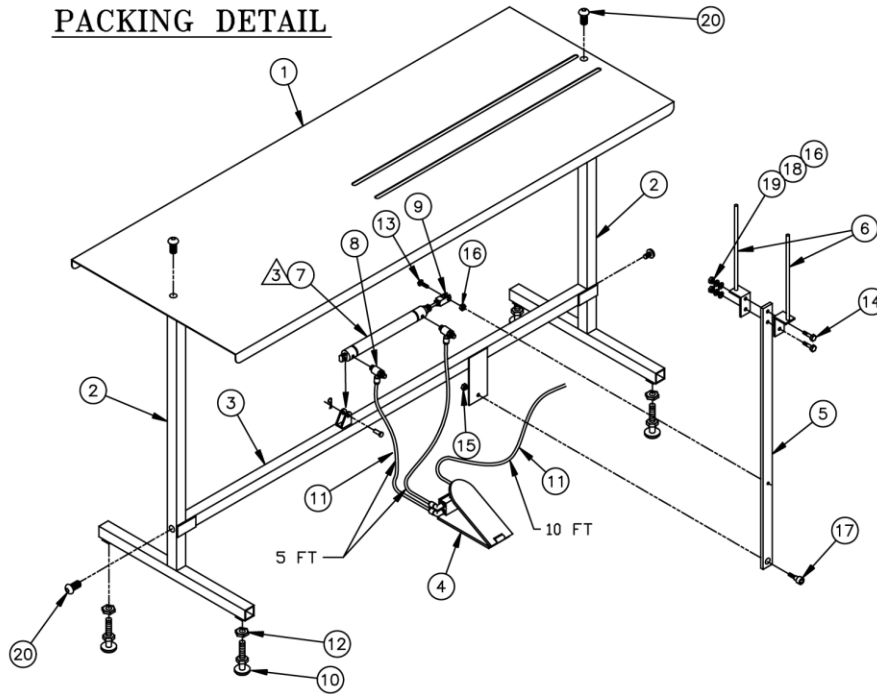
ITEM	QTY.	PART NUMBER	DESCRIPTION	ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	010-022C	BRACKET, FOLDER MOUNT, LONG	8	1	AAQUY-5-5	QUICK UNION Y, 5/32
2	1	010-022E	BRACKET, FOLDER MOUNT, XL	9	3	NNH10-24	HEX-NUT 10-24 REG.
3	1	011-011H4	FOLDER TOP, 3/4 W/EXT TONGUE	10	8	SSPS95024	#10-24 X 3/8 PAN HD SLTD
4	1	011-013D	EDGE GUIDE, RIGHT, .100 THK	11	2	TTCL1BPPK1	KNOB, PLASTIC, #10-24
5	1	211-093	BASE, FOLDER MOUNT BRKT	12	2	WWB5/32	WASHER, FLAT, 5/32", BRAS
6	1	2213051	TONGUE, FOLDER	13	9	WWFS10	WASHER, FLAT, #10, SAE
7	1	AA2001F-03	FLOW CONTROL, INLINE, 5/32				

211-162 Indexing Table

AAC Drawing Number 191010B Rev 4



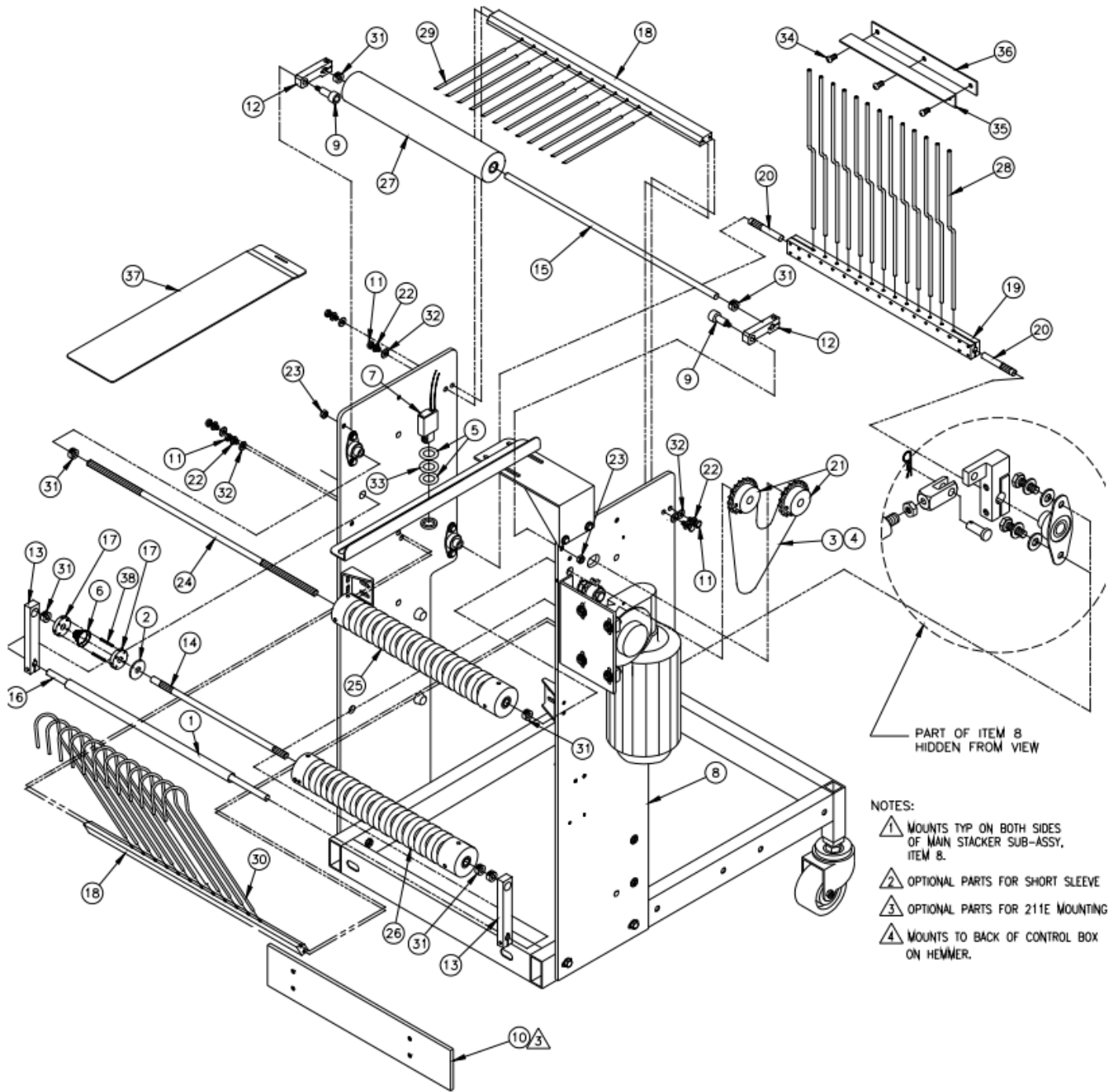
PACKING DETAIL




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

311-006C Fold in Half Stacker Assembly

AAC Drawing Number 190031D Rev 0

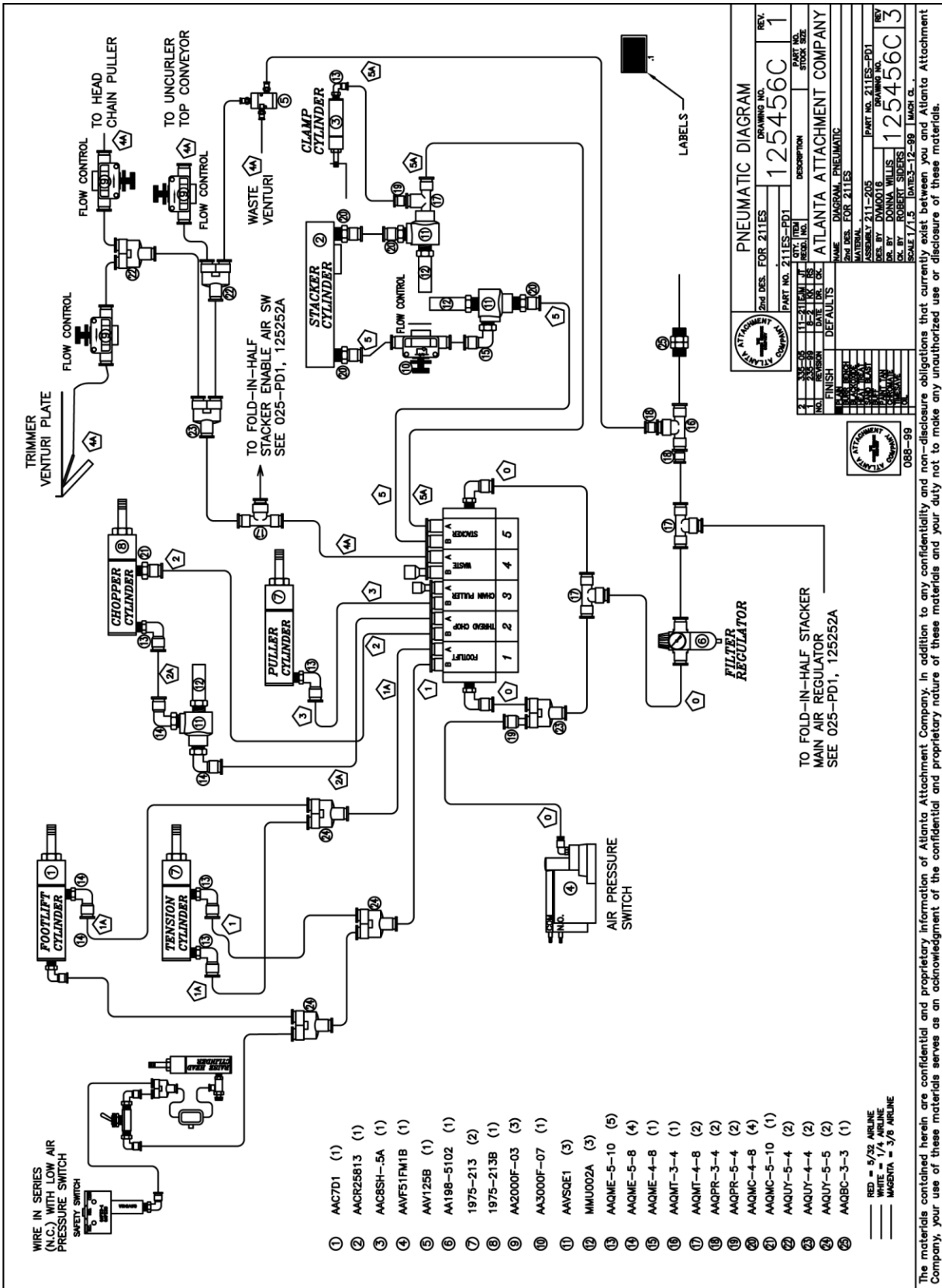


311-006C parts list

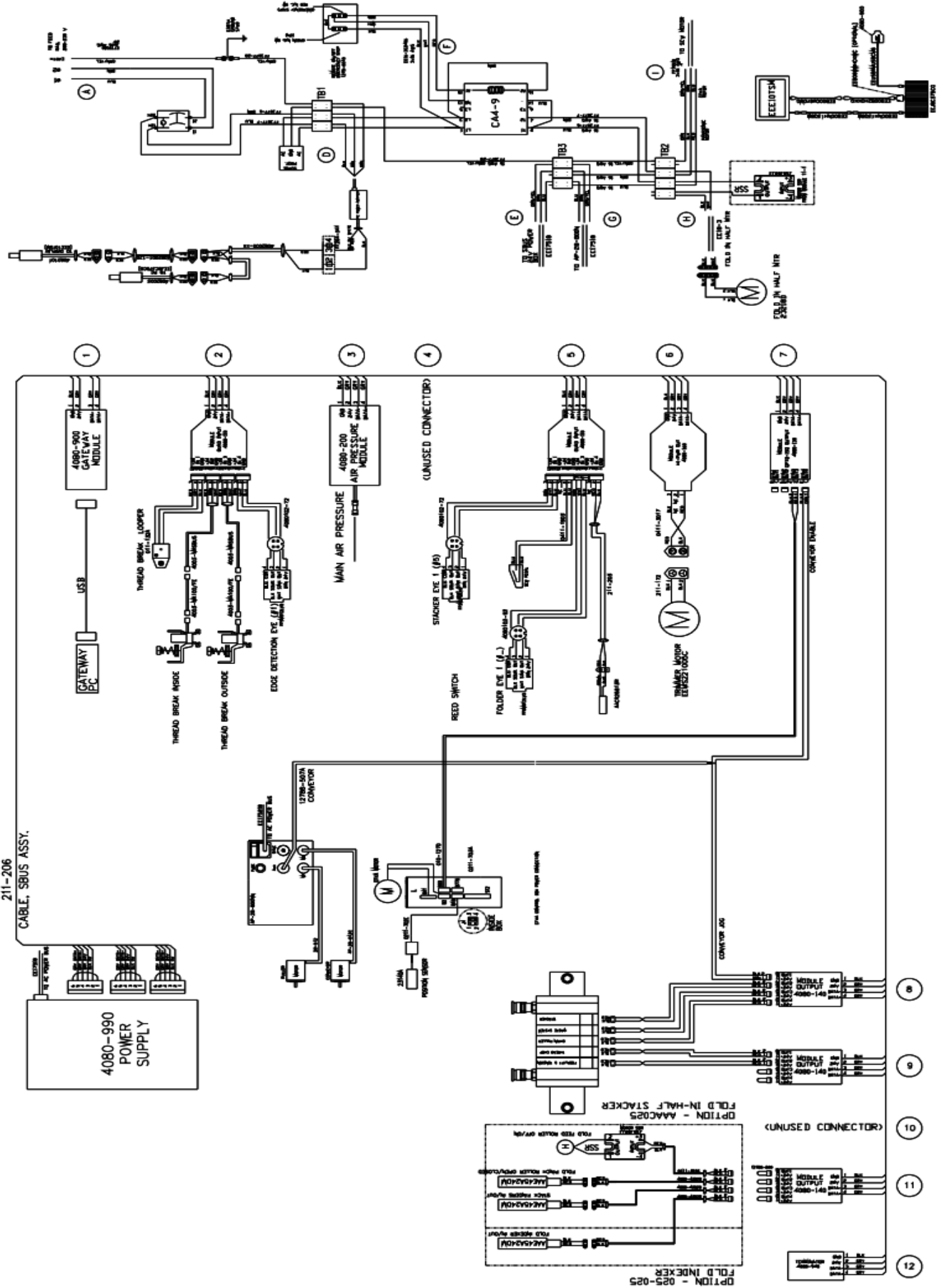
4	1	43	COVER, 4 x 4	K-234
	1	42	BOX, ELECTRICAL	K-233
	1	41	RECEPTACAL, 4 POLE	EET8966
	1	40	PNEUMATIC DIAGRAM	O25-PD1
	1	39	WIRING DIAGRAM	O25-WD4
2	2	38	SPRING PIN 1/8 X 1-1/8	IIS008X072
	0	37	SLED EXTENSION	311-039
	0	36	SHORT SLEEVE STOP MNT	311-041
	0	35	SHORT SLEEVE STOP	311-040
	0	34	SCREW, BUTTIN CAP 16-32 x 1/2	SSBC98032
	1	33	SPRING WASHER	WWSW3/4
	6	32	WASHER	WWF1/4
	7	31	COLLAR	CCCL6F
	12	30	FINGER STRIPPER	O25-017A
	12	29	FINGER, SHELF	O25-016
	13	28	FINGER, FLIP STACKER	O25-014
	1	27	ROLLER, URETHANE	O25-013A
	1	26	ROLLER, CLUTCH DRIVE	O25-011
	1	25	ROLLER, MAIN DRIVE	O25-010
	1	24	AXLE, MAIN DRIVE	O25-009
	2	23	5/16-18 JAM NUT	NNJ5/16-18
	6	22	WASHER LOCK	WWL1/4
	2	21	SPROCKET, MOD.	O17-039
	2	20	AXLE, FLIP STACKER	O17-032
	1	19	MOUNT, FLIP STACKER	O17-030
	2	18	MOUNT, STRIPPER FING.	O17-027
	2	17	CLUTCH DISC	O17-024
	1	16	AXLE, PIVOT CLUTCH	O17-023
	1	15	AXLE, IDLER	O17-022
	1	14	AXLE, CLUTCH DRIVE	O17-021
	2	13	ARM, CLUTCH DRIVE	O17-019
	2	12	ARM, IDLER ROLLER	O17-017
6	11	SCREW, HEX CAP 1/4-20 x 1/2	SSHCO1032	
1	10	DROP ADAPTOR	211-175 	
2	9	SCREW, ALUM SPOKED 5/8 x 3/4, 5/16-18	SSAS024048	
1	8	MAIN STACKER SUB ASSY	311-006D	
1	7	ELECTRIC EYE	FFSM312LV	
1	6	SPRING	RRBEEHIVEM	
2	5	SHIM	MM3088A434	
1	4	CONNECTING LINK	MM35CL	
1.5'	3	SINGLE STRAND CHAIN	MM35	
1	2	THRUST WASHER	BBTRA613	
14"	1	HEAT SHRINK	ZTH3/8	
QTY. REQD.	ITEM NO.	DESCRIPTION	PART NO. STOCK SIZE	

Pneumatic and Electrical Details

211ES-PD1 Pneumatic Diagram



211ES-WD2 Wiring Diagram, SBUS AAC drawing # 125982C



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 a la 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 neumática-cas.
- Desgaste normal de piezas como correas, anillos de goma, cuchillas, agujas, etc.
- Ajustes de la máquina en relación con 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.



Atlanta Attachment Company
362 Industrial Park Drive
Lawrenceville, GA 30046
770-963-7369
www.atlatt.com

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