

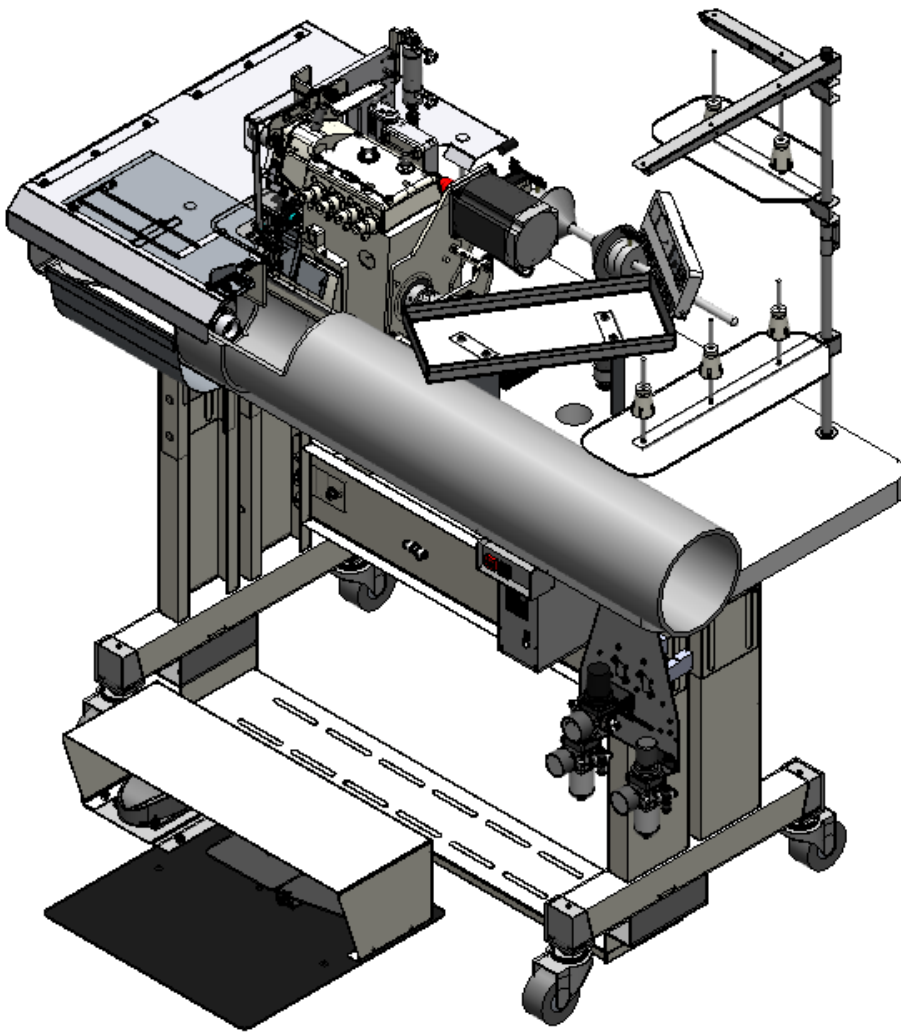


Model:

# 1337HEJ

Revision 2 August 2,2023(wr)

## Technical Manual



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# Atlanta Attachment Company, Inc.

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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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The sale of this product does not sell or otherwise transfer any license or other rights under any U.S. Patent or other corresponding foreign patent.

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

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## 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 Workstation 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.

## Safety

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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

## Safety

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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.

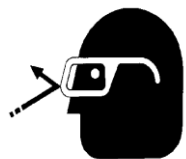
### Signs on the Machine

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.

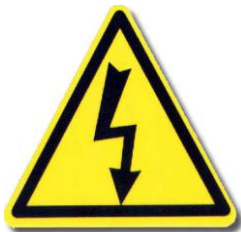
The following fire extinguishers may be used:

- 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.

## Safety

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### **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.

## Safety

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### 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.

## Safety

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### 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 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.

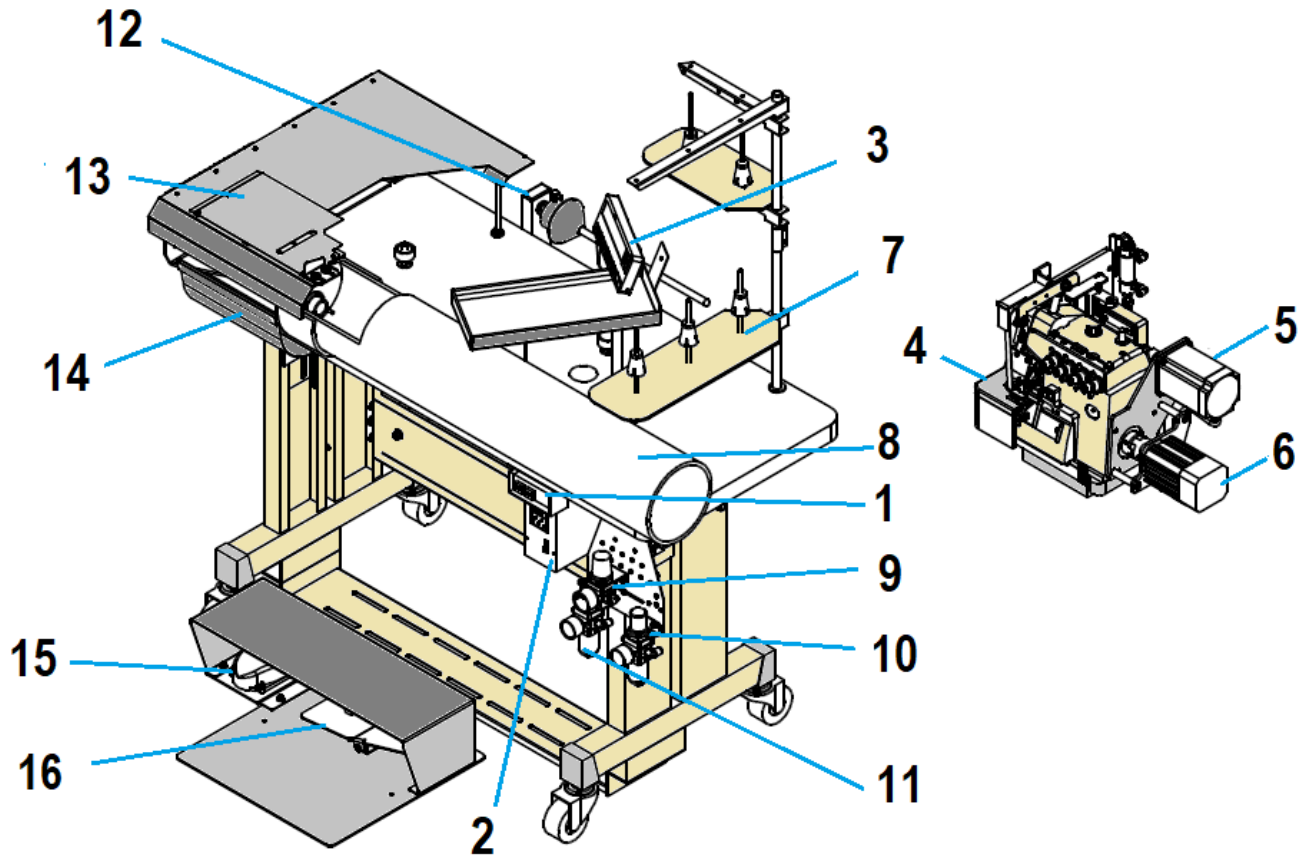
ALWAYS wear adequate eye protection when servicing the hydraulic system and battery.

- 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.

# 1. INSTALLATION

**NOTE:** It is important that the machine technician read this manual and is familiar with all the functions and safety concerns of the unit before Installing and operating.

## 1.1. Parts and Components



1. Main Power Switch	2. Motor Control Box.	3. Operator Control Panel	4. Sewing Head
5. Belt Stepping Motor	6. Sewing Head Motor	7. Thread Stand	8. Vacuum Tube
9. Presser Foot Air Regulator	10. Waist Air Regulator	11. Main Pressure Regulator	12. Flanger roll Holder
13. Flanger Front Guide	14. Flanger Lower guide	15. Presser foot air release	16. Sewing Pedal

## 1.2. Technical Data

SPECIFICATIONS / ESPECIFICACIONES	1337HEJA	1337HEJC
Max sewing speed (rpm) / Max velocidad de costura (rpm)	4500	
Factory preset speed (rpm) / Velocidad de Fábrica (rpm)	3500	
Max stitch length (spi) / Max longitud de puntada (spi)	5-6	
Needle system / Sistema de aguja	SN135X722	SN135X5
Needle size / Tamaño de aguja	22/140	
Needle distance / Distancia de aguja	3/4" - 1/4"	5mm x 5mm
Weight of material / Tipo de material	LIGHT / MEDIUM / HEAVY	
Voltage (v/ph/hz) / Voltaje (v/ph/hz)	220V 1PH 60HZ	
Current (amps) / Amperaje (amperios)	5	
Motor type / Tipo de motor	EFKA DC	
Air pressure (psi) / Presión de aire (psi)	70	
Air consumption (cfm) / Consumo de aire (cfm)	6	
Shipping weight (lbs) / Peso de embarque (lbs)	600	
Shipping dimensions (w/l/h, inch) / Dimensiones de embarque (w/l/h, pulgadas)	55 x 60 x 48	

## 1.3. Production

Approximately 90-110 Panels per Hr.

## 1.4. Identification Label

Machine identification is located on top to the table. Its contents are the machine class and the Serial Number.

Serial number is divided as follow.

Example: 208005081657

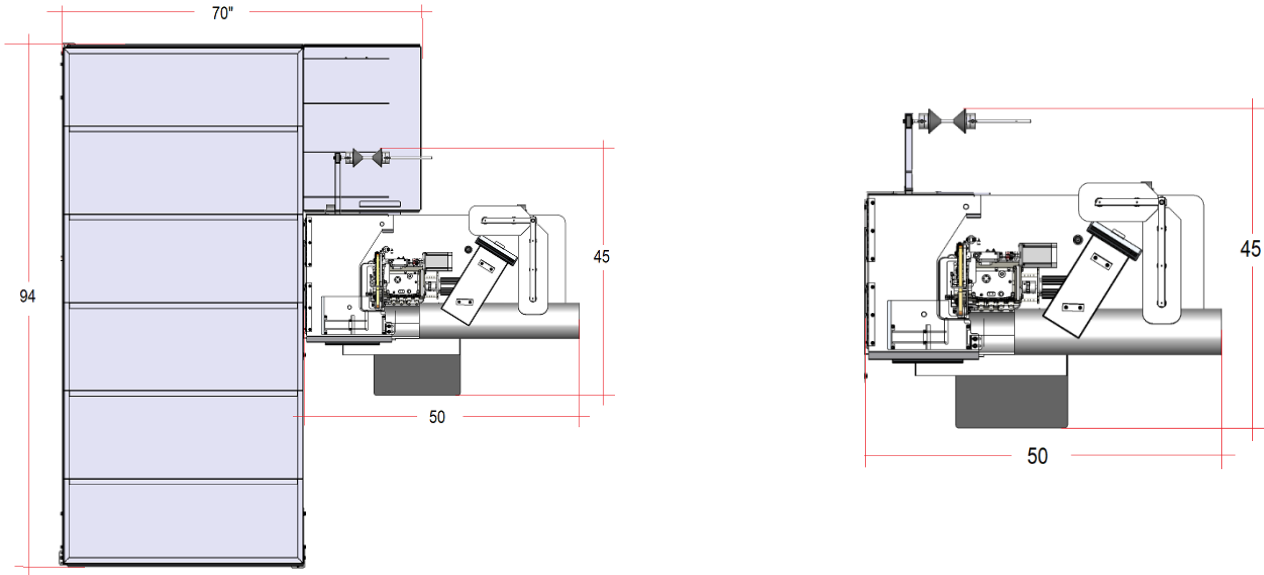
First number identifies the order number  
 Next 2 numbers month of manufacturing  
 Next 2 numbers the year of manufacturing  
 Last 2 are reference numbers

208005  
 (08)  
 (16)  
 (57)


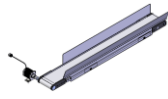

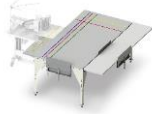

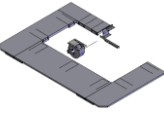



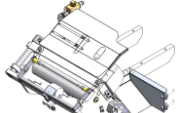


# Installation

## 1.5. Foot print



## 1.6. Accessories

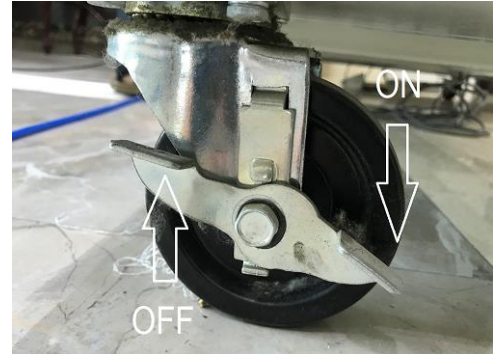
Part Number	Drawing	Description	Part Number	Drawing	Description
11337AT		Single Pneumatic Flotation Table Table: 47" x 94" Back Shelf: 18" x 30.5"	1337930		Waste removal conveyor
1337ATE		Air table double 2 Tables: 47" x 94" each Side Shelf: 48" x 21"	1337KIT13		Matters Panel Measuring Kit
1337ATB		Single air table drop-down shelf: Table: 47" x 94" Back Drop-Down Shelf 26" x 30.5" Front Shelf: 8" x 37"	1337510		Table extension Flat Shelf 142"x83"
1335001		Triple pneumatic flotation table. Table: 96" x 147" Back Shelf: 18.4" x 56.7	1337022		Single air table extension, 18'
1335146		Triple pneumatic flotation table. Table: 96" x 147" Back Shelf: 18.4" x 56.5" Front Shelf: 12" x 30" Insert: 20" x 24"	11337050		Pneumatic flanging cutter



## Installation

### 1.8. Set Up

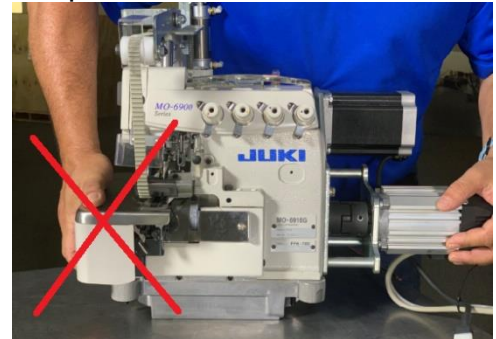
- Remove all shipping straps from machine and all packing material (bubble wrap, foam padding, etc.).
- Inspect the machine for any damage that may have occurred during shipping. If damage is found, report this immediately to your supervisor. Document the damage and provide details and photographs.
- The equipment has a locking wheel system for easy movement in the production area.
  - Pressing the lever in the direction of arrow "ON" locks the wheel and the equipment remains stationary.
  - Pressing the lever in the direction of arrow "OFF" unlocks the wheel and allows the movement of the equipment.
- 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.
- Apply with a clean towel a light coat of oil to all black oxide parts to avoid future



### 1. Sewing Head

Sewing heads has been remove for transportation.

**Attention:** Do not hold the cloth plate cover when carrying the machine.



- Install the sewing head.



- Connect all wires.

**ATTENTION:** Stepping motor cable should be connected on B5 (Stepper motor 1)

- Connect the swing pedal.



## 2. Lubrication

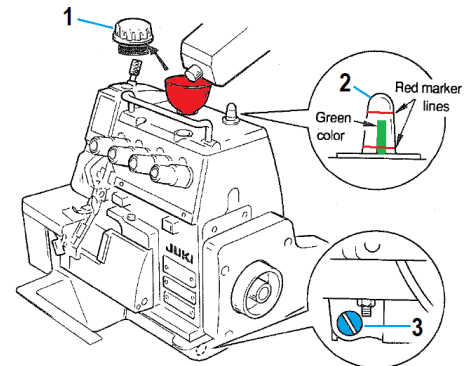
**ATTENTION:** Before shipping, **all the oil in the sewing head should have been drained.** Be sure to supply oil to the sewing head before using the machine.

Follow the lubrication procedures of the sewing head. (ISO Viscosity Grade 22)

- Remove oil cap **1**
- Pour New Oil into the oil reservoir.
- Supply oil until the pointer bar almost reaches the upper red marker line when oil gauge **2** is observed from the side.

**Caution:** Be careful not to exceed the upper red marker line, or else troubles due to excessive lubrication may result.

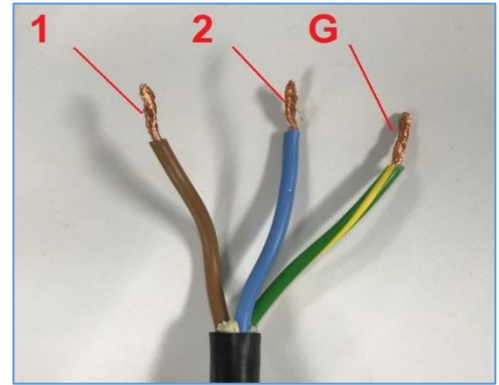
- Remove oil drain cap **3** when draining the oil reservoir.
- Turn the hand wheel of the head and check the freedom of movement.
- Apply two or three drops of oil to the needle bar and upper looper guide when operating the machine for the first time after setup of after a long period of disuse.



## Installation

### 3. Electric Power Supply

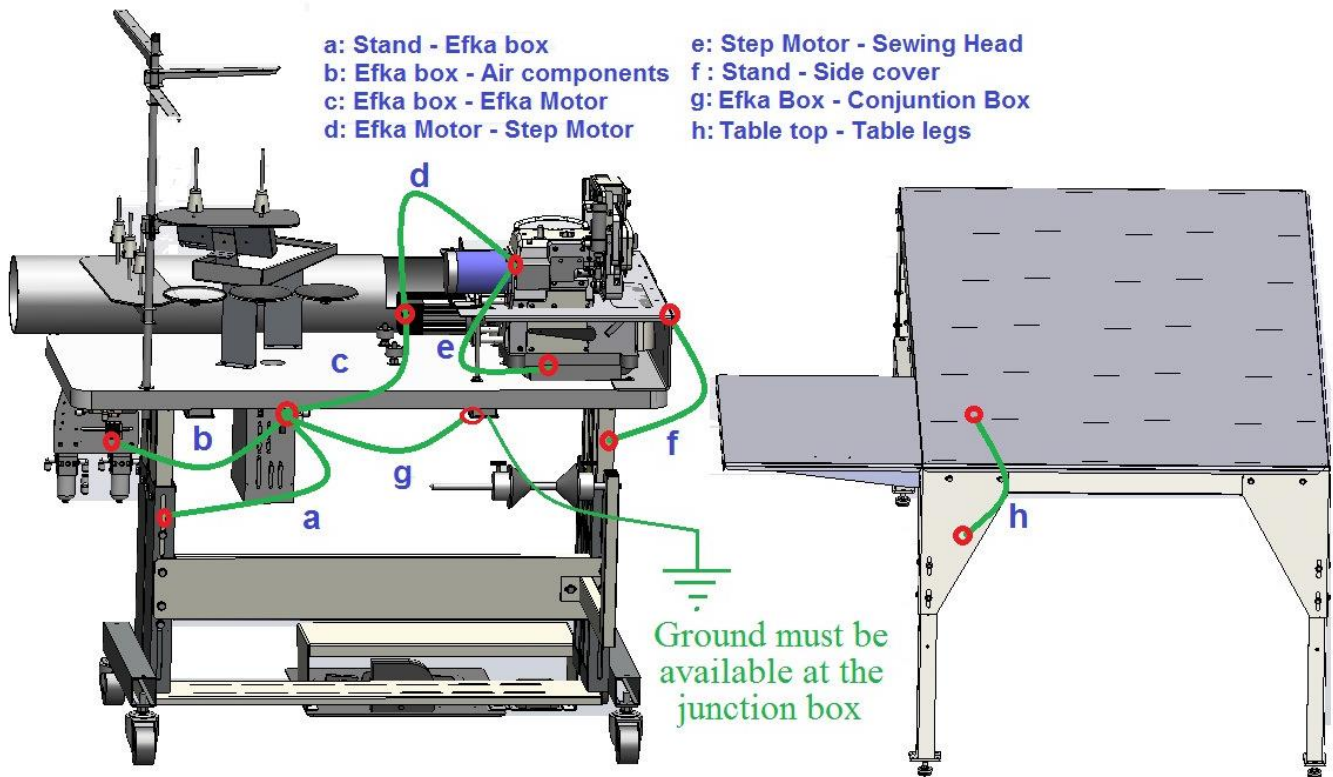
The machine should only be connected to the power grid of the plant by a qualified electrician who is aware of local regulations. Before turning on the main switch, verify that all connections are secure. An isolation transformer can be convenient depending on the state of the power supply. Power requirements: 208-230 Vac, single phase. 5 Amp. Connect wires 1 and 2 to a 220V source and the Green / Yellow "G" wire to ground.



### 4. Grounding

**ATTENTION:** It is extremely important that the green / yellow wire is connected to ground and this at the same time to all the components of the machine.

- Follow the connections according to the following graphic.



## Installation

### 5. Air Supply

**WARNING:** Some moving parts can be activated when opening the valve. Only compressed, dry and filtered air should be used. Make sure that the air pressure always stays within the specified ranges, otherwise, faults can occur.

Feed two 3/8-inch diameter air lines to the air inlet connectors with a pressure greater than 80 psi (8 Bar) and a minimum flow of 6 SCFM per minute. The 80-pound pressure must be maintained throughout the automatic cycle.



#### 1.9. Power “ON”

**WARNING:** The unit will be energized and some moving parts can be activated when turning on the machine.

##### 1. Power Button

Turn the machine “ON” by pressing the green button on the box. Machine will first display on the Efka V820 panel the parameters for the main motor and after couple of seconds the main Operation Screen.

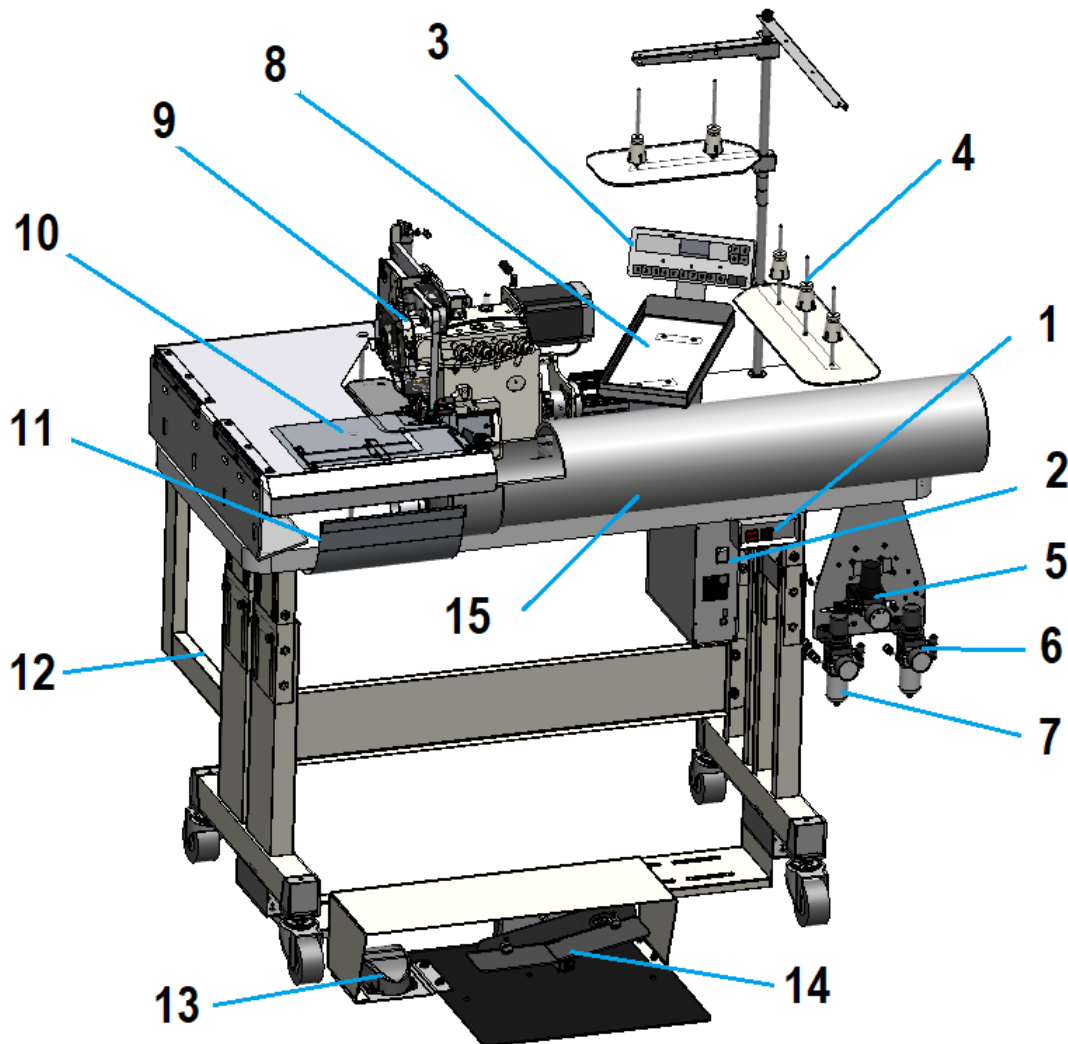


##### 2. Interim Storage

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.

## 2. OPERATION

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



### 2.1. Individual Components

1. Main Power Switch	2. Motor Control Box.	3. Operator Control Panel	4. Thread Stand
5. Presser Foot Air Regulator	6. Waist Air Regulator	7. Main Pressure Regulator	8. Tray
9. Sewing Head	10. Flanger Front Guide	11. Flanger Lower guide	12. Flanger Roll Holder
13. Presser foot air release	14. Sewing Pedal	15. Vacuum Tube	

## Operation

### 1. Main Power Switch



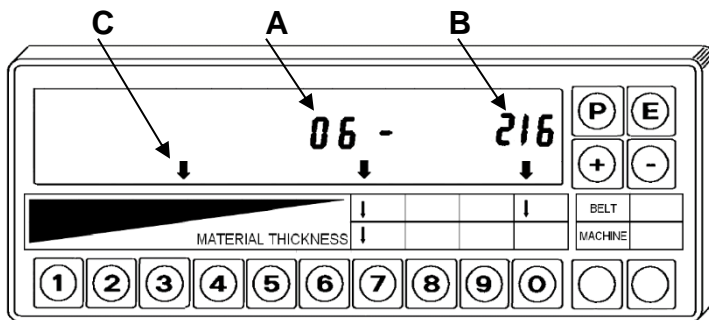
### 2. Motor Control Box.

Should not be touched by the operator. The amber pilot light on the Efka Box should light when the equipment is on.



### 3. Operator Control Panel (V820)

The control panel is responsible for controlling Sewing motor and the Stepping motor.



- A = Belt Feeding Step
- B = Belt Feeding Value
- C = Belt Feed Step Selected

#### a.Function of push Buttons:



Pressing buttons 1 thru 6 to select a different Belt Feeding Step (You will have two Feeding Steps per button). Reference: Step 1 for Heavy materials, Step 12 for Light materials

Position	1	2	3	4	5	6	7	8	9	10	11	12
Step Value	246	240	234	228	222	216	210	204	198	192	186	180

#### 4. Thread Stand

#### 5. Presser Foot Pressure

Control the pressure of the presser foot. (Upper position)



Avoid having too much pressure on it.  
To adjust, proceed as follow.

- Reduce the air pressure through the presser foot pressure regulator and start sewing.
- Increase the pressure little by little until the material is fed correctly (There are no variations in the length of the stitch).
- Once the correct point is found, gain 5 pounds.

**Reference:** medium or light materials at 30-40 PSI, heavy materials at 40-60 PSI.



#### 6. Waist Air Regulator

Control the amount of air blow to the material. (Lower right)  
Adjust that the material is removed from the sewing area. If there is too much you can lose air pressure when sewing.

#### 7. Main Pressure Regulator

Is the main regular. (Lower left) Should Stay in a fix value of 8- PSI. Not required to be touched by the operator. If pressure is lower call the technician.



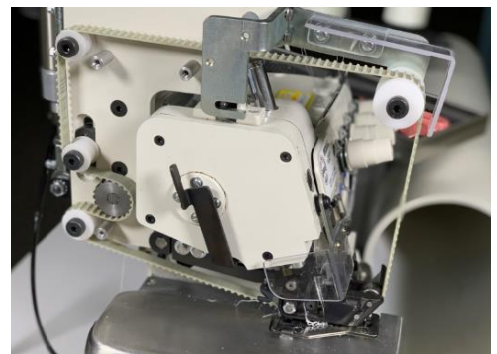
**8. Tray**



**9. Sewing Head**



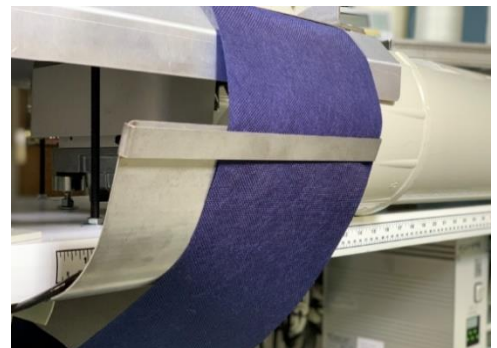
**10. Feeding belt**



**11. Flanger Front Guide**



**12. Flanger Lower guide**



**13. Flanger Roll Holder**



**14. Presser foot air release**



**15. Sewing Pedal**

They are located in the floor. They operate the seamer head. Pressing the left side raise the presser foot. Pressing the right machine start sewing. As much s as is presser as faster as the speed goes.



**16. Vacuum Tube**

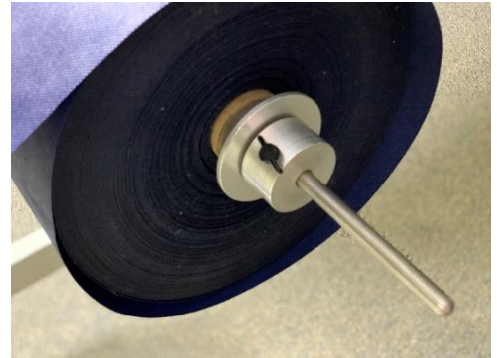


## 2.2. Operation

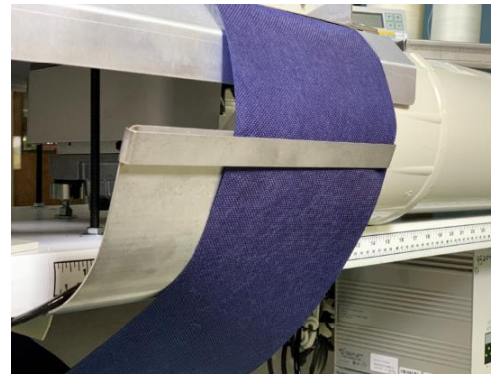
**Attention:** Before threading the machine turn “OFF” the machine.

### 1. Flanger

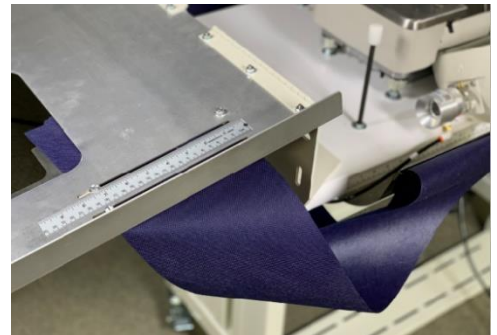
- Load the roll and use the cone to hold it in position



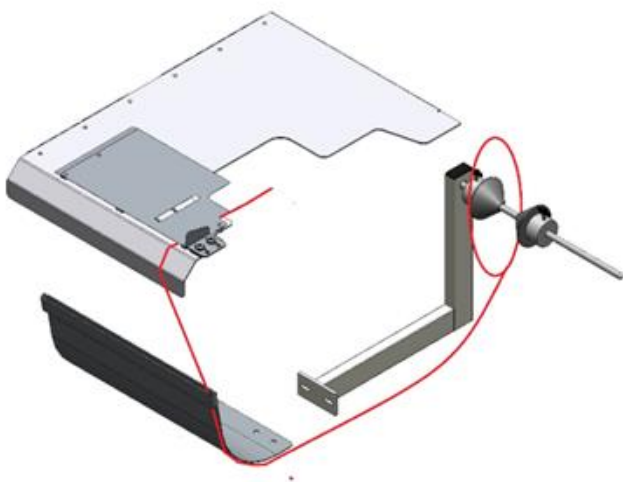
- Thread the Flanger though the lower guide



- Thread the Flanger though the upper guide. Use the ruler as a reference if necessary to be adjust the guide to the proper Flanger width.



- Close cover and run some stitches



Thread

## Operation

### 2. Starting Cycle

- Press the green button on the main switch to turn on the machine.
- The Amber switch on the Efka motor box will light.



- The control panel will start an automatic cycle as follow:

- With machine "Off" Screen do not have any information



- Sewing motor parameter (for 3 seconds)



- Operating Screen.



### 3. Sewing.

**Attention:** Does not sew outside the sewing material. When this happens, the belt comes into direct contact with the teeth and the life of the belt is shortened.

#### a. Top feed Belt

The toothed belt must accompany the lower teeth during the sewing process. The feeding will be done through the motor panel.

**Note:** For thick materials the upper belt should feed slightly more than the lower teeth.

#### b. Function of Push Buttons



Pressing buttons 1 thru 6 to select a different Belt Feeding required.

**Reference:** Step 12 for Heavy materials, Step 1 for Light materials

In case of transport problems in the upper belt, pay attention to the following:

Identifying transportation deficiencies.

- Cut a pair of fabrics of equal length and width Approx. 90 x 6 inches (100 x 15 cm) "A" and sew it together on the machine.
- Start sewing by aligning the edges of the two strips. At the end, check which of the two tapes has been shorter.
- If it is the lower "B", the problem is the toothed belt that is not pulling correctly.
- If it is the upper "C" the problem occurs in the lower teeth that do not drag properly.
- The adjective is to try to achieve a continuous drag on the two tapes so that at the end the two fabrics are aligned "D"



## 2.3. Maintenance

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

### 1. General Safety Instructions

Service should only be performed by trained, qualified personnel. Before performing any maintenance or repair work, lock out and tag out electrical, pneumatic, etc. power to the machine at the main source and secure it with a padlock to prevent unauthorized reconnection. Refer to lockout/tag out procedures.

- Always wear proper safety equipment when operating or servicing equipment.
- All recommended maintenance is based on a single shift schedule; adjust as necessary for a multi-shift operation.
- Equipment should not be used for purposes other than those for which it was designed or specified.
- Before performing any maintenance, the equipment must be shut down, brought to a complete stop, and secured to prevent accidental restart.
- Use proper lockout/tagout procedures to secure the machine against accidental startup.
- Remove all oil, grease, dirt, and debris from the machine, especially from the connections and bolts, before beginning maintenance and/or repair work.
- Do not use corrosive-cleaners
- Use lint-free rags.
- Check for loose hardware and tighten all screw that must be loosened for the maintenance and repair.
- Any safety mechanisms that must be removed for adjustments, maintenance or repair must be reinstalled and inspected immediately upon completion of the work

Regularly scheduled maintenance of the model 1337 unit reduces possible problems and downtime. Proper care will also ensure a longer life and better performance of the machine.

## Operation

### 2. Cleaning:

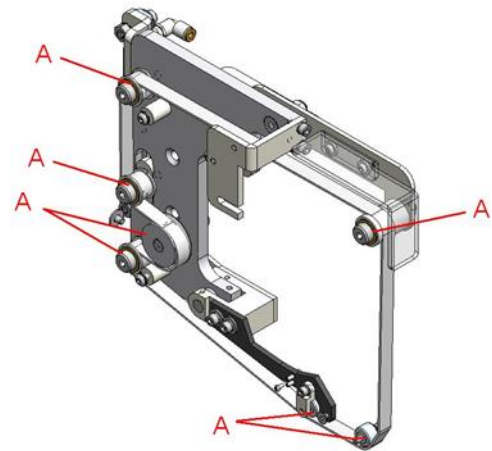
All the elements in the lower and upper transport system must be clean and free of threads or dirt. In the case of the upper belt, there must be no threads in the toothed pulley, the Teflon pulleys, the fabric presser bearings, etc. **(A)**

### 3. Belt conditions:

The normal life of the feeding belt is more or less 8 months depending on the use and handling of the machine.

### 4. Preparation

Turn of the machine and open all sewing head covers.



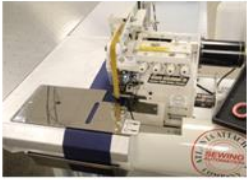







### 5. Preventive Maintenance 8 Hrs.

See printable sheet on next page.



# Preventive Maintenance

<b>Model:</b>	11337HEJ28A	<b>Materials Required</b>
<b>Serial #:</b>		
<b>Operation:</b>	Overedge Panels	
<b>Sew Head:</b>	Juki MO-6916G	
<b>Serial #:</b>		
<b>Needle::</b>	SNTVX7140	

<b>Daily ( 8 Hrs )</b>	<b>Before starting the day's shift with "The Machine Off"</b>	
	.- Wipe with a clean cloth any debris accumulated	
	.- Check for liquid waste in the air filter and drain if necessary	
	.- Check the oil level and apply two drops of oil on the upper looper bar	 
	<b>After the day's shift with "The Machine Off"</b>	
	.- Remove the belt cover and remove any dirty or tangled threads	
	.- Check for any thread accumulation in the lower movable parts	
	.- Remove the covers, blow out and wipe the machine off with a clean cloth and remove any dirty or tangled threads	
	.- Cover the machine and notify the supervisor of any unusual noise or abnormality that is present during the day	

Service

### 3. SERVICE

**NOTE:** Maintenance should only be performed by trained, qualified personnel.

#### 3.1. Lockout/Tagout Program

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

Equipment Energy Control Procedure Lockout/Tagout Program				
Description: <b>Panel Serger</b>		Model: <b>11337HEJ28A</b>		
Manufacturer: <b>Atlanta Attachment Co.</b>		Location:		
Energy		Location	Magnitude	Control Method
Electrical:	X	Disconnect/Ctrl Box	<b>220V</b>	Lockout & Tag
Pneumatic:	X	Main Regulator	<b>90 PSI</b>	Lockout & Tag
Gravity:	X	Rollers		
Remember to Release All Stored Energy!				
<b>Shutdown Procedure:</b>				
Inform all affected personnel that the machine will be in Lockout status. Turn the power and pneumatic disconnects to the OFF position. Fill out the tag with necessary information of the Lockout. Install the Lockout device. Verify all stored electrical energy has been released by pressing the power on button. Also, use meter to test circuits in the electrical panel to insure stored energy is released there as well. Perform necessary maintenance, services and/or repairs.				
<b>Startup Procedure:</b>				
Inform all affected personnel that the Lockout of this machine is being removed. Replace any guards or safety devices which may have been removed during maintenance. Remove the Lockout device and tag. Turn the power and pneumatic disconnects to the ON position. Push the green button on the back of the control panel to turn the machine on. Inform all affected personnel that the Lockout has been removed and that the machine is ready for normal production operation.				

Approved By: \_\_\_\_\_

Date: \_\_\_\_\_

### 3.2. Mechanical

**NOTE:** All maintenance should be performed by a qualified service technician.

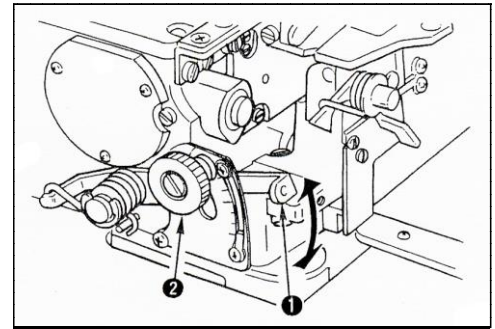
#### 1. Adjusting the Differential Feed Mechanism

Loosen the differential feed lock nut (2). Move the lever (1) up for stretching stitch or down for gathering stitch.

When the differential feed adjusting lever is set to graduation S, the machine will perform stretching with a differential feed ratio of 1:0.6, or 1:0.7 only for MOG-3714.

For shirring, the maximum differential feed ratio is 1:1.75, or 1:2.0 only for MOG-3714.

Note that the differential feed ratio for shirring can be set to 1:3.8 by adjusting the internal mechanism of the sewing machine. Graduations are used only as a guide.

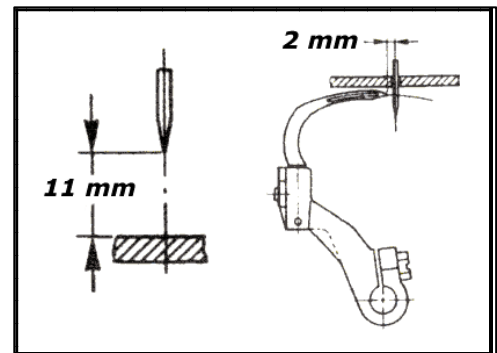


#### 2. Adjusting the Timing of Loopers and Needle Guard

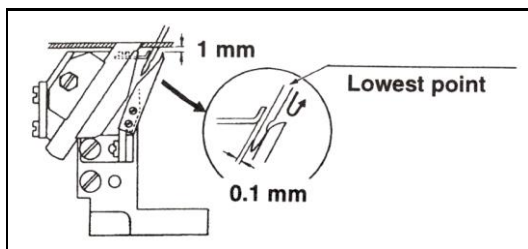
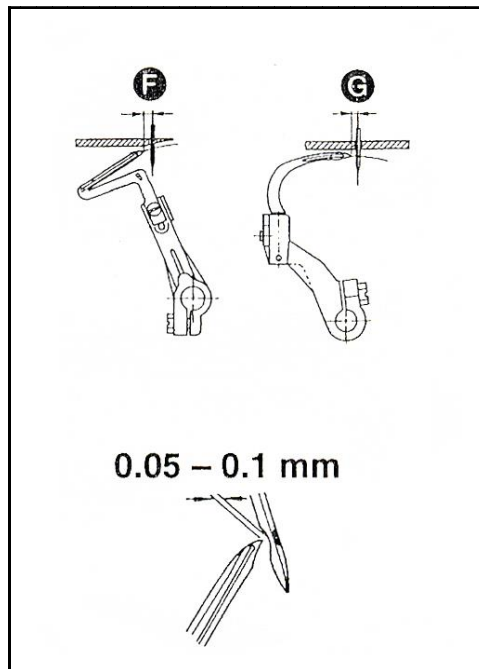
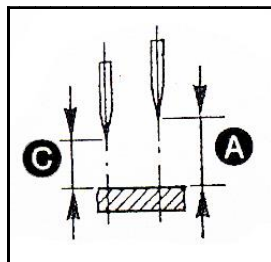
The looper and needle guard are set at the factory to the dimensions in the illustrations on this page at the factory.

Adjustment depends on the sewn products and the thread characteristics

**Caution:** These adjustments should be made by a qualified technician. To prevent injury, disconnect the power source before making any adjustments. Make sure that all screws are tightened and that no components are in contact with each other before reconnecting power.



A=1/2"  
C=7/16"  
F=9/64"  
G=1/16"

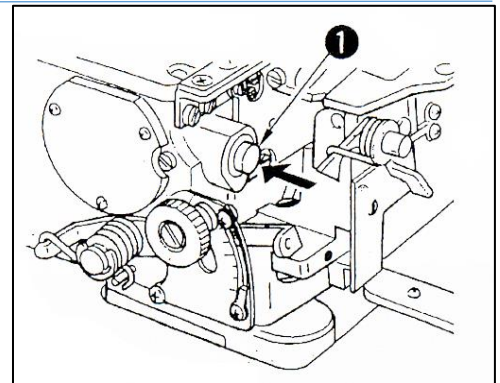


## Service

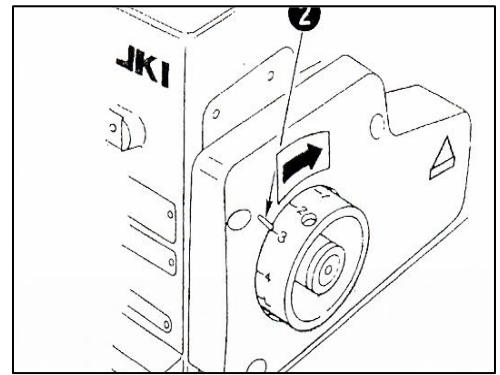
### 3. Adjusting the Stitch Length

The lower feed dog is attached to the differential feed bar. To adjust the stitch length first adjust the general feeding to maximal and after use the differential level to adjust the final stitch length,

- Slowly turn the hand wheel as you keep depressing the pushbutton (1), and you will find a point at which the pushbutton goes farther.
- With the above condition maintained, align the desired scale mark on the hand wheel with mark (2) on the belt cover.
- Reset the pushbutton after setting the dial.



**Caution:** Confirm that pushbutton (1) has returned to its original position before starting to run the sew head since there is a danger that the machine parts may be damaged, or the operator or other persons may be injured.



### 3.3. Pneumatic

**NOTE:** All maintenance should be performed by a qualified service technician.

#### 1. Foot Pedal Down

#### 2. Waste System Pressure

#### 3. Air Amplifier

#### 4. Air valves (AAEVQZ2121)

Waste Valve  
Foot Lift



## 5. Foot Lift Cylinder

The air pressure cylinder has a travel control ring. Adjust this ring so that the belt does not apply full pressure to the feed dog.



## 6. Foot Down Pressure

## 7. Main pressure

### 3.4. Electrical

**NOTE:** All service should be performed by a qualified service technician.

#### 1. Stepper Motor (011-020)

The Stepper motor: It is responsible for driving the toothed belt. The speed of this motor can be changed from the control panel. While the materials are thicker, we will need to increase the speed, the lighter to decrease it.

#### 2. Sewing motor (4059-1500)

The Efka motor is what gives the sewing movement to the machine. At the same time, it is responsible for the movement of the feed dog of the machine. The tooth is usually the one that determines the stitch length of the seam. This adjustment is mechanical and is made through a lever located inside the head behind the machine.

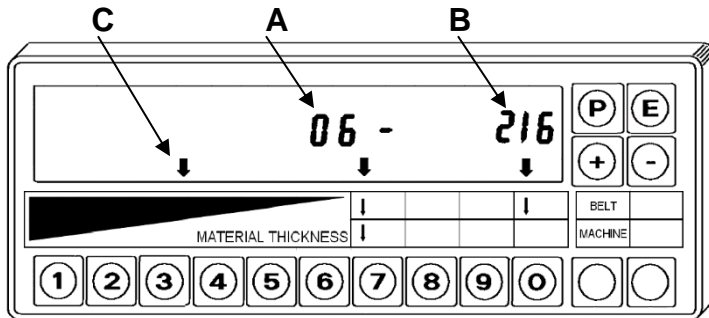
#### a. Input Output Signal.

V820 control panel: Controls functions or signals that generate impulses that can be directly checked by arrows above keys 1...10. Several inputs can be controlled and displayed simultaneously.

#### 3. Treadle

## 4. Control Panel V820

The control panel is responsible for controlling both the Efka motor and the Step motor. Later you will find details of its operation.



### Function of push buttons on V820 :

**A** = Belt Feeding Step

**B** = Belt Feeding Value. The value “B” on the display shows a ratio and not a speed. As lower the ratio as higher the speed

**C** = Belt Feed Step Selected



Pressing buttons 1 thru 6 to select a different Belt Feeding Step (You will have two Feeding Steps per button). Reference: Step 1 for Heavy materials, Step 12 for Light materials

Position	1	2	3	4	5	6	7	8	9	10	11	12
Step Value	246	240	234	228	222	216	210	204	198	192	186	180

Button 7 = Display stepper values of puller 1 or puller 2

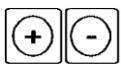
Button 8 = Puller delay at seam begin ON/OFF and input of stitches for puller delay

Button 9 = Puller coupling with presser foot lift ON/OFF

Button 0 = Puller function ON/OFF

Button F1 = Change display from puller to standard sewing

Button F2 = Go to next stepper value ( 1 –12 ) in sequenced mode



+ = Increase Belt Feeding Value when Panel is unlocked

-- = Decrease Belt Feeding Value when Panel is unlocked

## 5. Enabling Disabling buttons

Function is available just with latest software version. .

Parameter F-620.

F-620 = 1 enables buttons 7,8,9,0,F1.F2

F-620 = 0 disables the buttons

As a preset the buttons are enabled.

After finishing the settings change parameter 620 from 1 to 0 and save it with F-401 = 1.

Then power off and on again and the buttons are locked.

To go back repeat the same procedure with 620=1

## 6. Motor Control Box (AB425S)

### 3.5. Programming

#### 1. Erase all memory.

- Hold “P”, turn machine on
- Type code “5913”.
- Press [E]
- Set parameter F-459 to 3112
- Press [E]
- Press [P]. It will erase all memory sections.
- Turn Machine Off

**Note:** For initial operation after software updating or maintenance procedures, make sure to set parameter [467] for the specific motor to be used (DC1500, F-467 = 1 / DC1550, F-467 = 2)

#### 2. Reading the installed software

In service Area

- In Service area type [F-179]
- Press [E] show Sr5
- Press [>>] (Last key on the bottom right corner) machine show program number
- Press [E] show data
- Press [E] show chk
- Press [E]
- Press [E]
- Press [P]
- Press [P]

If the original factory software is not the right one you will need to erase all memory data and reload new Software. After this procedure, you will require to load the Sewing head parameters and Step motor parameters again.

#### 3. Save settings.

- Cycle power,
- Press “P”. Enter 3112.
- Type 401 parameters
- Press [E]
- Set to [1]
- Press [E]
- Press [P]
- Press [P]

#### 4. Sewing Head Parameter

##### a. Use SIR for Initial Settings

- Keeping [P] pressed and turn the machine “ON” until screen show “C:0000”
- Type [3112]

## Service

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- Press [E]
- Parameter “F-200” is showing, Type [500] Input Parameter
- Press [E]
- Press [>>] (Last key on the bottom right corner) machine shows F-467
- Press [E]
- Parameter “F-290” is showing. Type [5] Functional sequence
- Press [E]
- “F-161” is showing, Type [1] Direction of the motor
- Press [E]
- “F-272” is showing, Type [1000] Transmission Ration
- Press [E]
- “F-270” is showing, Type [0] Type of positioning sensor
- Press [E]
- “F-451” is showing, Do not change (Ndl Dn)
- Press [E]
- “F-453” is showing, Do not change (Ndl Up)
- Press [E]
- “F-467” is showing, Do not change (Mtr type)
- Press [E]
- Program returns to Parameter F-467
- Press [P]
- Press [P]
- End of SIR

### b. Set Needle Position Up

Set parameter F-171 to set 1 needle position “UP” and 2 Needle position “UP”.

- Press [P]
- Type [171] Setting the needle positions.
- Press [E]
- Press [>>] (Last key on the bottom right corner) machine show 1E = Start, Turn handwheel in direction of sew until needle is up. Note parameter setting.
- Press [E]
- 2E = Start position, enter same number as 1E
- Press [E]
- 1A = End position. Set equal to 1E+60.
- Press [E]
- 2A = End position, Set equal to 2E+60.
- Press [E]
- Press [P]
- Press [P]

### c. Set Maximal Speed

After parameter, F-171 is set change F-111 to 4.000 Maximal Sewing Speed

- Press [P]
- Type [111] Type [4000] Maximal Sewing Speed
- Press [E]
- Press [P]
- Press [P]










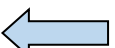

## 5. Step Motor

### a. Parameter List

Value	Function	Parameter
0	601	Puller coupling with presser foot lift ON/OFF ( button 9 / V820 )
1	602	Puller ON/OFF ( button 0 / V820 )
1	603	Direct choice of steps via button 1 -6 or sequence choice of steps via button F2 on V820
0	604	Stitch delay until puller down at seam begin ON/OFF ( button 8 / V820 )
0	605	Display puller function or normal sewing function ON/OFF ( button F1 / V820)
1	606	Change of direction of stepper motor during back tack ON/OFF
0	607	Change display of puller 1 and puller 2 ( button 7 / V820 )
0	702	0 / Synchronous run of stepper motor, 1 / of stepper motor
0	703	Stitches until Puller down at seam begin
0	704	Automatic Puller lifting after trimming ON/OFF
100	705	Speed for manual run of stepper motor 1 and stepper motor 2
100	707	Holding current SM1 (100 = .1 A)
4000	708	Running current SM1 (4000 = 4.0A)
200	710	Ratio SM1 ( Sets frequency of the pulses in intermitted run mode)
60	711	Start delay in degrees from position until stepper 1 starts for intermitted running
100	717	Holding current SM2
4000	718	Running current SM2
200	720	Ratio SM2 ( Sets frequency of the pulses in intermitted run mode)
60	721	Start delay in degrees from position 2 until stepper 2 starts for intermitted running
1	734	Turning direction SM1
1	744	Turning direction SM2

## 6. Memory Stick Operation

### a. Data Transfer







Operation	Parameter		Type of file
Parameters	F-510		
Parameters	F-511		0100DATA.par
Compare parameters	F-512		
Array Data	F-514		
Array Data	F-515		0400DATA.pay
Compare Array Data	F-516		
Compiler.	F-523		Puller_V10.prg
Control Software	F-526		
Control Software	F-527		5850K_11020307.H86
Compare Control	F-528		

### b. Loading Information Memory Stick

**Note:** Before starting the loading process, the memory stick should have the Control Software and parameters installed.

Memory Stick (USB) preparation.

- The Usb must be 4GB or less.
- Format should be on Fat.
- The file directory should content this files.

Name	Date modified	Type	Size
 0100DATA.par	6/26/2010 6:58 AM	PAR File	41 KB
 0300DATA.pay	12/31/2004 11:02 PM	PAY File	201 KB
 1337HESEWPAR.doc	3/28/2018 4:29 PM	Microsoft Word 9...	726 KB
 1337HESEWPAR.zip	3/28/2018 4:30 PM	Compressed (zipp...	1,420 KB
 5850K_11020307.H86	2/3/2011 6:36 AM	H86 File	2,519 KB
 AB425SPullerV820SM8.prg	6/2/2009 9:06 AM	PRG File	6 KB

**Attention:** Is recommended to erase all memory before loading the information from the memory stick (See Erase all Memory for instructions)

Access Code : 3112

- Turn on power, plug in the Memory stick, wait for normal screen.
- Press “P”, screen shows “F 000”
- Type “527”
- Press “E”
- Machine displays “F527 cdl (o)”
- Press [>>] (Last key on the bottom right corner) machine shows 5850 k\_ 1 h86
- Press “E” twice quickly.
- Machine show “read data” for some time. Wait until display returns to normal and “prog” has gone from Efka box display. (Several minutes)
- Wait until machine displays “F527”
- Type “523”
- Press “E”.
- Press [>>] (Last key on the bottom right corner)
- Press “E” twice quickly.
- Machine show “read data”. Wait until display shows “F 523”.
- Type “511”
- Press “E”.
- Press [>>] (Last key on the bottom right corner)
- Press “E” twice quickly.
- Machine show “read data”. Wait until display shows “F 511”.
- Enter “515”, Press “E”.
- Press [>>] (Last key on the bottom right corner)
- Press “E” twice quickly.
- Wait for normal screen.
- Turn power off.
- Remove memory stick.
- Hold “P”, turn machine on
- Type code “5913”.
- Press [E]
- Type 436, Press “E”. Change value from “1” to “0”
- Press [E]
- Press [P].

**Note:** For initial operation after software updating or maintenance procedures, make sure to set parameter [467] for the specific motor to be used (DC1500, F-467 = 1 / DC1550, F-467 = 2)

## 3.6. Machine Maintenance

**NOTE:** Always wear proper safety equipment when operating or performing maintenance on any equipment.

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

### 1. General Safety Instructions

Service should only be performed by trained, qualified personnel. Before performing any maintenance or repair work, lock out and tag out electrical, pneumatic, etc. power to the machine at the main source and secure it with a padlock to prevent unauthorized reconnection. Refer to lockout/tag out procedures.

- Always wear proper safety equipment when operating or servicing equipment.
- All recommended maintenance is based on a single shift schedule; adjust as necessary for a multi-shift operation.
- Equipment should not be used for purposes other than those for which it was designed or specified.
- Before performing any maintenance, the equipment must be shut down, brought to a complete stop, and secured to prevent accidental restart.
- Use proper lockout/tagout procedures to secure the machine against accidental startup.
- Remove all oil, grease, dirt, and debris from the machine, especially from the connections and bolts, before beginning maintenance and/or repair work.
- Do not use corrosive-cleaners
- Use lint-free rags.
- Check for loose hardware and tighten all screw that must be loosened for the maintenance and repair.
- Any safety mechanisms that must be removed for adjustments, maintenance or repair must be reinstalled and inspected immediately upon completion of the work





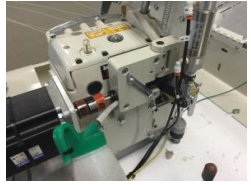



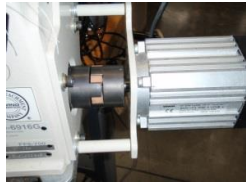



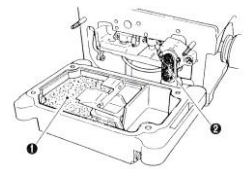


Regularly scheduled maintenance of the model 1337 unit reduces possible problems and downtime. Proper care will also ensure a longer life and better performance of the machine.

### 2. Cleaning the Filter and Pump Net

When using the sewing machine for an extended period of time, clean filter and pump net regularly two or three times a year. If the filter and pump net are clogged with dust, etc., the machine components may jam or worn out abnormally. Check the filter and pump net carefully.

If the lubricating oil in the machine is soiled, change the oil at the same time as cleaning.

Service

<b>Weekly ( 40 Hrs )</b>	.- Open covers, remove needle plate. With an air gun blow the machine out and remove accumulated dirt in hard to reach areas	
	.- Oil all moving parts of the belt arm and presser foot	  
	.- Oil all external moving parts of feeding shaft	 
	.- Clean fan motor of the machine and the air table blower	 
	<b>.- Perform Daily Maintenance</b>	
<b>Semi-Annual (960 Hrs)</b>	.- Check the condition of the cuplings	
	.- Remove the dust pipe, remove the oil plug and replace the oil in the machine, check the status of the oil filter	  
	<b>.- Perform Weekly Maintenance</b>	
<b>Yearly ( 1.920 Hrs )</b>	.- Remove the lower oil tank, clean the tank, open the top cover and replace the filter	 
	.- Disassemble and Clean the Pneumatic maintenance unit	
	.- Check for any wear and replace parts if necessary	
	<b>.- Perform Monthly Maintenance</b>	

**6. High Mortality Parts**

Part# : SP1337HEJ28A - Spare Parts Set

Line	Knife		Qty.
1	115-65900	Cutter, Upper(Carbide)	2
2	115-66502	Cutter, Lower	2

**Looper**

2	123-83501	Looper, Upper	1
4	123-84202	Looper, Lower	1
5	123-84400	Looper,Chain,Mog-3716	1

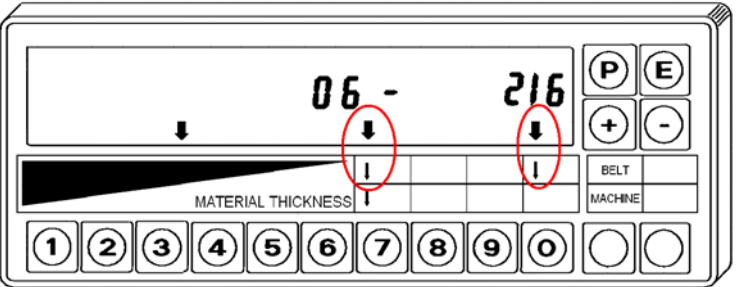
**Guards**

6	X 1337001	Guard, Front Needle	1
7	X 1337002	Guard, Rear Needle	1
8	118-90001	Needle Guard, Lower Looper Mog-3716 Juki	1

**Miscellaneous**

9	120-15400	Needle Holder (Guard)	1
10	X 1342Z-201A	Roller, Delrin, Top Belt	1
11	X 1342Z-201B	Roller, Delrin, Top Belt Fd Dim.877x.752x.375 .5belt	1
12	AAEVQZ2121	Valve,Body Ported	1
13	BBB-68	Bearing, Needle, .375b	1
14	GG356XL050U	Belt, Gear, Kevlar Core,Ure 1/5p,1/2w,178t	2
15	X M1J96-004C	Shaft,60c, .375dia	1
16	X M4J28-002	Needle Chuck,3/4 Ga	1
17	RRE29C	Spring, Ext, .035d Wire 100.0000	1
18	SNTVX722-140GB	Needle, Sys Tvx7,22/140	100
19	SS8080310TP	Screw,Set,Slotted,1/8-44 2.8l,Mog-3716 Juki	2

### 3.7. Troubleshooting

Problem	Cause:	Corrective action:
U1	Parameter value	The AB425S reads a non-valid parameter or array value. This could be caused by the new preset value after power on we have add to the software.
Top feed belt	Belt not working	<ul style="list-style-type: none"> <li>• Check that the stepping motor is moving at slow sewing speed. It doesn't matter if it moves slow or fast; but what if it moves when you activate the sewing pedal. This will tell us that the engine is running. In case of no movement, you should check the following.</li> <li>• Check that the direction of rotation of the belt is correct. Lest the belt is feeding backwards instead of accompanying the movement of the tooth. In case this happens, you will need to go to parameter 734 and change the value from "0" to "1 " or vice versa.</li> </ul>
	Wrong Motor Port	That the step motor cable is connected to the control box. Verify that it is connected to the socket that says motor 1 in the control box.
	Wrong Selection on the V820	Indicative arrows on the control panel screen should coincide with the dates that are printed in the column belonging to "BELT". See red circles as reference. <div style="text-align: center;">  </div>
	Too much feeding value	Make sure that the gathering values on the control panel are above 180. If this value is too low, the rotation of the stepper motor will be too high, which will cause it to stop suddenly at high speed and stop to transport. If the value is above 180 and this effect still occurs, you should verify parameter 708 is at the value 5,000. This value is the amperage delivered to the stepper motor
	Too much presser foot pressure	To high presser foot pressure require extra efforts to the stepping motor. Reduce the presser foot pressure as much as possible

Parts

## Assembly Drawings & Parts Lists

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### **One-Stop Shopping**

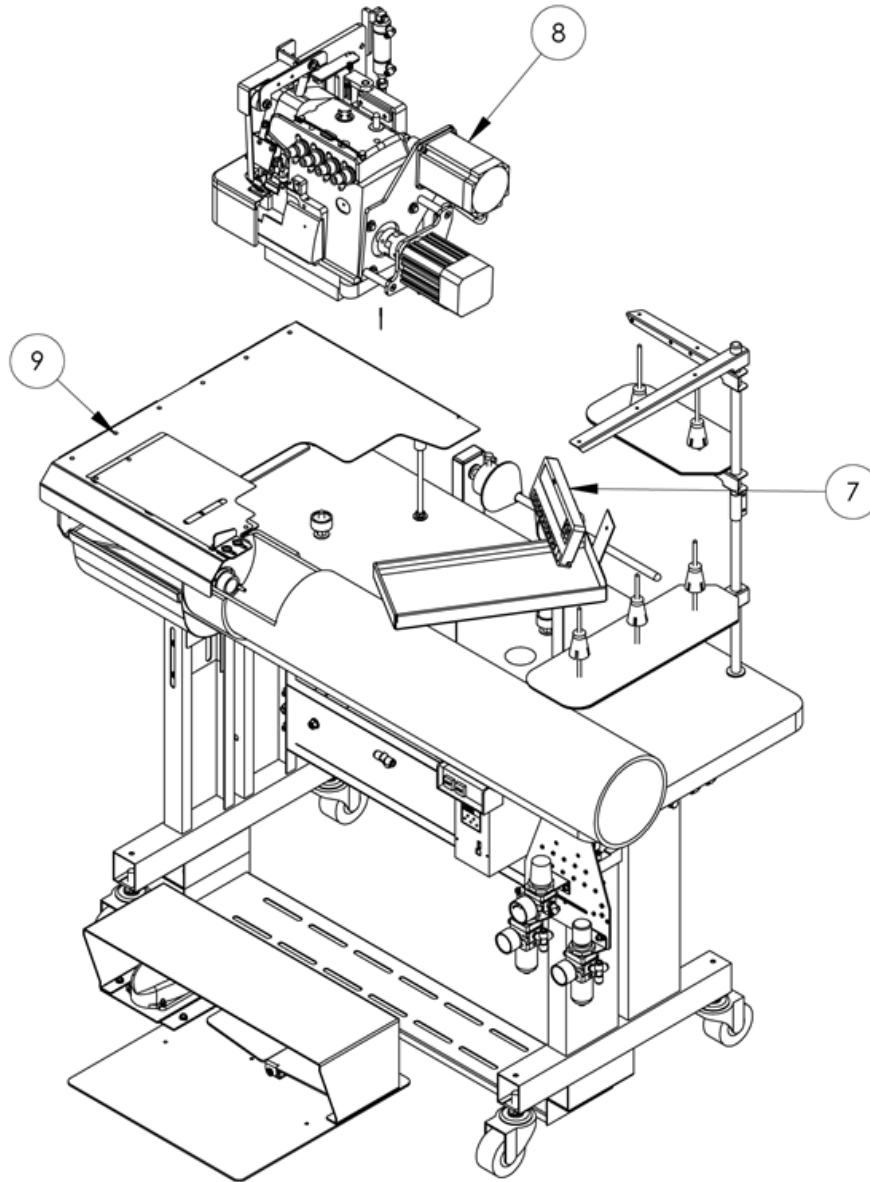
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# 11337HEJ28A Console Assembly

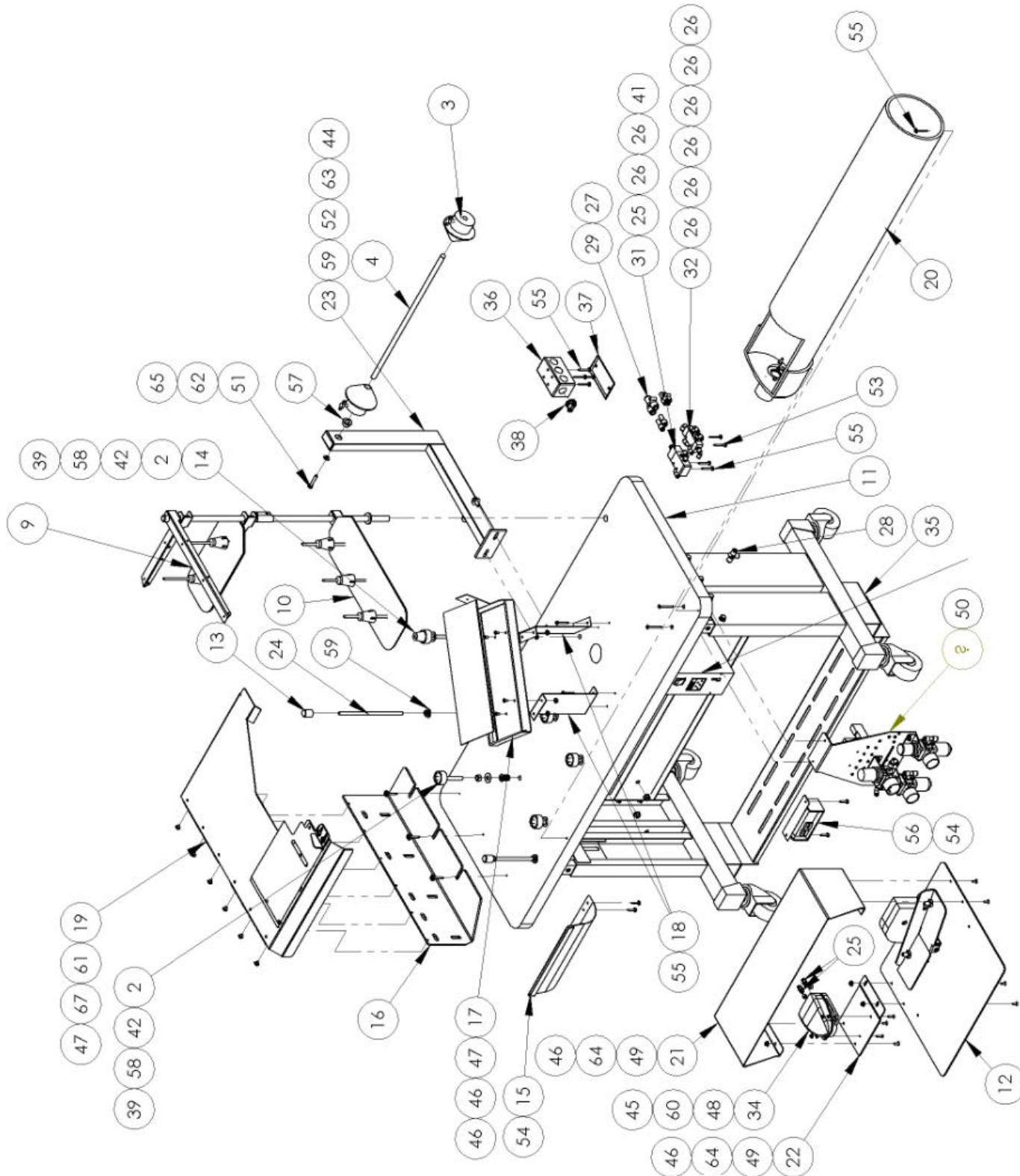
AAC Drawing Number 9002687 Rev 1



NO	QTY	PART #	DESCRIPTION
1	*1	1337-LAB2	LABELS
2	*1	1337-LAB3	LABEL, V820 PANEL
3	*1	1337H-PD	PNEUMATIC DIAGRAM
4	*1	1337H-WD	WIRING DIAGRAM
5	*1	1337HESEWPAR	PARAMETER LIST
6	*1	4059-DC09	CABLE, STEPPER, 6 FT
7	1	4059-V820	EFKA V820 OP PANEL
8	1	11337HSEJ28A	SEW HEAD, FLANGER, BLT FEED
9	1	1337884	GENERIC CONSOLE ASSY, HL

# 1337884 Generic Console Assembly, HL

AAC Drawing Number 1337884 Rev 2



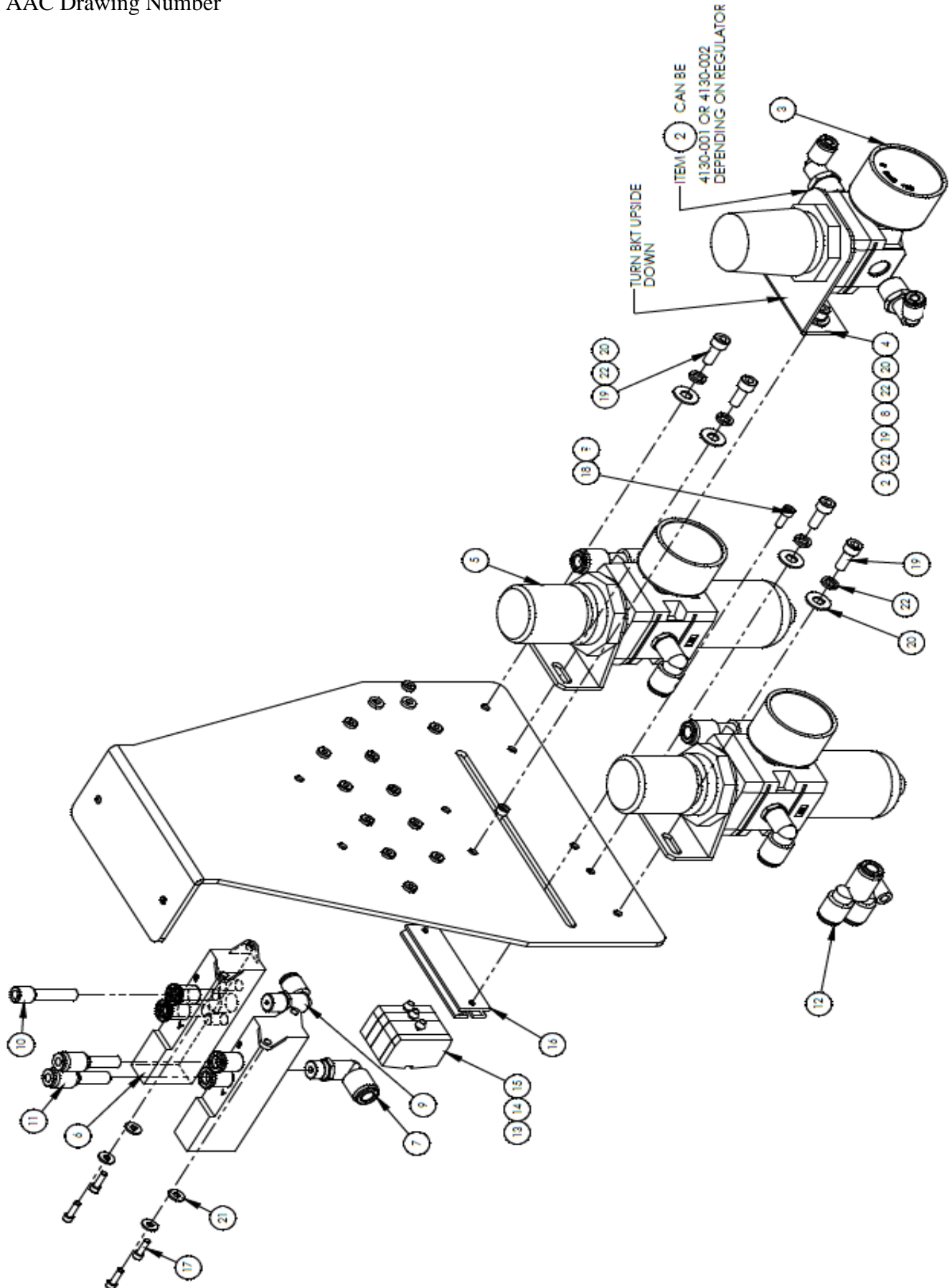
1337884 parts

ITEM NO.	QTY	PART NUMBER	DESCRIPTION	ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	0211-701EA	CABLE,I/O,FL, SAFETY SW	35	1	K-4DS	HD T LEG ADJ STAND SHORT
2	5	0411-128B	ISOLATOR MOUNT ASSEMBLY	36	1	K-230	BOX,METAL, 2X4X2
3	2	787-4A-032	CONE BEARING ASSY.	37	1	K-231	COVER, 2X4
4	1	1335-816	ROD,SS, 1/2 X 15.0 L	38	2	K-235	CONNECTOR,ROMEX,1/2"
5	1	1337-1500A	PNEUMATIC PANEL, 3 REG.	39	5	K-3401-3/8	INSERT,LEG,1" LONG, 3/8-16
6	*1	1337-LAB2	LABELS	40	1	MM132-1496	PLUG 1 X 2
7	*1	1337HE-WD	DIAGRAM, WIRING	41	1	MM4554K11	PLUG, 1/8" PIPE
8	*1	1337HEC-PD	DIAGRAM, PNEUMATIC	42	5	NNH3/8-16	NUT,HEX,3/8-16
9	1	1959-112	2 POS THREAD PLATE ASSY	43	5	NNJ5/16-24	NUT,JAM,5/16-24
10	1	1959-161	3 POS THREAD PLATE ASSY.	44	2	NNK5/16-18	NUT,KEP,5/16-18
11	1	4048-11337HSE	TABLE TOP 20X48,6900 JUKI	45	2	NNK8-32	NUT,KEP,8-32
12	1	4059-FP301D	FOOT PEDAL ASSY,EFGA	46	10	NNK10-32	KEP NUT, 10-32
13	2	11200A	BUMPER 5/16-24	47	10	SSBC98024	10-32 X 3/8 BUTTON CAP SC
14	1	51295A	ISOLATOR, MACHINE MOUNT	48	2	SSFC90048	8-32 X 3/4 FLAT AL CAP
15	1	1337140	MATERIAL DEFLECTOR	49	6	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
16	1	1337177	PLATE, CONNECTING, CONSOL	50	2	SSFC98112	#10-32 X 1-3/4 FLAT CAP
17	1	1337178	TOOL TRAY,1X6X14	51	1	SSHCO1096	1/4-20 X 1-1/2 HHCS
18	2	1337180	MOUNT, TOOL TRAY	52	2	SSHCM8X20	SCREW,HEX CAP
19	1	1337187	FLANGER GUIDE ASS	53	3	SSZH#6096	SCREW,SHT.METAL HEX 6
20	1	1337189	WASTE CHUTE TUBE	54	4	SSZH#10064	SCREW,SHT.METAL HEX 10
21	1	1337224	COVER,FOOT PEDAL,UPPER	55	18	SSZH#10096	SCREW,SHT.METAL HEX 10, 1
22	1	1337225	BRKT,PEDAL	56	1	T75	ON/OFF IPH SWITCH BOX, ONLY
23	1	1959335	ROLL HOLDER ARM	57	1	UUFF707-05	BEARING,BRONZE,.502ID
24	2	4400025	THREADED ROD, 5/16-24 X 8	58	5	WWF3/8	WASHER,FLAT,3/8 OR 10MM
25	3	AAQMC-5-8	QU. MALE CONN 5/32X1/8	59	10	WWF5/16	WASHER,FLAT,5/16
26	8	AAQME-5-8	QUICK MALE ELBOW	60	2	WWF8	WASHER, FLAT, #8
27	2	AAQPR-3-4	QUICK REDUCER 3/8-1/4	61	10	WWF10	WASHER, FLAT, #10, COM
28	2	AAQUT-4-4	QUICK UNION T 1/4X1/4	62	4	WWF5/14	WASHER,FLAT,SAE,1/4
29	1	AAQUY-3-3	QUICK UNION Y,3/8X3/8	63	2	WWF5/16	WASHER,FLAT,SAE,5/16
30	2	AAQUY-5-5	QUICK UNION Y, 5/32	64	6	WWF510	WASHER, FLAT, #10, SAE
31	1	AAV125B	PILOT VALVE	65	1	WWL1/4	WASHER,LOCK, 1/4
32	1	AAV180-4A2	DOUBLE PILOT VALVE	66	7	WWL5/16	WASHER,LOCK, 5/16
33	1	FFHBL4579C	RECEPTACLE,3 POLE,3W	67	6	WWL10	WASHER,LOCK,#10
34	1	K-3C30A2S	FOOT AIR SWITCH PURCHASED				

Parts

# 1337-1500A Pneumatic Panel

AAC Drawing Number



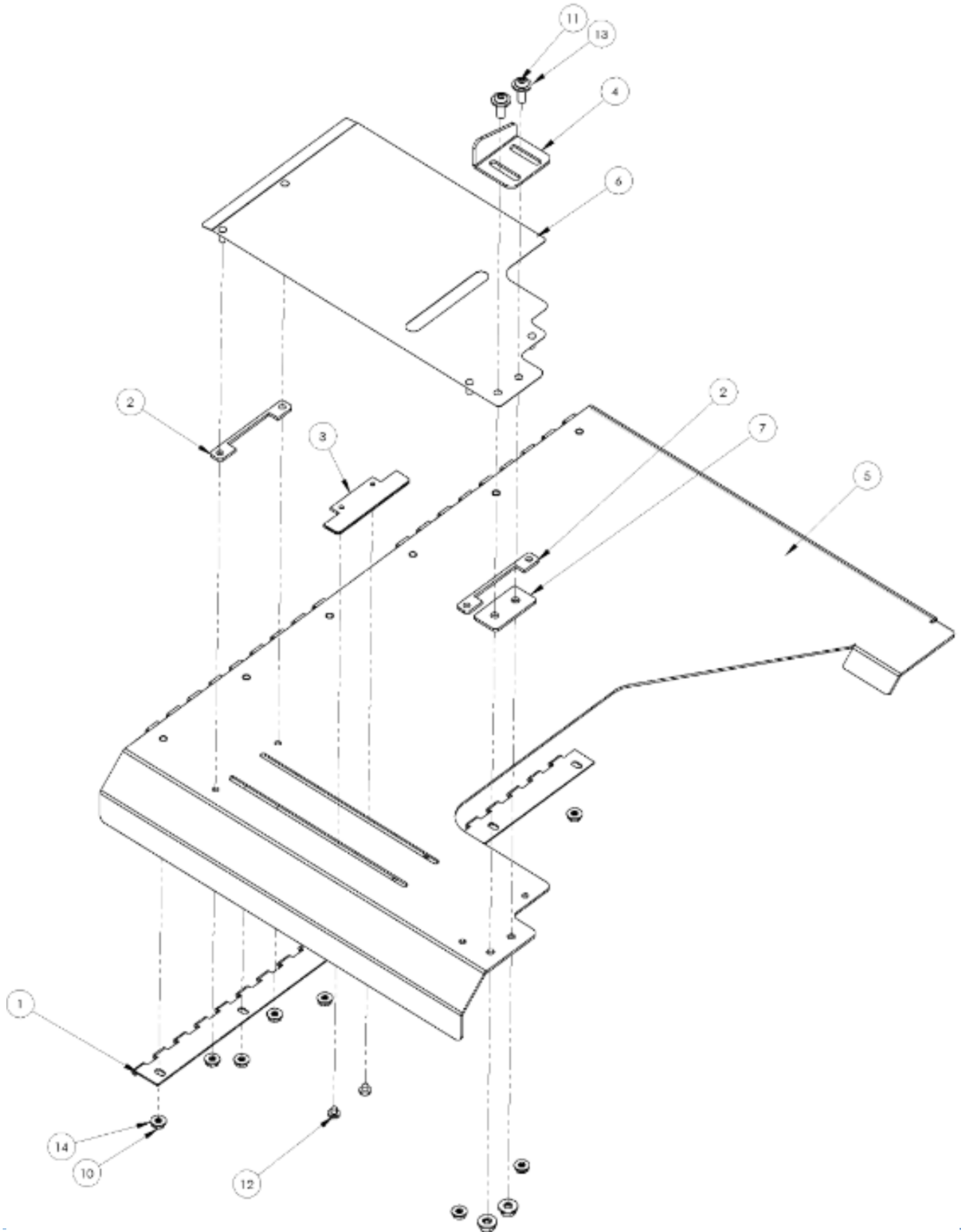
## 1337-1500A parts list

ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1338-024	PANEL, PNEUMATIC
2	1	4130-001 or 4130-002	REGULATOR BRACKET
3	1	AA198-5031	0-160PSI AIR GAGE 1/8NPT
4	1	AA198-503A	REG-0-125 W/GAUGE& BRKT
5	2	AA198-5102	REG W/FILTER, GAUGE, BRKT, NUT, & AAQME-4-8 FITTINGS
6	2	AAEVQZ2121	VALVE, BODY PORTED
7	1	AAQME-4-8	QUICK MALE ELBOW, 1/4T
8	2	AAQME-5-4	ELBOW, QUICK MALE, 5/32 X 1/4 NPT
9	1	AAQME-5-8	QUICK MALE ELBOW
10	1	AAQPP-07	QUICK PLUG 1/4
11	2	AAQPR-5-4	REDUCER, QUICK, 1/4- 5/32
12	1	AAQUY-5-4	Y UNION, 5/32X1/4
13	2	FF264-311	TERMBLK,WAGO,TOP,SINGLE,GRY
14	1	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
15	1	FF264-371	TERMBLK,WAGO,TOP,END
16	1	FF264-3BKT2.5	MOUNT, WAGO, 2" LONG
17	4	SSSC70024	4-40 X 3/8 SOCKET CAP
18	2	SSSC80024	6-32 X 3/8 SOC CAP SC
19	6	SSSC98032	10-32X1/2, SOC CAP
20	6	WWF10	WASHER, FLAT, #10, COM
21	4	WWF4	WASHER, FLAT, #4
22	6	WWL10	WASHER, LOCK, #10

Parts

# 1337187 Flanger Guide Assembly

AAC Drawing Number Rev 0



1337187 parts list
--------------------

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	4	1337-4217	HINGE,PIANO,S/S, 2W, .06THK.
2	2	1337-4302	SPACER
3	1	1337-4304	PLATE, ADJUSTMENT
4	1	1337138	GUIDE, EDGE, RIGHT
5	1	1337175	PLATE BASE FOLDER
6	1	1337176	PLATE,FOLDER TOP
7	1	1337188	SPACER,FLANGER GUIDE
8	1	MM1910A23M	RULER,SILVER MYLAR 36"
9	2	NNH1/4-20	NUT,HEX,1/4-20
10	10	NNK10-32	KEP NUT, 10-32
11	2	SSBC01048	SCREW,BUTTON CAP,1/4-20X3/4
12	2	SSPS98012	10-32 X 3/16 PAN HD SLOT
13	4	WWFS1/4	WASHER,FLAT,SAE,1/4
14	10	WWFS10	WASHER, FLAT, #10, SAE

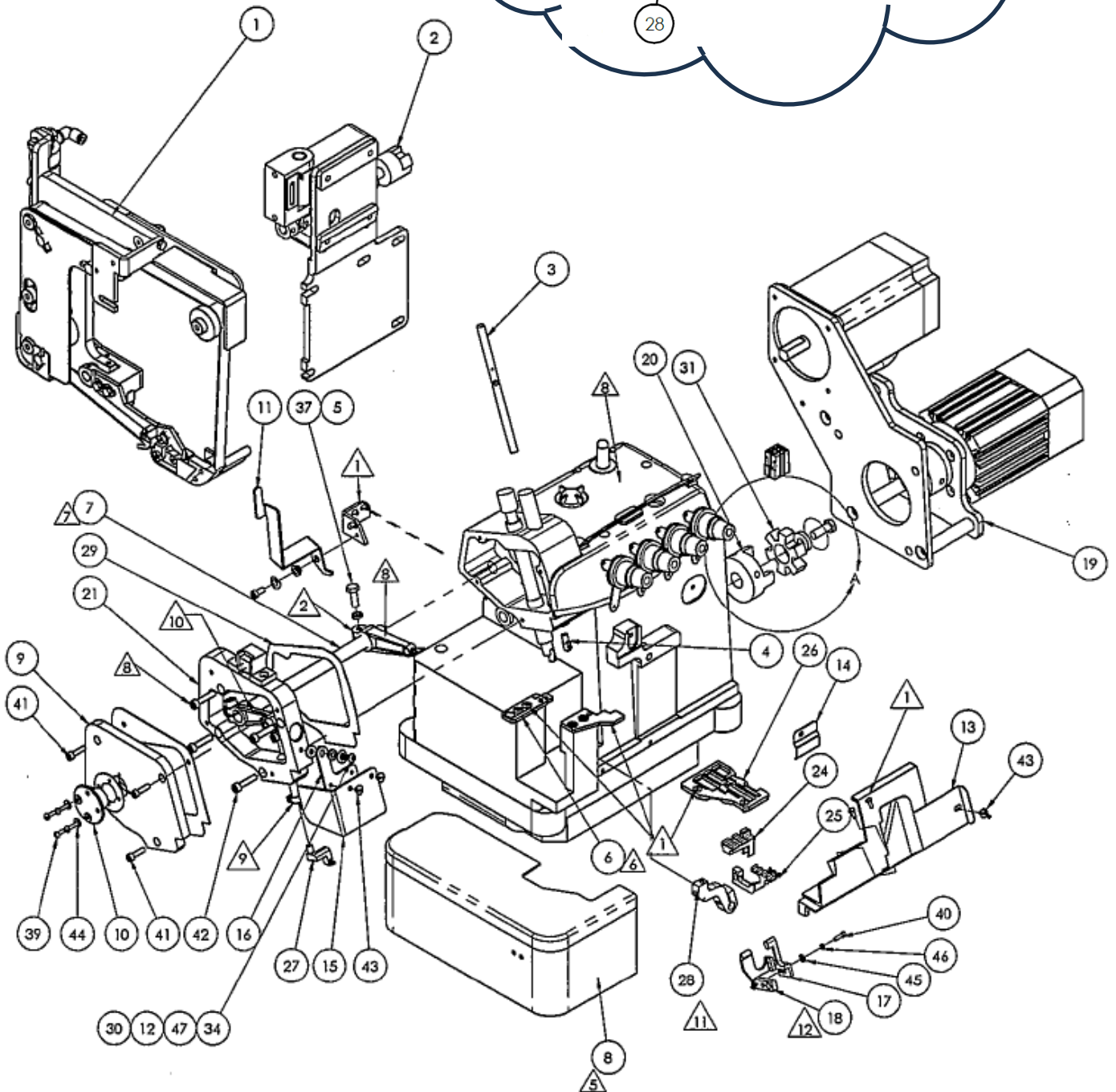
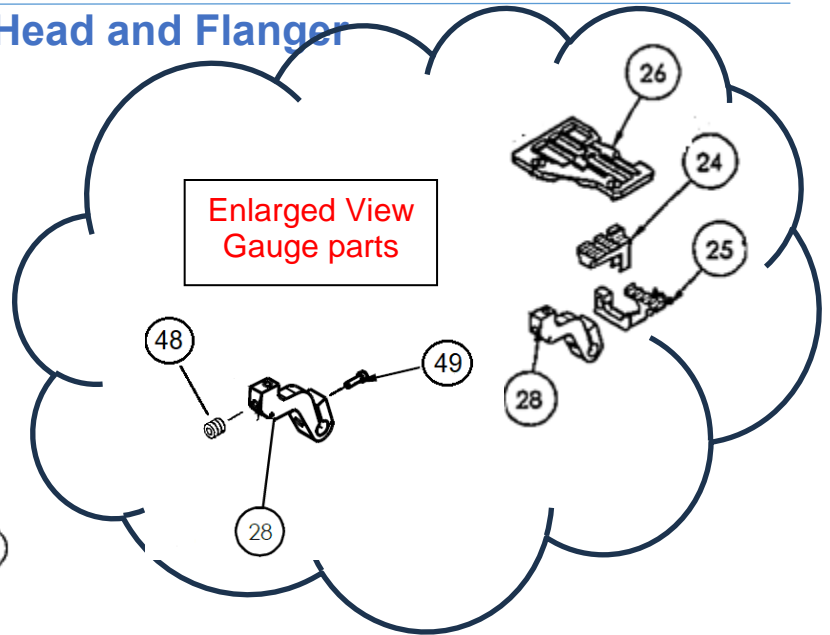
Parts

**11337HSEJ28A Rev 4, Sew Head and Flanger**

AAC Drawing Number 9002680 **Rev 4**

Note: Rev 4 used two-piece feed dog and old style gauge parts see below

- M2J96-002 MAIN FEED
- M2J96-003 DIFF FEED
- M2J96-003 PLATE
- M5J96-001 LOOPER HOLDER



11337HSEJ28A Rev 4 parts list  
**Two-Piece Feed Dog** design  
 Main and Differential are separated.

ITEM NO.	Default/ QTY.	PART NUMBER	DESCRIPTION
1	1	49-1000C	BELT FEED ASSY.11337HSEJ2
2	1	49-2000E	DRIVE ASSY.HEAVY DUTY
3	1	123-72157M	NEEDLE BAR.MODIFIED
4	1	123-78808M1	NEEDLE CLAMP.M06919G JUK
5	1	425-14179	STUD SPACER
6	1	49005	REAR THROAT PLATE MT.
7	1	49006	SHAFT,PLAIN,60C,12MMX7.0L
8	1	49021	PLATE,CLOTH MOD.
9	1	49025A	PLATE, SIDE COVER, MO-6916C, 11337HSJ28A
10	1	49026	BEARING CAP ASSY
11	1	49047	PRESSER BAR LEVER
12	1	49063	LEVER SLEEVE
13	1	49065	CHIP DEFLECTOR
14	1	49066	TRIM DEFLECTOR
15	1	49067	GUARD, NEEDLE
16	1	49069	BRACKET, NEEDLE GUIDE
17	1	1337001	FRONT NEEDLE GUARD
18	1	1337002	REAR NEEDLE GUARD
19	1	1337169	MOTOR MOUNT ASSY
20	1	1337218	COUPLING, 15MM BORE
21	1	1337570	LINKAGE ASSY.OUTSIDE NDL, 1337 FLANGER
22	1	9003365	MOD,JUKI PT WP-0764016-SP
23	1	B-2402-716-000	LOOPERTHREAD GUIDE TUBE
24	1	M2J96-002	MAIN FEED DOG

ITEM NO.	Default/ QTY.	PART NUMBER	DESCRIPTION
25	1	M2J96-003	DIFFERENTIAL FEED DOG
26	1	M3J96-003	PLATE, THROAT, 3/4 GA
27	1	M4J28-002	NEEDLE CHUCK.3/4 GA
28	1	M5J96-001	LOOPER HOLDER
29	AR	MM96165K31	CORK GASKET
30	1	MM98029A043	WASHER,.188ID,.438OD
31	1	MML075H	SPIDER,HITRL
32	1	SJUKI-6916G	SEWING HEAD,JUKLSS,4.8MM
33	10	SNTVX722-140GB	NEEDLE,SIZE 140/22
34	1	SSBC90032	8-32X1/2 BUTTON CAP
35	1	SSBC90040	8-32 X 3/4 BUTTON CAP
36	2	SSFC01056	1/4-20 X 7/8 FLAT CAP
37	1	SSHCM6X16S	SCREW, HEX M6X16 SS
38	1	SSPS70016	4-40 X 1/2 PAN HD SLOTTED
39	4	SSPS70032	4-40 X 1/2 PAN HD SLOTTED
40	1	SSSC70024	4-40 X 3/8 SOCKET CAP
41	4	SSSC90040	8-32 X 5/8 SOC CAP SC
42	4	SSSC98056	10-32 X 7/8 SOC CAP
43	3	SSTS85012	6-40 X 3/16 TRUSS HEAD
44	4	WWF4	WASHER, FLAT, #4
45	1	WWFM3	FLAT WASHER, M3
46	1	WWL4	WASHER,LOCK,#4
47	1	WWS3502-27	SPRING WASHER

- 48 1 SS811422TP SET SCREW, 11/64-40 L = 4
- 49 1 SS9151210TP SCREW 15/64-28, L = 11.8

Parts

**11337HSEJ28A Rev 6, Sew Head and Flanger**

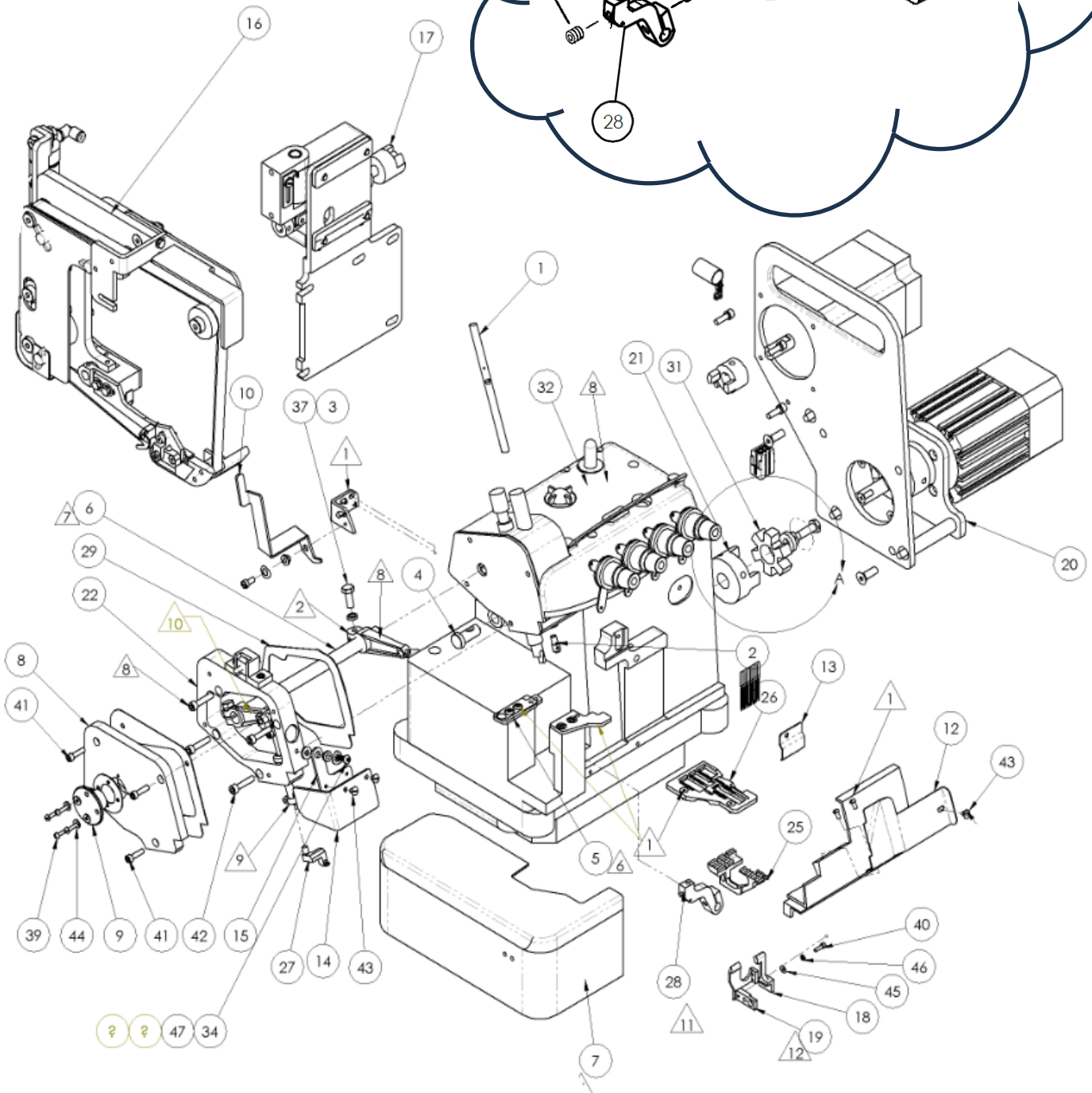
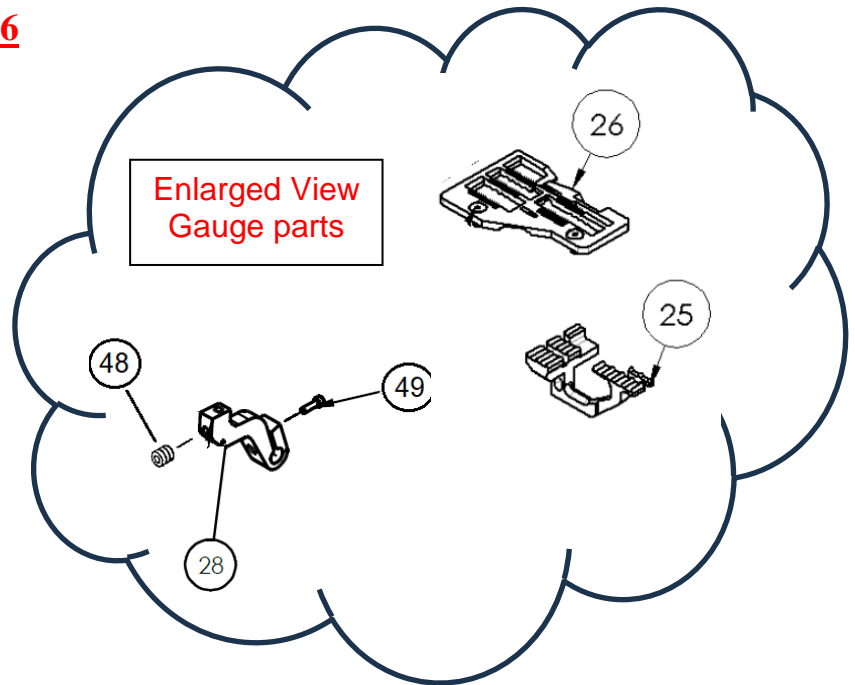
AAC Drawing Number 9002680 **Rev 6**

Note: Rev 6 used one-piece feed dog and new style gauge parts see below

M2J28-006 MAIN FEED

M2J28-003 PLATE

M5J96-001 LOOPER HOLDER



11337HSEJ28A parts list  
with **One-Piece Feed Dog**

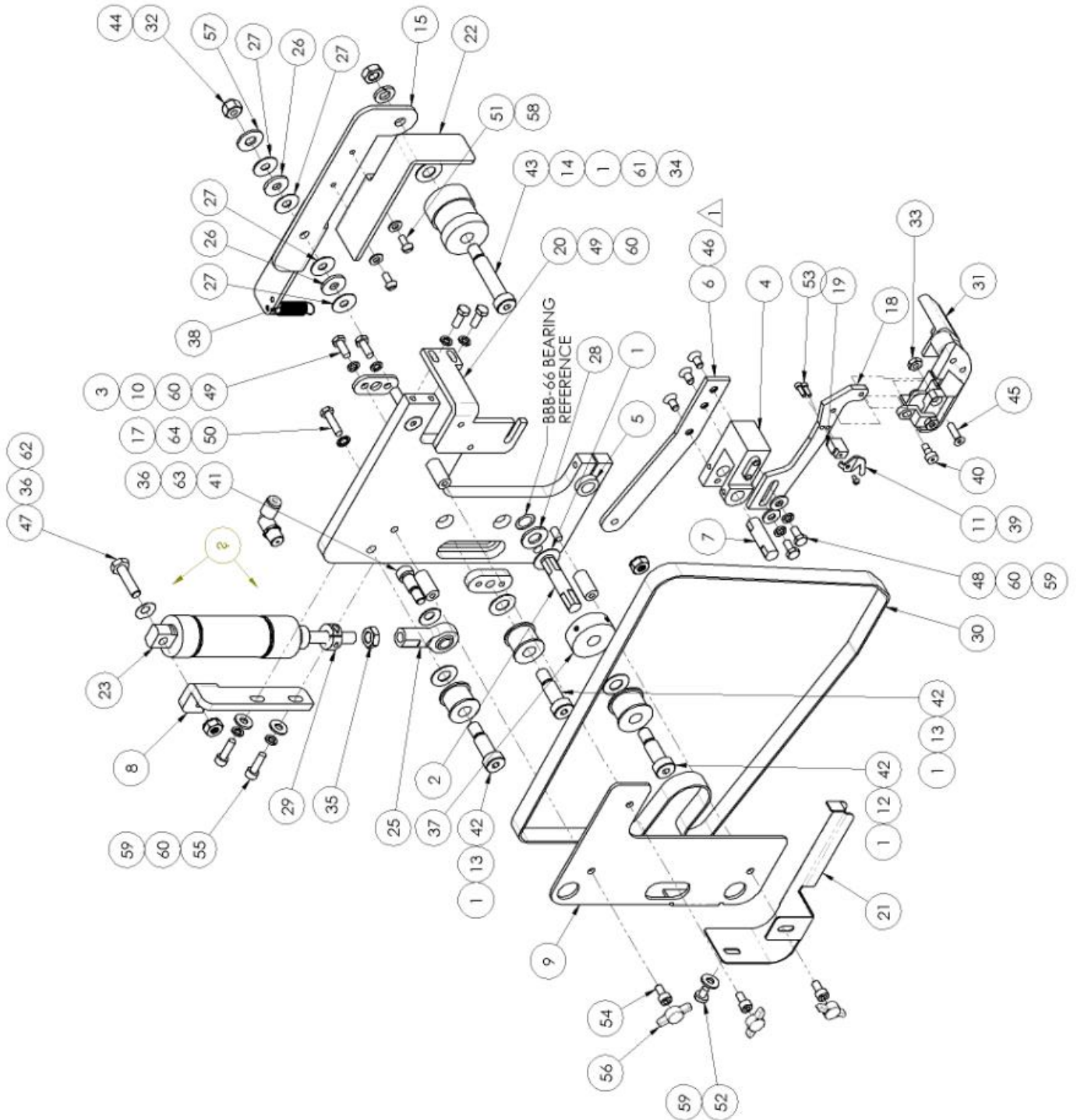
NO	QTY	PART NUMBER	DESCRIPTION	NO	QTY	PART NUMBER	DESCRIPTION
1	1	123-72157M	NEEDLE BAR,MODIFIED	25	1	M2J28-006	MAIN FEED DOG
2	1	123-78808M1	NEEDLE CLAMP, M06919G JUK	26	1	M3J28-003	PLATE, THROAT, 3/4 GA,
3	1	425-14179	STUD SPACER	27	1	M4J28-002	NEEDLE CHUCK,3/4 GA
4	1	49001	STUD,PUSH BUTTON,MOD	28	1	M5J96-001	LOOPER HOLDER
5	1	49005	REAR THROAT PLATE MT.	29	AR	MM96165K31	CORK GASKET
6	1	49006	SHAFT,PLAIN,60C,12MMX7.0L	30	1	MM98029A043	WASHER,,188ID,,438OD
7	1	49021B	PLATE,CLOTH MOD.	31	1	MML075H	SPIDER,HITRL
8	1	49025A	PLATE, SIDE COVER,	32	1	SJUKI-6916G	SEWING
9	1	49026	BEARING CAP ASSY	33	10	SNTVX722-	NEEDLE,SIZE 140/22
10	1	49047	PRESSER BAR LEVER	34	1	SSBC90032	8-32X1/2 BUTTON CAP
11	1	49063	LEVER SLEEVE	35	1	SSBC90040	8-32 X 3/4 BUTTON CAP
12	1	49065	CHIP DEFLECTOR	36	2	SSFC01056	1/4-20 X 7/8 FLAT CAP
13	1	49066	TRIM DEFLECTOR	37	1	SSHCM6X16S	SCREW, HEX M6X16 SS
14	1	49067	GUARD, NEEDLE	38	1	SSPS70016	4-40 X 1/2 PAN HD SLOTTED
15	1	49069	BRACKET, NEEDLE GUIDE	39	4	SSPS70032	4-40 X 1/2 PAN HD SLOTTED
16	1	49-1000C	BELT FEED ASSY,11337HSEJ2	40	1	SSSC70024	4-40 X 3/8 SOCKET CAP
17	1	49-2000E	DRIVE ASSY,HEAVY DUTY	41	4	SSSC90040	8-32 X 5/8 SOC CAP SC
18	1	1337001	FRONT NEEDLE GUARD	42	4	SSSC98056	10-32 X 7/8 SOC CAP
19	1	1337002	REAR NEEDLE GUARD	43	3	SSTS85012	6-40 X 3/16 TRUSS HEAD
20	1	1337169	MOTOR MOUNT ASSY	44	4	WWF4	WASHER, FLAT, #4
21	1	1337218	COUPLING,15MM BORE	45	1	WWFM3	FLAT WASHER, M3
22	1	1337570	LINKAGE ASSY,OUTSIDE NDL	46	1	WWL4	WASHER,LOCK,#4
23	1	9003365	MOD,JUKI PT WP-0764016-SP	47	1	WWS3502-27	SPRING WASHER
24	1	B-2402-716-000	LOOPER THREAD GUIDE TUBE	48	1	SS8110422TP	SET SCREW, 11/64-40 L=4

49 1 SS9151210TP SCREW 15/64-28 L = 11.8

Parts

**49-1000C Belt Feed Assembly**

AAC Drawing Number 9002697 Rev 6



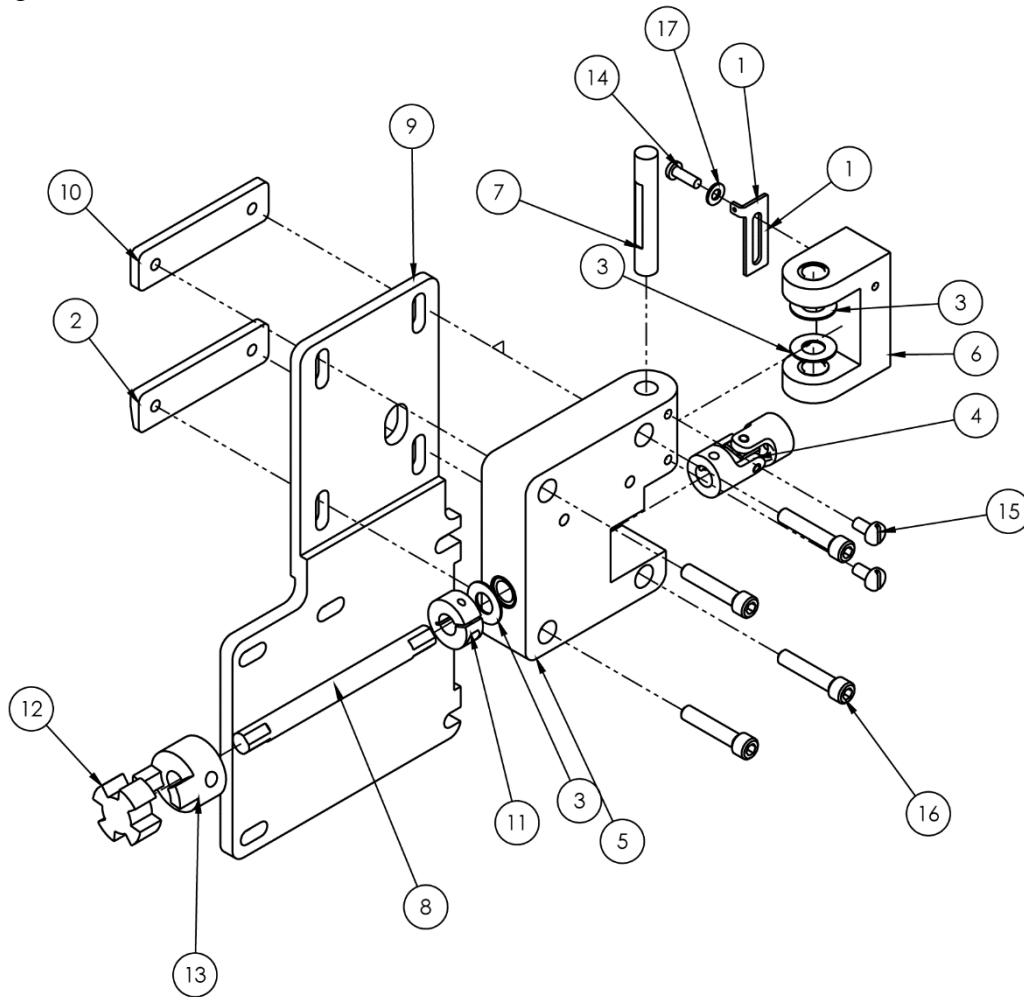
49-1000C parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION	ITEM	QTY.	PART NUMBER	DESCRIPTION
1	5	3517	WASHER,THRUST,BRONZE	33	1	NNH8-32	NUT,HEX, 8-32 REG.
2	1	49030	SHAFT,DRIVE	34	1	NNJ5/16-18	NUT,JAM,5/16-18
3	1	49031	SPACER,IDLER ROLLER	35	1	NNJ5/16-24	NUT,JAM,5/16-24
4	1	49033	BLOCK,PRESSER ARM PIVOT	36	2	NNK1/4-20	NUT,KEP,1/4-20
5	1	49035	BUSHING,PIVOT,PRESSER ARM	37	1	PP20XLB037M4	PULLEY,MOD,1/5P,20T,3/8B
6	1	49036	ARM,FOOTLIFT	38	1	RRE29C	SPRING,EXT .020X.19X1.5
7	1	49040	PRESSER ARM PIVOT SHAFT	39	1	SS-7060510-SP	3/32-56 x 3/16 PAN HD
8	1	49045	MOUNT,FOOTLIFT CYL	40	1	SSAS012012S	SCREW,ALLEN SHOULDER,S/S
9	1	49048	BELT COVER	41	1	SSAS020032	SHOULDER BOLT 5/16 X 1/2L
10	1	49049	PLATE,WASHER	42	3	SSAS024048	SHOULDER BOLT,3/8X3/4X5/16-18
11	1	13116702	THREAD TRIMMER	43	1	SSAS024096	SHULDER BOLT 3/8 X 1 .50L
12	1	1342Z-201A	ROLLER,DELRLIN,TOP BELT FD	44	1	SSFC01080	1/4-20 X 1-1/4 FLAT CAP
13	2	1342Z-201B	ROLLER,DELRLIN,TOP BELT FD	45	1	SSFC90040	8-32 x 2 FLAT ALLEN
14	1	49023A	ROLLER,FRONT	46	3	SSFC98024	#10-32 X .375 FLAT CAP
15	1	49028A	ARM,BELT TENSION	47	1	SSHC01064	1/4-20 X 1 HHCS
16	1	49032A	MAIN MOUNTING PLATE	48	2	SSHC98024	10-32 X 3/8 HEX CAP
17	3	49038A	BELT COVER SPACER	49	4	SSHC98032	10-32X1/2 HEX HD
18	1	49039D	ARM,PRESSER,11337HSJ28A	50	3	SSHC98048	SCREW, HEX CAP #10-32X.75
19	1	49039E	BRKT, THREAD CUTTER	51	2	SSPS90024	SCREW, #8-32 X 3/8 LG PAN HD
20	1	49041A	TOP SUPPORT BRKT	52	1	SSPS98016	10-32 X 1/4 PAN HD SLOT
21	1	49050B	GUARD,BELT,EXTENDED	53	2	SSSC70020	#4-40 X 5/16 SOCKET CAP
22	1	49068A	GUARD,BELT	54	3	SSSC98024	10-32 X 3/8 SOC CAP
23	1	AAC6DP-1	CYLINDER,AIR,DA	55	2	SSSC98040	10-32 X 5/8 SOC CAP
24	2	AAQME-5-8	QUICK MALE ELBOW	56	3	SSW#10	WING SCREW KNOB
25	1	BBAW-5Z	ROD END, SPHERICAL .5/16ID	57	1	WWF1/4	WASHER, FLAT, 1/4", COM
26	2	BBNTA411	BEARING,THRUST,.250B	58	2	WWF8	WASHER, FLAT, #8
27	4	BBTRA411	WASHER,THRUST,STEEL	59	5	WWFS10	WASHER, FLAT, #10, SAE
28	1	BBT710-01	WASHER, THRUST, BRNZ.	60	8	WWL10	WASHER,LOCK,#10
29	1	CCCL5F	CLAMP COLLAR,5/16" BORE	61	1	WWL5/16	WASHER,LOCK, 5/16
30	1	GG356XL050U	BELT,GEAR,KEVLAR CORE,URE	62	1	WWS307-1	WASHER,SPRING,BELVEL
31	1	M1J28-001A	FOOT,3/4 GA,TBF,MO6916G	63	1	WWS5808	BELVILLE WASHER,.323I.D.X
32	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20	64	3	WWS110	WASHER,INTERNAL TOOTH,10

Parts

**49-2000E Heavy Duty Drive Assembly**

AAC Drawing Number 9002699 Rev 2

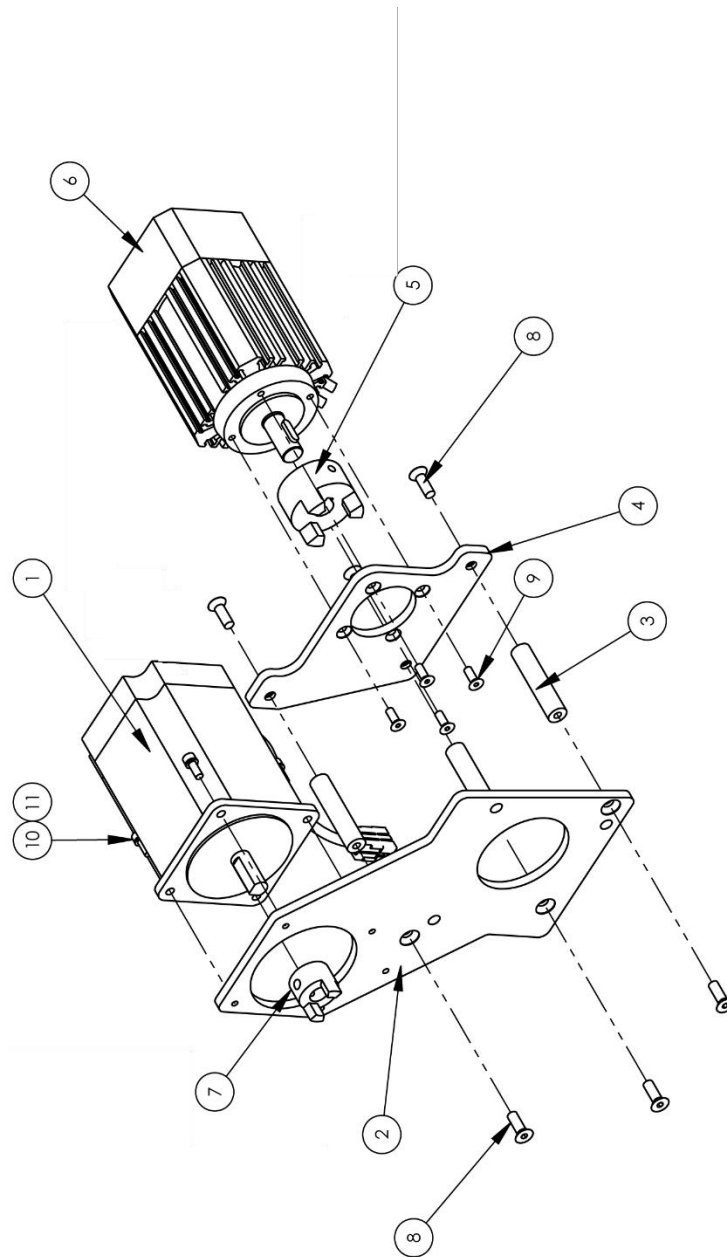


NO.	QTY	PART #	DESCRIPTION
1	1	1325-39C	SPRING CLIP
2	1	1337031	PLATE, NUT, 1/4-20, ANGLED
3	3	3517	WASHER, THRUST, BRONZE
4	1	3524-02	3/8" U JOINT
5	1	49012	TRANSFER BLOCK
6	1	49014	PIVOT BLOCK
7	1	49015	PIVOT SHAFT
8	1	49016B	SHAFT, TRANSFER
9	1	49018A	PLATE, REAR MOUNT
10	1	49022	PLATE, NUT, 2 PL, 2.20 CT
11	1	CCCL6F	CLAMP COLLAR- 3/8
12	1	MML050	SPIDER, COUPLING
13	1	MML050-375	COUPLING, 3/8 BORE
14	1	SSPS90032	#8-32 X 1/2 LG PAN HD
15	2	SSPS98024	10-32X3/8 PAN HD SLOT
16	4	SSSC01080	1/4-20X1-1/4, SOC CAP
17	1	WWF8	WASHER, FLAT, #8

Parts

**1337169 Motor Mount Assembly**

AAC Drawing Number 1337169 Rev 1

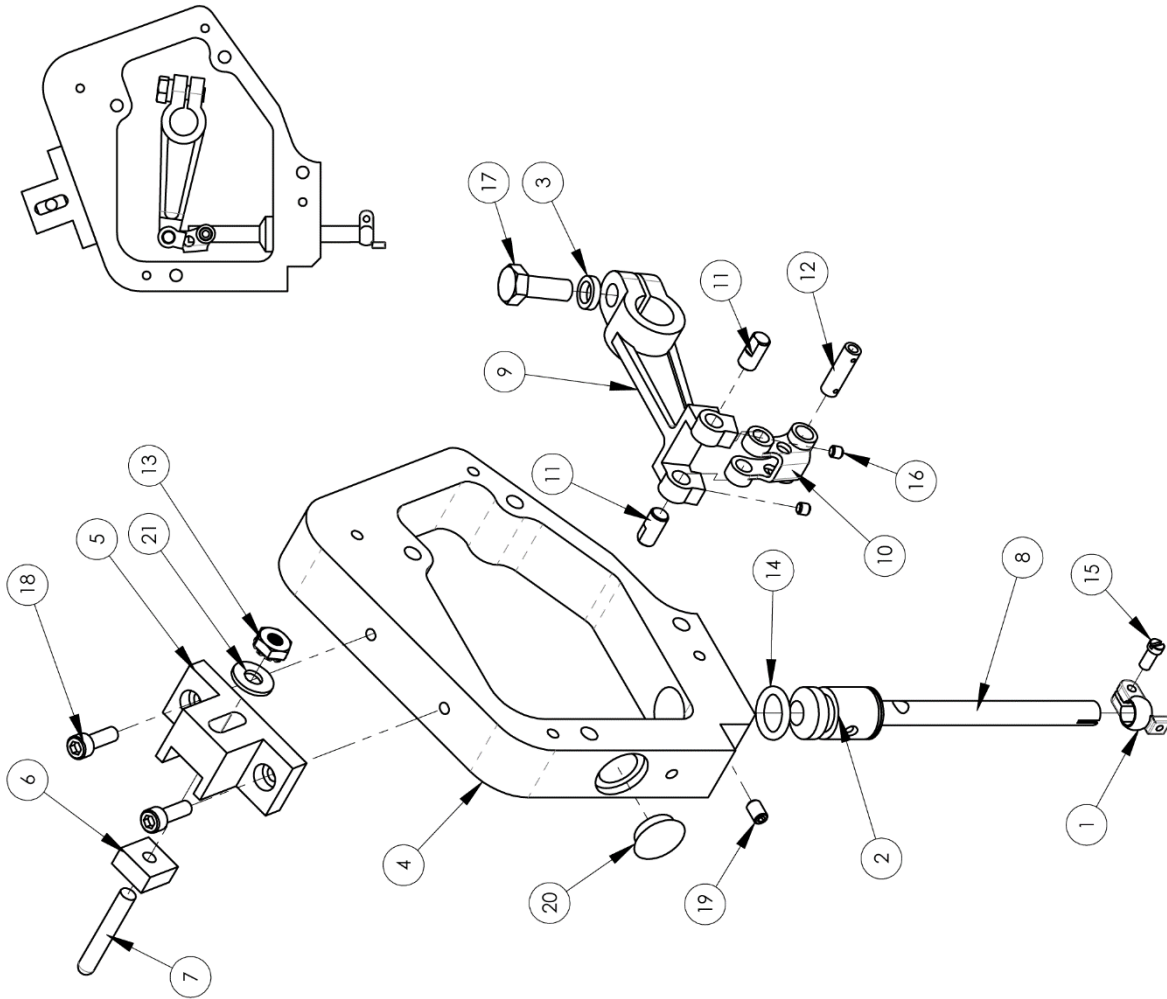


NO.	QTY	PART #	DESCRIPTION
1	1	011-020C	MOTOR, STEPPER W/PLUG
2	1	1337166	PLATE,MNT,DUAL EFKA
3	3	1337167	SPACER,MOTOR MNT
4	1	1337168	BRKT,MOTOR MNT
5	1	1337191	COUPLING,14MM BORE,W/KEY
6	1	4059-AB425S	MOTOR & STEPPER CONTROL
7	1	MML050-500	COUPLING,1/2" BORE
8	6	SSFC01048	1/4-20 X 3/4 FLAT CAP
9	4	SSFCM5X14	M5-0.8X14, FLAT ALLEN
10	4	SSSC98032	10-32X1/2, SOC CAP
11	4	WWL10	WASHER,LOCK,#10,S/S

Parts

1337570 Linkage Assembly, Outside NDL

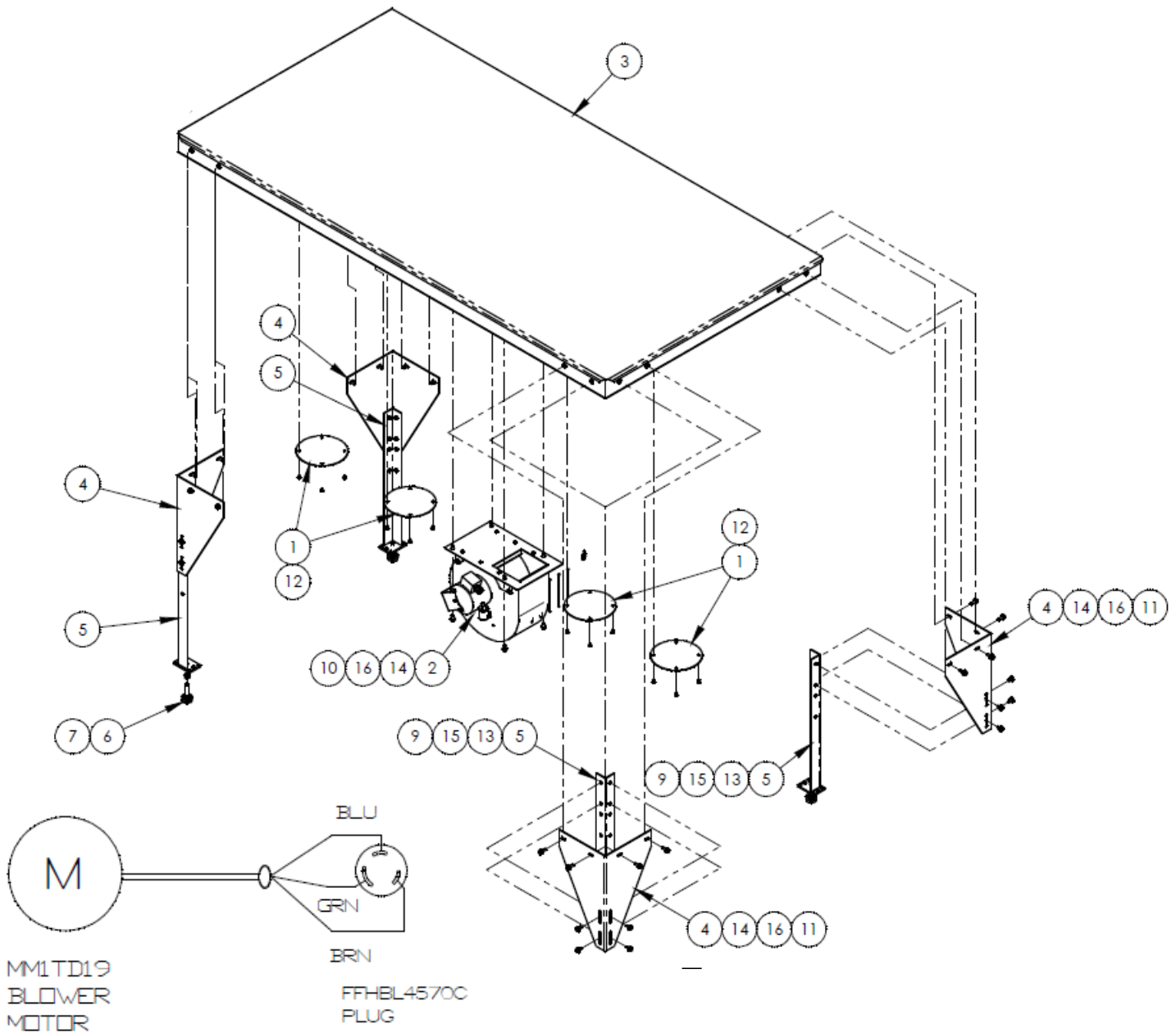
AAC Drawing Number 1337570 Rev 4



NO	QTY	PART #	DESCRIPTION
1	1	122-80608	NEEDLE CLAMP
2	1	12253100	NEEDLE BAR BUSHING
3	1	425-14179	STUD SPACER
4	1	49017A	SPACER,SIDE COVER
5	1	49042	LATCH BLOCK
6	1	49044	LATCH PIN NUT
7	1	49053	STUD, LATCH
8	1	1337568	NEEDLE BAR,MODIFIED
9	1	13207956	NEEDLE DRIVE ARM, 6916G
10	1	13208004	NEEDLE DRIVING LINK
11	2	13209200	NDL DRIVE ARM PIN B
12	1	13209507	NEEDLE DRIVING PIN "B"
13	1	NNK10-32	KEP NUT, 10-32
14	1	R0108240100	O-RING
15	1	SS6080720SP	SCREW , NEEDLE CLAMP MOG-3176
16	2	SS-8090530-TP	SCREW F/ JUKI
17	1	SSHCM6X16S	SCREW , HEX M6X16 SS
18	2	SSSC90032	#8-32 X 1/2 SOC CAP SC
19	1	SSSS90016	#8-32 X 1/4 SET SCREW
20	1	TA1250406R0	RUBBER PLUG
21	1	WWFS10	WASHER, FLAT, # 10, SAE

# 1337A-160 Air Table Assembly, Single TBL

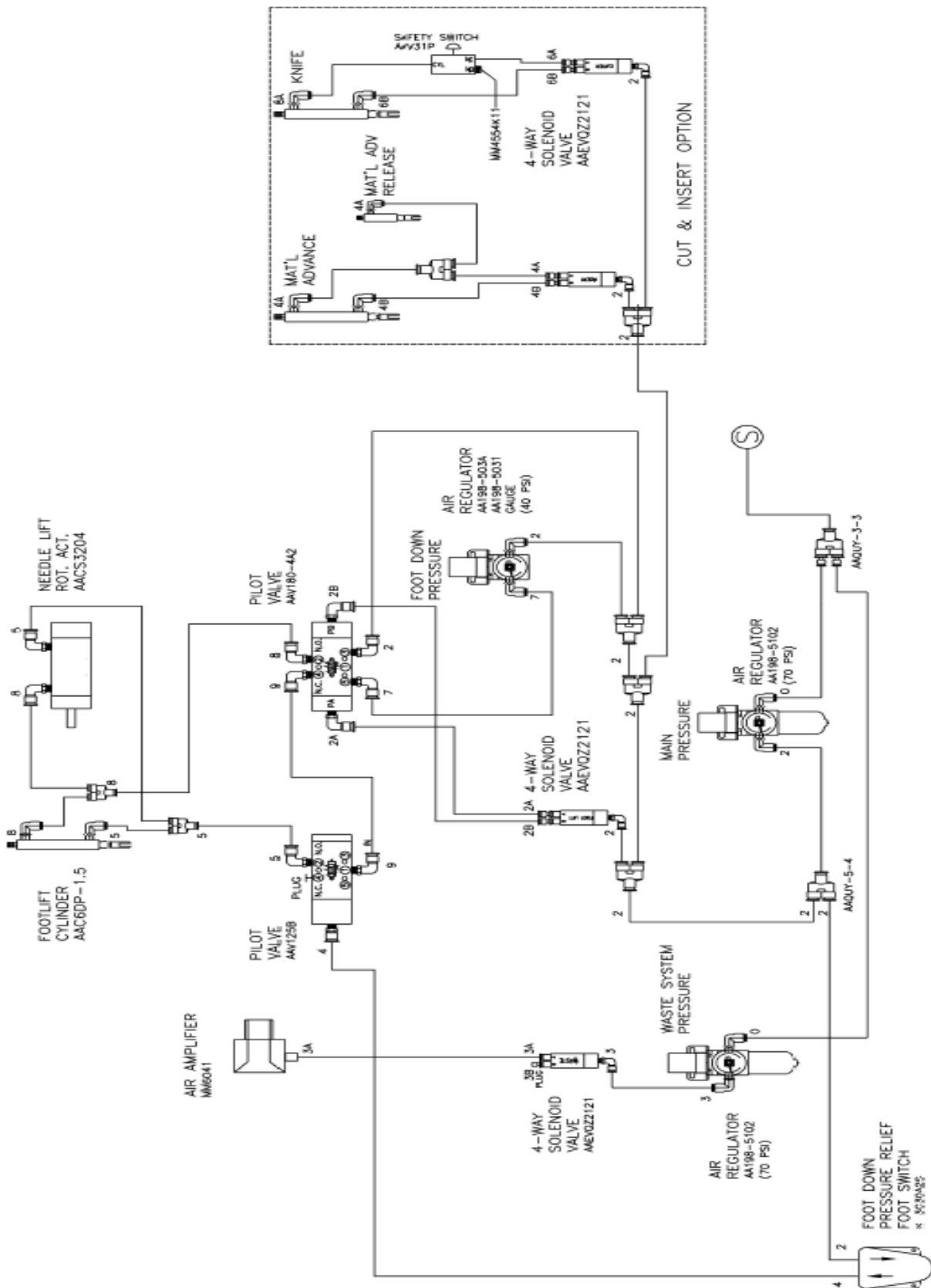
AAC Drawing Number 1337296 Rev 8



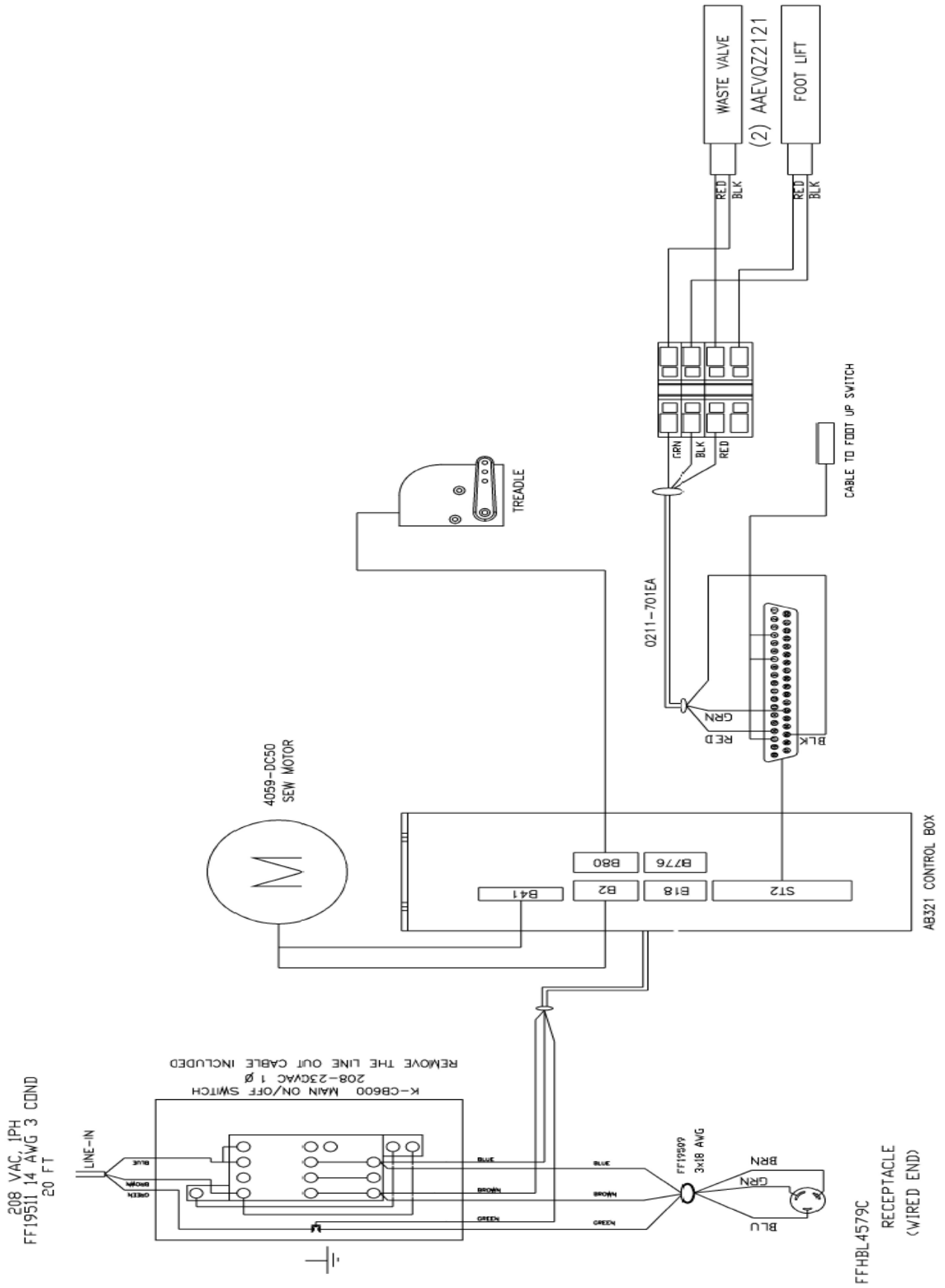
ITEM	QTY.	PART NUMBER	DESCRIPTION
1	4	1335-159	ACCESS COVER
2	1	1337860	BLOWER ASSY,1/6 HP
3	1	1337A-150	AIR TABLE ASSY
4	4	1337A-0161	ANGLE, CORNER
5	4	1337A-0163	WELDMENT, LEG, TABLE
6	4	MMFB4444	FOOT, RUBBER, 1/2-13 STUD
7	4	NNH1/2-13	NUT,HEX,1/2-13

ITEM	QTY.	PART NUMBER	DESCRIPTION
9	16	SSHC01048	1/4-20 X 3/4 HEX CAP
10	4	SSHC10048	5/16-18 X 3/4 HHCS
11	16	SSHC10064	5/16-18 X 1 HHCS
12	28	SSZH#10032	SCREW,SHT.METAL HEX 10
13	16	WWF1/4	WASHER, FLAT, 1/4", COM
14	20	WWFS5/16	WASHER,FLAT,SAE,5/16
15	16	WWL1/4	WASHER,LOCK, 1/4
16	20	WWL5/16	WASHER,LOCK, 5/16

# 1337HEC-PD Pneumatic Diagram



# 1337HE-WD Wiring Diagram



## 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.

## X TRAINING

Check	Description	Time Hrs.
	<b>Basic Function - Review Of Machine</b> <ul style="list-style-type: none"> <li>• Sequence of operation</li> <li>• Operation For Technicians</li> </ul>	.5
	<b>Sewing Head</b> <ul style="list-style-type: none"> <li>• Belt Feed adjustments.</li> <li>• Maintenance of edge trimmer</li> <li>• Oil and filter change intervals.</li> </ul>	2
	<b>Waste System</b> <ul style="list-style-type: none"> <li>• Disassemble vacuum assembly; adjust for proper air volume; set to proper PSI (80 psi.)</li> </ul>	1
	<b>Sew Off Machine</b> <ul style="list-style-type: none"> <li>• Start review of any questions thus far.</li> </ul>	1
	<b>Electrical and Pneumatics</b> <ul style="list-style-type: none"> <li>• Diagram evaluation.</li> <li>• Discuss Efka Programing</li> </ul>	4
	<b>Troubleshoot Unit</b>	1
	<b>Basic Function - Review Of Machine with Operator</b> <ul style="list-style-type: none"> <li>• Sequence of operation</li> <li>• Operator instruction and breakdown</li> </ul>	2
	<b>Evaluate any questions.</b>	1

**Participants:**

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**Instructor:** \_\_\_\_\_

**Date:** \_\_\_\_\_



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## Notes:



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Training



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