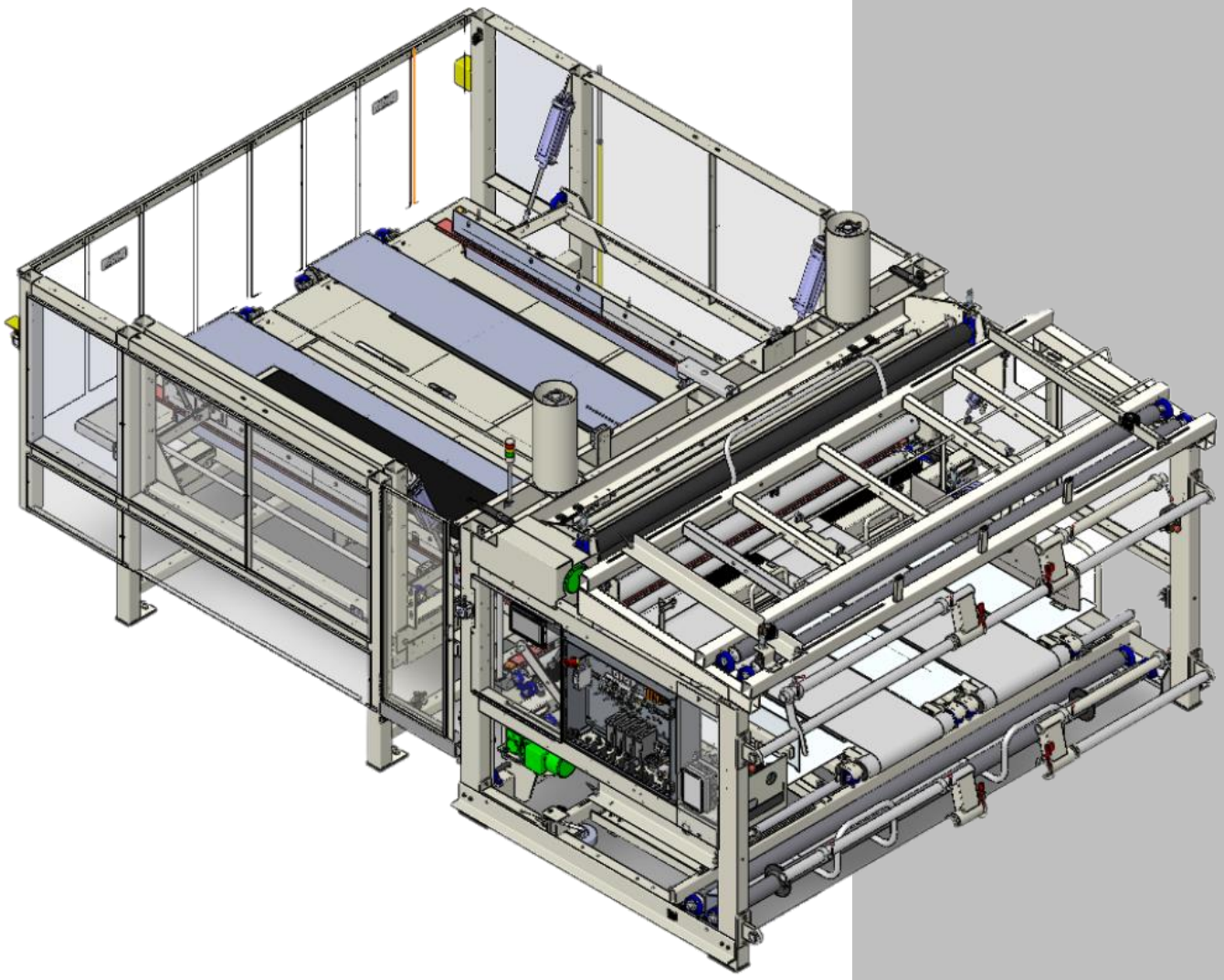
Model **1390BA**

Revision 0 Released October 10, 2023(wr)

Technical Manual & Parts Lists



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ATLANTA ATTACHMENT COMPANY, INC.

Confidential and Proprietary Information

IMPORTANT

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

Contents

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 1390B Auto pack should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include.

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

Intended Use

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

Exclusion of Misuse

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

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

Liability

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

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

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

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

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

Choice and Qualification of Personnel

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

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

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines

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

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

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

Damage

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

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

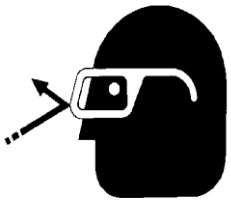
Faults or Errors

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

Signs on the Machine

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

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

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

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

Electrical Power Supply

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

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

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

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

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

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

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

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

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

Workplace Environment

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

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

Local Regulations

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

Maintenance

General Safety Instructions

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

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

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

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

Repair

Replacement Parts

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

Repair, Electrical

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

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

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

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

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

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

Ventilation/Hazardous Gases

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

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

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

1. INSTALLATION

Component Identification

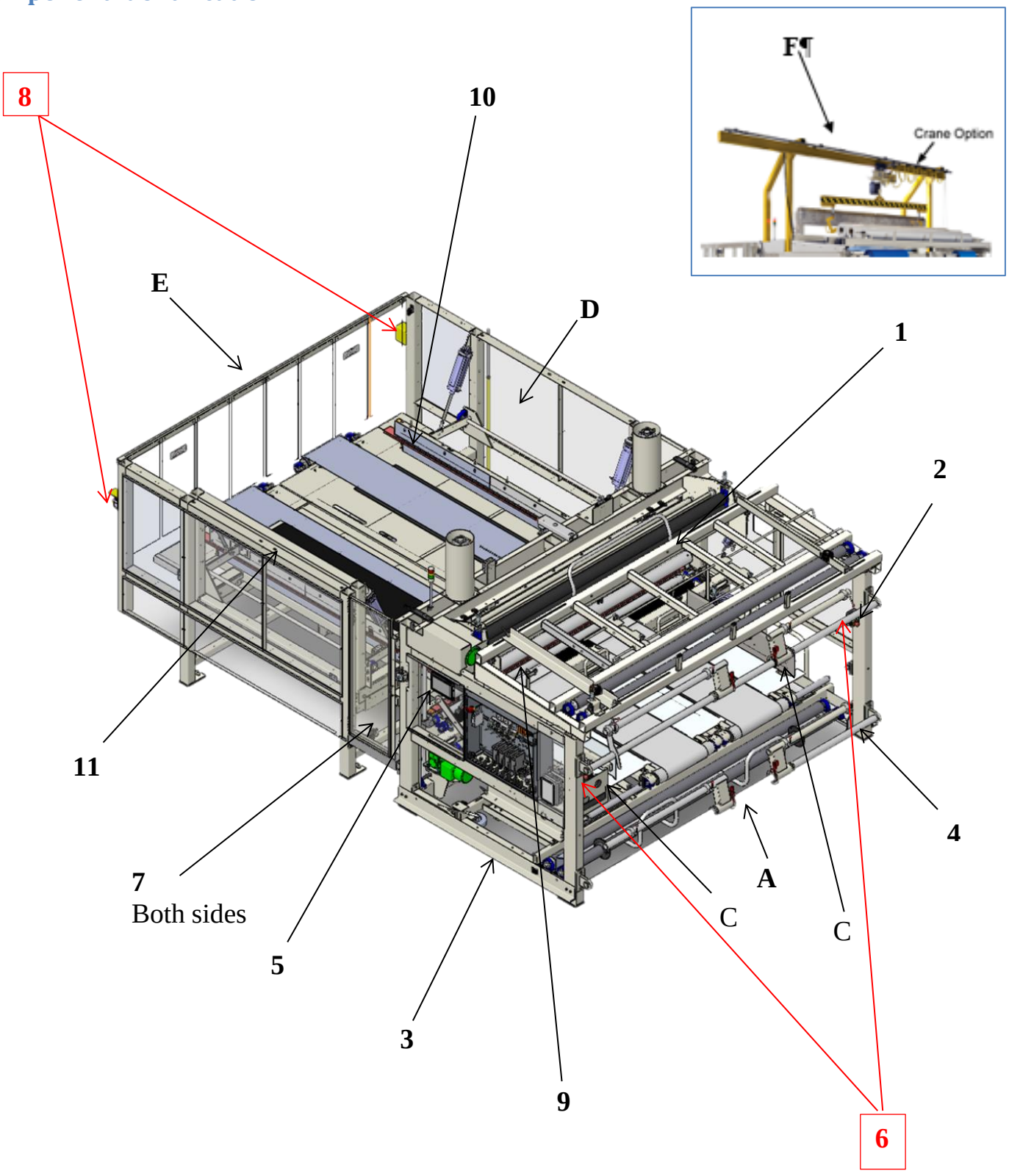


Figure 1

Machine Layout

Refer to Figure 1 on page 10.

A. Infeed End

1. Top Film Roll storage
2. Top Boot Roll support bar
3. Bottom Film Roll storage
4. Bottom Boot Roll support bar

B. Machine Controls

5. Touch Screen
6. Pause/Stop Cable
7. Side Doors
8. A Output Emergency Stops
8. B Input Emergency Stops

C. Alignment Area

Right Side - Fixed
Left Side - Adjustable

D. Seal Area

9. Cross Seal
10. Right Side Seal – Fixed
11. Left Side Seal – Adjustable
Compression option (not shown.)

E. Outfeed End

F. Optional:

Overhead roll holder and hoist Option for loading the Top Film rolls**.**

Machine Specifications

Capacity & Production Specs.

Max. Width of Infeed	85”
Min. Width of Infeed	72”
Max Height under Pressure Roller:	21”
Roll capacity, top & bottom (12” dia)	4
Infeed/outfeed conveyor height (inch)	36.5
Overall height	103
Max Film width (inch)	120
Film width: Top (inch)	108
Film width: Bottom (inch)	100
Boot roll dia (inch)	10-12
Machine Weight (lbs.)	16,000
Shipping weight (lbs.)	18,000

Production Rate:

3.25 Queens/min.	(without compression)
2.50 Queens/min.	(with compression)

NOTE: The machine has 3 adjustable width settings. They are typically set to 84" for Cal-Kings, 80" for Queen, XL Full and Twin beds, and 76" for regular Full and Twin beds. If required, the width settings can be set to any three positions desired, within the 72"-85" range. There is an optional 4th setting available.

Power Requirements

Volts	208-240 Delta 3-phase 50/60 Hz
Amps	30A/Leg
Air Consumption in SCFM	35 SCFM
Air Pressure	80 Psi
Power and Air Connection	Left, Mid, Side

Physical Specs:

Infeed/Outfeed Conveyor Height	36"
Overall Dimensions	152"w X 240"l X 103"h
Overall Height w/ Hoist Option	13'
Weight (w/o Crane or Compression)	16000lbs
Max Film Width Top or Bottom	120"
Typical Film Width - Top (Up To 16in Bed Thk.)	112" w/o Compression 108" w/ Compression
Typical Film Width - Bottom	102"
Roll Capacity (Top & Bottom)4 Rolls (12" Dia.)	Boot Roll Dia. 10" Nom., 12" Max
Max. Left Side Boot Length	36"
Max. Right Side Boot Length	30"

Pressure Gauge Settings:

Main Pressure	70-80psi
Film Roll Brake Pressure	5 –10psi
Input light Press. Roller (white PVC)	50psi
Output left Side Seal Pos. Cylinder	50psi

Mattress Size Limitations:

(With Raised Seal Bars / 118" top roll)

feed in 80" side.....	21" mattress height
feed in 84" side.....	19" mattress height

(w/o Raised Seal Bars / 118" top roll)

feed in 80" side.....	18" mattress height
feed in 84" side.....	16" mattress height

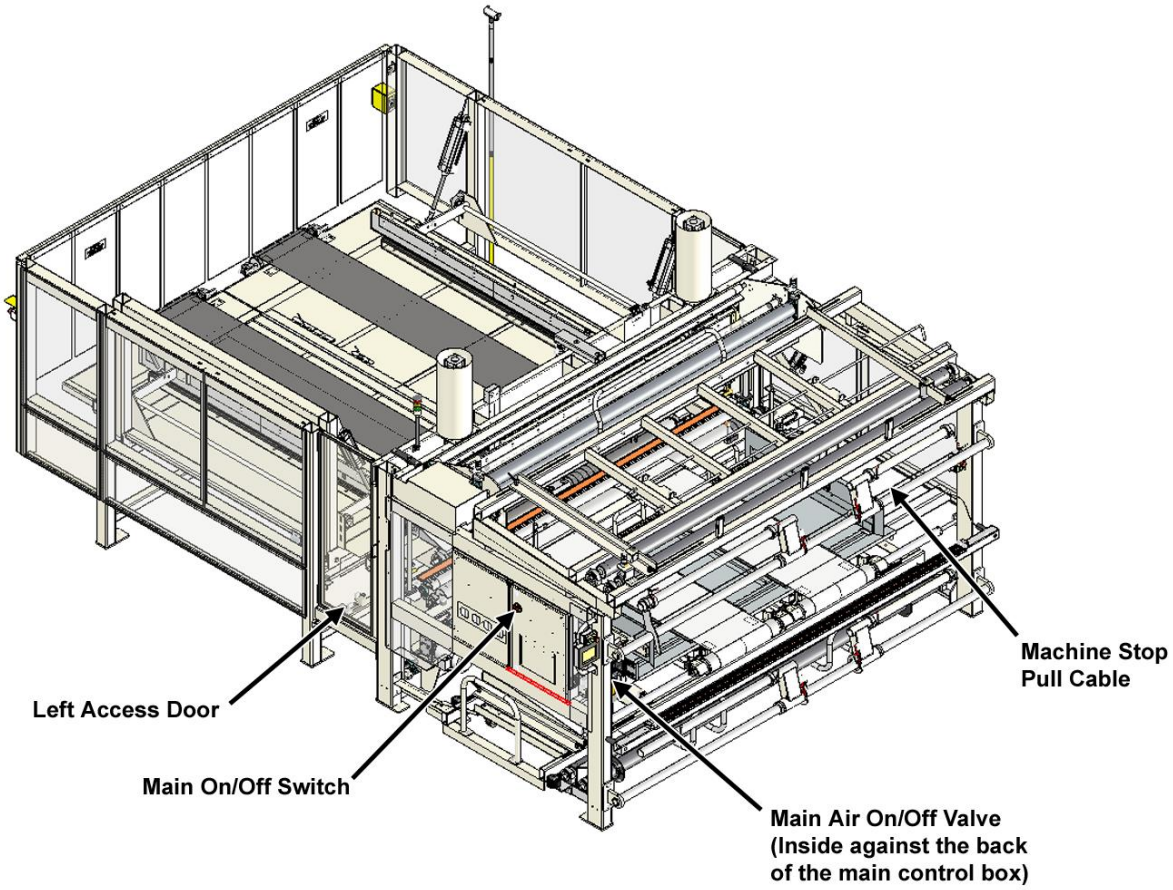
Machine Safety

The 1390BA Auto-Pack is large machine and has many powerful drives and mechanisms.
ANYONE assigned to operate and/or maintain this machine must be properly trained by an Atlanta Attachment technician, or a trained and qualified factory mechanic. Operation and/or maintenance of this machine by untrained personnel may result in a serious injury or even death.
ANYONE assigned to operate and/or maintain this machine, must read, understand, and follow the safety instructions and guidelines listed below mentioned in following pages.
ANYONE assigned to operate or maintain this machine MUST READ AND BE FAMILIAR with the location and operation of ALL operator machine controls, with particular emphasis on the following:
Main Electrical Power ON/OFF switch
Main Air Supply ON/OFF valve
Four Emergency-Stops, located on:

- Main Control Box
- Remote Operator Box
- Left Output post
- Right Output post

Machine STOPS include:

- The Input PULL CABLE STOP
- The main panel STOP push button
- The Remote Operator Panel STOP push button
- The two side Access Doors.



WARNING 1

In auto mode, this machine can start automatically at any time. Therefore, when the machine is turned on:
- NEVER ENTER INSIDE THE MACHINE
- NEVER CRAWL UNDER THE MACHINE
- NEVER CLIMB ON TOP OF THE MACHINE
- NEVER REACH INSIDE THE MACHINE FOR ANY REASON
- NEVER PLACE ANY PART OF YOUR BODY INSIDE THE MACHINE

WARNING 2

In manual mode, this machine may be prompted to execute any of its functions. Therefore, to prevent injury or machine damage, only a properly trained operator or mechanic should use the machine in this mode of operation.

WARNING 3

To perform any machine maintenance always follow steps below:
1. FIRST, POWER DOWN THE MACHINE AND LOCK-OUT THE ELECTRICAL AND THE PNEUMATIC POWER SOURCES.
2. WAIT UNTIL SEAL BARS COOL OFF SUFFICIENTLY (APROX. 3 HOURS) BEFORE SERVICING THE SEAL BARS OR THE NEARBY AREAS OF THE MACHINE.

NOTE: If machine maintenance is absolutely necessary before seal bars have sufficiently cooled off, a service person must wear OSHA approved safety gear to protect him/her from a potential burn.

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:	Auto Pack Workstation	Model:	**1390BA**
Manufacturer:	Atlanta Attachment Co.	Location	

Energy		Location	Magnitude	Control Method
Electrical:		Disconnect/Ctrl Box	480V 3-Ph	Lockout & Tag
Pneumatic:		Main Regulator	90 PSI	Lockout & Tag
Gravity:		Cut bar Assy, presser belt Assy, Seal Bar assembly, Plastic Holder Clamp		

Remember to Release All Stored Energy!

Shutdown Procedure:

1. Inform all affected personnel that the machine will be in Lockout status.
2. Turn the power and pneumatic disconnects to the OFF position.
3. Fill out the tag with necessary information of the Lockout.
4. Install the Lockout device.
5. Verify all stored electrical energy has been released by pressing the power on button

. 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.

Startup Procedure:

1. Inform all affected personnel that the Lockout of this machine is being removed.
2. Replace any guards or safety devices which may have been removed during maintenance.
3. Remove the Lockout device and tag.
4. Turn the power and pneumatic disconnects to the ON position.
5. Push the green button on the back of the control panel to turn the machine on.
6. Inform all affected personnel that the Lockout has been removed and that the machine is ready for normal production operation.

Approved By: _____ Date: _____

2. OPERATION

Machine Start (Cold)

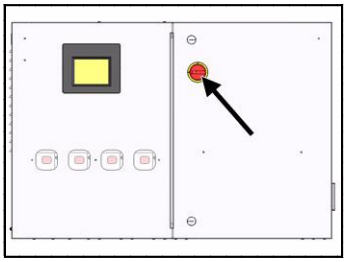


Fig. 3

Fig. 4

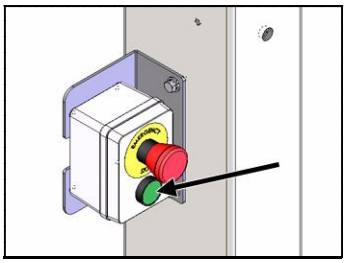


Fig. 5

1. Turn the Main On/Off switch to the ON position. See Fig. 3.
2. Turn the Main Air valve to the ON position. The pressure gauge should be set to 80 PSI. See Fig. 4.
3. Press the green POWER ON push button. See Fig. 5.

The Seal Bars begin to heat up at this point. It takes approx. 30 minutes to get the Seal Bars to their operating temperature.

Note: The Standard machine Temperature Settings are:

Side Seal Bars - 325 ºF (w/o boot film)
Side Seal Bars - 345 ºF (w/ boot film)
Cross Seal Bar - 345 ºF

Note: Under the normal machine conditions, the start screen will appear on the touch screen. When the green light on the light tower is on, the machine has reached operating temperature and is ready to run. If the green light does not illuminate, it usually indicates that one or more Emergency Stops are not reset, or other error condition exists. Refer to "Light Tower Indicator" on page 35 of this manual for further light tower color explanation.

4. Wait for all three Seal Bars to heat up to their preset temperatures. It will take approx. 20-30 minutes depending on the room temperature.

Note: The Seal Bars will not seal properly until they reach their proper temperature.

After a short delay (approx. 5 sec.) the INPUT belts will turn on. Machine is now ready for production.

5. Press the Start button on the touch screen. See Fig 6.

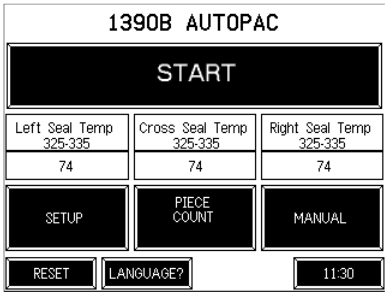


Fig. 6

Machine Start (Warm)

1. Wait for all three Seal Bars to heat up to their preset temperatures. It will take approx. 20-30 minutes depending on the room temperature.

Note: The Seal Bars will not seal properly until they reach their proper temperature.

2. Press the Start button on the touch screen. See Fig 6.
After a short delay (approx. 5 sec.) the INPUT belts will turn on.
Machine is now ready for production.

Note: If the machine does not start and you do not get an error message on the screen, refer to the LIGHT TOWER INDICATOR on page 35 of this manual for additional information.

Film Loading

Bottom Film Loading

The standard 1390BA machine comes with a pull-out Bottom Film Roll storage rack that can handle up to (3) 12” diameter x 120” long rolls of plastic film.

The Bottom Film Rack can be assembled two ways so it can be pulled out to the left or to the right of the machine for loading.

To load the rack:
1. Pull out the (2) locating/locking pins to (one on each side of the machine) unlock the rack from the rest of the machine.
2. Pull the rack out from under the machine far enough to load the rolls of film. Load three rolls using a standard forklift or other means.

Important note!
The film rolls must be loaded such that they unwind clockwise, looking from the left side of the machine (see “Film Routing” on page 20).

3. Roll the rack back under the machine and insert the locating/locking pins.

The Bottom Film Roll Rack assembly has two roll release rods which allow the operator to advance one roll of film at a time into the Bottom Film Roll Cradle. The release rods are extended to the right end of the rack, so the rolls can be advanced with the rack assembly locked in place.

Figure 8

Top Film Loading

The standard 1390BA machine comes with a Top Film Roll storage rack that can handle up to (4) 12" diameter x 120" long rolls of plastic film.

Important note! The film rolls must be loaded such that they unwind counterclockwise, looking from the left side of the machine (see "Film Routing" on page 20).

Besides the standard top film roll rack, Atlanta Attachment Company offers two options to aid in the loading and storage of the Top Film Rolls:

1. Crane option - For installations with a limited space on each side of the machine. The crane lifting mechanism can be swiveled 360 degrees from the shown position this allows any orientation of rolls on the floor next to the machine.
2. Extended Top Roll Rack option - For installations where the rolls can only be loaded from the Output End of the machine. This option allows loading of up to (18) 12" diameter rolls on top of the machine. The Extended Roll Rack option excludes the Crane option due to space limitations on top of the machine.

If the side space is not limited, an operator can load the Top Film using a standard forklift.

The standard Top Film Roll Rack has (2) roll film release rods to allow the rolls to be advanced one at a time.

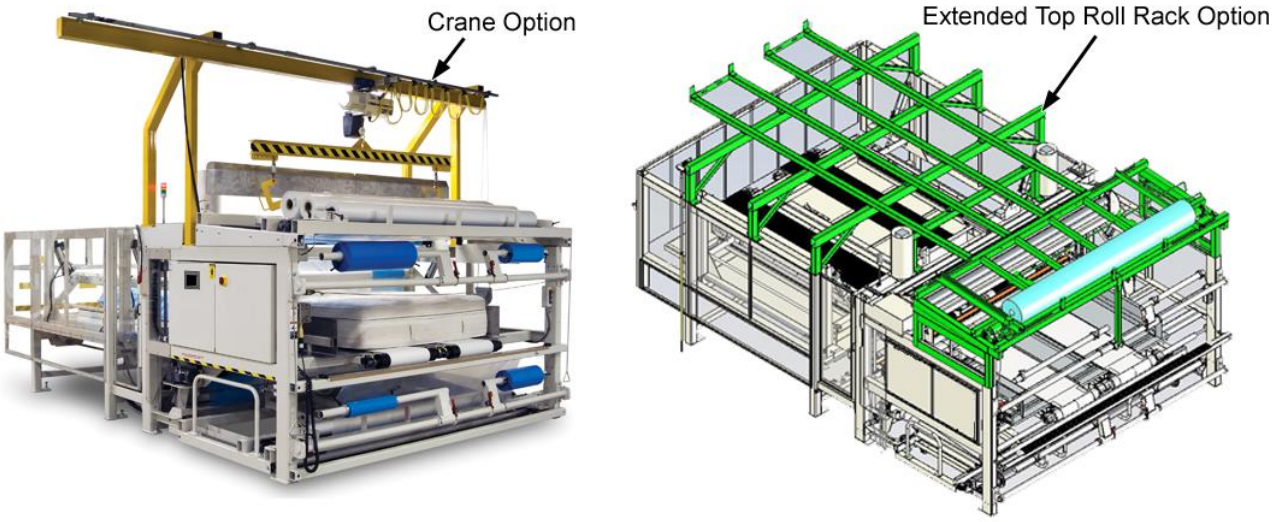


Figure 9

Boot Film Loading

The standard 1390BA machine comes with (4) Boot film Support Bars. See Figure 10. They are pivot mounted on a main support and each have a ratchet type mechanism. This design allows the operator to easily rotate the bar down to a lower, more ergonomic loading position. Once loaded, it is easy to rotate the boot roll into its working position. In addition, for more ergonomic loading, all boots load from outside - in. **Important note! All boot rolls must be loaded to unwind from the top of the roll.**

The right-side Boot bars will support rolls up to 12” diameter x 30” long.
The Left Side Boot bars will support rolls up to 12” diameter x 36” long.
Each Support Bar has two (Boot locating) collars. The inner collars are adjusted once during the initial installation and remain fixed thereafter. Their purpose is to properly locate the boot in reference to the corresponding Top or Bottom film edge. The outer collars are designed to prevent the boot roll from moving side to side. They have a ratchet type handle designed to lock the collar in place and to allow easy removal to remove and replace boot rolls. The outer collars should be clamped against the boot roll in such a way to allow the roll to rotate without much drag.

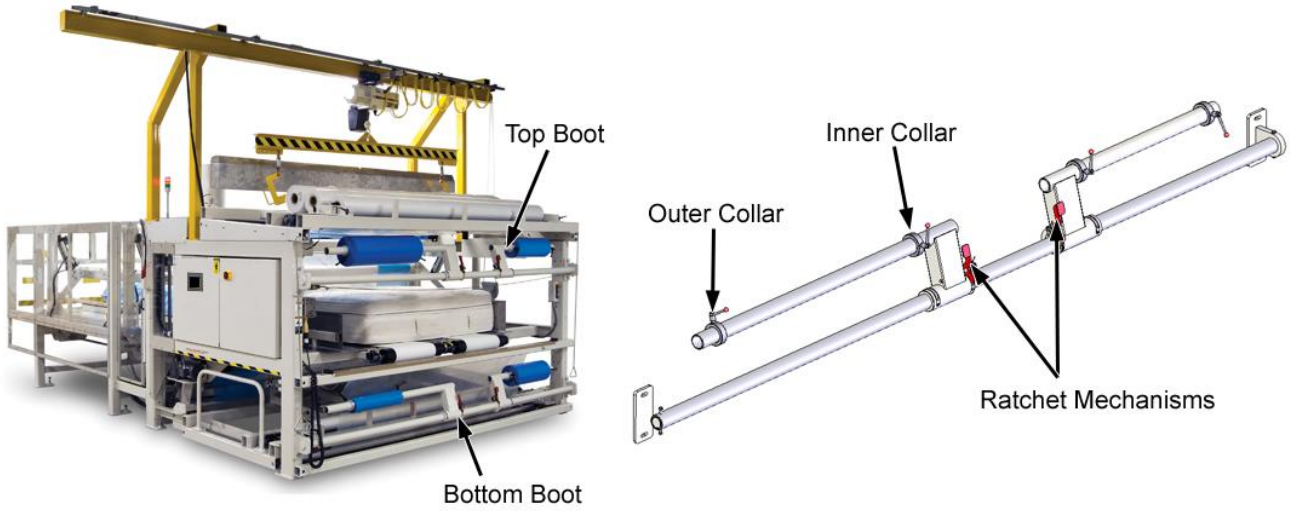


Figure 10

Film Routing

The Top and the Bottom plastic film routing is very important. The illustration below (Figure 11) must be carefully followed.
For the operator's convenience, a copy of this illustration is attached to the left input post of the machine.

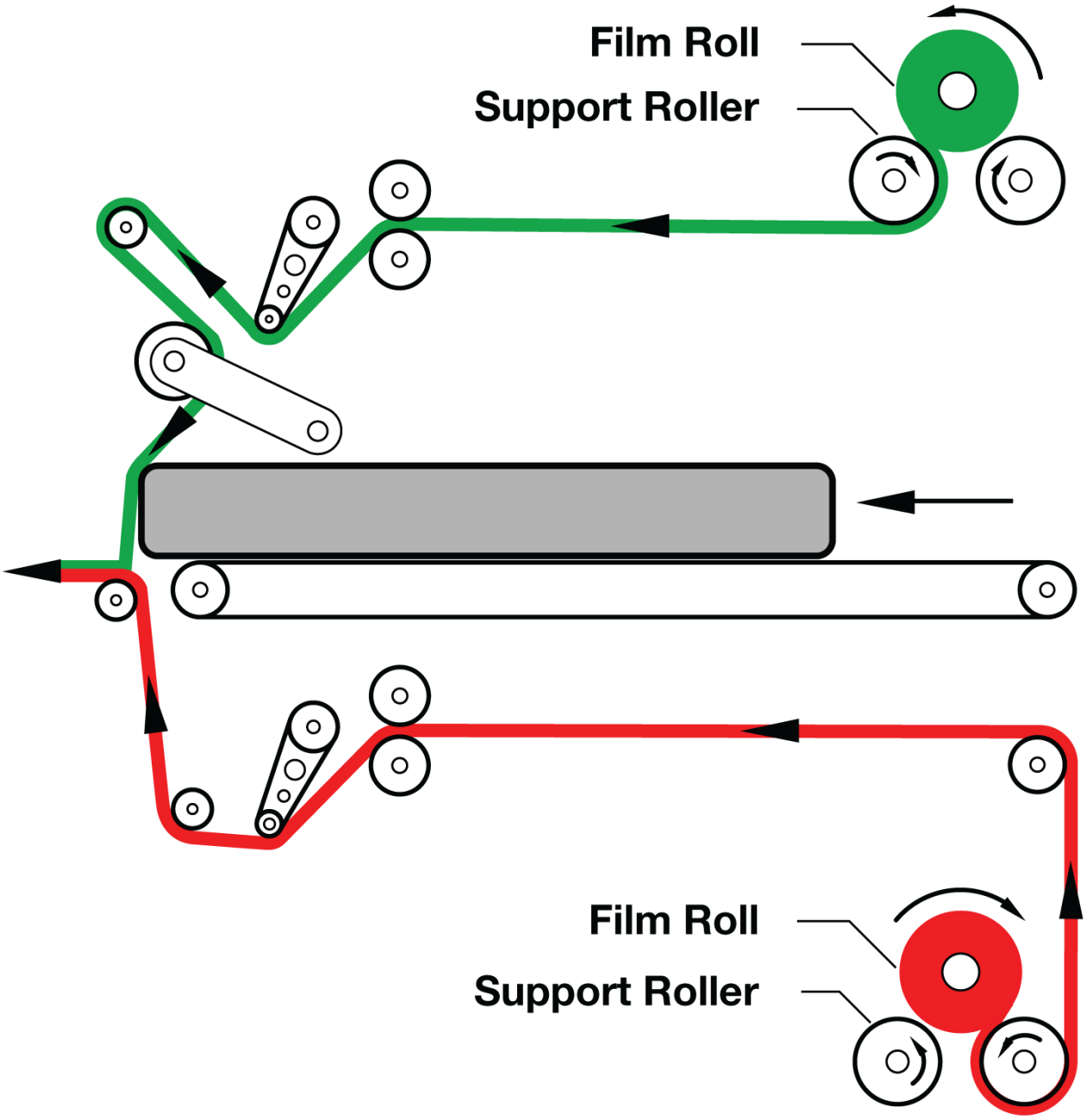


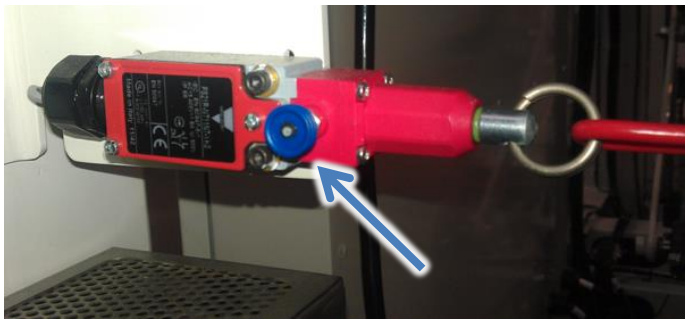
Figure 11

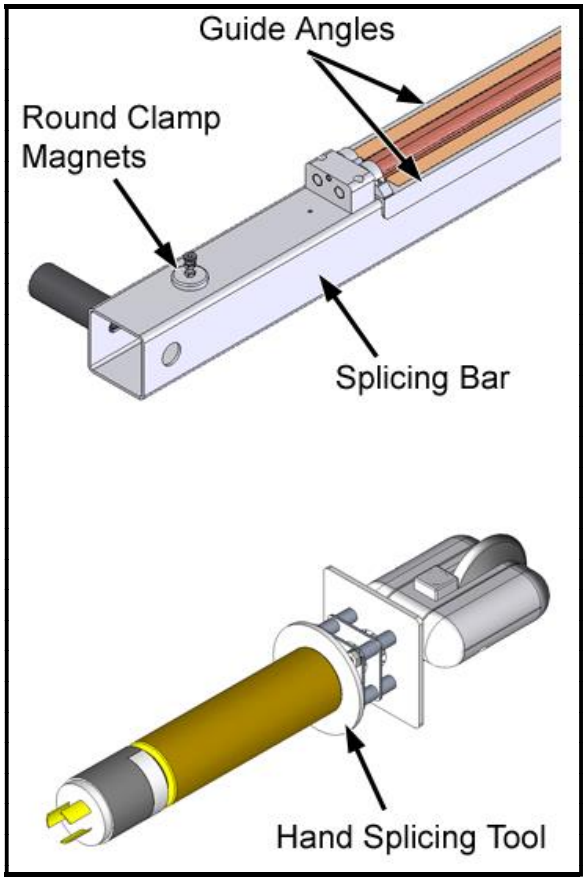
Film Splicing

1. When the plastic film runs out (from any roll), cut off the last 3 to 4 feet of it in order to eliminate any plastic that was adhered to the core and may have glue residue left on it. Make sure that there is no adhesive left on the film. If not removed, the adhesive will likely stick to the puller roller and wrap around causing a potential machine jam and/or machine component damage. In order to have enough film to make the splice, it may be necessary to reverse feed the roll being spliced. Before any reverse feeding top or bottom film rolls, one must feed the other film roll forward approximately the same amount.

2. Pull the emergency stop cord.

3. Use a handheld splicing tool (located in a cage on the back side of the main control box) to join the trailing edge of the old roll with the leading edge of the new roll. A specially designed splicing bar is mounted to the input end of the machine to aid the operator in holding film plies together and flat during the splicing process. This bar has (2) long angles mounted on it for guiding the sealing tool and for holding the film ends flat and in alignment.
4. Lift the two angles up and rest them against one another. Insert the old film's trailing edge (approx. 3 to 4 inches of it) under the angles. Clamp the corners using the round magnets at each end.
5. Pull enough plastic from the new roll and insert it under the angles on top of the old film.
6. Align the two edges and reuse the magnets to hold both corners together.
7. Lower the guide angles down and use the splicing tool to join the films. Press the tool wheel lightly against the ridge and slowly follow it to the other side. Repeat the same on the other side of the ridge on the way back.
8. Reset emergency switch by pulling the blue button.



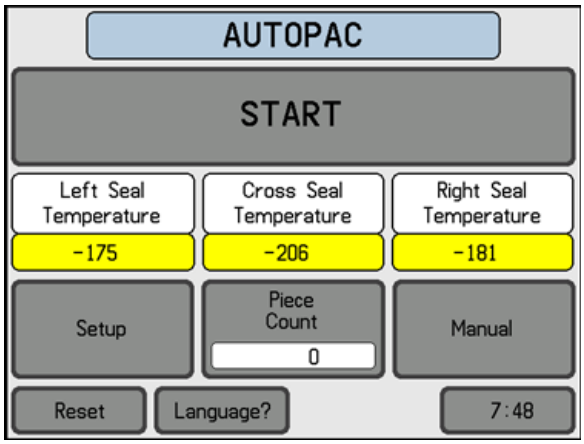


Machine Controls

Note: It is recommended that the emergency stop and power on buttons be used for normal, everyday machine power up and power down needs. The main On/Off/Lockout switch should be used to turn the machine on or off during maintenance or other extended power down situations.

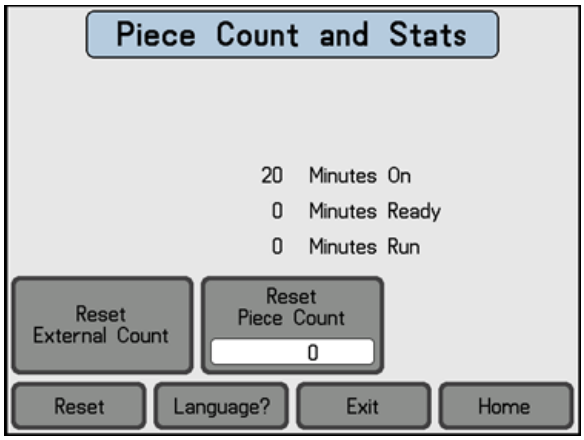
Main Screen

This is the main screen. From this screen you can start the machine, see the temperature of all three seal bars, and view the piece count. You can also access the setup, manual and piece count screens.



Piece Count

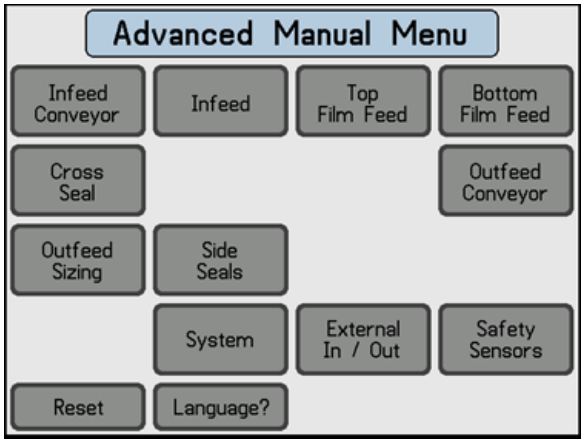
From this screen you can reset the piece count and/or the optional External count display.



Manual

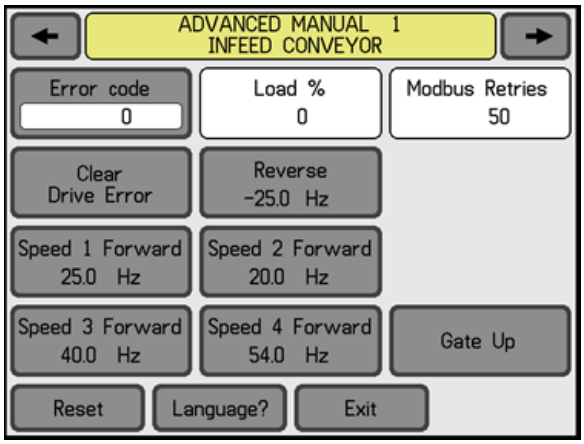
Pressing the Manual button on the Main screen will display the Manual screens, which provides controls for top and bottom film (loading, unloading, tracking, pleat correction) as well as the infeed conveyor and cross sealing.

Pressing the individual buttons will allow quick control to specific features or by pressing the right and left arrows at the top of the main screen will toggle through all screens from Manual 1 through Manual 14.



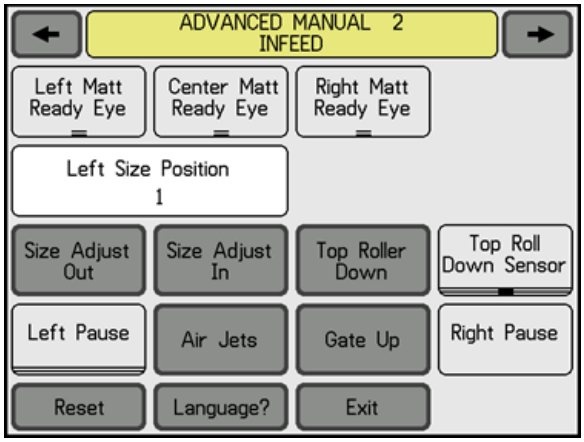
Manual 1

Provides controls for the Infeed Conveyor.



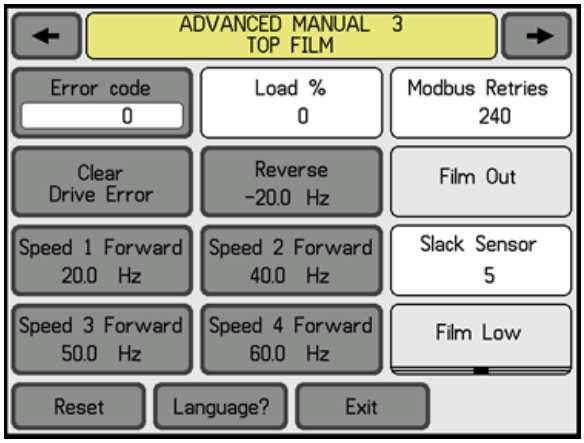
Manual 2

Provides controls for Infeed



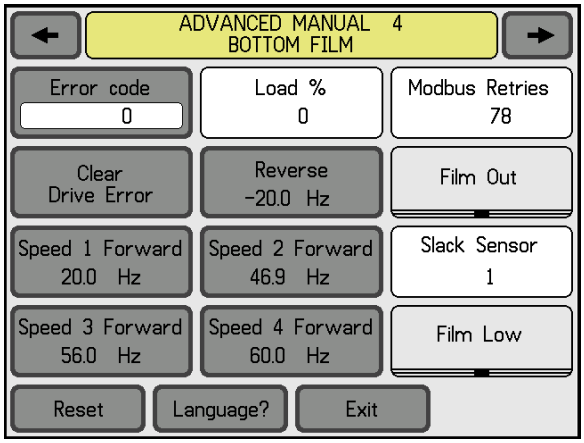
Manual 3

Provides controls for the Top Film



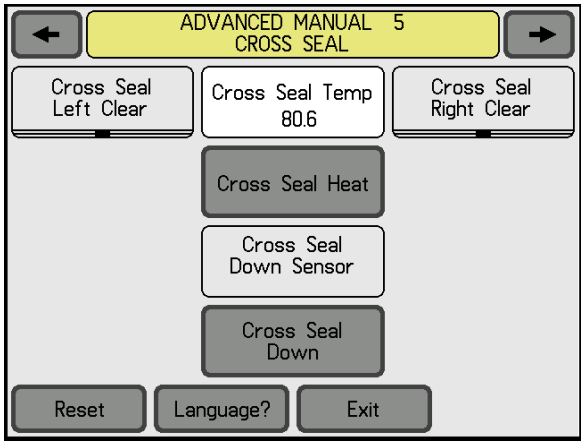
Manual 4

Provides controls for the Bottom Film



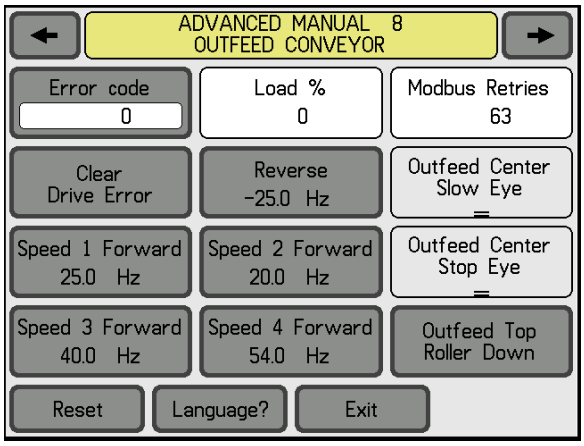
Manual 5

Provides controls for the Cross Seal



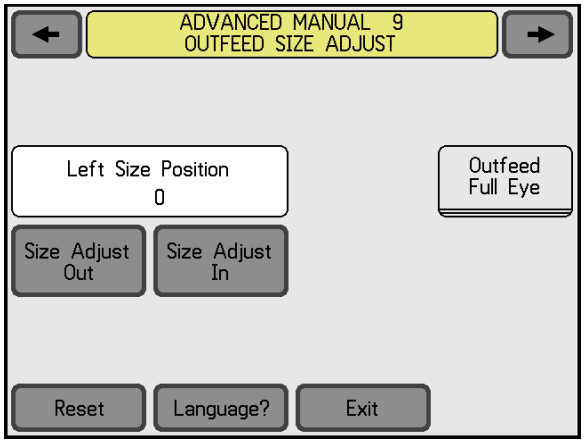
Manual 8

Provides controls for the Outfeed Conveyor



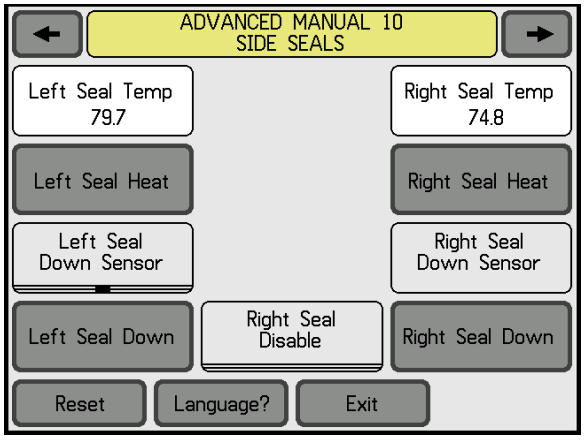
Manual 9

Provides controls for the Outfeed Size Adjustments



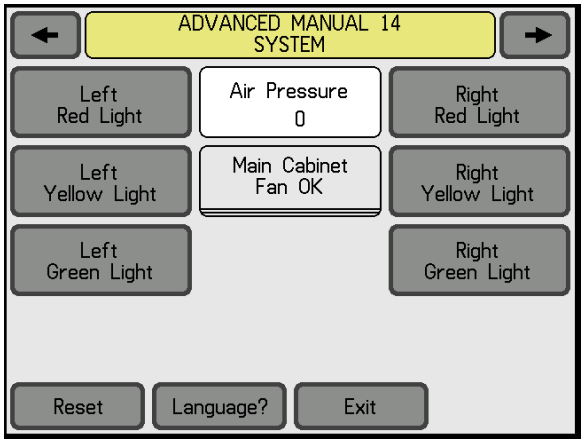
Manual 10

Provides controls for the Side Seals



Manual 14

Provides controls for the System.

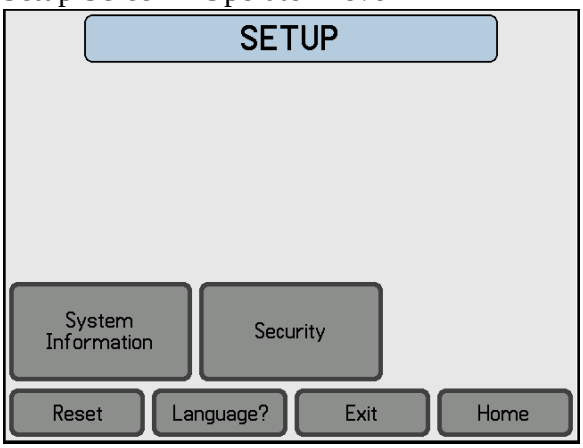


Setup

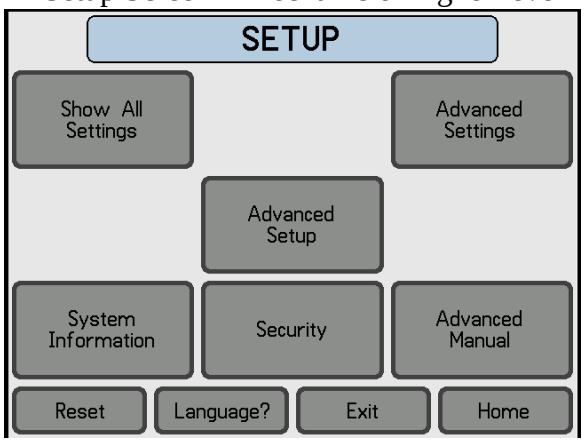
Pressing the Setup button on the Main screen will bring you to the Setup screen. From here you can access advanced settings, advanced setup, and advanced manual controls.

Note: When in the Advanced Manual screen, the heat to the seal bars is turned off. Use extreme caution when in Advanced Manual mode.

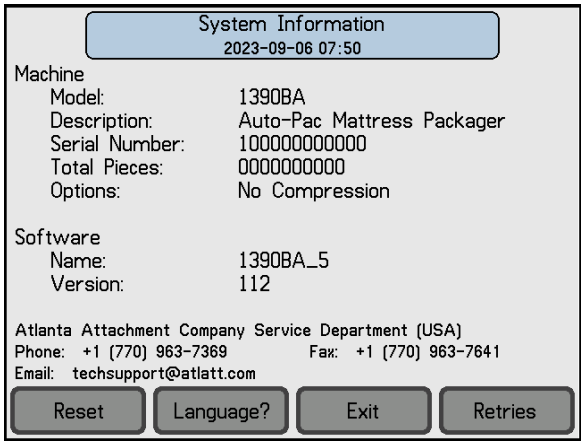
Setup Screen – Operator Level



Setup Screen – Mechanic or higher level

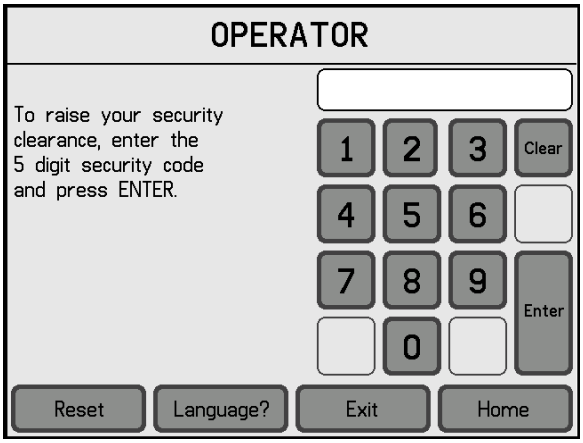


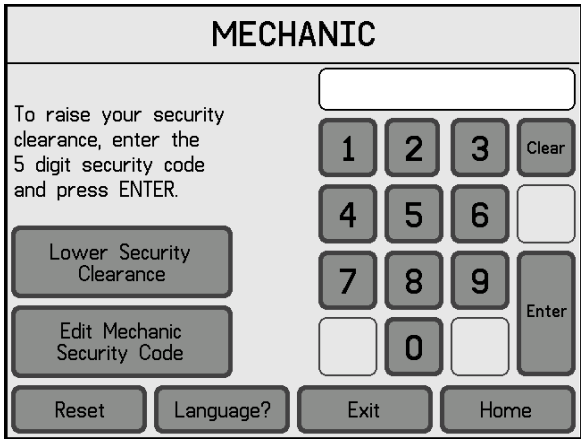
System Information



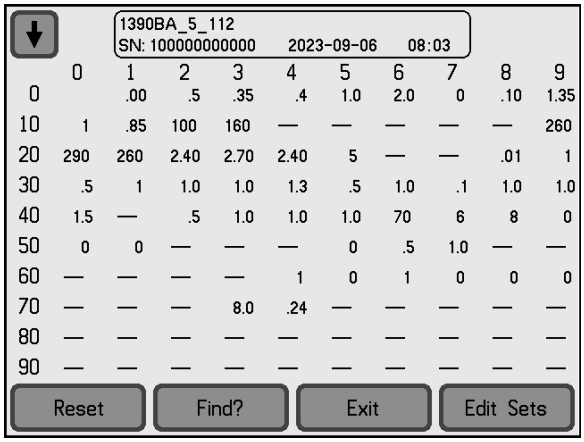
Security

Raise or Lower Security from Operator level to Engineering level as required with input of code.



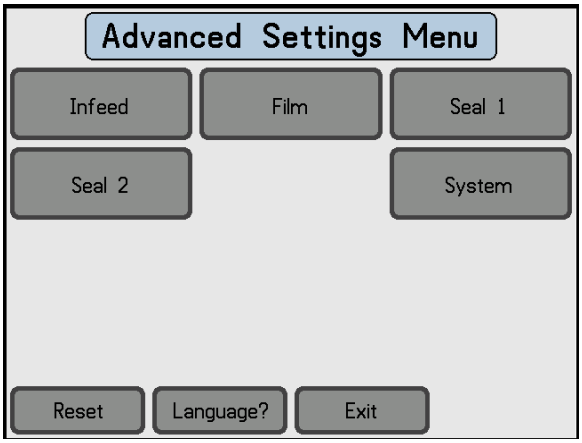


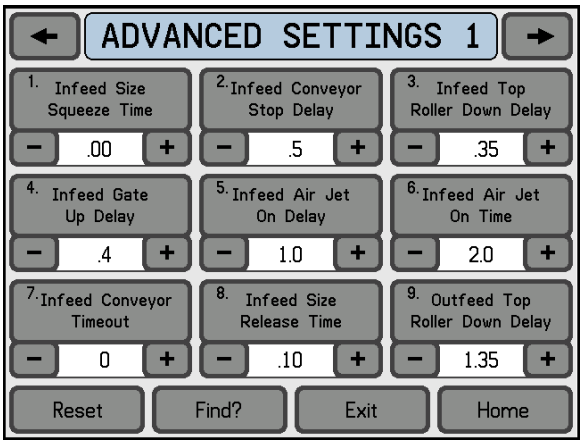
Show All Settings

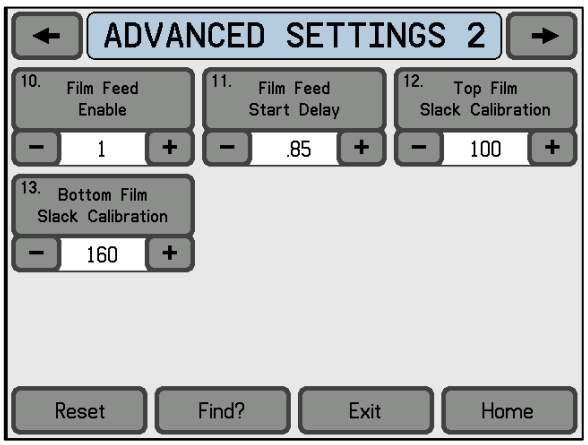


Advance Settings

Access to Infeed, Film, Sealing and System.
Screens 1 through 6

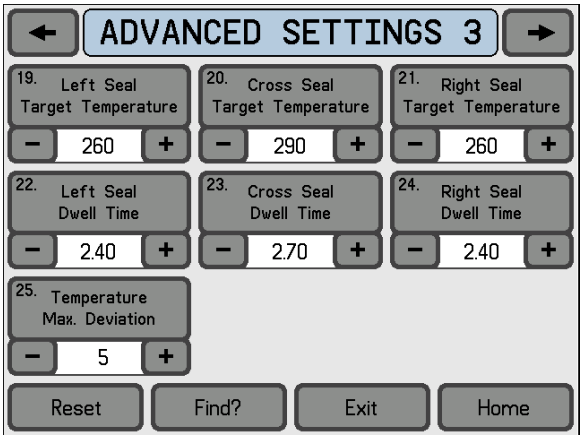




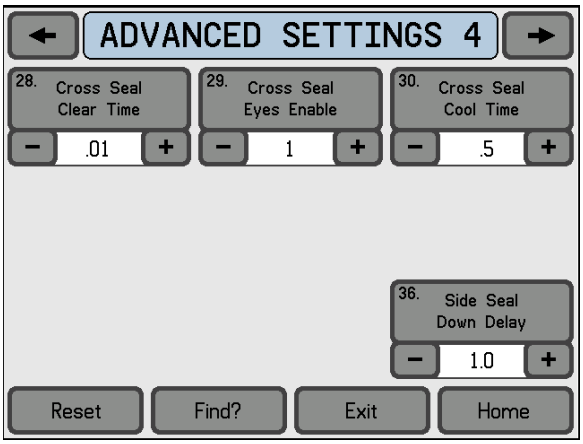


Advanced Settings Continued

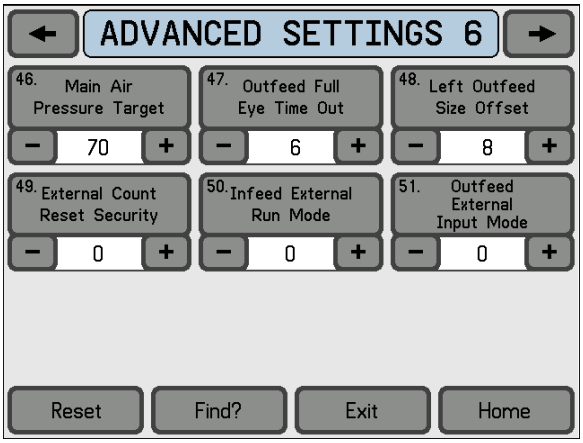
Seal 1



Seal 2

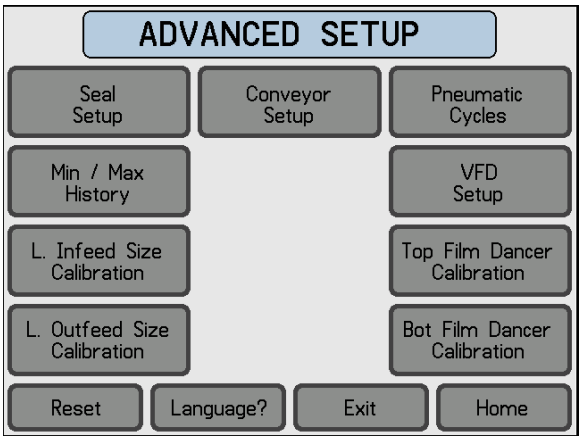


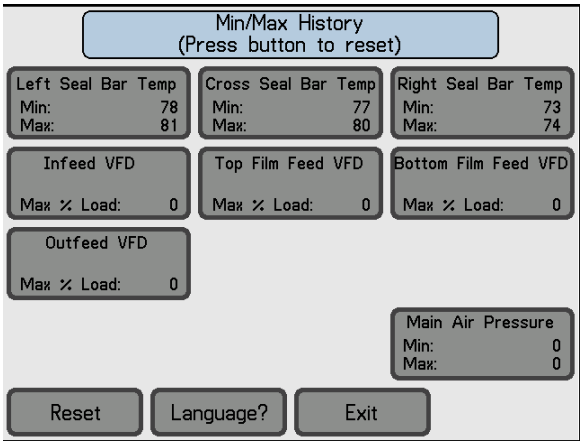
System

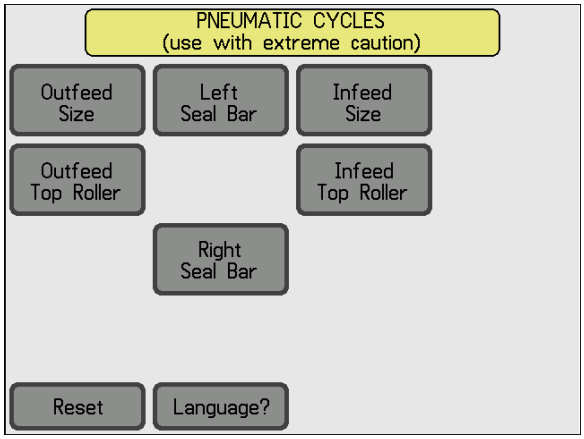


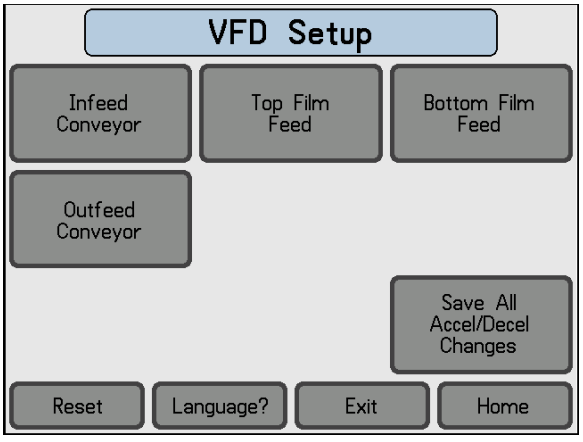
Advanced Setup

Access to Seal, Conveyor Setup, History, Cycles, Calibration, VFD Drives



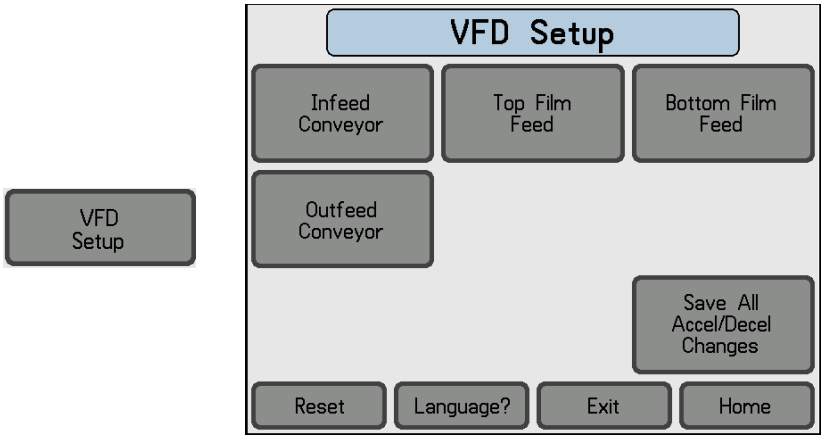


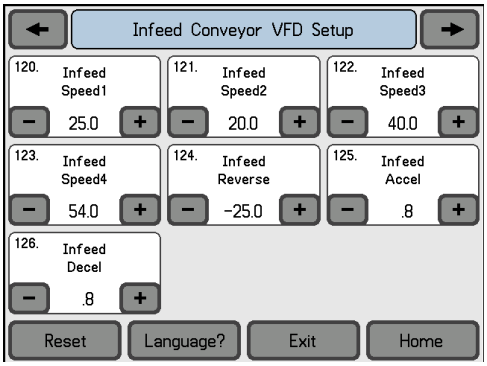


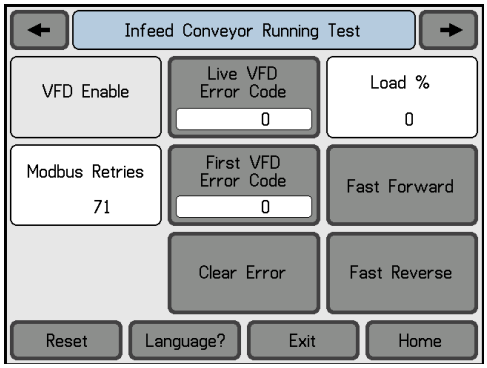


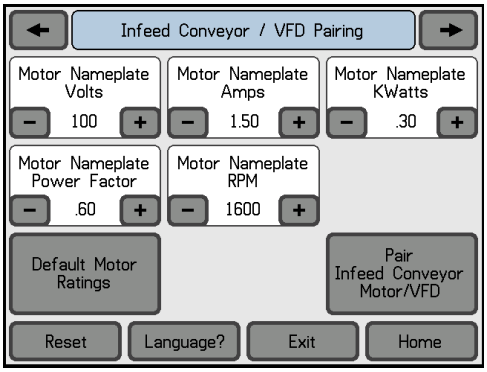
VFD Drives

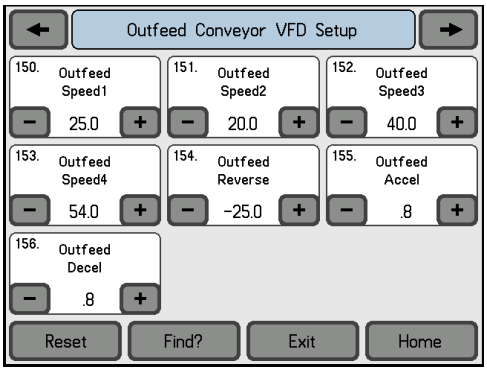
Provides access to drives that controls Infeed and Outfeed Conveyor, as well as Top and Bottom Film Feed

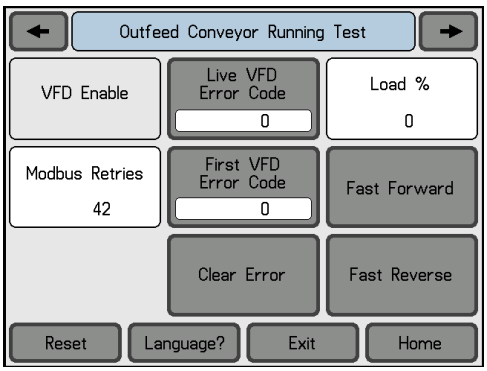


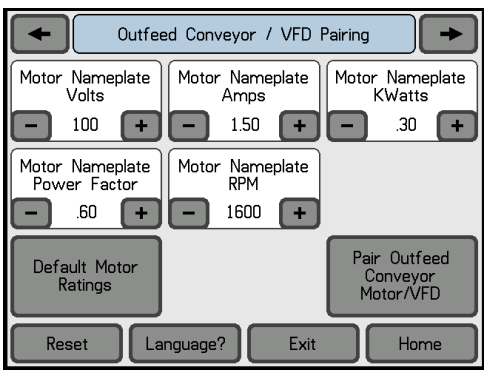




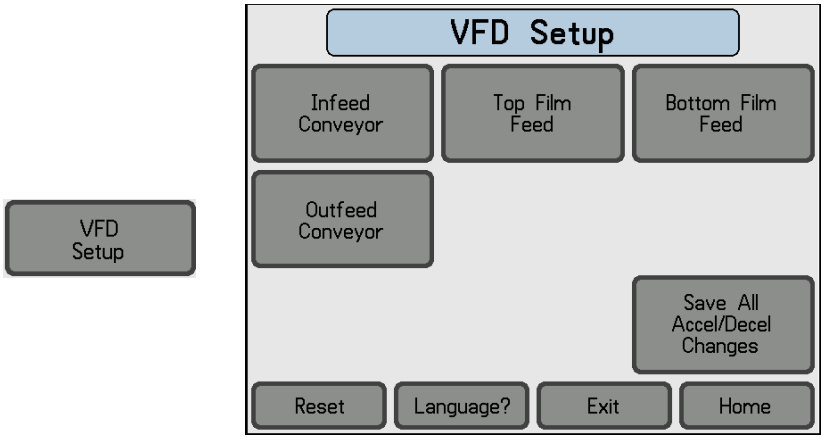


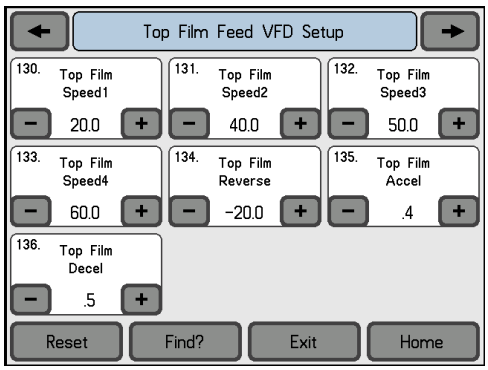


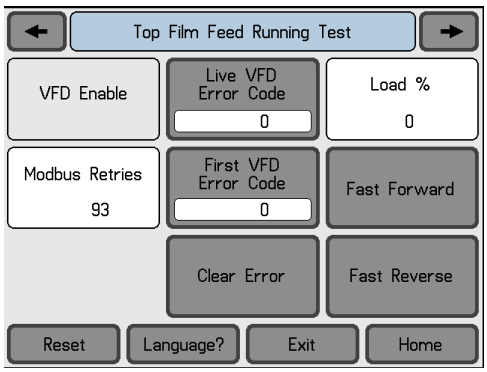


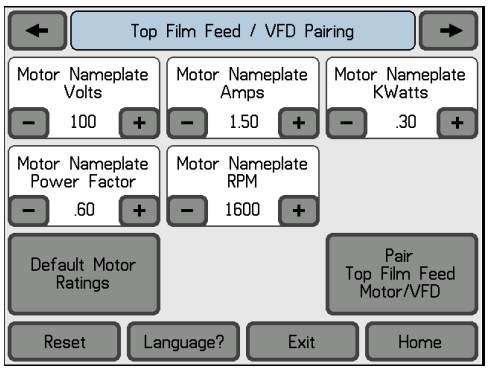


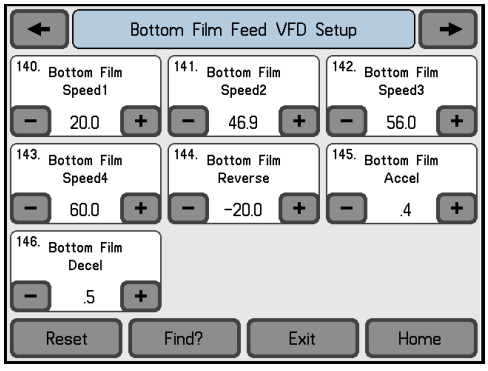
VFD Drives continued

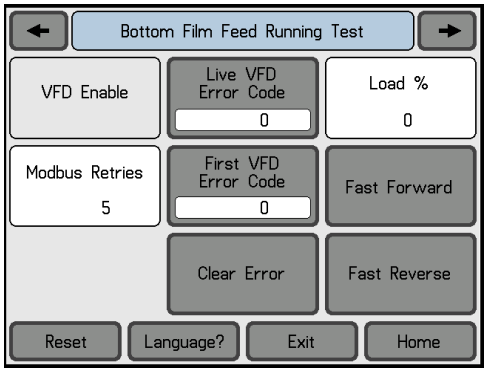


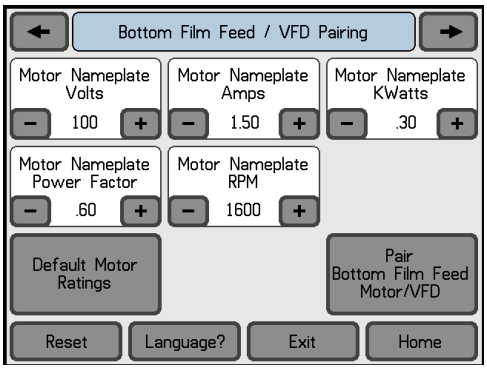






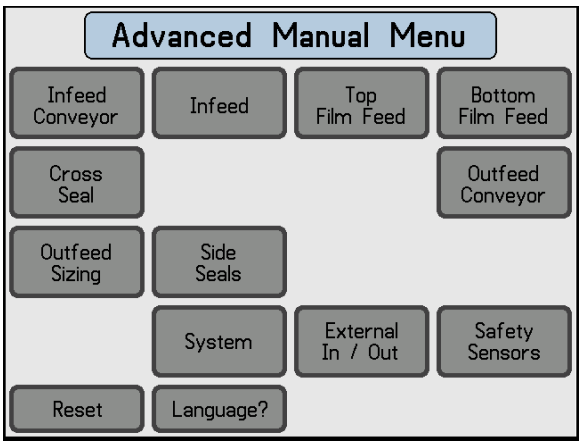


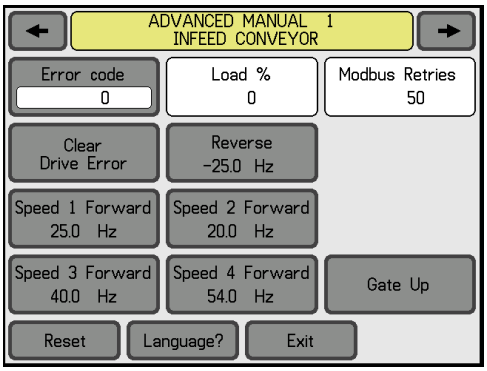


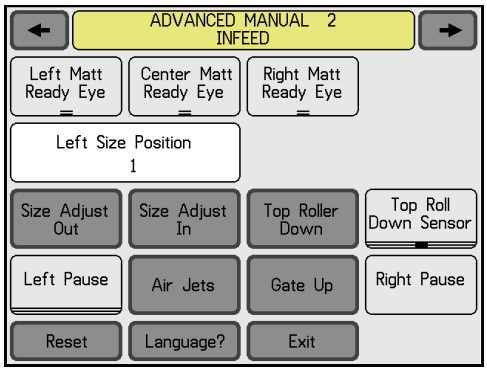


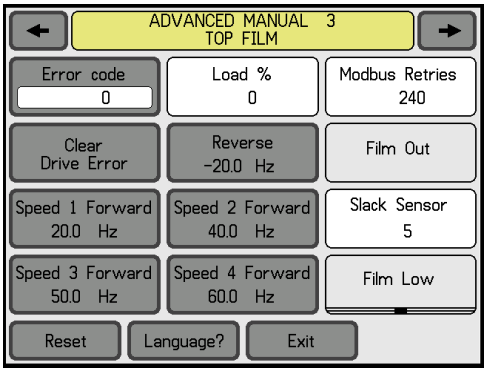
Advanced Manual Menu

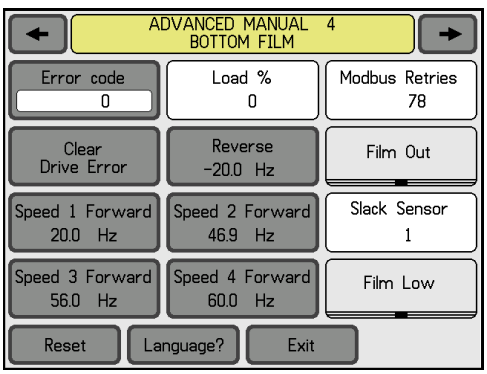
Provides access to current status of Conveyors, Drives, Sealing, System, I/O and Safety Sensors.

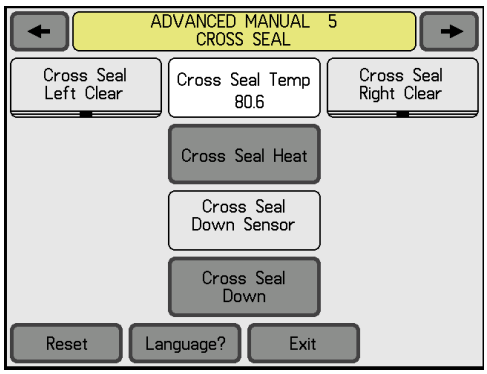


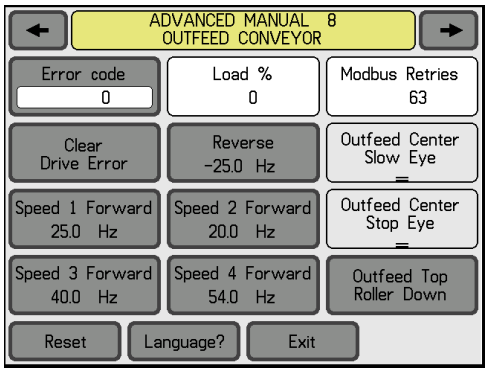




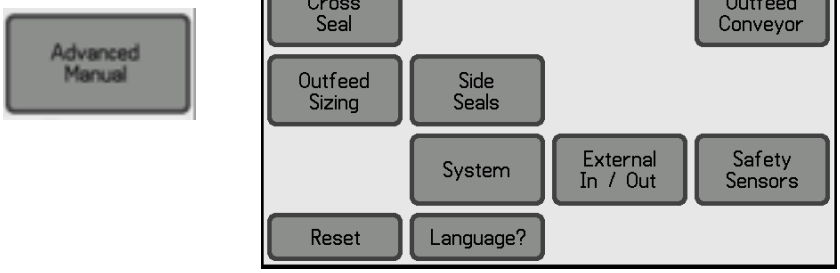


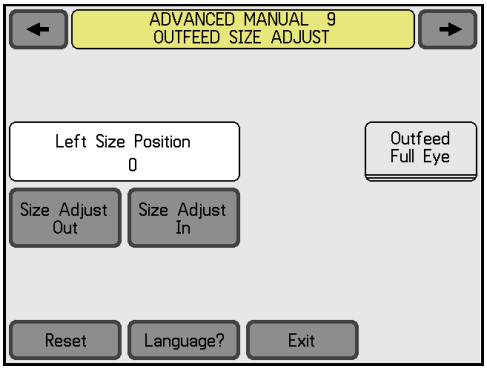


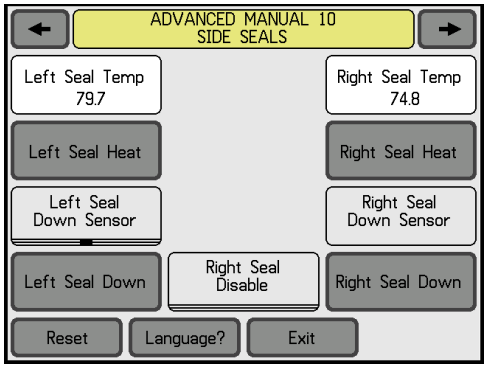


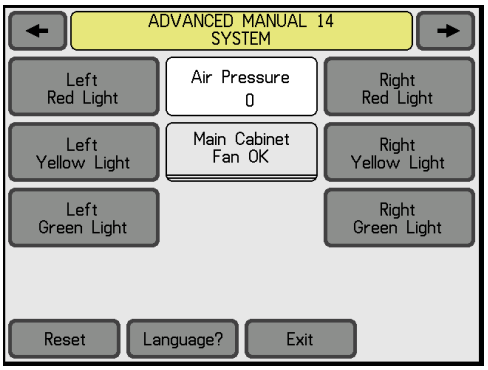


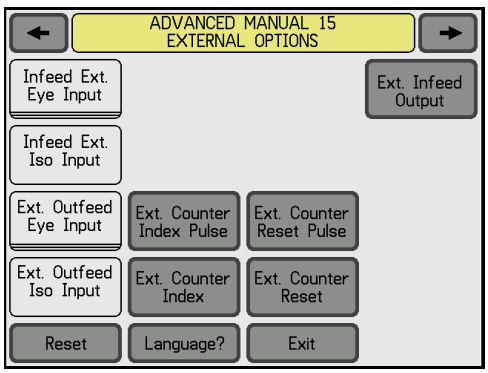
Advanced Manual continued

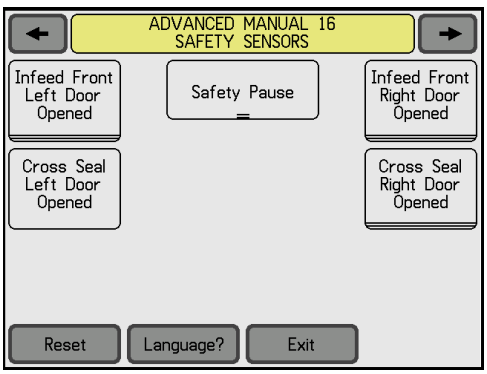






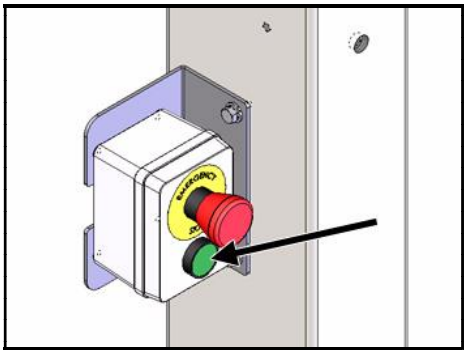




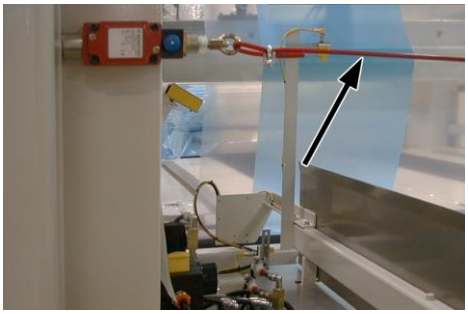


Other Operator Controls

1. Emergency Stop & Power On -
allows the machine to be turned on and stopped.



2. Stop Pull Cable - stretched above the INPUT conveyor in the loading area, allows the operator to quickly stop the machine in case of any problems.



3. Output Emergency Stops - located on the output end of the machine. One e-stop is mounted on each end post for the operator convenience.

4. Side Doors - located on each side of the machine, allow the mechanic easy access to the SEALING AREA to correct any problems.
Note: Side Doors can be used to stop the machine if necessary.

Light Tower Indicator

The LIGHT TOWER is designed to help the operator/mechanic in machine operation and troubleshooting.

- **YELLOW LIGHT ON** means that the machine is out of the Top or the Bottom film. (Heaters On)
- **RED LIGHT ON** means that one or both side doors are open, or the Pull (red) Cable switch is activated. (Heaters On)
- **RED LIGHT FLASHING** means the seal bars are too hot.
- **GREEN LIGHT ON** means that the machine is ready to run. It comes on as soon as the POWER ON button is pressed, and there are no faults to prevent the machine from running.
- **GREEN LIGHT FLASHING** means the seal bars are heating up and have not yet reached operating temperature.

Note: To start the machine, the MACHINE START button on the touch screen may need to be pressed.

- **ALL LIGHTS OFF** means that one or more of the E-STOP buttons are pressed, or the Main Power is turned OFF, or otherwise disabled.

Note: If the above indications do not solve the problem, please refer to “Troubleshooting” section of this manual for additional help or call Atlanta Attachment Company’s service department at 770-963-7369.

3. SERVICE

Motor Drives and Settings

The 1390BA machine has four motor drives. The following images below show the physical drive locations. The table in the bottom right corner shows the drive machine parameters and their settings. These parameters may vary slightly based on the final installation requirements. To edit these drive parameters, refer to “Editing Motor Drive Parameters” on page 27. If the parameters have to be modified, record the new settings, and keep them with this manual for future reference.

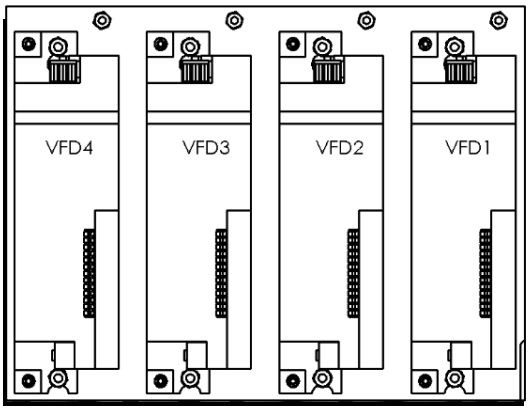
Note: Do not change any of the other drive parameters, leave them as defaults.

Input Conveyor Drive

Output Conveyor Drive

Top Film Drive

Bottom Film Drive



Drive Controllers

Motor Drive Parameters

These are defaults according to the latest software version

When commissioning a machine, replacing a drive, or replacing a motor (with a different model), the user initiates the 'pairing' processes (via the Setup -> Advanced Setup -> VFD Setup menu). The user will be warned that this needs to be done when commissioning a machine or replacing a drive – but not when replacing a motor… As part of this processes, the user temporarily sets some settings to match the nameplate of the motor (volts, amps, rpm, etc). This data is used in the pairing process, but it is saved in the drive and is not a numbered/saved software setting

Setting name	Setting number	Default value
Infeed Speed 1	120	25.0 (Hz)
Infeed Speed 2	121	20.0 (Hz)
Infeed Speed 3	122	40.0 (Hz)
Infeed Speed 4	123	54.0 (Hz)
Infeed Reverse	124	(-) 25.0 (Hz)
Infeed Acceleration	125	0.8 (seconds)
Infeed Deceleration	126	0.8 (seconds)

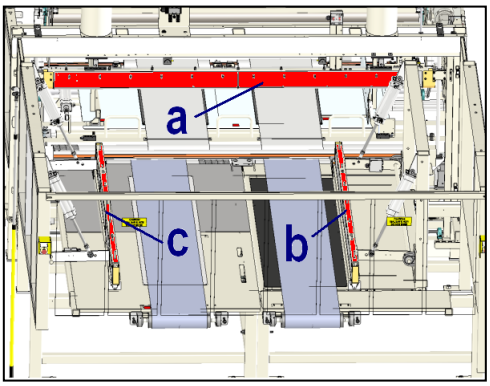
Setting name	Setting number	Default value
Top Film Speed 1	130	20.0 (Hz)
Top Film Speed 2	131	40.0 (Hz)
Top Film Speed 3	132	50.0 (Hz)
Top Film Speed 4	133	60.0 (Hz)
Top Film Reverse	134	(-) 20.0 (Hz)
Top Film Acceleration	135	0.4 (seconds)
Top Film Deceleration	136	0.5 (seconds)

Setting name	Setting number	Default value
Bottom Film Speed 1	140	20.0 (Hz)
Bottom Film Speed 2	141	46.9 (Hz)
Bottom Film Speed 3	142	56.0 (Hz)
Bottom Film Speed 4	143	60.0 (Hz)
Bottom Film Reverse	144	(-) 20.0 (Hz)
Bottom Film Acceleration	145	0.4 (seconds)
Bottom Film Deceleration	146	0.5 (seconds)

Setting name	Setting number	Default value
Outfeed Speed 1	150	25.0 (Hz)
Outfeed Speed 2	151	20.0 (Hz)
Outfeed Speed 3	152	40.0 (Hz)
Outfeed Speed 4	153	54.0 (Hz)
Outfeed Reverse	154	(-) 25.0 (Hz)
Outfeed Acceleration	155	0.8 (seconds)
Outfeed Deceleration	156	0.8 (seconds)

Seal Bar Maintenance and Replacement

WARNING: *Wait until the heat-sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.*



The unit has three (3) heat sealing bars. (a-cross seal), (b-right seal), and (c-left seal). The optimum temperature and the dwell settings depend on the type of plastic film being used, the thickness of the film, and the bag construction. For instance, if the requirement is for boot plastic only at one end of the bed, this means there are four plies of plastic on one side, but only two plies on the other side. Furthermore, the Cross Seal has to seal four plies on one end, and only two on the other. Due to the variations such as that, the dwell times and/or the temperature are fine-tuned during the machine installation. After Installation if the packaging variables ever change, the dwell time in most cases is the only correction needed for a proper weld.

Temperature Settings
Standard temperature settings of the heat-sealing bars are as follows:

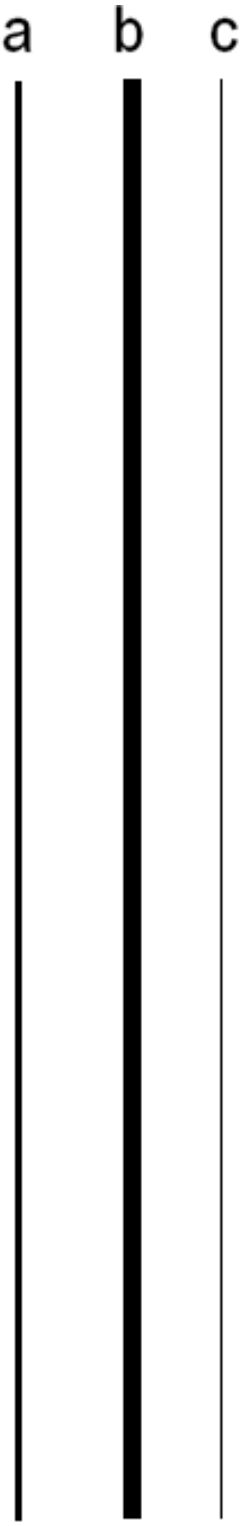
Sealing Bar	Temperature º F / º C	Closing Time
Cross Seal No Boot	325 º F / 162 º C	170 a 200
Cross Seal W/Boot	345 º F / 173 º C	170 a 200
Right edge No Boot	325 º F / 162 º C	170 a 200
Right edge W/Boot	345 º F / 173 º C	170 a 200
Left edge No Boot	325 º F / 162 º C	170 a 200
Left edge W/Boot	345 º F / 173 º C	170 a 200

The left seal thermocouple is monitored by the # 59 module, the right seal is module # 5 and the cross seal is module # 52.

Seal power left, right, cross seal are controlled by module # 34.

There are four major variables for obtaining a good weld.

1. Temperature: The value is set via the control panel. The degrees are expressed in Fahrenheit. Try not to alter the temperature settings as much as possible. A variation of 5 degrees in Fahrenheit temperature will change the clarity of welded materials. Always adjust the dwell time first.
2. Time: The value is set via the control panel. Sealing time is expressed in 0.01 seconds, or 100 equals one second.
3. Pressure: A value that is set by the stroke of the air cylinders from the factory. Unless you are changing the seal rail system height, leave settings as they are.
4. Condition of seal bars: upper seal bars black coating is smooth with no cut or scraps and a dull finish. Lower seal bed smooth with not cuts and a shiny finish on tape.



Note: ***The Machine is configured to operate with two sheets of 3 mill plastic from the factory. If the thickness changes, you should only have to adjust the dwell. More Heat and pressure can create expensive problems later.***

Explanation of chart written out below: ⟶

(a) Temperature and Time Correct. The plastic appears melted with small bubbles and a connecting line between the bubbles. The solder is constant throughout.
.
(b) Excessive time or temperature. The melted plastic bubble appears irregularly, several of which are joined together and, in some cases, bundling between these portions.
The weld is not constant throughout.

(c) Lack of time or temperature. The plastic melted with small bubbles appear regularly without union between these parts.
The weld looks constant without proper seal.

Cleaning seal bars: for best performance, seal bars should be kept clean, clean whenever necessary with a soft cloth dampened with WD-40. Be very careful not to scratch or disturb the coating on the upper heat seal bar as this will cause sticking and film buildup and poor seal quality.
Very Important Note: *If you are having issues with a complete seal, (for example the rear), check for air movement around the machine. A large fan overhead near the 1390 can cool the seal bar enough to make you think you need to add heat or pressure to correct the problem. This is not always the best solution.*

Always be aware of your surroundings before changing any settings.

Side Sealing Bars

WARNING: Wait until the heat-sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.

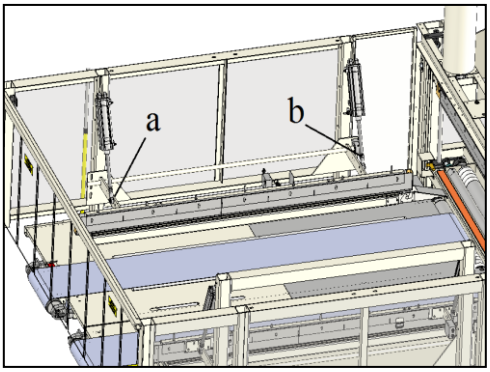
Refer to table on page **Error! Bookmark not defined.** for details

(A). - Welding is even and the depth of a weld's right.

The melted plastic appears with small bubbles and a connecting line between these bubbles. The weld is constant throughout.

(B). - Sealing bars are too deep

To set the depth of the shaft, loosen the nuts (a), (b) and rotate the cylinder shaft clockwise from top view on both cylinders which support the seal bars. Rotate the shaft ¼ turn at a time and test the quality of the seal between each setting.



(C). - Heat sealing bars Lack depth.

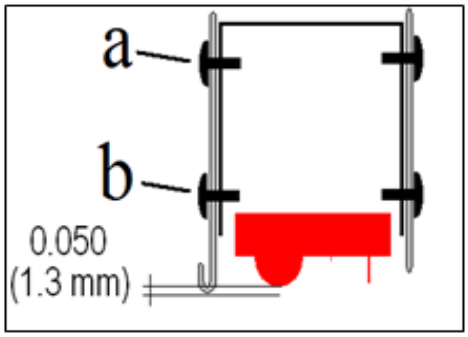
Adjust the height of the shaft, loosen the nuts (a), (b) and rotate cylinder shaft counterclockwise from top view on both cylinders which support the seal bars. Rotate the shaft ¼ turn at a time and test the quality of the seal between each setting.

(D). - Heat sealing bar is not parallel with the non-stick tape lengthwise.

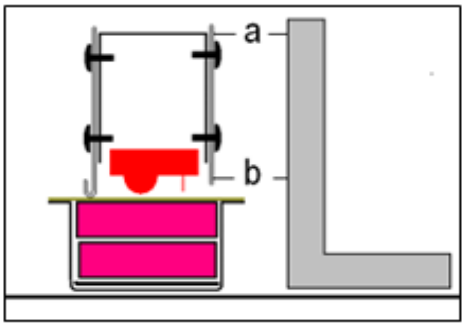
Adjust the parallelism between the heat seal bar and nonstick ribbon by loosening the nut (a) or (b) and rotate the corresponding cylinder rod. Rotate the shaft ¼ turn at a time and test the quality of the seal between each setting.

(E). - Irregularity along the sealing

1. Make sure the sheet metal clamping the plastic film is at the correct height. The bar should be protruding to 0.050 inch (1.3mm) below the seal bars. To do this, loosen the screws (a) and (b) holding the pressure plate and lower it until the measurement is correct. Atlanta Attachment has a tool to facilitate this adjustment Part # 1390965 included in the kit of replacement parts.



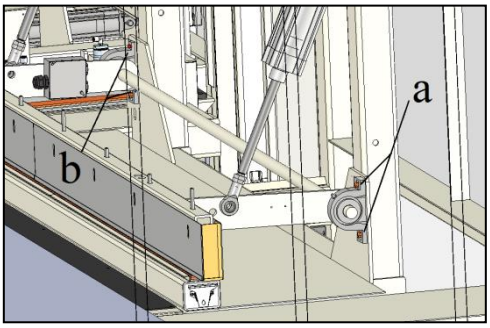
2. Verify that the sealing bar is parallel with reference to the non-stick tape. Rest the cooled seal bar on the non-stick tape and place a square on the tabletop next to seal bar and check the distance between the top of the heat baffle (a) and the bottom (b). You should have equal reference to the square. Make sure that the sheet metal is on the rubber and not the metal lip of the bottom tray. You should have equal reference to the square. If not, go to alignment on page 31.



Note: *Upper bar should always come into contact with tape and silicone cushion. At no time should any part of the upper seal bar contact the metal of the lower bar assembly.*

Alignment (continued)

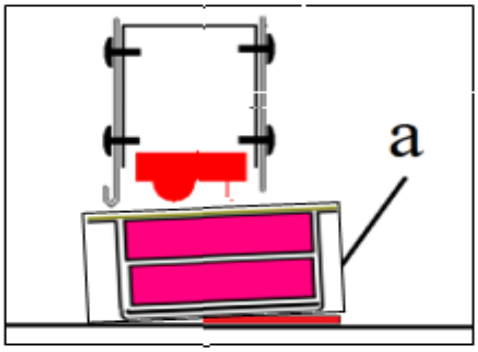
Loosen the four screws (a) and (b) securing the two bearings and slide up or down to meet the proper angle. Check after each adjustment. It is very likely need to adjust the height of the bar.



(F). - Random irregularities in the seals.

1. Check the non-stick tape on all three seal bars, tape should be smooth, clean, no air pockets and or crevices. Tape must be cleaned periodically and replaced as needed.
2. Inspect the silicone rubber backing under tape for cuts. If cut or damaged, replace silicone rubber cushion in that area as they are all glued together. After replacement follow the procedure for system realignment on page 34.
3. Check the upper sealing bars for damage, they should look black with a dull finish all along the bar. If any shinny areas are seen along the bar, it is damaged and needs replacement.

(G). - Irregularities constant seal.



1. Check the non-stick tape on all three seal bars, tape should be smooth, clean, no air pockets or crevices. Tape must be cleaned periodically and replaced as needed.
2. Inspect the silicone rubber backing under tape for cuts. If cut or damaged, replace silicone rubber cushion in that area as they are all glued together. After replacement follow the procedure for system realignment on page 34.
3. Check and see if shims under the support tray of non-stick tape are in place. Otherwise move them or insert new shims in that area.
4. Check the upper sealing bars for damage, they should look black with a dull finish all along the bar. If any shinny areas are seen along the bar, it is damaged and needs replacement.

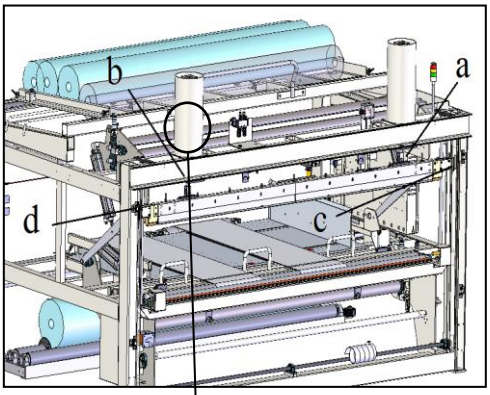
Note: *Upper bar should always come into contact with tape and silicone cushion. At no time should any part of the upper seal bar contact the metal of the lower bar assembly.*

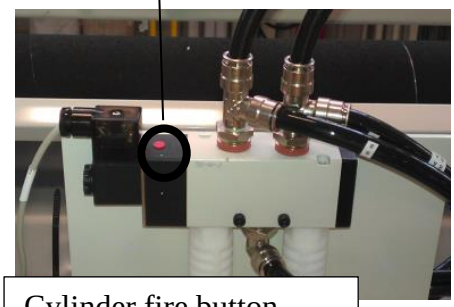
Symptoms and adjustments of the cross-seal Bar

(a) through (g) in the previous graph are types of heat-sealing problems that also apply to the cross-seal bar with the following additions:

(D). Bar-Gradient

Position cross seal bar to the height as pictured until you see the four bolts (C) & (D) in the chain guard opening. Loosen these bolts with a 7/16 wrench as well as the 30mm nut above the clevis on the cylinder where pressure needs to be added. Rotate the cylinder shaft counterclockwise from top view ¼ turn only, then tap the cylinder cycle button (1/10 sec) to jog cylinders. Tighten the four chain bolts with a 7/16 wrench and test seal. Repeat if needed, otherwise tighten nut above clevis to complete adjustment.





Cylinder fire button

(E). - Stamped Irregularities in crossbar seal

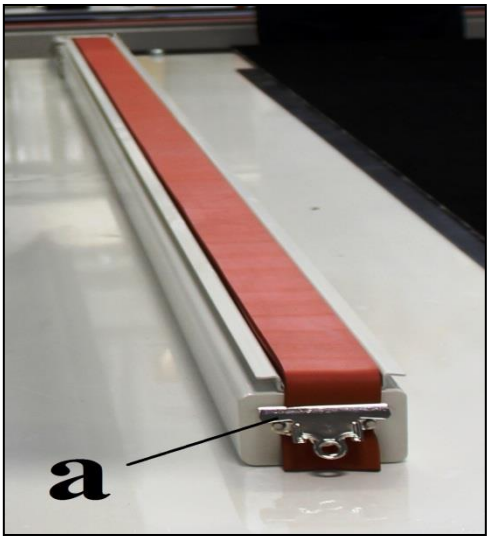
1 Check the non-stick tape on all three seal bars, tape should be smooth, clean, no air pockets and or crevices. Tape must be cleaned periodically and replaced as needed.
2. Inspect the silicone rubber backing under tape for cuts. If cut or damaged, replace silicone rubber cushion in that area as they are all glued together. After replacement follow the procedure for system realignment on page 34.
3. Check and see if shims under the support tray of non-stick tape are in place. Otherwise move them or insert new shims in that area.
4. Check the upper sealing bars for damage, they should look black with a dull finish all along the bar. If any shinny areas are seen along the bar, it is damaged and needs replacement.

Replacement of Nonstick Tape

1. Make sure heat seal bars are in the up position.

2. Open the clamping system (a) peal back non-stick tape

3. Inspect the silicone rubber backing under tape for cuts. If cut or damaged, replace silicone rubber cushion in that area as they are all glued together. After replacement follow the procedure for system realignment on page 34.
4. Pull out enough new tape from the roll located in front of raised rail to cover silicone padding.
5. Align the tape and adhere to the silicone rubber and metal flanges of support tray.
6. Cut the excess tape and mount into the front clamping system. (A)



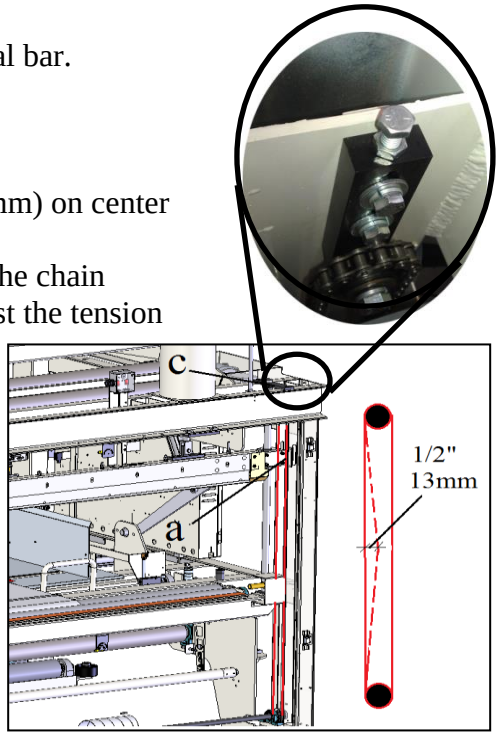
Replacement Tape here.

Cross Bar chain tension

Chains are responsible for parallel movement of the cross-seal bar.

To check tension and adjust if needed:

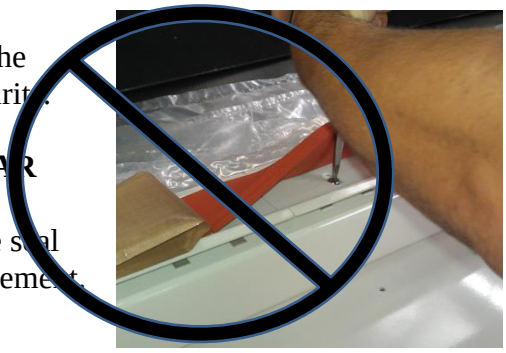
The chain (a) displacement is approximately 0.5 inches (12 mm) on center if light pressure is applied to the chain.
The adjusting tensioners (c) are located at the upper ends of the chain system. Use a 9/16 wrench to loosen the two mounting bolts and adjust the tension bolt. Retighten the mounting bolts.



Note: *Tension should be checked every three months.*

Replacing silicone rubber padding:

WARNING: *Wait until the heat-sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.*



With seal bar in the up position remove non-stick tape. Next remove the damaged silicone padding completely. Clean glue off with mineral spirits. **(DO NOT LOOSEN ANY OF THE SCREWS BENEATH THE SILICONE PADDING AS THIS WILL DISRUPT THE SEAL BAR LOWER RAIL ALIGNMENT!)**
Glue new padding to the rail. Secure PTFE tape and see shimming the seal bar on page **Error! Bookmark not defined.** after lower rubber replacement.

Side Seal and Cross Seal Bladder Adjustments

Reference parts 1406995 and 13901145

1406995 Cross Seal

Note: 10 – 15 psi is average setting

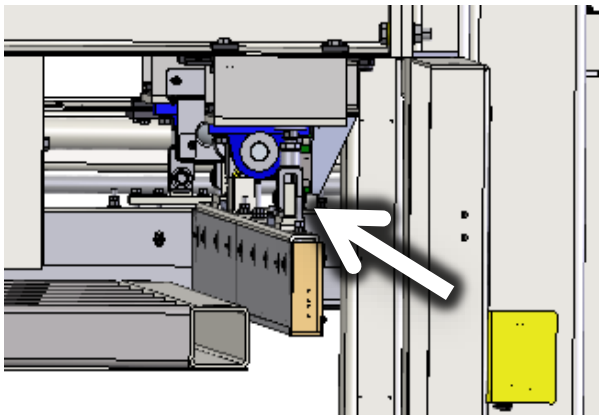
13901145 Side Seals

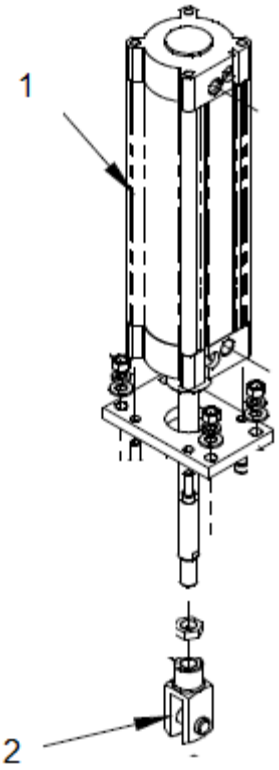
Note: 10 – 15 psi is average setting

Adjusting the Seal bar Pressure

Note: For cross seal bar see symptoms and adjustment of cross seal bar.

WARNING: *Wait until the heat-sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.*





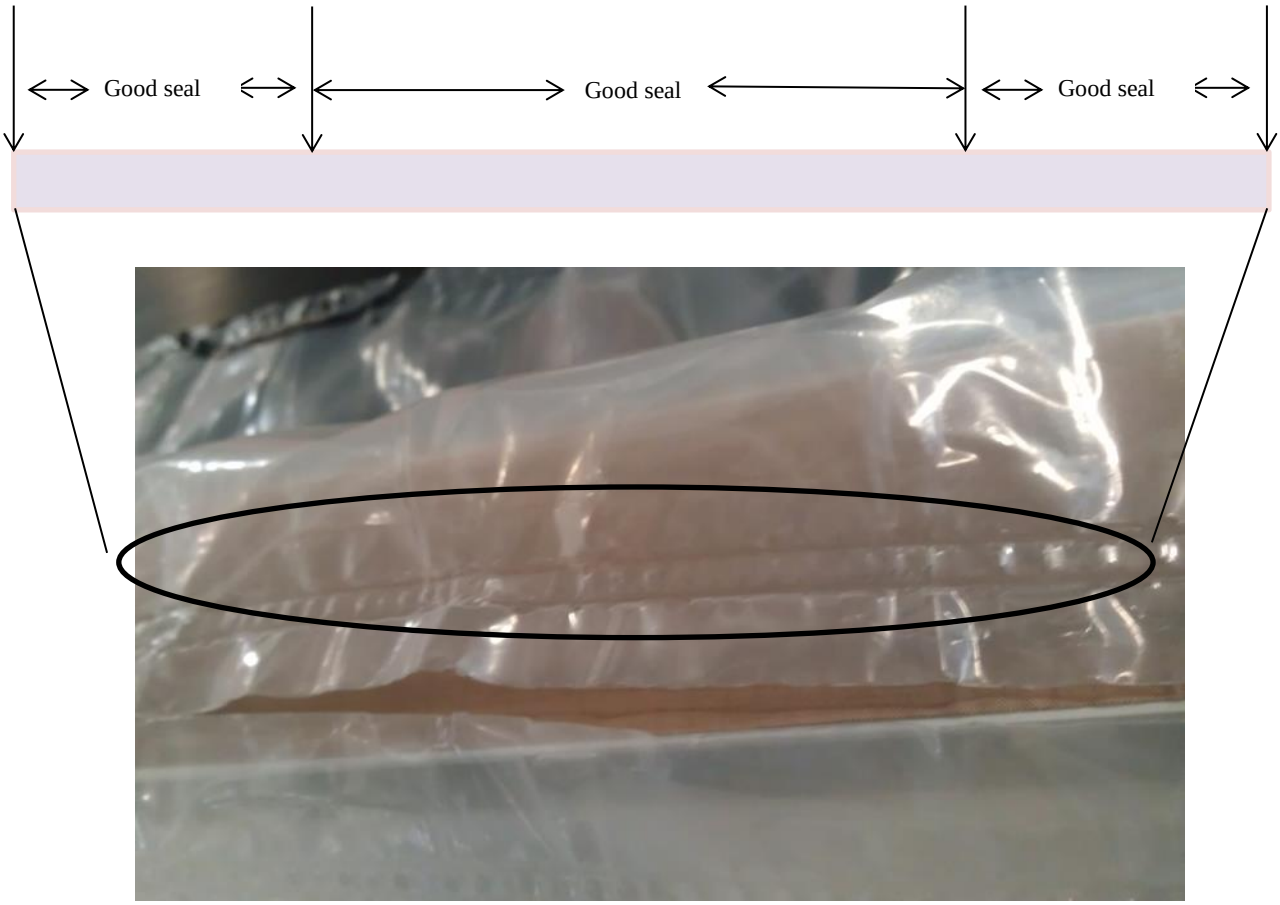
Loosen nut above clevis on each cylinder rod and rotate rod cylinder counterclockwise ¾ turn. Take a sample set of plastic layers used in production and perform a seal. What we are trying to determine is a sealing pressure point. The object is to get the heated seal bar sealing the plastic evenly with as little force as possible.

Note: We are only adjusting the cylinder rods, not shimming.

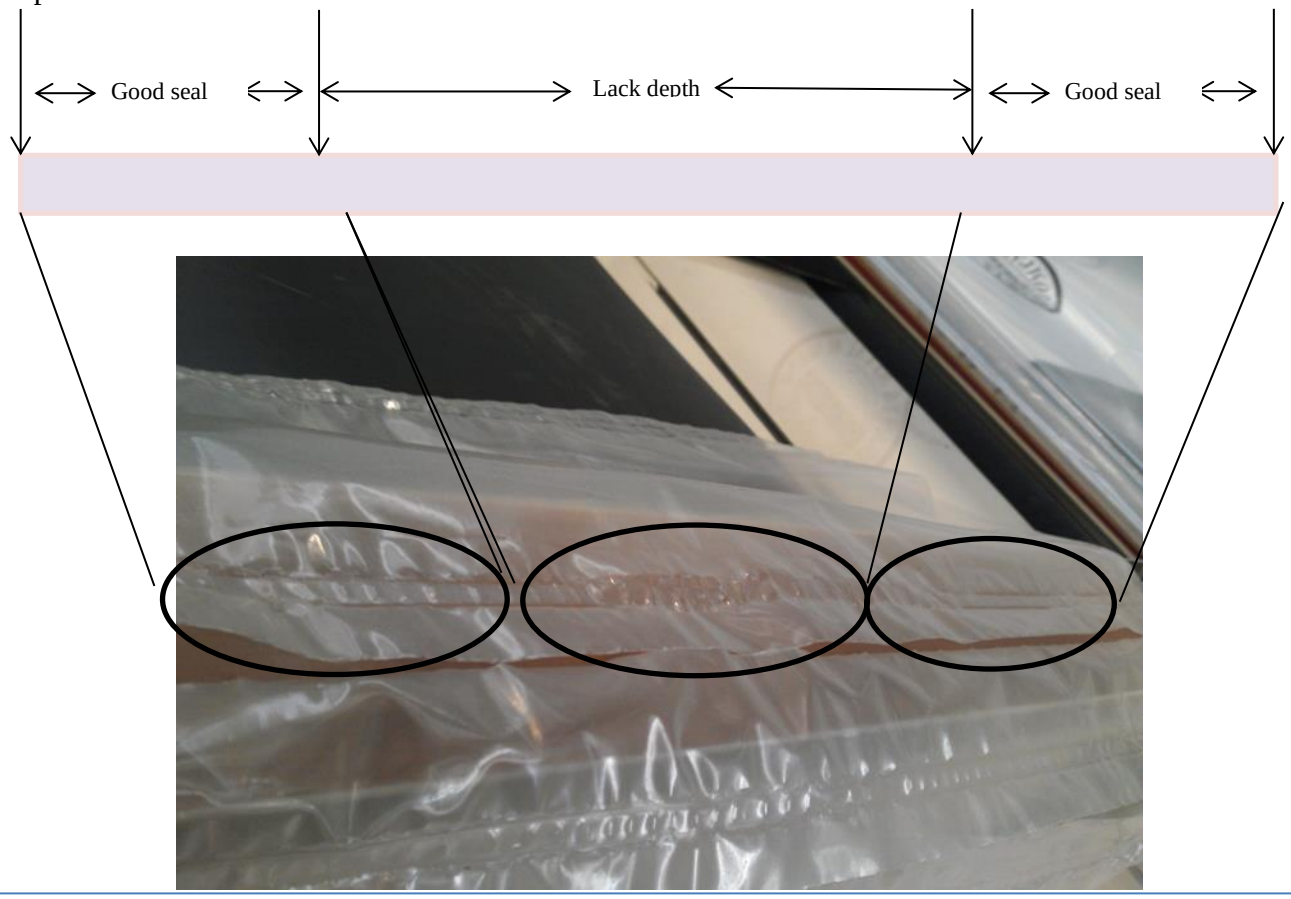
Once you have example A, try to decrease pressure by a ½ turn on both cylinders and see if you get example B.

If not, keep decreasing until you see example B If so, then increase pressure ½ turn and tighten the cylinder rod nuts and you are finished.

Example A



Example B

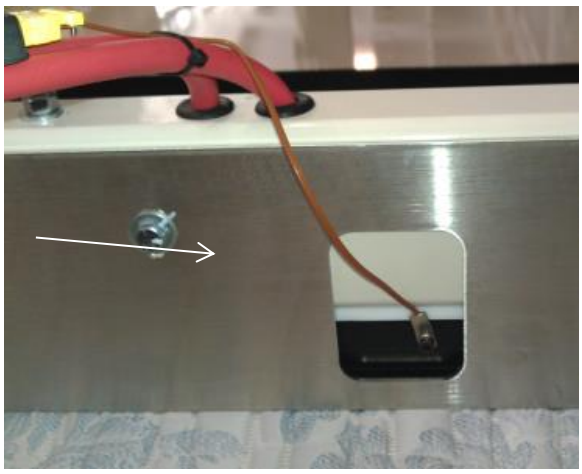


Upper Seal Bar Element Replacement

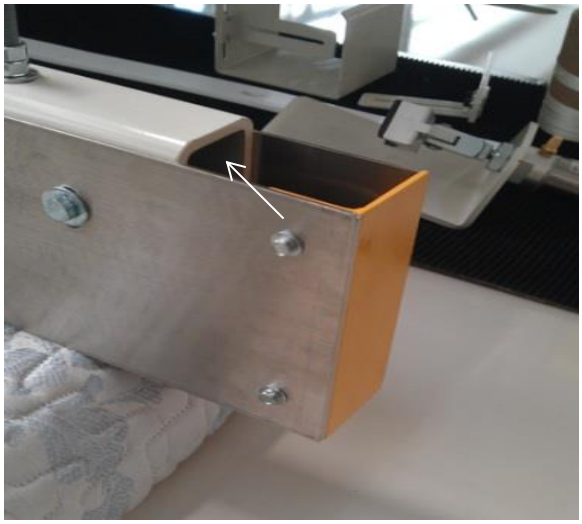
WARNING: Wait until the heat-sealing bar has cooled enough (approx. 3 hours) before servicing seal bars or the areas near the bars. If maintenance on the machine is absolutely necessary before sealing bars have had a chance to cool down, the person performing the maintenance must use safety equipment approved by OSHA or local law to protect against burns.

1) Turn Power supply off

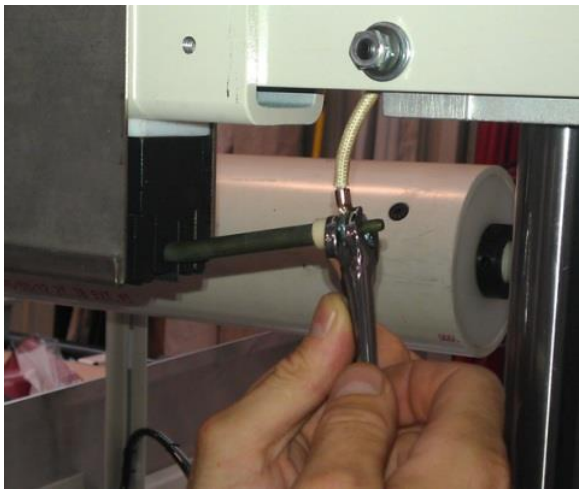
2) Remove thermocouple wire.



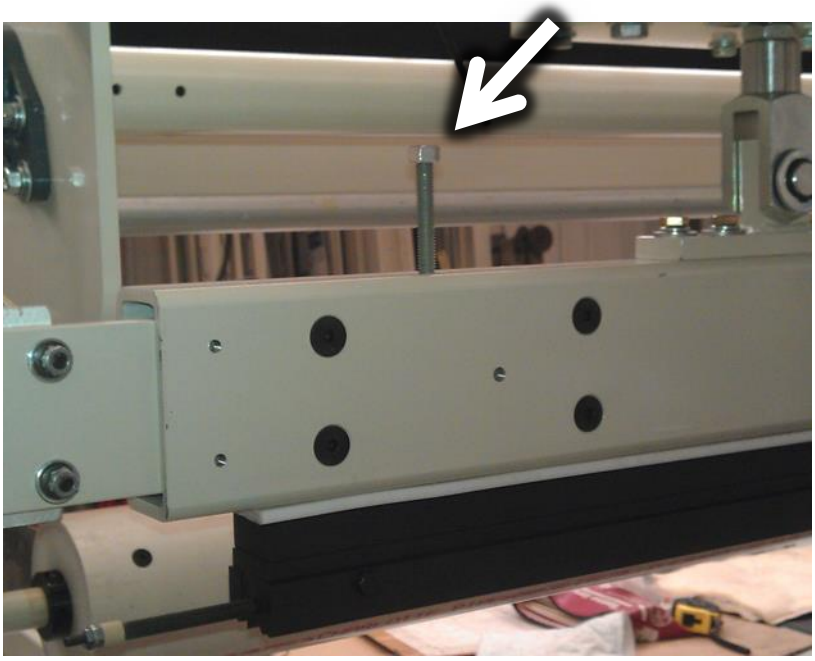
3) Remove protective end plates from seal bar



4) Disconnect wire from both ends of heating element.



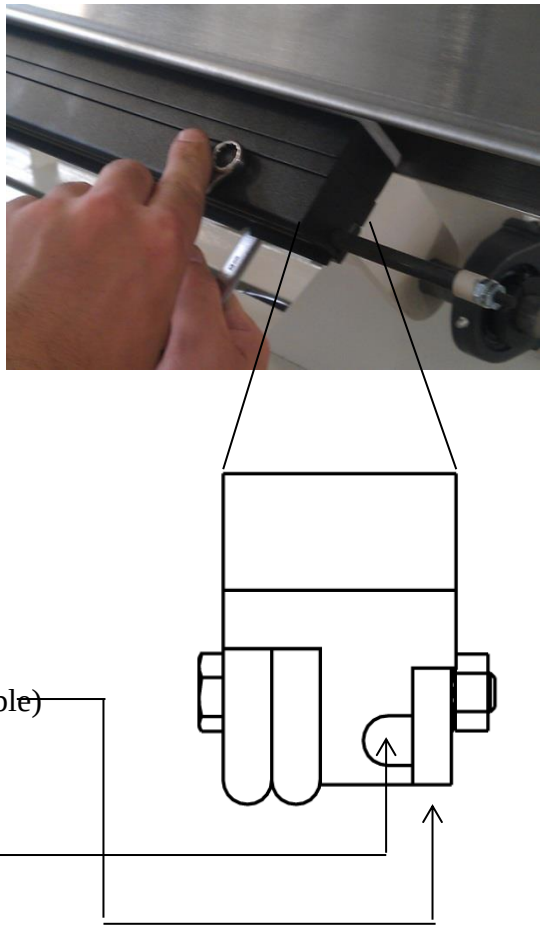
5) On the three tallest studs remove the top nut and back out the bottom nut to the end of stud without removing.



6) Remove all of the remaining nuts from shorter studs. This will allow the seal bar assembly to slide out pass stainless steel guards far enough for servicing.

Warning: It is imperative to lay out a large pad to protect parts being removed from this point on.

7) Using two closed end wrenches remove the nuts while leaving the bolts in place. **Be careful not to scratch any part of the coating on the seal bar assembly.** Note the order in which you remove the nuts because it is important that they are installed exactly in the same order.



8) Remove the Spacer bar (and Knife if applicable)

9) Remove damaged heating element.

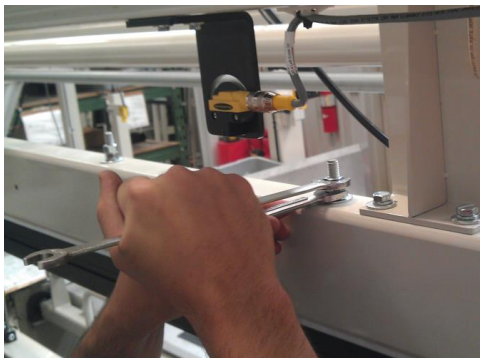
10) On one end of the new heating element make a mark 3 ½" in from the tip with a sharpie. Starting with your mark begin inserting the heating element into the open slot of seal bar. Once in place, you should have 3 ½ "of extra heating element protruding from both ends of the seal bar.

Reverse steps 1 thru 10 to complete replacement with special attention to steps 7, 6, 5, & 4.

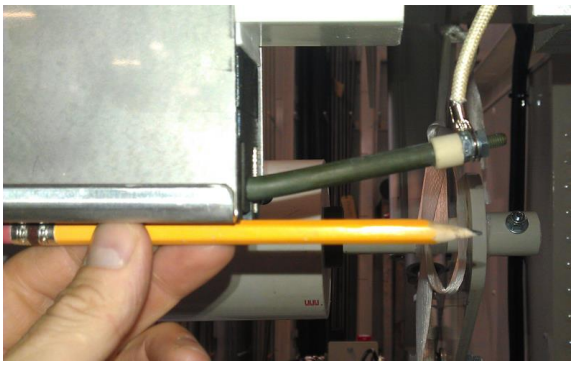
On step (7) torque each bolt to 7 in. lb. torque only!

On step (6) & (5) Push seal bar assembly up with one hand as you tighten the first set of nuts with the other hand. After all of the nuts are finger tight; use a wrench to turn each nut ¼ to a ½ turn to finish compression of nylon gasket. (**WARNING DO NOT TIGHTEN PAST ½ TURN**!)

Install the second nut on each shaft and lock it to the bottom nut using two wrenches. Use caution in this procedure making sure the bottom nut does not move from its set point.



(4) Bend heat element up approximately 30 degrees.



After replacement is complete refer to Adjusting the Seal bar Pressure on previous pages for final adjustments.

Shimming the Seal Bar

Note: For cross seal bar see symptoms and adjustment of cross seal bar; once adjustment is complete, move to #3 on this page 32.

Follow procedures for replacing Left and Right seal edge or heating element page.37.

After replacement, some very important steps are needed for the system to perform properly.

If you are inexperienced, It is always advisable to contact Atlanta Attachment service techs for detail procedures on setting up seal bar alignment, the next couple of steps are crucial to the machine's performance.

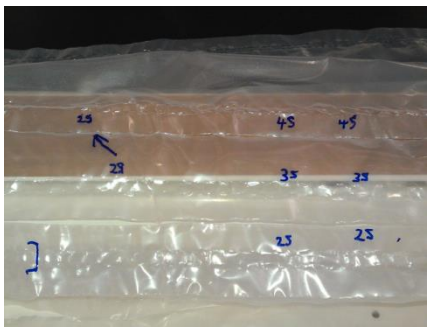
1) Setup test plastic as seen on right

2) Adjusting the Seal bar Pressure

Somewhere between Example A and B on page 29 is a good starting point for a new setup before moving on to shimming. Always make this adjustment **before** shimming.

3) Shimming rail system.

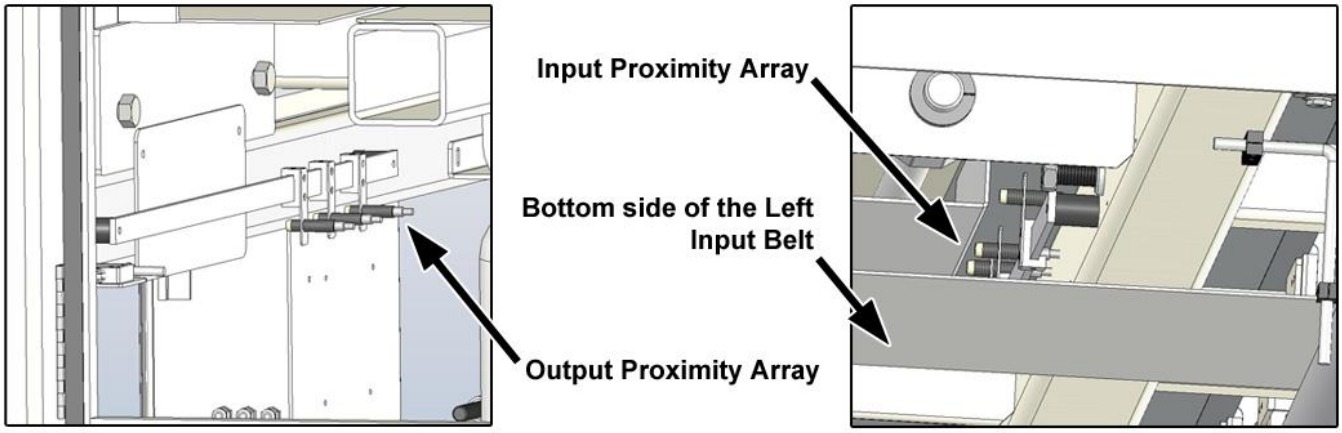
After test seal, shim the low points and record the value.



Keep repeating until you have a smooth seal. Then go back to Adjusting the Seal bar Pressure on page 35 and repeat this final adjustment to complete alignment of weld.

Mattress Size Adjustments

The 1390B machine is designed to automatically detect and adjust itself for one of the three basic bed lengths: 75”, 80” and 84”. To detect the bed length, the machine uses two arrays of three proximity sensors which are mounted on rectangular guide rails. One array is mounted on the left side of the Input frame, under the table, near the front of the machine (right illustration). The sensors detect the position of the (left) movable Input frame during the bed alignment and locating cycle. Depending on how many sensors are covered in this array, the machine controller determines how long the bed is and how far to move the adjustable Output Seal Bar frame assembly. This assembly uses the second array to get it positioned for the subsequent sealing process. The Output array is located near the left access door under the movable Seal bar frame (left illustration). It is adjusted to ensure that the opening between the two Side Seal bars is about 1” greater than the length of the bed detected in the Input end of the machine, to prevent bed jamming during the transfer from Input to the Output side of the machine.



Before this machine is shipped, it is adjusted and tested according to the customer bed specifications and should not need to be readjusted. If the parameters of the bed change after installation and it is necessary to readjust these arrays, it is very easy to do so. Simply loosen the screw that clamps the proximity sensor mounting block and move in the desired direction. If you want to be able to detect a smaller bed in the Input, move the sensor toward the center of the machine and vice versa. It works the same way if you want to stop the adjustable Output Seal bar frame.

Maintenance

Under normal operating circumstances, the 1390B machine does not require much maintenance. The following list outlines the normal machine maintenance that should be performed on periodic bases to keep the machine in a good working order:

Daily

Clean the three Seal bars at least once a day, preferably at the beginning of the first shift, before the seal bars begin to heat up. To clean the Seal bars, use a soft cloth and WD-40 as the solvent. Use extra caution and make sure Seal bars are not hot or heating up before cleaning. Also, use extra care not to scratch the Seal bar’s anti-stick coating. If the coating surface is scratched to the bare metal, the plastic film may stick to it, which in turn may result in poor seal quality and /or machine down time.

Visually inspect PTFE tape (covering the lower seal bars) for any cuts and delaminating from the lower seal bar. If necessary, replace the tape.

During machine operation, listen for any unusual noises and watch for any uncommon machine behavior For example: jerky cross seal bar up/down movement, squeaky belt drive, etc.

Clean the machine and remove any plastic film scraps or other debris. They may cause mechanism to jam and potentially fail.

Weekly

Check the main air supply filter for any accumulation of oil or debris. Empty the filter bowl before it is filled to the maximum level indicated on the side of the bowl.
Check the smoothness of the up/down movement of the Cross Seal Bar. If the bar chatters at all or does not move smooth, wipe the rods clean and apply a coat of sewing head oil to keep the rods lightly lubricated. This will improve the performance and extend the life of the bearing and keep the shafts for rusting. If the condition persists after application of the lubricant, check the tension and alignment of the two synchronizing chains. Also check the condition of the Cross Seal Guide rods for any unusual wear.

Monthly

Check the chain tension on all four motor drives. Adjust as needed.
Check the tension of the input and output belts. Adjust as needed.

Quarterly

Check the conveyor bearings and other pivot bearings and lubricate using PTFE based grease.
Check the condition of the Seal bar tape and the silicone rubber cushion below it for any through cuts particularly in the area where the hot knife cuts through the plastic. If the PTFE tape or cushion or both is cut or damaged, the whole setup must be replaced.

Bi-Annually

Replace the air supply filter element.

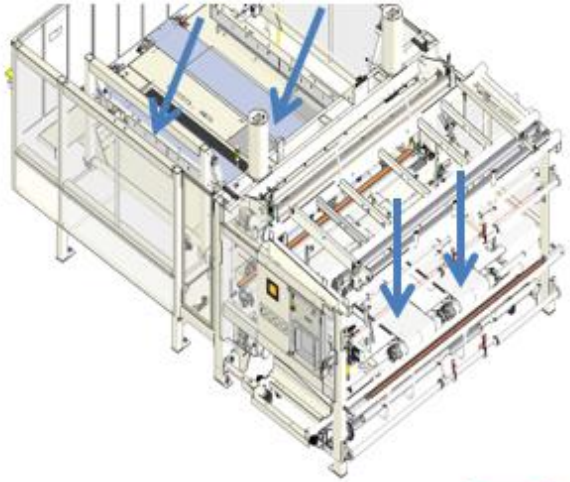
Operator Shift Maintenance Charts

Two(2) Printable Sheets

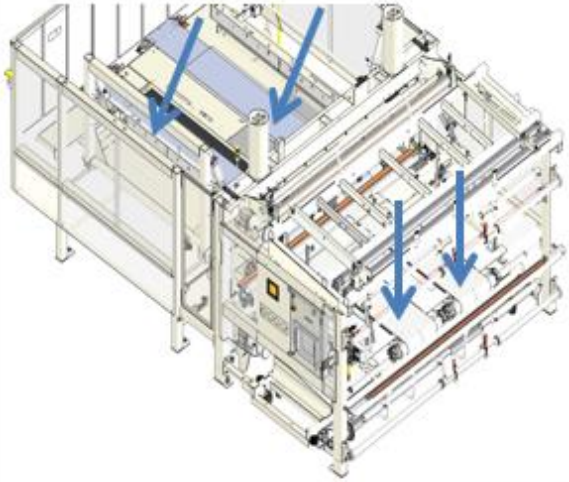
Technician Maintenance Charts

Four(4) Printable Sheets

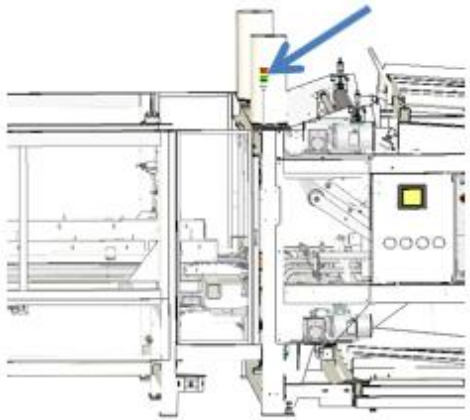
Preventative Maintenance (**Shift Schedule**)	**1390B Auto Pack**	Frequency START MID END



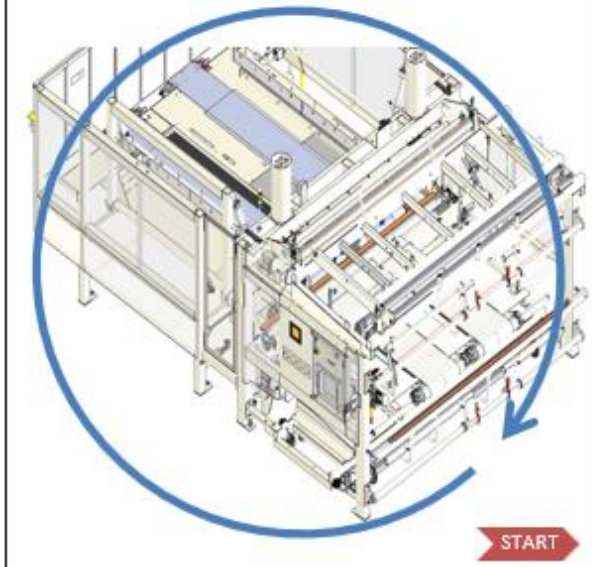
1. Check all conveyor belts for cracks , tears, rips, check seams and tension.



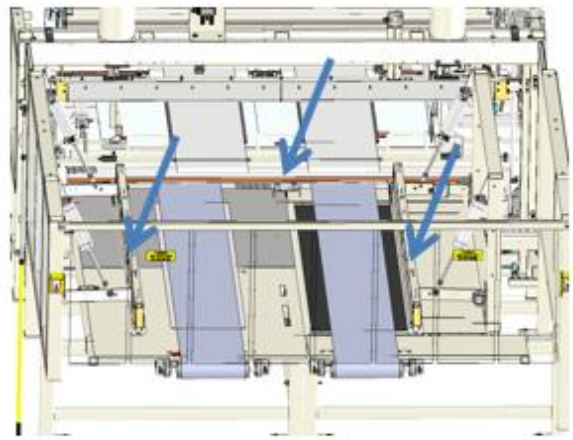
1. A Check the alignment of the belts. Make sure they are tracking properly.



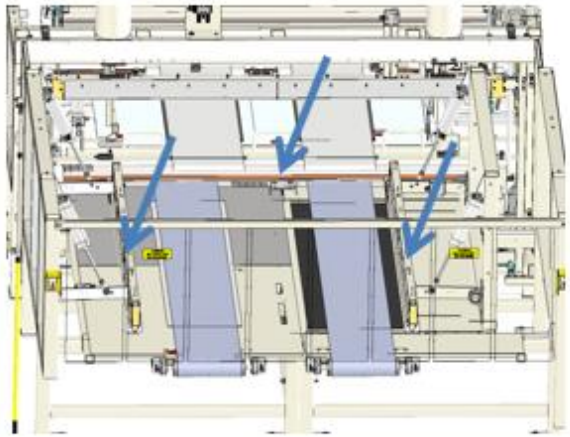
2. Check to see if the light tower indicator is working properly.



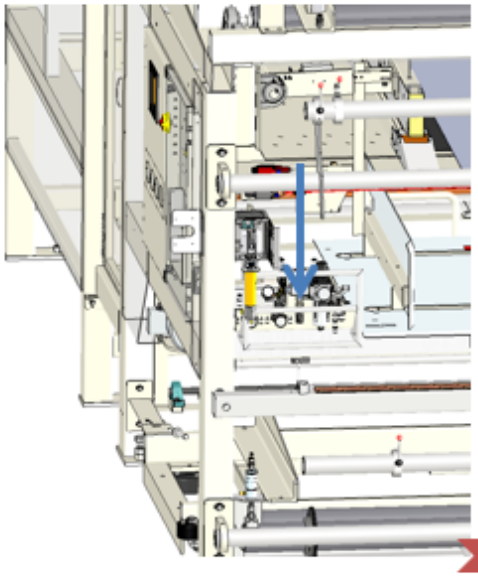
3. Check for unusual noises and or air leaks. Alert a technician if any.



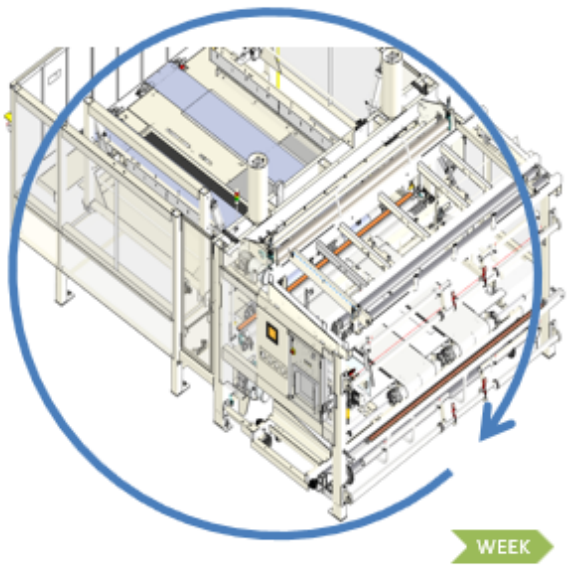
4. Check PTFE tape on lower three seal bars. Tape should be smooth no tears or cracking.



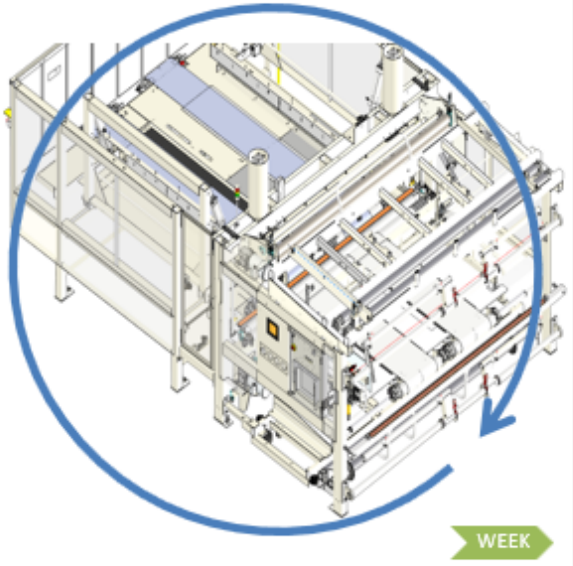
5. Inspect seal bars for any damage, cracks and wear. **See note at end on seal bars**

Preventative Maintenance (**Shift Schedule**)	**1390B Auto Pack**	Frequency START MID END
	Upper seal bars have a coating and the Lower Seal bars are made of PTFE which is a non-stick material. Use extreme caution when inspecting seal bars . If everything looks perfect DO NOTHING. If this material is scratched or torn in any way it could cause buildup on the seal bar. If this happens, a clean thick rag with WD-40 sprayed on it needs to be wipe on the seal bar to keep it clean. By doing this it will prevent buildup and burn through.	
6. Check air system for moisture		

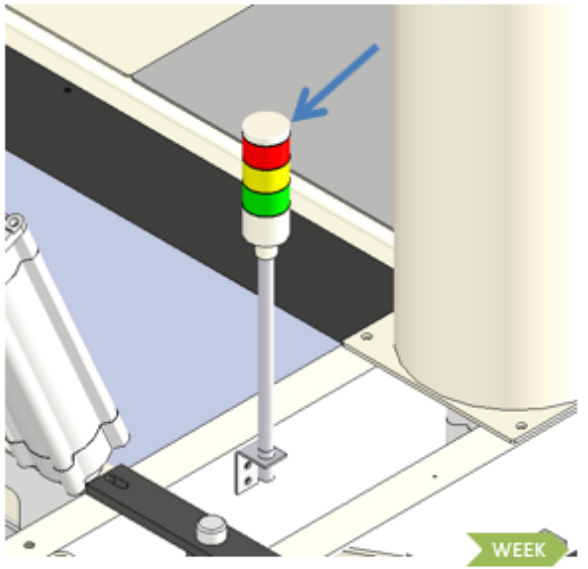
Preventative Maintenance (**Mechanic schedule**)	**1390B Auto Pack**	Frequency DAY WEEK MONTH



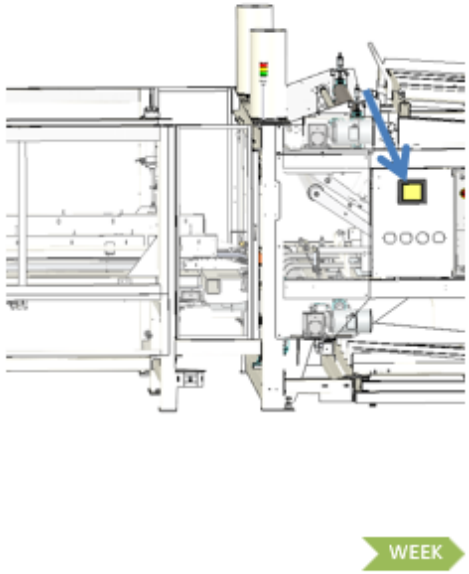
1. Check for unusual noises and or air leaks.



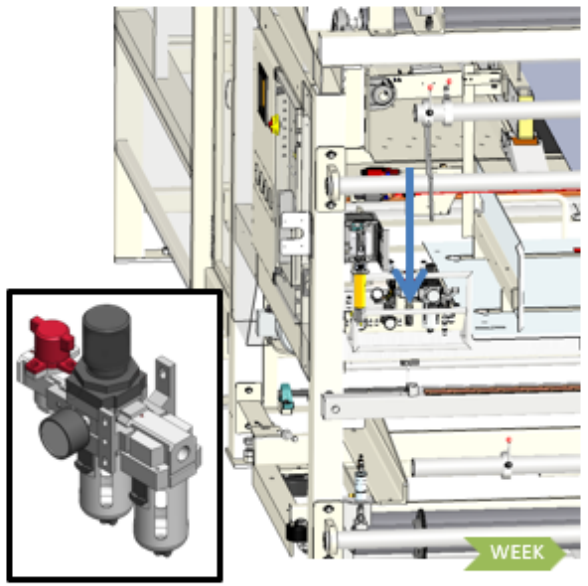
2. General cleaning of the machine.



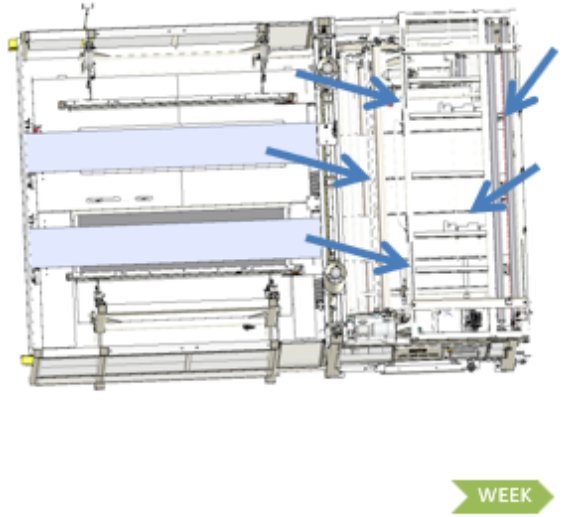
3. Check to see that Light tower functions properly.



4. Check screen operation, Recalibrate only if having issues . Procedure in owners manual .

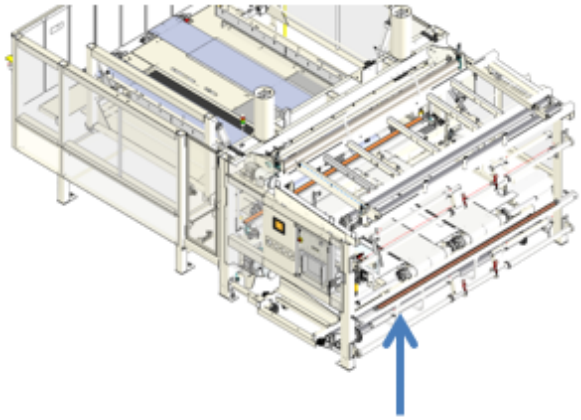


5. Check air filter and replace as needed.



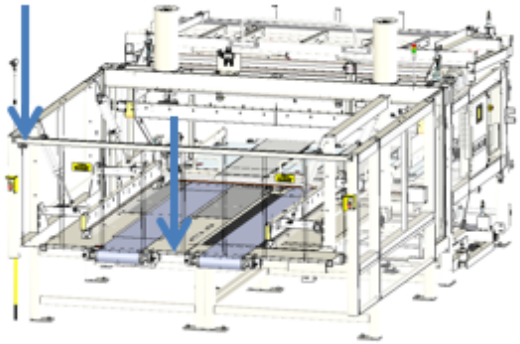
6. Check and clean photo eyes and reflective tape in infeed area. Replace tape if damaged.

Preventative Maintenance (**Mechanic schedule**)	**1390B Auto Pack**	Frequency DAY WEEK MONTH



WEEK

6.a. Check photo eye and reflective tape under infeed. Replace tape if damaged.



WEEK

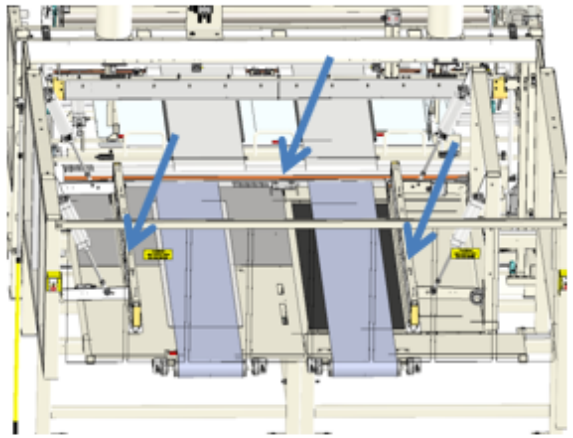
6.b. Clean photo eye and reflective tape (outfeed) . Replace tape if damaged.

VERY Important Message:

Upper seal bars have a coating and the Lower Seal bars are made of PTFE which is a non-stick material. Use extreme caution when inspecting seal bars . If everything looks perfect DO NOTHING. If this material is scratched or torn in any way it could cause buildup on the seal bar. If this happens, a clean thick rag with WD-40 sprayed on it needs to be wipe on the seal bar to keep it clean. By doing this it will prevent buildup and burn through.

caution

Never reuse cleaning rags in this procedure. Always discard after cleaning!

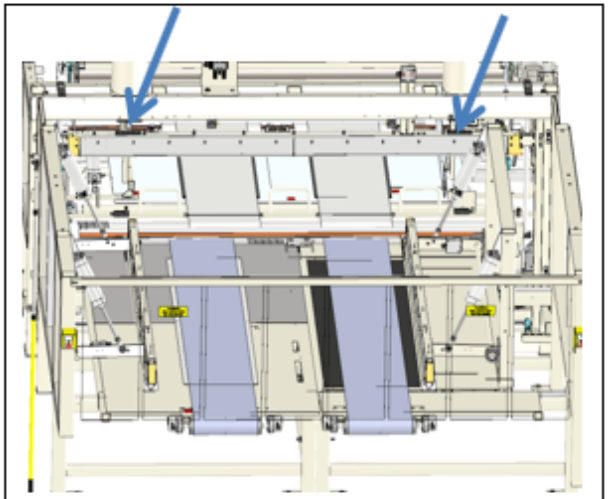


WEEK

7. Check PTFE tape on lower seal bars. Tape should be smooth w/ o tears or cracks.

Most importantly is where the seal bar knife presses down on the PTFE tape. If the tape is cut , check the silicone rubber cushion underneath the tape for cuts or damage. If damaged it is possible to flip over the cushion and use the bottom side. If damage is too severe , switch the top cushion with the bottom one.

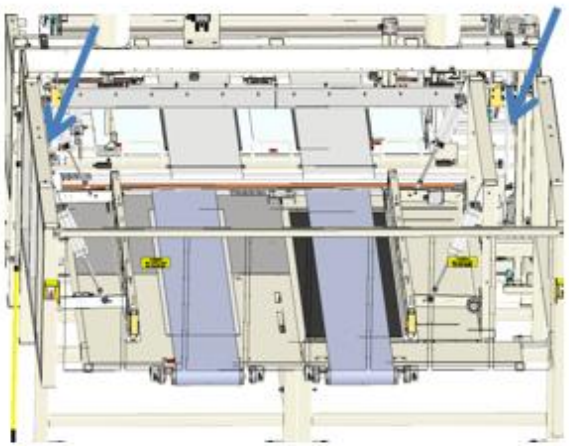
caution



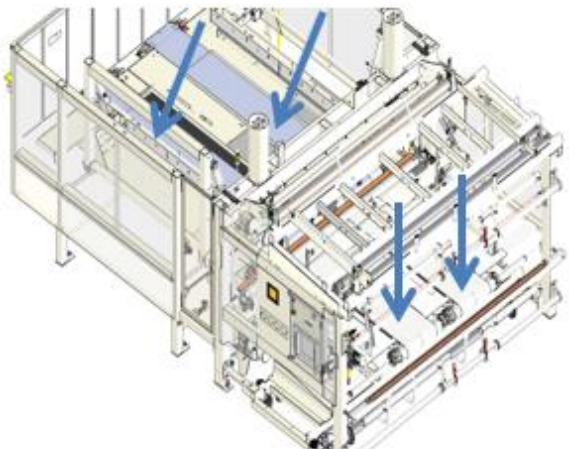
WEEK

8. Clean cross seal bar cylinders and lubricate. Do not touch cylinders with bare hands.

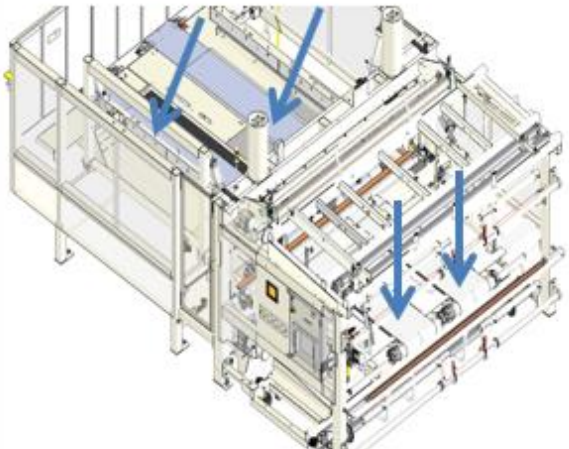
Preventative Maintenance (**Mechanic schedule**)	**1390B Auto Pack**	Frequency DAY WEEK MONTH



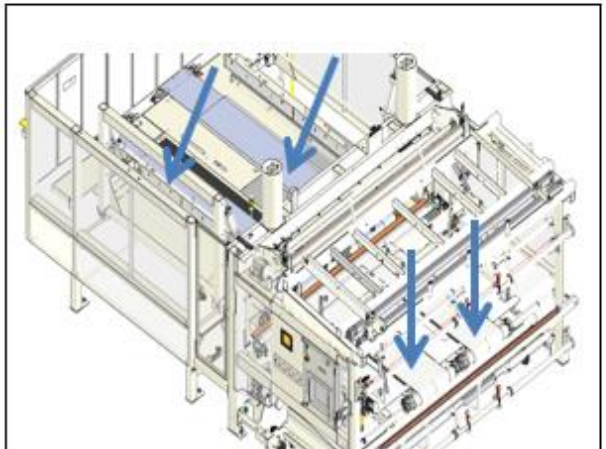
9. Clean seal bar guides and lubricate. Do not touch with bare hands.



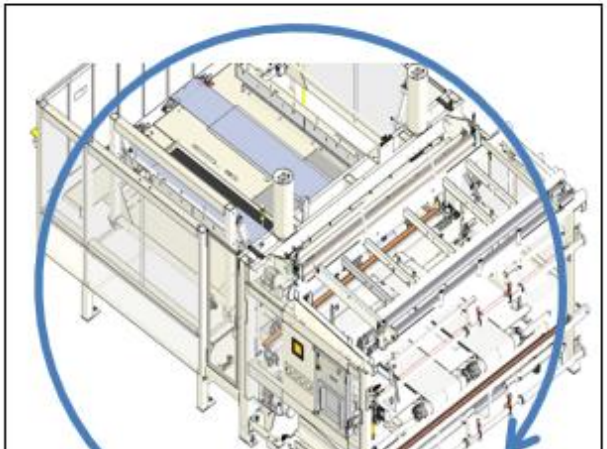
10. Check all conveyor belts for cracks , tears, rips, check seams and tension.



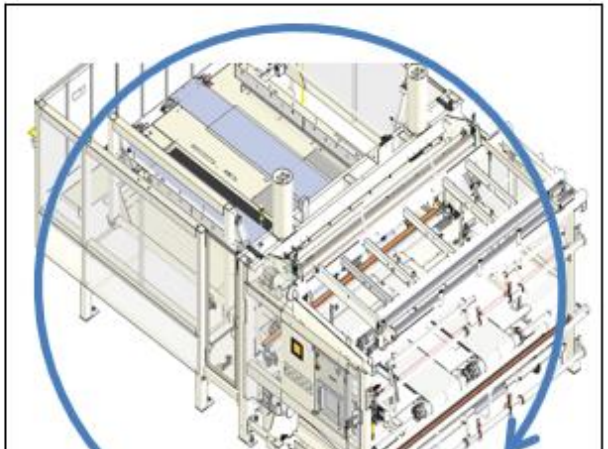
10. a. Check the alignment of the belts. Make sure they are tracking properly.



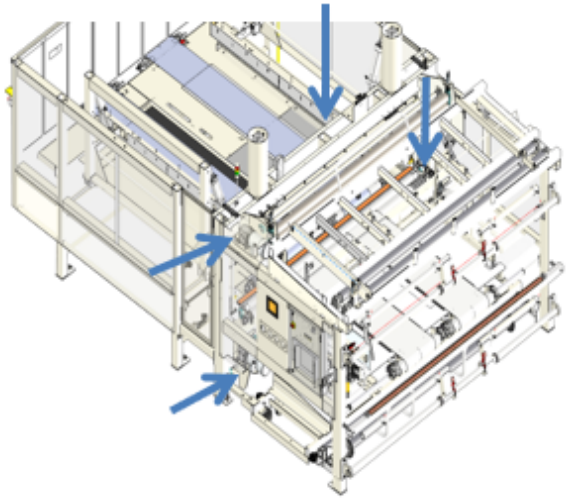
10. b. Check tension on both the infeed and outfeed belts. Adjust as needed.



11. Check conveyor belt bearings and lubricate w/ PTFE based grease.



12. Check all bearings and lubricate.

Preventative Maintenance (**Mechanic schedule**)	**1390B Auto Pack**	Frequency DAY WEEK MONTH
 MONTH		
13. Check chain tension on drive motors. 3 in infeed section and 1 under outfeed.		

Lockout Procedure

Make sure all seal bar cylinders are in the desired position (up or down). It is necessary to observe the position of these cylinders. When the main air is turned off to the machine, the cylinders are pneumatically locked in the position they are at that moment.
Turn off the main air lockout valve and let the airlines and the air tank bleed-off completely.
Install a lockout padlock in the air lockout valve.
Turn off the main electrical switch and lock it out.
Wait until all seal bars cool off sufficiently before attempting to work near any of the seal bars.

Note: Do not lock seal bars in the down position if they are hot.

See page 15 for printable sheet on procedure.

Troubleshooting

Machine does not power up when the Power ON button is pressed.

1. Check to make sure all four Emergency Stops are pulled out and operational.
2. Check for a short circuit. Turn off all breakers and turn the machine back ON. If it comes ON, switch ON one breaker at a time.

The Input Conveyor belts turn in reverse upon machine startup before the bed is loaded on the input conveyor.

1. All three eyes bed Alignment Eyes are covered (dark) upon machine startup. Check, and if necessary, adjust the sensitivity screw. The Red led should blink 3 times /sec.
2. If sensitivity is ok but the problem persists, check the dark/light operate mode (white) screw, all three eyes should be set to light operate (turned clockwise).
3. If the eyes appear to be set correctly but the problem still exists, replace one eye at a time. Make sure to adjust as the new eye as described above.

The Input Conveyor belts turn in reverse once the bed is loaded and aligned.

1. None of the three size detecting proximity sensors were covered during the alignment phase. Adjust the left most proximity sensor in the input array and reload the bed. Repeat this procedure until the problem is solved.

The Input aligns and positions the bed properly and does not continue. The left output frame does not adjust for size.

1. The Customer conveyor eye is blocked (dark). The Red LED is not on. Adjust the eye sensitivity and make sure the Eye mode is set to Dark Operate (Counter-clockwise)
2. If problem persists, replace the eye (adjust as described)

The bed transfers to the Output area for sealing; the Cross Seal begins to go down but goes back up before cross sealing.

1. The cross-seal eye is too sensitive or adjusted too far toward the Input end of the machine. Adjust the pot on the amplifier to reduce the sensitivity some, but no less than 5 on the scale. If problem persists, realign the cross-seal sensor.

The bed climbs or hits the bottom left seal bar.

1. Adjust the location of the corresponding bed size proximity sensor on the output array.

The Side or Cross Seal is spotty in appearance.

1. Check the quality of the Teflon tape on the lower seal bar. Check the silicone rubber tape backing for cuts.
2. Adjust the Air Cylinder rod ends, out ¼ turn at a time, to lower the seal bar. Test the seal quality between every adjustment.

The seal is good in appearance but weak.

1. Adjust the seal bar Temperature, and/or dwell time (do not exceed 30).

Input aligns and positions the bed, and the left sizing plate retracts, but the bed does not move.

1. Check to make sure that a bed or another object is not covering the Customer Conveyor Eye.
2. If the eye is unobstructed, check the eye to make sure it is set and working properly. Note: this is the only eye on the machine that must be set to the Dark Operate mode of operation; all other eyes are set to Light Operate mode.

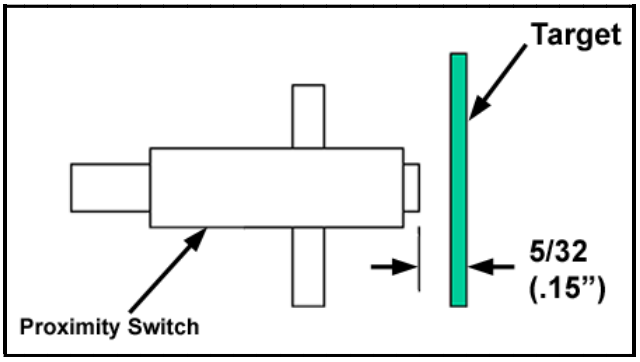
Machine continues to run even after the film (top or bottom) has run out.

1. Check to make sure that the Film run-out Eye for the corresponding film is set and working properly.

Sensor Adjustments

Proximity Switch

All proximity switches used on the 1390B machine have 8mm sensing range. The distance between the end of the sensor and the target flag should be set at about 5/32” for best performance.



Cross Seal Photo Detector

The amplifier sensitivity for the Cross Seal bar is located in the bottom-right corner of the main control box. It is factory set to the maximum setting of 10 (on the adjustment knob). It can be adjusted down if a false detection of the trailing edge of the mattress occurs often. The false detection usually results in an incomplete downward movement of the Cross Seal bar.

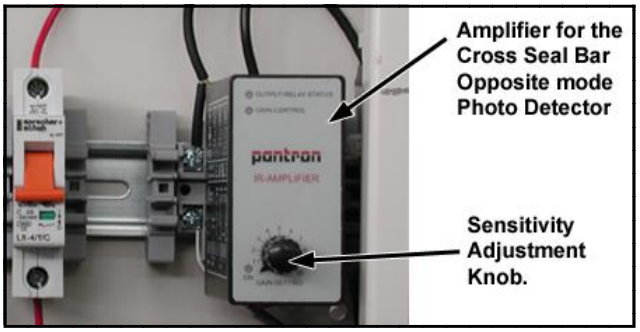
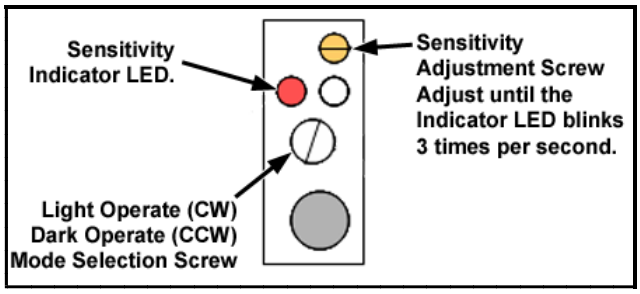


Photo Eye

All retro-reflective photo eyes on the 1390B machine are set to Light operated mode (except the “Custom Conveyor Full Eye” which is set to the dark operated mode).



Conveyor Connection for the 1390BA

Customer's infeed conveyor

There are 2 types of connections to connect a conveyor to the infeed.

- Module 17, channel 1 is for connecting a relay for an external infeed conveyor to the 1390BA.
- Module 19, channel 1 is for connecting a PLC for an external infeed conveyor to the 1390BA.

Using one of the two options will synchronize the external conveyor with the infeed-belt of the 1390BA.

Customer's outfeed conveyor

There are 2 options to connect an external outfeed conveyor to the 1390BA.

- Module 16, channel 2 is for connecting a 24-volt eye/sensor. This eye/sensor can be placed anywhere in the customers conveyor. As long as this eye/sensor is blocked the 1390BA will not unload a mattress. **(Setting #8 in "Advanced Settings" need to be set)**
- Module 18, channel 2 is for a signal from the customer's PLC to stop unloading the 1390BA. **(Setting #12 in "Advanced Settings" need to be set)**

Installation

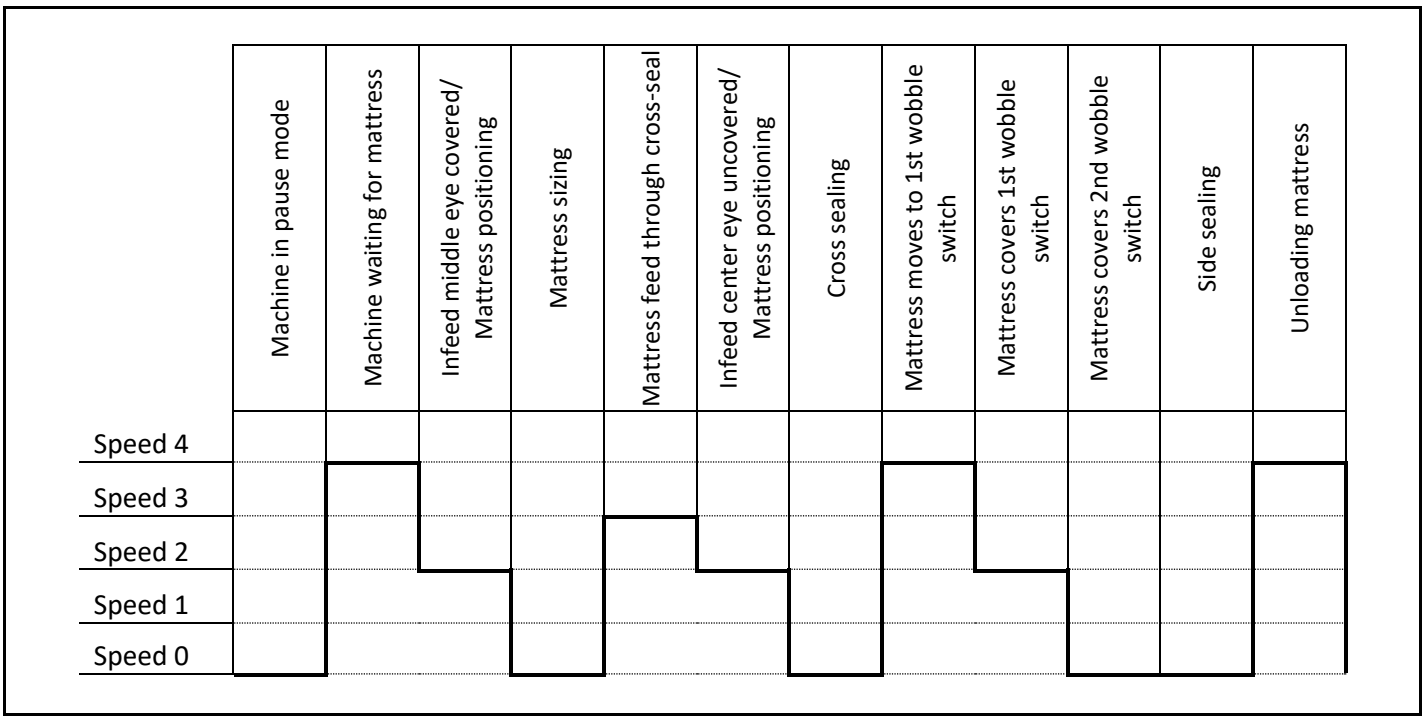
To make a connection to one of the modules use 22-gauge wire.
The part numbers for the plugs used for the modules/wire connection are:

- 2 pin connector FF100F2202
- 2 pin cover FFSC10002
- 3 pin connector FF100F2203
- 3 pin cover FFSC10003

A special crimping tool is recommended for the connectors. (AAC part #: MMIT-100F)

****** Always use a current wire diagram for wire connection information ******

Mattress Speed Cycle



Speed Cycle

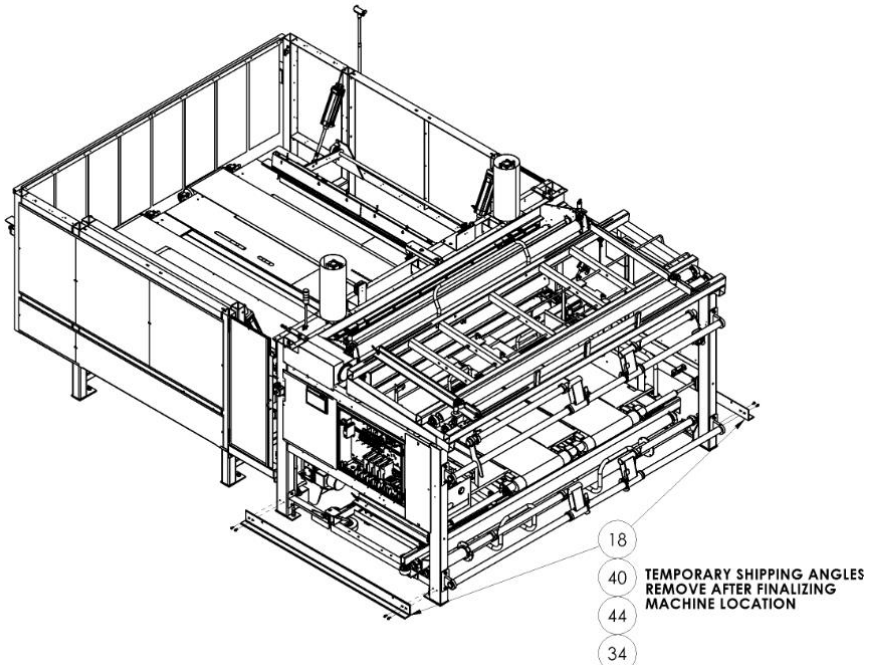
	Infeed	Top Film	Bottom Film	Outfeed
Speed 1	Only used in manual	Depends on position of dancer-bar speed 1, 2, 3 or 4	Depends on position of dancer-bar speed 1, 2, 3 or 4	Only used in manual
Speed 2	Position speed			Position speed
Speed 3	Mattress through cross seal speed			Mattress through cross seal speed
Speed 4	Ready for receiving mattress			Outfeed Mattress (full speed)

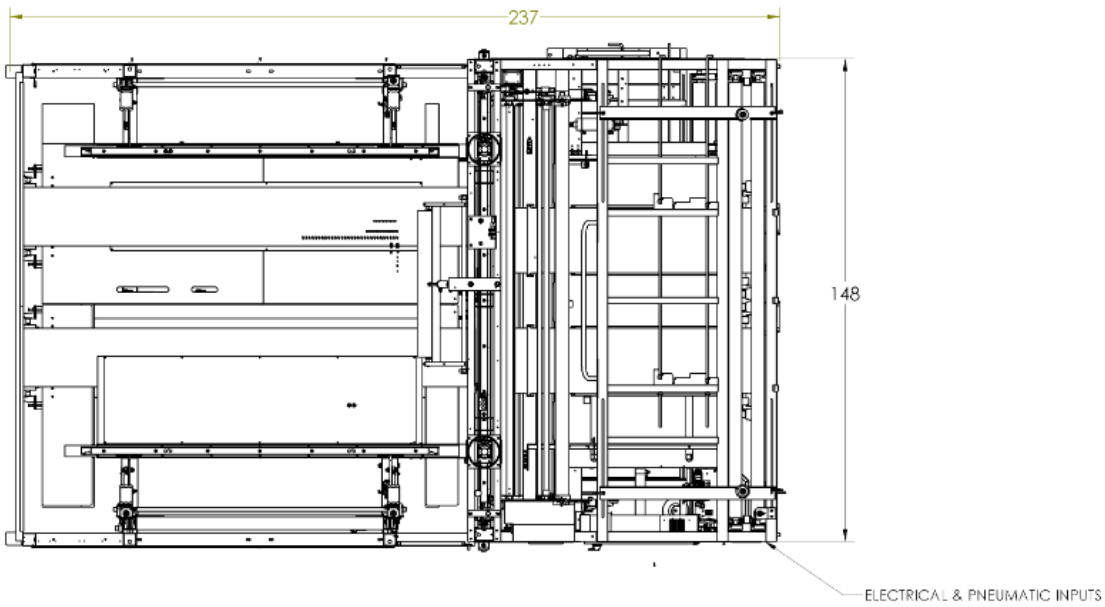
4. ASSEMBLY DRAWINGS AND PARTS LISTS

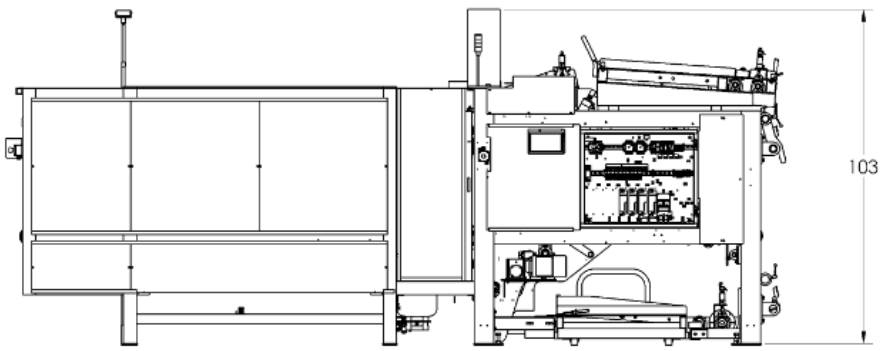
The materials contained herein are confidential and proprietary information of Atlanta Attachment Company. In addition to any confidentiality and non-disclosure obligations that currently exist between you and Atlanta Attachment Company, your use of these materials serves as an acknowledgment of the confidential and proprietary nature of these materials and your duty not to make any unauthorized use or disclosure of these materials.

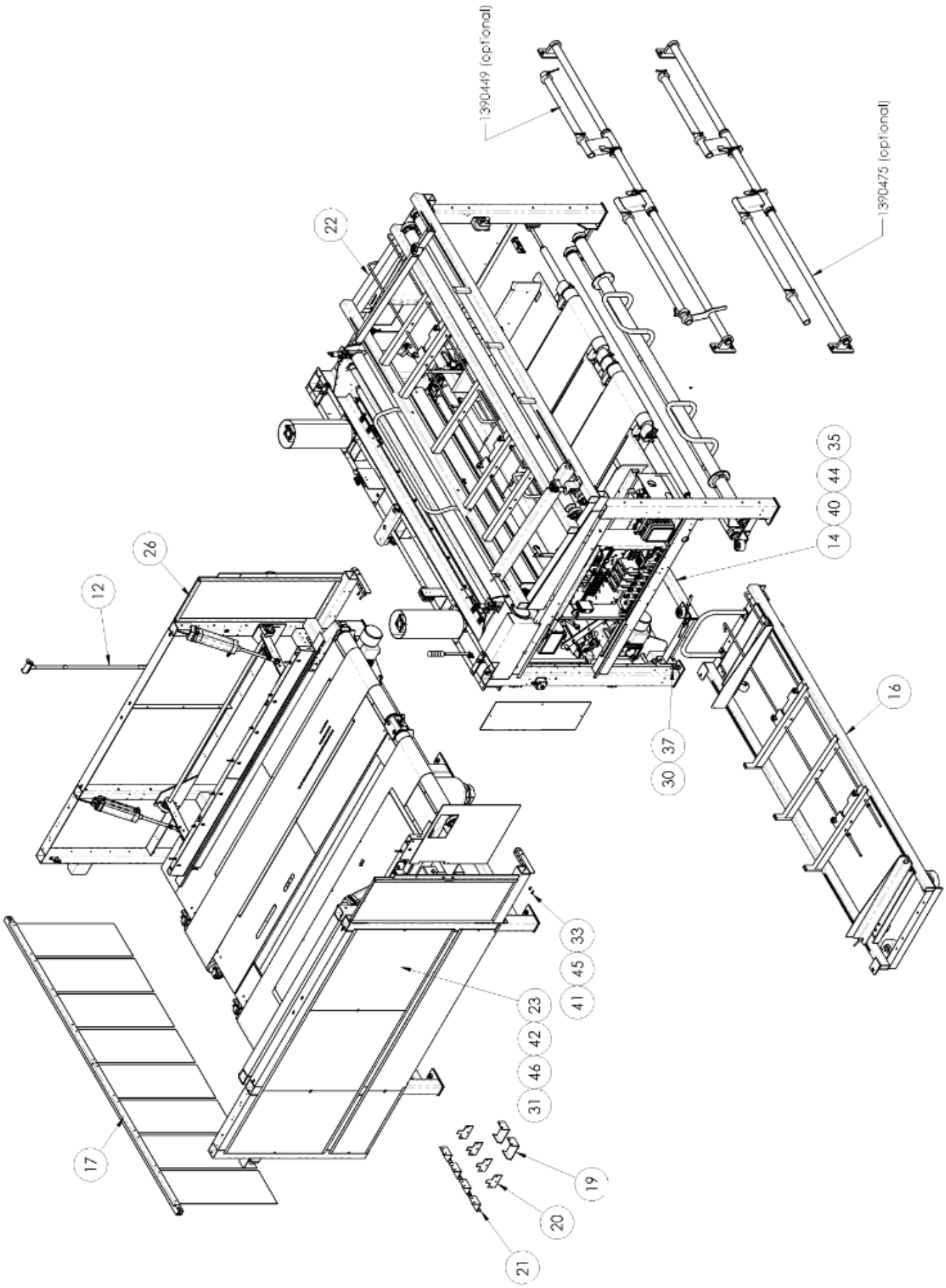
11390BA Auto Pack 24-8

AAC Drawing Number 9009108 Rev 1








1390449 (optional)
1390475 (optional)
22
26
12
14
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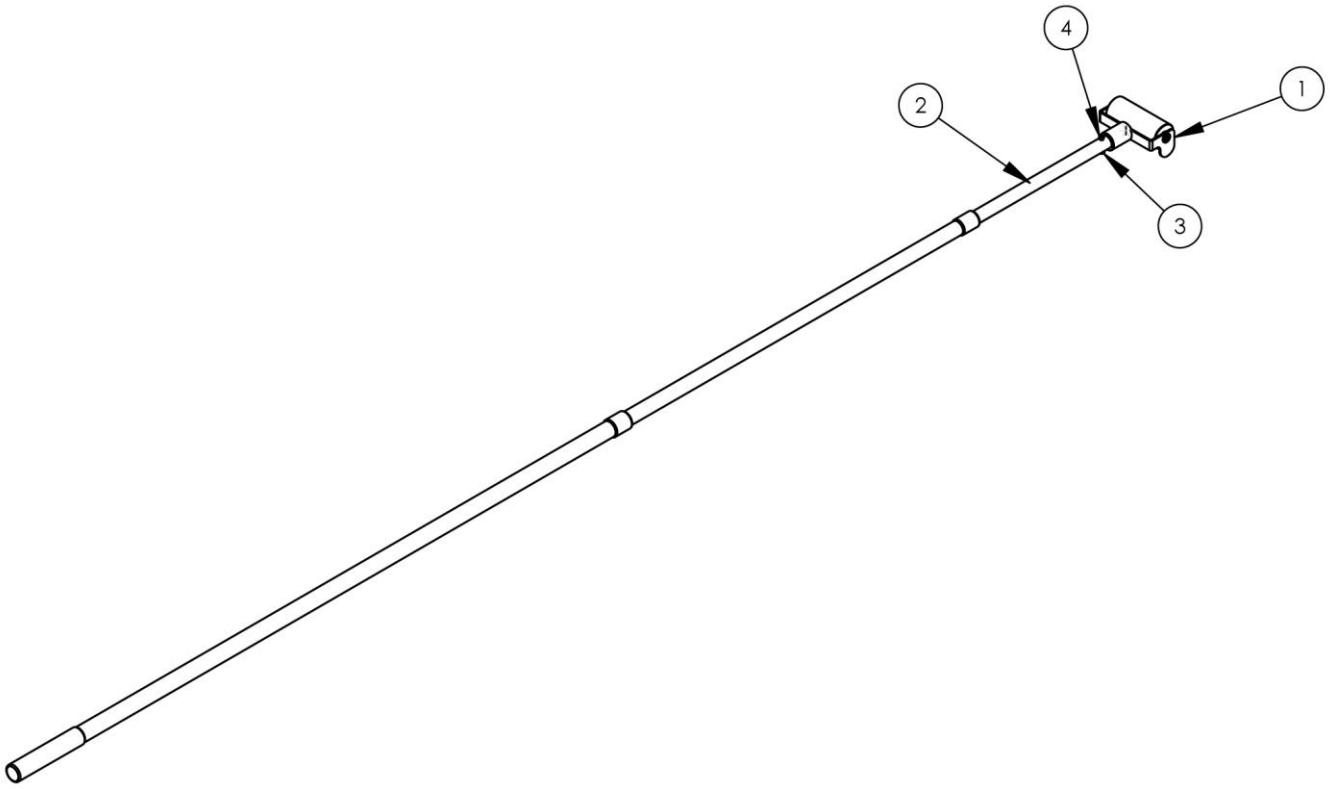
11390BA parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	*1	1390-LAB1	LABEL,DANGER,VOLTAGE,
2	*2	1390-LAB2	LABEL, DANGER, HOT SURFACE 1390A
3	*8	1390-LAB3	LABEL, WARNING, START AUTO KEEP AWAY,
4	*2	1390-LAB4	LABEL, IMPORTANT, YELLOW 1390A
5	*1	1390-LAB5	LABEL, FILM ROUTING
6	*4	1390-LAB7	LABEL, CAUTION, YELLOW
7	*4	1390-LAB8	LABEL, PRECAUTION, SPANISH YELLOW, 1390A
8	*4	1390-LAB13	LABELS, CAUTION, NVR CLIMB LAS
9	*2	1390-LAB14	LABELS, CAUTION, LONG LASER EN
10	*4	1390-LAB16	LABELS, CAUTION, BIG, BLK/YL L
11	1	1390KIT06	GUARD AND STIFFENER KIT
12	1 AR	1390170	HANDLE ASBLY, TAPE ROLLER
13	1 AR	1390449	TOP BOOT ROLL HLDR ASY
14	1	1390457	MOUNT,LOWER CASTER
15	1 AR	1390475	BOTTOM BOOT ROLL HLDR ASY
16	1	1390500	ROLL HOLDER FRAME, LOWER
17	1 AR	1390788	GUARD, EXIT END
18	2	1391923	ANGLE,SHIPPING
19	2	1394000	SHIPPING BRACKET 1
20	4	1394284	SHIPPING BRACKET 2
21	4	1394285	SHIPPING BRACKET 3
22	1	13901279	INPUT CONVEYOR
23	1	13901289	LEXAN GUARDS

ITEM	QTY.	PART NUMBER	DESCRIPTION
24	*1	13901307	ELECTRICAL KIT, CABLES
25	1	13901331	PC HMI MOUNT ASSEMBLY KIT
26	1	13901390	EXIT ASSEMBLY, AUTO-PAK
27	1	EEJBC375CG	GATEWAY PC, W-PWR CBL, SERIAL
28	*1	LIGHT TOWER	LABEL, LIGHT TOWER
29	3	MMSG1305	TAPE, TEX PTFE, 3.4W X 54'L, 6 MIL
30	4	NNH7/8-9	7/8-9 HEX NUT
31	27	SSBC98048	10-32 X 3/4 BUTTON CAP SC
32	1	SSFC90064	10-32 x 2 FLAT ALLEN
33	4	SSHC10064	5/16-18 X 1 HHCS
34	8	SSHC25064	3/8-16 X 1,HEX CAP
35	4	SSHC25080	3/8-16X1-1/4 HHCS
36	8	SSHC45112	1/2-13 X 1-3/4 HHCS, G8
37	4	SSHC49192	7/8-9 X 3 HEX CAP
38	8	WWF10	WASHER, FLAT, #10, COM
39	8	WWFS1/2	WASHER,FLAT,1/2, SAE
40	13	WWFS3/8	WASHER,FLAT,SAE,3/8
41	4	WWFS5/16	WASHER,FLAT,SAE,5/16
42	21	WWFS10	WASHER, FLAT, #10, SAE
43	8	WWL1/2	1/2 LOCK WASHER
44	12	WWL3/8	WASHER,LOCK, 3/8
45	4	WWL5/16	WASHER,LOCK, 5/16
46	28	WWL10	WASHER,LOCK,#10

1390170 Tape Roller Handle Assembly

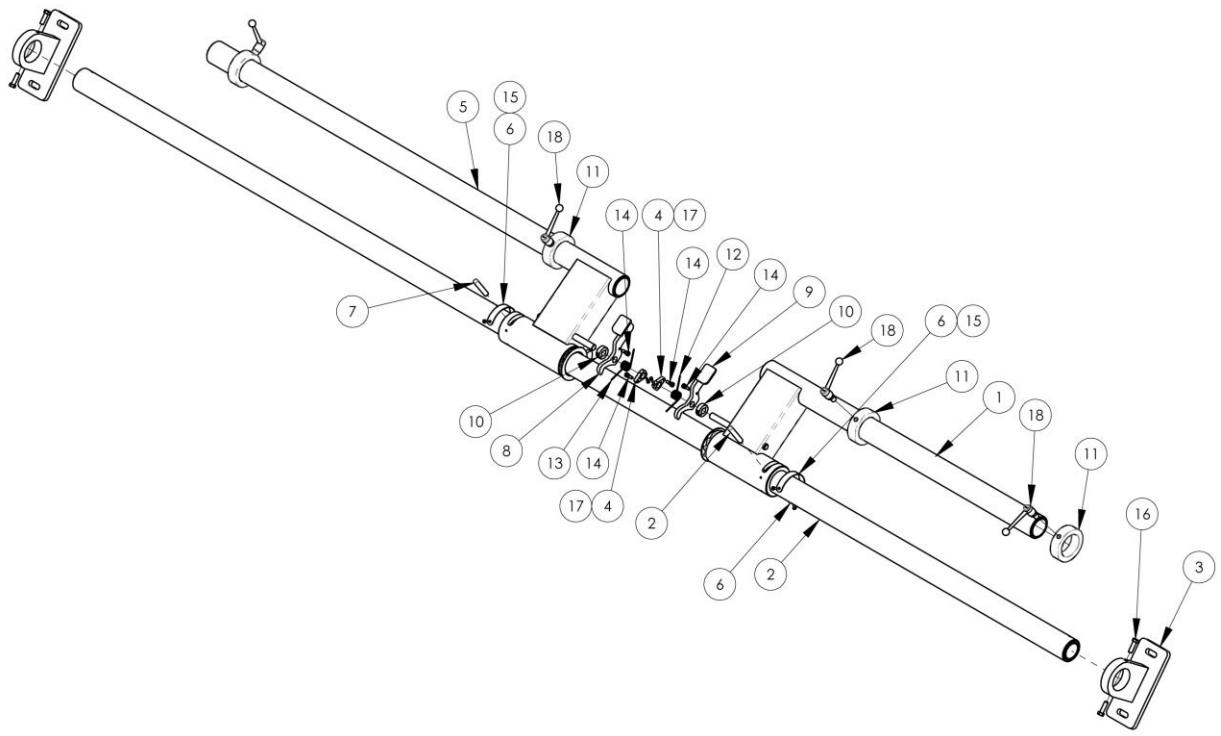
AAC Drawing Number 1390170 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	1	1390520	ROLLER,TAPE REMOVING
2	1	MM78005T44	Telescoping Pole-6'-18'

1390449 Top Boot Roll Holder Assembly

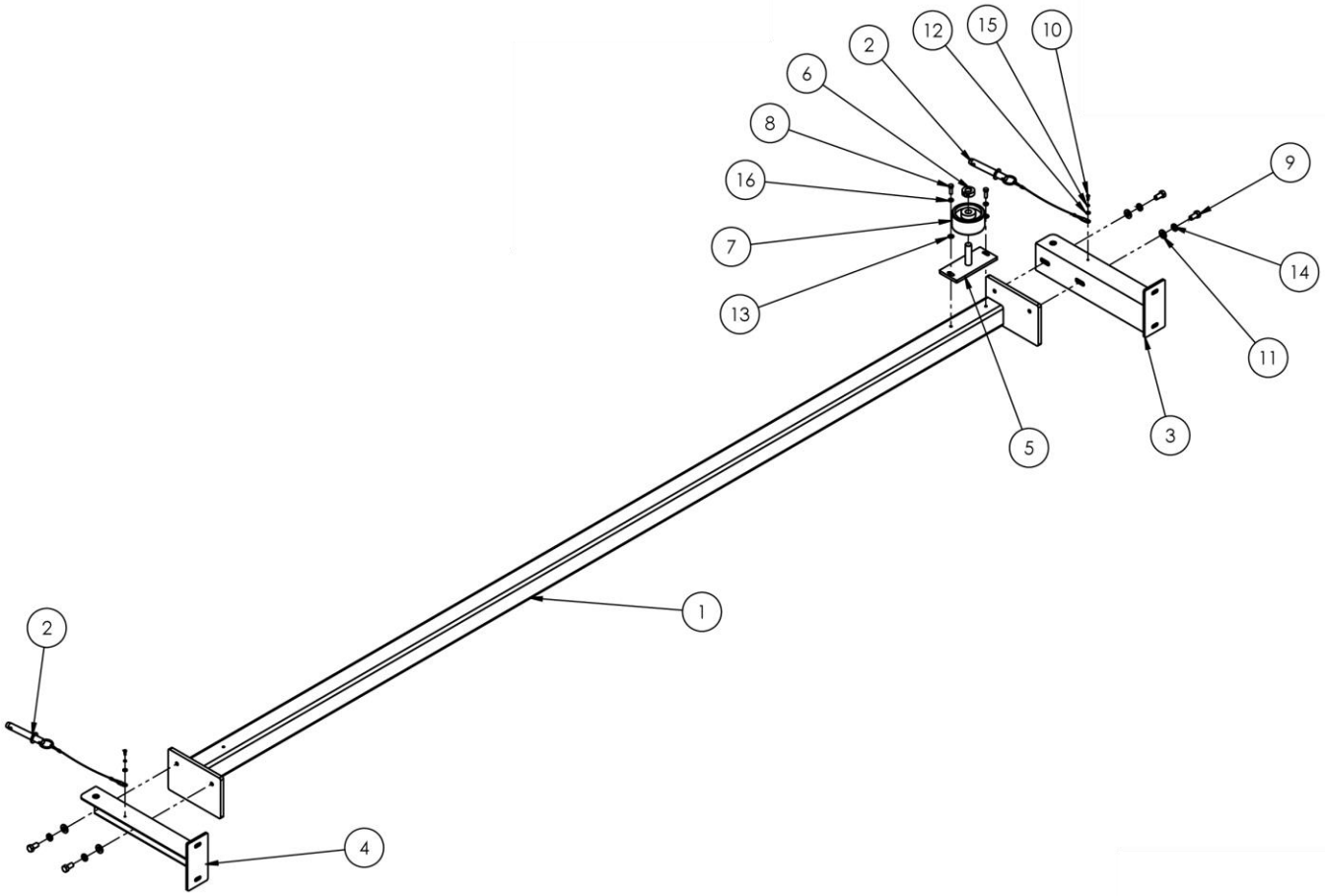
AAC Drawing Number 1390449 Rev 4



NO	QTY	PART #	DESCRIPTION
1	1	1390014	WELDMENT,ROLLER BAR
2	1	1390444	PIVOT BAR ASSY, UPPER
3	2	1390448	SADDLE ASSY
4	2	1390502	CLAMP,SPRING, 5/8B
5	1	1390506	WLDMNT, ROLLERBAR
6	2	1390509	SLOT COVER
7	2	1390510	DOWEL PIN, 1/2 X 2 15/16
8	1	1390892	RATCHET DOG, LEFT
9	1	1390893	RATCHET DOG, RIGHT
10	2	CCCL10F	CLAMP COLLAR- 5/8 ID
11	4	CCSC2-9-16	SHAFT COLLAR, SET 2-9/16"
12	1	RRLT085N4L	SPRING,TORSION,.085 WIRE, LEFT
13	1	RRLT085N4R	SPRING,TORSION, MOD
14	4	SSAS020016	SHOULDER BOLT 1/4 X 1/4L
15	4	SSBC98032	10-32 X 1/2 BUTTON CAP SC
16	4	SSHC25080	3/8-16 X 1-1/4 HHCS
17	2	SSSC90032	#8-32 X 1/2 SOC CAP SC
18	4	TTH6271K450	ADJUSTABLE HANDLE 1/2-13x

1390457 Lower Caster Mount

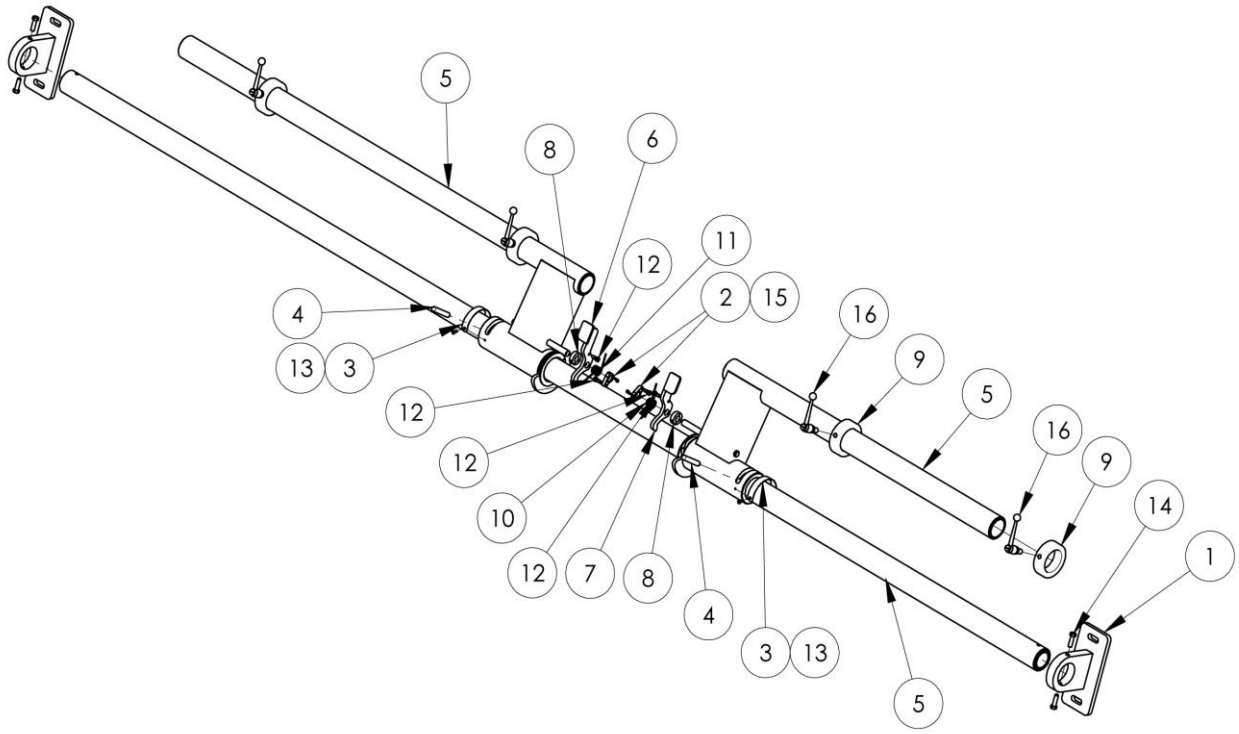
AAC Drawing Number 1390457 Rev 1



NO.	QTY	PART #	DESCRIPTION
1	1	1390658	REAR CASTER MTG FRAME
2	2	1390692	LOCATING PIN ASSY,
3	1	1390736	MTG ARM, CASTER FRAME-LH
4	1	1390738	MTG ARM, CASTER FRAME- RH
5	1	1390819	GLIDE PIVOT WELDMENT
6	1	CCCL12F	CLAMP COLLAR- 3/4
7	1	MM2419T31	WHEEL, 4"OD X 2"W X 3/4 B
8	2	SSHC10064	5/16-18 X 1 HHCS
9	4	SSHC45064	1/2-13X1 HEX CAP
10	2	SSHC98032	10-32X1/2 HEX HD
11	4	WWFS1/2	WASHER,FLAT,SAE,1/2
12	2	WWFS10	WASHER, FLAT, #10, SAE
13	2	WWFS5/16	WASHER,FLAT,SAE,5/16
14	4	WWL1/2	1/2 LOCK WASHER
15	2	WWL10	WASHER,LOCK,#10
16	2	WWL5/16	WASHER, LOCK, 5/16

1390475 Bottom Boot Roll Holder Assembly

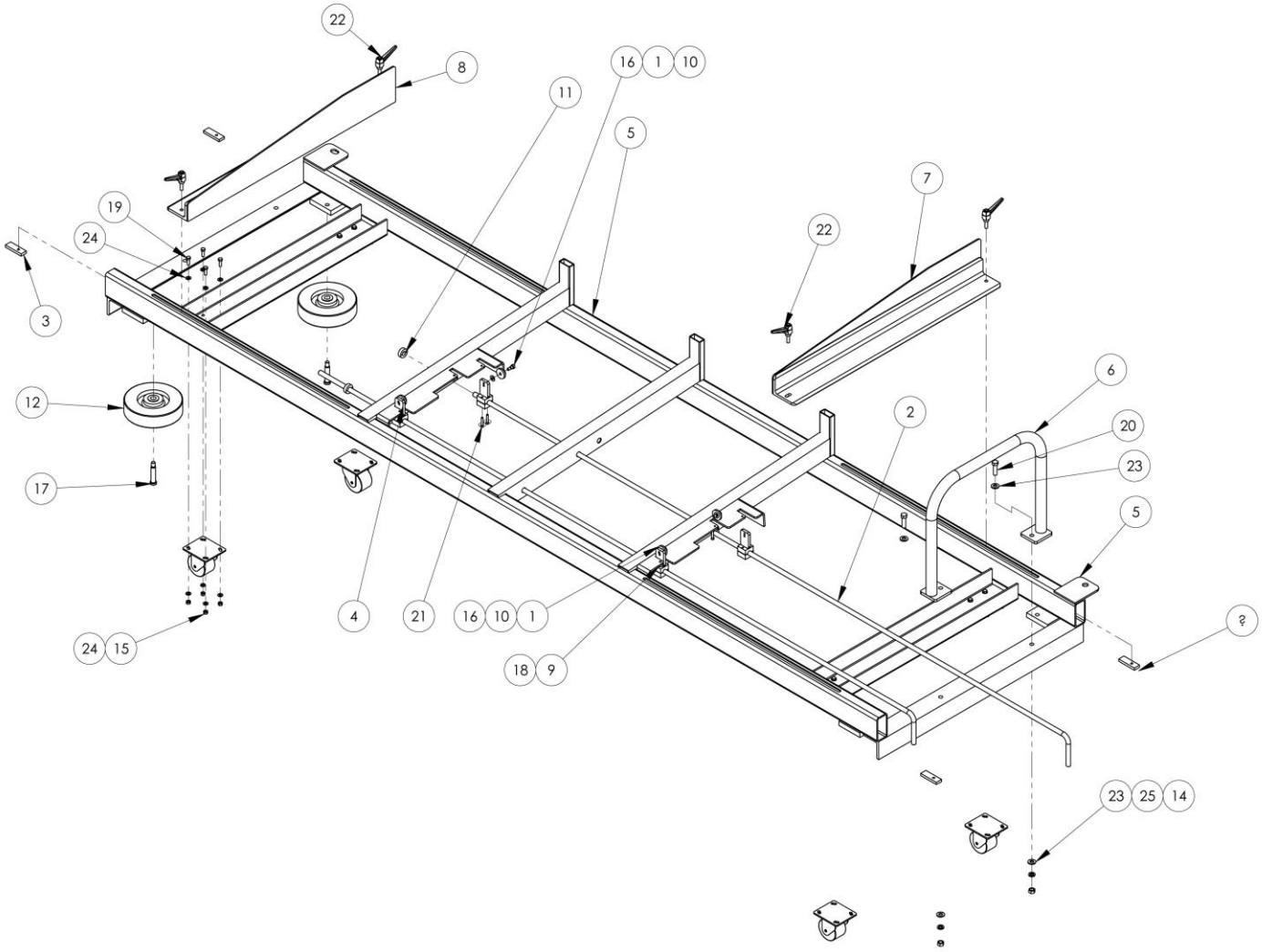
AAC Drawing Number 1390475 Rev 4



ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1390448	SADDLE ASSY
2	2	1390502	CLAMP,SPRING, 5/8B
3	2	1390509	SLOT COVER
4	2	1390510	DOWEL PIN, 1/2 X 2 15/16
5	1	1390528	BOTTOM BOOT HLDR SUB-ASBY
6	1	1390892	RATCHET DOG, LEFT
7	1	1390893	RATCHET DOG, RIGHT
8	2	CCCL10F	CLAMP COLLAR- 5/8 ID
9	4	CCSC2-9-16	SHAFT COLLAR, SET 2-9/16"
10	1	RRLT085N4L	SPRING,TORSION,.085 WIRE, LEFT
11	1	RRLT085N4R	SPRING,TORSION, MOD
12	4	SSAS020016	SHOULDER BOLT 1/4 X 1/4L
13	4	SSBC98032	10-32 X 1/2 BUTTON CAP SC
14	4	SSHC25080	3/8-16X1-1/4 HHCS
15	2	SSSC90032	#8-32 X 1/2 SOC CAP SC
16	4	TTH6271K450	ADJUSTABLE HANDLE 1/2-13x

1390500 Lower Roll Holder Frame

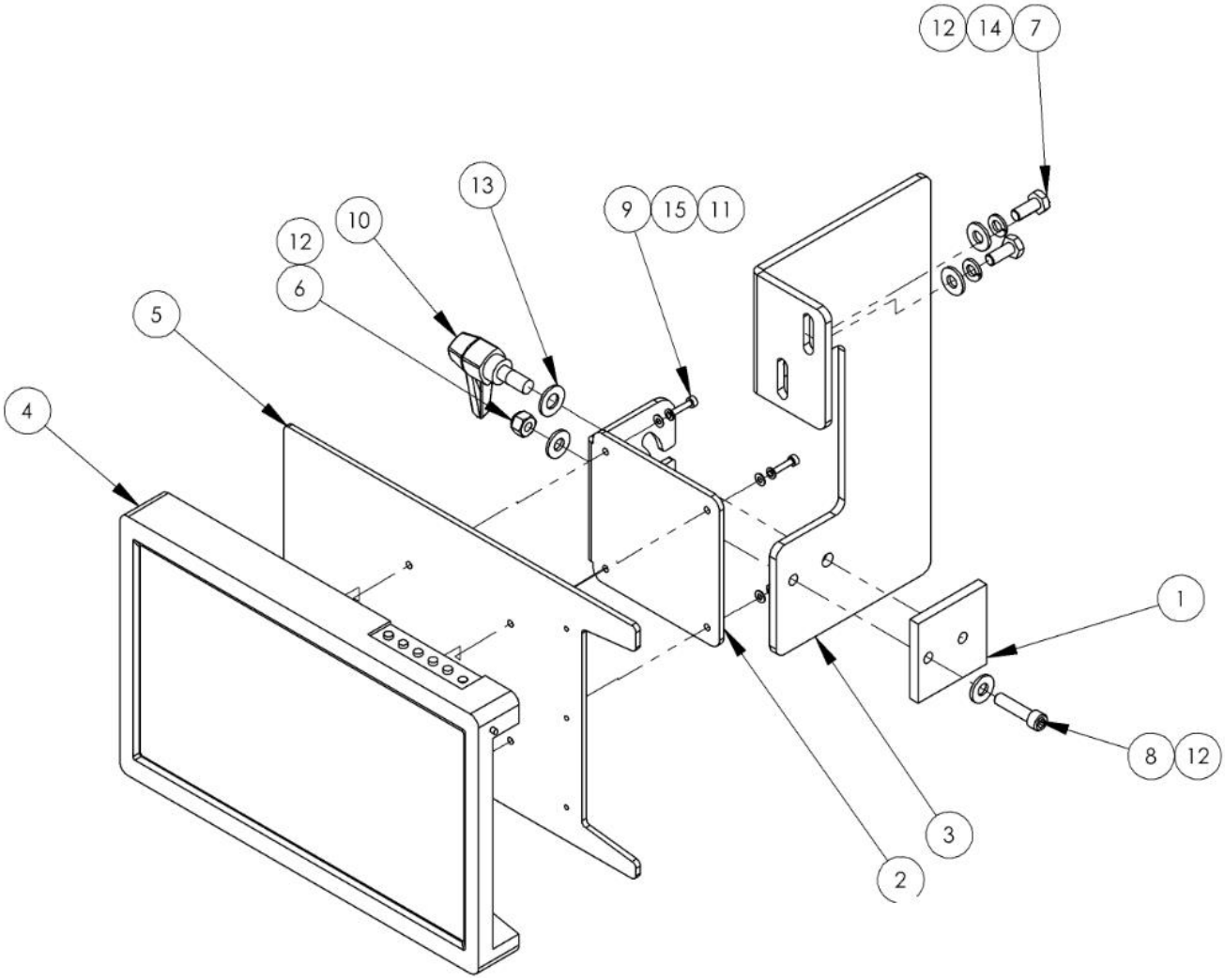
AAC Drawing Number 1390500 Rev 5



NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	4	1390198	ROLL RELEASE DISK	14	2	NNH1/2-13	NUT,HEX,1/2-13
2	2	1390458	ROD, ROLL STOP	15	16	NNK5/16-18	KEP NUT, 5/16-18
3	4	1390459	NUT PLATE-SIDE ROLLER ADJ	16	4	SSAS024024	SHOULDER BOLT 3/8 X 3/8L
4	4	1390463	ROLL STOP, WELD'T	17	2	SSAS048160	SHOULDER BOLT 3/8 X 2.5L
5	1	1390508	FRAME WELDT- BOTTOM ROLLS	18	4	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
6	1	1390559	HANDLE ASSEMBLY	19	16	SSHC10064	5/16-18 X 1 HHCS
7	1	1390565	RIGHT IDLER ROLLER, ROLL	20	2	SSHC45112	1/2-13 X 1-3/4 HHCS, G8
8	1	1390566	LEFT IDLER ROLLER, ROLL	21	8	SSSC05080	SREW,SOCKET CAP 1/4-28X1-1/4
9	4	BB1L038	BEARING,BALL,.375B	22	4	TTH32430	HANDLE,THRD,3/8-16X1-1/4
10	4	BBTRA613	WASHER,THRUST,STL, .375B	23	4	WWFS1/2	WASHER,FLAT,SAE,1/2
11	2	CCCL10F	CLAMP COLLAR- 5/8 ID	24	32	WWFS5/16	WASHER,FLAT,SAE,5/16
12	2	MM082008	CASTER,PPP,1200LBS/WHEEL	25	2	WWL1/2	1/2 LOCK WASHER
13	4	MM16CA03201-S	CASTER,SWIVEL, 3.25" STEEL				

13901331 PC HMI Assembly

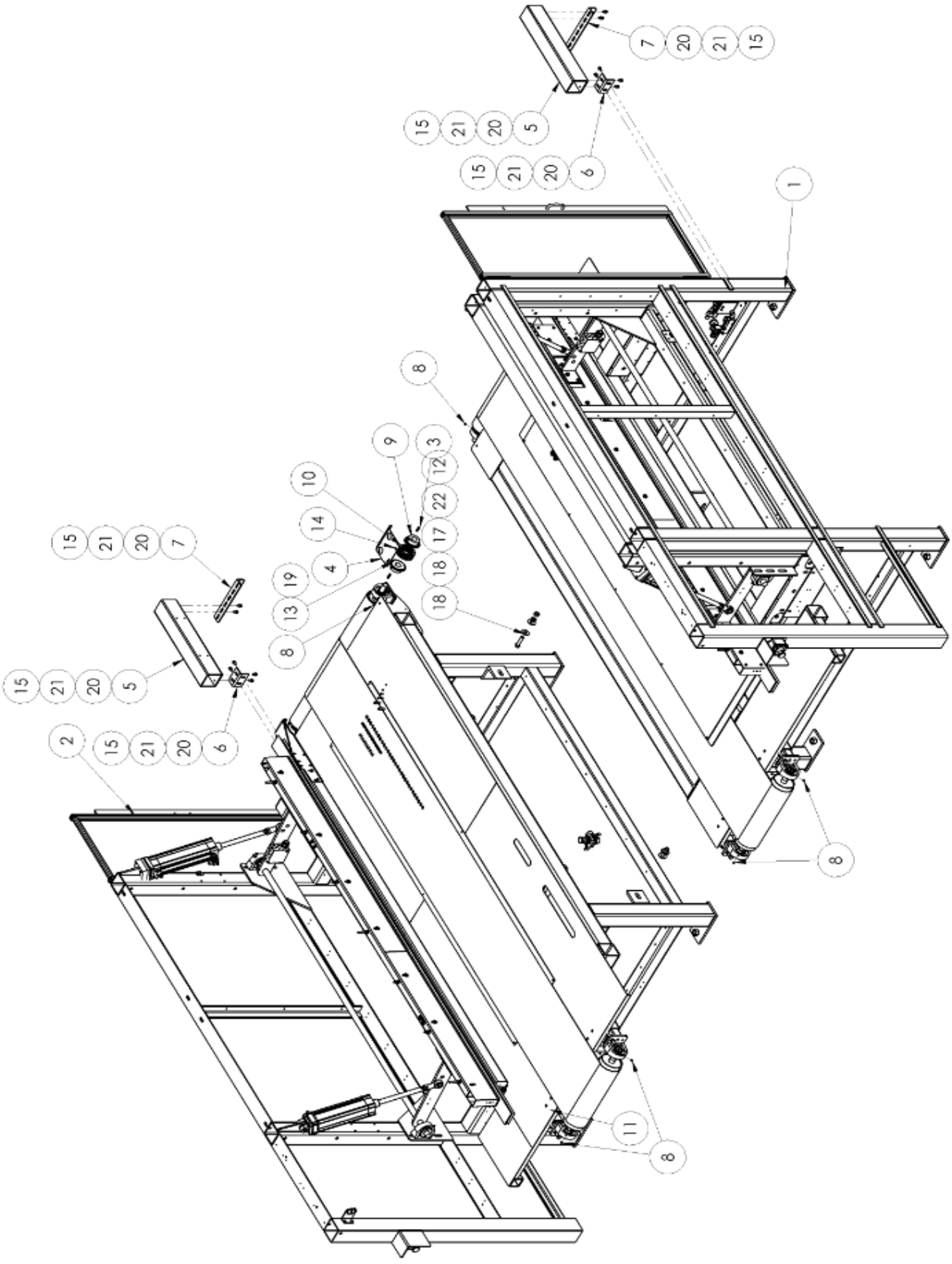
AAC Drawing Number 13901331 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	0411-3708	NUT PLATE,BOX MOUNT
2	1	13901328	MOUNT, HMI, PC DISPLAY
3	1	13901329	MOUNT, TOUCH SCREEN
4	1	4082105	TOUCHSCREEN. 10", SUB ASSEMBLY
5	1	4082105B	HMI BACKING PLATE, EEE10TSM
6	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
7	2	SSHC01040	1/4-20 X 5/8 HHCS
8	1	SSSC01064	1/4-20 X 1 SOC CAP
9	4	SSSCM3X16	M3-0.5X16 ,SOCKET CAP
10	1	TTH32425	HANDLE,THRDED,5/16-18X3/4
11	4	WWFM3	FLAT WASHER, M3
12	4	WWFS1/4	WASHER,FLAT,SAE,1/4
13	1	WWFS5/16	WASHER,FLAT,SAE,5/16
14	2	WWL1/4	WASHER,LOCK, 1/4
15	4	WWLM3	WASHER, LOCK, M3

13901390 Exit Assembly

AAC Drawing Number 13901390 Rev 0



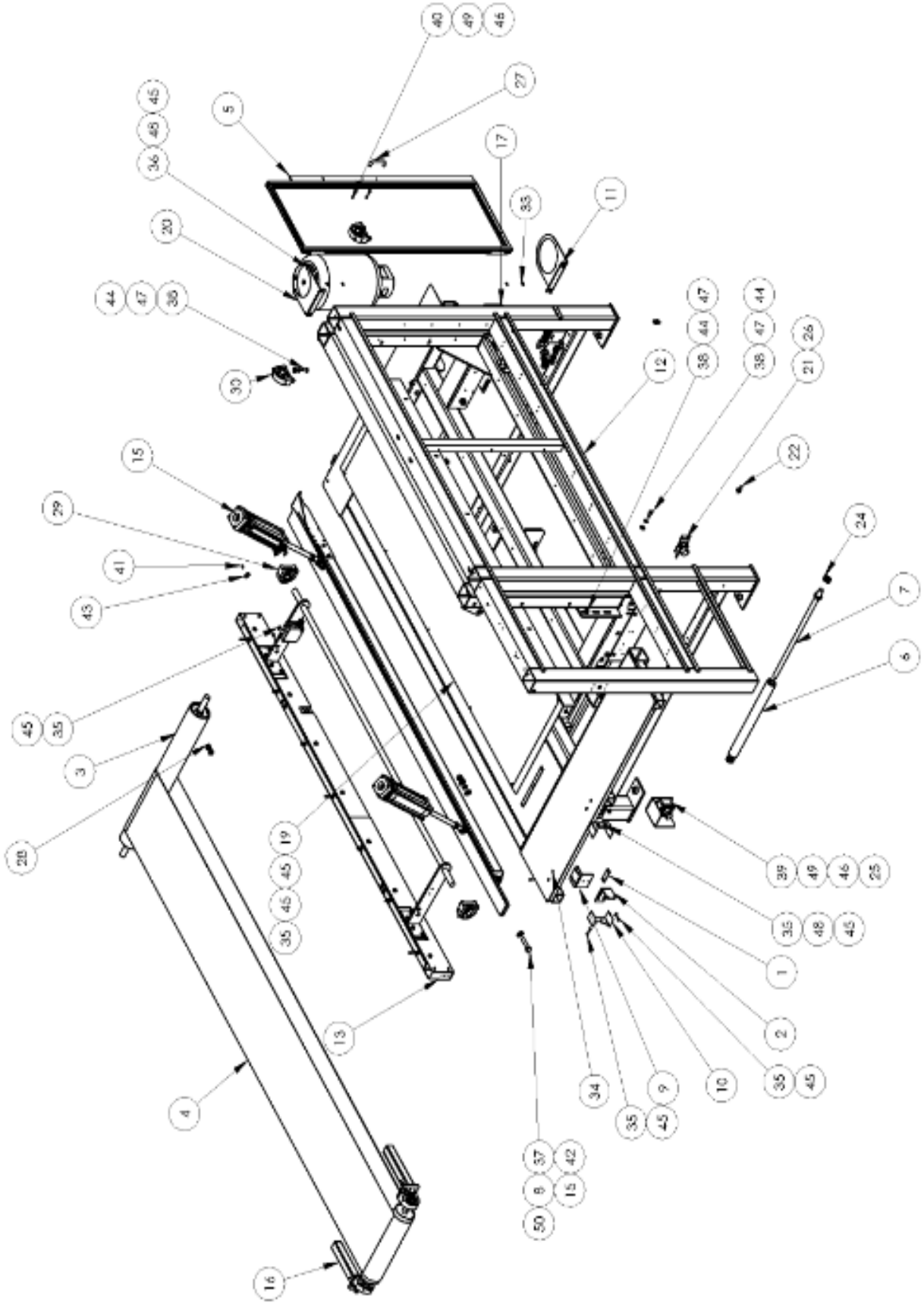
13901390 parts list

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	13901391	SIDE SEALER, LEFT
2	1	13901392	SIDE SEALER, RIGHT
3	2	1390160	KEY, 1/4 X 1.25L
4	1	1390225	GUARD, COUPLING
5	2	1390382	TUBE,F,4X4X.25WX23.50L,D
6	2	1390384	PLATE, MOUNTING
7	2	1390789	SUPPORT, FRAME JOINER
8	6	MM2421K31	GREASE FITTING, FLUSH-STYLE
9	2	MM6407K43	SPROCKET, 5/8P, 16T
10	1	MM6407K53	CHAIN, #50-2, 16LINKS
11	*2	MMT9945	TAPE,REFLECTIVE,2" WIDE

ITEM	QTY	PART NUMBER	DESCRIPTION
12	2	NNH5/8-11	NUT,HEX,5/8-11
13	2	NNK10-32	KEP NUT, 10-32
14	2	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
15	12	SSHC10048	5/16-18 X 3/4 HHCS
16	1	SSHC10080	HEX HEAD, 5/16-18 X 1-1/4
17	2	SSHC41160	5/8-11X2-1/2 HEX CAP
18	4	WWF5/8	WASHER,FLAT,5/8
19	2	WWFS10	WASHER, FLAT, #10, SAE
20	12	WWFS5/16	WASHER,FLAT,SAE,5/16
21	12	WWL5/16	WASHER,LOCK, 5/16
22	2	WWL5/8	WASHER,LOCK 5/8

13901391 Left Side Exit Sealer

AAC Drawing Number 13901391 Rev 0



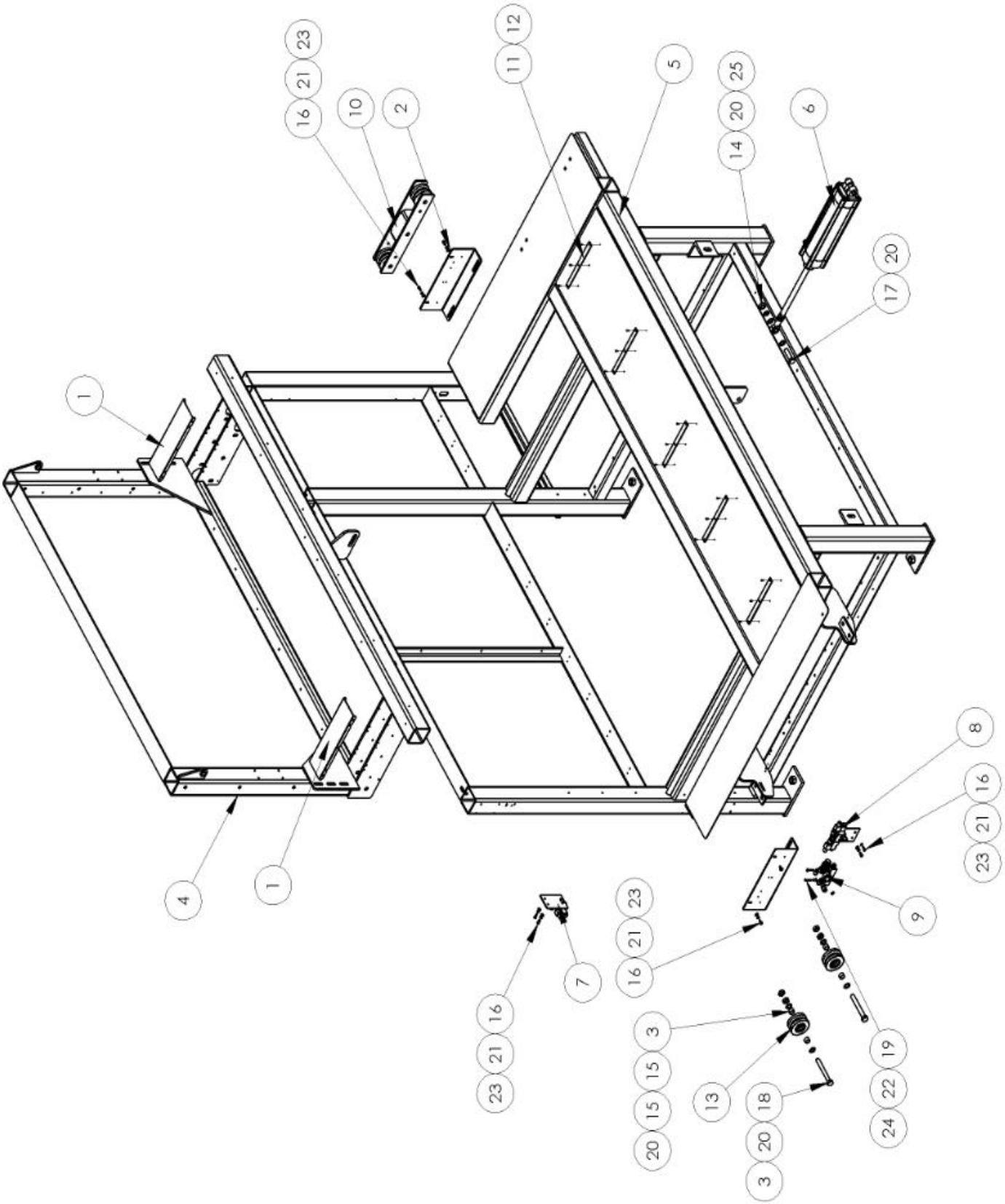
13901391 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	1349293	PLATE,NUT 1/4-20,2.50 CTC
2	2	1390162	GUARD,BRACKET
3	1	1390229	DRIVE-ROLLER REAR CONV.
4	1	1390255	BELT, OUTPUT CONV, 18" W
5	1	1390256	DOOR FRAME, LEFT
6	2	1390277	ASSY, ROLLER, SUPPORT
7	2	1390278	SHAFT, BELT-SUPPORT, LONG
8	4	1390427	WASHER, S/S, .755ID X 1-1/2OD
9	2	1390607	GUARD,BRACKET
10	2	1390694	GUARD, REAR ROLLER
11	1	1390696	TOP PLATE, AIR TANK
12	1	1391021	EXIT FRAME ASSY, LEFTSIDE
13	1	1391025	ASSY, SEALBAR, LEFT
14	1	1391034	E-STOP GUARD-LH
15	1	1391043	RAISED SEAL BAR OPTION
16	1	1391061	IDLER ROLLER ASSY
17	1	1391157	DOOR SENSOR MTG BRKT.
18	1	1391176	MTG BRKT, SIX MODULE STAT
19	1	1391902	BED-PLATE ASSY
20	1	1394521	AIR TANK ASSY.
21	1	1396746	MOUNT, LINEAR TRANSDUCER
22	1	AAQUT-4-4	QUICK UNION T 1/4X1/4
23	1	AAQUY-5-4	Y UNION, 5/32X1/4
24	8	CCCL16F	COLLAR,1" CLAMP TYPE
25	1	EEPTS25302G	ENCLOSURE W/ BUTTON, E-STOP

ITEM	QTY.	PART NUMBER	DESCRIPTION
26	1	EESP150-3	LINEAR, XDUCER (STRING POT) 50" RNGE
27	1	MM1897A24	HANDLE,DOOR,PULL,OVAL,5/8
28	3	MM9307K63	GROMMET,1/2ID,13/16 HOLE
29	2	MMGRPA207-20	1.25" BEARING, GRIP-IT
30	2	MMUCPA207-20	1.25" BEARING
31	1	NNH1/2-13	NUT,HEX,1/2-13
32	2	NNH3/4-10	NUT,HEX,3/4-10
33	4	SSBC01032	1/4-20 X 1/2 BUT CAP SC
34	4	SSFC01048	1/4-20 X 3/4 FLAT CAP
35	18	SSHC01048	1/4-20 X 3/4 HEX CAP
36	10	SSHC01064	1/4-20 X 1 HHCS
37	2	SSHC34192	3/4-10 X 3 HEX CAP
38	8	SSHC45080	1/2-13X1-1/4 HEX CAP
39	4	SSHC98048	SCREW, HEX CAP #10-32X.75
40	2	SSPS98040	10-32X5/8 PAN HD SLOT
41	2	SSZS93032	SCREW, SHT.METAL 10 ZIP
42	2	WWF3/4	WASHER,FLAT,3/4
43	2	WWFE016	WASHER,FENDER,LARGE,1/4
44	8	WWFS1/2	WASHER,FLAT,1/2, SAE
45	28	WWFS1/4	WASHER,FLAT,SAE,1/4
46	6	WWFS10	WASHER, FLAT, #10, SAE
47	8	WWL1/2	1/2 LOCK WASHER
48	28	WWL1/4	WASHER,LOCK, 1/4
49	6	WWL10	WASHER,LOCK,#10
50	2	WWL3/4	3/4 LOCK WASHER

1391021 Exit Frame Assembly

AAC Drawing Number 1391021 Rev 8



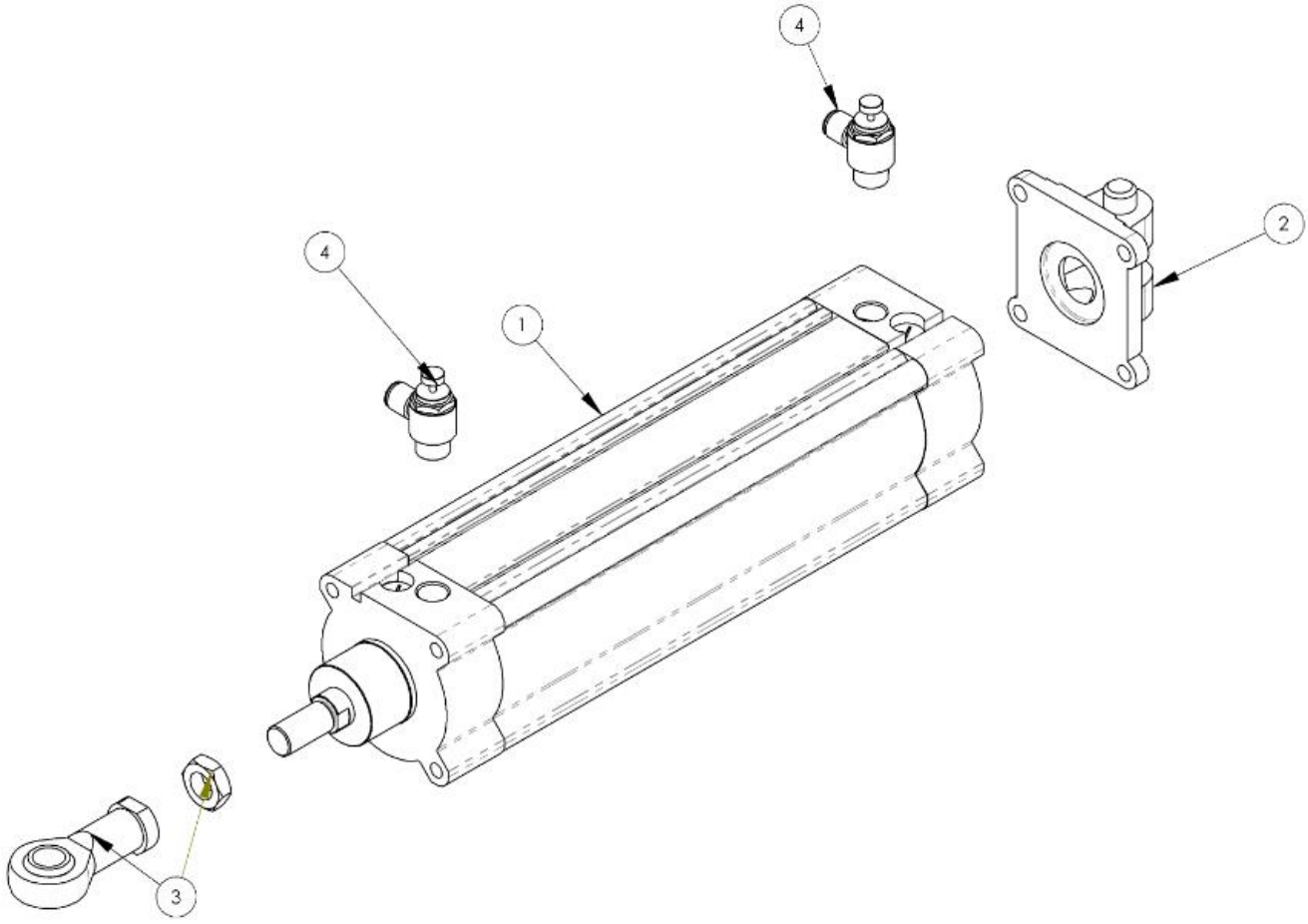
1391021 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	13901406	COVER, CASTER MOUNT, SIDE SEAL
2	2	1390237	ANGLE, KEEPER
3	4	1390251	SPACER, PUSHER-CARRIAGE
4	1	1391020	WLDMNT, LEFT SIDE SEAL
5	1	1391022	WELDMENT,EXIT SUBFRAME,LT
6	1	1391036	CYLINDER ASSY, LH FRAME S
7	1	1391038	VALVE ASSY, L SIDE SEAL
8	1	1391039	VALVE ASSY, CARRIAGE
9	1	1391040	MANIFOLD ASSY, TABLE ADJ
10	1	1391771	ROLLER CARRIAGE ASBLY
11	5	1391907	SKID PLATE,UHMW
12	15	MM5X521	RIVET,POP,1/8D,.313-.375
13	2	MMVG04201-12	V-GROVE CASTER .75 X 4

ITEM	QTY.	PART NUMBER	DESCRIPTION
14	1	NNH3/4-10	NUT,HEX,3/4-10
15	4	NNJ3/4-10	3/4-10 JAM NUT
16	8	SSHC01048	1/4-20 X 3/4 HEX CAP
17	1	SSHC33176	3/4-16 X 2-3/4 HEX CAP
18	2	SSHC34384	3/4-10 X 6 HEX CAP
19	2	SSHC98096	#10-32 X 1-1/2 HEX CAP
20	7	WWFE3/4	WASHER,3/4 FENDER
21	8	WWFS1/4	WASHER,FLAT,SAE,1/4
22	2	WWFS10	WASHER, FLAT, #10, SAE
23	8	WWL1/4	WASHER,LOCK, 1/4
24	2	WWL10	WASHER,LOCK,#10
25	1	WWL3/4	3/4 LOCK WASHER

1391036 Cylinder Assembly, LH frame

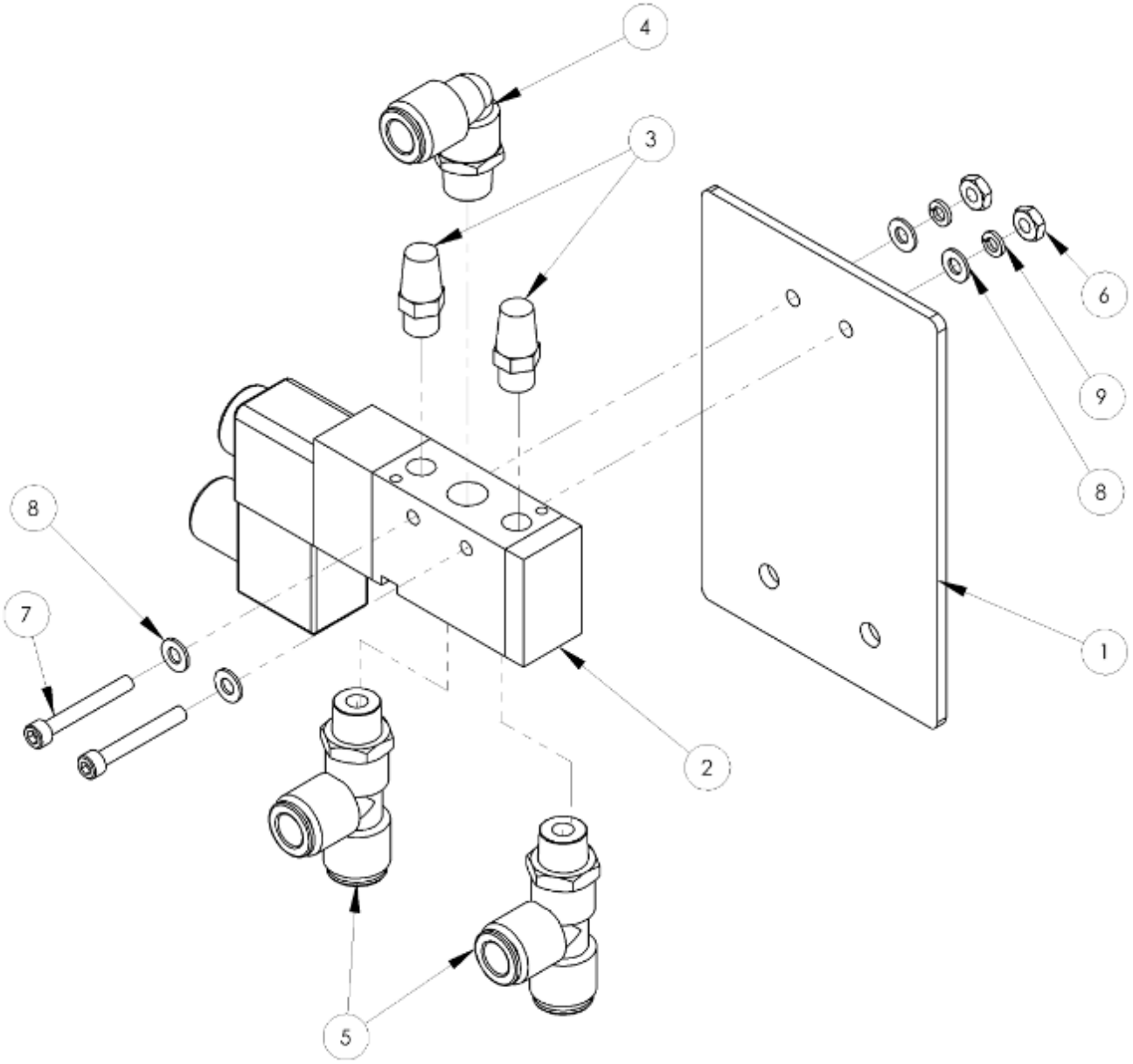
AAC Drawing Number 1391036 Rev 0



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	AACDNCB100320PP	CYLINDER,100MMB X 320MMS
2	1	AAFSNC100	REAR PIVOT BRKT, 100MM
3	1	AAFSGSM20x15	ROD END, FEM-20MM X 1.5MM
4	2	AA1984201FU0411	FLOW CONTROL, 1/2 UNIFIT

1391038 Valve Assembly, Left Side

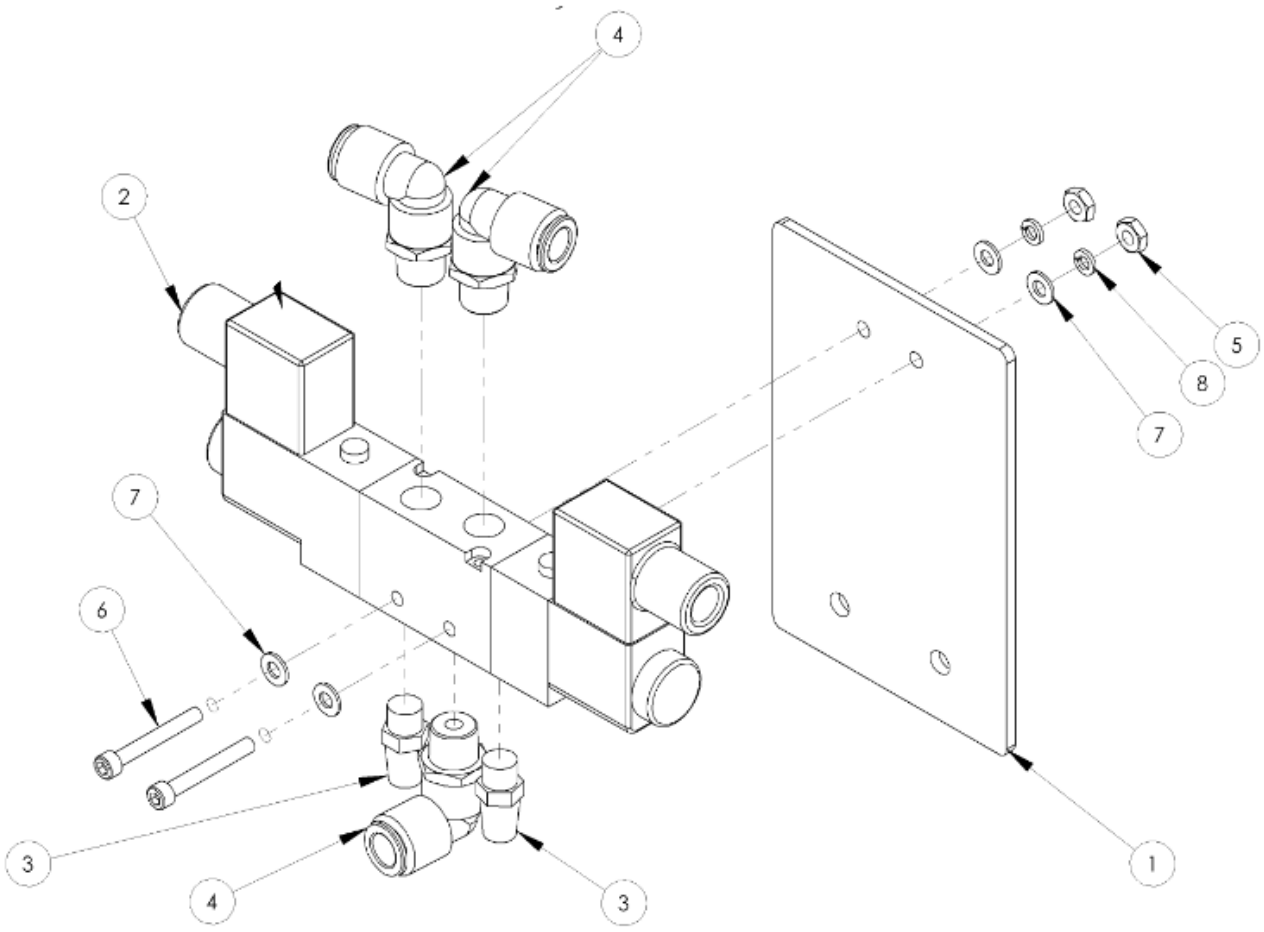
AAC Drawing Number 1391038 Rev



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1390351	VALVE MTG PLATE
2	1	AAE4V21008	VALVE, 1/4" PORTED, 24VDC
3	2	AAFP18	MUFFLER,1/8 NPT, BRONZ
4	1	AAQME-4-3S	FITTING,ELBOW,1/4NPT,3/8
5	2	AAQMT-4-3S	TEE,1/4NPT-3/8 TUBE
6	2	NNH8-32	NUT,HEX, 8-32 REG.
7	2	SSSC90080	#8-32 X 1-1/4 SOC CAP SC
8	4	WWF8	WASHER, FLAT, #8
9	2	WWL8	WASHER,LOCK,#8

1391039 Valve Assembly, Carriage

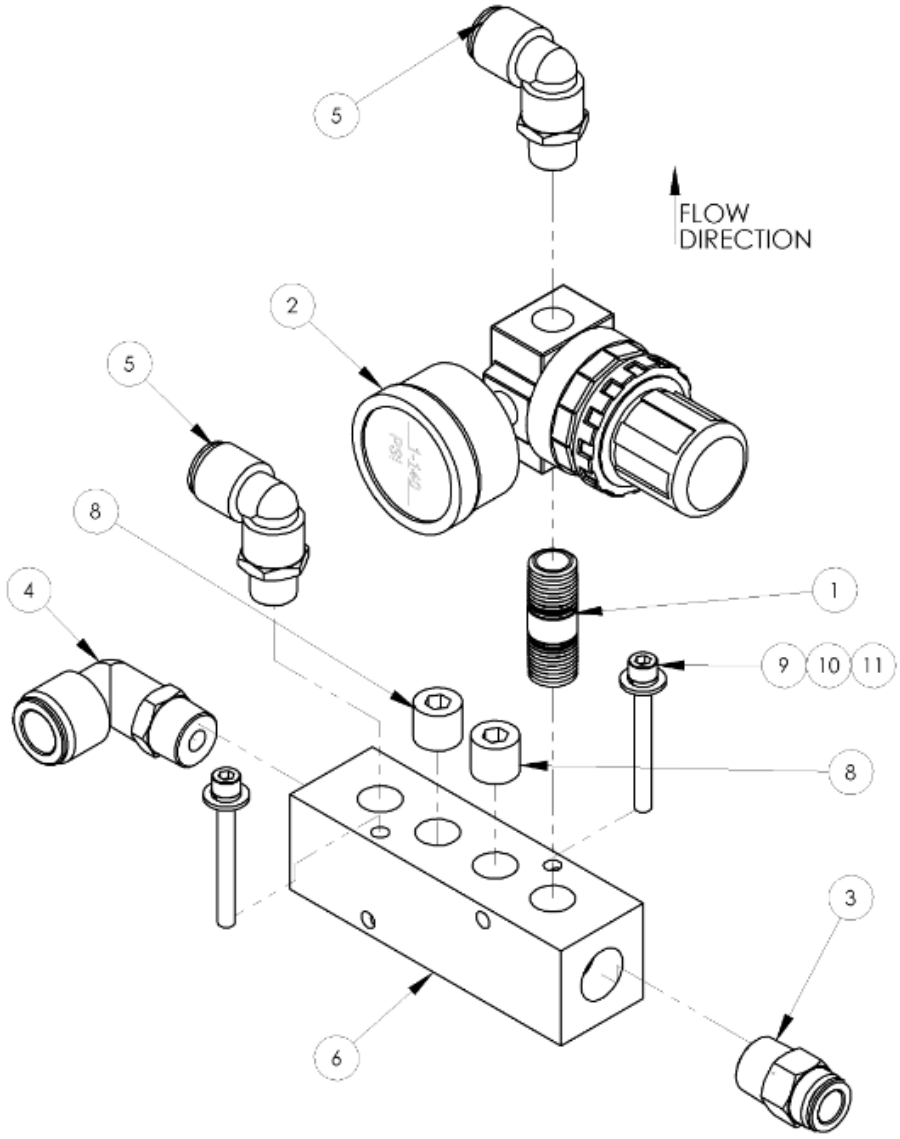
AAC Drawing Number 1391036 Rev



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1390351	VALVE MTG PLATE
2	1	AAE4V230C08	VALVE, 1/4",24VDC,CNTR BK
3	2	AAFP18	MUFFLER,1/8 NPT, BRONZ
4	3	AAQME-4-3S	FITTING,ELBOW ,1/4NPT,3/8
5	2	NNH8-32	NUT,HEX, 8-32 REG.
6	2	SSSC90080	#8-32 X 1-1/4 SOC CAP SC
7	4	WWF8	WASHER, FLAT, #8
8	2	WWL8	WASHER,LOCK,#8

1391040 Manifold Assembly, Table

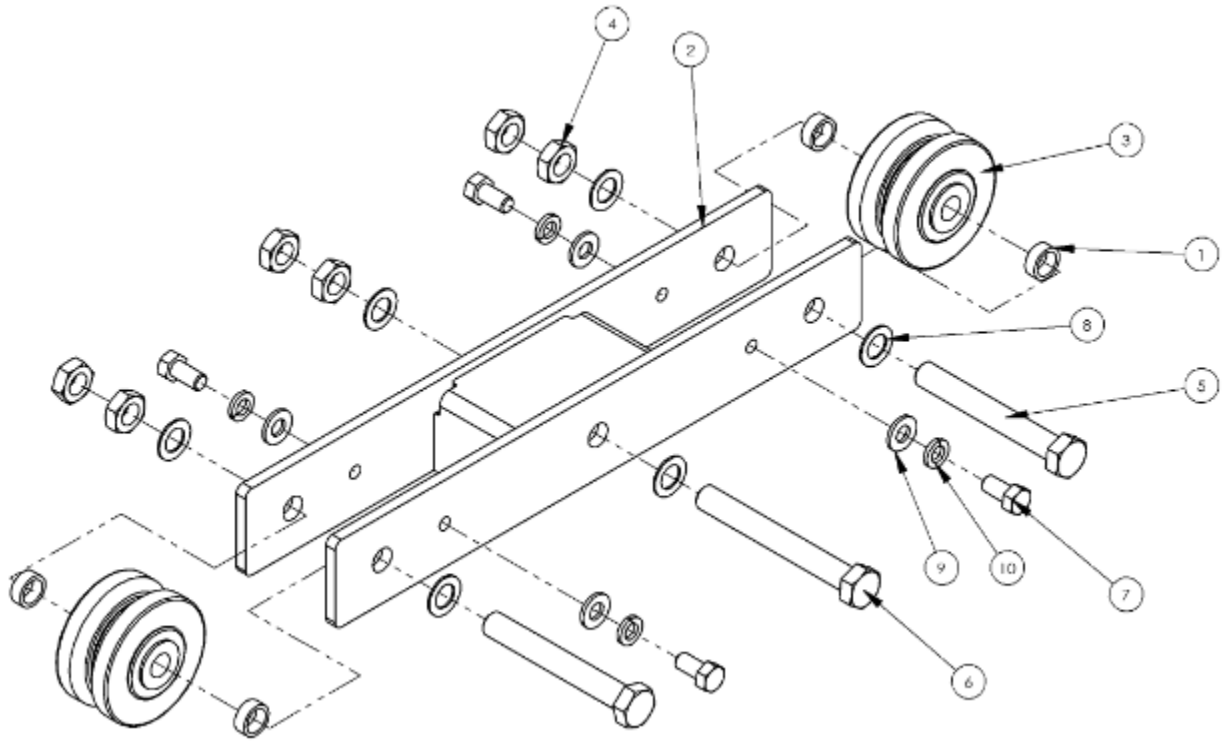
AAC Drawing Number 1391040 Rev



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	AAF4549K532	NIPPLE,1/4NPT X 1.5L
2	1	AAMSR20008	REGULATOR, 0-140 PSI RELIEVING, W/BRKT
3	1	AAQMC-3-3S	FITTING,STRT,3/8NPT,3/8
4	1	AAQME-3-2S	FITTING,ELBOW,3/8NPT,1/2
5	2	AAQME-4-3S	FITTING,ELBOW,1/4NPT,3/8
6	1	AAVM4A	MANIFOLD, 3/8(2) X 1/4(4)
7	2	EE6X750	TIE WRAP - Small.
8	2	MM4554K12	PLUG, 1/4" PIPE
9	2	SSSC98112	SCR, SOC CAP 10-32 X 1-3/4
10	2	WWFS10	WASHER, FLAT, #10, SAE
11	2	WWL10	WASHER,LOCK,#10

1391771 Roller carriage Assembly

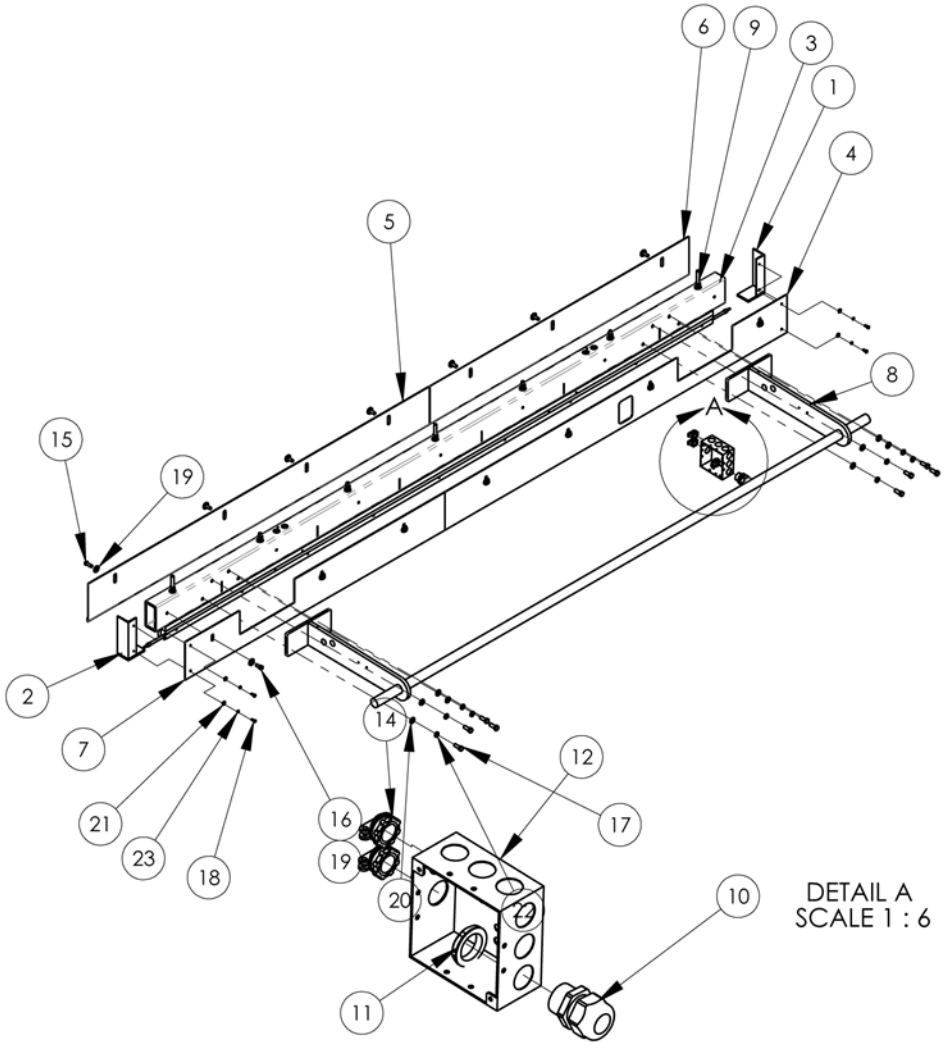
AAC Drawing Number 1391771 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	4	1391765	SPACER, ROLLER, 3/8
2	1	1391766	ROLLER CARRIAGE WELDMENT
3	2	MMVG04201-12	V-GROVE CASTER .75 X 4
4	6	NNJ3/4-10	3/4-10 JAM NUT
5	2	SSHC34352	3/4-10 X 5.5 HEX CAP
6	1	SSHC34384	3/4-10 X 6 HEX CAP
7	4	SSHC45064	1/2-13X1 HEX CAP
8	6	WWFE3/4	WASHER,3/4 FENDER
9	4	WWFS1/2	WASHER,FLAT,1/2, SAE
10	4	WWL1/2	1/2 LOCK WASHER

1391025 Left Seal Bar Assembly

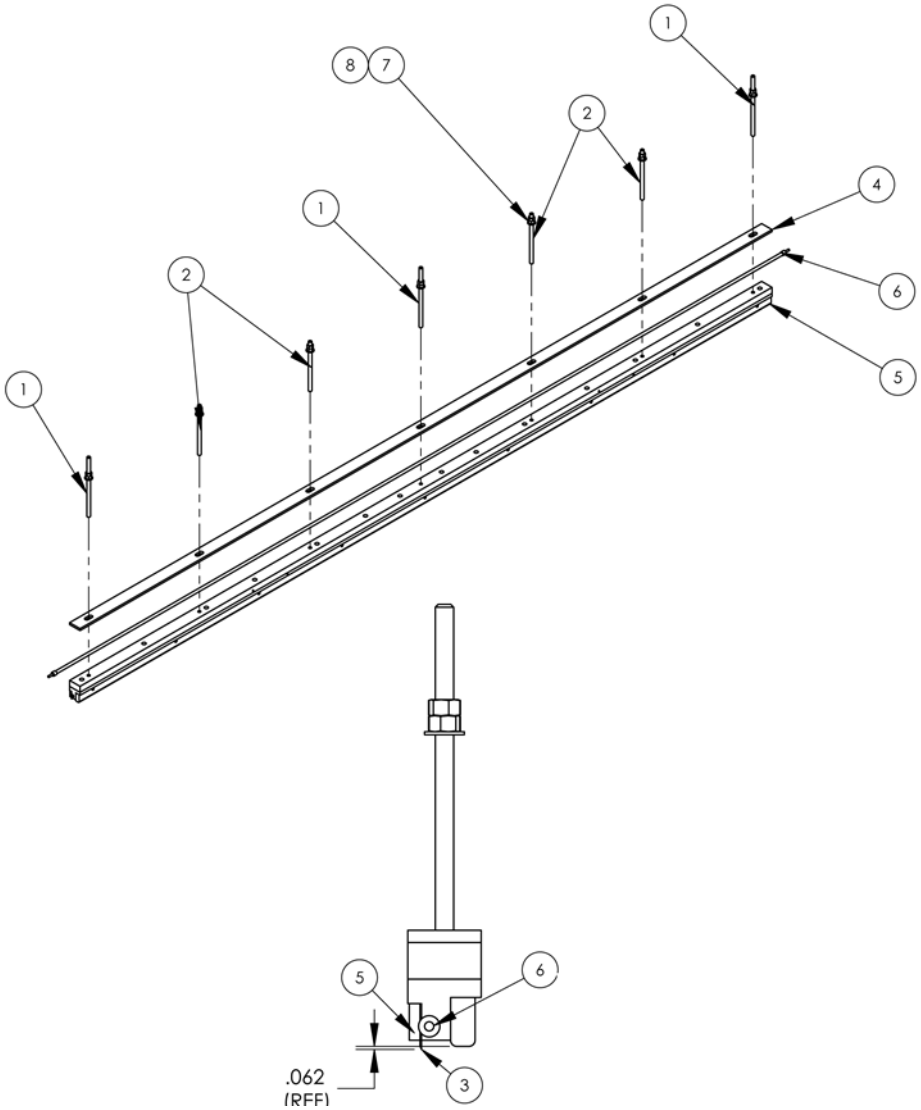
AAC Drawing Number 1391025 Rev 4



NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	1390130	END PLATE,RIGHT	13	1	K-234	COVER,4IN SQUARE
2	1	1390131	END PLATE,LEFT	14	2	K-235	CONNECTOR,ROMEX,1/2"
3	1	1390212	TUBE, SIDE SEAL	15	7	SSBC10064	5/16-18 X 5/8 L
4	1	1390336	SIDE SEAL CLAMP GUARD	16	7	SSHC10048	5/16-18 X 3/4 HHCS
5	1	1390853	SIDE SEAL CLAMP GUARD	17	8	SSHC25064	3/8-16 X 1,HEX CAP
6	1	1390855	SIDE SEAL CLAMP GUARD	18	4	SSHC95032	10-24 X .5, HEX CAP
7	1	1390960	SIDE SEAL CLAMP GUARD	19	14	WWF5/16	WASHER,FLAT,5/16
8	1	1391024	PIVOT ARM, HEAT BAR, LH	20	8	WWFS3/8	WASHER,FLAT,SAE,3/8
9	1	1406516	SEAL BAR ASSY, 100"	21	4	WWFS10	WASHER, FLAT, #10, SAE
10	1	FF3234	STRAIN RELIEF,3/4NPT	22	8	WWL3/8	WASHER,LOCK, 3/8
11	1	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK	23	4	WWL10	WASHER,LOCK,#10
12	1	K-233	BOX,ELECTRICAL,SQUARE				

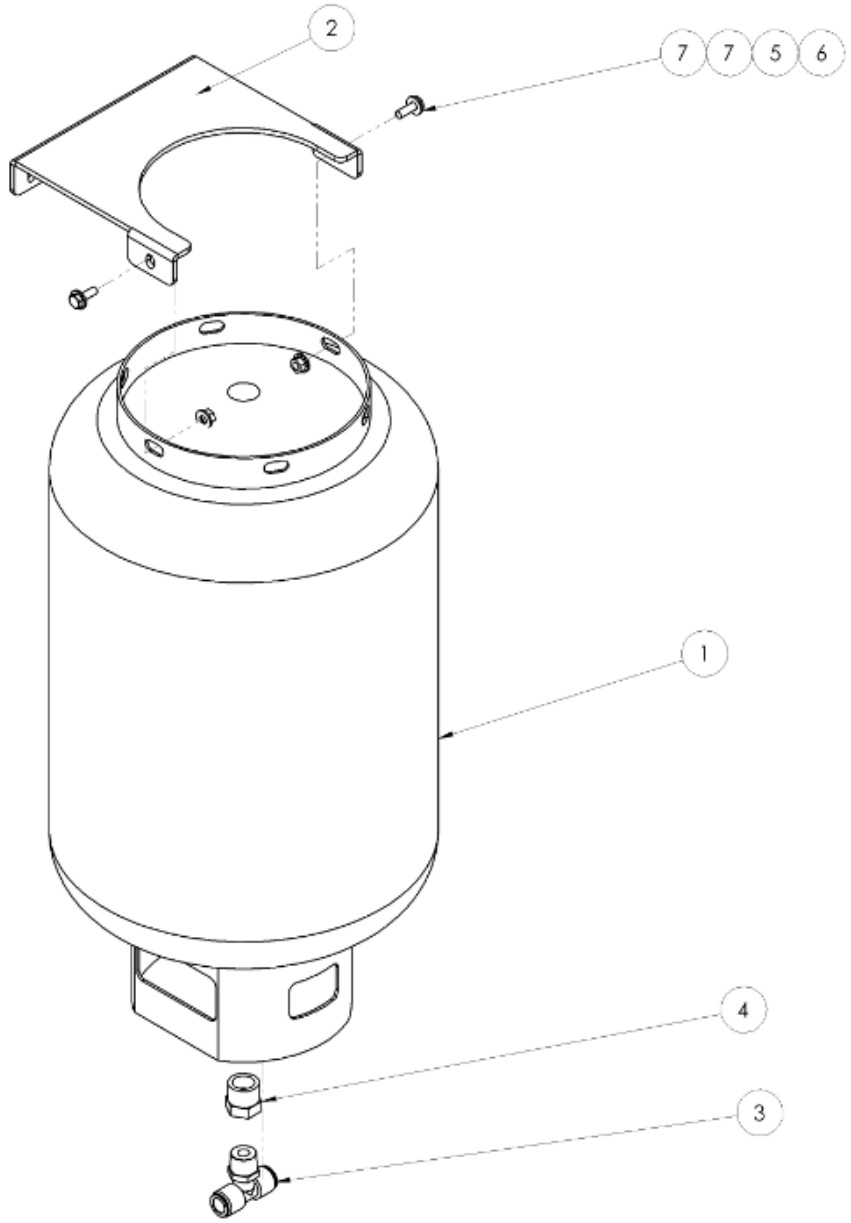
1406516 Seal Bar Assembly, 100”

AAC Drawing Number 1406516 Rev 1



NO	QTY	PART #	DESCRIPTION
1	3	1390385	THREADED ROD, 7.5"
2	4	1390386	THREADED ROD, 6.25"
3	1	1390438	CUT BLADE 100"
4	1	1396590	SPACER, PTFE
5	1	1406517	SEAL BAR ASSY, 100"
6	1	EERBN105A10A-2	HEAT ELEMENT,105L,.315D
7	14	NNH3/8-16	NUT,HEX,3/8-16
8	7	WWFS3/8	WASHER,FLAT,SAE,3/8

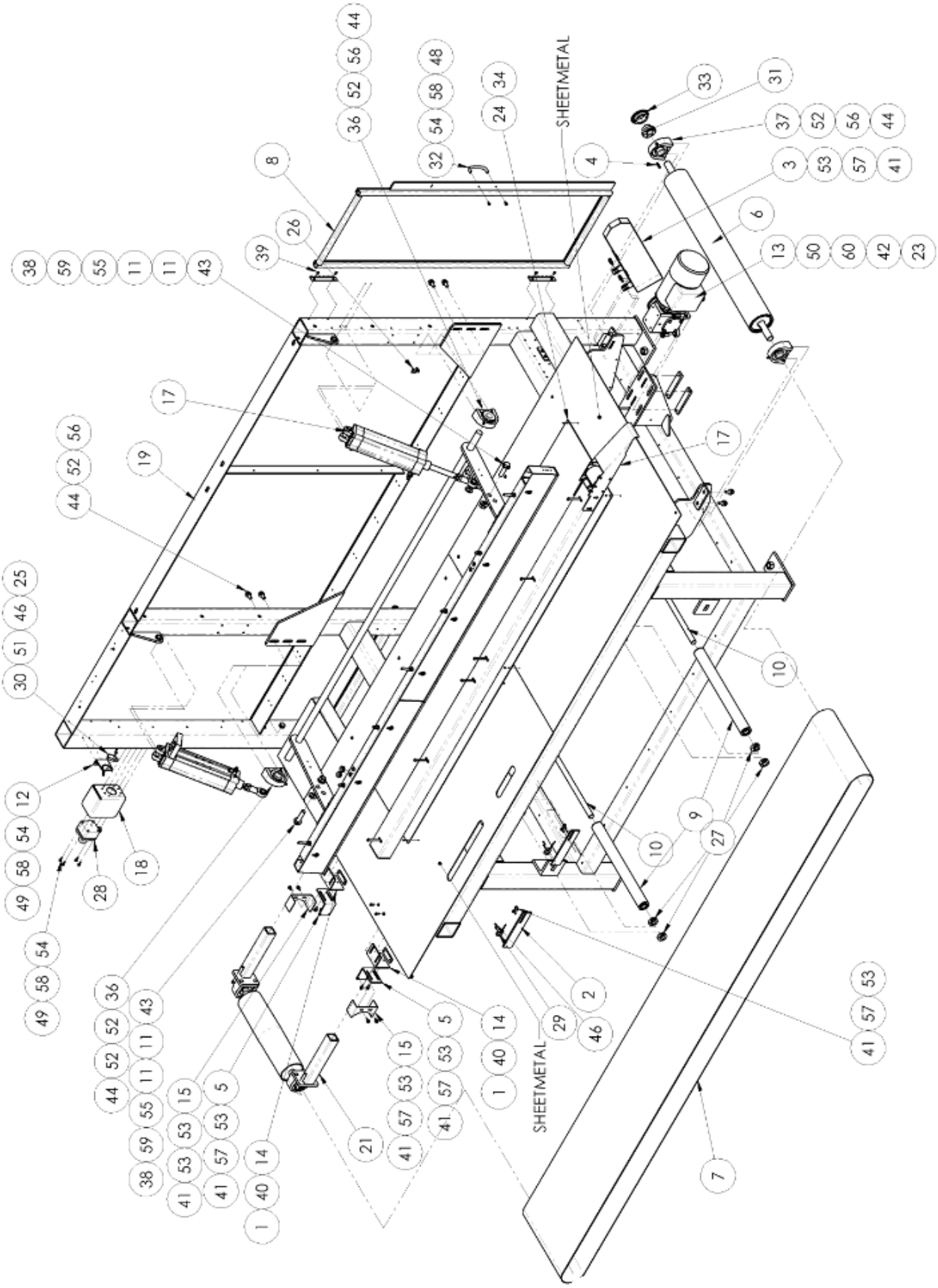
1394521 Air Tank Assembly
AAC Drawing Number 1394521 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	261007	AIR TANK ASSEMBLY
2	1	1394520	TOP PLATE, AIR TANK
3	1	AAQBT-2-2	QUICK BRANCH "T"
4	1	MM44605K24	HEX BUSHING, 3/4 X 1/2
5	2	NNK1/4-20	KEP NUT, 1/4-20
6	2	SSHC01048	1/4-20 X 3/4 HEX CAP
7	4	WWFS1/4	WASHER,FLAT,SAE,1/4

13901392 Right Side Exit Sealer

AAC Drawing Number 1391392 Rev 0



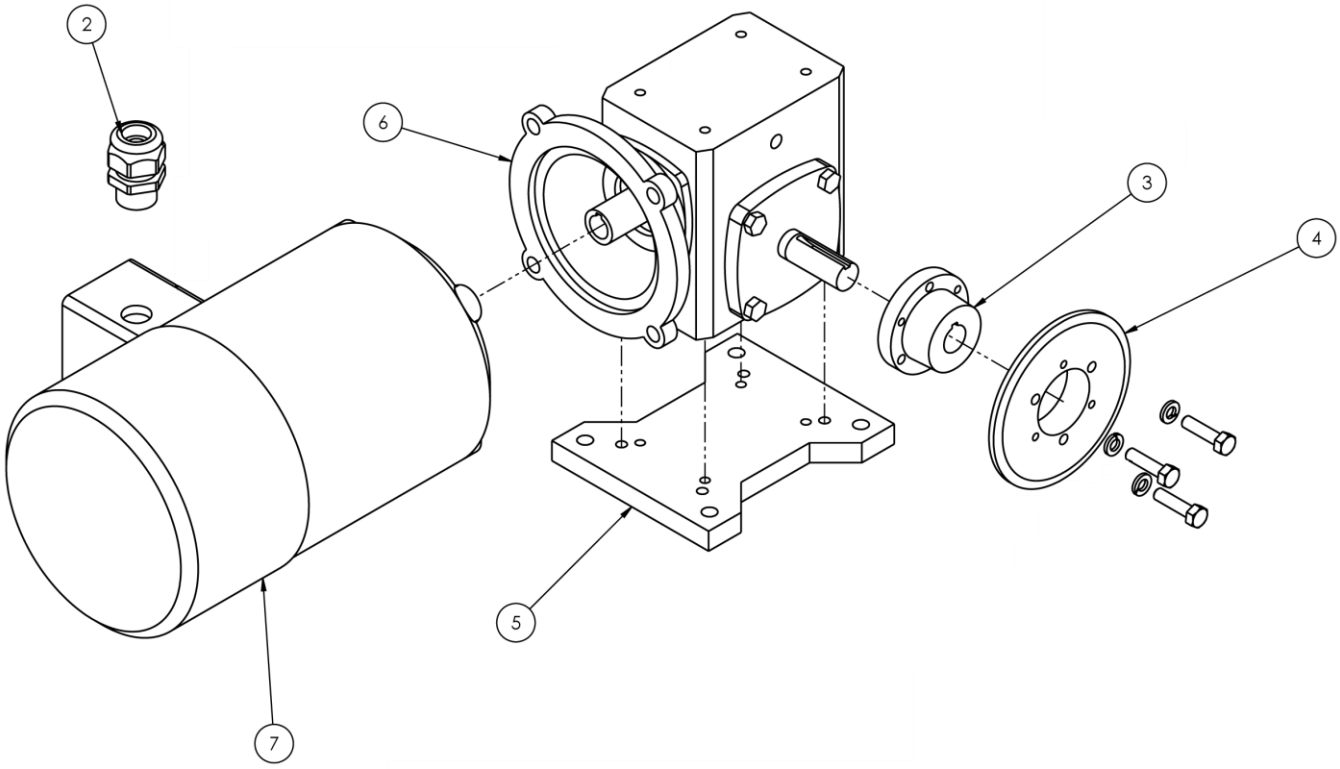
13901392 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	1349293	PLATE,NUT 1/4-20,2.50 CTC
2	2	13901319	BRACKET, SENSOR
3	1	1390153	BRACKET,GUARD
4	1	1390160	KEY, 1/4 X 1.25L
5	2	1390162	GUARD,BRACKET
6	1	1390229	DRIVE-ROLLER REAR CONV.
7	1	1390255	BELT, OUTPUT CONV, 18" W
8	1	1390273	DOOR FRAME, RIGHT
9	2	1390277	ASSY, ROLLER, SUPPORT
10	2	1390279	SHAFT, BELT-SUPPORT, LONG
11	4	1390427	WASHER, S/S, .755ID X 1-1/2OD
12	1	1390468	BRACKET, EYE MOUNT,LH
13	1	1390473	MOTOR/REDUCER ASSY
14	2	1390607	GUARD,BRACKET
15	2	1390694	GUARD, REAR ROLLER
16	1	1391038	VALVE ASSY, L SIDE SEAL
17	1	1391043	RAISED SEAL BAR OPTION
18	1	1391046	E-STOP GUARD-RH
19	1	1391047	WELDMENT,EXIT SUBFRAME,RT
20	1	1391052	ASSY, SEALBAR, RIGHT
21	1	1391061	IDLER ROLLER ASSY
22	2	1391176	MTG BRKT, SIX MODULE STAT
23	2	1391177	NUT PLATE, GEAR MOTOR MTG
24	1	1391183	PANEL, TOP RH STATIC UHMW
25	1	1975-412A	PLATE,NUT,4-40,.95CTC
26	1	AAQUY-5-4	Y UNION, 5/32X1/4
27	8	CCCL16F	COLLAR,1" CLAMP TYPE
28	1	EEPTS25302G	ENCLOSURE W/ BUTTON, E-STOP
29	2	FFQS18VN6AFF	SENSOR,PROXIMITY
30	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC

ITEM	QTY.	PART NUMBER	DESCRIPTION
31	1	MM11/4SH	HUB, TAPERLOCK
32	1	MM1897A24	HANDLE,DOOR,PULL,OVAL,5/8
33	1	MM40SH21H	SPROCKET, 1/2 P, 21T
34	6	MM5X521	RIVET,POP,1/8D,.313-.375
35	3	MM9307K63	GROMMET,1/2ID,13/16 HOLE
36	2	MMGRPA207-20	1.25" BEARING, GRIP-IT
37	2	MMUCPA207-20	1.25" BEARING
38	2	NNH3/4-10	NUT,HEX,3/4-10
39	4	SSBC01032	1/4-20 X 1/2 BUT CAP SC
40	4	SSFC01048	1/4-20 X 3/4 FLAT CAP
41	19	SSHC01048	1/4-20 X 3/4 HEX CAP
42	4	SSHC25096	3/8-16 X 1 1/2 HHCS
43	2	SSHC34176	3/4-10 X 2-3/4 HEX CAP
44	8	SSHC45080	1/2-13X1-1/4 HEX CAP
45	1	SSHC45256F	1/2-13X4 FULL THD HEX CAP
46	6	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
47	1	SSPS70064	4-40 X 1 PAN HD SLOTTED
48	2	SSPS98040	10-32X5/8 PAN HD SLOT
49	6	SSSC98048	10-32 X 3/4 SOC CAP
50	4	WWF3/8	WASHER,FLAT,3/8 OR 10MM
51	2	WWF4	WASHER, FLAT, #4
52	8	WWFS1/2	WASHER,FLAT,1/2, SAE
53	18	WWFS1/4	WASHER,FLAT,SAE,1/4
54	8	WWFS10	WASHER, FLAT, #10, SAE
55	2	WWFS3/4	WASHER, .797ID X 1-1/2OD
56	8	WWL1/2	1/2 LOCK WASHER
57	18	WWL1/4	WASHER,LOCK, 1/4
58	8	WWL10	WASHER,LOCK,#10
59	2	WWL3/4	3/4 LOCK WASHER
60	4	WWL3/8	WASHER,LOCK, 3/8

1390473 Motor Reducer Assembly

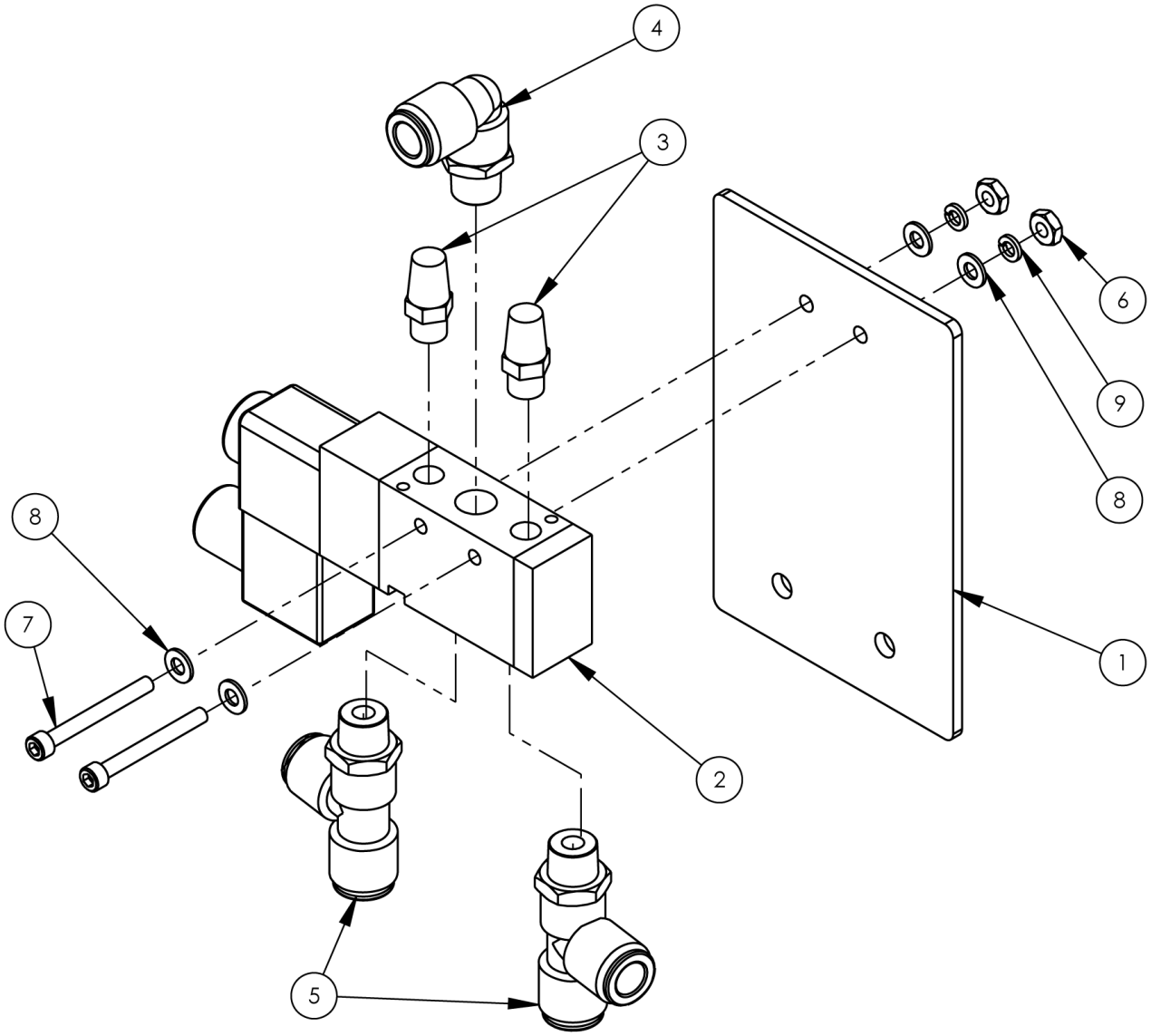
AAC Drawing Number 1390473 Rev 3



NO.	QTY	PART #	DESCRIPTION
1	AR	51494	LUBRICANT,MOBIL SHC634
2	1	FF3460	STRAIN RELIEF,LIQ TIGHT
3	1	MM3/4SH	HUB, TAPERLOCK
4	1	MM40SH28H	SPROCKET, 1/2 P, 28T
5	1	MM56438	HORIZONTAL BASE,CI U
6	1	MMF71520B5J	SPEED REDUCER,WORM,
7	1	MMVM3542	3/4 1800 TEFC 208/460

1391038 Left Side Valve Assembly

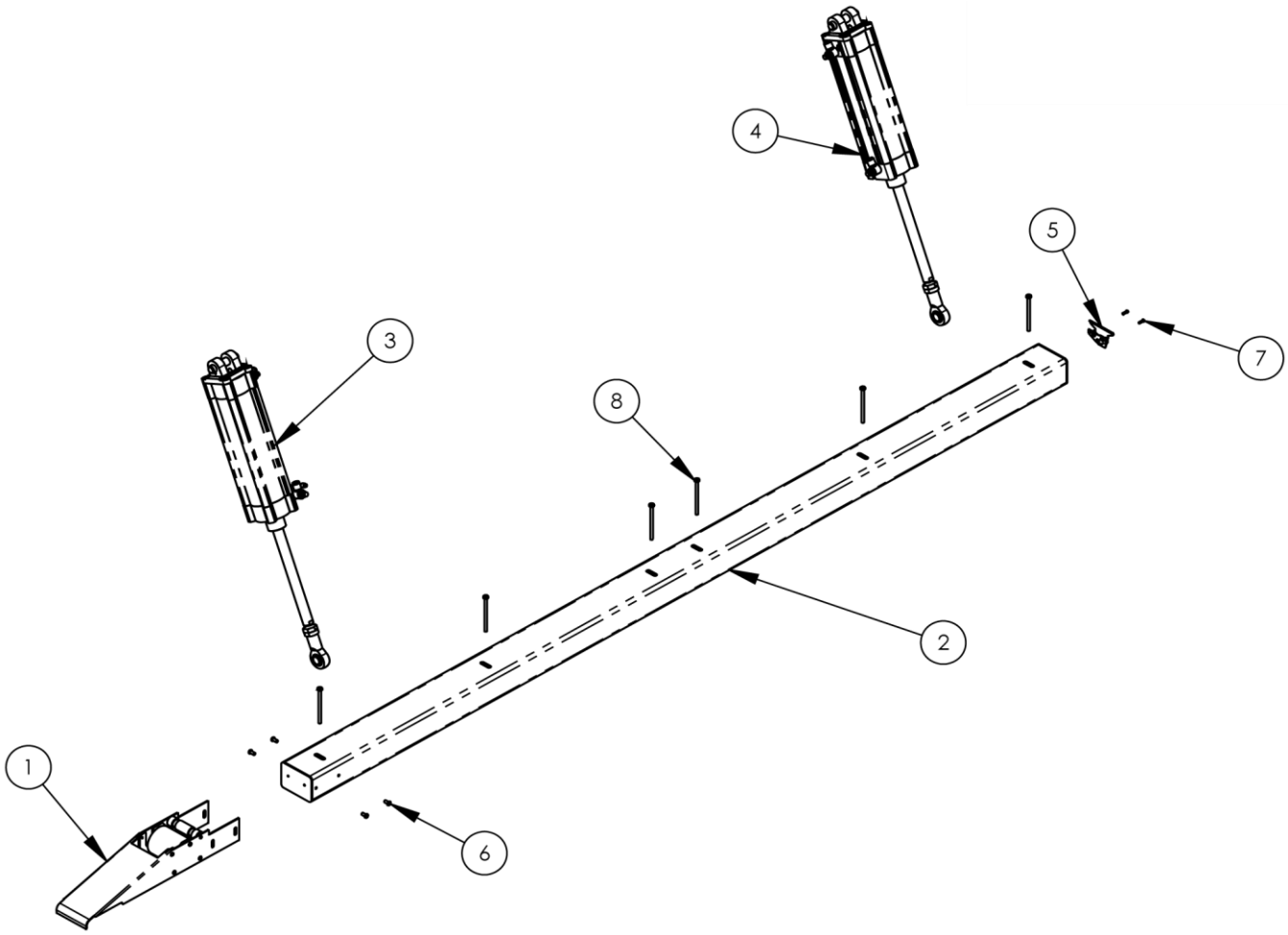
AAC Drawing Number 1391038 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	1	1390351	VALVE MTG PLATE
2	1	AAE4V21008	VALVE, 1/4" PORTED, 24VDC
3	2	AAFP18	MUFFLER,1/8 NPT, BRONZ
4	1	AAQME-4-3S	FITTING,ELBOW,1/4NPT,3/8
5	2	AAQMT-4-3S	TEE,1/4NPT-3/8 TUBE
6	2	NNH8-32	HEX-NUT 8-32 REG.
7	2	SSSC90096	#8-32 X 1-1/2 SOC CAP SC
8	4	WWF8	WASHER, FLAT, #8
9	2	WWL8	WASHER,LOCK,#8

1391043 Raised Seal Bar Option

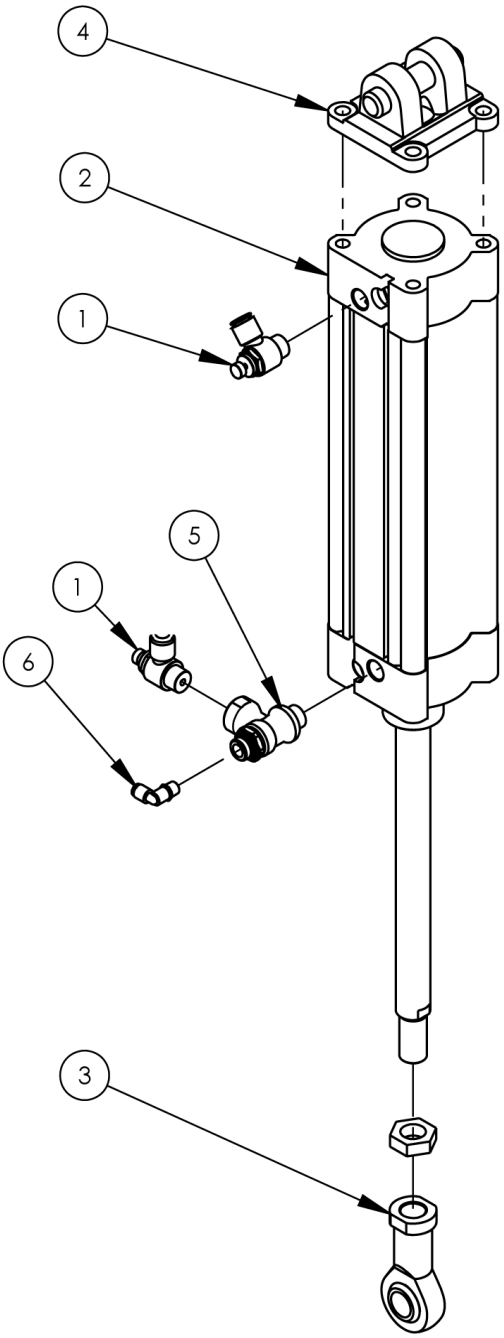
AAC Drawing Number 1391043 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	1	1390514	TAPE DISPENSER
2	1	1390530	TEMP HEAT PAD RISER
3	1	1391033	CYLINDER ASSY-SEAL BAR
4	1	1391037	CYLINDER ASSY-SEAL BAR
5	1	MM1268T63	SPRING CLIP, STEEL, 3"
6	4	SSBC01032	1/4-20 X 1/2 BUT CAP SC
7	2	SSHC90032	#8-32 X 1/2 HEX CAP
8	6	SSPS01256	1/4-20 X 2-1/4 PAN HD SLOT

1391033 Seal Bar Cylinder Assembly

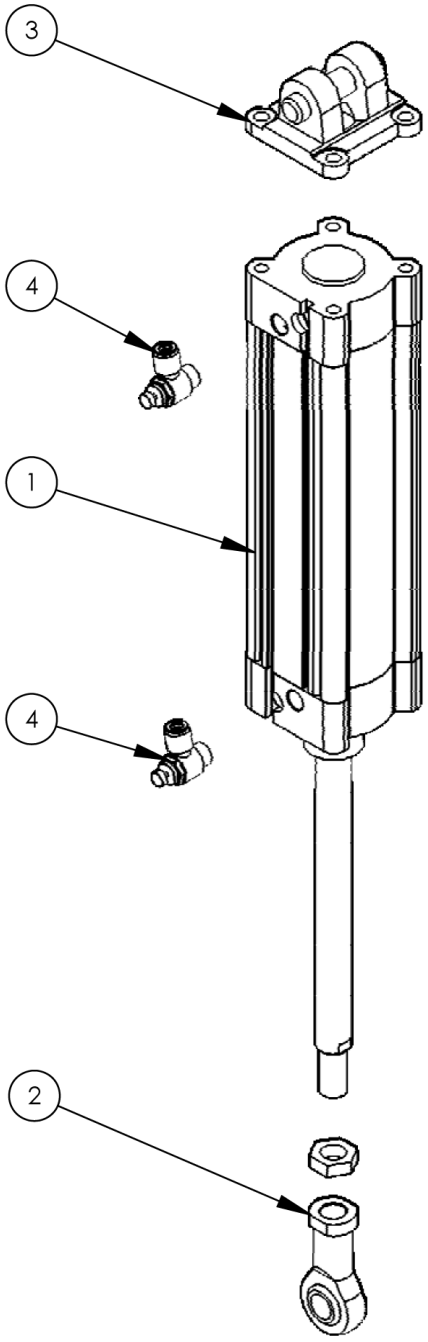
AAC Drawing Number 1391033 Rev 2



NO.	QTY	PART #	DESCRIPTION
1	2	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8
2	1	AACDNCB80250PPV	CYLINDER, 80MM X 250MM
3	1	AAFSGSM20x15	ROD END, FEM-20MM X 1.5MM
4	1	AAFSNC80	REAR PIVOT
5	1	AAV78861717	VALVE, BLOCKING, R3/8
6	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT

1391037 Seal Bar Cylinder Assembly

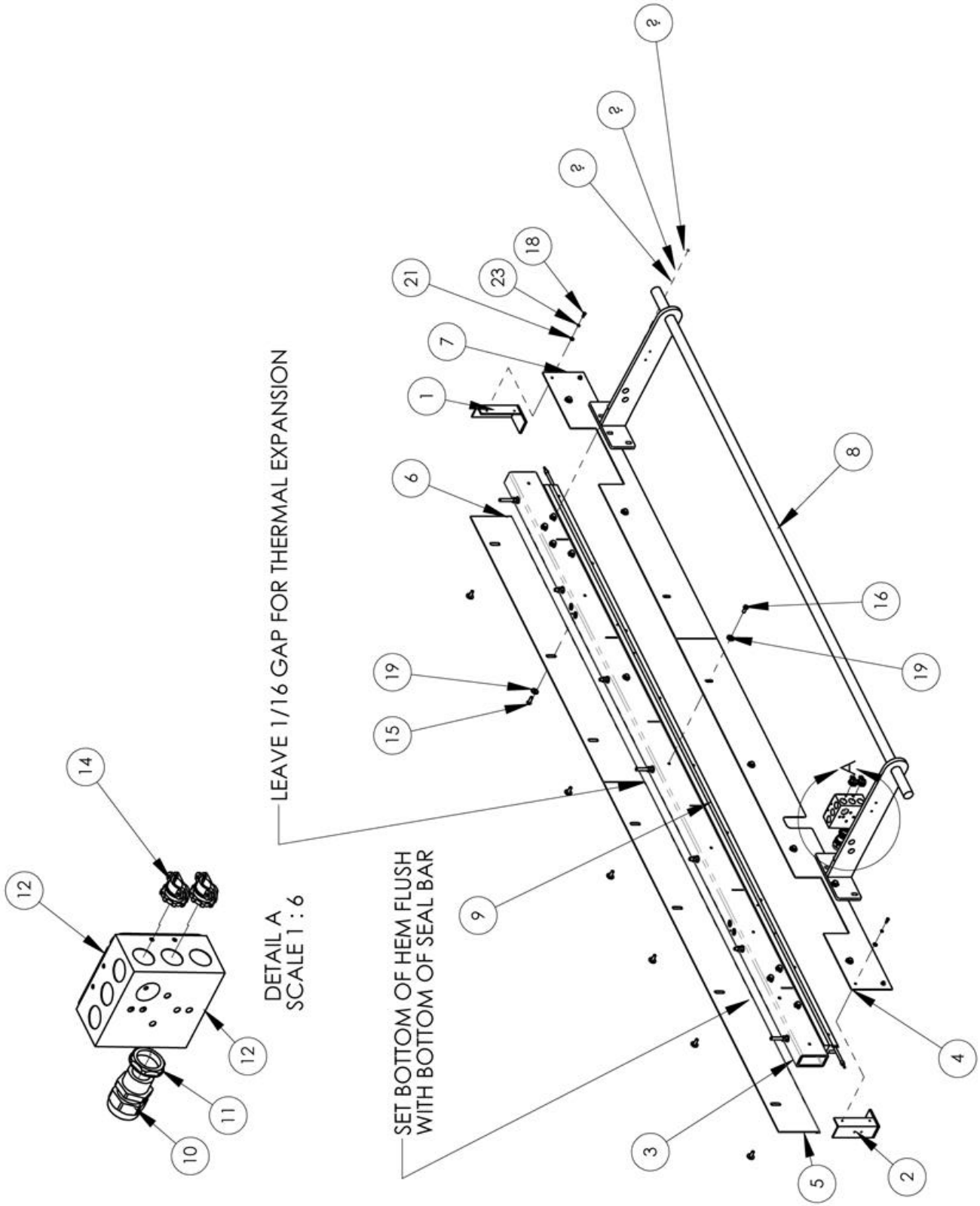
AAC Drawing Number 1391037 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	1	AACDNCB80250PPV	CYLINDER, 80MM X 250MM
2	1	AAFSGSM20x15	ROD END, FEM-20MM X 1.5MM
3	1	AAFSNC80	REAR PIVOT
4	2	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8

1391052 Right Seal Bar Assembly

AAC Drawing Number 1391052 Rev 5

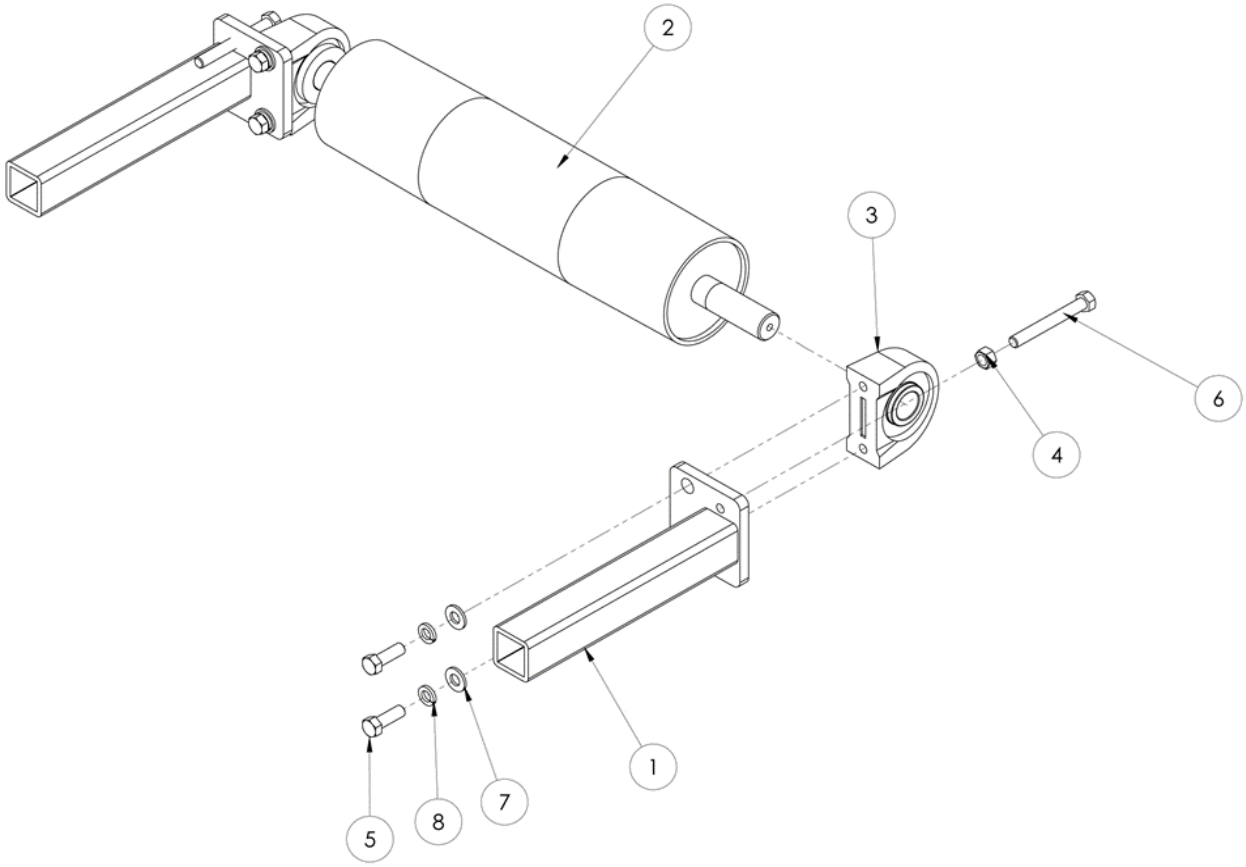


1391052 parts list

NO	QTY	PART #	DESCRIPTION
1	1	1390130	END PLATE,RIGHT
2	1	1390131	END PLATE,LEFT
3	1	1390212	TUBE, SIDE SEAL
4	1	1390336	SIDE SEAL CLAMP GUARD
5	1	1390853	SIDE SEAL CLAMP GUARD
6	1	1390855	SIDE SEAL CLAMP GUARD
7	1	1390960	SIDE SEAL CLAMP GUARD
8	1	1391051	SIDE SEAL ASSM
9	1	1406516	SEAL BAR ASSY, 100"
10	1	FF3234	STRAIN RELIEF,3/4NPT
11	1	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK
12	1	K-233	BOX,ELECTRICAL,SQUARE
13	1	K-234	COVER,4IN SQUARE
14	2	K-235	CONNECTOR,ROMEX,1/2"
15	7	SSBC10064	5/16-18 X 5/8 L
16	7	SSHC10048	5/16-18 X 3/4 HHCS
17	8	SSHC25064	3/8-16 X 1,HEX CAP
18	4	SSSC95032	10-24 X1/2, SOC CAP
19	14	WWF5/16	WASHER,FLAT,5/16
20	8	WWFS3/8	WASHER,FLAT,SAE,3/8
21	4	WWFS10	WASHER, FLAT, #10, SAE
22	8	WWL3/8	WASHER,LOCK, 3/8
23	4	WWL10	WASHER,LOCK,#10

1391061 Idler Roller Assembly

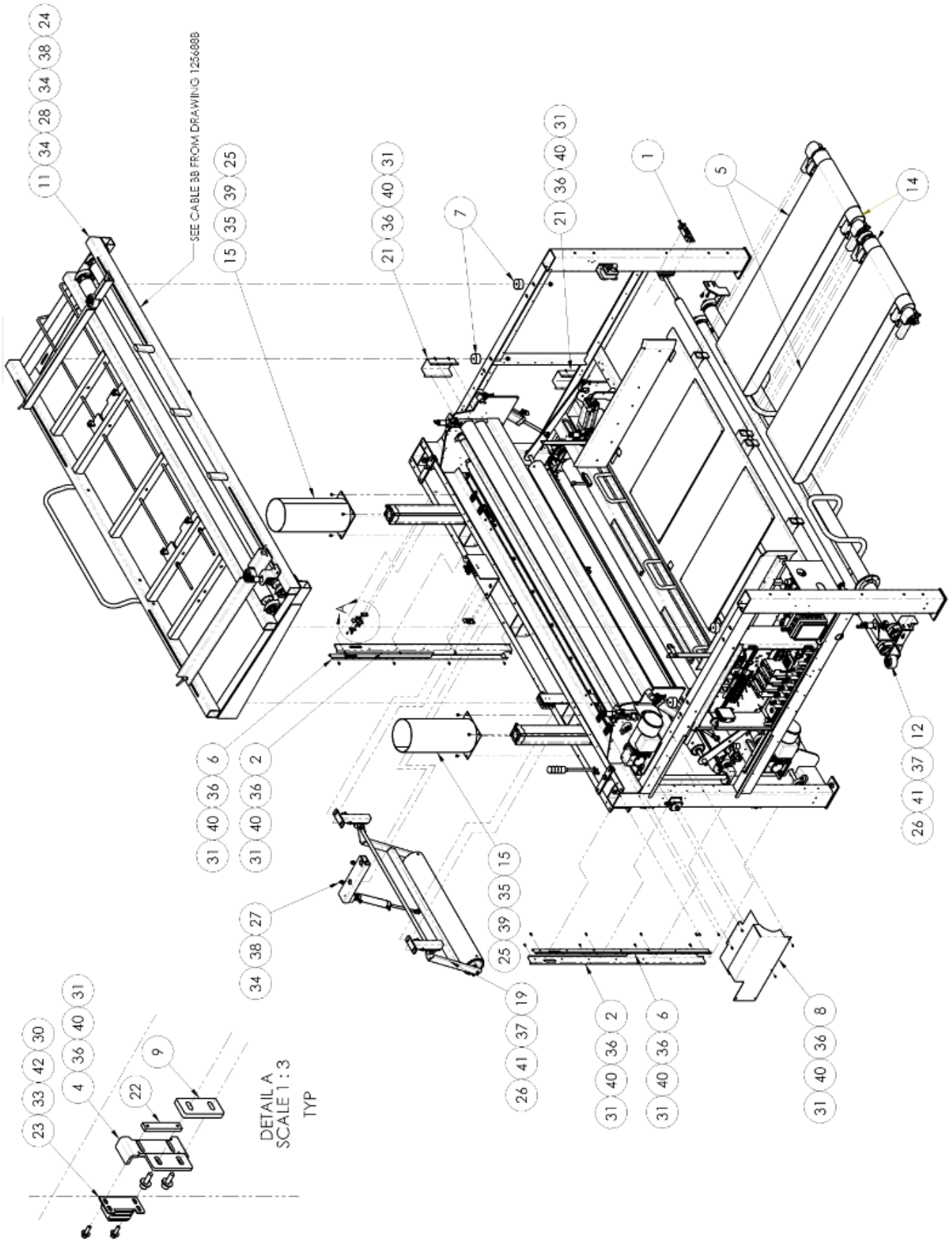
AAC Drawing Number 1391061 Rev 2



NO	QTY	PART #	DESCRIPTION
1	2	1390247	WELDMENT, BELT-TENSIONER
2	1	1390258	IDLER-ROLLER, REAR CONV.
3	2	MMGRPA207-20	1.25" BEARING, GRIP-IT
4	2	NNH1/2-13	NUT,HEX,1/2-13
5	4	SSHC45096	1/2-13X1-1/2 HEX CAP
6	2	SSHC45256F	1/2-13X4 FULL THD HEX CAP
7	4	WWFS1/2	WASHER,FLAT,SAE,1/2
8	4	WWL1/2	1/2 LOCK WASHER

13901279 Input Conveyor

AAC Drawing Number 13901279 Rev 1



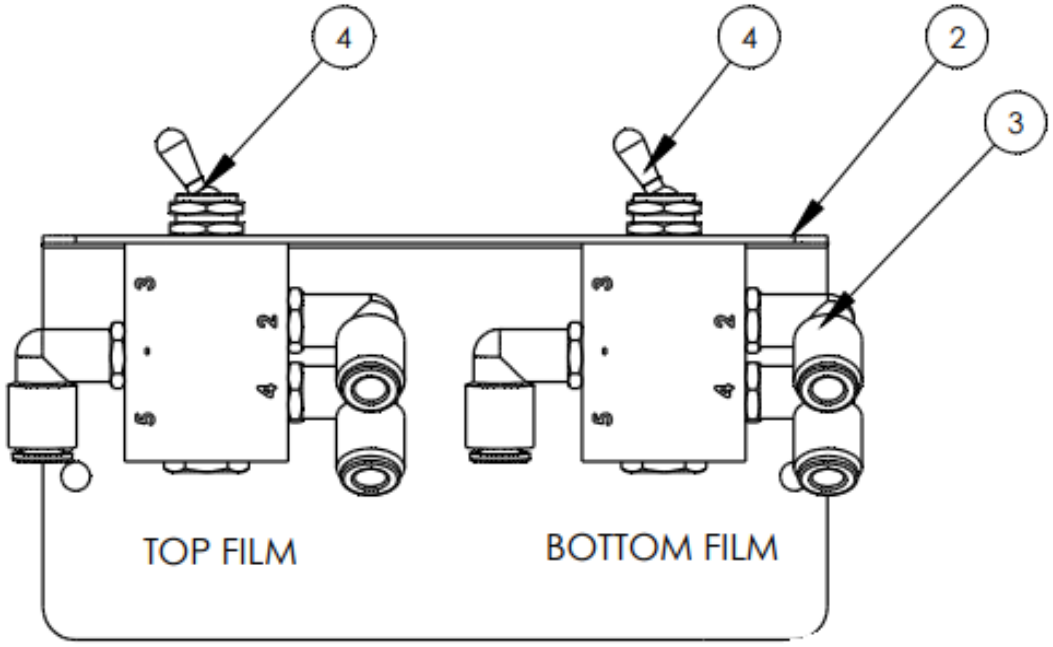
13901279 parts list

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	13061105	VALVE ASSY, DUAL 4-WAY MANUAL
2	2	1390067	GUARD, CHAIN, SEAL-BAR, R
3	1	13901280	INPUT CONVEYOR ASSY. #4
4	4	1390159	SPACER,LATCH,LEFT
5	2	1390286	BELT,CONVEYOR
6	2	1390394	GUARD, CHAIN, SEAL-BAR, R
7	4	1390617	TOP RACK SPACER
8	1	1390623	GUARD, CHAIN, UPR ROLLER
9	4	1390969	PLATE, SPACER, DOOR LATCH
10	1	1390B-PD3	DIAGRAM, PNEUMATIC,
11	1	1391054	ROLL HOLDER FRAME
12	1	1391056	LOWER ROLL FEED
13	1	1391057	ROLLER TAKEUP ASSY
14	1	1391057	ROLLER TAKEUP ASSY
15	2	1391091	GUARD, CYLINDER
16	1	1391178	GUARD, CHAIN, LWR ROLLER
17	1	1391179	GUARD, LOWER FILM GEAR BO
18	2	1391180	MTG BRKT, LOWER FILM MOTO
19	1	1391269	OUTFEED PRESSURE ROLLER
20	1	1391435	GUARD, CHAIN, UPR ROLLER
21	2	1391873	GUARD, ROLLER BEARINGS

ITEM	QTY	PART NUMBER	DESCRIPTION
22	4	1394286	NUT PLATE
23	4	MM1676A12	MAGNETIC CATCH
24	4	NNH1/2-13	NUT,HEX,1/2-13
25	8	SSHC01048	1/4-20 X 3/4 HEX CAP
26	8	SSHC25080	3/8-16X1-1/4 HHCS
27	2	SSHC45064	1/2-13X1 HEX CAP
28	4	SSHC45192	1/2-13X3 HEX CAP
29	2	SSSC01032	1/4-20X1/2 SOC CAP
30	8	SSSC80032	6-32 X 1/2 SOC CAP SC
31	48	SSSC98040	10-32 X 5/8 SOC CAP
32	1	WWF10	WASHER, FLAT, #10, COM
33	8	WWF8	WASHER, FLAT, #8
34	10	WWFS1/2	WASHER,FLAT,1/2, SAE
35	8	WWFS1/4	WASHER,FLAT,SAE,1/4
36	46	WWFS10	WASHER, FLAT, #10, SAE
37	8	WWFS3/8	WASHER,FLAT,SAE,3/8
38	6	WWL1/2	1/2 LOCK WASHER
39	10	WWL1/4	WASHER,LOCK, 1/4
40	48	WWL10	WASHER,LOCK,#10
41	8	WWL3/8	WASHER,LOCK, 3/8
42	8	WWL8	WASHER,LOCK,#8

13061105 Valve Assembly

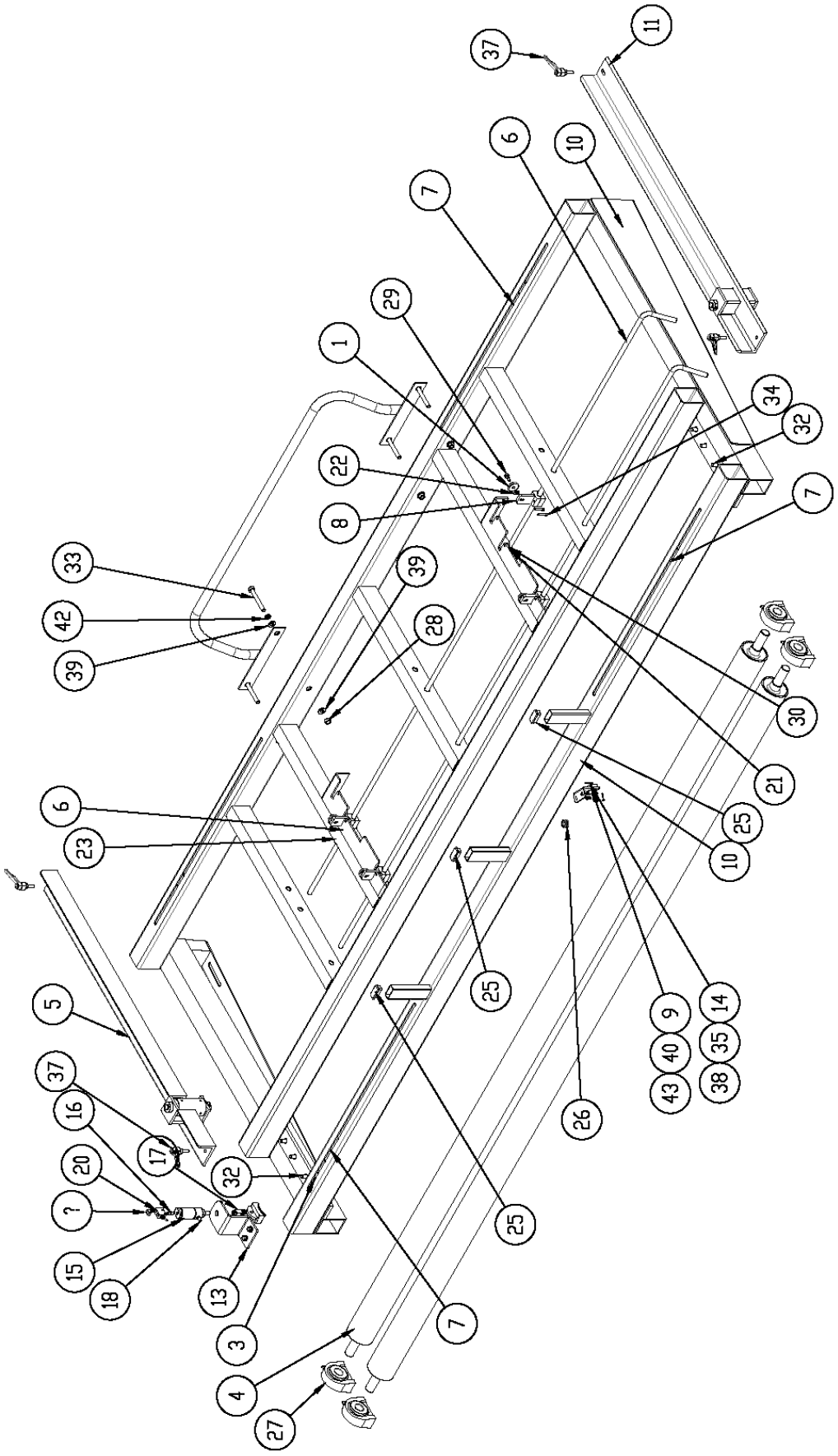
AAC Drawing Number 13061105 Rev 1



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	*1	1390HCD-LAB1	LABEL, VALVE ASSY, DUAL 4-WAY
2	1	13061106	MOUNT, DUAL MAN. TOGGL VALVE
3	6	AAQME 4 8	QUICK MALE ELBOW, 1/4T
4	2	AAVMJTV-4	VALVE TOGGLE 4W, 1/8NPT

1391054 Roll Holder Frame

AAC Drawing Number 1391054 Rev 3



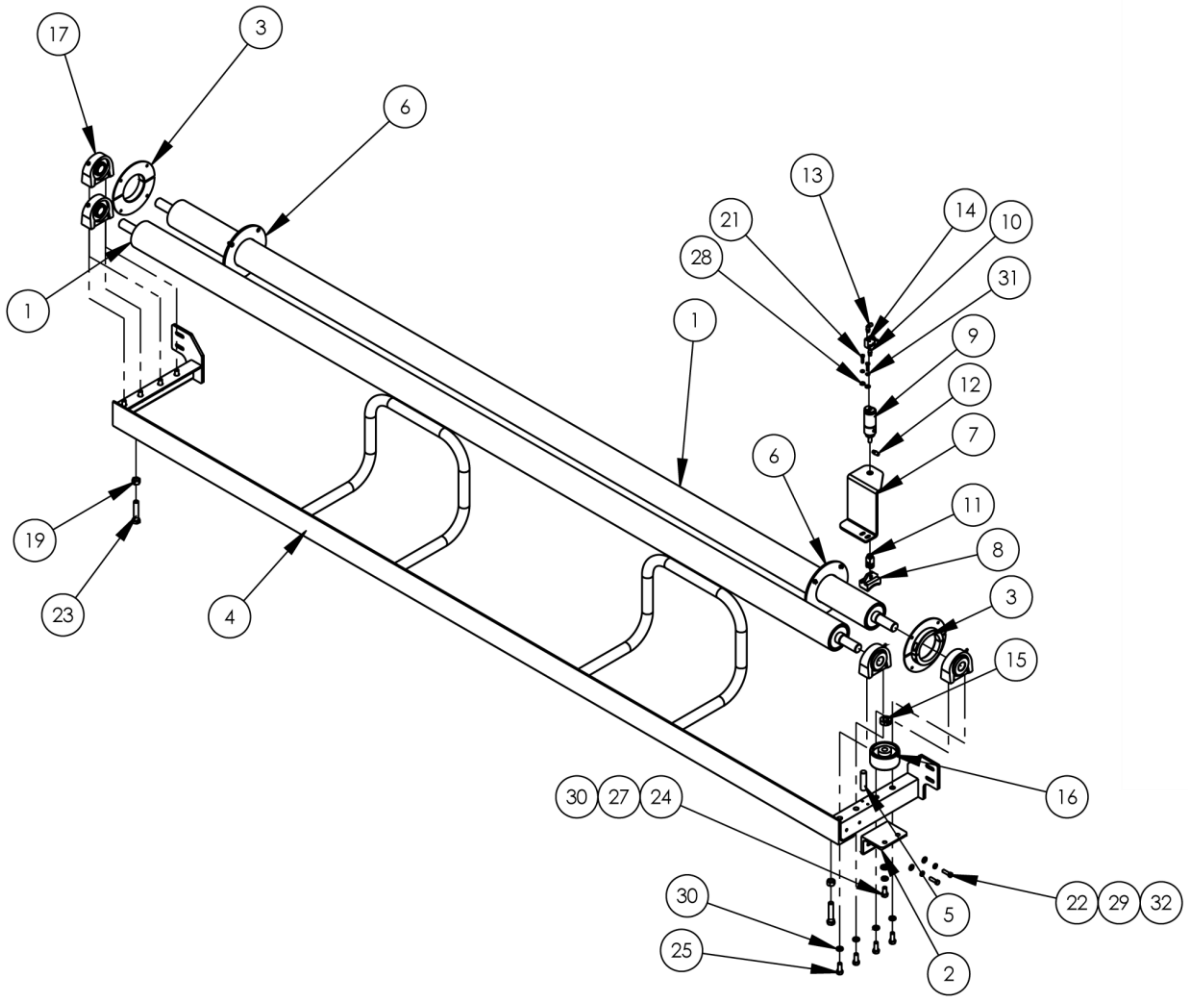
1391054 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	4	1390198	ROLL RELEASE DISK
2	1	1390233	ROLL STOP TUBE
3	1	1390276	NUT PLATE-ROLL BRAKE MTG
4	2	1390405	SUPPORT ROLLER WELDT
5	1	1390412	SIDE ROLLER, ROLL HOLDER
6	2	1390458	ROD, ROLL STOP
7	4	1390459	NUT PLATE-SIDE ROLLER ADJ
8	4	1390463	ROLL STOP, WELD'T
9	1	1390468	BRACKET, EYE MOUNT,LH
10	1	1390470	FRAME WELDT- TOP ROLL
11	1	1390759	SIDE ROLLER, LONG
12	1	1391096	BRAKE BLOCK ASSY, 1390B
13	1	1391098	MTG. BRKT. ROLL BRAKE
14	1	1975-412A	PLATE,NUT,4-40,.95CTC
15	1	AAC171D	CYLINDER,AIR,DA,1-1/2 B,1 ST
16	1	AAF122A-A	1/8" NPT HEX CLOSE
17	1	AAFCT-15	CLEVIS,AIR CYL,7/16-20
18	1	AAFP18	MUFFLER,1/8 NPT, BRONZ
19	1	AAQME-5-8	QUICK MALE ELBOW
20	1	AAVMJTV-3	VALVE,TOGGLE
21	4	BB1L038	BEARING,BALL,.375B
22	4	BBTRA613	WASHER,THRUST,STL, .375B

ITEM	QTY.	PART NUMBER	DESCRIPTION
23	2	CCCL10F	CLAMP COLLAR- 5/8 ID
24	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
25	3	MM132-1496	PLUG 1 X 2
26	2	MM9307K63	GROMMET,1/2ID,13/16 HOLE
27	8	SSSC05080	1/4-28X1-1/4 SOC CAP
28	4	NNH1/2-13	NUT,HEX,1/2-13
29	4	SSAS024024	SHOULDER BOLT 3/8 X 3/8L,
30	5	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
31	2	SSHC25064	3/8-16 X 1,HEX CAP
32	8	SSHC45096	1/2-13X1-1/2 HEX CAP
33	4	SSHC45256	1/2-13X4 HEX CAP
34	2	SSSC98040	10-32 X 5/8 SOC CAP
35	2	SSSC70064	4-40 X 1 SOCKET CAP
36	4	MMGRPA207-20	1.25" BEARING, GRIP-IT
37	4	TTH32430	HANDLE,THRD,3/8-16X1-1/4
38	2	WWF4	WASHER, FLAT, #4
39	16	WWFS1/2	WASHER,FLAT,1/2, SAE
40	2	WWFS10	WASHER, FLAT, #10, SAE
41	2	WWFS3/8	WASHER,FLAT,SAE,3/8
42	12	WWL1/2	1/2 LOCK WASHER
43	2	WWL10	WASHER,LOCK,#10
44	2	WWL3/8	WASHER,LOCK, 3/8

1391056 Lower Roll Feed

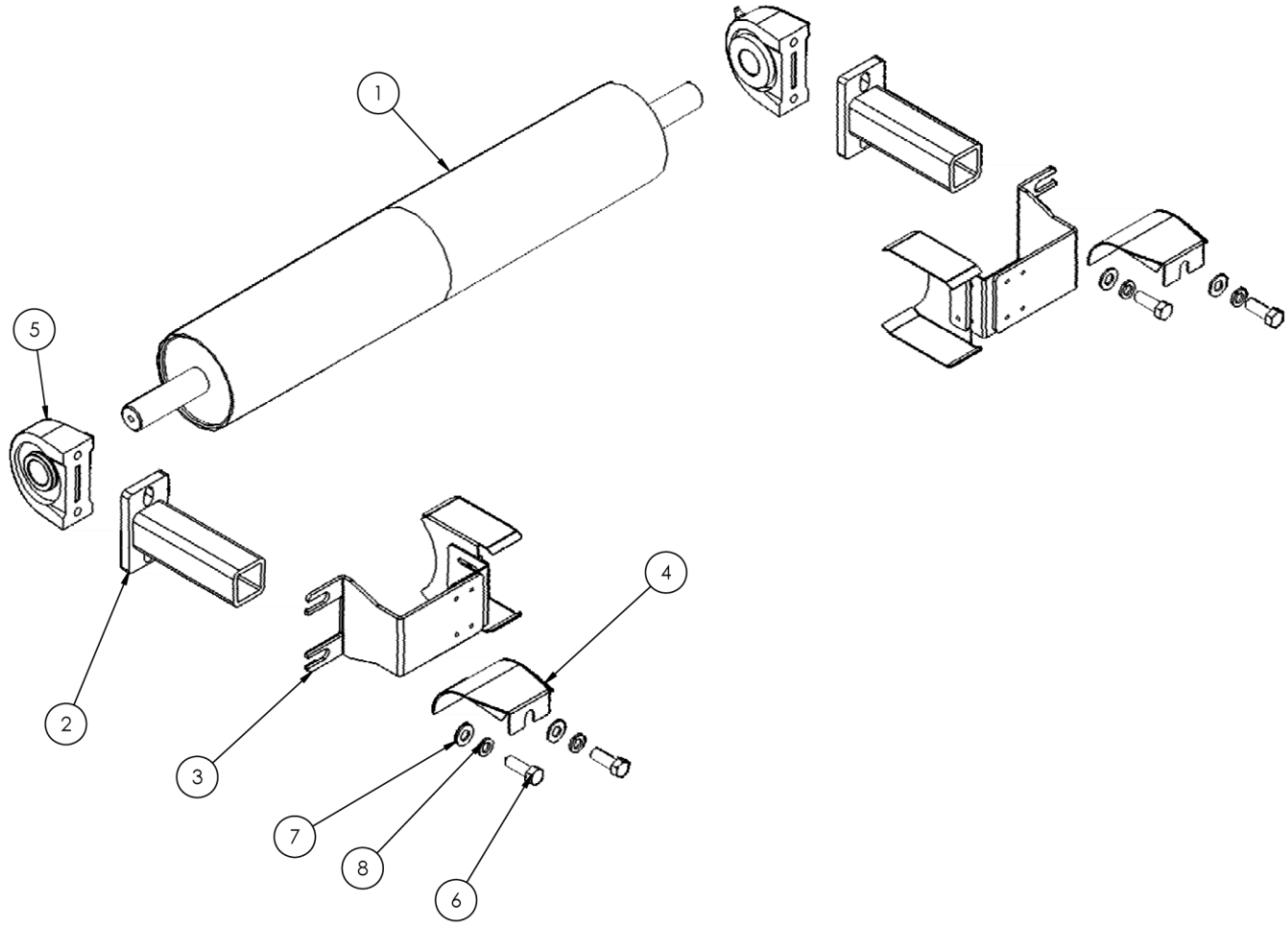
AAC Drawing Number 1391056 Rev 2



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	1390405	SUPPORT ROLLER WELDT	17	4	MMGRPA207-20	1.25" BEARING, GRIP-IT
2	1	1390804	BOTTOM ROLLER MTG BRKT FO	18	8	NNE10-32	NUT,ELASTIC LOCK
3	2	1390810	GUIDE PLATE ASSY, LOWER R	19	2	NNH5/8-11	NUT,HEX,5/8-11
4	1	1390811	LOWER ROLLER WELDMENT	20	8	SSFC98048	#10-32 X .75 SHCSF
5	1	1390812	AXEL, GLIDE WHEEL	21	2	SSHC01064	1/4-20 X 1 HHCS
6	2	1390882	SIDE PLATE- BOTTOM ROLL	22	2	SSHC25080	3/8-16 X 1-1/4 HEX CAP
7	1	1391095	MTG. BRKT. BRAKE	23	2	SSHC41192F	5/8-11X4 HEX CAP FULL THD
8	1	1391096	BRAKE BLOCK ASSY, 1390B	24	1	SSHC45064	1/2-13X1 HEX CAP
9	1	AAC171D	CYLINDER,AIR,DA,1-1/2 B,1 ST	25	8	SSHC45080	1/2-13X1-1/4 HEX CAP
10	1	AAF122A-A	1/8" NPT HEX CLOSE	26	8	WWF10	WASHER, FLAT, #10, COM
11	1	AAFCT-15	CLEVIS,AIR CYL,7/16-20	27	1	WWFS1/2	WASHER,FLAT,SAE,1/2
12	1	AAFP18	MUFFLER,1/8 NPT, BRONZ	28	2	WWFS1/4	WASHER,FLAT,SAE,1/4
13	1	AAQME-5-8	QUICK MALE ELBOW	29	2	WWFS3/8	WASHER,FLAT,SAE,3/8
14	1	AAVMJTV-3	VALVE,TOGGLE	30	9	WWL1/2	1/2 LOCK WASHER
15	1	CCCL12F	CLAMP COLLAR- 3/4	31	2	WWL1/4	WASHER,LOCK,1/4
16	1	MM2419T31	WHEEL, 4"OD X 2"W X 3/4 B	32	2	WWL3/8	WASHER, LOCK, 3/8

1391057 Roller Take-up Assembly

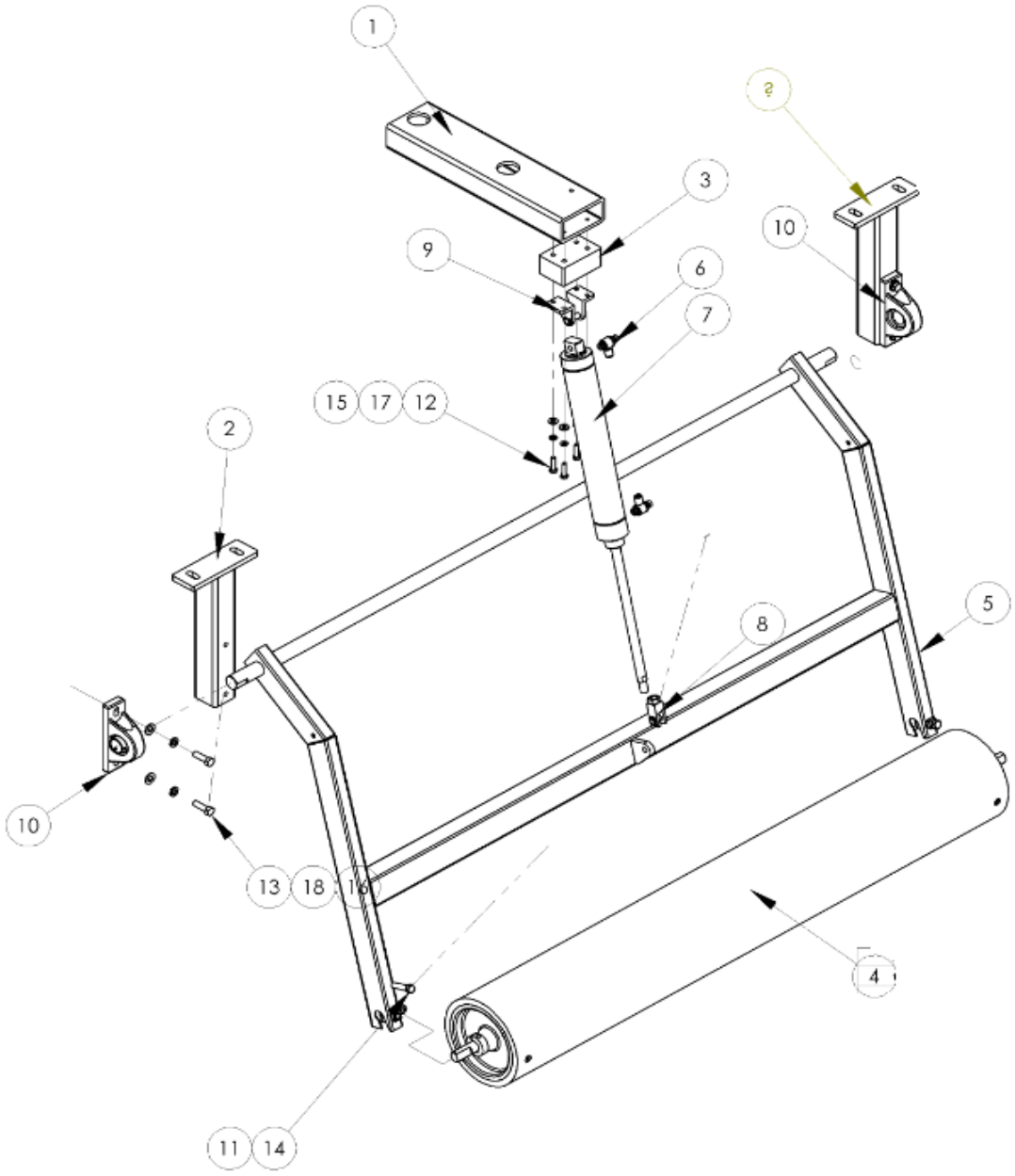
AAC Drawing Number 1391057 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	1	1390248	IDLER-ROLLER, INFEED CONV
2	2	1390282	WELDMENT, BELT-TENSIONER
3	2	1390681	GUARD, ROLLER
4	2	1390859	COVER, PILLOWBLOCK
5	2	MMGRPA207-20	1.25" BEARING, GRIP-IT
6	4	SSHC45096	1/2-13 X 1-1/2 HEX HEAD
7	4	WWFS1/2	WASHER, FLAT, 1/2
8	4	WWL1/2	1/2 LW

1391269 Outfeed Pressure Roller

AAC Drawing Number 1391269 Rev 2

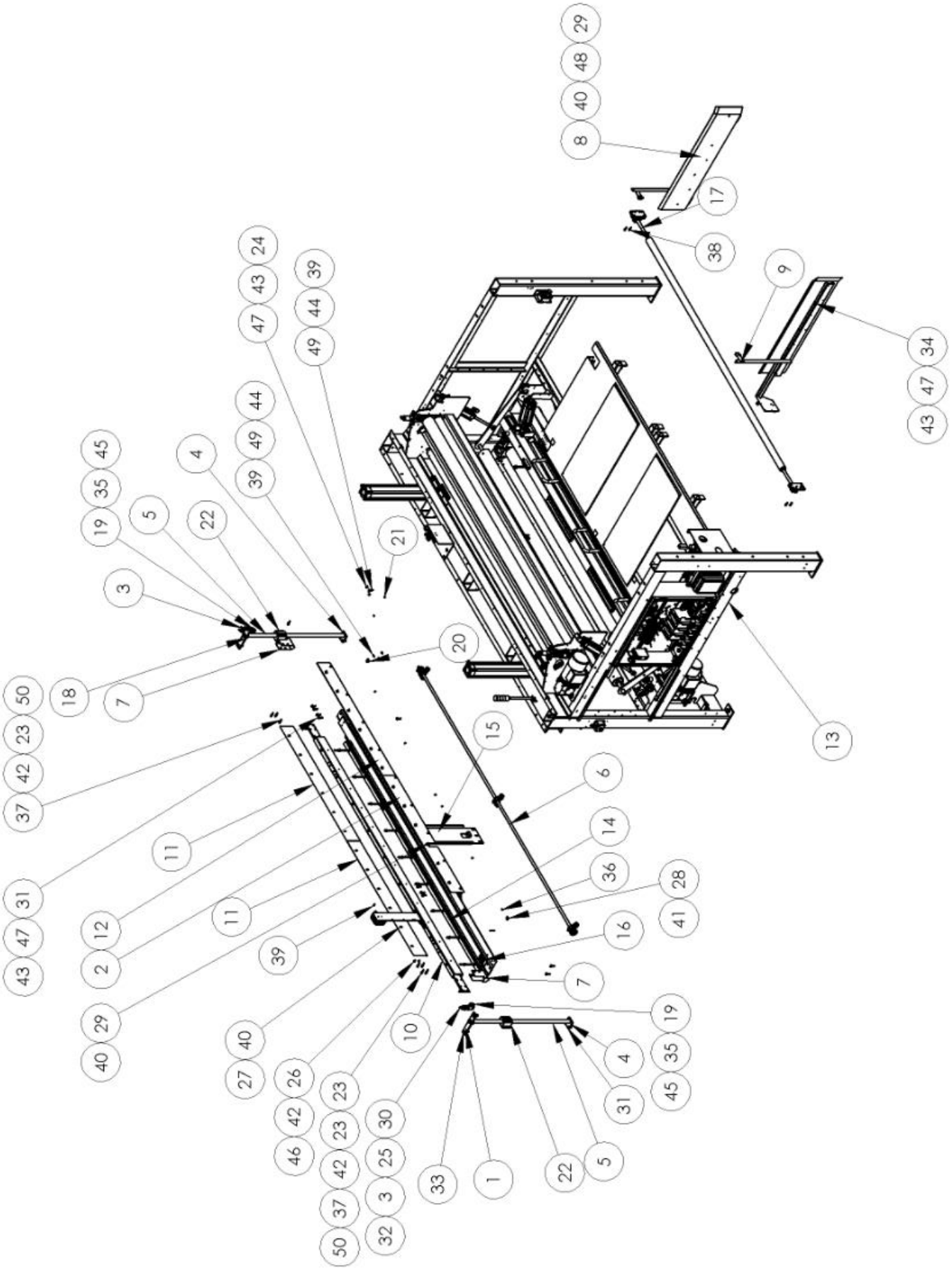


ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1390755	CYL. MTG. BRTK.
2	2	1390766	PIVOT HANGER-TOP ROLLER O
3	1	1390856	SPACER - CYL. MTG. BRTK.
4	1	1391185	ROLLER ASSY -OUTFEED
5	1	1391270	FRAME - TOP ROLLER. OUTFE
6	2	AA198RA404U	FLOW CONTROL,1/4PTX1/4
7	1	AACM3110DXP	CYLINDER,AIR,DA W/MAGNET
8	1	AAFD2313	CLEVIS, AIR CYL 1/2-20
9	1	AAFD620	REAR PIVOT BRKT

ITEM	QTY.	PART NUMBER	DESCRIPTION
10	2	MMVPLS-116	BEARING,PILLOW BLOCK 1.0B
11	2	NNJ3/8-16	3/8-16 JAM NUT
12	4	SSHC01064	1/4-20 X 1 HHCS
13	4	SSHC25080	3/8-16X1-1/4 HHCS
14	2	SSHC25096	3/8-16 X 1 1/2 HHCS
15	4	WWFS1/4	WASHER,FLAT,SAE,1/4
16	4	WWFS3/8	WASHER,FLAT,SAE,3/8
17	4	WWL1/4	WASHER,LOCK, 1/4
18	4	WWL3/8	WASHER,LOCK, 3/8

13901280 Input Conveyor Assembly # 4

AAC Drawing Number 13901280 Rev 0



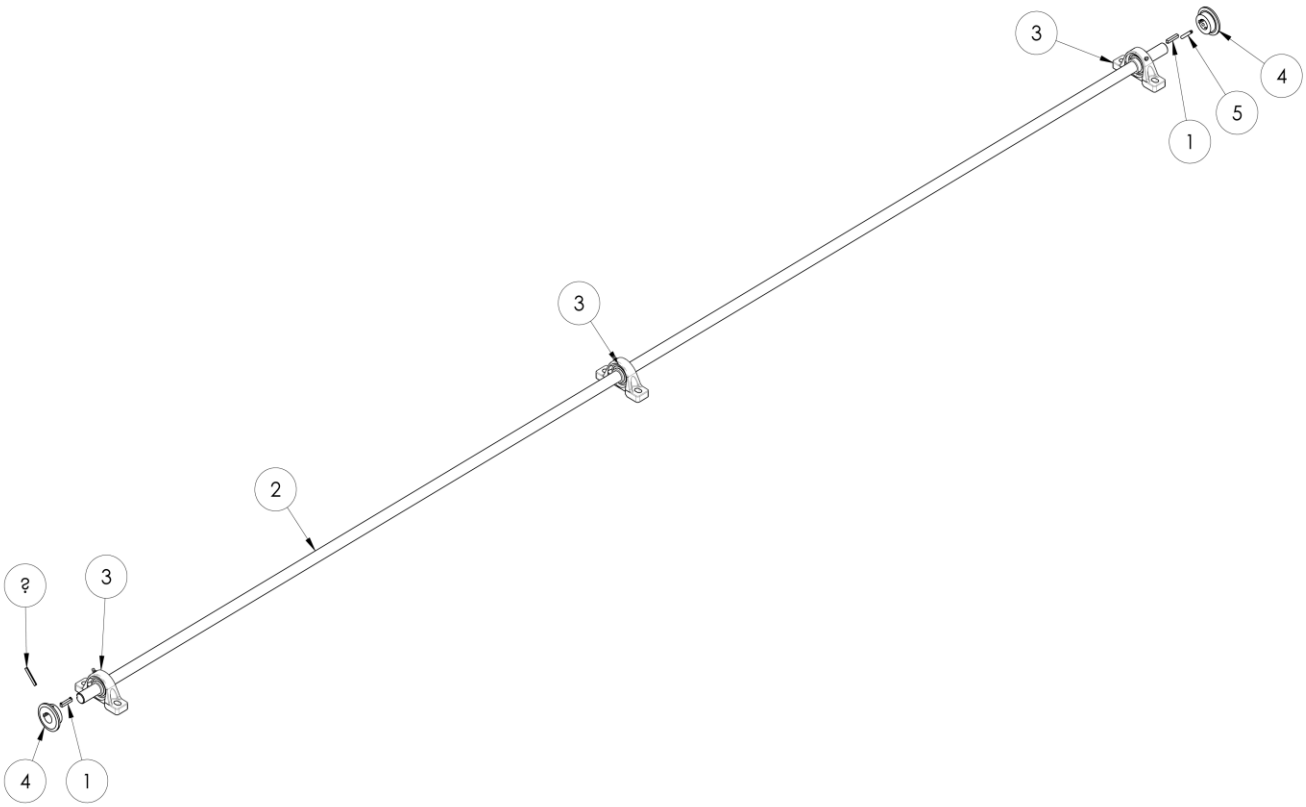
13901280 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	1390324	TOP BRACKET LINEAR SHAFT
2	1	1390337	INPUT GUARD CROSS SEAL RT
3	2	1390342	TOP CHAIN TENSIONER
4	2	1390343	LOWER LINEAR BRKT CROSS
5	2	1390346	SHAFT,ROLLER
6	1	1390484	SHAFT ASSY,IDLER SPKTS
7	2	1390485	END PLATE, CROSS SEAL
8	1	1390504	STOP PLATE ASSEMBLY
9	1	1390507	PLATE ASSY, PUSHER
10	1	1390609	MOUNT, CROSS SEAL BAR
11	2	1390858	INPUT GUARD CROSS SEAL
12	1	1390967	INPUT GUARD CROSS SEAL LT
13	1	13901281	INPUT CONVEYOR ASSY. #3
14	1	1406519	SEAL BAR 120" ASSEMBLY
15	1	1406823	SUPPORT, CENTER CROSSBAR
16	1	1406995	BLADDER SEAL KIT, 120"
17	1	1490345	IDLER ROLLER ASSY. FILM
18	2	CCCL20F	COLLAR,1 1/4" CLAMP TYPE
19	2	MM41E15	SPROCKET, 1/2 P, 15T
20	1	MM9307K63	GROMMET,1/2ID,13/16 HOLE
21	2	MM94807A029	PUSHNUT,ROUND,1/4 DIA
22	2	MMPB20M	LIN. PILLOW-BLOCK,MOD.
23	16	NNH1/4-28	NUT,HEX,1/4-28
24	8	NNH3/8-16	NUT,HEX,3/8-16
25	2	NNJ3/8-16	3/8-16 JAM NUT

ITEM	QTY.	PART NUMBER	DESCRIPTION
26	4	SSBC01040	1/4-20 X 3/4 BUT CAP SC
27	12	SSBC10064	5/16-18 X 5/8 L
28	2	SSBC98048	10-32 X 3/4 BUTTON CAP SC
29	16	SSHC10064	5/16-18 X 1 HHCS
30	2	SSHC25080	3/8-16X1-1/4 HHCS
31	18	SSHC25096	3/8-16 X 1 1/2 HHCS
32	4	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
33	4	SSHC25128	3/8-16 X 2 HEX CAP
34	2	SSHC25224	3/8-16 X 3.5 HEX CAP
35	2	SSHC45112	1/2-13 X 1-3/4 HHCS, G8
36	6	SSPS98032	10-32X1/2 PAN HD SLOT
37	8	SSSC05096F	1/4-28X1-1/2 SOC CAP FUL
38	4	SSSC25064	3/8-16X1 SOC CAP
39	6	SSSC98040	10-32 X 5/8 SOC CAP
40	28	WWF5/16	WASHER,FLAT,5/16
41	2	WWFE016	WASHER,FENDER,LARGE,1/4
42	12	WWFS1/4	WASHER,FLAT,SAE,1/4
43	36	WWFS3/8	WASHER,FLAT,SAE,3/8
44	6	WWFS10	WASHER, FLAT, #10, SAE
45	2	WWL1/2	1/2 LOCK WASHER
46	4	WWL1/4	WASHER,LOCK, 1/4
47	26	WWL3/8	WASHER,LOCK, 3/8
48	4	WWL5/16	WASHER,LOCK, 5/16
49	6	WWL10	WASHER,LOCK,#10
50	8	WWS307-1	WASHER,SPRING,BELVEL

1390484 Drive Shaft Assembly

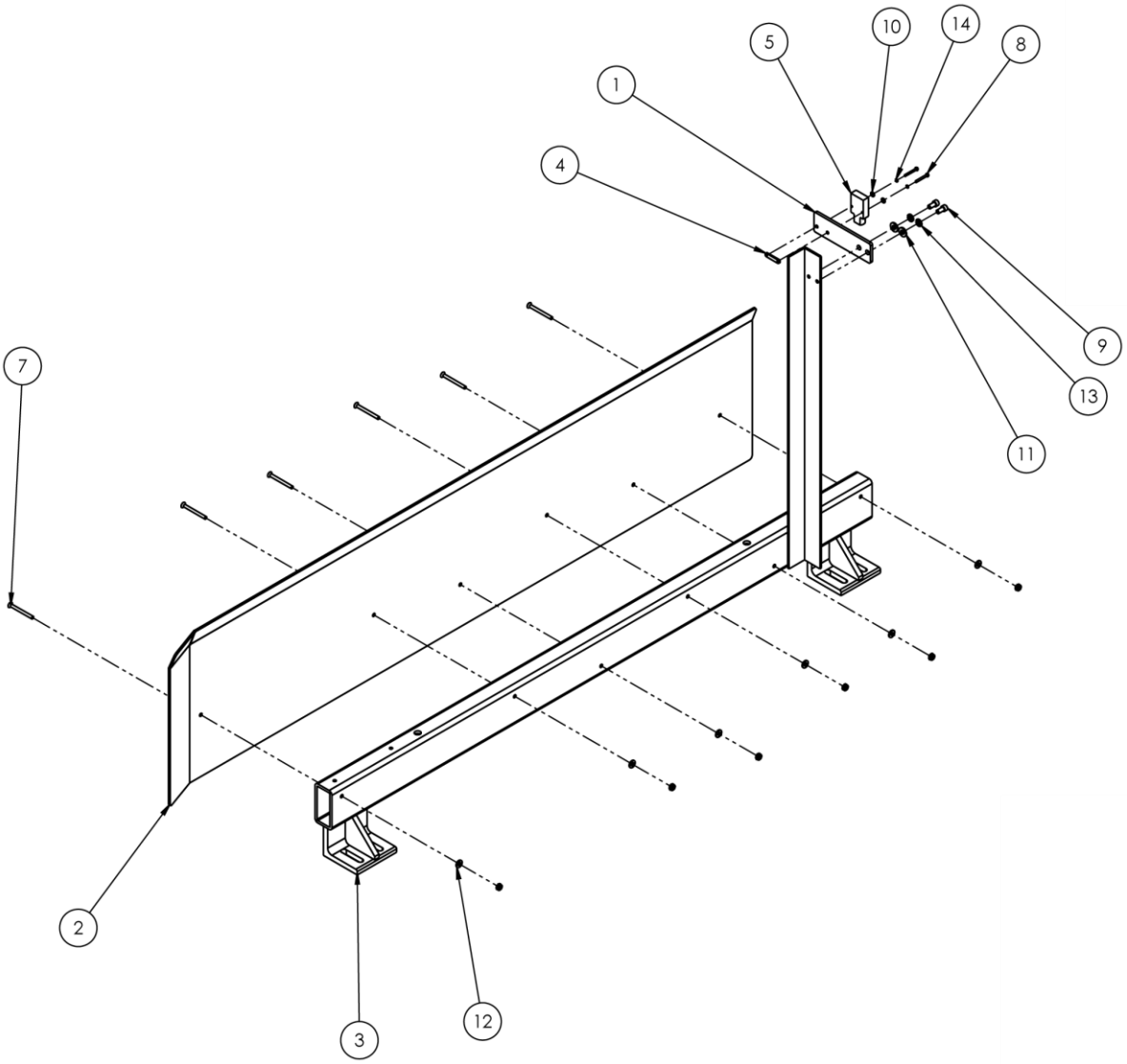
AAC Drawing Number 1390484 Rev 3



NO	QTY.	PART #	DESCRIPTION
1	2	1386645	MODIFIED SPROCKET
2	1	1390355	JACK SHAFT CROSS SEAL
3	2	1390997	KEY, 1/4 X 1.25L, W/STEP
4	2	IIS016X112	ROLL PIN 1/8 DIA X 1 1/2 SS
5	3	MMUCP205-16	BEARING,PILLOW BLOCK,1"

1390504 Stop late Assembly

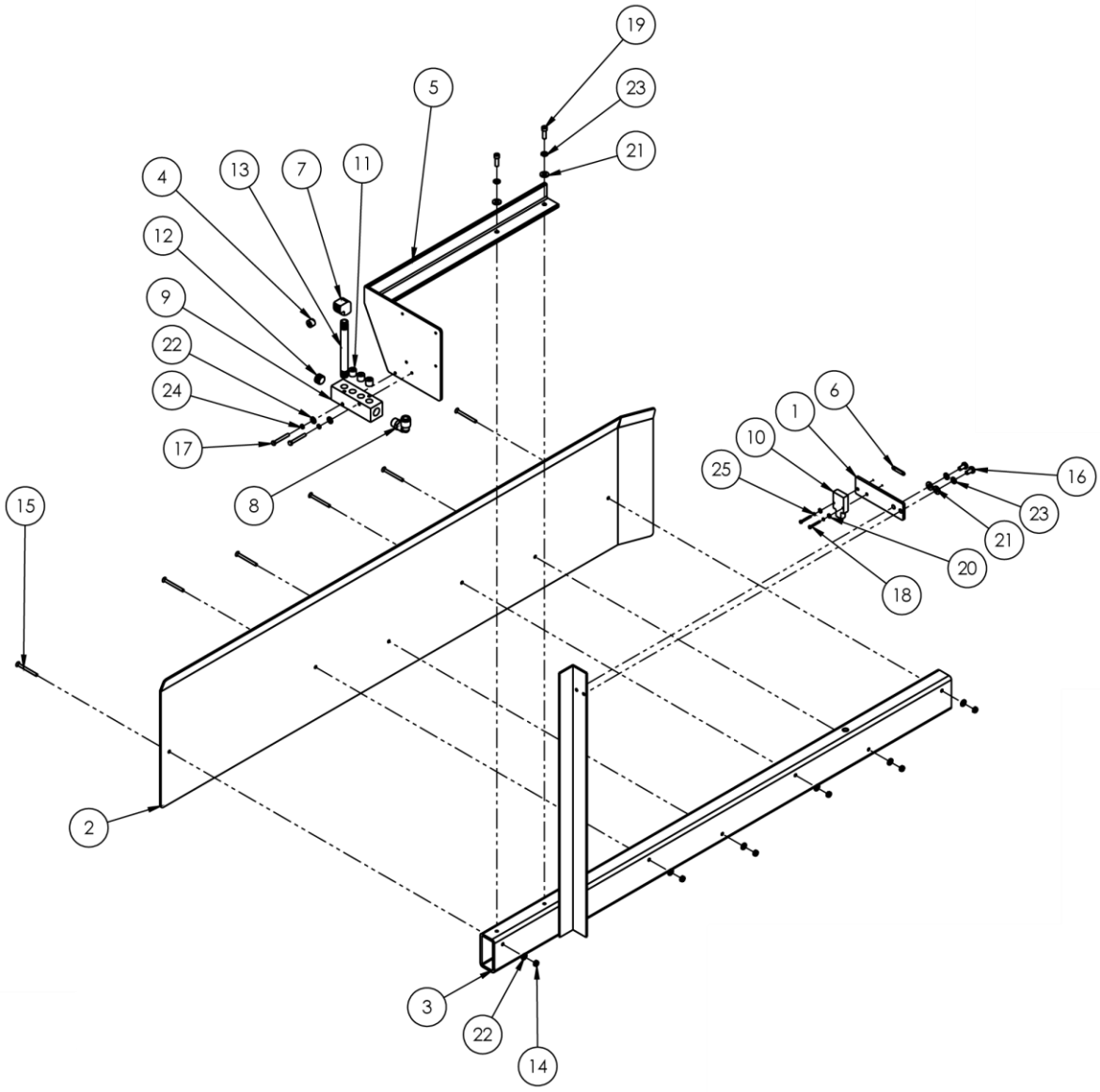
AAC Drawing Number 1390504 Rev 1



NO.	QTY	PART #	DESCRIPTION
1	1	1390194	BRACKET, SENSOR
2	1	1390304	GUIDE, RIGHT POSITION
3	1	1390308	GUIDE, LEFT, WELDMENT
4	1	1975-412A	PLATE,NUT,4-40,.95CTC
5	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
6	6	NNK10-32	KEP NUT, 10-32
7	6	SSFC98128	#10-32 X 2 FLAT CAP
8	2	SSHC01032	1/4-20 X 1/2 HHCS
9	2	SSPS70064	4-40 X 1 PAN HD SLOTTED
10	2	WWF4	WASHER, FLAT, #4
11	2	WWFS1/4	WASHER,FLAT,SAE,1/4
12	6	WWFS10	WASHER, FLAT, #10, SAE
13	2	WWL1/4	WASHER,LOCK,1/4
14	2	WWL4	WASHER,LOCK,#4

1390507 Pusher Plate Assembly

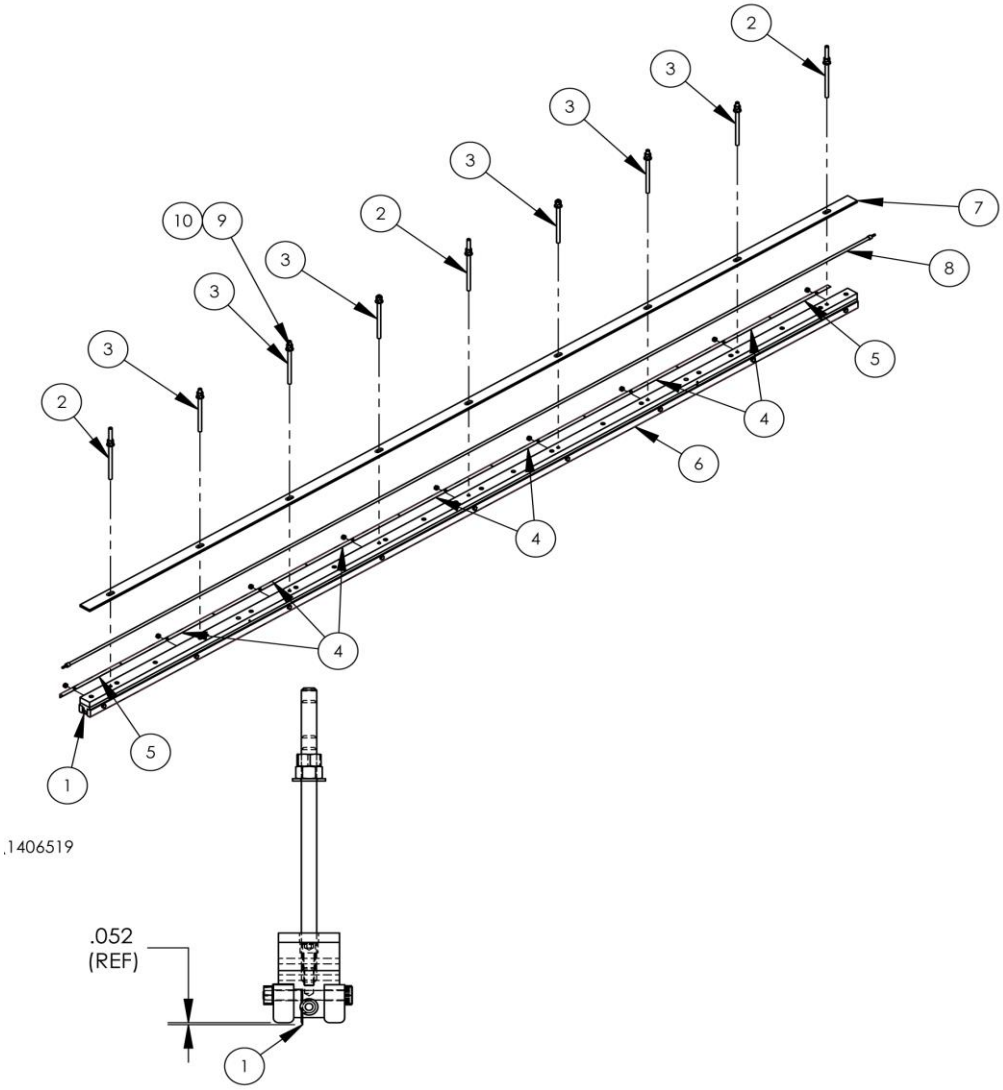
AAC Drawing Number 1390507 Rev 4



NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1390194	BRACKET, SENSOR	14	6	NNK10-32	KEP NUT, 10-32
2	1	1390305	GUIDE, RIGHT POSITION	15	6	SSFC98128	#10-32 X 2 FLAT CAP
3	1	1390309	GUIDE, RIGHT, ASSEM	16	2	SSHC01032	1/4-20 X 1/2 HHCS
4	1	1390350	PLUG,1/4" PIPE, MOD	17	2	SSHC98096	#10-32 X 1-1/2 HEX CAP
5	1	1390674	BRACKET, MANFOLD	18	2	SSPS70064	4-40 X 1 PAN HD SLOTTED
6	1	1975-412A	PLATE,NUT,4-40,.95CTC	19	2	SSSC01048	1/4-20 X 3/4" SOC CAP SC
7	1	AAF1/4-BFF	90 DEG ECONO ELBOW, NPTF, 1/4"	20	2	WWF4	WASHER, FLAT, #4
8	1	AAQME-3-3S	FITTING,ELBOW,3/8NPT,3/8	21	4	WWFS1/4	WASHER,FLAT,SAE,1/4
9	1	AAVM4A	MANIFOLD, 3/8 X 1/4	22	8	WWFS10	WASHER, FLAT, #10, SAE
10	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	23	4	WWL1/4	WASHER,LOCK,1/4
11	3	MM4554K12	PLUG, 1/4" PIPE	24	2	WWL10	WASHER,LOCK,#10
12	1	MM4638K513	PLUG,3/8",HEX SOCKET	25	2	WWL4	WASHER,LOCK,#4
13	1	MM4830K137	NIPPLE,1/4NPT X 5.0L				

1406519 Seal Bar Assembly, 120”

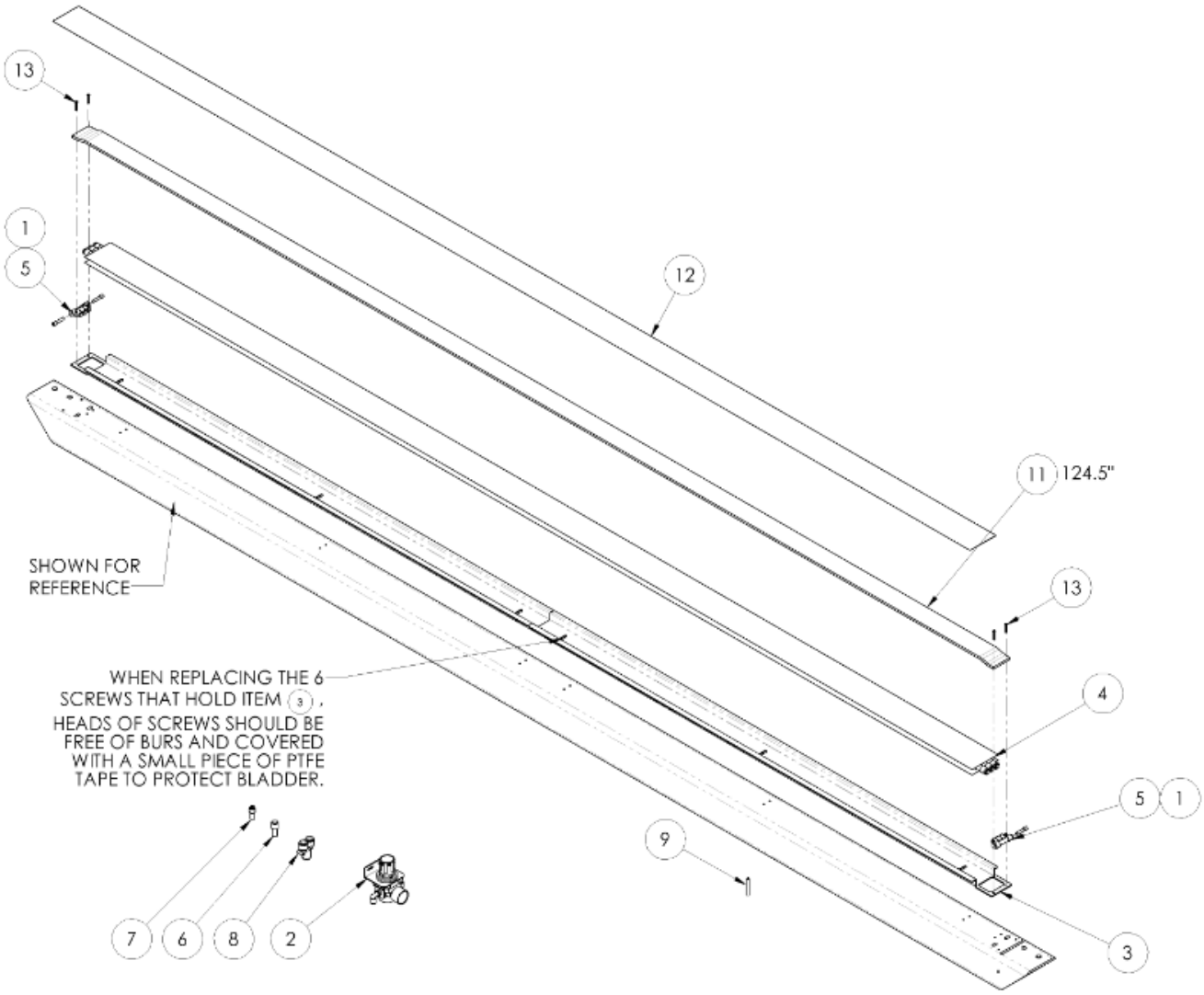
AAC Drawing Number 1406519 Rev 1



NO	QT	PART #	DESCRIPTION
1	1	1390333	CUT BLADE 120"
2	3	1390385	THREADED ROD, 7.5"
3	6	1390386	THREADED ROD, 6.25"
4	7	1391898	SHIM, .018, CROSS SEAL
5	2	1391899	SHIM, .018, CROSS SEAL
6	1	1406518	SEAL BAR 120" ASSEMBLY
7	1	1490508	STRIP, INSULATING
8	1	EERBN125A10A-4	HEAT ELEMENT,125L,.315D
9	18	NNH3/8-16	NUT,HEX,3/8-16
10	9	WWFS3/8	WASHER,FLAT,SAE,3/8

1406995 Bladder Seal, 120”

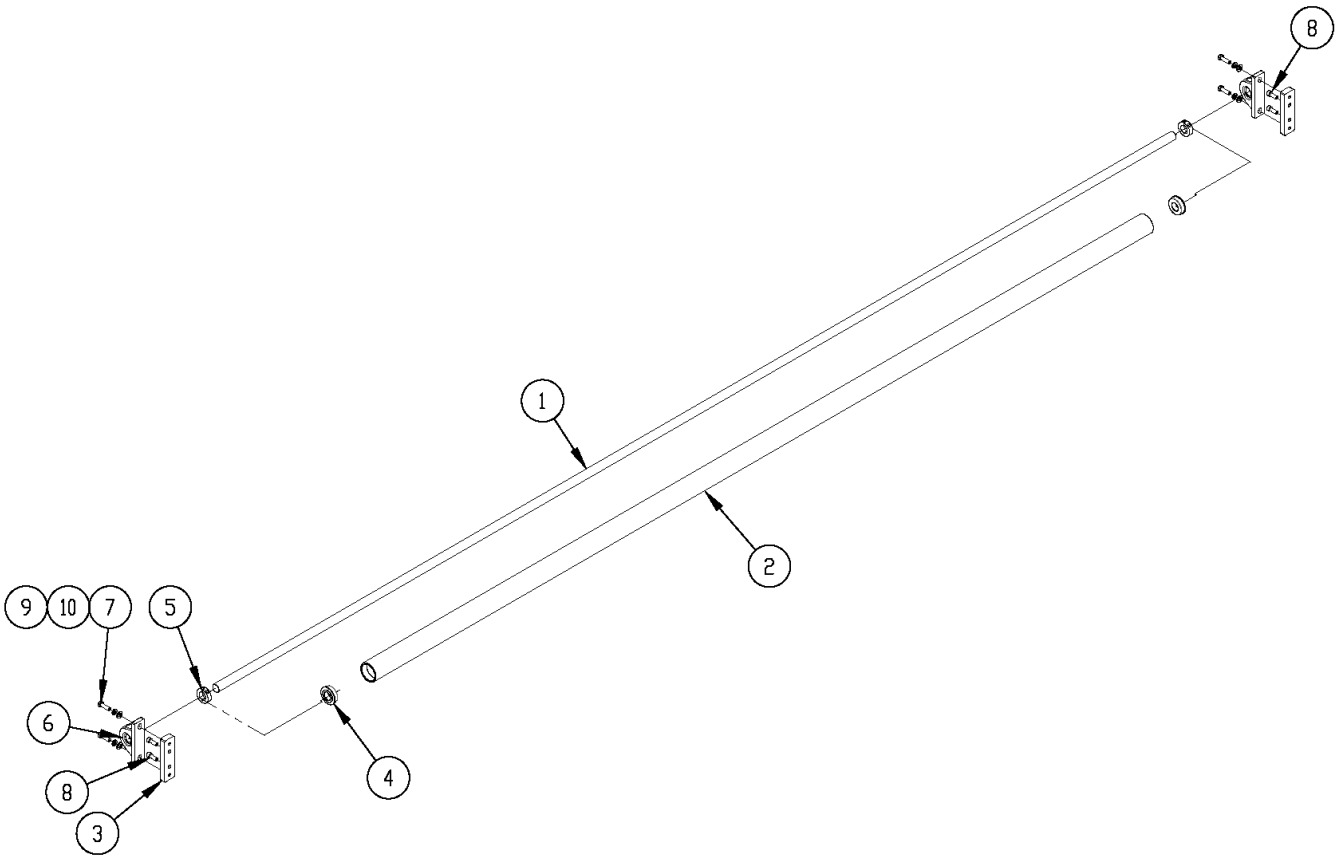
AAC Drawing number 1406995 Rev 10



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	3	1406938	QUICK PLUG 1/4, MODIFIED
2	1	1406942	REGULATOR ASSY, MODIFED
3	2	13901203	TROUGH, SEAL BAR 120"
4	1	14061357	BLADDER ASSY, 120"
5	2	AAQMF-4	MANIFOLD, 3, 1/4-1/4-1/4
6	1	AAQPR-2-3	QUICK PLUG REDUCER
7	1	AAQPR-3-4	QUICK REDUCER 3/8-1/4
8	1	AAQUY-2-2	QUICK UNION Y,1/2X1/2
9	10'	AATP4-1	1/4" OD POLYURETHANE
10	1 KIT ONLY	DDB#29	#29 DRILL BIT
11	1	MMRF118914	SILICONE,STRIP,2.25X.25TK
12	1	MMSG1305	TAPE, TEX PTFE, 3.4W X 54'L, 6 MIL
13	4	SSFC70064	SCREW, FLAT ALLEN CAP 4-40 X 1
14	2	SSSC90032	SCREW, SOCKET CAP
15	2	SSSC90080	SCREW, SOCKET CAP
16	1 KIT ONLY	TTA8-32	8-32 TAP

1490345 Film Idler Roller Assembly

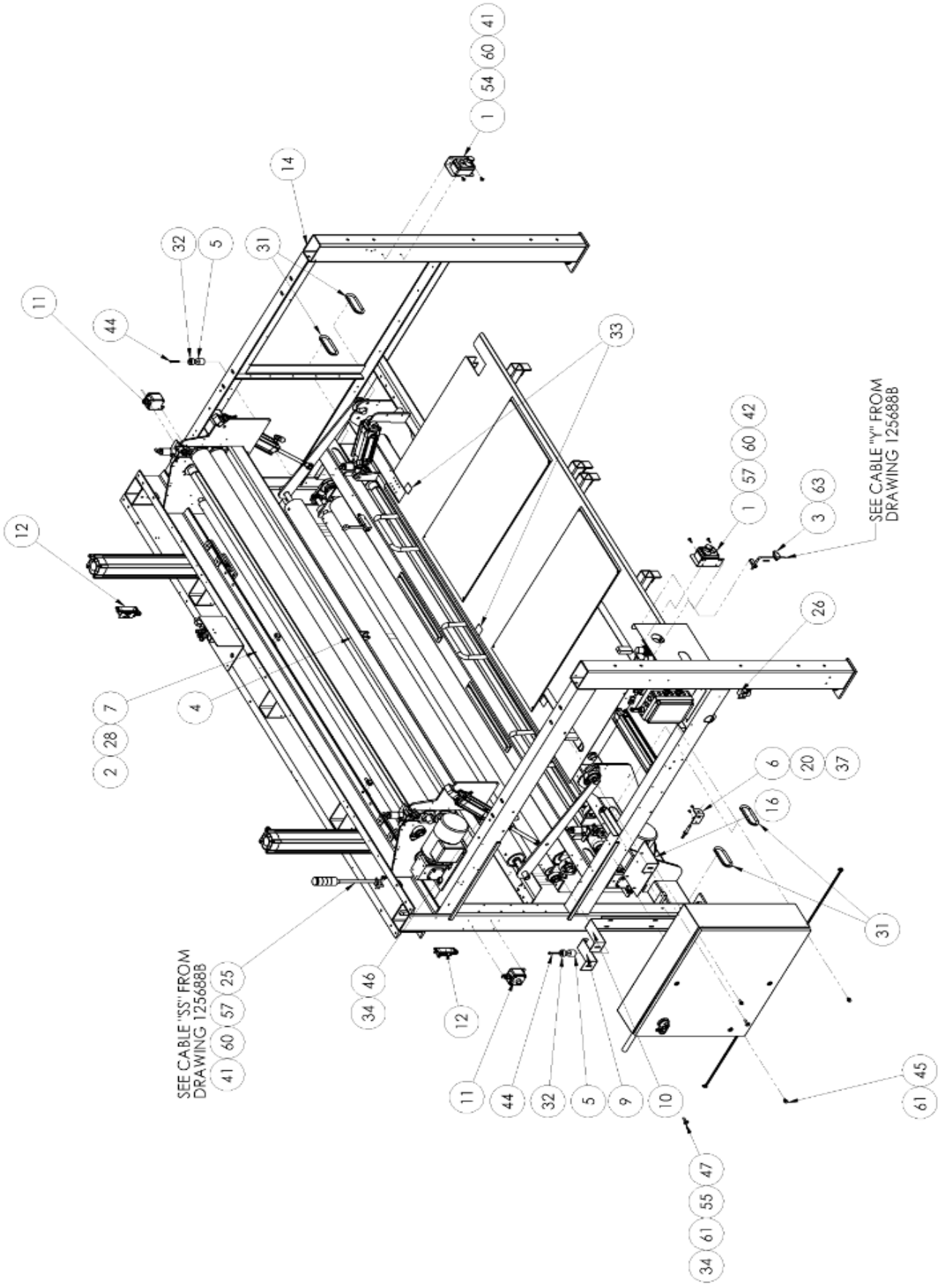
AAC Drawing Number 1490345 Rev 0

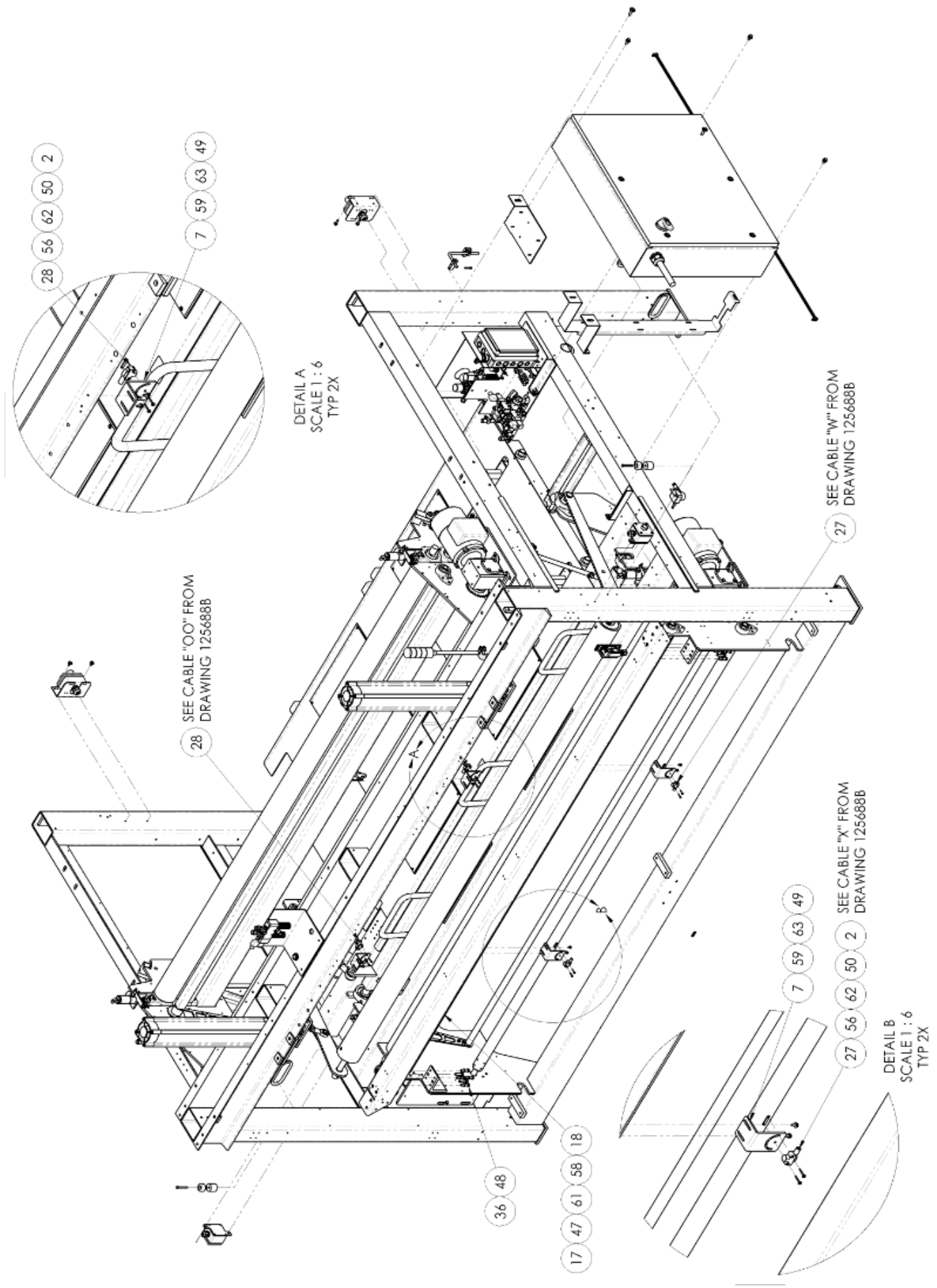


ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1390446	TURN-AROUND ROD
2	1	1390464	TUBE, IDLER ROLLER
3	2	1490346	SPACER, PILLOW BLOCK
4	2	BBF-1000-4	BEARING, BALL, 1 1/4 B, UNGRD
5	2	CCCL16F	COLLAR,1" CLAMP TYPE
6	2	MMVPLS-116	BEARING,PILLOW BLOCK 1.0B
7	4	SSHC25080	3/8-16X1-1/4 HHCS
8	4	SSSC25064	3/8-16X1 SOC CAP
9	4	WWFS3/8	WASHER,FLAT,SAE,3/8
10	4	WWL3/8	WASHER,LOCK, 3/8

13901281 Input Conveyor Assembly # 3

AAC Drawing Number 13901281 3




DETAIL A
SCALE 1 : 6
TYP 2X
28 56 62 50 2
7 59 63 49
SEE CABLE "OO" FROM
DRAWING 125688B
28
SEE CABLE "W" FROM
DRAWING 125688B
27
SEE CABLE "X" FROM
DRAWING 125688B
27 56 62 50 2
7 59 63 49
DETAIL B
SCALE 1 : 6
TYP 2X
36 48
17 47 61 58 18
A
A
B
B

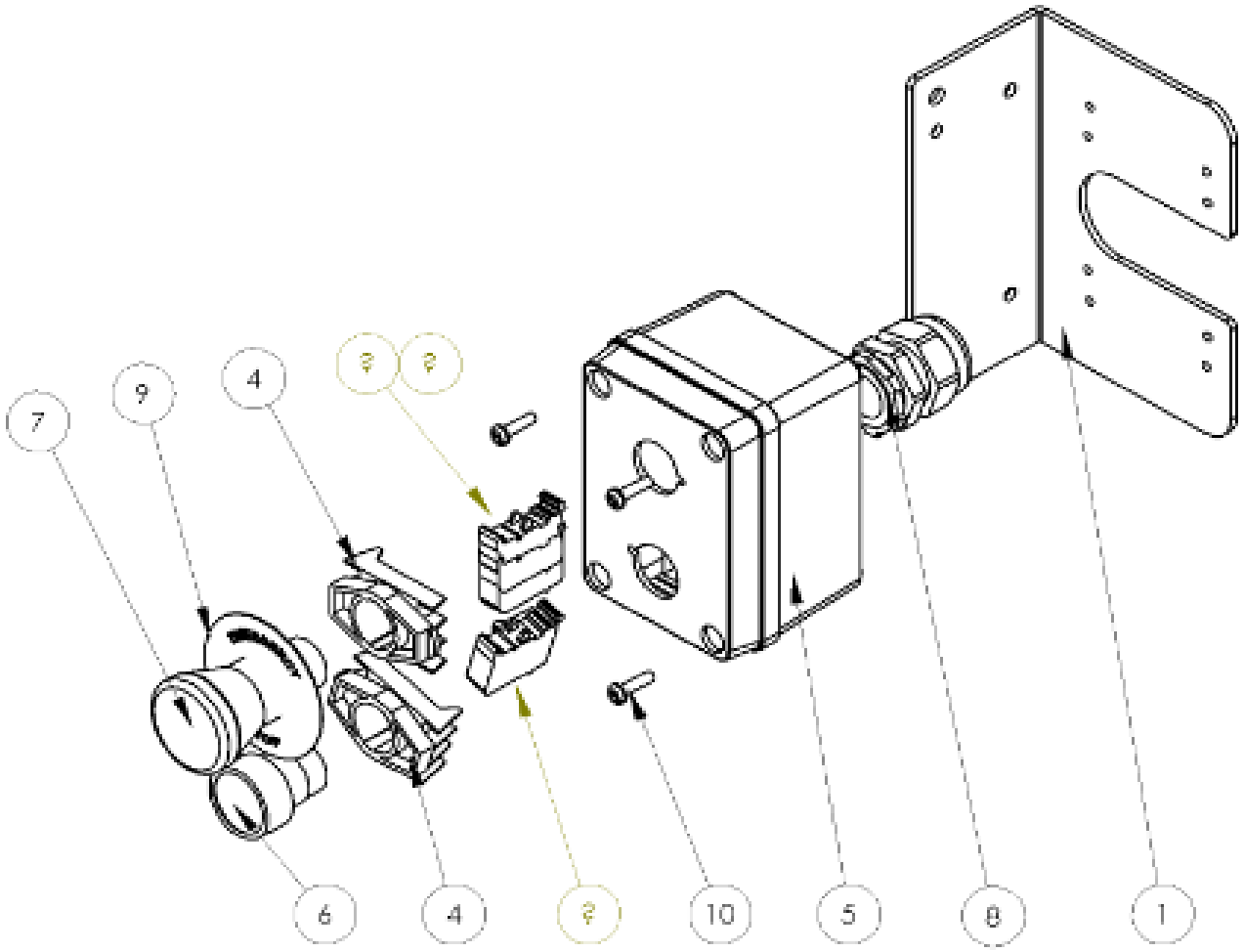
13901281 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	13901053	BUTTON BOX, E-STOP/START
2	5	1975-412A	PLATE,NUT,4-40,.95CTC
3	1	1390443	SENSOR ASSEMBLY, FILM OUT
4	1	1390468	BRACKET, EYE MOUNT,LH
5	2	1390478	SPACER, BUMPER
6	2	1390703	BRACKET, DAMPENING MOUNT
7	4	1390846	BRACKET, EYE MOUNT,LH
8	3	1391176	MTG BRKT, SIX MODULE STAT
9	1	13901032	TOP MTG BRKT, MAIN BOX
10	1	13901041	CABLE TRACK, 1390 CABINET
11	2	13901055	BUTTON BOX, RESET,BLUE
12	2	13901091	SAFETY INTERLOCK SWITCH ASSY
13	1	13901207	ENCLOSURE, SBUS, EXTERNAL
14	1	13901282	INPUT CONVEYOR ASSY. #2
15	1	13901292	CABINET, ELECT CNTRL 1390BA
16	1	13901326	TOP MTG BRKT, MAIN BOX, PC MOUNT
17	2	13901557	PLATE, NUT, 3/8-16@2.00 CTC
18	1	13901558	TUBE,F,4X4X.25WX135.25L
19	*50	AAF3/16	CLAMP, BLACK PLASTIC, 3/16 DIA
20	2	AAPR025IF2B	SHOCK 5/8 STK,1/2-20 THD
21	*100'	AATP1/2	1/2" OD POLYURETHANE
22	*300'	AATP3/8	3/8" OD POLYURETHANE
23	*150'	AATP4-1	1/4" OD POLYURETHANE
24	*75'	AATP5/32	5/32" OD POLYURETHANE
25	1	EELES302RAG	TOWER,SIGNAL,LED,RAG
26	1	EESP150-3	LINEAR, XDUCER (STRING POT) 50" RNGE
27	2	FFQS18VN6RQ8	SENSOR,LASER RECEIVER,NPN
28	2	FFQS186LEQ8	SENSOR,LASER EMITTER
29	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
30	*50	MM5X521	RIVET,POP,1/8D,.313-.375
31	*6'	MM8507K22	EDGE TRIM
32	2	MM9540K28	BUMPER, 1-1/2 DIA, 70A

ITEM	QTY.	PART NUMBER	DESCRIPTION
33	*36"	MMT9945	TAPE,REFLECTIVE,2" WIDE
34	6	NNH3/8-16	NUT,HEX,3/8-16
35	4	NNJ1/2-20	NUT, JAM, 1/2-20
36	8	NNJ3/8-16	3/8-16 JAM NUT
37	1	NNK1/4-20	KEP NUT, 1/4-20
38	*468"	PPP40	CHAIN, #40 RIVET
39	*10	PPP40CL	LINK, CONNECTING, #40
40	4	SSHC01032	1/4-20 X 1/2 HHCS
41	4	SSHC01048	1/4-20 X 3/4 HEX CAP
42	2	SSHC01064	1/4-20 X 1 HHCS
43	2	SSHC01096	1/4-20 X 1-1/2 HHCS
44	2	SSHC01144	HEX HEAD, 1/4-20 X 2-1/4
45	2	SSHC25048	3/8-16X3/4,HEX CAP
46	2	SSHC25064	3/8-16 X 1,HEX CAP
47	6	SSHC25096	3/8-16 X 1 1/2 HHCS
48	8	SSHC25096F	3/8-16 X 1 1/2 HEX HEAD
49	8	SSHC98032	10-32X1/2 HEX HD
50	8	SSPS70064	4-40 X 1 PAN HD SLOTTED
51	2	SSSC70048	4-40 X 3/4 SOCKET CAP
52	2	SSSC98048	10-32 X 3/4 SOC CAP
53	2	SSSC98080	10-32 X 1-1/4 SOC CAP
54	2	WWF1/4	WASHER, FLAT, 1/4", COM
55	4	WWF3/8	WASHER,FLAT,3/8 OR 10MM
56	10	WWF4	WASHER, FLAT, #4
57	6	WWFS1/4	WASHER,FLAT,SAE,1/4
58	14	WWFS3/8	WASHER,FLAT,SAE,3/8
59	10	WWFS10	WASHER, FLAT, #10, SAE
60	8	WWL1/4	WASHER,LOCK, 1/4
61	10	WWL3/8	WASHER,LOCK, 3/8
62	8	WWL4	WASHER,LOCK,#4
63	12	WWL10	WASHER,LOCK,#10

13901053 E-Stop / Start Button Assembly

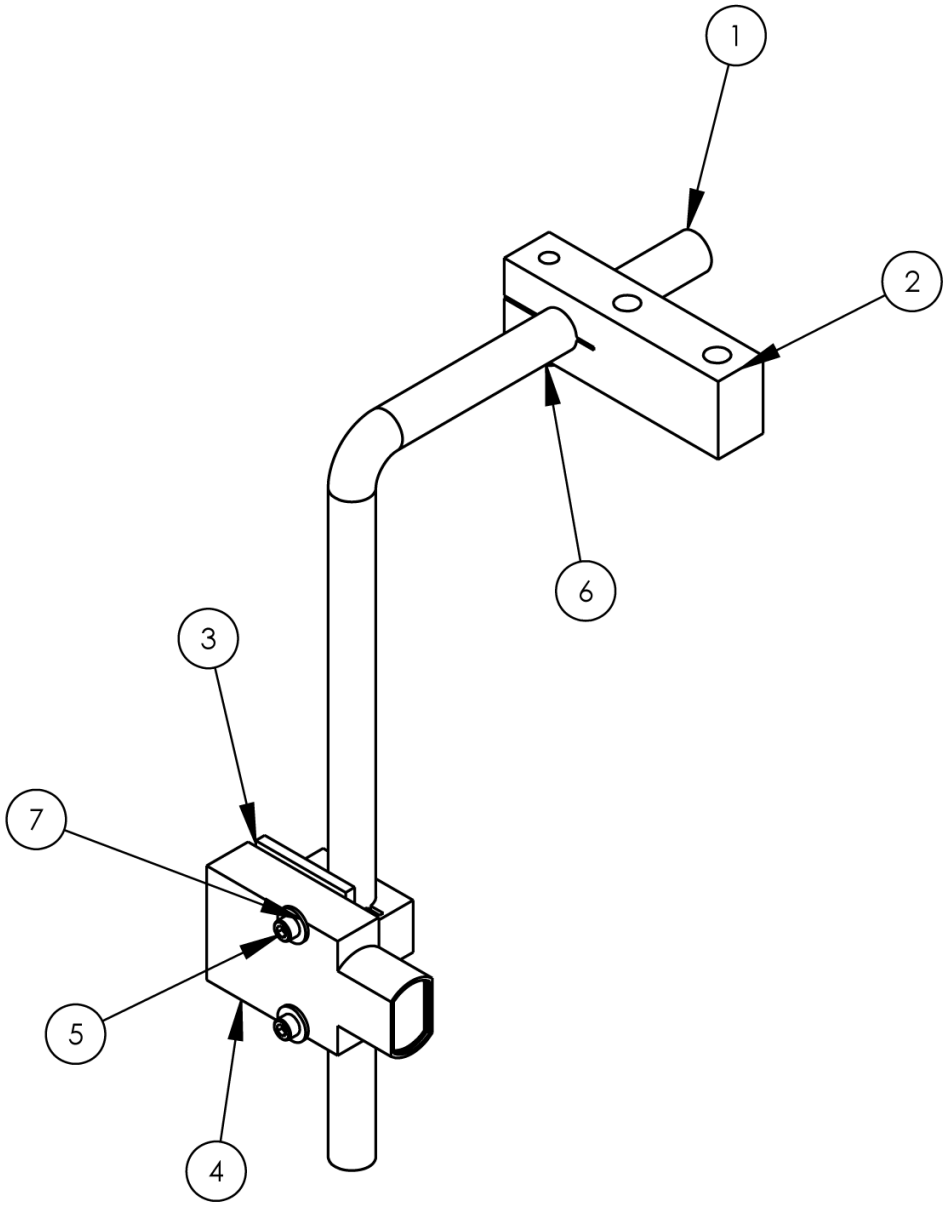
AAC Drawing Number 13901053 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1391142	MTG BRKT REMOTE CONTROL
2	2	EE3Q01	CNTK BLOCK, N.C. (RED) SPNG TERM
3	1	EE3Q10	CNTK BLOCK, N.O. (GRN) SPNG TERM
4	2	EEA3L	LATCH,PUSH BUTTON
5	1	EEPCB65GM8	ENCLOSURE,80X110X65
6	1	EEPF3	BUTTON, PUSH 22MM, GREEN MO
7	1	EEPMTS44	E-STOP BUTTON, TWIST REL.
8	1	FFM3234GBR-SM1	STRAIN RELIEF, 3/4NPT, 5 HOLE, BLK
9	1	MM800E15YE112	E-STOP LEGEND PLATE
10	4	SSPS90040	8-32 X 5/8 PAN HD

1390443 Sensor Assembly, Film Out

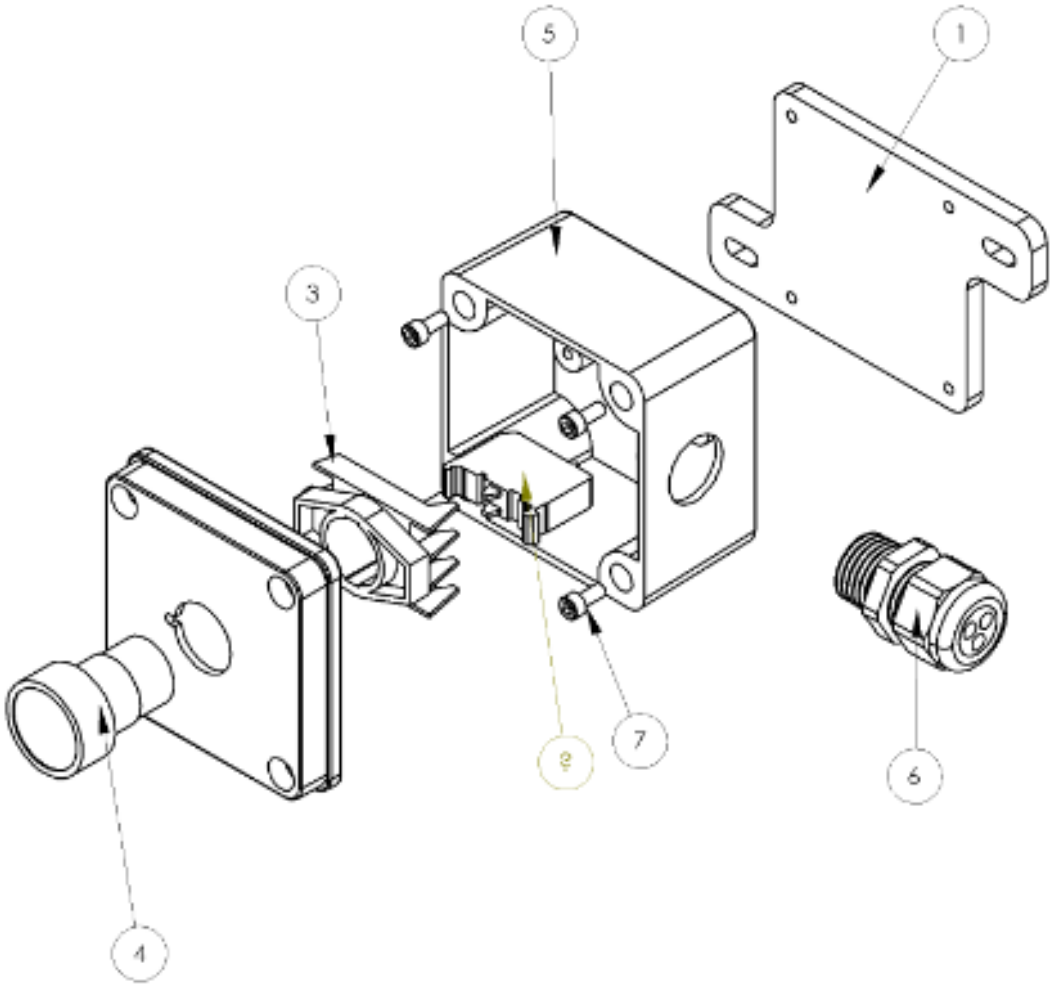
AAC Drawing Number 1390443 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	1	1335-316	ROD, SS, "L", 3/8, 4.0 X
2	1	23080	BLOCK,CLAMP,EYE
3	1	23132A	HOLDER, EYE
4	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
5	2	SSSC70040	4-40 X 5/8, SCREW,SOCKET CAP
6	2	SSSC98040	10-32 X 5/8 SOC CAP
7	2	WWF4	WASHER, FLAT, #4

13901055 Reset Button Assembly

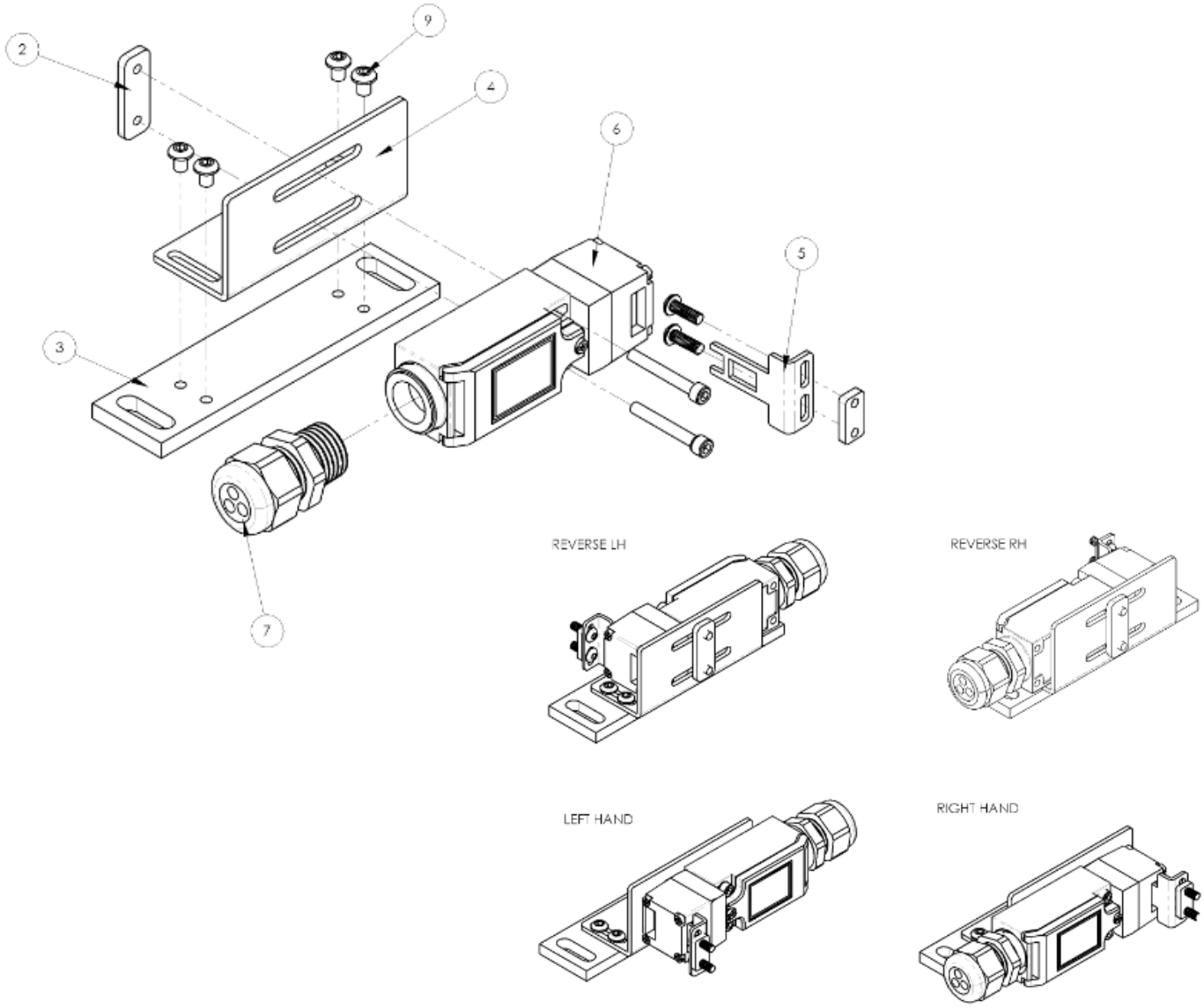
AAC Drawing Number 13901055 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	13901071	PLATE,MOUNTING,80X80 J-BOX
2	1	EE3Q10	CNTK BLOCK, N.O. (GRN) SPNG TERM
3	1	EEA3L	LATCH,PUSH BUTTON
4	1	EEPF6	PUSH BUTTON,22MM,BLUE,MO
5	1	EEPTS25302M1	BOX, 80X80X60MM, ONE BUTTON 7/8,
6	1	FFM3200GAH-SM	STRAIN RELIEF, 1/2NPT, 3 HOLE, BLK
7	4	SSSC90024	8-32 X 3/8 SOC CAP SC

13901091 Safety Interlock Switch Assembly

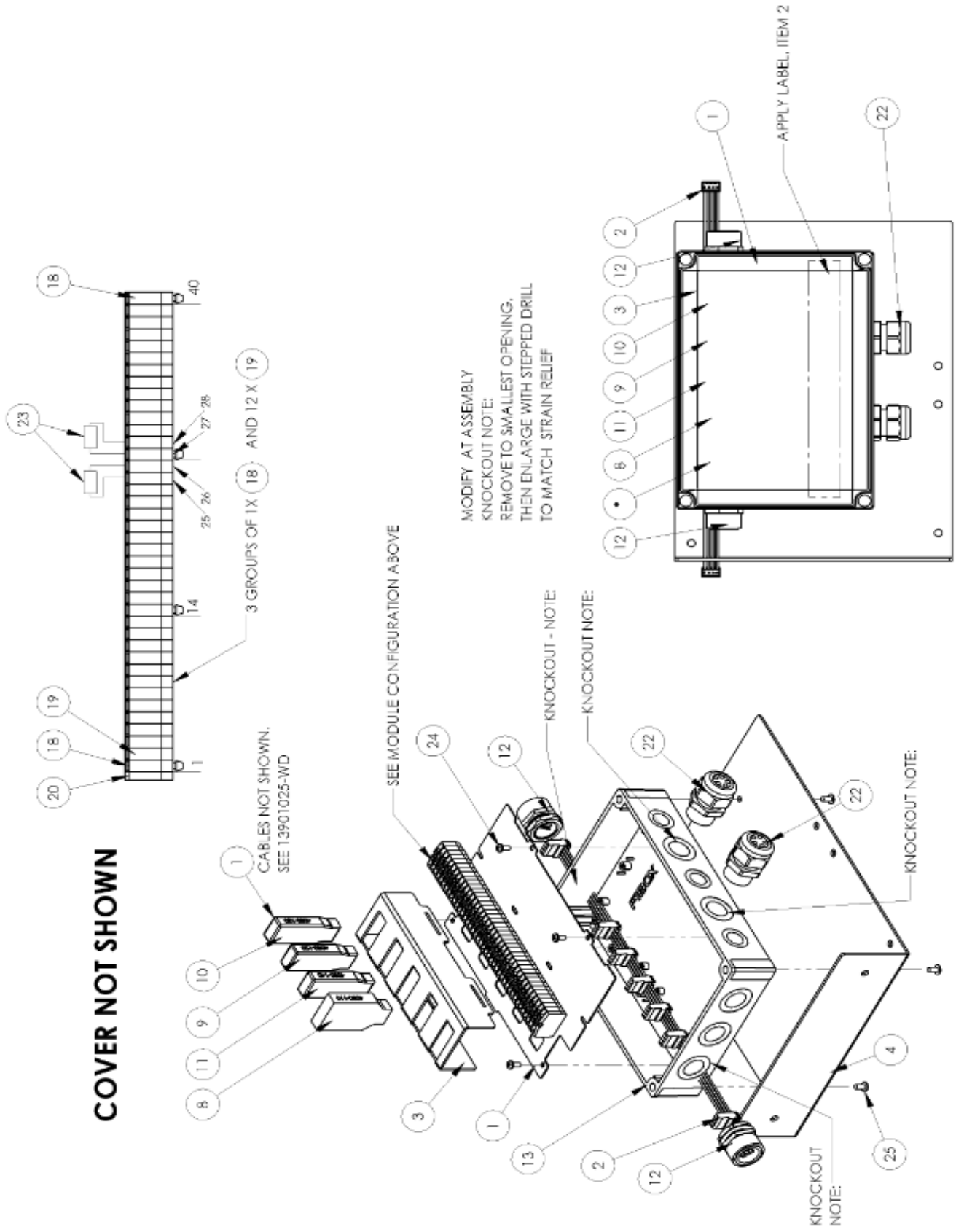
AAC Drawing Number 13901091 Rev 2



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1060008	PLATE,NUT,8-32X.50
2	1	1307374	PLATE, NUT, 8-32 X 22MM CTC X 10 GA
3	1	1318377	SAFETY SWITCH MOUNT
4	1	13901092	SAFETY SW MNT FOR EEIDIS190051
5	1	EE140103	KEY,SAFETY SW,IDIS,90 DEG
6	1	EEIDIS190051	SWITCH, SAFETY, DOOR.
7	1	FFM3200GAH-SM	STRAIN RELIEF, 1/2NPT, 3 HOLE, BLK
8	2	SSBC90032	8-32X1/2 BUTTON CAP
9	4	SSBC98016	10-32 X 1/4 BUTTON CAP SC
10	2	SSSC90080	#8-32 X 1-1/4 SOC CAP SC
11	2	WWL6	WASHER,LOCK,#6

13901207 Enclosure, S-Bus

AAC Drawing Number 13901207 Rev 0

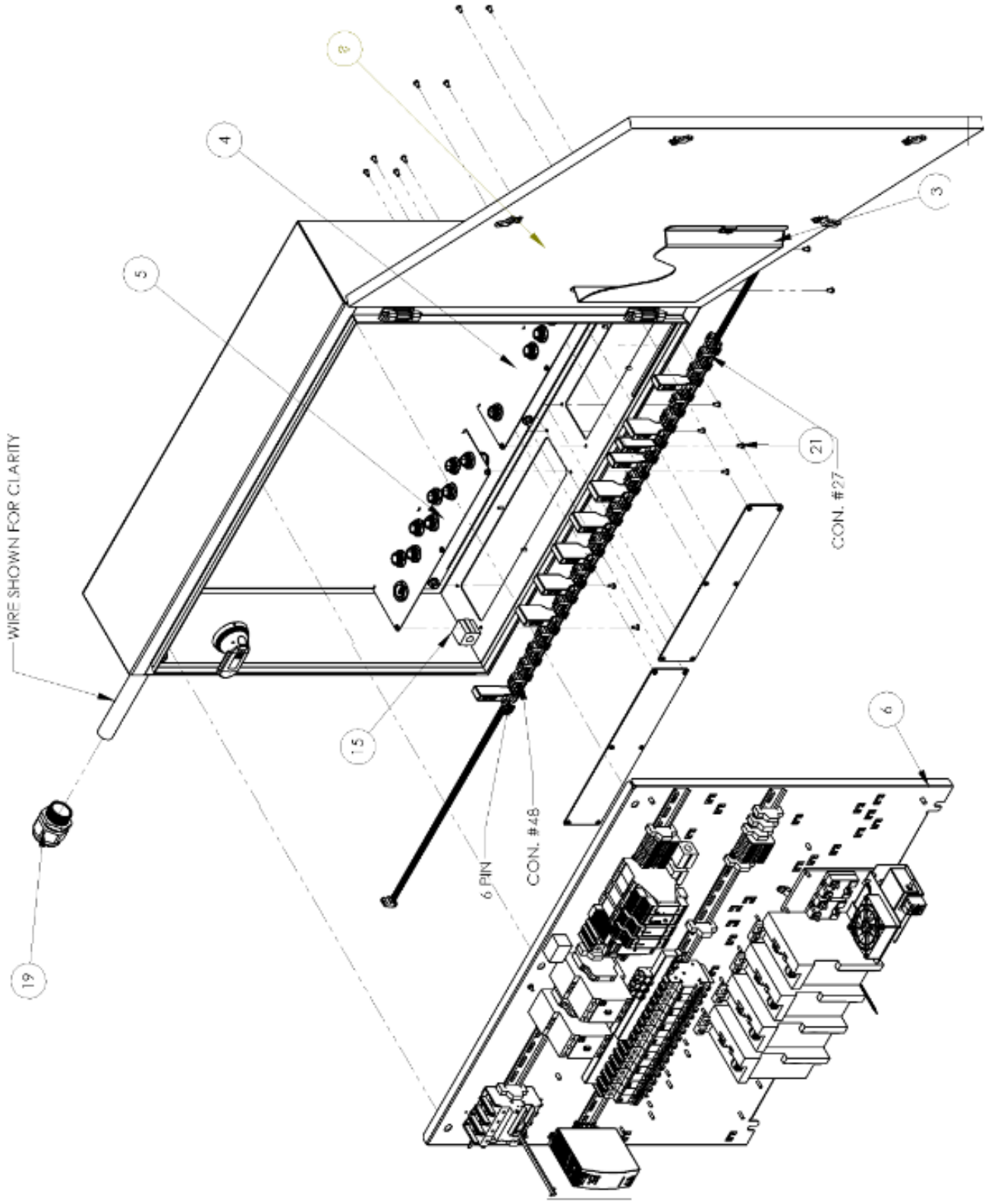


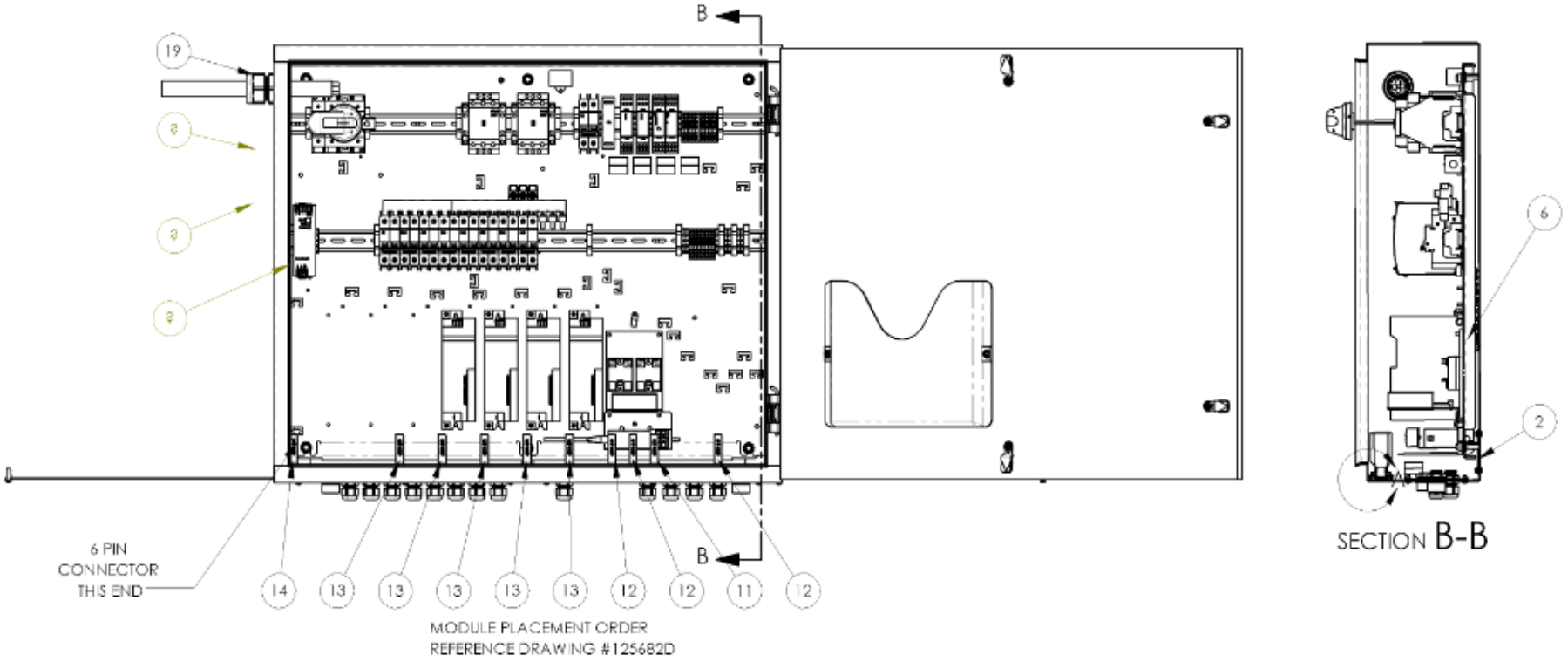
13901207 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION	ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	13901027	PLATE, SBUS HOLDDOWN, EXT	14	1	FF248-502	TERMBLK,WAGO,TP,MARK (1-10)
2	1	13901028	CABLE, SBUS, EXTERNAL CONNECT	15	1	FF248-503	TERMBLK,WAGO,TP,MARK (11-20)
3	1	13901029	COVER, SBUS MODULE GUARD	16	1	FF248-504	TERMBLK,WAGO,TP,MARK (21-30)
4	1	13901042	BRACKET, EXT CONNECTION PANEL	17	1	FF248-505	TERMBLK,WAGO,TP,MARK (31-40)
5	1	13901207-CAB	CABLE KIT - 1390 GENERIC	18	4	FF264-311	TERMBLK,WAGO,TOP,SINGLE,GRY
6	1	13901207-LAB	LABEL - 1390 EXT CONNECTION BOX	19	36	FF264-321	TERMBLK,WAGO,TP,SNGL,GRY, NO FT
7	1	13901207-WD	DIAGRAM, WIRING - EXT CONNECTION	20	1	FF264-371	TERMBLK,WAGO,TOP,END
8	1	4080-110	MODULE,QUAD INPUT	21	2	FF8465	NUT,LOCK, 3/4NPT,NYLON,BLK
9	1	4080-120	MODULE,SBUS, DUAL OPTO-ISO, INPT	22	2	FFM3234GBR-SM	STRAIN RELIEF, 3/4NPT, 5 HOLE, BLK
10	1	4080-130	MODULE,QUAD OPTO-ISO	23	2	FFR10K	RESISTOR,10K,1/4W, 5%
11	1	4080-140	MODULE,QUAD OUTPUT	24	4	SSPP90024	8-32X3/8 PAN PHLPS
12	2	4080-960	CONNECTOR, BULKHEAD, SBUS	25	4	SSPP98024	10-32 X 3/8 PAN HD PHILIP
13	1	EEPCM200100G	ENCLOSURE, PLASTIC, 255 X180X100				

13901292 Electrical Control Cabinet

AAC Drawing Number 13901292 Rev 0



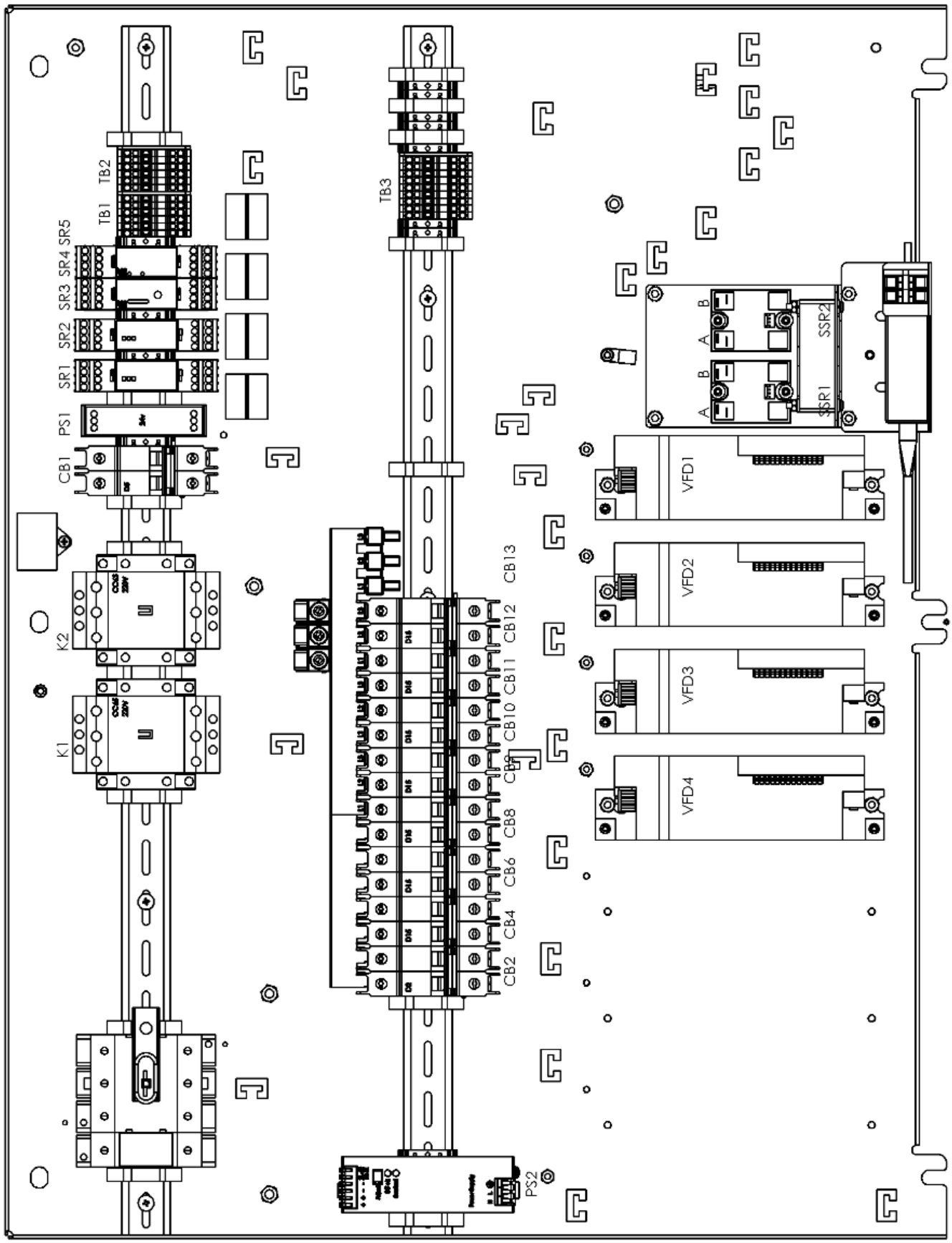


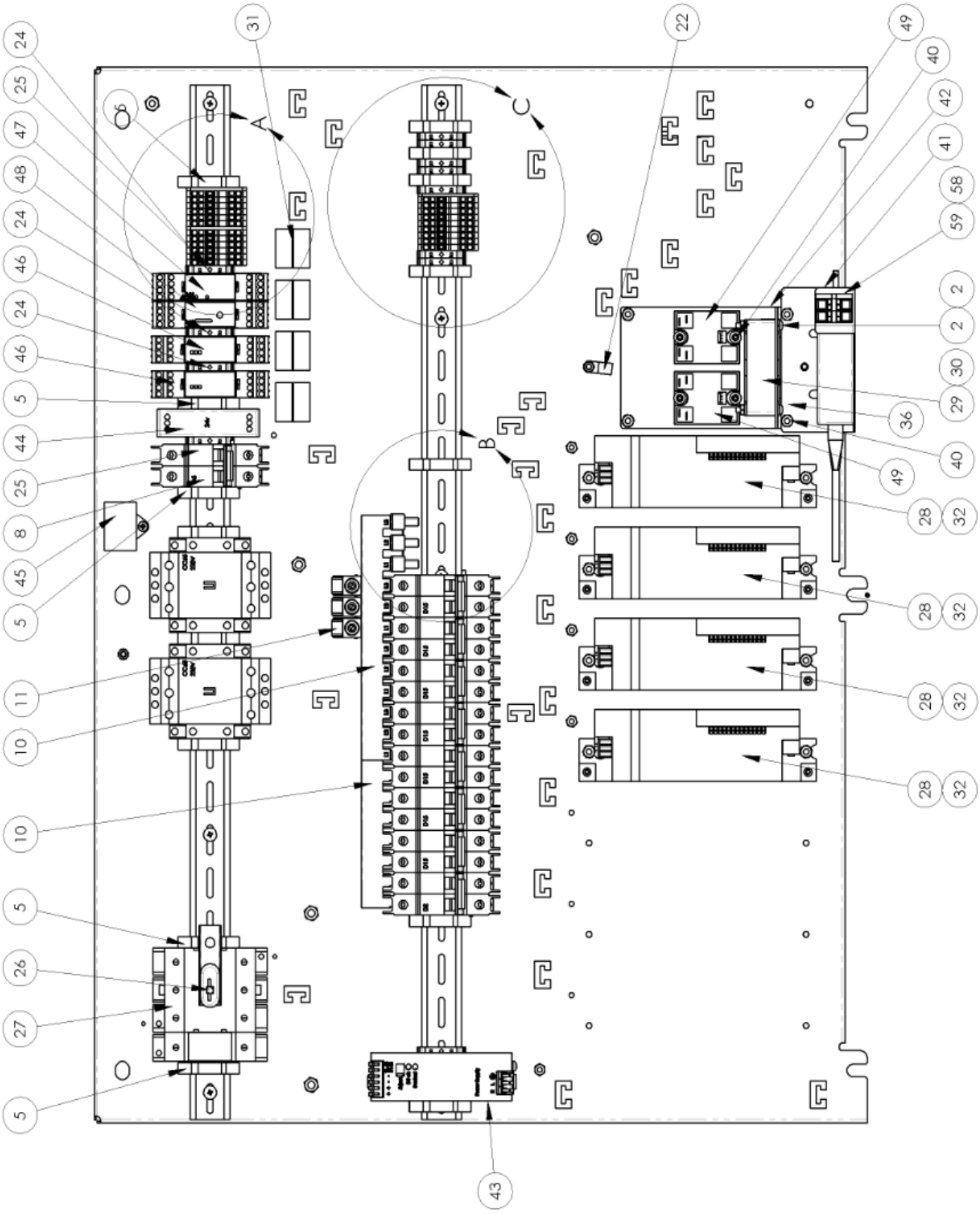
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	13061116	CABINET, 1306D GENERIC,
2	2	13901004	PLATE, INSERT, BACK 1390
3	1	13901017	SBUS ASSEMBLY, 1390 HCB GENERIC
4	1	13901208	PANEL, CABLE ENTRY, BOTTOM RIGHT
5	1	13901209	PANEL, CABLE ENTRY, BOTTOM LEFT
6	1	13901293	PANEL ELECTRICAL CNTRL 1390BA
7	1	1390BA-WD1	WIRING DIAG, CONTROL BOX, POWER
8	1	1390BA-WD2	WIRING DIAG, SBUS
9	1	1390BA-WD3	WIRING DIAGRAM, SAFE, PAUSE,
10	1	1390BA-WD4	WIRING, DIAG, SAFETY CIRCUIT
11	1	4080-110	MODULE,QUAD INPUT

ITEM	QTY	PART NUMBER	DESCRIPTION
12	3	4080-140	MODULE,QUAD OUTPUT
13	5	4080-270	MODULE,MODBUS
14	1	4080-950	MODULE,POWER
15	2	EE64151B	FERRITE CORE,SPLIT,CABLE
16	1	EEHR65	DISCONNECT HANDLE,PISTOL
17	1	FFRTV1035	SILICONE, RTV, CLEAR, NON-COROS
18	1	MM4952-1/4	TAPE,DOUBLE SIDED,1/4"W X .035 T
19	1	RBM4524	STRAIN RELIEF,1-1/4 NPT, .87-.1.26, BLK
20	1	RBM9144	LOCKNUT,NYLON,1-1/4"NPT
21	25	SSPP98024	10-32 X 3/8 PAN HD PHILIP

13901293 Panel, Electrical Control Cabinet, 1390BA

AAC Drawing Number 13901293 Rev 0




A
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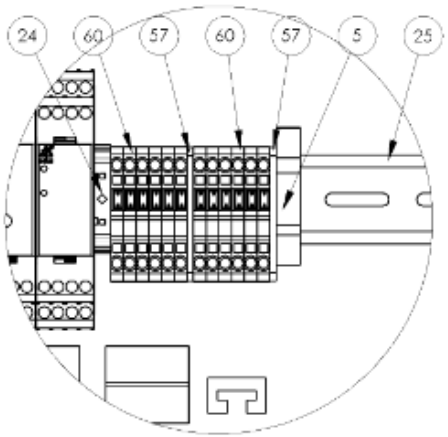
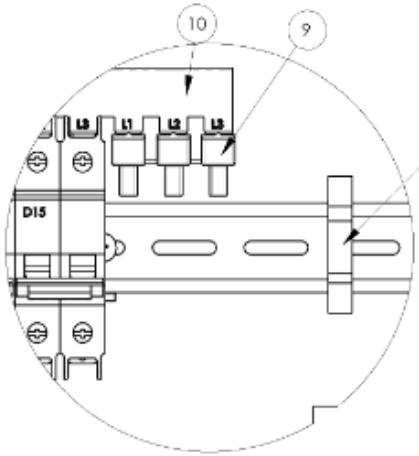
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	EEB077MD27LR	
2	4	SSPS90096	#8-32 X 1-1/2 PAN HD
3	12	SSTP98024	10-32 X 3/8, TRUSS HD SCR
4	4	SSSC80032	6-32 X 1/2 SOC CAP SC
5	15	EECLIPFIX	ANCHOR,DIN RAIL
6	1	FFFAZD22NA	BREAKER,2P, 2A,UL489,240VT-MAG
7	7	FFFAZD215NA	BREAKER,2P,15,UL489,240VT-MAG
8	1	FFFAZD52NA	BREAKER,2P,5A,UL489,
9	1	FFM9XUTC15	BREAKER,ACC,UL489,COMB,18MM,3-COVER
10	2	FFM9XUP312	BREAKER,ACC,UL489,COMB,18MM,3P12
11	3	FFM9XUPC04	BREAKER,ACC,UL489,COMB,18MM,TOP
12	AR	EE6X750	CABLE TIE, 4-0, BLACK, 18#

ITEM	QTY	PART NUMBER	DESCRIPTION
13	AR	EE6X752	CABLE TIE, 5.51, 40 LB BLACK
14	AR	EE6X753	CABLE TIE,7.40,50 LB
15	1	4080-4255	CABLE, SBUS, PAUSE/WARN, 2 COND, 3'
16	1	FF881812	CABLE,12 COND,18 AWG,300V,THICK
17	1	4080-4254	CABLE,SBUS,3 CHAN HYD CONTROL
18	1	4080-4252	CABLE,SBUS,3 CHAN SEAL BAR HEAT
19	1	4080-4253	CABLE,SBUS,3 CHAN SEAL BAR SOLN
20	5	4080-4251-12	CABLE,SBUS,MODBUS I510 DRIVE,12"
21	1	4080-4250-24	CABLE,SBUS,POWER,PS - PWR MOD,24"
22	1	AAF3/8	CLAMP, BLACK PLASTIC
23	2	EECGC85A220	CONTACTOR,65A,220VAC
24	12	FF209-120	DIN MOUNTING FOOT,SHORT

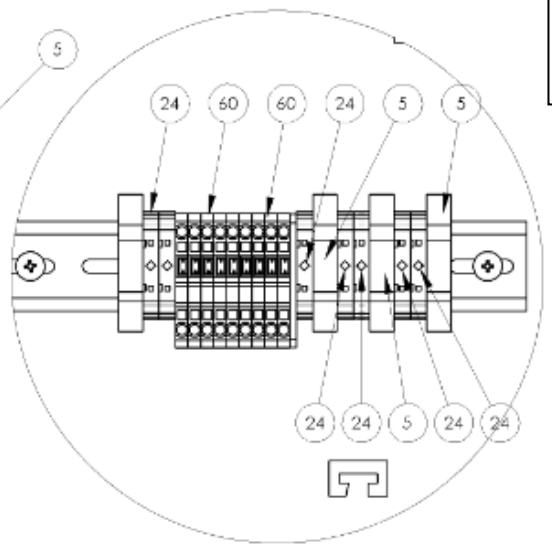
13901293 parts list



DETAIL A
SCALE 1 : 2



DETAIL B
SCALE 1 : 2



DETAIL C
SCALE 1 : 2

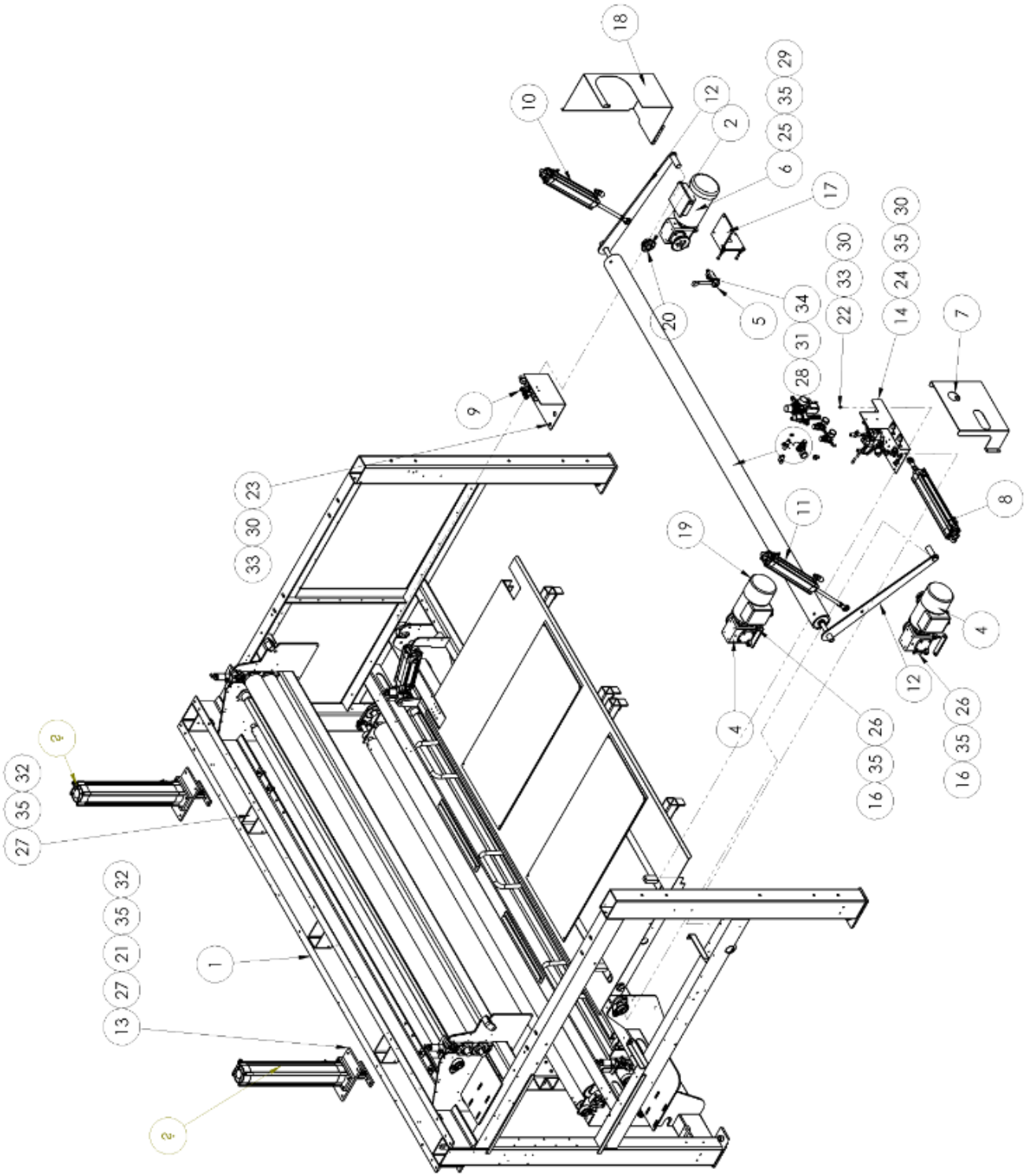
13901293 parts list continued

ITEM	QTY	PART NUMBER	DESCRIPTION
25	70"	EETS35X7.5A	DIN RAIL-AMERICAN
26	1	EESPA210-6.90	DISCONNECT SHAFT,MOD
27	1	EEM60U3M	DISCONNECT, 3PH, 60A, UL98
28	4	MM510155B1M1	DRIVE, VFD ,1510,.75HP, 240V, 1PH, NET,
29	1	FF109R0824SM1	FAN ASSY, 24V, 80MM
30	2	FF08172	FAN GUARD, 80MM, METAL
31	4	EE64151B	FERRITE CORE,SPLIT,CABLE
32	12	NNK10-32	KEP NUT, 10-32
33	1	FF793-5501	MARKER (BLANK)TERMBLK,WAGO,10X CRD
34	5	FF209-502	MARKER, WAGO,TOP, #1-10
35	1	FF209-503	MARKER,WAGO,TOP,11-20
36	1	13901078	MOUNT, FAN
37	10	NNH8-32	NUT,HEX, 8-32 REG.
38	6	NNH1/4-20	NUT,HEX,1/4-20
39	6	NNK8-32	NUT,KEP,8-32
40	1	13901011	PANEL, SUB, 1390 BASIC
41	1	13901384	PC POWER BLOCK BRACKET
42	1	13901012	PLATE, HEAT SPREADER, SINK

ITEM	QTY	PART NUMBER	DESCRIPTION
43	1	EEQS5DNET	POWER SUP,SW,24V 3.8A,85-264V,
44	1	EEMDR2024	POWER SUP,SWITCHER,24V,1.0A,DIN
45	1	EERCM601BUZ4M1	PROTECTOR, SURGE, W/RING TERMINALS
46	2	EELG5925-24	RELAY,SAFETY, 2 CHAN, 24V
47	1	EELG5929-61	RELAY,SAFETY,24V,EXTENSION,5 NO,1 NC
48	1	EELG5928-3	RELAY,SAFETY,24V,EXTENSION,DLAY
49	2	FF84140210M1	RELAY,SSR,24VAC,25A
50	1	SSPP90032	SCREW,#8-32 X 1/2, PAN HD, PHIL
51	3	TTDBNYDS218	TERM, FLAT BLADE,INS, 14 AWG,BLUE
52	3	TT552514	TERM, RING, 1/4", 14-16GA, INS BLU
53	8	TT0190670071	TERM, RING, 1/4", 6 AWG, INS BLU
54	5	TT192130011	TERM, WIRE PIN, 14-16AWG, CRIMP, BLU
55	5	TTBB5263	TERM, .25 FULLY INSUL QUICK D,
56	2	TT191930152	TERM,RING,1/4",8AWG,NON INS
57	3	FF280-308	TERMBLK ENDPLATE,WAGO,280
58	2	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
59	1	FF264-371	TERMBLK,WAGO,TOP,END
60	21	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY

13901282 Input conveyor Assembly # 2

AAC Drawing Number 13901282 Rev 0

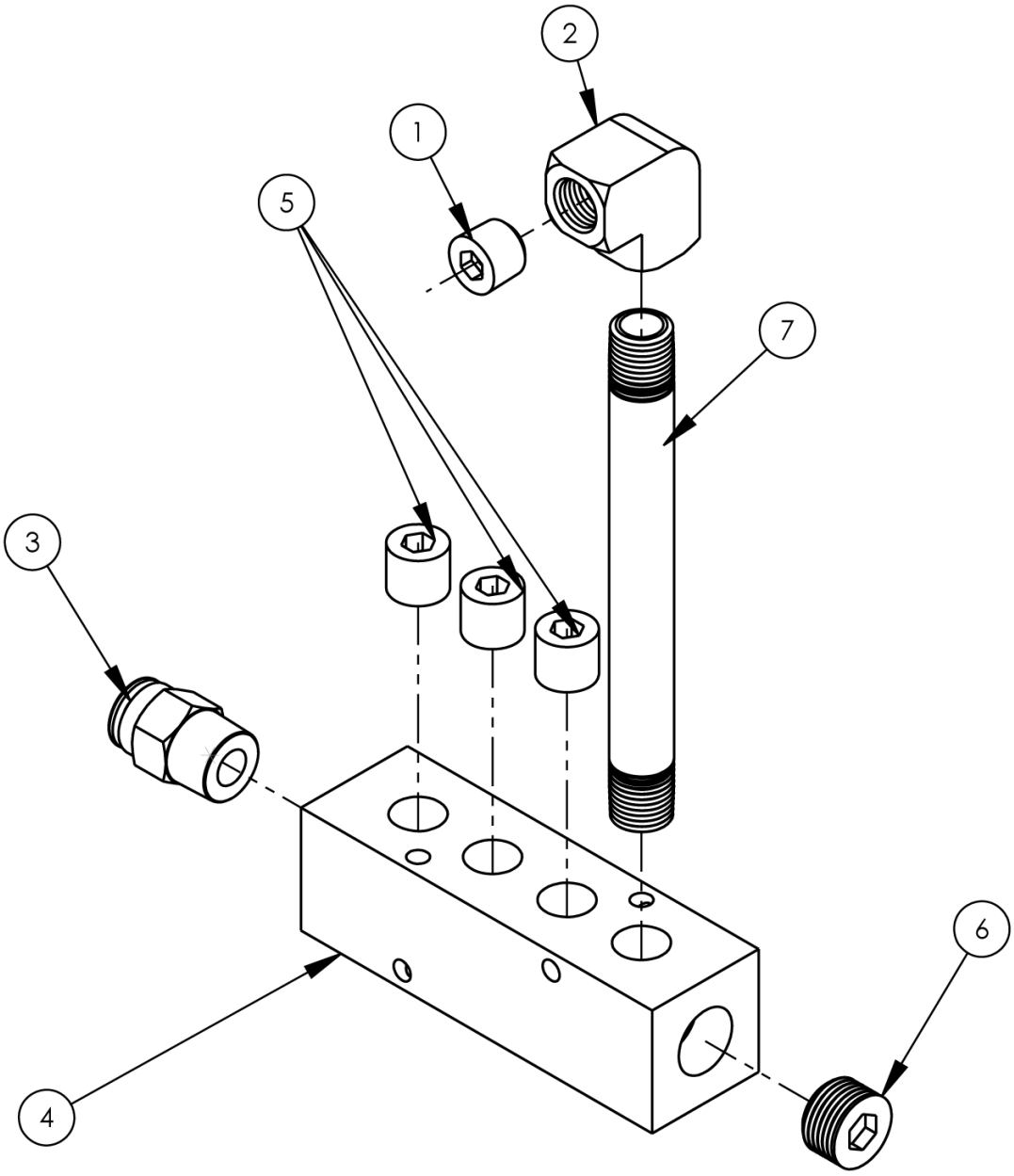


13901282 parts list

ITEM	QTY	PART NUMBER	DESCRIPTION	ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	13901283	INPUT CONVEYOR ASSY #1	19	3	MM11/4SH	HUB, TAPERLOCK
2	4	1390160	KEY, 1/4 X 1.25L	20	3	MM40SH21H	SPROCKET, 1/2 P, 21T
3	1	1390297	PVC ROLLER ASM	21	8	NNH3/8-16	NUT,HEX,3/8-16
4	2	1390473	MOTOR/REDUCER ASSY	22	2	SSHC01032	1/4-20 X 1/2 HHCS
5	1	1390498	BLOWER/MANIFOLD ASSY	23	2	SSHC01064	1/4-20 X 1 HHCS
6	1	1390979	MOTOR ASSEMBLY	24	1	SSHC25064	3/8-16 X 1,HEX CAP
7	1	1390991	GUARD,PNEUMATICS	25	4	SSHC25080	3/8-16X1-1/4 HHCS
8	1	1391032	CYLINDER ASSY-INFEED SIDE	26	8	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
9	1	1391035	VALVE ASSY, CROSS SEAL	27	8	SSHC25128	3/8-16 X 2 HEX CAP
10	1	1391062	CYL ASSY, LRG INFEED ROLL	28	2	SSSC98112	SCR, SOC CAP 10-32 X 1-3/4
11	1	1391063	CYL ASSY, LRG INFEED ROLL	29	4	WWF3/8	WASHER,FLAT,3/8 OR 10MM
12	2	1391068	ARM, PVC ROLLER	30	4	WWFS1/4	WASHER,FLAT,SAE,1/4
13	1	1391071	CYLINDER ASSY. CROSS SEAL	31	2	WWFS10	WASHER, FLAT, #10, SAE
14	1	13911013	VALVE BANK ASSEMBLY	32	17	WWFS3/8	WASHER,FLAT,SAE,3/8
15	1	1391145	CYLINDER ASSY. CROSS SEAL	33	4	WWL1/4	WASHER,LOCK, 1/4
16	4	1391177	NUT PLATE, GEAR MOTOR MTG	34	2	WWL10	WASHER,LOCK,#10
17	1	1396850	MOTOR MOUNTING ANGLE	35	21	WWL3/8	WASHER,LOCK, 3/8
18	1	1396853	GUARD, CHAIN, INFEED MTR				

1390498 Blower / Manifold Assembly

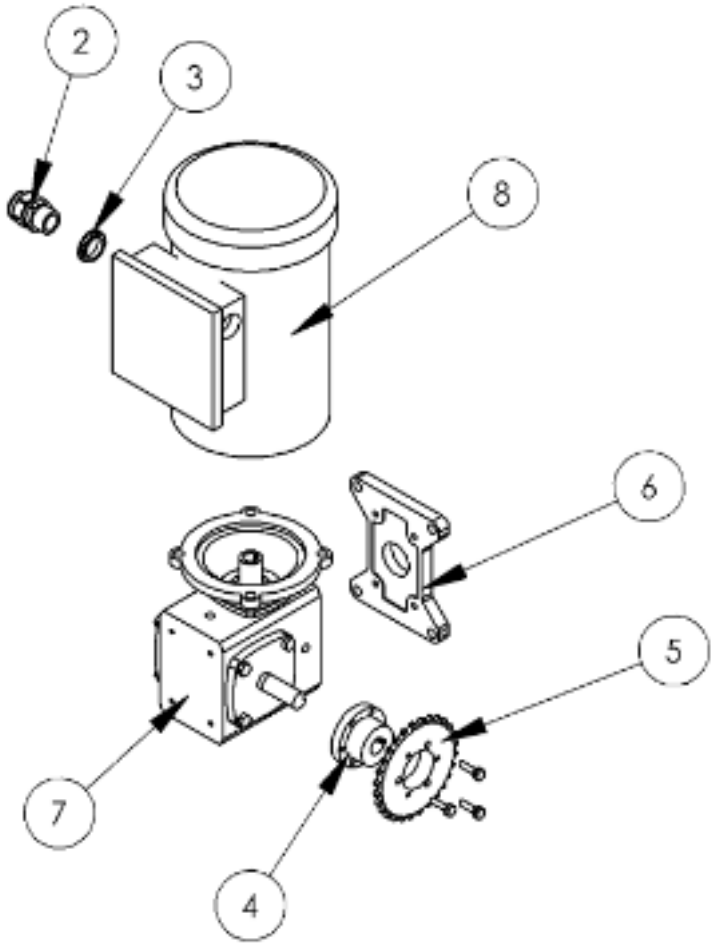
AAC Drawing Number 1390498 Rev 1



NO.	QTY	PART #	DESCRIPTION
1	1	1390350	PLUG,1/4" PIPE, MOD
2	1	AAF1/4-BFF	90 DEG ECONO ELBOW, NPTF, 1/4"
3	1	AAQMC-3-3S	FITTING,STRT,3/8NPT,3/8
4	1	AAVM4A	MANIFOLD, 3/8 X 1/4
5	3	MM4554K12	PLUG, 1/4" PIPE
6	1	MM4638K513	PLUG,3/8",HEX SOCKET
7	1	AAF112A-B	NIPPLE,1/4 NPT

1390979 Motor Assembly

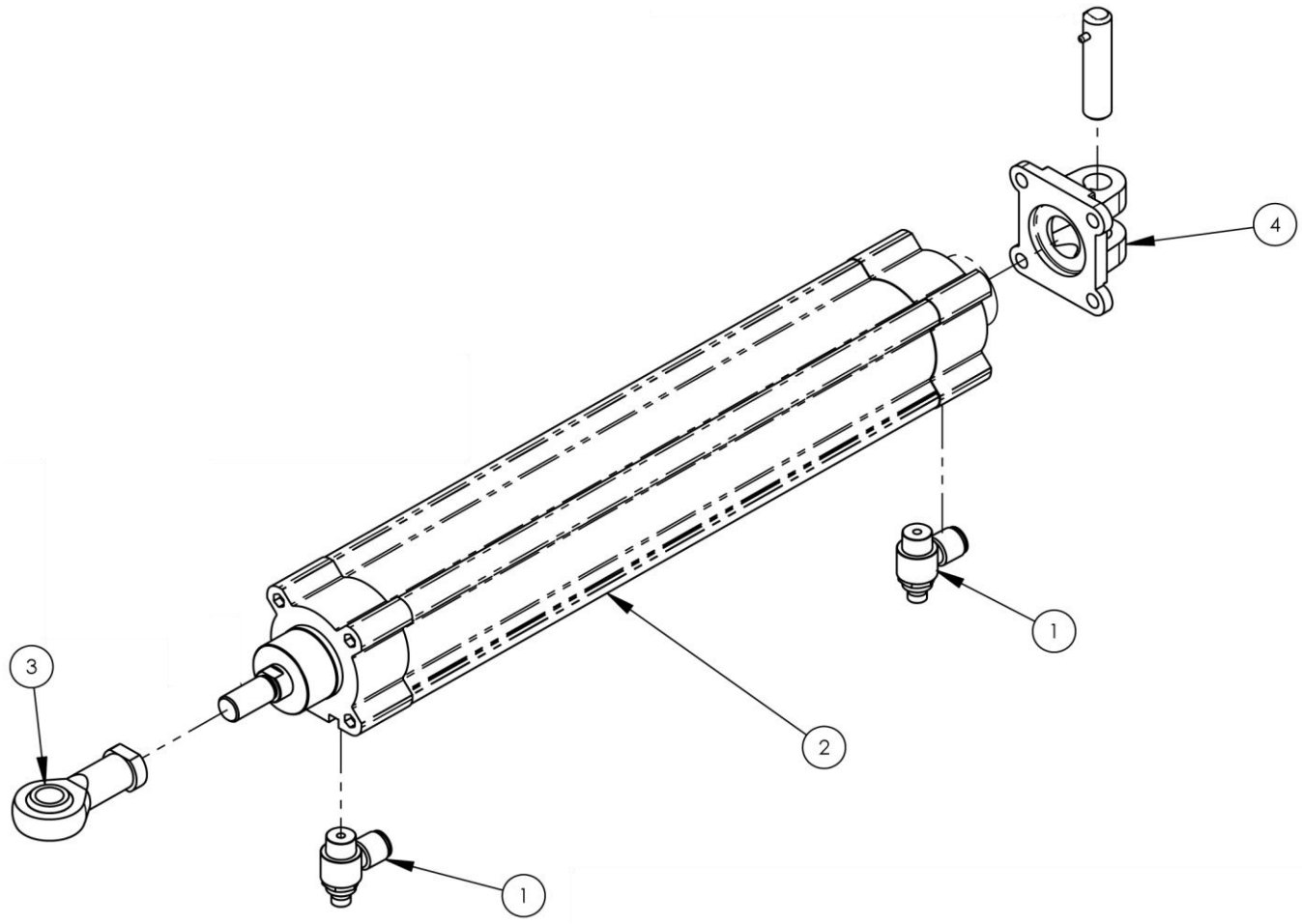
AAC Drawing Number 1390979 Rev 0



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	51494	LUBRICANT,MOBIL SHC634
2	1	FF3460	STRAIN RELIEF,LIQ TIGHT, 3/4NP
3	1	FF8465	NUT,LOCK, 3/4NPT,NYLON,BLK
4	1	MM3/4SH	HUB, TAPERLOCK
5	1	MM40SH28H	SPROCKET, 1/2 P, 28T
6	1	MM56438	HORIZONTAL BASE,CI U
7	1	MMF71520B5J	SPEED REDUCER,WORM,
8	1	MMVM3542	MOTOR,3PH,3/4HP,230/460V

1391032 Cylinder Assembly, Infeed Side

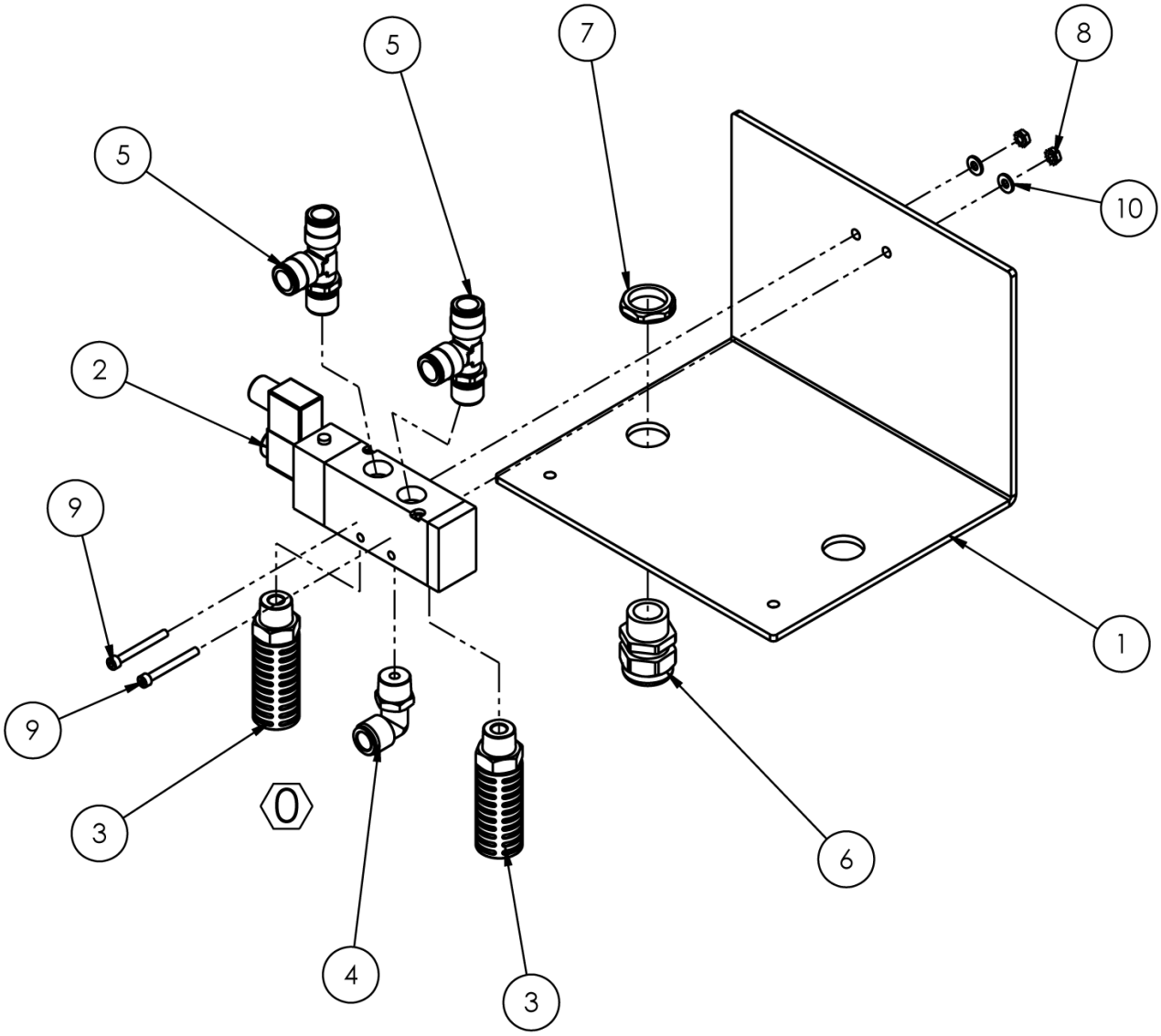
AAC Drawing Number 1391032 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	2	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8
2	1	AACDNCB63380PPV	CYLINDER,AIR,ISO,63BX380S
3	1	AAFSGSM16x15	BEARING,ROD END, FOR DNCB50
4	1	AAFSNC63	REAR PIVOT BRKT, 63MM BORE FESTO

1391035 Cross Seal Valve Assembly

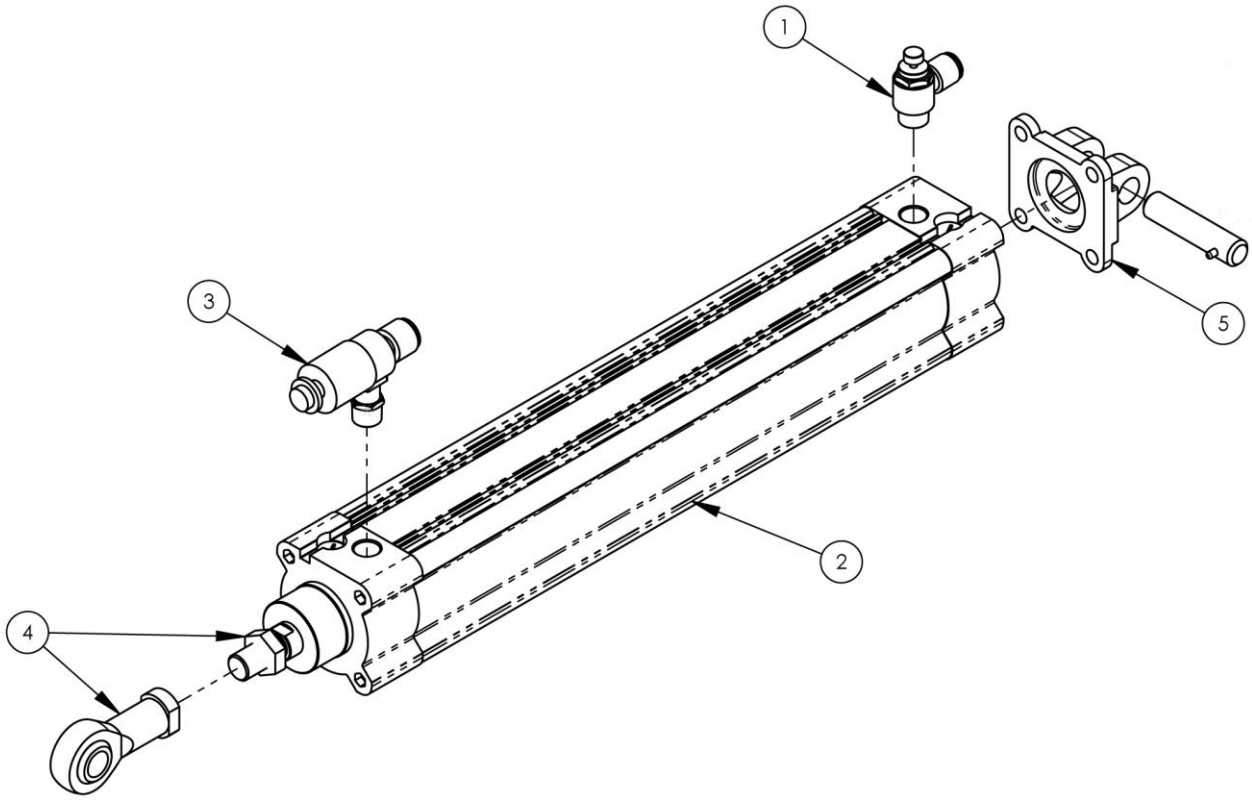
AAC Drawing Number 1391035 Rev 1



NO.	QTY	PART #	DESCRIPTION
1	1	1391086	MOUNT, VALVE,JUNCTION BOX
2	1	AAE4V41015	VALVE, 1/2" PORTED, 24VDC
3	2	AAFAN400N04	MUFFLER,1/2NPT,PLASTIC
4	1	AAQME-2-2S	FITTING,ELBOW,1/2NPT,1/2
5	2	AAQMT-2-2S	TEE,1/2NPT-1/2 TUBE
6	1	FF3234	STRAIN RELIEF,LIQ TIGHT
7	1	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK
8	2	NNK10-32	KEP NUT, 10-32
9	2	SSSC98112	SCR, SOC CAP 10-32 X 1-3/4
10	2	WWFS10	WASHER, FLAT, #10, SAE

1391062 Cylinder Assembly, Large Infeed Roll

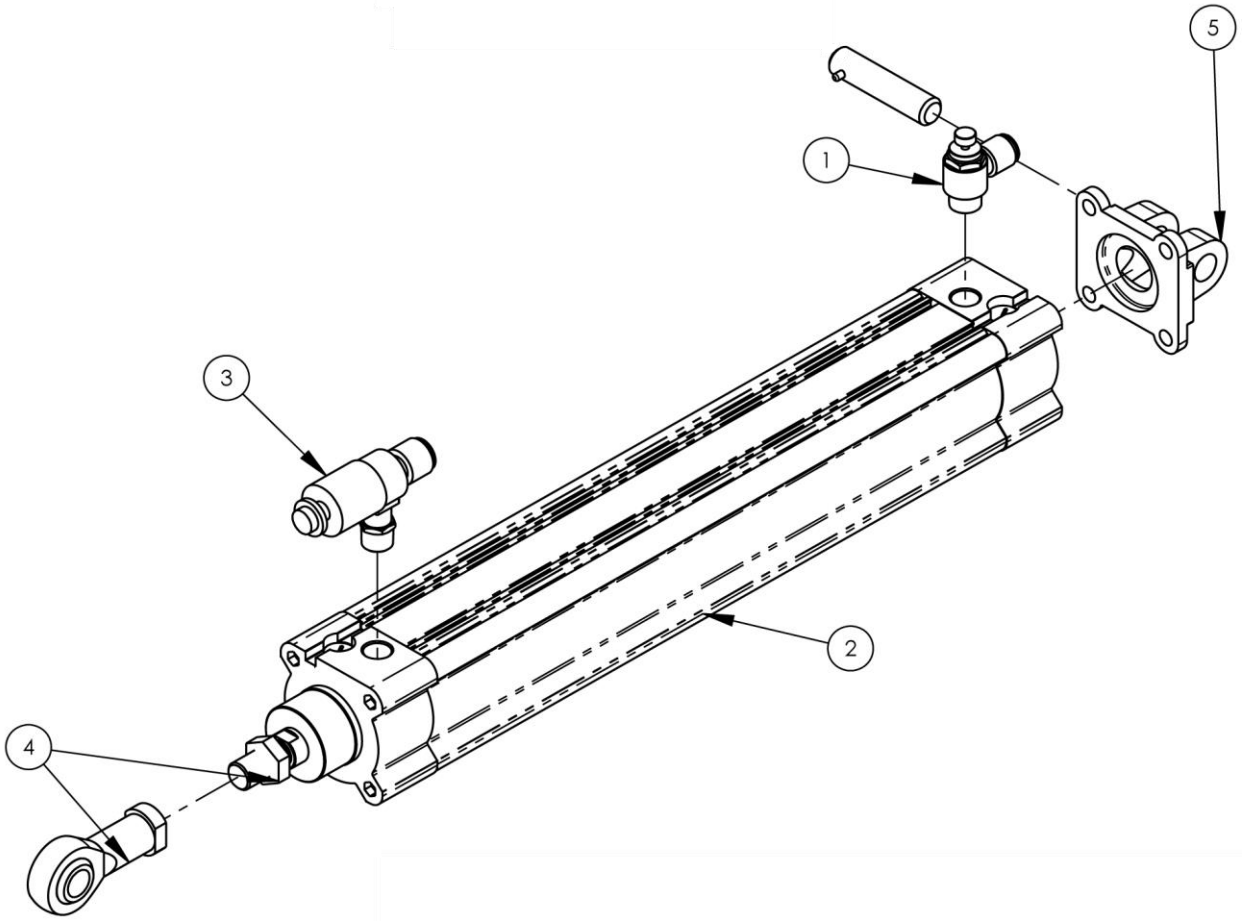
AAC Drawing Number 1391062 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	1	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8
2	1	AACDNCB63380PPV	CYLINDER,AIR,ISO,63BX380S
3	1	AAFASV510F3R	QUICK EXHAUST,3/8R,3/8T
4	1	AAFSGSM16x15	BEARING,ROD END, FOR DNCB50
5	1	AAFSNC63	REAR PIVOT BRKT, 63MM BORE FESTO

1391063 Cylinder Assembly, Large Infeed Roll

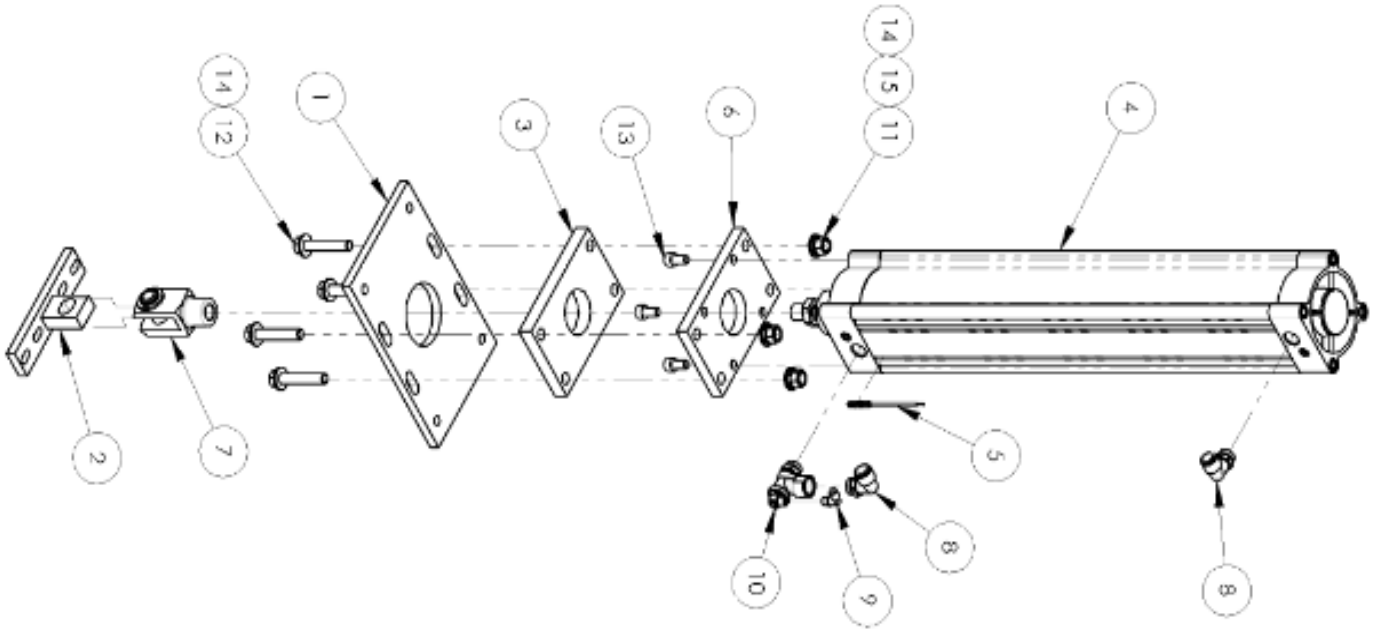
AAC Drawing Number 1391063 Rev 1



NO.	QTY	PART #	DESCRIPTION
1	1	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8
2	1	AACDNCB63380PPV	CYLINDER,AIR,ISO,63BX380S
3	1	AAFASV510F3R	QUICK EXHAUST,3/8R,3/8T
4	1	AAFSGSM16x15	BEARING,ROD END, FOR DNCB50
5	1	AAFSNC63	REAR PIVOT BRKT, 63MM BORE FESTO

1391071 Cross Seal Cylinder Assembly

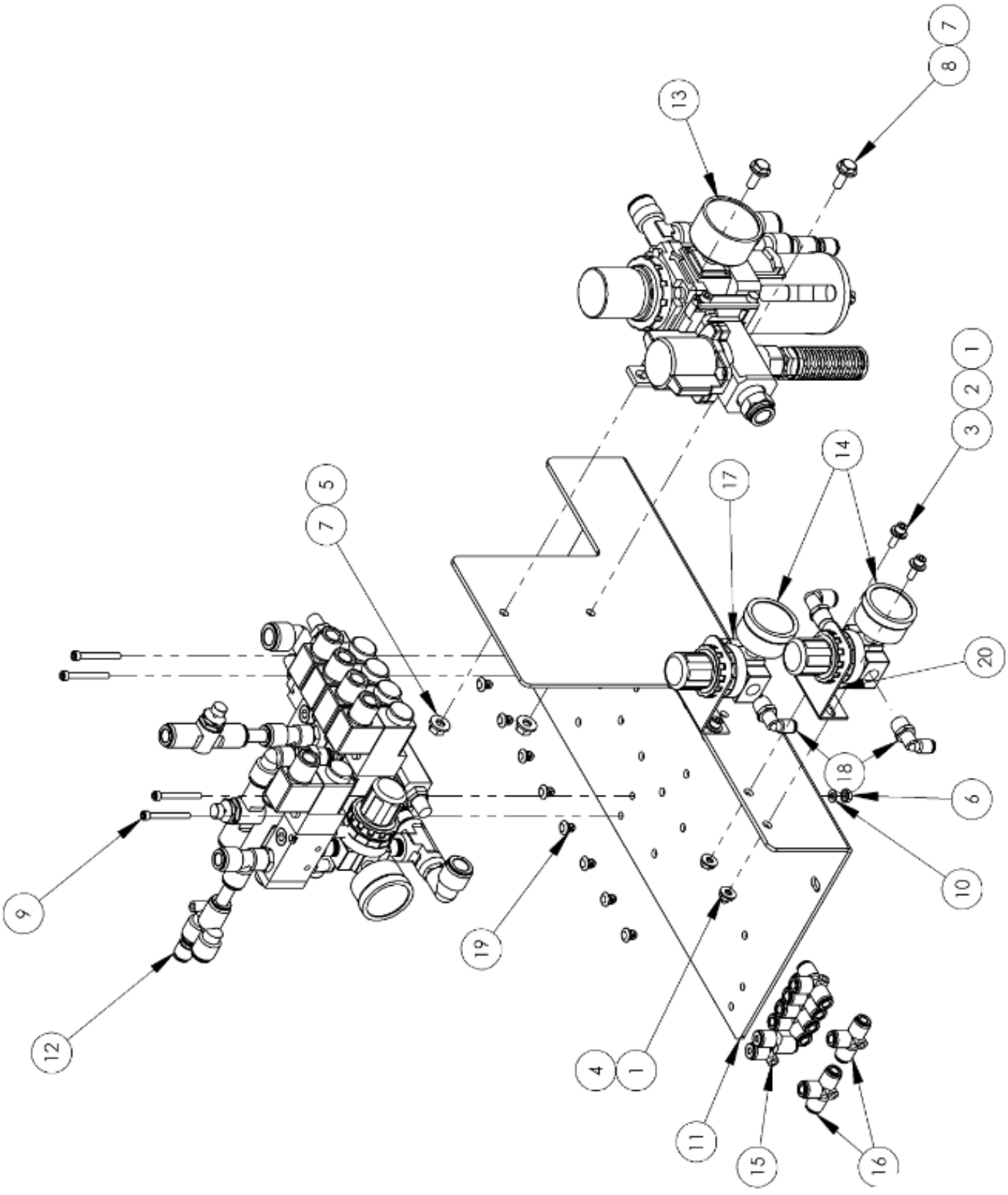
AAC Drawing Number 1391071 Rev 2



ITEM #	QTY.	PART #	DESCRIPTION
1	1	1391072	CYLINDER MOUNT PLATE-END
2	1	1391073	CROSS SEAL CYL. MNT
3	1	1391075	SPACER,MOUNTING PLT,- DNC
4	1	AACDNCB100600PP	CYLINDER, AIR, ISO, 100BX600 METRIC ISO
5	AR*	AAESME8MDS24	SENSOR FOR FESTO ISO CYL
6	1	AAFNC100	FLANGE,MOUNTING PLT,- DNCB100610
7	1	AAFSGM20X15	CLEVIS,ROD,M20 X 1.5
8	2	AAQME-2-2U	FITTING, 1/2T-1/2 UNIFIT
9	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
10	1	AAV78862121	VALVE, BLOCKING, R1/2
11	4	NNH1/2-13	NUT,HEX,1/2-13
12	4	SSHC45176	1/2-13X2-3/4 HEX CAP
13	4	SSSCM10X20	CAP SCREW 10MM X 20MM
14	8	WWFS1/2	WASHER,FLAT,1/2, SAE
15	4	WWL1/2	1/2 LOCK WASHER

13911013 Valve Bank Assembly

AAC Drawing Number 13911013 Rev 0

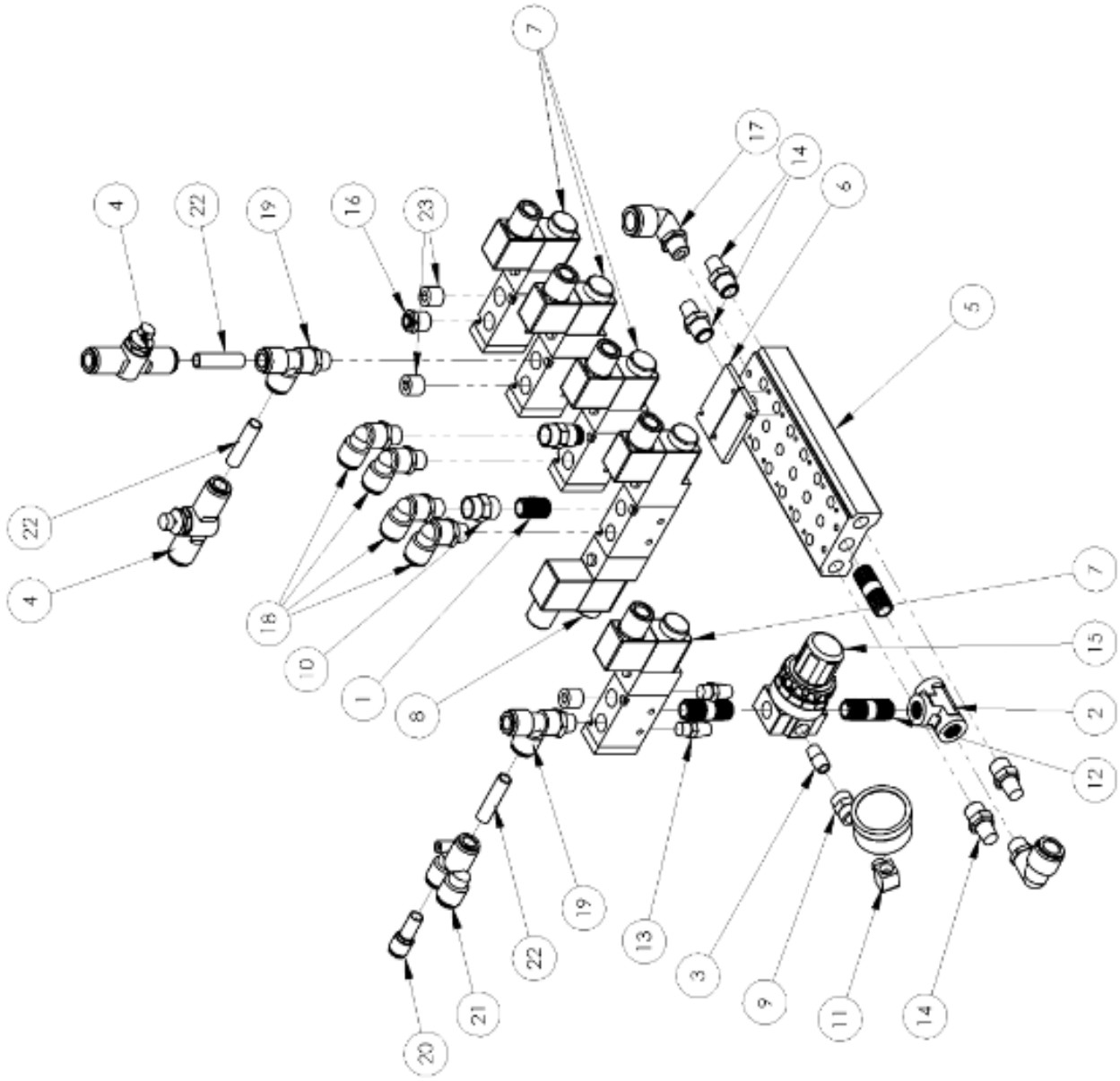


13911013 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION	ITEM	QTY.	PART NUMBER	DESCRIPTION
1	8	WWFS10	WASHER, FLAT, #10, SAE	11	1	1391105	PLATE, MOUNTING
2	4	WWL10	WASHER,LOCK,#10	12	1	13911014	VALVE STACK ASSY
3	4	SSSC98040	10-32 X 5/8 SOC CAP	13	1	1391116	MAIN REGULATOR ASSEMBLY
4	4	NNK10-32	KEP NUT, 10-32	14	2	AAMSR20008	REGULATOR, 0-140 PSI RELIEVING, W/BRKT,
5	2	NNK1/4-20	KEP NUT, 1/4-20	15	1	AAQUY-5-4	Y UNION, 5/32X1/4
6	4	NNK8-32	KEP NUT, 8-32	16	6	AAQUT-4-4	QUICK UNION T 1/4X1/4
7	4	WWFS1/4	WASHER,FLAT,SAE,1/4	17	2	AAQME-4-4	ELBOW, MALE,Q, 1/4 TUBE, 1/4 NPT
8	2	SSHC01048	1/4-20 X 3/4 HEX CAP	18	2	AAQME-5-4	ELBOW, QUICK MALE, 5/32 X 1/4 NPT
9	4	SSSC90096	#8-32 X 1-1/2 SOC CAP SC	19	8	EEPBMSH25C	MOUNT,CABLE TIE,NYLON
10	4	WWF8	WASHER, FLAT, #8	20	2	4130-002	BRACKET, REGULATOR

13911014 Valve Stack Assembly

AAAC Drawing Number 13911014 Rev



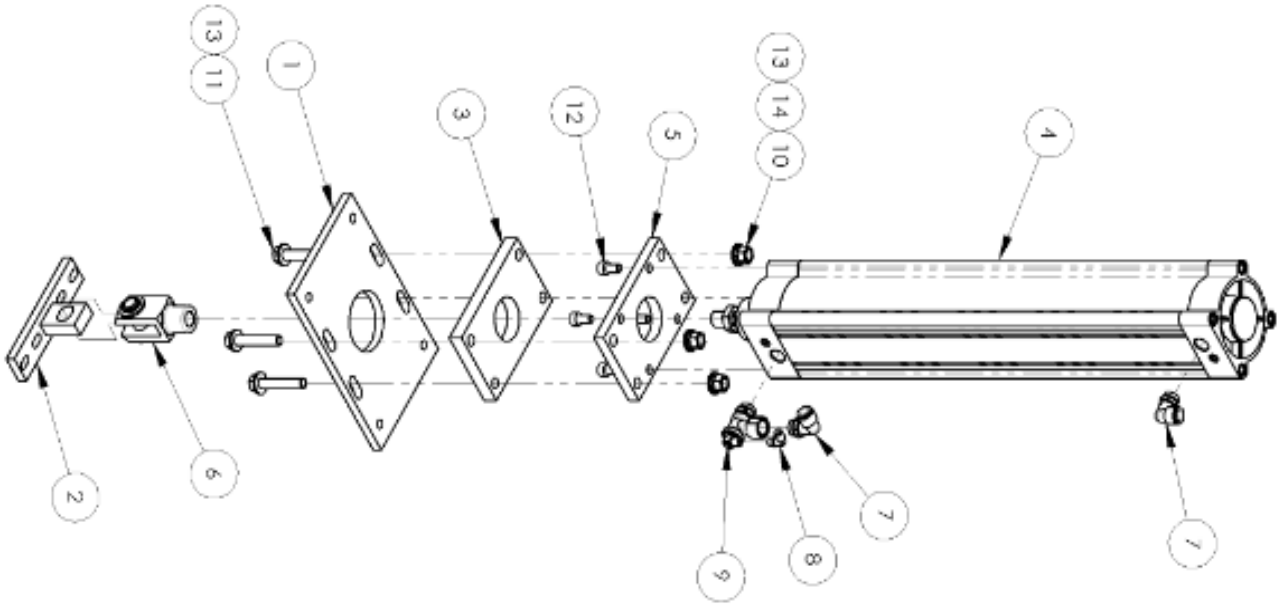
13911014 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	2156	FTG,GALV,NPPL,CLOSE,1/4
2	1	2289	FTG,GALV,TEE,1/4
3	1	273-4-504	CLOSE NIPPLE
4	2	AA3001F-11	FLOW CONT,INLINE,3/8 LINE
5	1	AAE4V200M6	MANIFOLD, 6 STATION
6	2	AAE4V200MB	MANIFOLD, BLANK PLATE
7	4	AAE4V21008	VALVE, 1/4" PORTED, 24VDC
8	1	AAE4V230C08	VALVE, 1/4",24VDC,CNTR BK
9	1	AAF207P-2	COUPLING,1/8 NPT,FEMALE
10	2	AAF207P-4	COUPLING,1/4 NPT,FEMALE
11	1	AAF23400-2	"L",BRASS,1/8 FM - 1/8 M
12	3	AAF4549K532	NIPPLE,1/4NPT X 1.5L

ITEM	QTY.	PART NUMBER	DESCRIPTION
13	2	AAFP18	MUFFLER,1/8 NPT, BRONZ
14	4	AAFP28	MUFFLER,1/4 NPT
15	1	AAMSR20008	REGULATOR, 0-140 PSI RELIEVING, W/BRKT,
16	1	AAQMC-4-4	Male Connector
17	2	AAQME-4-2S	FITTING,ELBOW,1/4NPT,1/2
18	4	AAQME-4-3S	FITTING,ELBOW,1/4NPT,3/8
19	2	AAQMT-4-3S	TEE,1/4NPT-3/8 TUBE
20	1	AAQPR-3-4	QUICK REDUCER 3/8-1/4
21	1	AAQUY-3-3	QUICK UNION Y 3/8 X 3/8
22	6"	AATP3/8	3/8" OD POLYURETHANE
23	3	MM4554K12	PLUG, 1/4" PIPE

1391145 Cross Seal Cylinder Assembly

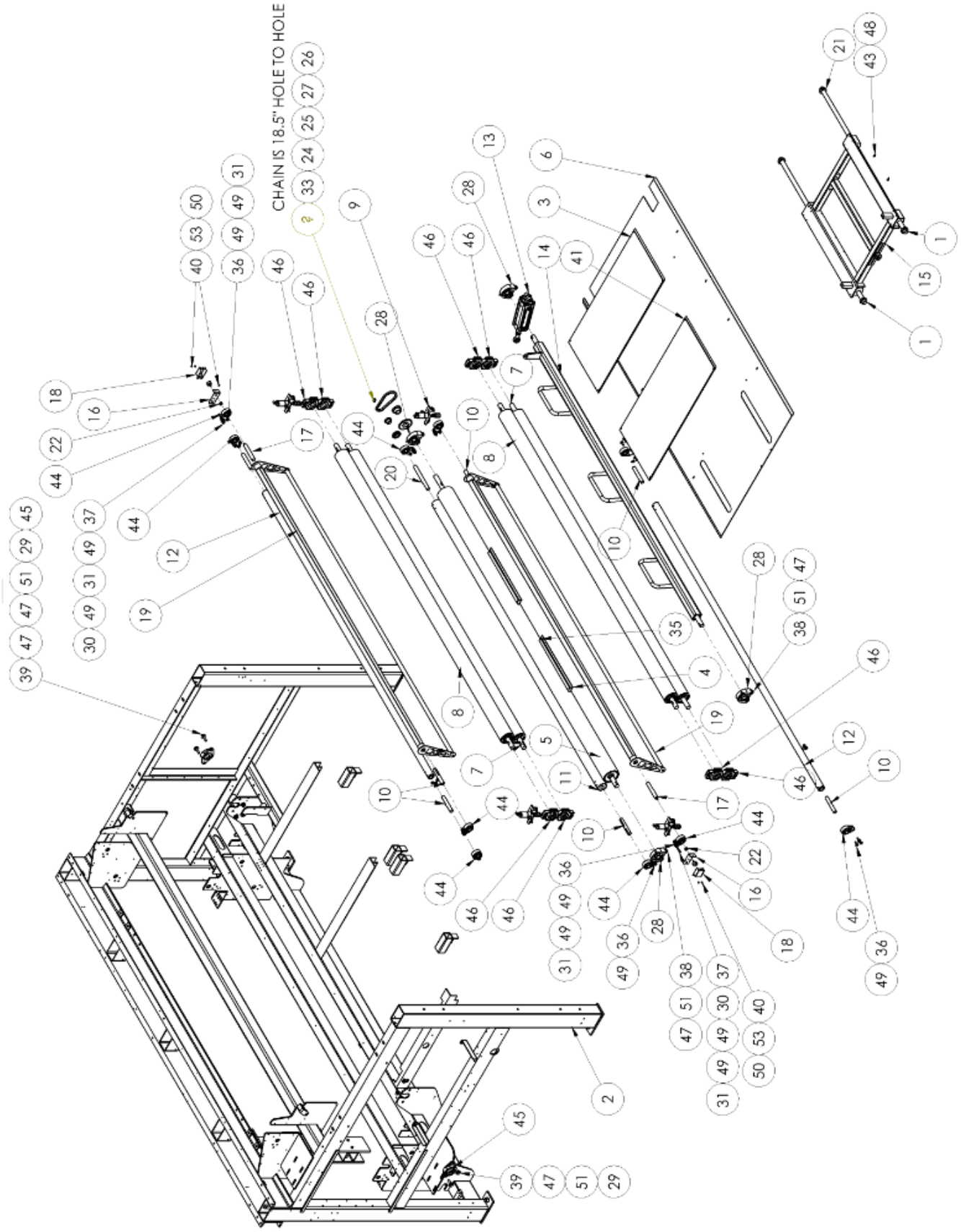
AAC Drawing Number 1391145 Rev 2



ITEM #	QTY.	PART #	DESCRIPTION
1	1	1391072	CYLINDER MOUNT PLATE-END
2	1	1391073	CROSS SEAL CYL. MNT
3	1	1391075	SPACER,MOUNTING PLT,- DNC
4	1	AACDNCB100600PP	CYLINDER, AIR, ISO, 100BX600 METRIC ISO
5	1	AAFNC100	FLANGE,MOUNTING PLT,- DNCB100610
6	1	AAFSGM20X15	CLEVIS,ROD,M20 X 1.5
7	2	AAQME-2-2U	FITTING, 1/2T-1/2 UNIFIT
8	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT
9	1	AAV78862121	VALVE, BLOCKING, R1/2
10	4	NNH1/2-13	NUT,HEX,1/2-13
11	4	SSHC45176	1/2-13X2-3/4 HEX CAP
12	4	SSSCM10X20	CAP SCREW 10MM X 20MM
13	8	WWFS1/2	WASHER,FLAT,1/2, SAE
14	4	WWL1/2	1/2 LOCK WASHER

13901283 Input Conveyor # 1

AAC Drawing Number 13901283 Rev 0



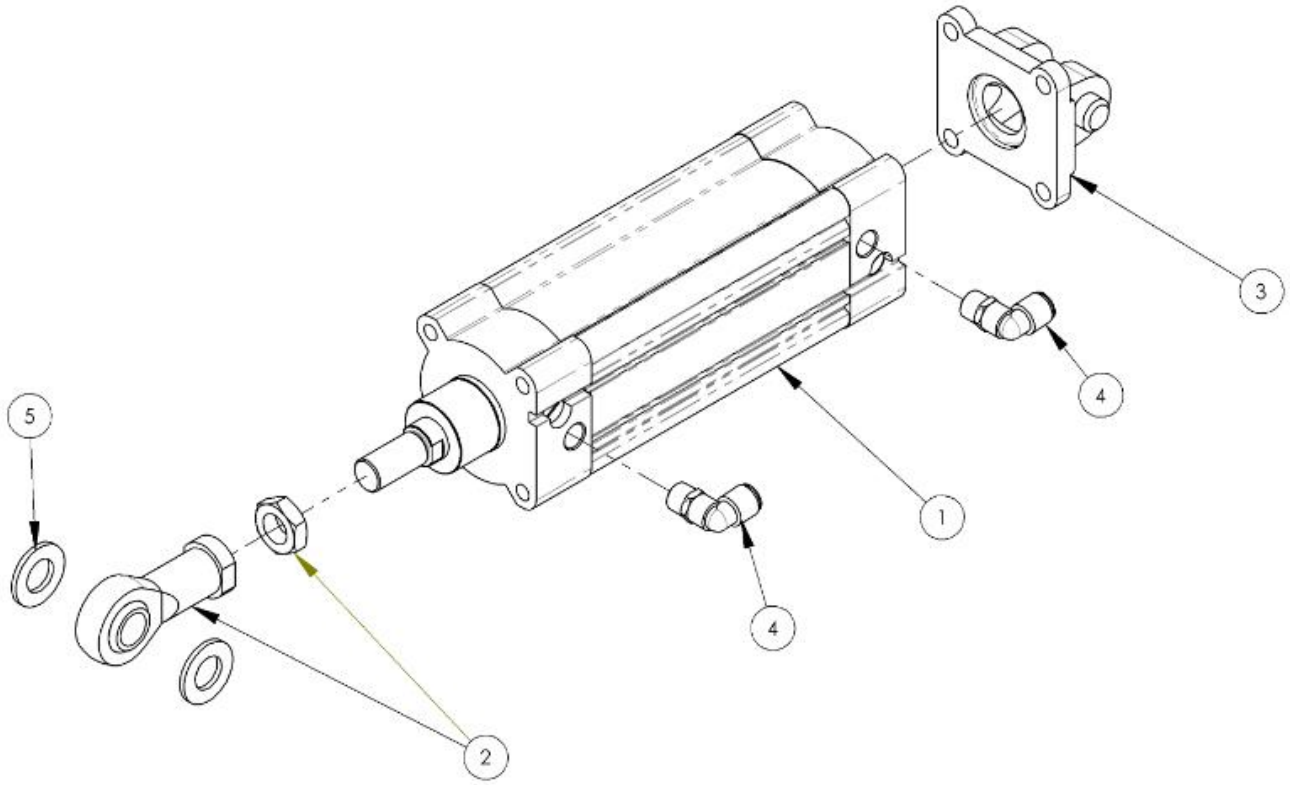
13901283 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	2	1390026	ROD,THOMSON,1-1/4ODX61"L
2	1	13901284	FRAME, INPUT, WELDMENT
3	2	1390165	FOUNDATION PLATE
4	2	1390178	BELT SPACER-IN-FEED
5	1	1390224	ROLLER, DRIVE ASSY
6	1	1390310	PLATE, TOP
7	2	1390360	ROLLER ASSY,4-1/4",DRIVE
8	2	1390365	ROLLER ASSY,4-1/4",IDLER
9	4	1390378	PINCH ROLLER AIR CLAMP
10	7	1390491	SHAFT, STUD
11	1	1390698	ROLLER, IDLER, FILM
12	2	1390699	WELDMENT, IDLER ROLLER
13	1	1391077	GATE PIVOT CYLINDER ASSY
14	1	1391078	BAR, STOP.ASSM
15	1	1391081	INPUT CARRIAGE ASSY
16	2	1391132	BRACKET, POT MNT.
17	2	1391133	SHAFT, DANCER BAR
18	2	1391147	COVER-POT, DANCER ARM
19	2	1391151	BAR,DANCER ASBLY
20	1	1391432	SHAFT, STUD, LONG
21	4	CCCL20F	COLLAR,1 1/4" CLAMP TYPE
22	2	CCCL6F	CLAMP COLLAR- 3/8
23	AR	FF6657S1102	POTENTIOMETER,PREC,1K
24	1	MM11/4SH	HUB, TAPERLOCK
25	1	MM1JA	HUB, TAPERLOCK,1 B
26	1	MM40JA15H	SPROCKET, 1/2 P, 15T
27	1	MM40SH25H	SPROCKET, 1/2 P, 25T

ITEM	QTY.	PART NUMBER	DESCRIPTION
28	4	MMUCPA207-20	1.25" BEARING
29	4	NNH1/2-13	NUT,HEX,1/2-13
30	2	NNH5/16-18	NUT,HEX, 5/16-18
31	30	NNK5/16-18	NUT,KEP,5/16-18
32	1	NNK8-32	NUT,KEP,8-32
33	*18.5"	PPP40	CHAIN,#40 RIVET
34	1	PPP40CL	LINK, CONNECTING, #40
35	4	SSFC98048	#10-32 X .75 SHCSF
36	28	SSHC10080	HEX HEAD, 5/16-18 X 1-1/4
37	2	SSHC10224F	5/16-18 X 3.5 HEX CAP
38	8	SSHC45080	1/2-13X1-1/4 HEX CAP
39	4	SSHC45128	1/2-13 X 2,HEX CAP
40	6	SSPS90024	SCREW, #8-32 X 3/8 LG PAN HD
41	8	SSPS98032	10-32X1/2 PAN HD SLOT
42	1	SSSC90048	#8-32 X 3/4 SOC CAP SC
43	2	SSSC95048	10-24 X 3/4, SOC CAP
44	10	UUCFB205-16	BEARING, FLANGE, 3 BOLT
45	2	UUCFL207-20	1.25" BEARING, FLANGE
46	8	UUCT207-20	PEER207-TAKEUP-BEARING
47	16	WWF1/2	WASHER,FLAT,1/2
48	2	WWF10	WASHER, FLAT, #10, COM
49	60	WWF5/16	WASHER,FLAT,5/16
50	6	WWF8	WASHER, FLAT, #8
51	12	WWL1/2	1/2 LOCK WASHER
52	2	WWL10	WASHER,LOCK,#10
53	6	WWL8	WASHER,LOCK,#8
54	*305"	ZZZSH-310	DOUBLE SIDED TAPE

1391077 Gate Pivot Cylinder Assembly

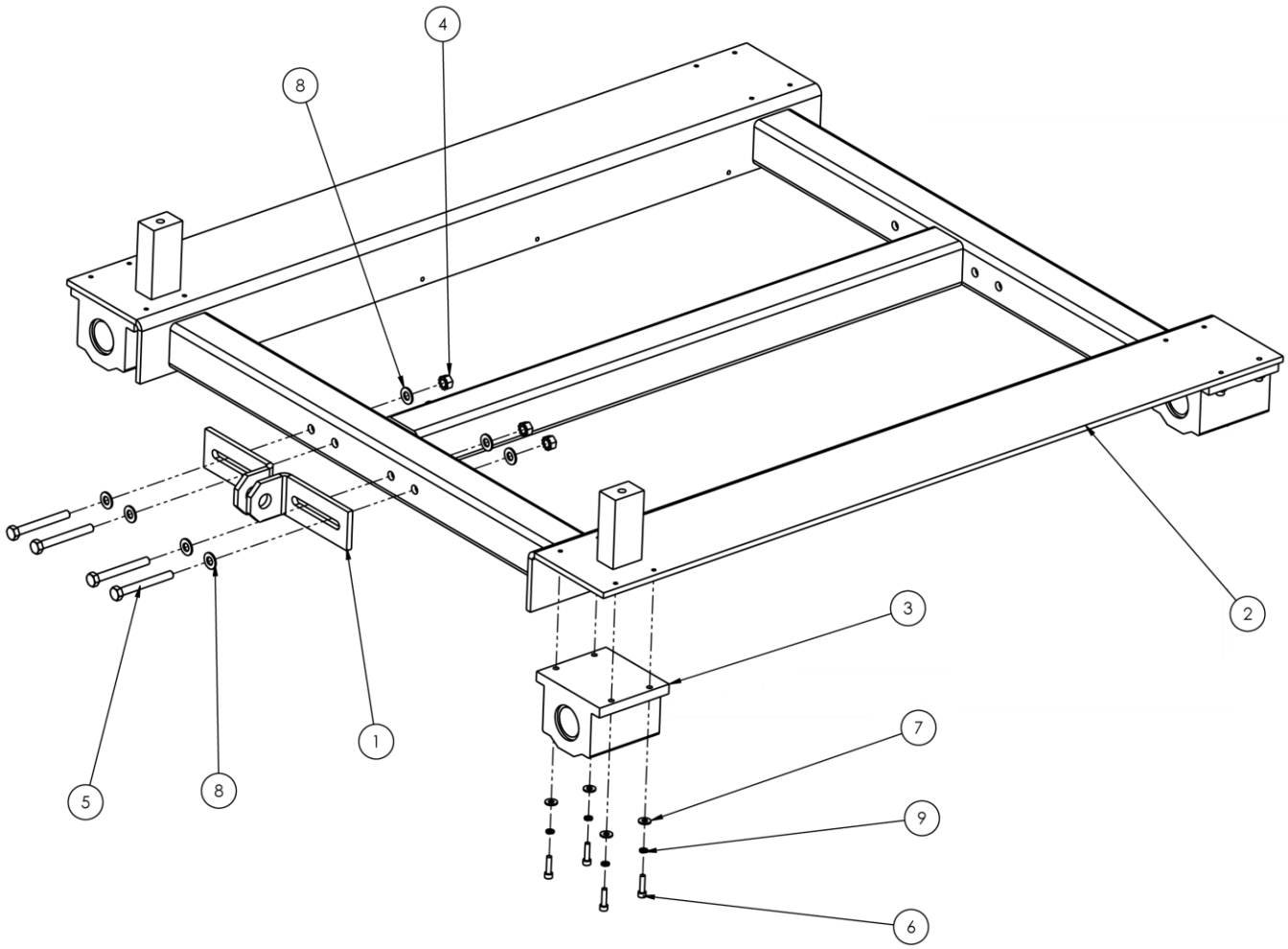
AAC Drawing Number 1391077 Rev 1



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	AACDNCB80160PPV	CYLINDER,AIR,ISO,80X160
2	1	AAFSGSM20x15	ROD END, FEM-20MM X 1.5MM
3	1	AAFSNC80	REAR PIVOT
4	2	AAQME-3-3U	MALE ELBOW 3/8 OD TUBE,3/8UNIFIT
5	2	WWFS3/4	WASHER, .797ID X 1-1/2OD

1391081 Input Carriage Assembly

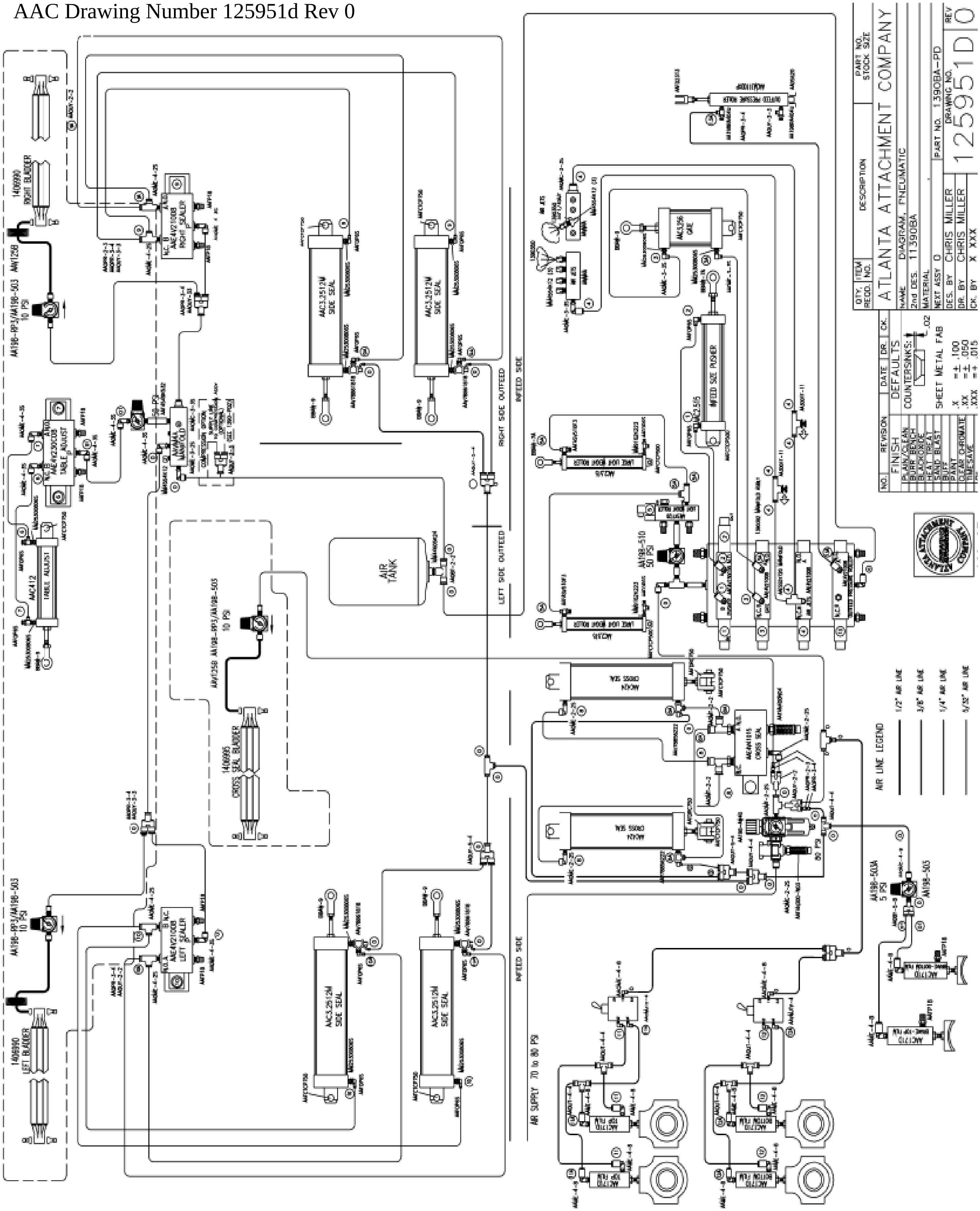
AAC Drawing Number 1391081 Rev 0



NO.	QTY	PART #	DESCRIPTION
1	2	1391082	BRACKET, CLEVIS
2	1	1391083	WELDMENT, SLIDE ASSY
3	4	MMP20	LIN.PILLOW-BLOCK,SEALIGN
4	4	NNK5/16-18	KEP NUT, 5/16-18
5	4	SSHC10176	SCREW,HEX CAP
6	16	SSSC98048	10-32 X 3/4 SOC CAP
7	16	WWFS10	WASHER, FLAT, #10, SAE
8	8	WWFS5/16	WASHER,FLAT,SAE,5/16
9	16	WWL10	WASHER,LOCK,#10

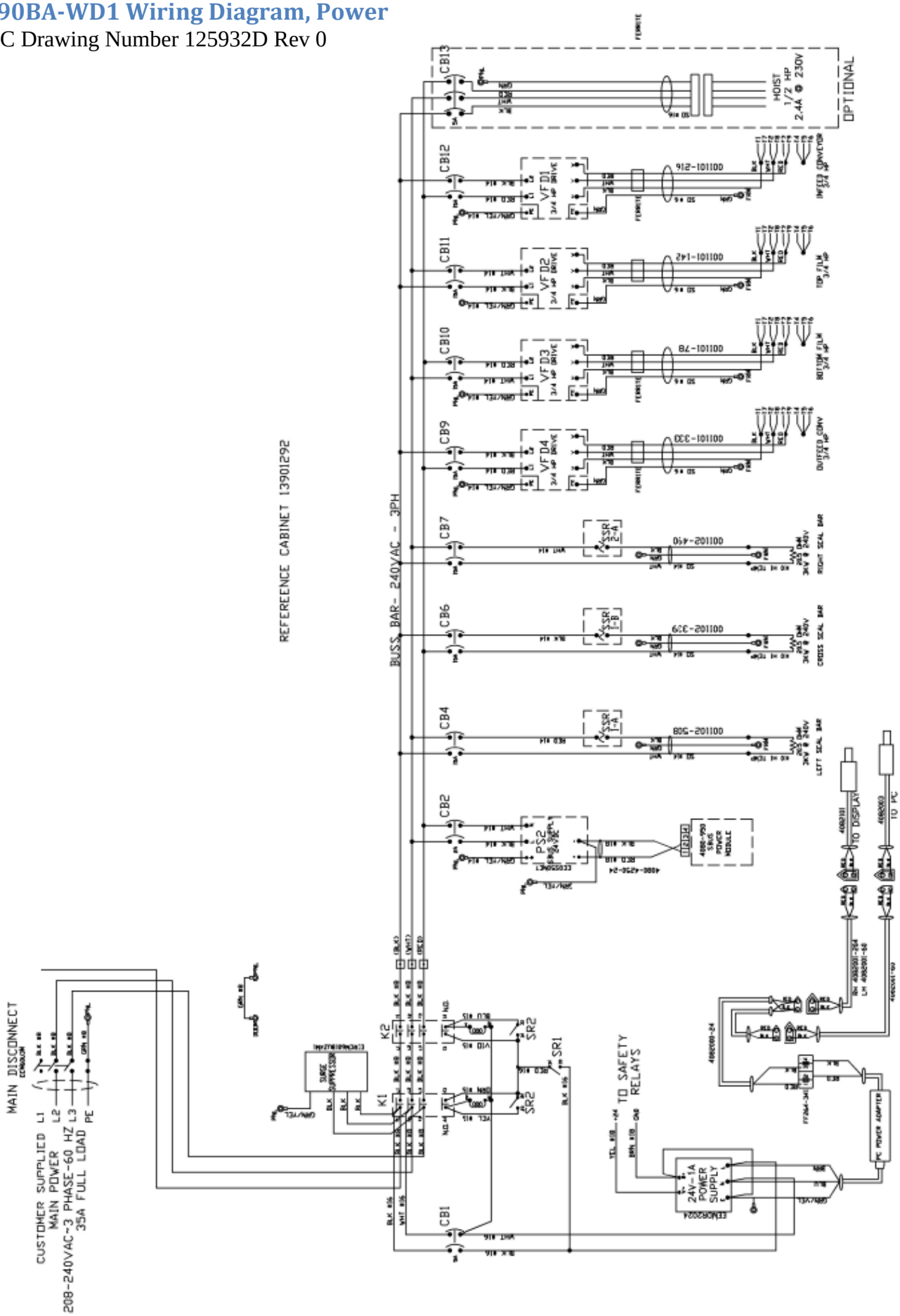
1390BA-PD Pneumatic Diagram

AAC Drawing Number 125951d Rev 0



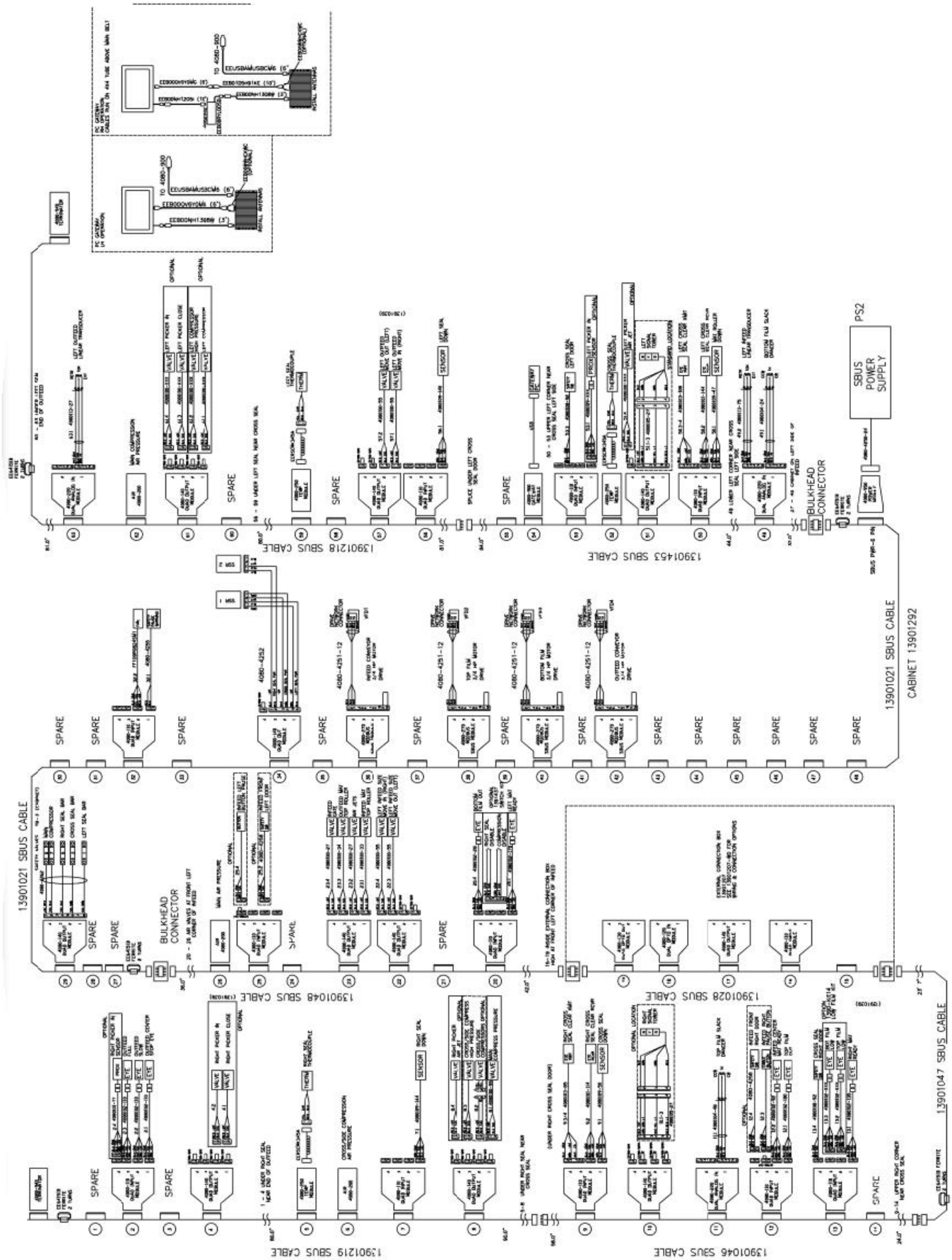
1390BA-WD1 Wiring Diagram, Power

AAC Drawing Number 125932D Rev 0



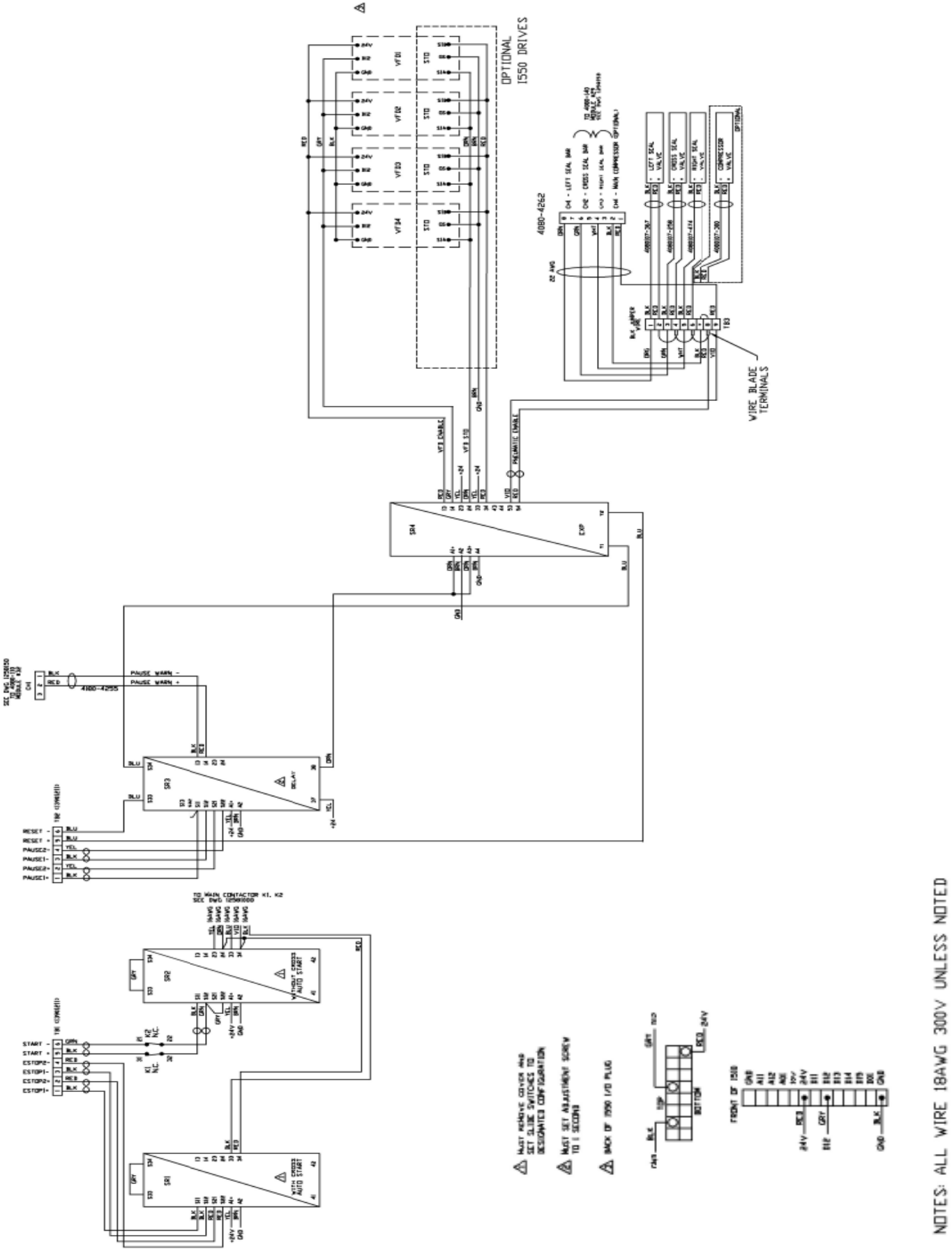
1390BA-WD2 Wiring Diagram, SBUS

AAC drawing Number 125933D Rev 1



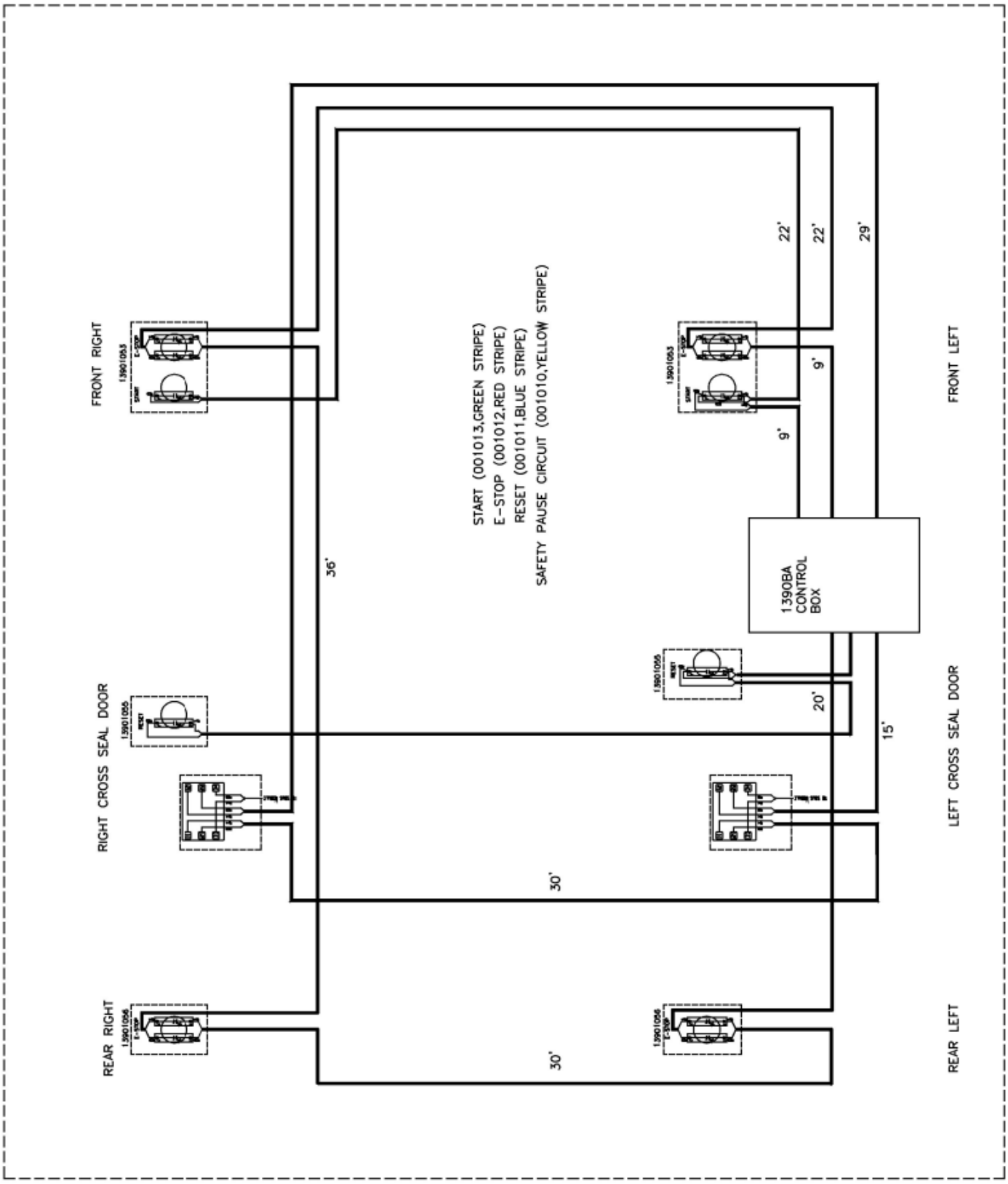
1390BA-WD3 Wiring Diagram, Pause & E-Stop

AAC Drawing Number 125934D Rev 0



1390BA-WD4 Wiring Diagram, Safety

AAC Drawing Number 125937d rev 0



5. TRAINING

Check	Description	Time Hrs.
	Safety Instructions	0.5
	Installation • Set up • Power On cycle	1.5
	Operation • Individual components • Serial Bus operator label • Operation Description • With / without dustcover • Maintenance Operator Label	3
	Service • Lock out tag out • Operation sequence Mechanical level	1
	Mechanical Adjustments • Table Adjustments • Tension wheel • Clamp fingers • Staplers	3
	Pneumatic components • Plumbing diagram • FRL unit • Solenoid valve manifold • Pressure adjustments • Pressure switch	1.5
	Electric component • Wiring diagram • Photoelectric Sensor	1.5
	Serial Bus • Touch screen • Modules • Program update • Technical screens	2
	Maintenance Technical Level	1
	Troubleshooting	0.5
	Evaluate any questions.	0.5

Participants: _____ _____

_____ _____

Instructor: _____ **Date:** _____

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 Garantia

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 cual-quier 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 manu-facturados 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 neumáticas.
- 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.

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