



Model **1409A**

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Technical Manual & Parts Lists



362 Industrial Park Drive

Lawrenceville, GA 30046

770-963-7369 • www.atlatt.com

ATLANTA ATTACHMENT COMPANY, INC.

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IMPORTANT

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

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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 your machine and describes the dangers inherent in machinery. Some of these dangers are obvious, while others are less evident.

Mandatory Information

All persons working on the Workstation 1409A, should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only work on the machine 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
- Serial Bus Control system Operator instructions
- 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 conducted by dependable 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 conducted 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 pneumatic 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.

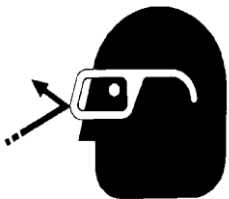
Signs on the Machine

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 evaluated 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 firefighters 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 control switch simultaneously so that they can conduct 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 set-up 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 control switch is off.

- Electricity - The machine is always isolated from the electrical power supply whenever the control 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 control switch.
- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the control 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 us and/or your transport insurer without delay. 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.

Machine Installation

This equipment must be installed by an Atlanta Attachment Co. technician, or by a professionally trained and authorized technician/mechanic. Atlanta Attachment Co. reserves the right to void any machine warranty if the machine is installed by anyone other than a qualified person as stated above

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.

Connection, Reconnection

Energy feed and discharge lines must be routed so that they do not run through the operator's working area, are not compressed, crushed, or buckled, are not subjected to tensile stresses, and cannot rub against anything. This is particularly important in the case of pneumatic, hydraulic and electricity lines or hoses. Always take the machine movements into account when routing such lines.

Electrical Connection

The machine shall only be connected to the factory power supply by a qualified electrician who is familiar with the local regulations. Before switching on the control switch, check that all fasteners are secure.

Pneumatic Connection

Only use dry filtered compressed air. Ensure that the air pressure always remains within the range specified, otherwise malfunctions may occur.

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 conducting 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 (control 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 conducted 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 evaluated 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 conduct work on live parts, a second person should be on hand to operate the emergency OFF switch or control 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 users 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 conducted 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.

General Machine Data

Electrical & Pneumatic Specifications

Electrical: 220 VAC, 20-amp, 50/60 Hz Single Phase

Pneumatic: 80 PSI, 5 SCFM avg. (3/8" Airline).

Set the MAIN regulator to 70 PSI

Installation & Setup

1. Remove all packing material (bubble wrap, foam padding, etc.).
2. Position the machine in a desired location on a sound and reasonably level floor.
3. Make sure that there is sufficient lighting over the machine.
4. Clean the machine of any dust that may have accumulated during shipping.
5. Make required electric and pneumatic connections using only appropriate connectors. Make sure the voltage has been set correctly.
6. Plug the Foot Pedal assembly into its cable (inside right panel door). Plug connectors in access slot in front of machine.

Adjustments / Controls

Control Panel – This panel of buttons allows operator to activate machine, stop the machine in case of emergency, change direction of the motion of the belts, manual jog, open and close the door, and adjust speed of the belts.

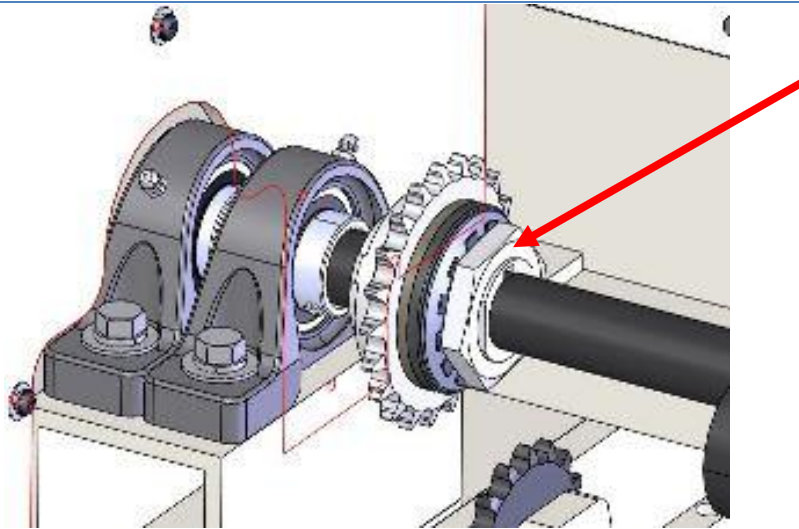


Foot Pedals – The foot pedal assembly has two pedals. The left is the Run pedal which toggles the machine into a continuous unload mode. The other is the Jog pedal which is a momentary switch and jogs the machine in high speed and will typically be used at the start and finish of a roll to wind excess wrap.

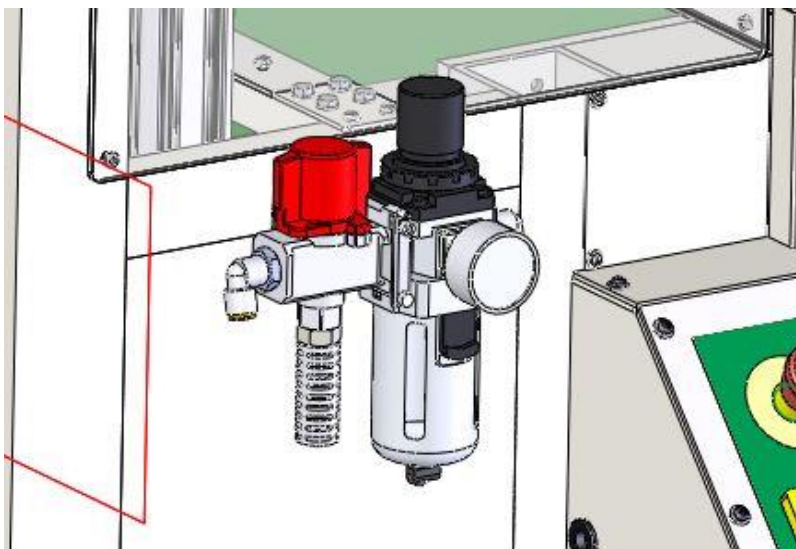


Accumulator slip clutch – Located underneath accumulator guard, tighten, or loosen the nut to adjust the amount of

tension the accumulator applies to the material wrap.



Pressure regulator – This controls the air pressure supplied to the air cylinder used to open and close the door.



Control Panel Functions

1. **Emergency Stop Button** – Pressing this button will turn power off to the machine. This button will lock when pressed. Twisting this button will cause it to unlock and return to its normal position.
2. **Power on button** – Pressing this button will energize the machine. It is lighted and will indicate when the machine has power.

3. **Forward/Reverse Switch** – This switch controls the direction the belts turn. Forward is the normal operating direction.
4. **Jog button** – This button is a momentary manual jog. This differs from the foot pedal jog because it drives the belts at the slower “Run” speed.
5. **Lockout** – This switch connects main power to the machine and needs to be on for the machine to operate. The switch may be mechanically locked for maintenance, using a lock-out tag-out procedure.
6. **Safety indicator** – This is a light that indicates when any door or guard is open or ajar. If this light is activated the machine will not run or will stop running.
7. **Door open/close** – This switch will open and close the back door to allow loading of bales. It is to remain in the close position unless being loaded.

CAUTION: This door will close at power loss.

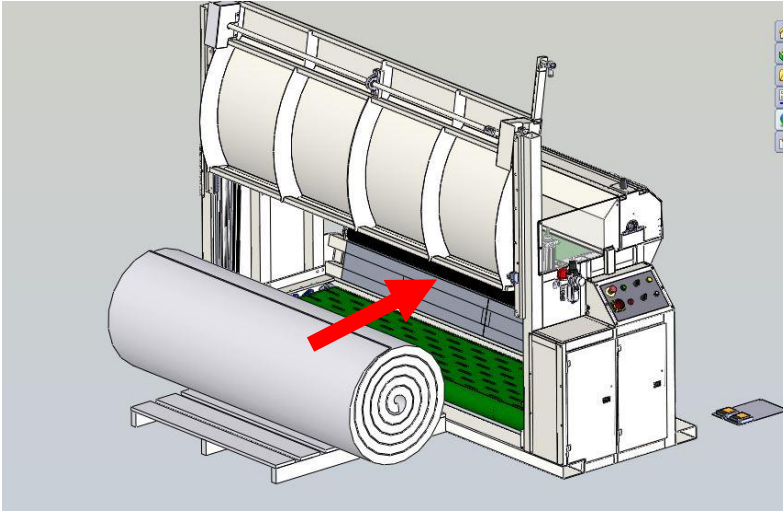
8. **Speed** – The speed control knob controls the continuous unload mode run speed and the yellow push button jog speed.

Foot Pedal Functions

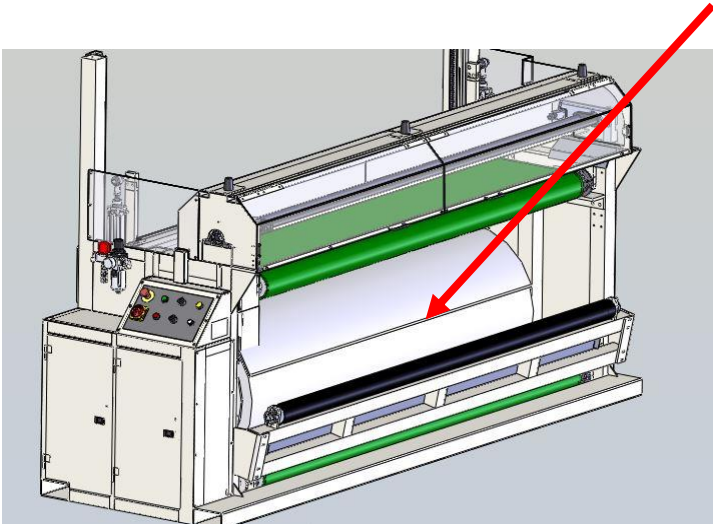
1. **Run** – The run pedal is a toggle switch to operate the machine in a continuous unload mode. Activating once will start unload operation. Activating a second time will stop the unload operation. The speed is set with the speed knob.
2. **Jog** – The jog pedal is a momentary pedal which has to be held down to operate. It operates the machine at high speed and is used in the beginning and ending of operation to feed out the excess wrapping material.

Operating procedure

1. Open (raise) the rear door using the Door Open/Close switch.



2. Roll the bale of springs into the machine so it will unwrap from the top. If the bale is wrapped with plastic, spray lightly with silicone spray before loading into machine.
3. Close (lower) the door.
4. Using the Jog pedal, Jog the machine to position the leading edge of material wrap at the exit opening.



5. Cut any shrink wrap or straps and remove any loose material if possible.

CAUTION: Roll may expand unexpectedly when bands/wrap are cut.

6. Jog the machine again, holding the leading edge of wrap, and feed out approximately 5-6 feet of wrap. Remove any loose material.

7. Open the accumulator front guard door, pull the end of the wrap between the accumulator bars, the loose end should hang down a foot or two, close the guard door.
8. Jog the machine more until the first spring is exposed.



9. Activate the Run pedal to start the continuous unload mode
10. Adjust the run speed control as desired.
11. With two people, remove the springs and stack.
12. You may stop the continuous mode any time by pressing the Run pedal again.
13. When all the springs are removed, press the Run pedal to stop the continuous cycle. Hold down the Jog pedal to rewind all the rest of the wrap onto the accumulator.
14. Go to opposite side of machine, unlatch the end guard door on the accumulator and swing it out of the way. Pull out the wrapping material. Open the front accumulator guard door and, while supporting the rods in place, close the end door so the rods engage the support spindle. Latch the end door and close the front accumulator guard door.



15. Repeat for next bale.

Troubleshooting

Machine does not run when foot pedal depressed

1. Verify power is on and pedal is connected.
2. Check e-stop is unlatched.
3. Check safety lamp indicating open doors or guards.
4. Check that foot pedal cable is plugged in.
5. Turn off main power, wait 10 seconds, re-apply power, and try again (This resets the VFW drive that runs the motor.)

Gate will not close

Check material roll is not interfering with closing of door.

Motor runs but belts do not turn

Check if belt is slipping on drive roller, tighten slightly if necessary.

Belt Adjustment

As belts wear in adjustments may be necessary to maintain proper tracking. If a belt is tracking to one side adjustment may be made while machine is empty by opening the gate, then doing one of the following:

If belt is tight:

1. Go to the side which the belt is moving toward.
2. Loosen the lock nut on the belt tensioning screw.
3. Turn belt tensioning screw counterclockwise 1/2 of a turn to reduce belt tension.
4. Retighten lock nut on belt tensioning screw.
5. Run belts while machine is not loaded. Monitor belt tracking, the adjusted belt should maintain a consistent position.
6. Continue unloading springs and monitoring belt tracking.
7. Readjust belt tension as necessary until proper tracking is achieved.

If the belt is loose:

1. Go to the opposite side which the belt is moving toward.
2. Loosen the lock nut on the belt tensioning screw.
3. Turn belt tensioning screw clockwise between 1/2 of a turn to increase belt tension.
4. Retighten lock nut on belt tensioning screw.
5. Run belts while machine is not loaded. Monitor belt tracking, the adjusted belt should maintain a consistent position.
6. Continue unloading springs and monitoring belt tracking.
7. Readjust belt tension as necessary until proper tracking is achieved.

During operation, the belts may show a slight amount of twist which is normal. The overall width of the belts is wider than the end rollers. In normal operation the inner rib of one side of the belt will contact the edge of the end rollers. If a belt starts to track to one side and the rib starts to climb onto the roller immediately stop operation and run the machine in reverse until the belt returns to the appropriate position. Adjust the belt tension as stated above.

General Machine Maintenance

Daily (8-10 hrs. of operation)

Clean machine of any wrapping debris with an air blower.

Use silicone lubricant on inside of gate and front skid plate as necessary if springs are wrapped with shrink wrap.

Weekly

Drain water from regulator trap.

Apply slight amount of oil to cylinder rods.

Monthly

Check chains and belts for tightness and wear.

Assembly Drawings & Parts Lists

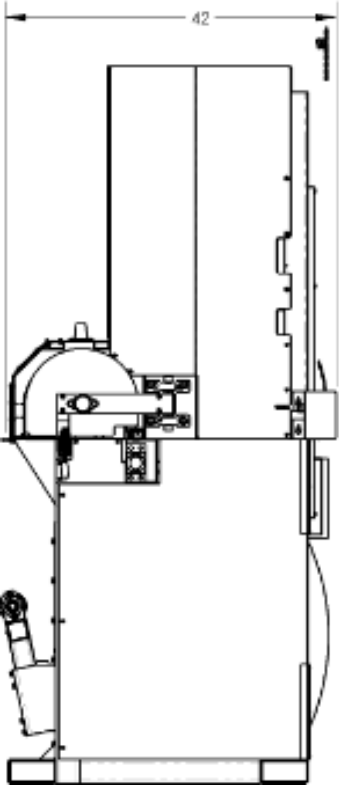
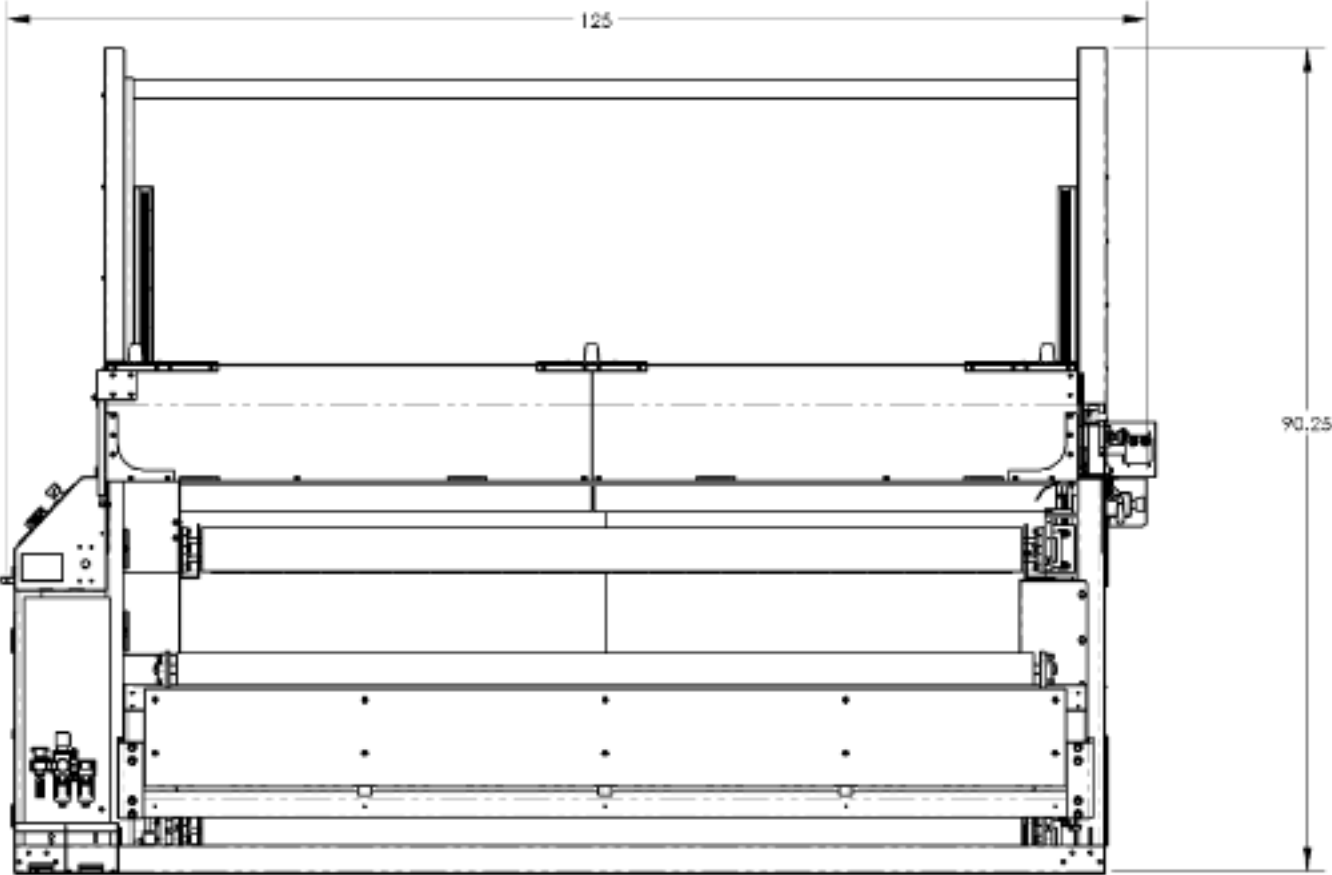
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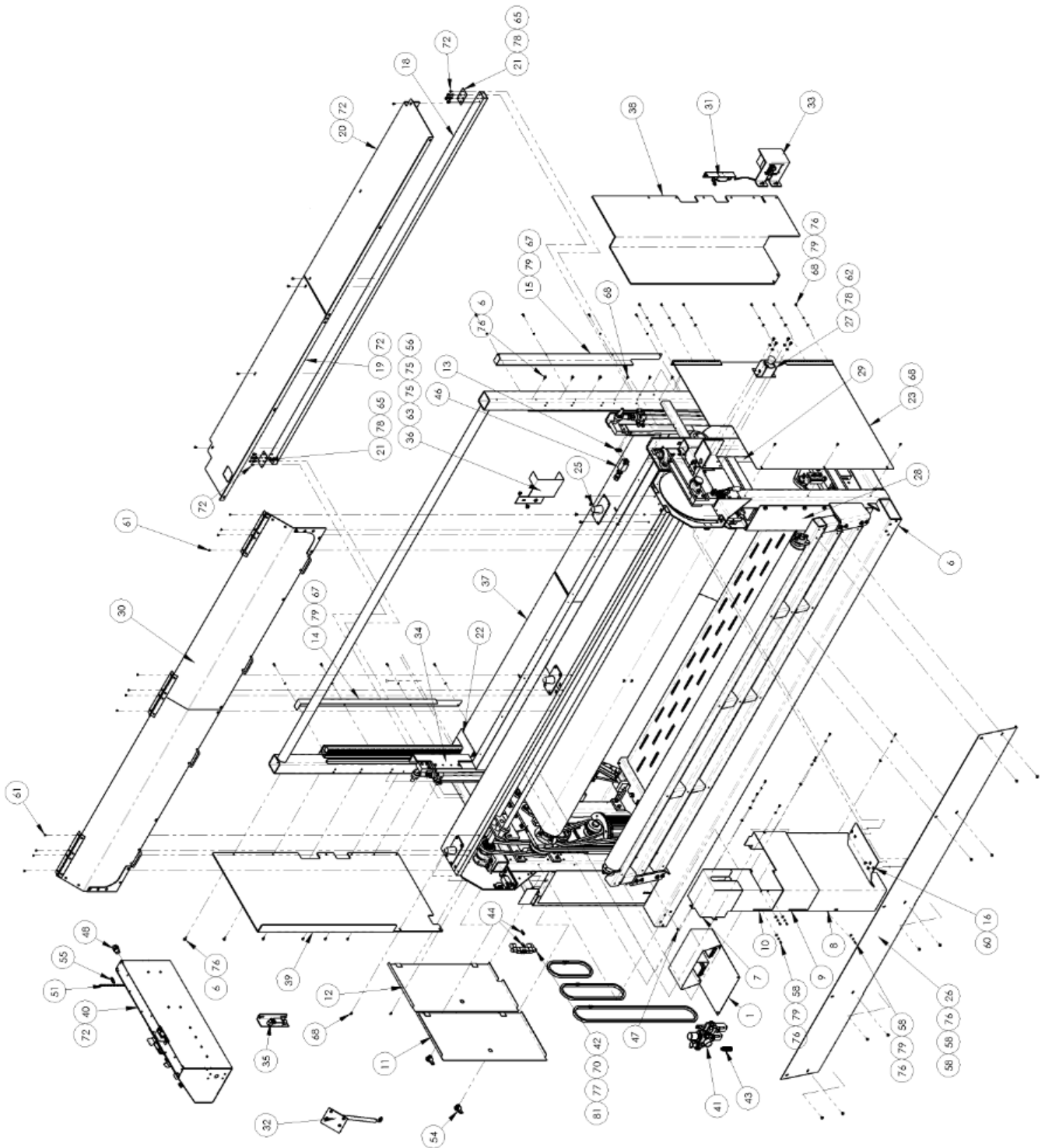


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11409A UNBALER, ROUND BALES

ACC Drawing Number 9004713 Rev.2



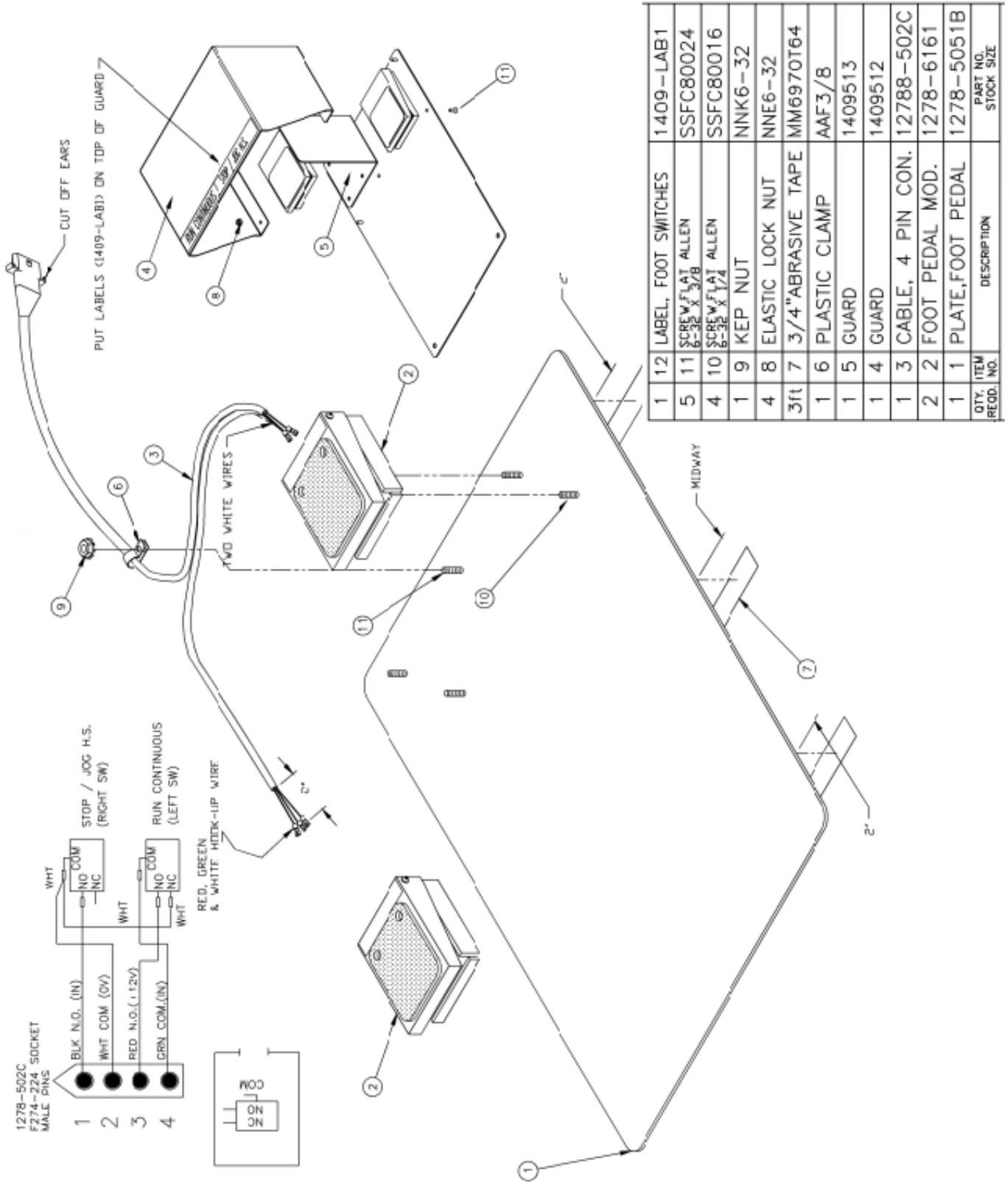


11409A parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION	ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1278-6160H	DUAL FOOT PEDAL ASSY	42	1	AAE513C120A	VALVE, 1/4", 24VDC, CNTR BK
2	*1	1390-LAB1	LABEL, DANGER, VOLTAGE,	43	1	AAFAN200-02	MUFFLER, 1/4 NPT
3	1	1409-10	CABLE, DOOR SW	44	2	AAFP18	MUFFLER, 1/8 NPT, BRONZ
4	*1	1409-LAB1	LABEL, FOOT SWITCHES, RUN-STOP/ JOG	45	2	AAQME-4-4	ELBOW, MALE, G, 1/4 TUBE, 1/4 NPT
5	*1	1409-WD8	DIAGRAM, WIRING 1409 NEW VFD	46	1	EEGLA01B	SWITCH, LIMIT, TOP PLUNGER
6	1	1409330	FRAME W/ REWINDER	47	2	EESB-375-4	HEYCO BUSHING 1/4" ID
7	1	1409344	CHAIN COVER, UPPER	48	1	FF3200	STRAIN RELIEF, 1/2NPT
8	1	1409345	CHAIN GUARD, LOWER	49	1	FF8463	NIUT, LOCK, 1/2NPT, NYLON, BLK
9	1	1409346	UPPER GUARD, SLIDING	50	1	FFM4518	STRAIN RELIEF, LIQ TIGHT
10	1	1409347	UPPER GUARD, SLIDING	51	1	K-3607511	SASH CHAIN
11	1	1409376	DOOR, LEFT	52	2	MM1676A12	MAGNETIC CATCH
12	1	1409378	DOOR, LEFT	53	3	MM9600K22	GROMMET, RUBBER, 1/2 ID
13	1	1409388	SENSOR BLOCK	54	2	MMELH-1	LATCH, 1/4 TURN, SLOTTED
14	1	1409402	GUARD, GEAR RACK, RIGHT	55	2	MM5064	HOOK, S, 1"
15	1	1409408	GUARD, GEAR RACK, LEFT	56	2	NNK1/4-20	NIUT, KEP, 1/4-20
16	1	1409410	SKID PLATE, ROLL	57	12	NNK10-32	KEP NUT, 10-32
17	1	1409446	GUARD, GEAR RACK, LEFT	58	22	SSBC98024	10-32 X 3/8 BUTTON CAP SC
18	1	1409451	TUBE, GUARD UPPER	59	12	SSBC98032	10-32 X 1/2 BUTTON CAP SC
19	1	1409452	BELT GUARD, RIGHT	60	6	SSFC01024	1/4-20 X 3/8 FLAT CAP
20	1	1409453	BELT GUARD, LEFT	61	12	SSFC90016	8-32 X 1/4 FL ALN CAP
21	2	1409454	TAB, UPPER BELT GUARD	62	6	SSHC01024	1/4-20 X 3/8 HHCS
22	1	1409455	GUARD, GEAR RACK, RIGHT	63	2	SSHC01032	1/4-20 X 1/2 HHCS
23	1	1409460	DOOR, LEFT SIDE	64	4	SSHC01040	1/4-20 X 5/8 HHCS
24	1	1409461	SMALL GUARD, LEFT	65	8	SSHC05032	1/4-28 X 1/2 HEX CAP
25	3	1409464	BUMPER ASSEMBLY	66	8	SSHC25080	3/8-16X1-1/4 HHCS
26	1	1409473	TOE GUARD	67	12	SSHC98032	10-32X1/2 HEX HD
27	1	1409516	STOP BUTTON BOX ASSY	68	19	SSPP98024	10-32 X 3/8 PAN HD PHILIP
28	1	1409567	GUARD, CHAIN, FRONT	69	4	SSSC35064	SCREW, SOC CAP 3/8-24 x 1
29	1	1409568	COVER, CHAIN, REAR	70	2	SSSC70064	4-40 X 1 SOCKET CAP
30	1	1409574	REWIND GUARD DOOR	71	8	SSSC80016	6-32 X 1/4 SOC CAP SC
31	1	1409585	LIMIT SW ASSY	72	18	SSZH#10032	SCREW, SHT, METAL HEX 10
32	1	1409586	GAS SPRING ASSY	6	6	SSZH#10048	SCREW, SHT, METAL HEX 10
33	1	1409587	GATE CONTROL SWITCH ASSY	74	6	SSZ93032	SCREW, SHT, METAL 10 ZIP
34	2	1409593	INSIDE GUARD, TOP	75	10	WWF1/4	WASHER, FLAT, 1/4", COM
35	1	1409604	LIMIT SW ASSY, LEFT GATE	76	50	WWF10	WASHER, FLAT, #10, COM
36	1	1409617	SIDE DOOR SWITCH GUARD	77	2	WWF4	WASHER, FLAT, #4
37	2	1409618	GUARD, BACK SHAFT	78	18	WWL1/4	WASHER, LOCK, 1/4
38	1	1409786	SIDE GUARD, LEFT	79	40	WWL10	WASHER, LOCK, #10
39	1	1409789	SIDE GUARD, RIGHT	80	12	WWL3/8	WASHER, LOCK, 3/8
40	1	1409805	CONTROL ASSEMBLY W/ NEW VFD	81	2	WWL4	WASHER, LOCK, #4
41	1	AA198-5110	FILTER/REGULATOR/LOCKOUT				

1278-6160H Dual Foot Pedal Assembly

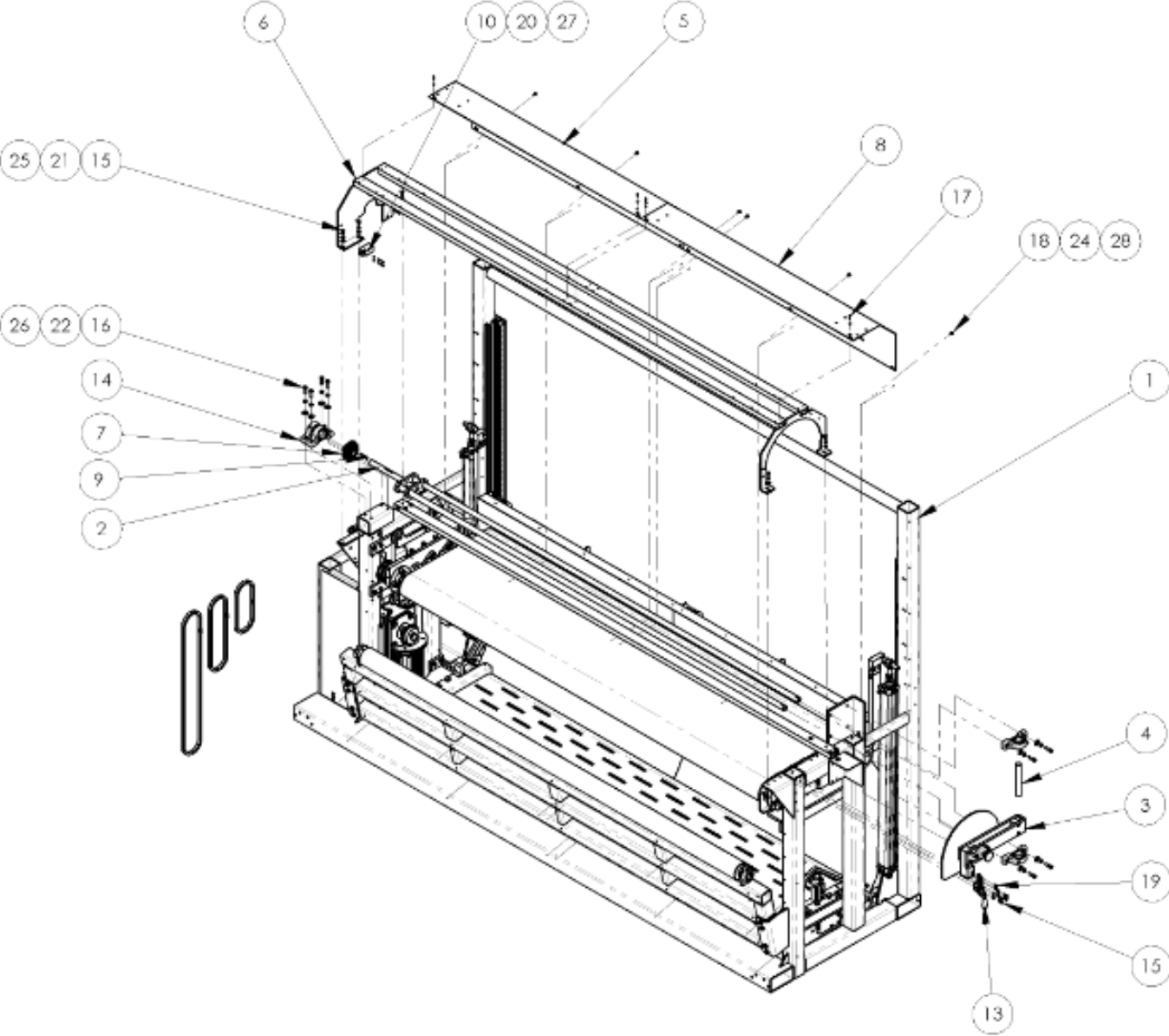
AAC Drawing Number 125962C Rev 2



QTY.	ITEM RECD. NO.	DESCRIPTION	PART NO.	STOCK SIZE
1	12	LABEL, FOOT SWITCHES	1409-LAB1	
5	11	SCREW, FLAT ALLEN 6-32 X 3/8	SSFC80024	
4	10	SCREW, FLAT ALLEN 6-32 X 1/4	SSFC80016	
1	9	KEP NUT	NNK6-32	
4	8	ELASTIC LOCK NUT	NNE6-32	
3ft	7	3/4" ABRASIVE TAPE	MM6970T64	
1	6	PLASTIC CLAMP	AAF3/8	
1	5	GUARD	1409513	
1	4	GUARD	1409512	
1	3	CABLE, 4 PIN CON.	12788-502C	
2	2	FOOT PEDAL MOD.	1278-6161	
1	1	PLATE, FOOT PEDAL	1278-5051B	

1409330 FRAME W/REWINDER

ACC Drawing Number 1409330 Rev.4

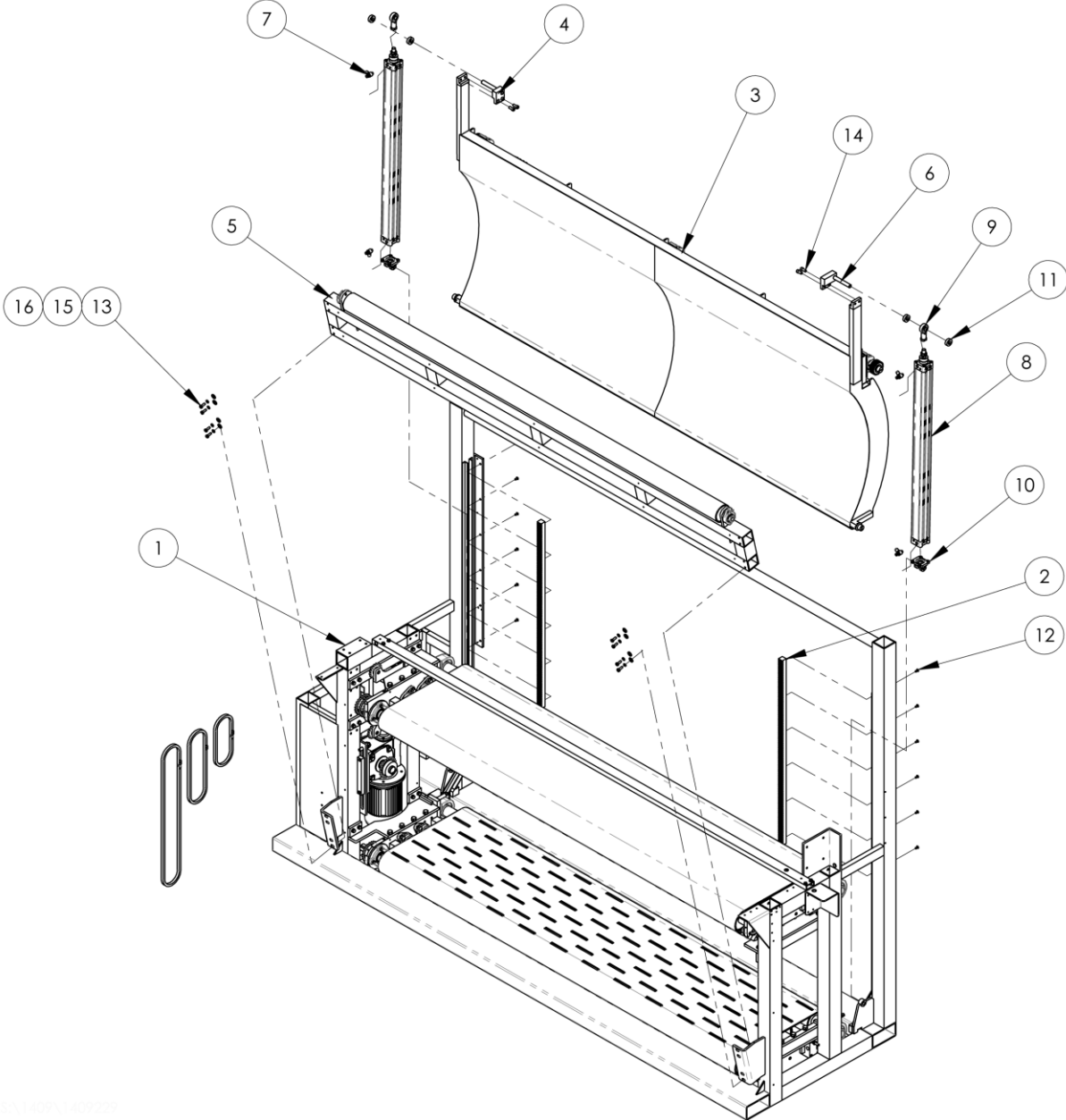


1409330 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1409229	FRAME ASSY, W/ BACKSTOP
2	1	1409243	REWINDER
3	1	1409247	REWINDER ARM
4	1	1409259	KEYED SHAFT, COUPLING ARM
5	1	1409353	REWINDER COVER
6	1	1409354	FRAME, REWINDER GUARD
7	1	1409384	TORQUE LIMIT ASSY
8	1	1409472	REWINDER COVER, LEFT
9	1	1409542	KEY, 6MM SQ X 1.75L
10	1	EEGLLA01B	SWITCH,LIMIT, TOP PLUNGER
11	1	FF8463	NUT,LOCK, 1/2NPT,NYLON,BLK
12	1	FFM4518	STRAIN RELIEF,LIQ TIGHT
13	1	MM331	CLAMP, PULL ACTION, 700LB
14	4	MMUCP205-16	BEARING,PILLOW BLOCK,1"
15	9	SSHCO1040	1/4-20 X 5/8 HHCS
16	8	SSHCO25080	3/8-16X1-1/4 HHCS
17	4	SSHCO90032	#8-32 X 1/2 HEX CAP
18	6	SSHCO98032	10-32X1/2 HEX HD
19	2	SSSCO1024	1/4-20 X 3/8 SOC CAP SC
20	2	SSSCO90080	#8-32 X 1-1/4 SOC CAP SC
21	4	WWF1/4	WASHER, FLAT, 1/4", COM
22	8	WWF3/8	WASHER,FLAT,3/8 OR 10MM
23	4	WWF8	WASHER, FLAT, #8
24	6	WWFS10	WASHER, FLAT, #10, SAE
25	9	WWL1/4	WASHER,LOCK, 1/4
26	8	WWL3/8	WASHER,LOCK, 3/8
27	6	WWL8	WASHER,LOCK,#8
28	6	WWL10	WASHER,LOCK,#10
29	1	WWFS1/4	WASHER,FLAT,SAE,1/4

1409229 FRAME ASSY. W/BACKSTOP

ACC Drawing Number 1409229 Rev.3



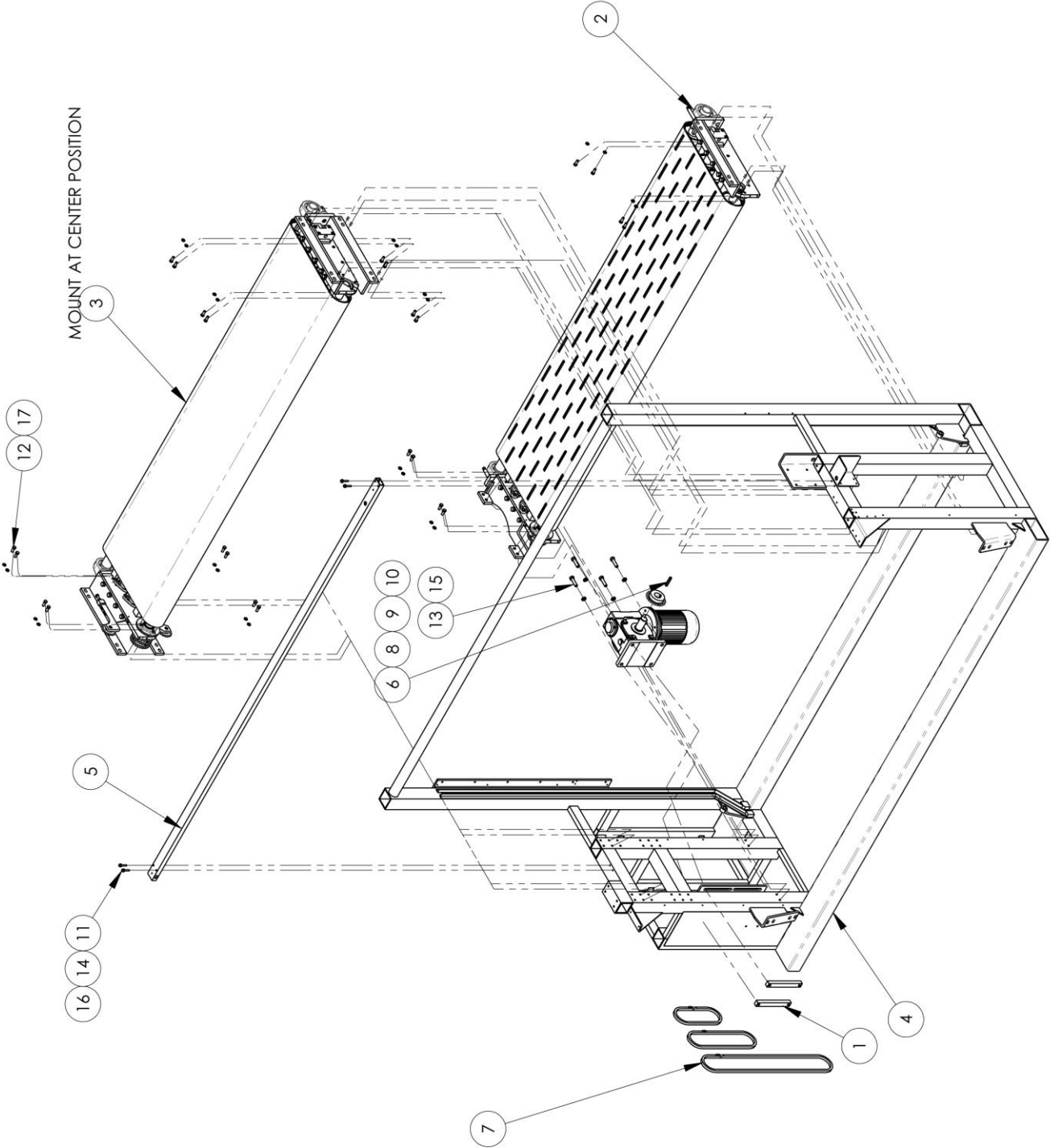
33 1409229

1409229 parts list

NO	QTY	PART #	DESCRIPTION
1	1	1409221	FRAME W/ BELTS
2	2	1409222	GEAR RACK, 10DP, 1" FACE
3	1	1409311	GATE, BACK SKID
4	1	1409421	WELDMENT, SHAFT MOUNT
5	1	1409450	SKID PLATE ASM
6	1	1409458	WELDMENT, SHAFT MOUNT, L
7	4	AA198RA404U	FLOW CONTROL, 1/4PTX1/4
8	2	AACDNC50900PPV	CYLINDER, AIR, ISO, 50X500
9	2	AAFSGSM16x15	BEARING, ROD END, FOR DNCB50
10	2	AAFSNC50	FLANGE, SWIVEL, FOR DNCB50
11	4	CCCL10F	CLAMP COLLAR- 5/8 ID
12	12	SSFC01032	1/4-20 X 1/2 FLAT ALN CAP
13	8	SSHC20056	5/16-24 X 7/8 HEX CAP
14	4	SSSC25048	3/8-16X3/4 SOC CAP
15	8	WWF5/16	WASHER, FLAT, 5/16
16	8	WWL5/16	WASHER, LOCK, 5/16

1409221 FRAME W/BELTS

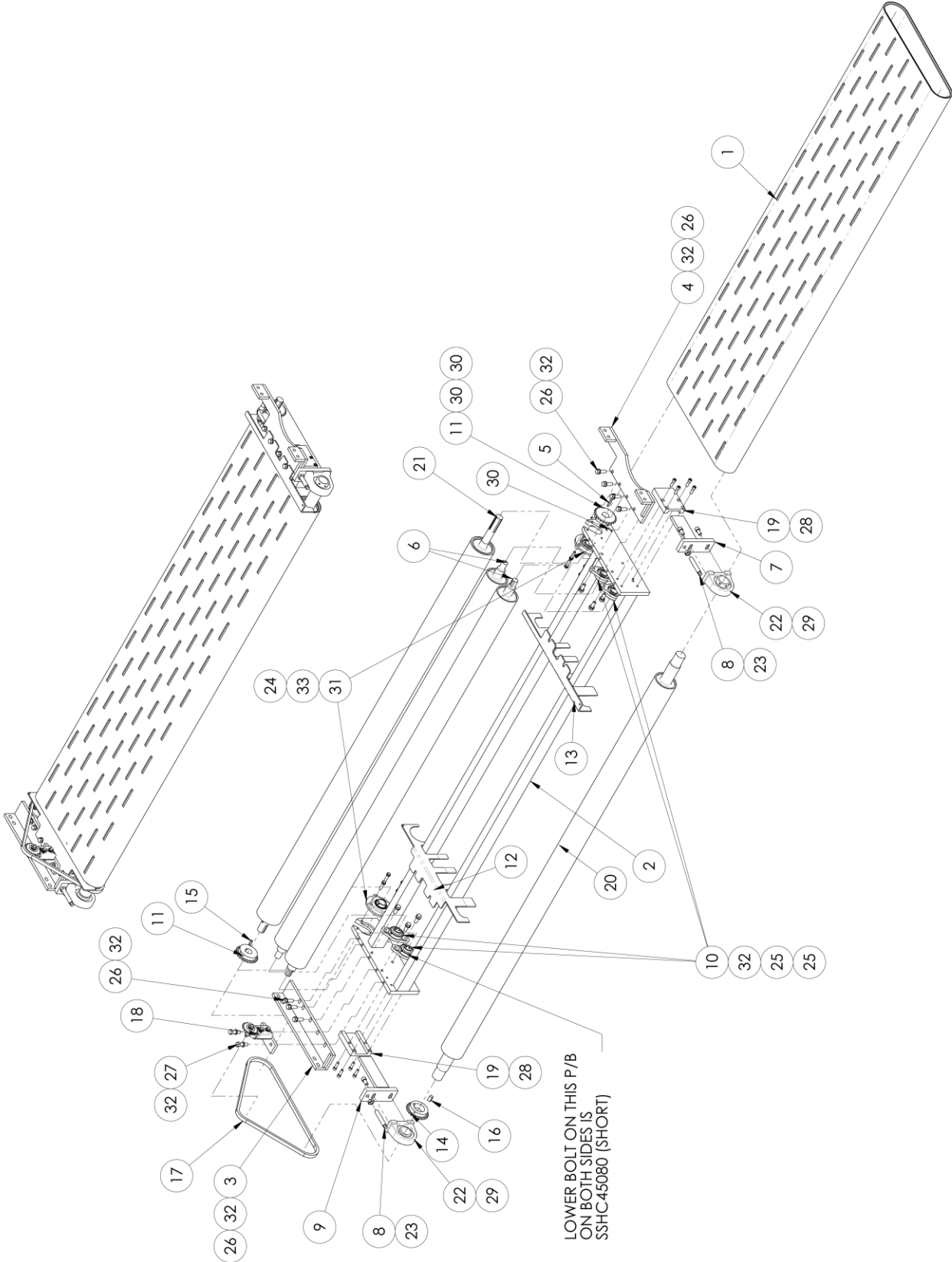
ACC Drawing Number 1409221 Rev.2



1409221 parts list

NO	QTY	PART #	DESCRIPTION
1	2	1306381	MOUNT,PLATE,MAIN DRIVE
2	1	1409197	LOWER CONVEYOR ASM
3	1	1409206	UPPER CONVEYOR ASM.
4	1	1409323	1409 FRAME
5	1	1409328	MAIN CROSS TUBE, GUARD
6	1	1409393	5/16 KEY 2.2 L
7	1	1409520	CHAIN ASSEMBLIES
8	1	MM90L4B5	MOTOR,1.5KW,IEC,B5,2HP
9	1	MMH4024-1-3_8	#40 SPROCKET 24T 1-3_8B
10	1	MMIC8030D90	GEARBOX,WORM,RV80,30:1
11	4	SSHC01096	1/4-20 X 1-1/2 HHCS
12	24	SSHC25064	3/8-16 X 1 HHCS
13	4	SSHC45128	1/2-13X2 HEX CAP
14	4	WWFS1/4	WASHER,FLAT,SAE,1/4
15	4	WWL1/2	1/2 LOCK WASHER
16	4	WWL1/4	WASHER,LOCK,1/4
17	24	WWL3/8	WASHER,LOCK, 3/8

1409197 LOWER CONVEYOR ASM
ACC Drawing Number 1409197 Rev.9

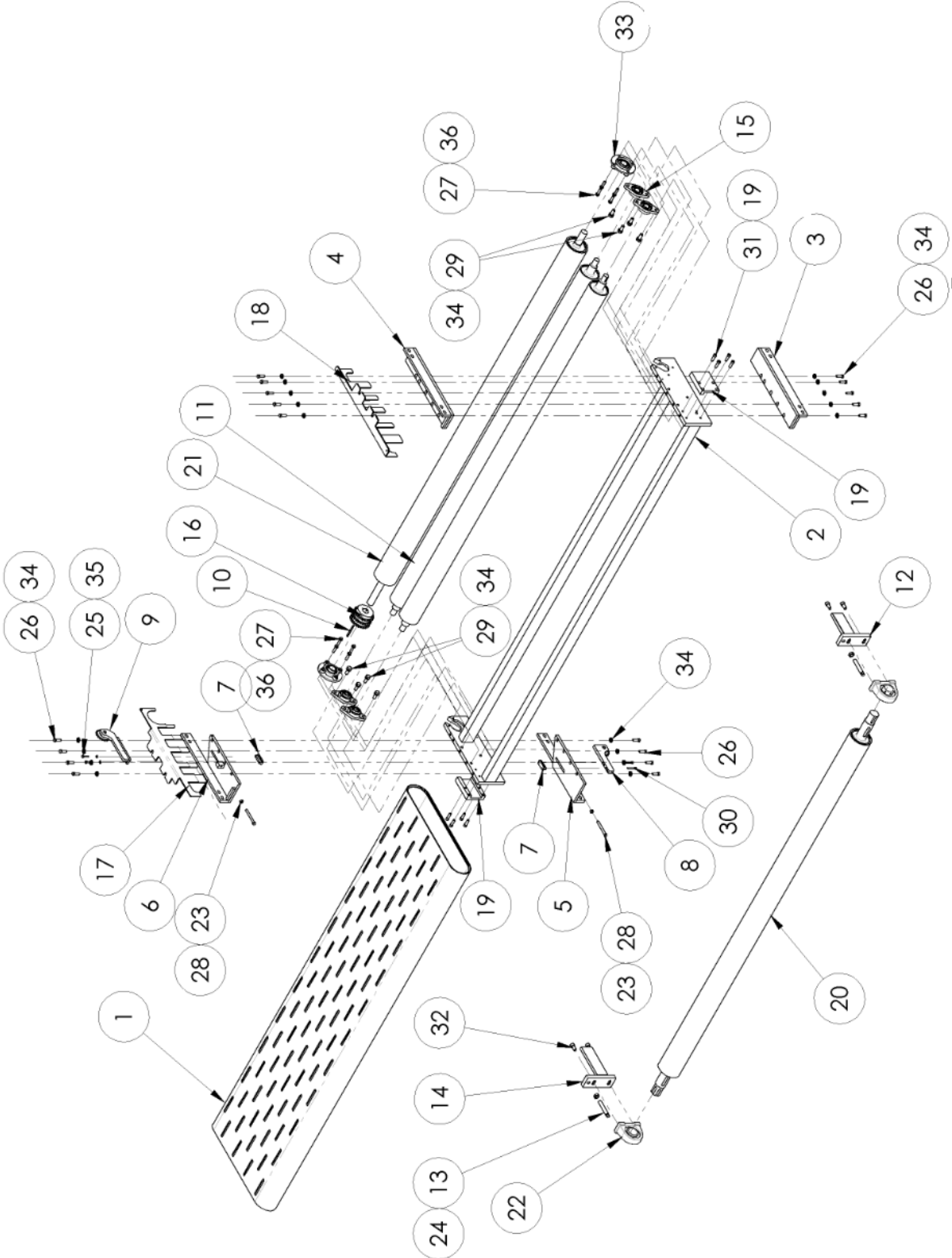


1409197 parts list

NO	QTY	PART #	DESCRIPTION
1	1	1409191	BELT, CONVEYOR, LOWER
2	1	1409192	FRAME, CONVEYOR, LOWER
3	1	1409233	MOUNT WLDMT, NON DRV SIDE
4	1	1409343	MOUNT SUPPORT WLDMNT
5	1	1409392	KEY, .25 SQ X 2.81
6	2	1409405	ROLLER, BELT, MIDDLE
7	1	1409466	MOUNT, BEARING, BR TL
8	2	1409467	SCREW, BELT TENSION, 5/8-18
9	1	1409469	MOUNT, BEARING, BL TR
10	4	1409471	BRNG MOD, FLANGE, 1", 2 BLT
11	2	1409521	SPROCKET, #40, 24T, 1.25"B
12	1	1409551	BRACKET, BELT GUIDE
13	1	1409552	BRACKET, BELT ALIGNMENT
14	1	1409557	SPROCKET, #40, 24T, 2.0B
15	1	1409563	KEY, .25 SQ X 0.9375
16	1	1409564	KEY, 1/2 x 0.9375
17	1	1409565	CHAIN, NO40, 54.5"
18	1	1409566	TENSIONER ASSEMBLY
19	2	1409570	BLOCK, BELT TENSION
20	1	1409594	RUBBER ROLLER ASSY
21	1	1409598	RUBBER ROLLER ASSEMBLY
22	2	MMUCPA209-28	BEARING, PILLOW BLOCK, 1.25
23	2	NNJ5/8-18	NUT-HEX JAM 5/8-18
24	8	SSHC25096	3/8-16 X 1 1/2 HHCS
25	8	SSHC45080	1/2-13X1-1/4 HEX CAP
26	7	SSHC45096	1/2-13X1-1/2 HEX CAP
27	2	SSHC45112	1/2-13 X 1-3/4 HHCS, G8
28	8	SSSC25080	3/8-16X1-3/8 SOC CAP
29	4	SSSC45064	SCREW, SOC CAP, 1/2-13 X 1"
30	2	SSSS01024	SCREW, SET, 1/4-20 X 3/8
31	2	UUCFC206-20	BEARING, FLANGE, 1.25B, 4 BOLT
32	17	WWL1/2	1/2 LOCK WASHER
33	8	WWL3/8	WASHER, LOCK, 3/8

1409206 UPPER CONVEYOR ASM

ACC Drawing Number 1409206 Rev.8

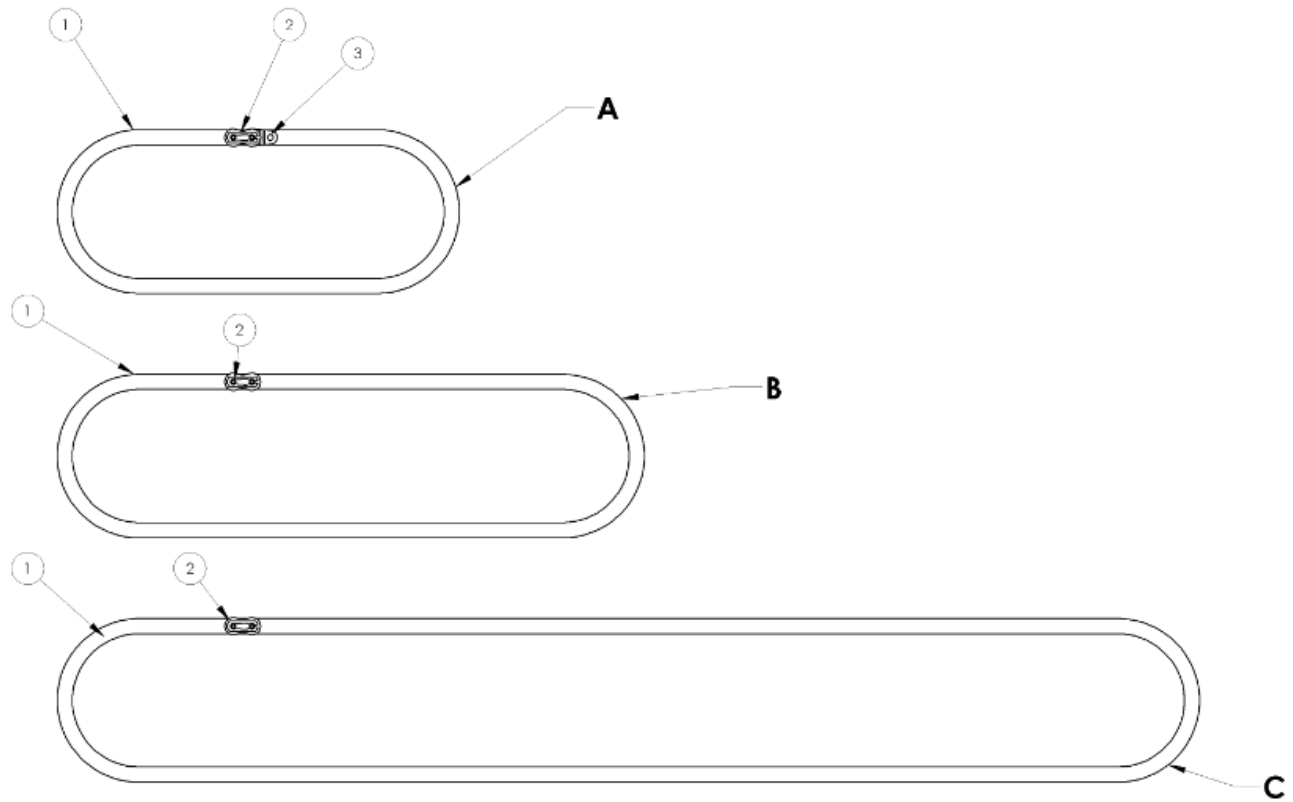


1409206 parts list

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1409191	BELT, CONVEYOR, LOWER
2	1	1409192	FRAME, CONVEYOR, LOWER
3	1	1409233	MOUNT WLDMT, NON DRV SIDE
4	1	1409239	MOUNT WLDMT, NON DR SIDE
5	1	1409319	SIDE MOUNT, DR SIDE UPR
6	1	1409321	SIDE MOUNT, DRV SIDE LWR
7	2	1409364	ADJUSTER TEE NUT BLOCK
8	1	1409370	CHAIN TENSIONER ASM UPR, 1409
9	1	1409372	CHAIN TENSIONER ASM BOTOM, 1409
10	1	1409392	KEY, .25 SQ X 2.81
11	2	1409405	ROLLER, BELT, MIDDLE
12	1	1409466	MOUNT, BEARING, BR TL
13	2	1409467	SCREW,BELT TENSION,5/8-18
14	1	1409469	MOUNT, BEARING, BL TR
15	4	1409471	BRNG MOD,FLANGE,1",2 BLT
16	3	1409521	SPROCKET,#40,24T,1.25"B
17	1	1409551	BRACKET, BELT GUIDE
18	1	1409552	BRACKET, BELT ALIGNMENT
19	2	1409570	BLOCK, BELT TENSION
20	1	1409594	RUBBER ROLLER ASSY
21	1	1409598	RUBBER ROLLER ASSEMBLY
22	2	MMUCPA209-28	BEARING,PILLOW BLOCK,1.25
23	2	NNH3/8-16	NUT,HEX,3/8-16
24	2	NNJ5/8-18	NUT-HEX JAM 5/8-18
25	2	SSHHC01080	HEX HEAD 1/4-20 X 1-1/4
26	18	SSHHC25080	3/8-16X1-1/4 HHCS
27	8	SSHHC25096	3/8-16 X 1 1/2 HHCS
28	2	SSHHC25224F	3/8-16 X 3.5 HHCS, FULL T
29	8	SSHHC45080	1/2-13X1-1/4 HEX CAP
30	2	SSSC01112	1/4-20 X 1-3/4 SOC CAP
31	8	SSSC25080	3/8-16X1-1/4 SOC CAP
32	4	SSSC45064	SCREW,SOC CAP,1/2-13 X 1"
33	2	UUCFC206-20	BEARING,FLANGE,1.25B,4 BOLT
34	26	WWL1/2	1/2 LOCK WASHER
35	2	WWL1/4	WASHER,LOCK, 1/4
36	8	WWL3/8	WASHER,LOCK, 3/8

1409520 Chain Assemblies

AAC Drawing Number 1409520 Rev 1



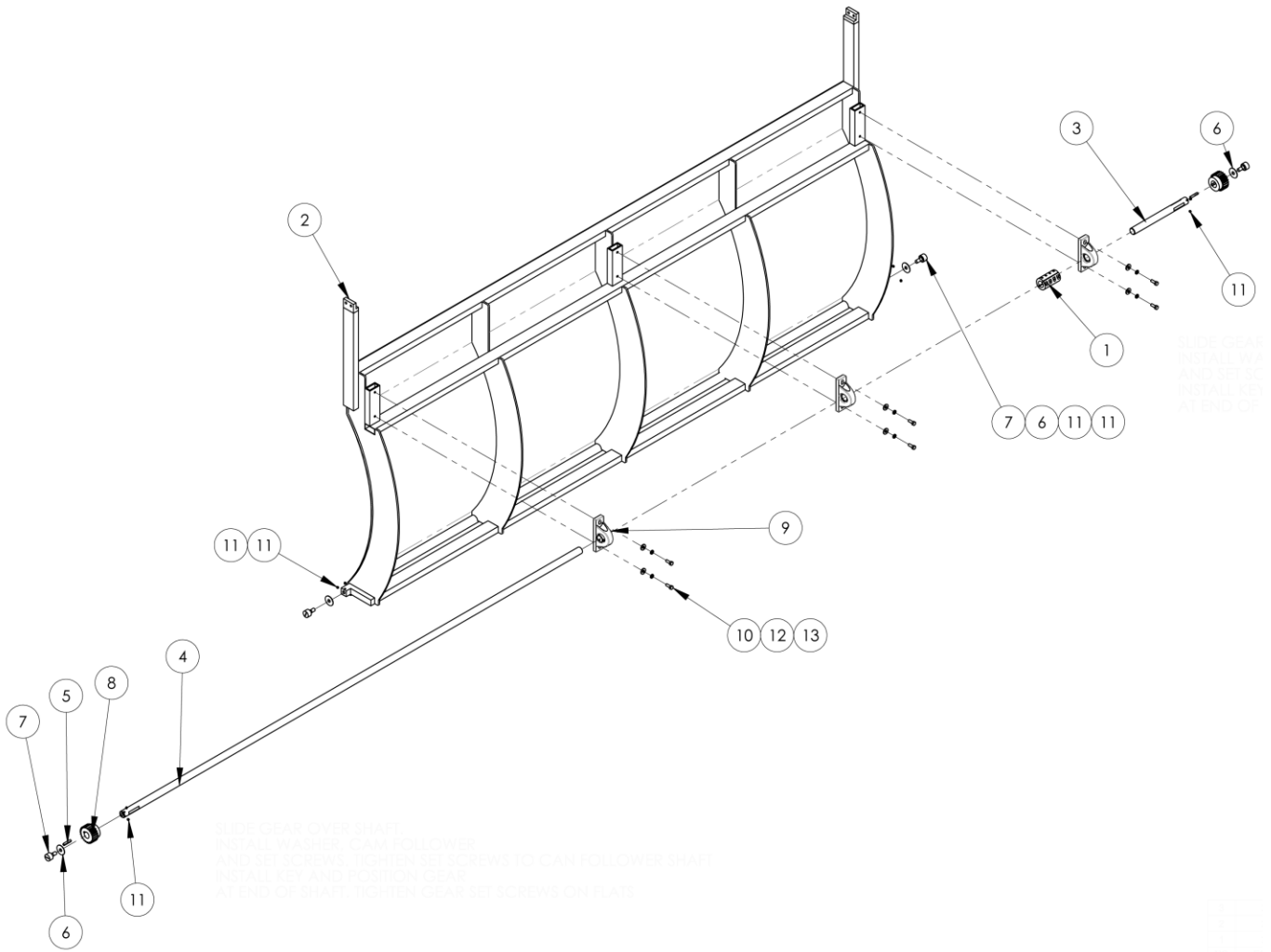
DETERMINE WHICH HOLES ARE BEING USED TO MOUNT THE UPPER CONVEYOR IN ASSEMBLY 1409221 BEFORE CUTTING CHAIN LENGTHS

CHAIN "A"	LENGTHS
UPPER HOLES	31.5"
MIDDLE HOLES (STANDARD)	35.5"
LOWER HOLES	39.5"
CHAIN "B"	
SAME LENGTH FOR ALL CONFIGURATIONS	45.5"
CHAIN "C"	
UPPER HOLES	79.5"
MIDDLE HOLES (STANDARD)	75.5"
LOWER HOLES	71.5"

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	156.5"	PPP40	CHAIN, #40 RIVET
2	3	PPP40CL	LINK, CONNECTING, #40
3	1	PPP40OL	OFFSET LINK, #40

1409311 GATE, BACK SKID

ACC Drawing Number 1409311 Rev.5



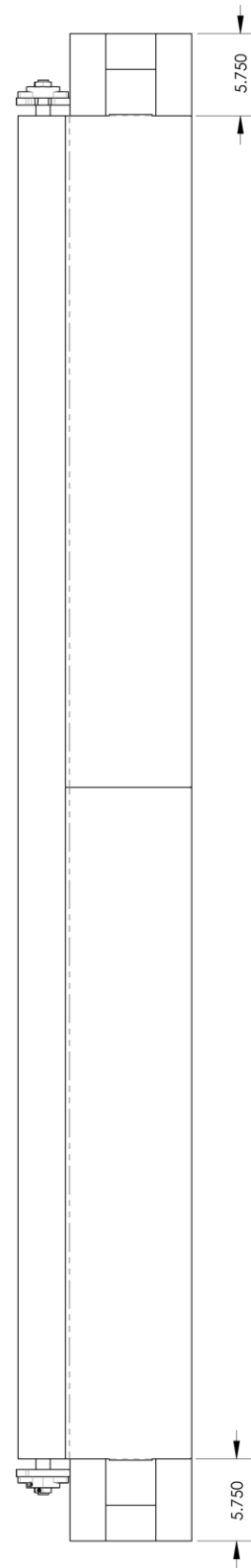
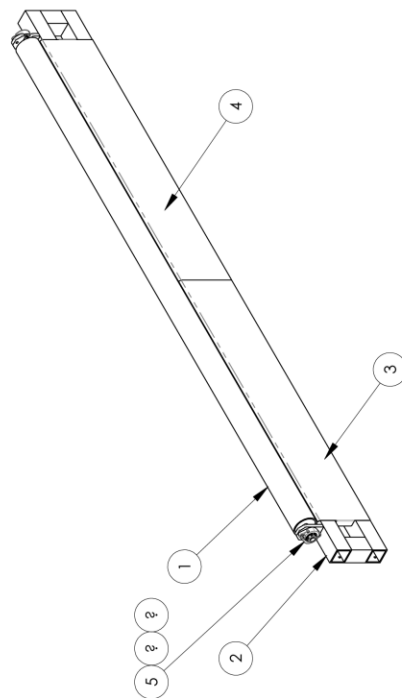
NO	QTY	PART #	DESCRIPTION
1	1	1306082	COUPLING,2-PIECE,1" BORE
2	1	1409283	BACK SKID WELDMENT
3	1	1409312	SHAFT, TRANSFER, SHORT,
4	1	1409313	SHAFT, TRANSFER, 1409
5	2	1409398	1/4X1.375 KEY
6	4	1409515	FENDER WASHER,.45 ID,
7	4	MMCCF1CSS	CAM FOLLOWER 1DIA CROWNED
8	2	MMNSS10F24-1M	GEAR,SPUR,10P,1 B W/KEY
9	3	MMVPLS-116	BEARING,PILLOW BLOCK 1.0B
10	6	SSH20080	5/16-24 X 1 1/4 HEX CAP
11	8	SSSS05016	1/4-28 X 1/4 SOC SET SC
12	6	WWF5/16	WASHER,FLAT,5/16
13	6	WWL5/16	WASHER,LOCK, 5/16

1409450 SKID PLATE ASM

ACC Drawing Number 1409450 Rev. 0

NO	QTY	PART #	DESCRIPTION
1	1	1409073	ROLLER, UNBAILER
2	1	1409434	BACK SKID WELDMENT
3	1	1409435	OUTFEED PLATE, LEFT
4	1	1409436	OUTFEED PLATE, RIGHT
5	2	BBFHSLF204-12G	BEARING, FLANGE, 3/4" ID

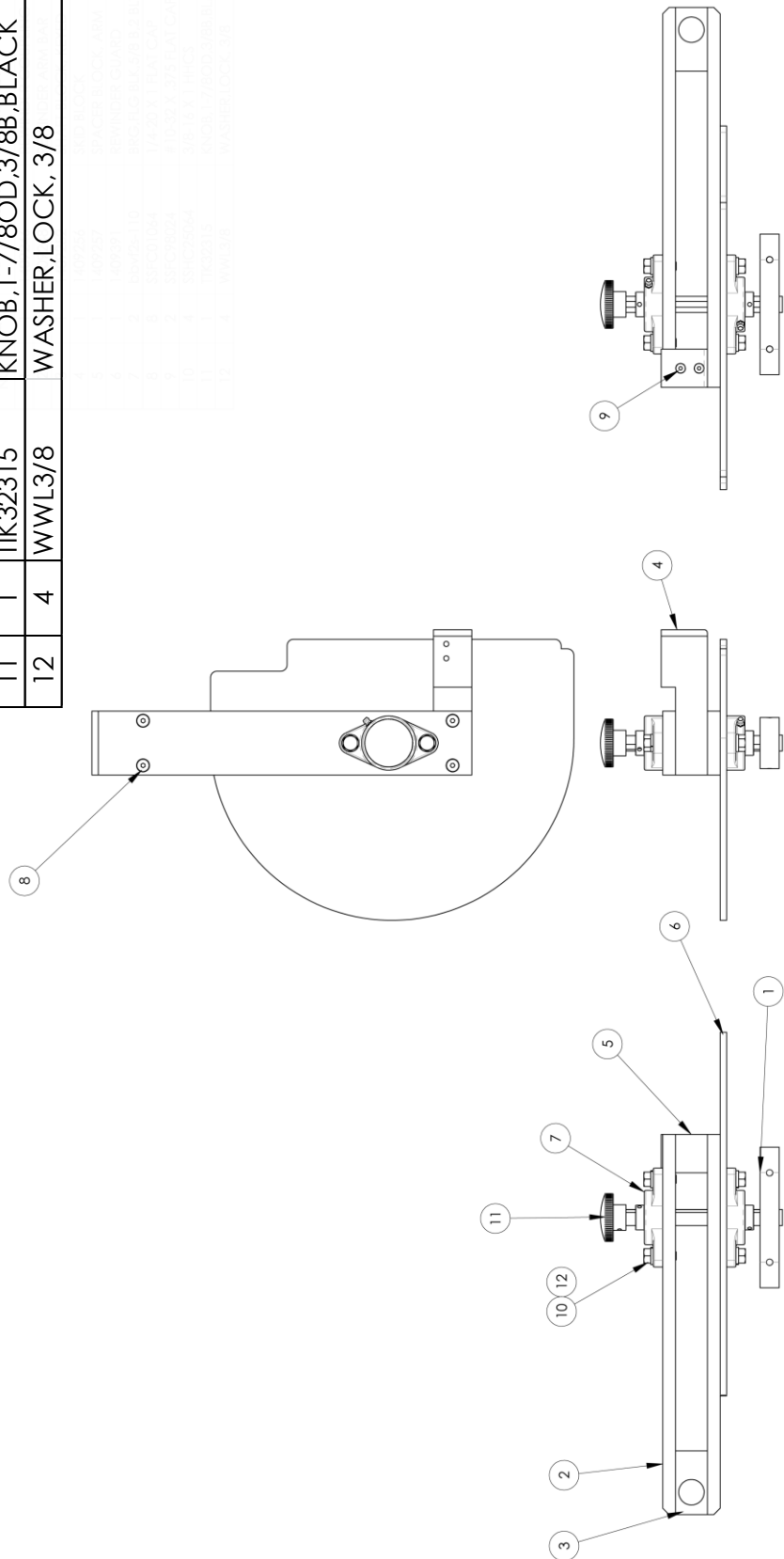
1409435
OUTFEED PLATE, LEFT
1409436
OUTFEED PLATE, RIGHT
BBFHSLF204-12G
BEARING, FLANGE, 3/4" ID



1409247 REWINDER ARM

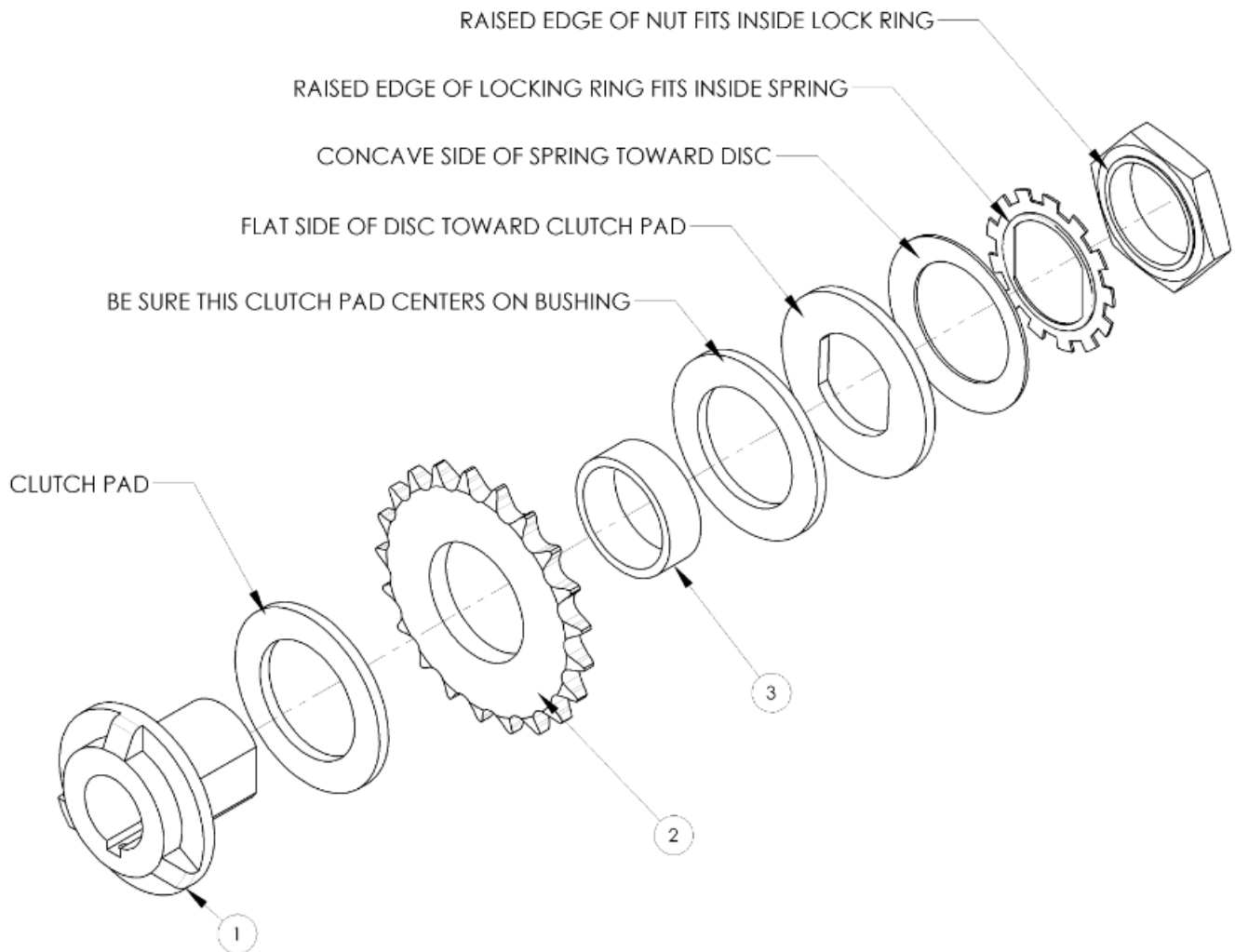
ACC Drawing Number 1409247 Rev.1

NO	QTY	PART #	DESCRIPTION
1	1	1409246	REWINDER COUPLING
2	2	1409248	REWINDER ARM BAR
3	1	1409252	SHAFT BLOCK, KEYED
4	1	1409256	SKID BLOCK
5	1	1409257	SPACER BLOCK, ARM
6	1	1409391	REWINDER GUARD
7	2	bbvf2s-110	BRG,FLG,BLK,5/8 B,2 BLT
8	8	SSFC01064	1/4-20 X 1 FLAT CAP
9	2	SSFC98024	#10-32 X .375 FLAT CAP
10	4	SSHC25064	3/8-16 X 1 HHCS
11	1	TK32315	KNOB,1-7/8OD,3/8B,BLACK
12	4	WWL3/8	WASHER,LOCK, 3/8



1409384 Torque Limit Assembly

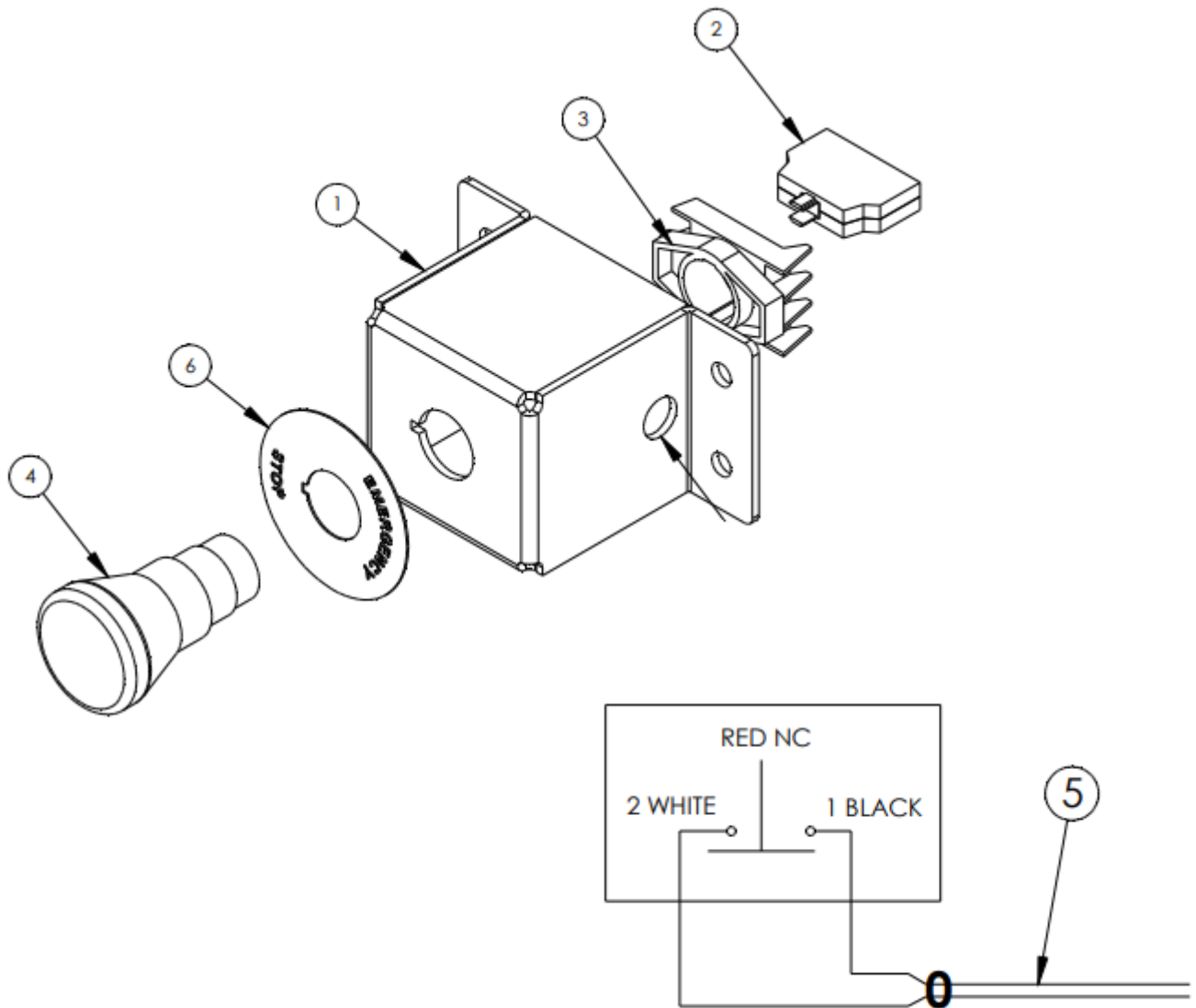
AAC Drawing Number 1409384 Rev 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1409050	HUB,MODIFIED,1" B
2	1	1409439	SPROCKET, MOD. #40, 21T
3	1	BB250AX_540	BUSHING,.54L,FOR TORQUE L

1409516 Stop Button Assembly

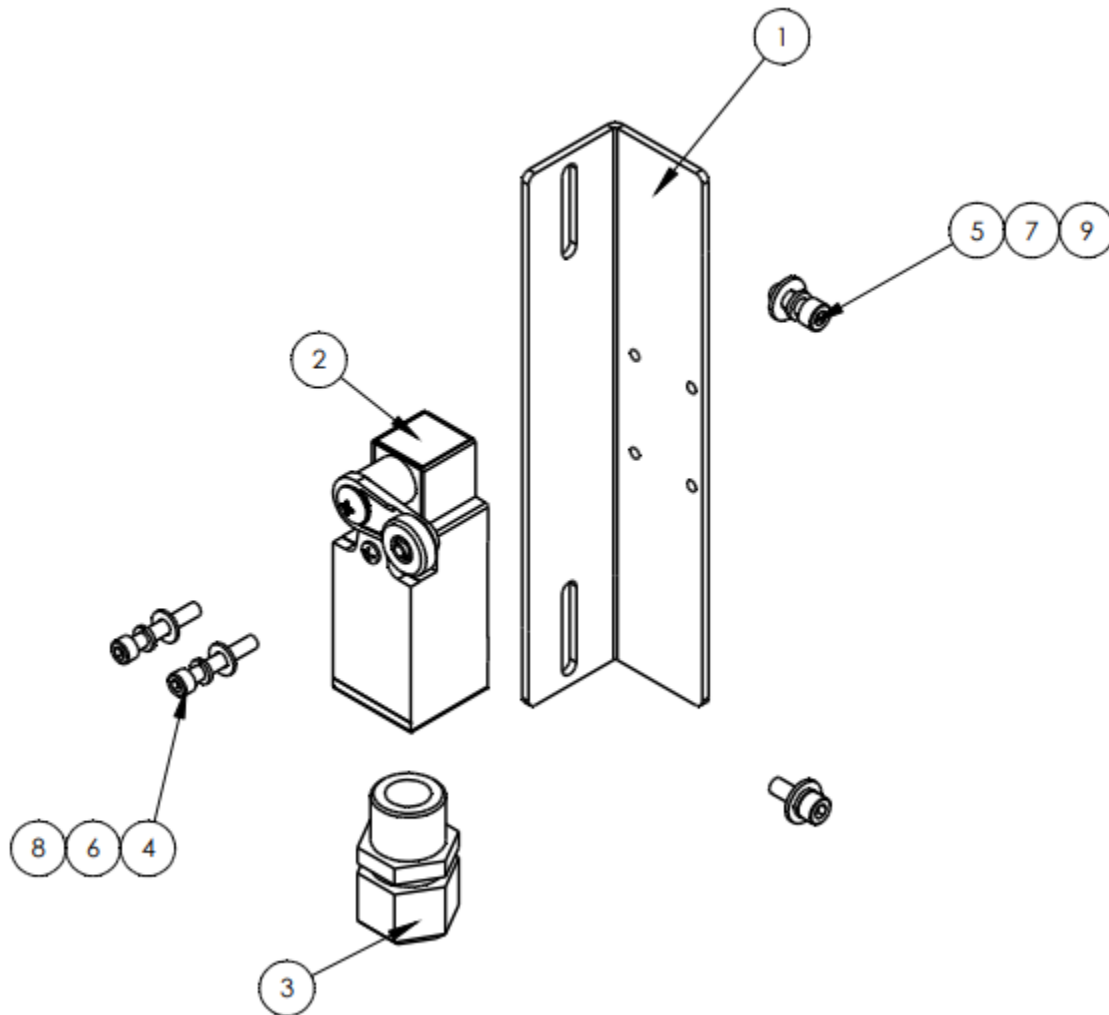
AAC Drawing Number 1409516 Rev 0



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	350-12154	BRKT,STOP BUTTON
2	1	EE3X01	BLOCK,P.B. CONTACT, N.C.
3	1	EEA3L	LATCH,PUSH BUTTON
4	1	EEPMTS44	E-STOP BUTTON, TWIST REL.
5	14'	FF822226	CABLE,SOOW,2X16AWG,600V
6	1	MM800E15YE112	E-STOP LEGEND PLATE

1409585 Limit Switch Assembly

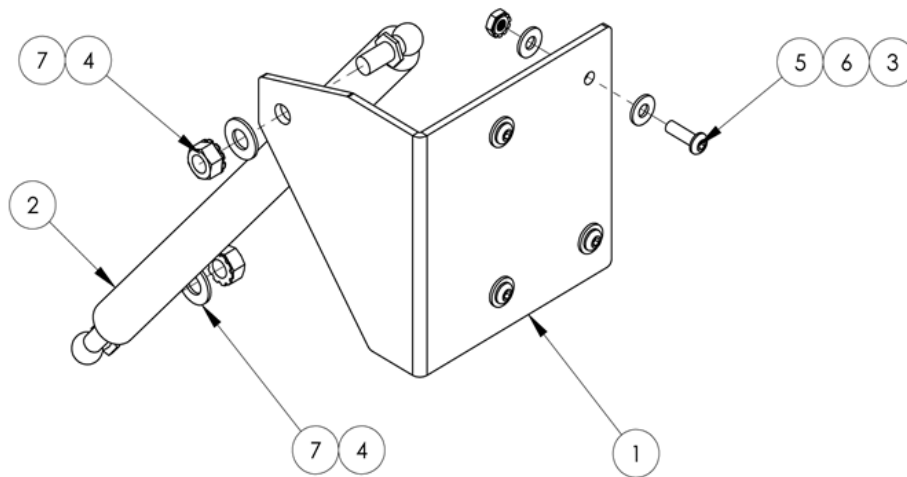
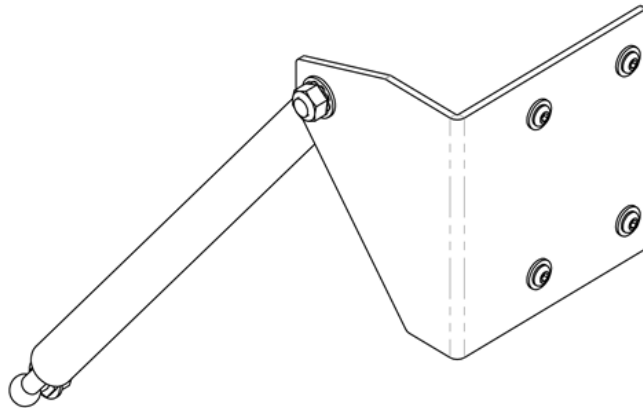
AAC Drawing Number 1409585 Rev 0



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1409583	LIMIT SW BRACKET
2	1	FFGLLA01A1B	SWITCH, LIMIT, ROLLER
3	1	FFM4518	STRAIN RELIEF, LIQ TIGHT
4	2	SSSC90064	#8-32 X 1 SOC CAP SC
5	2	SSSC98032	10-32X1/2, SOC CAP
6	2	WWF8	WASHER, FLAT, #8
7	2	WWFS10	WASHER, FLAT, #10, SAE
8	2	WWL8	WASHER, LOCK, #8
9	2	WWL10	WASHER, LOCK, #10

1409586 GAS SPRING ASSEMBLY

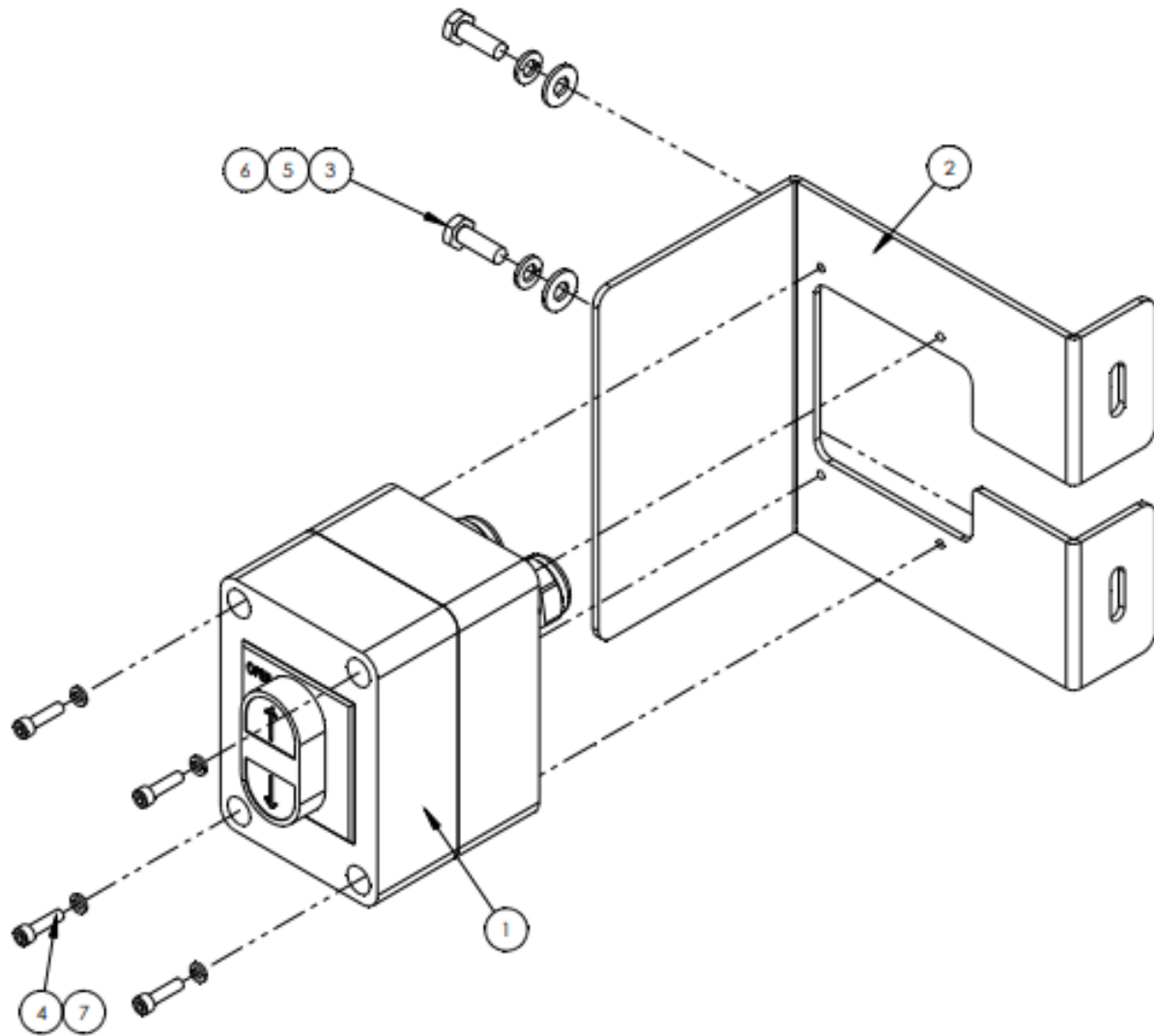
AAC Drawing Number 1409586 Rev 1



NO	QTY	PART #	DESCRIPTION
1	1	1409584	GAS SPRING BRACKET
2	1	MM4138T574	GAS SPRING W/END FITTING
3	4	NNK10-32	KEP NUT, 10-32
4	2	NNK5/16-18	NUT,KEP,5/16-18
5	4	SSBC98040	10-32 X 5/8 BUTTON CAP SC
6	8	WWFS10	WASHER, FLAT, #10, SAE
7	2	WWFS5/16	WASHER,FLAT,SAE,5/16

1409587 Gate Control Switch Assembly

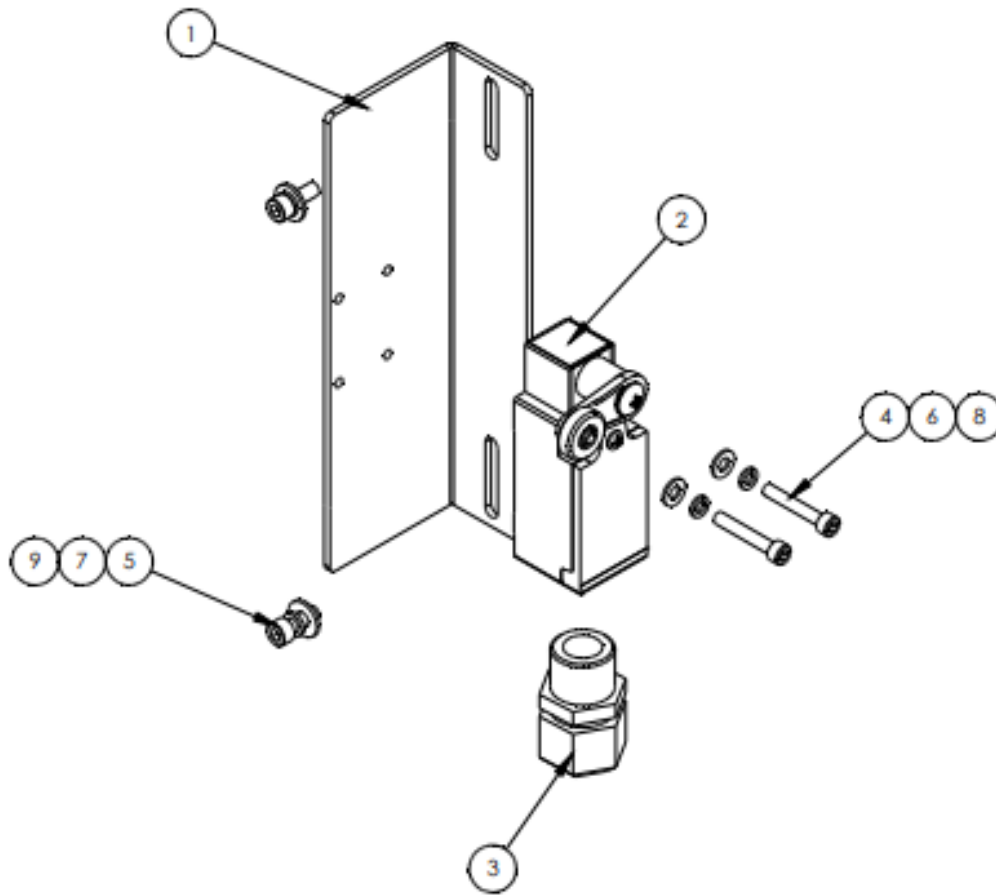
AAC Drawing Number 1409587 Rev 1



ITEM #	QTY.	PART #	DESCRIPTION
1	1	1409578	BOX, UP/DN CONTROL
2	1	1409582	MTG BRKT, GATE CONTROL
3	2	SSHC01048	1/4-20 X 3/4 HEX CAP
4	4	SSSC90040	8-32 X 5/8 SOC CAP SC
5	2	WWFS1/4	WASHER,FLAT,SAE,1/4
6	2	WWL1/4	WASHER,LOCK, 1/4
7	4	WWL8	WASHER,LOCK,#8

1409604 Limit Switch Assembly, Left Gate

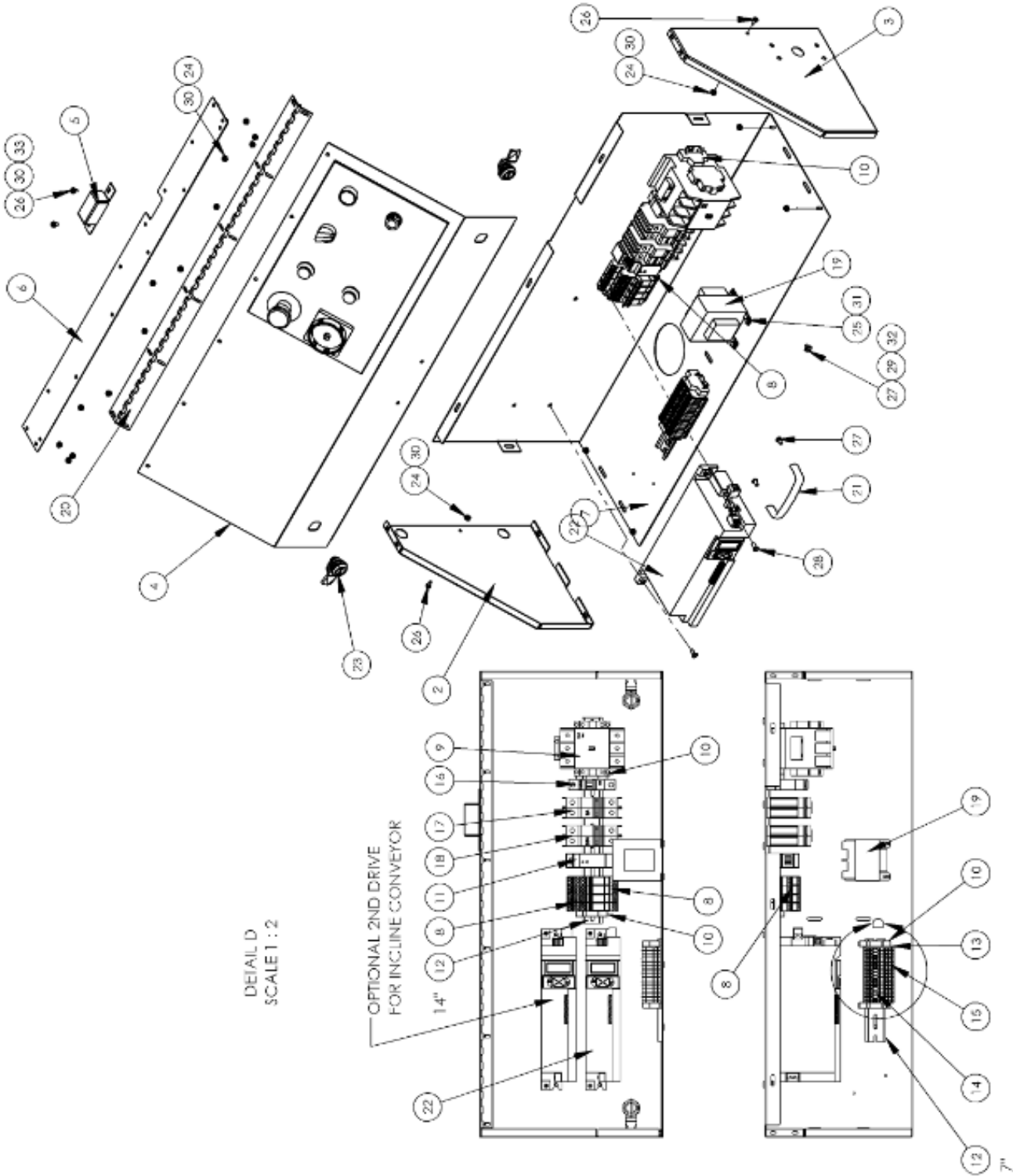
AAC Drawing Number 1409604 Rev 0



ITEM NO.	Hardware Shown/QTY.	PART NUMBER	DESCRIPTION
1	1	1409603	LIMIT SW BRACKET, LARGE
2	1	FFGLA01A1B	SWITCH, LIMIT, ROLLER
3	1	FFM4518	STRAIN RELIEF, LIQ TIGHT
4	2	SSSC90064	#8-32 X 1 SOC CAP SC
5	2	SSSC98032	10-32X1/2, SOC CAP
6	2	WWF8	WASHER, FLAT, #8
7	2	WWFS10	WASHER, FLAT, #10, SAE
8	2	WWL8	WASHER, LOCK, #8
9	2	WWL10	WASHER, LOCK, #10

1409805 CONTROLS ASM

Drawing Number 1409805 Rev.1

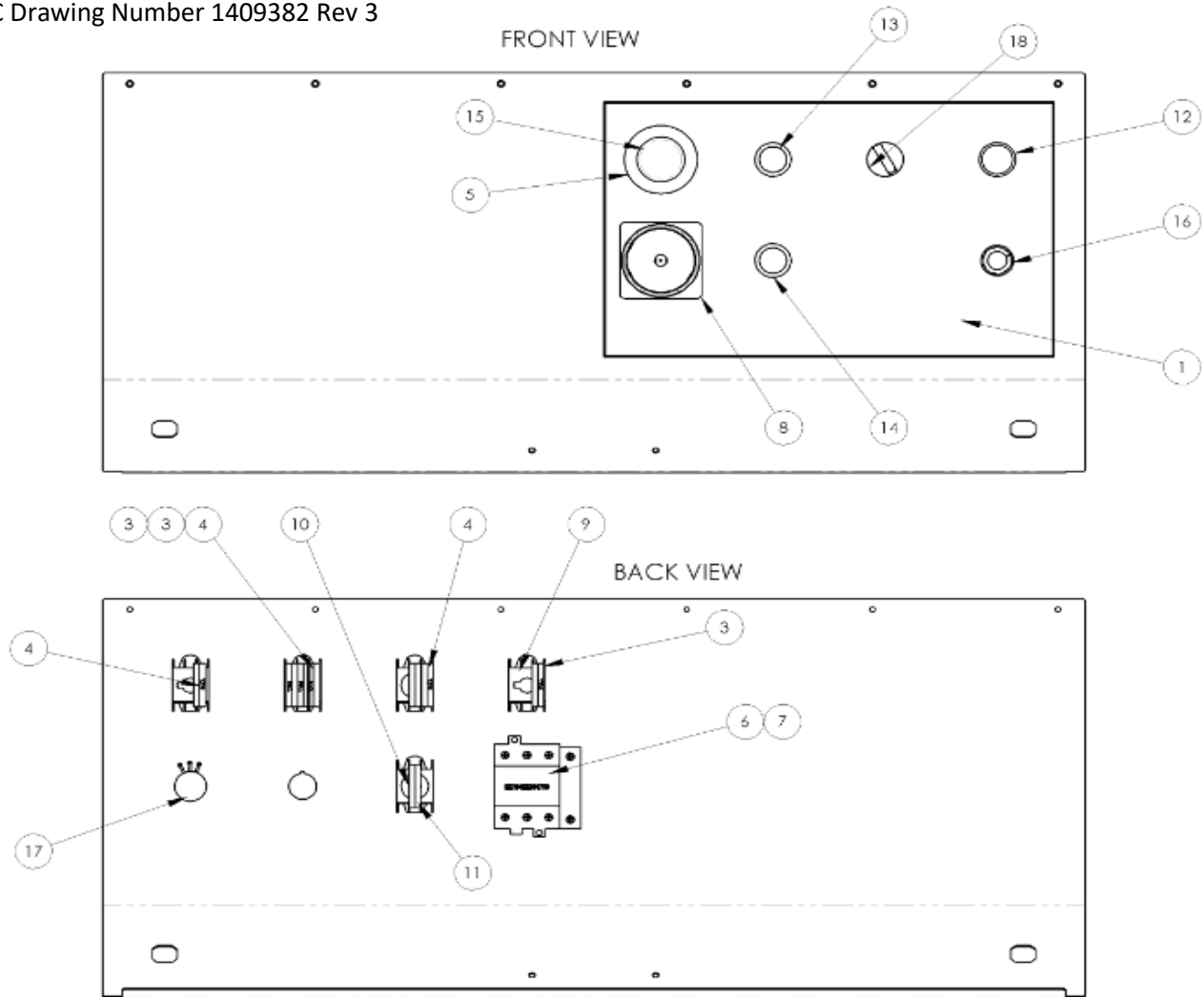


1409805 parts list

ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1409-WD8	DIAGRAM, WIRING 1409 NEW
2	1	1409260	PANEL MOUNT, LH
3	1	1409261	PANEL MOUNT, RH
4	1	1409382	1409 CONTROLS ASM
5	1	1409385	GUARD, CABLE
6	1	1409519	PLATE, CONTROL DOOR MNT
7	1	1409812	PLATE, CONTROLS
8	4	EE788311	RELAY,12V,DPDT,WAGO
9	1	EECGC85A24	CONTACTOR,65A,24VAC
10	6	EECLIPFIX	ANCHOR,DIN RAIL
11	1	EEDR1512	POWER SUP. SWITCHER,12V
12	*21"	EETS35X7.5A	DIN RAIL-AMERICAN
13	1	FF280-308	TERMBLK ENDPLATE,WAGO,280
14	9	FF280-402	JUMPER,WAGO,TOP,SNGL
15	19	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY
16	1	FFL741C	CIRCUIT BREAKER,THERM-MAG
17	1	FFQL213DMKM02	CIRCUIT BREAKER,2A,2P
18	1	FFQL213DMKM20	CIRCUIT BREAKER,20A, 2P
19	1	FFTX28/5A	TRANSFORMER,28V,4.6AMP
20	1	MM1155-305	HINGE,PIANO,STL,2X 30.5"
21	1	MM1897A24	HANDLE,DOOR,PULL,OVAL,5/8
22	1	MM510215B1M2	DRIVE,VFD,I510,2HP
23	2	MMELH-1	LATCH, 1/4 TURN, SLOTTED
24	19	NNK8-32	NUT,KEP,8-32
25	4	SSHC98024	10-32 X 3/8 HEX CAP
26	4	SSPP90024	8-32X3/8 PAN PHILPS
27	7	SSPP98024	10-32 X 3/8 PAN HD PHILIP
28	2	SSPP98032	10-32 X 1/2 PAN PHIL
29	5	WWF10	WASHER, FLAT, #10, COM
30	21	WWF8	WASHER, FLAT, #8
31	4	WWFS10	WASHER, FLAT, #10, SAE
32	5	WWL10	WASHER, LOCK, #10
33	2	WWL8	WASHER, LOCK, #8

1409382 Control Assembly

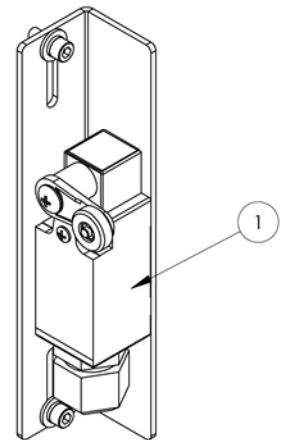
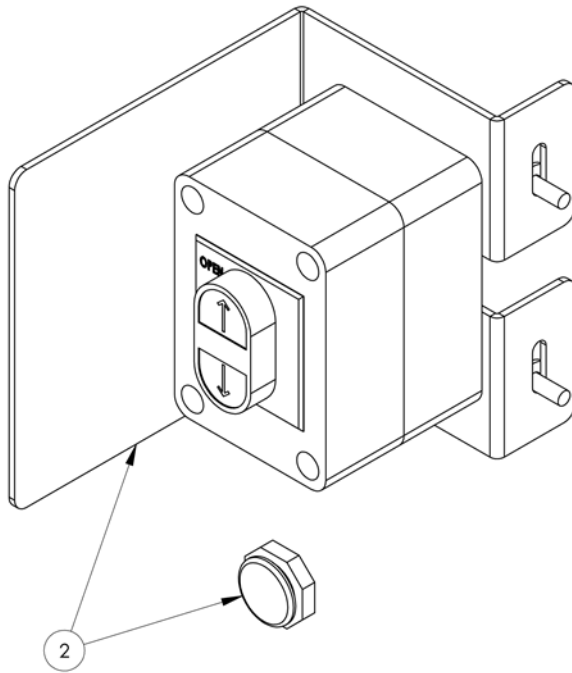
AAC Drawing Number 1409382 Rev 3



ITEM	QTY.	PART NUMBER	DESCRIPTION
1	1	1409-LAB	LABEL, 1409
2	1	1409381	CONTROLS PLATE
3	3	EE3X01	BLOCK,P.B. CONTACT, N.C. (RED)
4	3	EE3X10	BLOCK,P.B. CONTACT, N.O. (GRN)
5	1	EE15Y	PLATE, LEGEND, YELLOW
6	1	EE194EE631753	63AMP DISCON
7	1	EE194EE63PE	GROUND TERMINAL
8	1	EE194LHE6N175	DISCONNECT HANDLE,RED/YEL
9	5	EEA3L	LATCH,PUSH BUTTON
10	2	EED7N141	LAMP, INCONDES,12VAC/DC
11	2	EED53D0	BLOCK, LAMP, 22MM P.B.
12	1	EEPF5	BUTTON,PUSH,22MM,YELL,MO
13	1	EEPLE3	BUTTON, PUSH, GRN, ILLUM
14	1	EEPLE4	BUTTON, PUSH, RED, ILLUM
15	1	EEPMTS44	E-STOP BUTTON, TWIST REL.
16	1	FF274-416	KNOB,SPEED CONTROL
17	1	FFRPOT10K	POTENTIOMETER,10K
18	1	MM800EPSM22	SWITCH, 2 POS SELECTOR

1409580 GATE SAFETY CONTROL

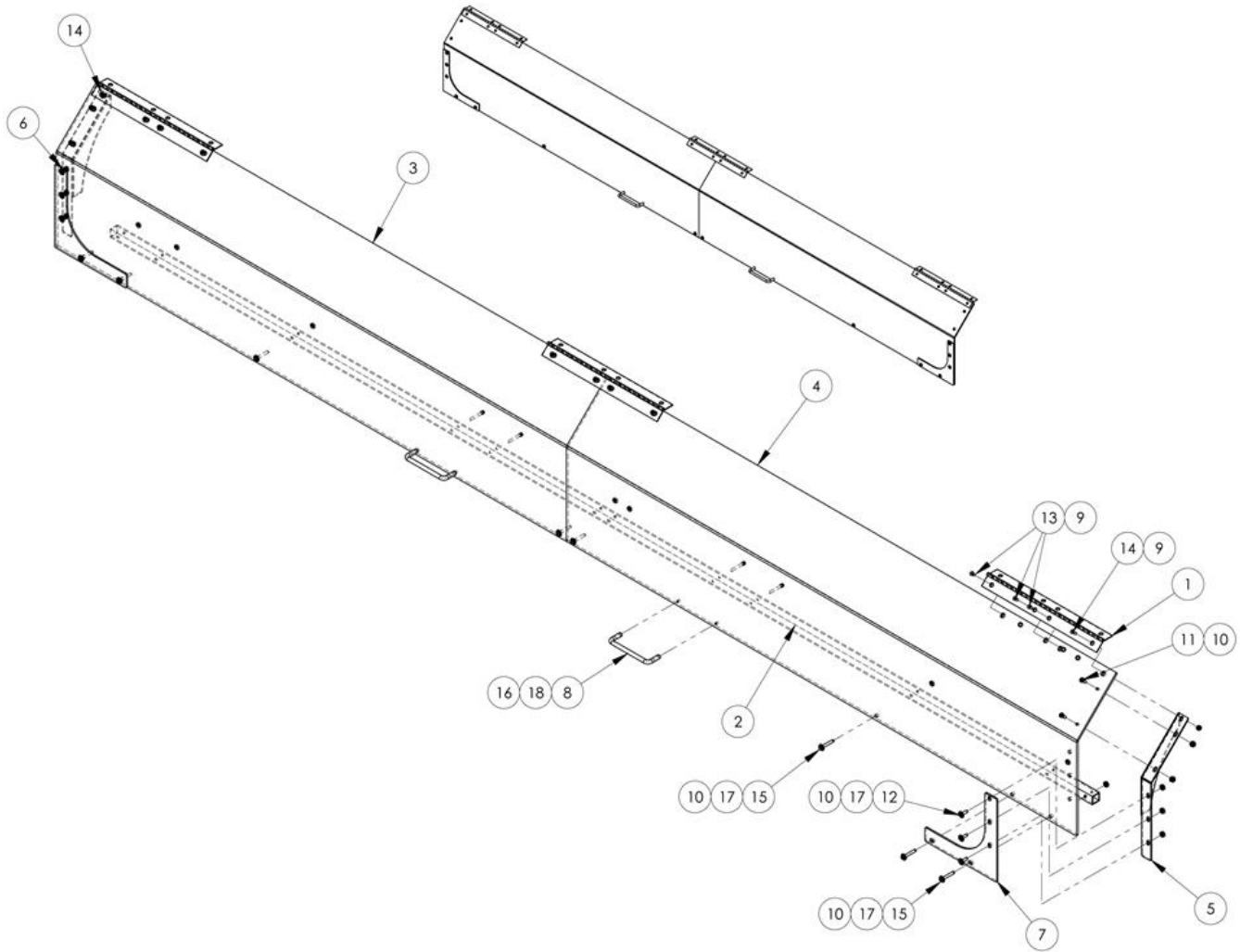
AAC Drawing Number 1409580 Rev 1



NO	QTY	PART #	DESCRIPTION
1	1	1409585	LIMIT SW ASSY
2	1	1409587	GATE CONTROL SWITCH ASSY
3	1	1409-WD4	WIRING, DBL SOL, & REMOTE
4	1	1409-WD5	WIRING, REMOTE DOOR SW

1409574 REWIND GUARD DOOR

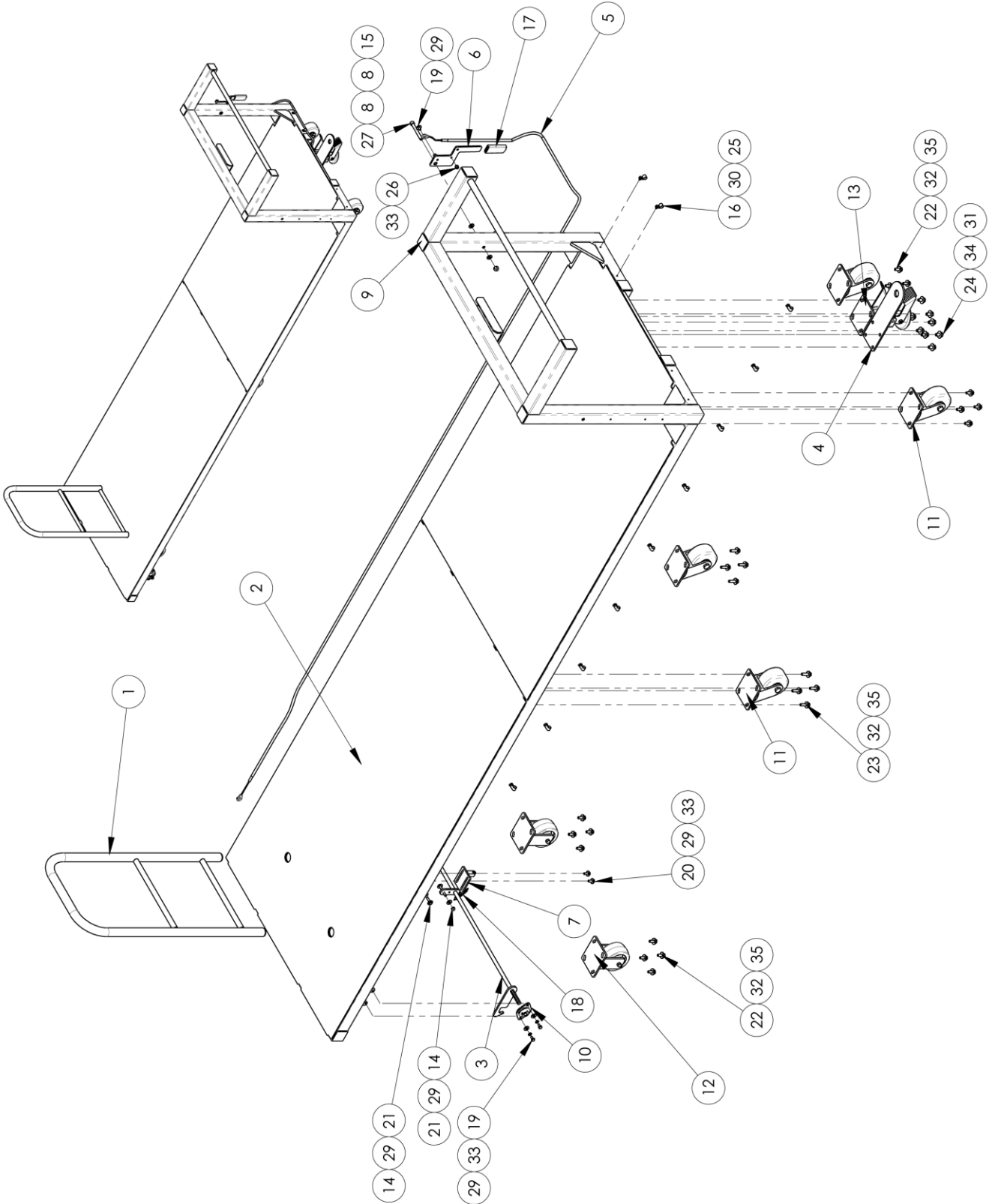
AAC Drawing Number 1409574 Rev 3



NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	3	1409130	12" HINGE	10	18	NNK10-32	KEP NUT, 10-32
2	1	1409362	DOOR STIFFENER	11	4	SSBC98032	10-32 X 1/2 BUTTON CAP SC
3	1	1409411	UPPER GUARD, REWIND, LEFT	12	6	SSBC98040	10-32 X 5/8 BUTTON CAP SC
4	1	1409412	UPPER GUARD, REWIND, RT	13	10	SSFC90024	8-32 X 3/8 FL ALN CAP
5	1	1409510	COVER BRACE, RIGHT	14	2	SSFC90032	8-32 X 1/2 FLAT ALLEN CA
6	1	1409511	COVER BRACE, LEFT	15	8	SSHC98080	10-32 X 1-1/4 HEX CAP
7	2	1409589	CORNER BRACE	16	4	SSSC90080	#8-32 X 1-1/4 SOC CAP SC
8	2	MM1568A45	HANDLE, DOOR, PULL	17	14	WWFS10	WASHER, FLAT, #10, SAE
9	12	NNK8-32	NUT, KEP, 8-32	18	4	WWL8	WASHER, LOCK, #8

1409625 Four Roll Cart, 36x125, (Optional)

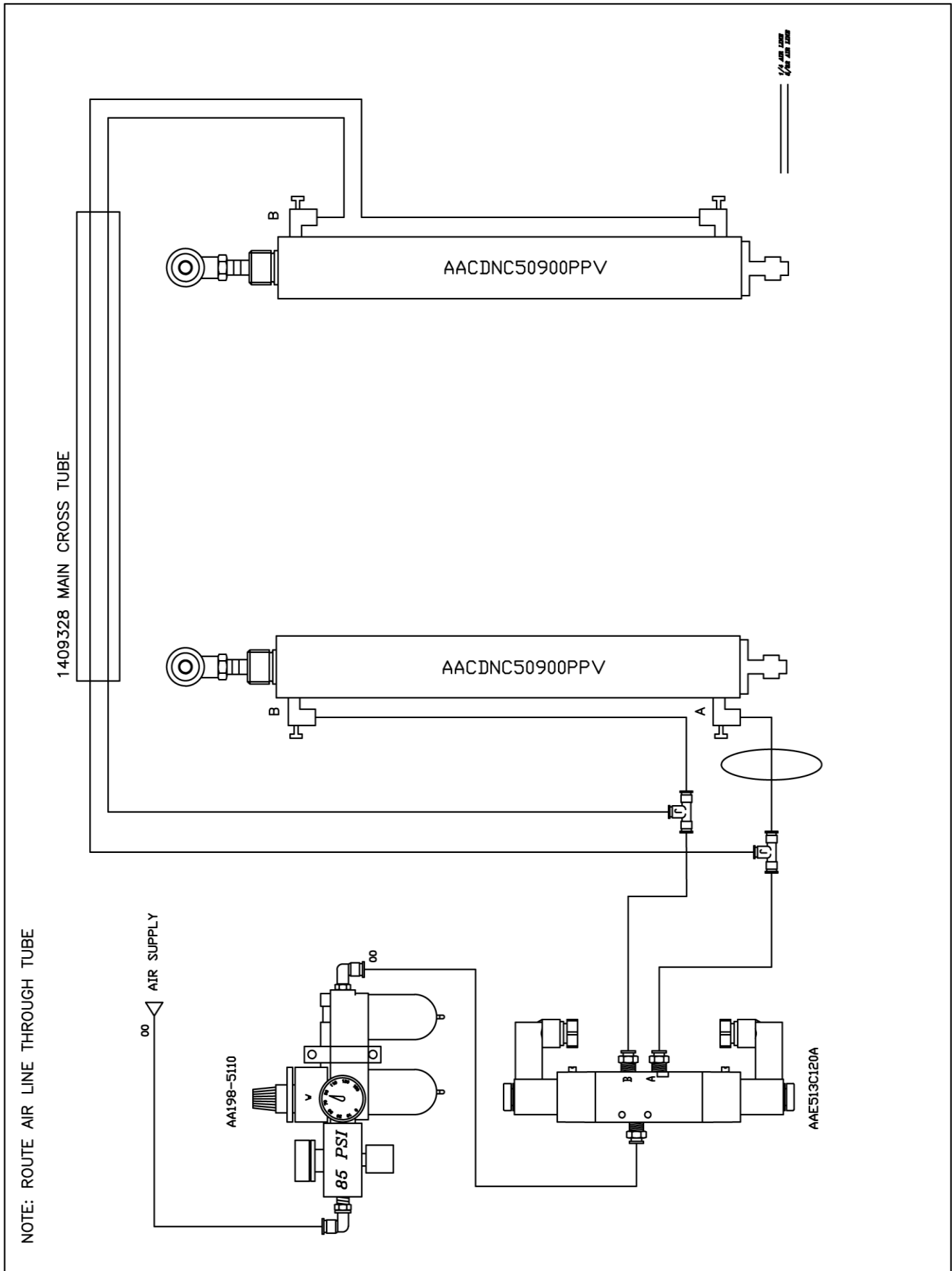
AAC Drawing Number 1409625 Rev.1



1409625 parts list

NO	QTY	PART #	DESCRIPTION
1	1	1409506	ROLL LOCKER
2	1	1409624	FRAME ASSEMBLY, FOUR ROLL CART
3	1	1409646	LATCH ASSEMBLY FOR MATERIAL CART
4	1	1409654	TUG PIN MOUNT
5	1	1409692	CLAMP CABLE
6	1	1409694	HANDLE, LOCK, WELDMENT
7	1	1409696	ANCHOR BLOCK SLOT, CABLE
8	2	BBTT710-01	WASHER, THRUST, BRNZ.
9	8	MM132-2X2	END CAP, SQUARE, 2X2
10	2	MM5913K51	BEARING, FLANGE, 1/2 BORE
11	4	MM664001PHN	CASTER, 4" SWIVEL
12	2	MM6640R01PHN	CASTER, 4" RIGID, 800#
13	1	MMAL16-LF-0680	FLOOR LOCK, 7-1/4" CASTER H, 7.5" EXT 6.5" RET
14	2	NNE1/4-20	NUT, ELASTIC LOCK, 1/4-20
15	1	NNE3/8-16	NUT, ELASTIC 3/8-16
16	13	PPP2215B	WIRE CLAMP, .193" I.D.
17	1	PPP9282K82	GRIP, CUSH. SLIDE ON, 3/16" X
18	1	RRLE055DE9	SPRING, EXT .055" X .44" X 2.5"
19	5	SSHC01032	1/4-20 X 1/2" HHCS
20	2	SSHC01048	1/4-20 X 3/4" HEX CAP
21	2	SSHC01128	1/4-20 X 2" HEX CAP
22	16	SSHC10056	5/16-18 X 7/8" HHCS
23	8	SSHC10080	5/16-18 X 1-1/4" HHCS
24	8	SSHC25048	3/8-16 X 3/4" HEX CAP
25	13	SSHC98024	10-32 X 3/8" HEX CAP
26	1	SSSC01016S	1/4-20 X 1/4" SOC CAP SC
27	1	SSSC25192	3/8-16 X 3" SOC CAP
28	2	SSSS80012	6-32 X 3/16" SOC SET SCREW
29	11	WWF1/4	WASHER, FLAT, 1/4", COM
30	11	WWF10	WASHER, FLAT, #10, COM
31	8	WWF3/8	WASHER, FLAT, 3/8" OR 10MM
32	24	WWF5/16	WASHER, FLAT, 5/16"
33	7	WWL1/4	WASHER, LOCK, 1/4"
34	8	WWL3/8	WASHER, LOCK, 3/8"
35	24	WWL5/16	WASHER, LOCK, 5/16"

1409-PD PNEUMATIC DIAGRAM



Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

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

Términos y Condiciones:

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

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

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



Atlanta Attachment Company

362 Industrial Park Drive

Lawrenceville, GA 30046

770-963-7369

www.atlatt.com

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