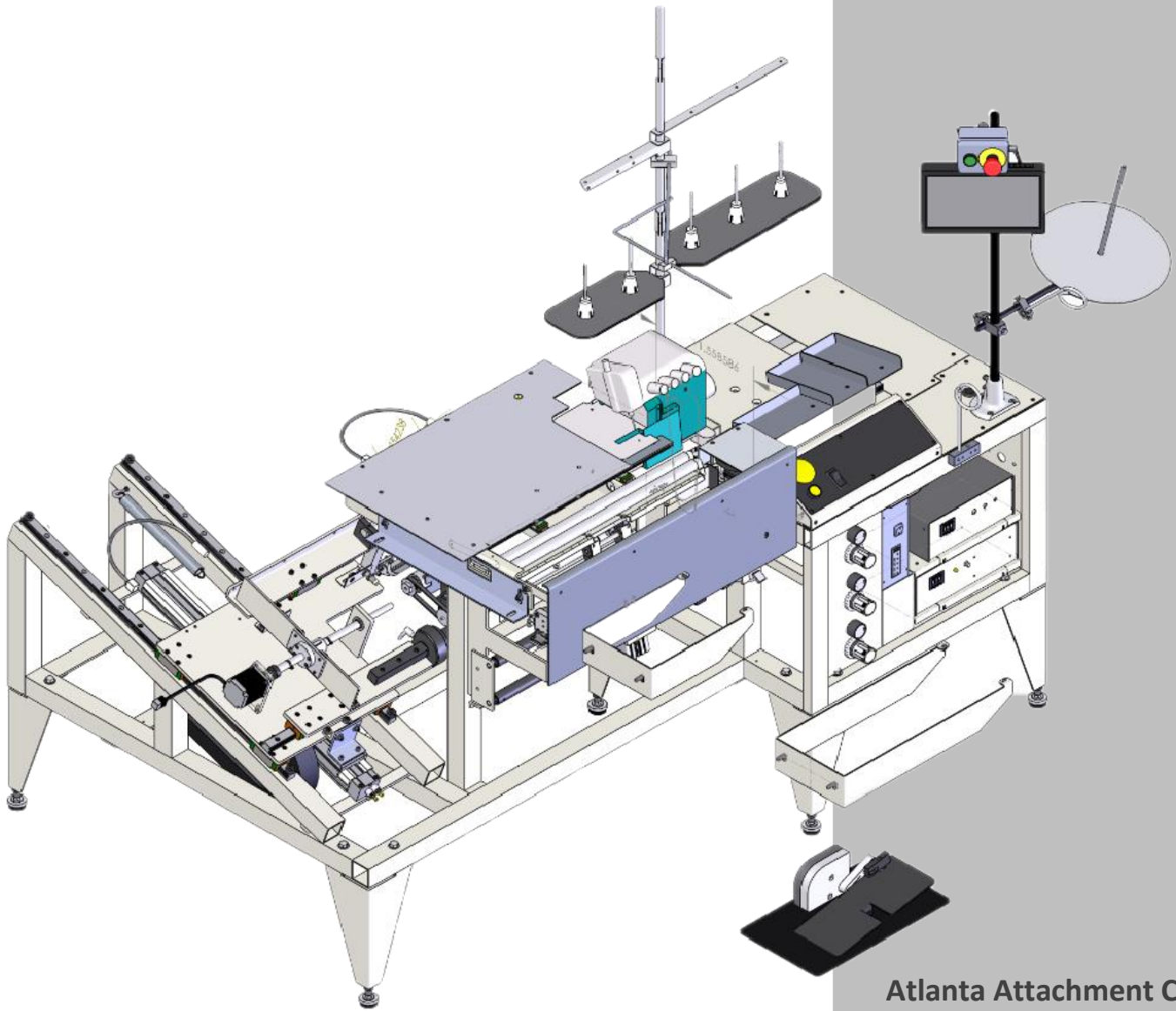




Model 1337DLA

Revision 0 Created September 19, 2024(wr)

Technical Manual & Parts Lists



Atlanta Attachment Company

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ATLANTA ATTACHMENT COMPANY, INC.

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

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Technical Manual & Parts Lists

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Important Safety Instruction



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

Mandatory Information

All persons operating and/or working on the 1337DLA , 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.

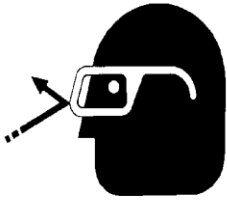
Signs on the Machine

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

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

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

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

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

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

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

Machine Overview

The 11337DLA is a semi-automatic unit designed to assemble prepared skirt material to mattress pads. This unit utilizes premade skirt material in roll format with the elastic already installed. This roll is installed under the machine and held by a friction brake to maintain a constant tension on the skirt. The operator presents mattress pads one at a time to sew the pad and skirt together.



Skirt Material Path

The following image indicates the skirt roll path to operate the semi-automatic mattress pad skirt feeder. For ergonomic purposes and ease of operation the skirt roll is loaded from behind the machine. Material then passes through a series of rollers which help align the target edge of the roll to the sewing plane.

Installation

- Remove any shipping straps from machine.
- Inspect the machine for any damage that may have occurred during shipping. If damage is found, report this immediately to your supervisor. Document the damage and provide details and photographs.
- Provide a 220VAC, single phase, 5 Amp
- Provide 3/8" air supply line (85 PSI).
- Oil is removed before shipping. Check the oil level in the oil pan.
- Install support Air Table and connect to the plug provided. When power is on at the Main Power Switch the blower on the air table will be running.



Major Machine Components

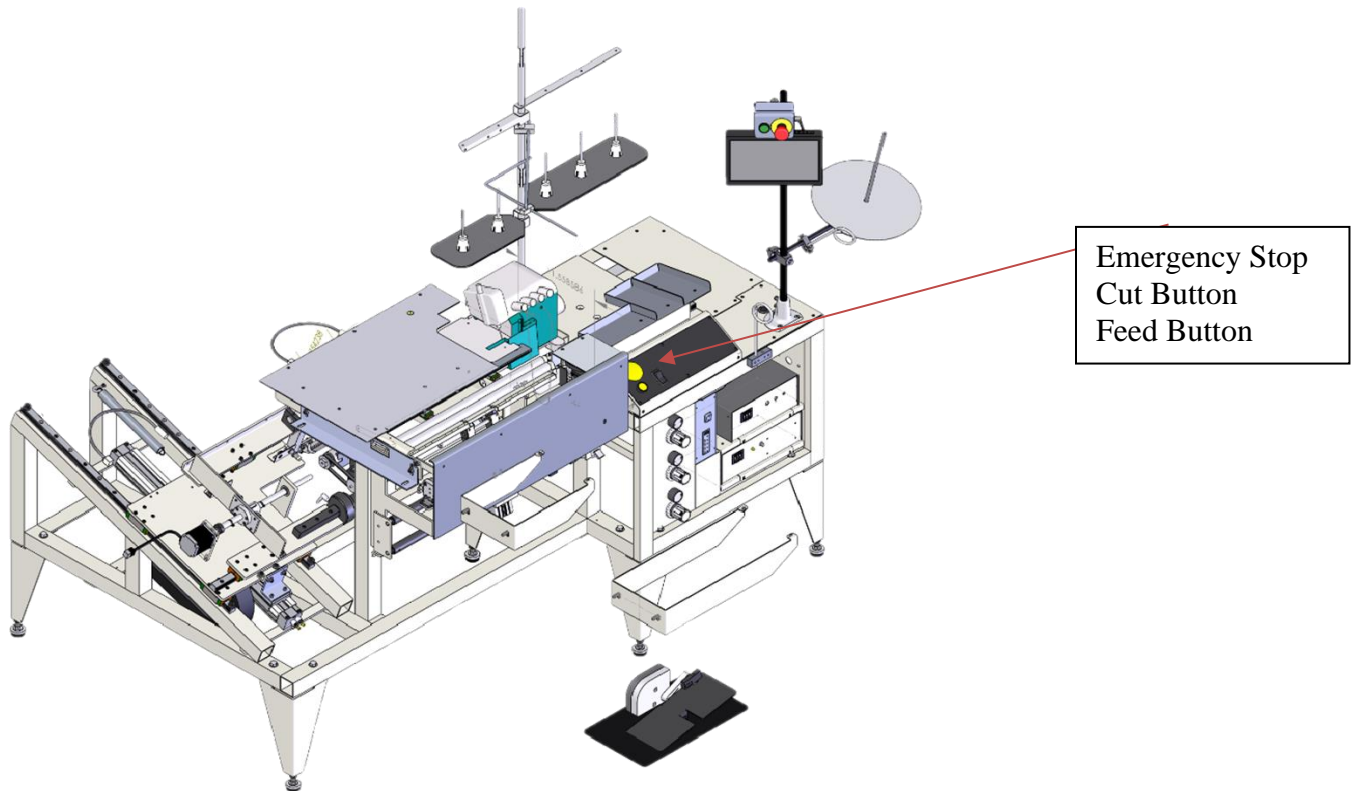
All directions (front, back, right or, left) are assumed to be from the front facing the unit unless otherwise stated.

ON / OFF Switch

- Basic on / off pushbutton operation for machine power.
- The ON button will not energize the machine unless the red EMERGENCY STOP BOTTON (Operator Panel) is in the up position.
- The red Off kill all power to the machine



Operator Panel



- EMERGENCY STOP (E-Stop) - LARGE RED BUTTON
 - Press Down to disengage all power to the machine (electrical and Pneumatic).
 - Turn CW and pull up to reset the E-STOP button.
 - The **ON / OFF Switch** will not operate if the E-STOP button is pressed.

-
- CUT – LARGE YELLOW BUTTON
 - In Manual Mode the Cut Cycle is activated every time.
 - In Auto Mode it performs two functions
 - First Press - Activates the Cut Cycle
 - Closes Finger Guard
 - Turns on Cutter Motor
 - Moves the Cutter Motor to across the material based on a specified amount of time timer controlled by the digit switches(Position 1-2) on the Main Controller front panel, Then back to the home position for that same amount of time.
 - Shuts off the Cutter Motor
 - Retracts Finger Guard.
 - Second Press - Activates the Feed Cycle
 - Feeds Skirt Material for a preset amount of time (length) and blows air to present material for operator to ready next cycle.
 - Amount of material is set by a timer controlled by the digit switches (Position 3-4) on the Main Controller front panel.
 - SKIRT FEED – SMALL YELLOW BUTTON
 - Feed a short piece of skirt cloth into the work area to load or start a new operation. Feeds while button is pressed.
-

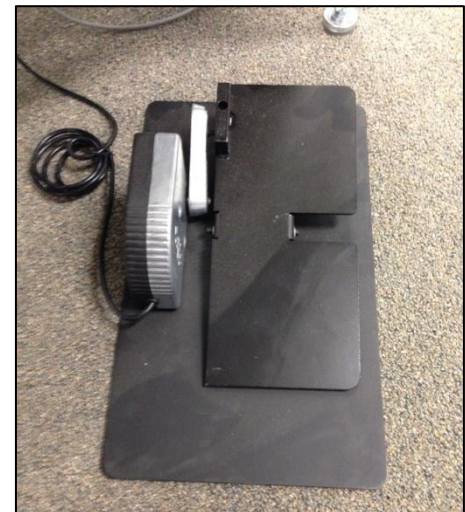
Pneumatic Pressure Panel

- SKIRT TENSION – Material Dependent - Controls the force of the Backpressure Roller against the Skirt Roll. If the pressure is too low the brake could slip on the material resulting in inconsistent tension. Too high a pressure will deform the roll and increase tension on the skirt. The Skirt Tension needs to be high enough to prevent the brake for slipping.
Suggested Start point ~ 20PSI
- ROLL PRESSURE – Material Dependent - Controls the brake force (drag) of the skirt Roll. Ultimately this brake force controls the amount of stretch for the skirt material being processed. Too little back pressure the material is not stretched, too much and it will not feed through the machine. NOTE: the brake force is only active while the Skirt Tension Roller is activated against the Skirt Roll.
Suggested Start point ~ 30PSI
- CUTTER GUARD - Controls the force with which the Finger Guard drives forward for the cut operation. Enough force is needed to stretch the material for a good cut operation but should not be so strong as not to permit the operator from removing a finger if momentarily “caught” as the cut operation starts.
Suggested Start point ~ 15PSI



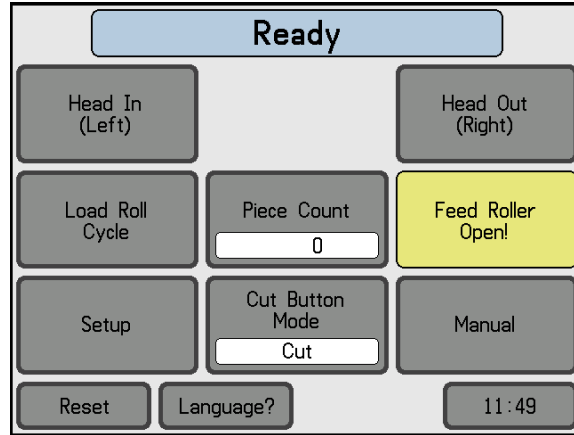
- **Foot Pedal**

– Controls the speed with which the sewing operation progresses. Analog input, the more pressure on the front of the pedal the faster the machine will run / sew / process. There is no backpressure or foot lift motion associated with this machine



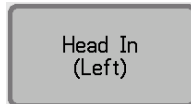
Touch Screen Controls

Ready Screen

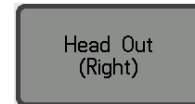


Position of Sewing Head

Move to Left

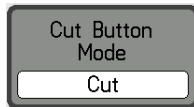


Move to Right

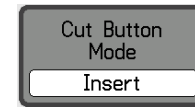


Cut Button Mode

Push to Cut elastic



Push to Insert elastic

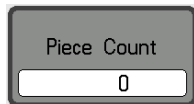


Feed Roller Position

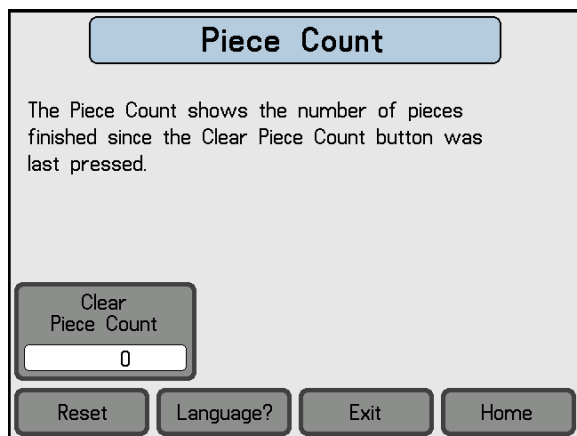
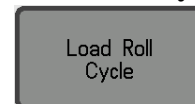
Push to Open



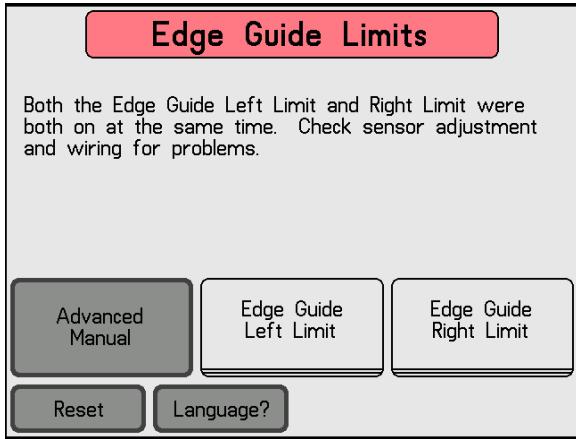
Piece Count



Load Roll Cycle



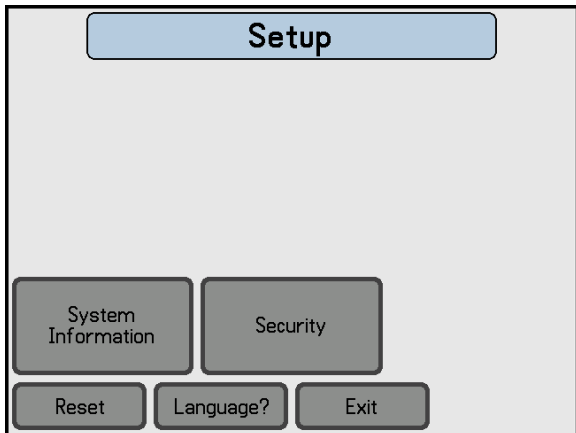
Manual Button



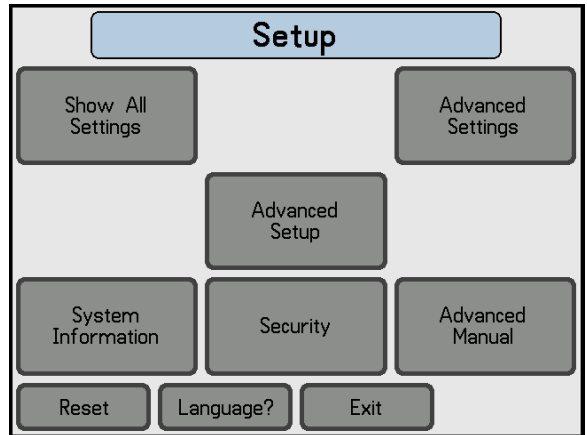
Setup Button



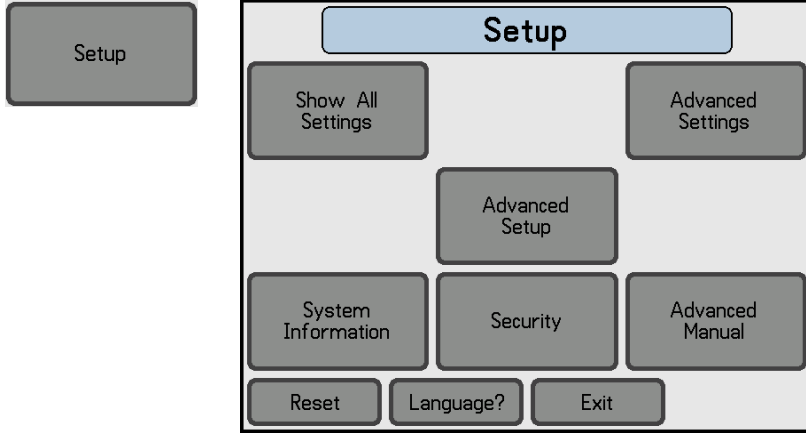
Operator level view



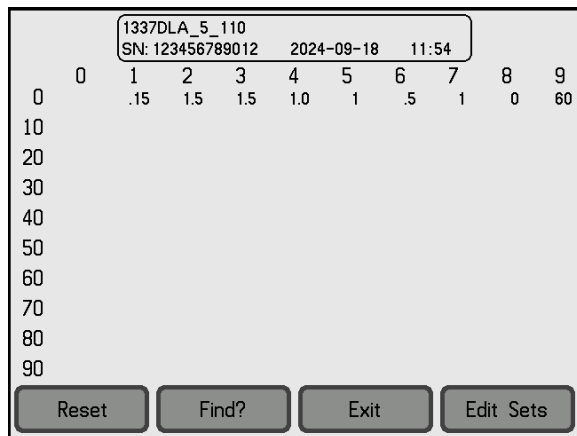
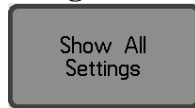
Head Mechanic or higher-level view



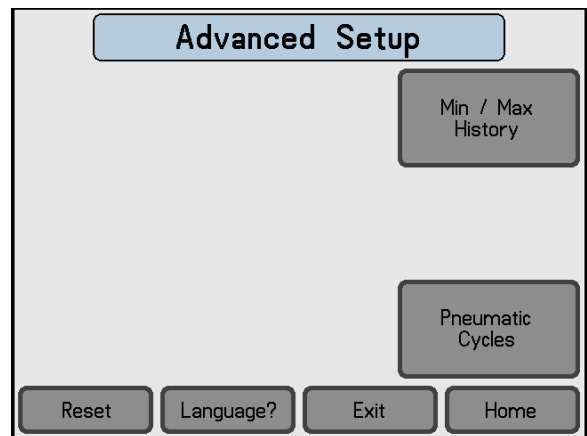
Technical Screens



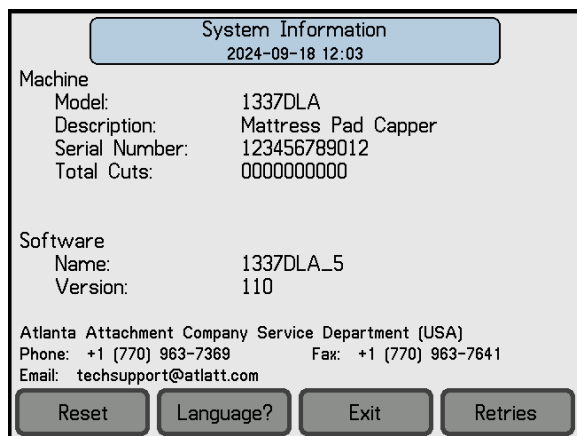
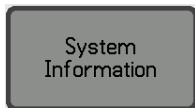
Show All Settings



Advanced Setup



System Information



Security (Levels of Access with Code)



OPERATOR

To raise your security clearance, enter the 5 digit security code and press ENTER.

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

Reset Language? Exit Home

SUPERVISOR

To raise your security clearance, enter the 5 digit security code and press ENTER.

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

Lower Security Clearance

Edit Supervisor Security Code

Reset Language? Exit Home

MECHANIC

To raise your security clearance, enter the 5 digit security code and press ENTER.

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

Lower Security Clearance

Edit Mechanic Security Code

Reset Language? Exit Home

HEAD MECHANIC

To raise your security clearance, enter the 5 digit security code and press ENTER.

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

Lower Security Clearance

Edit Head Mechanic Security Code

Reset Language? Exit Home

TECHNICIAN

To raise your security clearance, enter the 5 digit security code and press ENTER.

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

Lower Security Clearance

Security Code

Enabled

Reset Language? Exit Home

Engineer

To lower your security clearance, enter the 5 digit security code and press ENTER.

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

Lower Security Clearance

Security Code

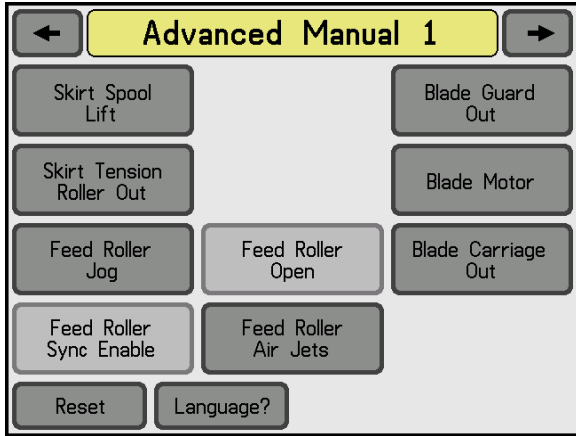
Bypassed

Reset Language? Exit Home

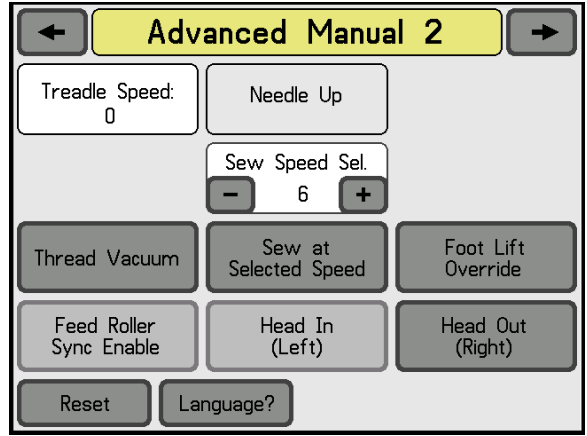
Advance Manual



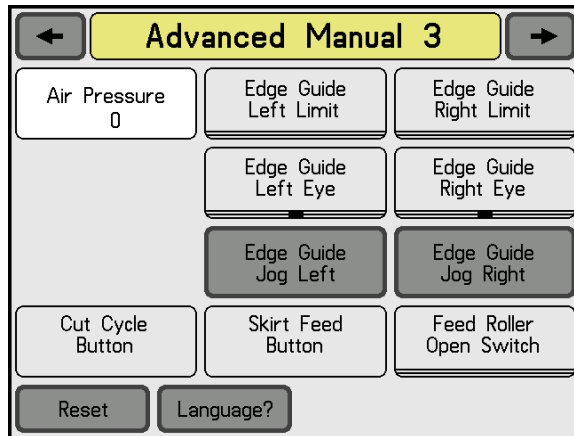
Page 1



Page 2



Page 3



Advanced Settings



ADVANCED SETTINGS 1

| | | |
|---|----------------------------------|---------------------------------------|
| 1. Feed Before Cut Time - .15 + | 2. Blade Spin Up Time - 1.5 + | 3. Cut Time - 1.5 + |
| 4. Insert Feed Time - 1.0 + | 5. Edge Guide Enable - 1 + | 6. New Roll Edge Guide Time - .5 + |
| 7. Sew Head Running Check Enable - 1 + | 8. Foot Lift Option - 0 + | 9. Air Pressure Target - 60 + |
| Reset | Find? | Exit |
| Home | | |

1. Feed Before Cut Time

- .15 +

←
→

1. Feed to Cut Time

Less - .15 + More

Time that material is fed before the Blade Guard is extended (during a Cut Cycle). This brief feed keeps the Blade Guard from pulling the material too tight.

Units are seconds.

Min, Typical, Max values: .05, .15, 1.00

Reset
Language?
Exit
Home

2. Blade Spin Up Time

- 1.5 +

←
→

2. Blade Spin Up Time

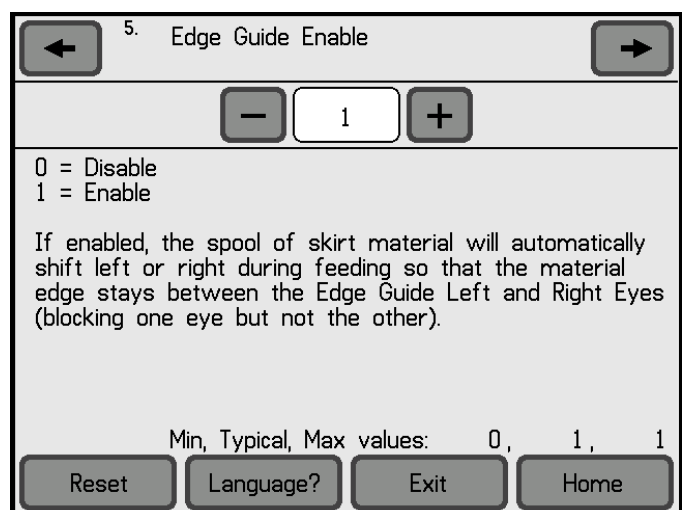
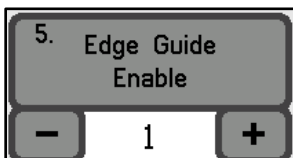
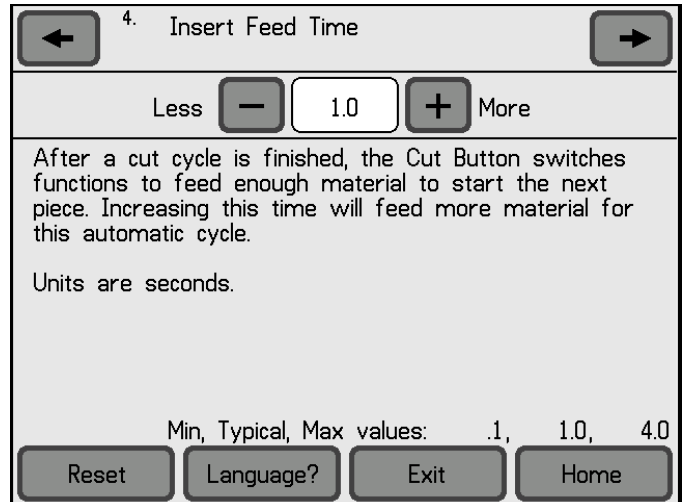
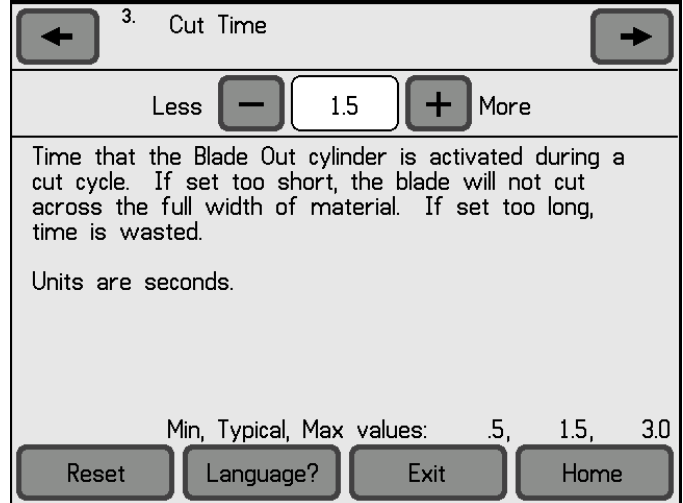
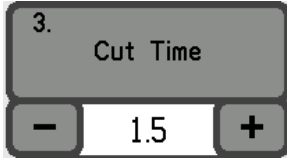
Less - 1.5 + More

Time from the Blade Motor starting (during a cut cycle) until the Blade Move cylinder is extended. This time allows the blade to come up to speed before making contact with the material. If set too low, the blade may not cut well. If set too high, time is wasted.

Units are seconds.

Min, Typical, Max values: .5, 1.5, 3.0

Reset
Language?
Exit
Home



6. New Roll Edge Guide Time

- .5 +

6. New Roll Edge Guide Time

Less - .5 + More

Time that the spool is sent In (Right) at the end of a Load Roll cycle. This can be adjusted to minimize Edge Guide movement at the start of a new roll.

Units are seconds.

Min, Typical, Max values: .1, .5, 2.0

Reset Language? Exit Home

7. Sew Head Running Check Enable

- 1 +

7. Sew Head Running Check Enable

- 1 +

0 = Disable
1 = Enable

If enabled, when the sew head is running, the Needle Up feedback from the sew motor controller will be monitored. If that signal does not change for more than 2 seconds, an error message will alert the user.

Min, Typical, Max values: 0, 1, 1

Reset Language? Exit Home

8. Foot Lift Option

- 0 +

8. Foot Lift Option

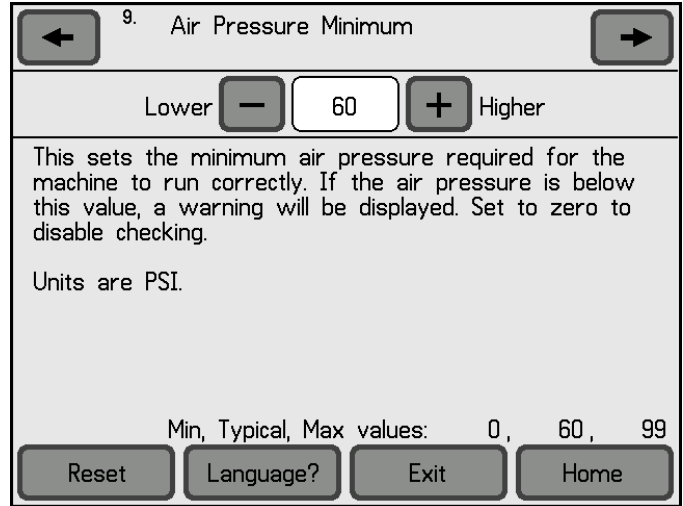
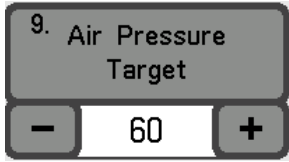
No Foot Lift - 0 + Foot Lift

This setting lets the software know if the optional foot lift (1337DLA-KIT1) has been installed.

0 = No foot lift installed
1 = Foot lift installed (1337DLA-KIT1)

Min, Typical, Max values: 0, 0, 1

Reset Language? Exit Home





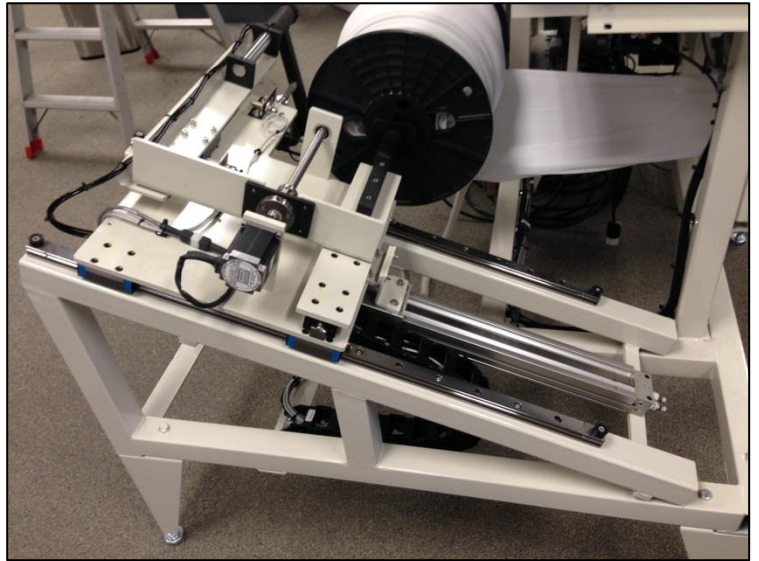
- STEPPING MOTOR CONTROLLER (SMALL) – Controls side to side motion of the Skirt Position Alignment Mechanism.
 - Digit Switch (3 position) - These switch have no effect in this model.
 - Jog Button - DO NOT USE - Drives the Skirt Alignment mechanism to the right in either Auto or Manual Modes. This will drive to the physical stops.
 - Rotary Potentiometer - Adjusts the speed of the drive function
 - Power Light – indicate power is applied to the system.



- STEPPING MOTOR CONTROLLER (LARGE) – Controls Skirt Roll Feeder Mechanism
 - Digit Switch (3 position) – This switch sets of a ratio between the Sewing Head stitch length and the number of motor steps that drive the feeder rollers. If the number is too low too much stretch can cause problems. Too high a number removes any stretch at all. The setting is very much trial, and error based on your material. We’ve found 215 to be a good starting point.
 - Power Light – indicate power is applied to the system.
 - Jog Button – Drives the Feed Rollers to provide additional Skirt Material in either Auto or Manual Modes

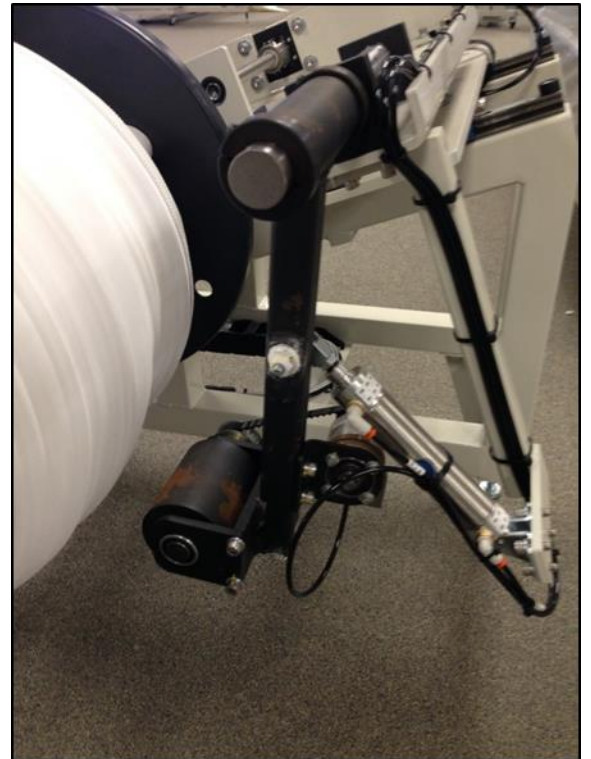
Skirt Loading Slide

– Inclined sliding mechanism to facilitate the loading and unloading of Skirt Material in a more ergonomic position



Back Pressure Assembly

– Located on the Skirt Loading Slide this controls the amount of brake force or “drag” on the Skirt Roll and as a result amount of stretch of the Skirt Material during processing.



- **Skirt Feeder Mechanism**

- Consists of two wide pinch roller connected to a stepping motor that feeds Skirt Material based on the speed of the machine. The speed of the material feed is adjustable to with respect to the Sewing Head speed to help maintain a constant stretch of the Skirt Material.

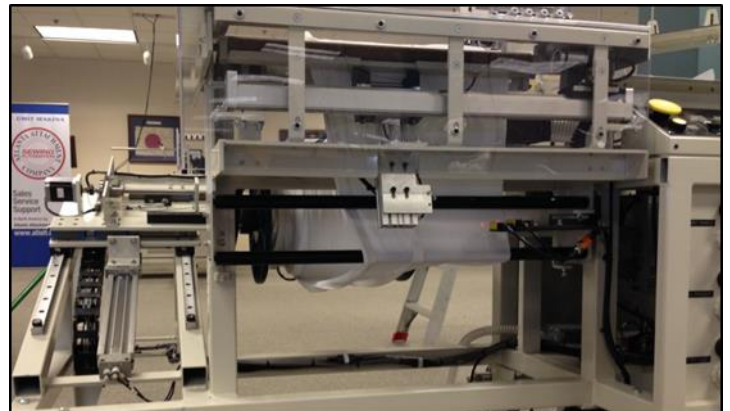
- **Skirt Cut Mechanism**

– Includes an air operated rotary knife and Finger Guard Mechanism to cut the Skirt Material at the end of each completed pad.



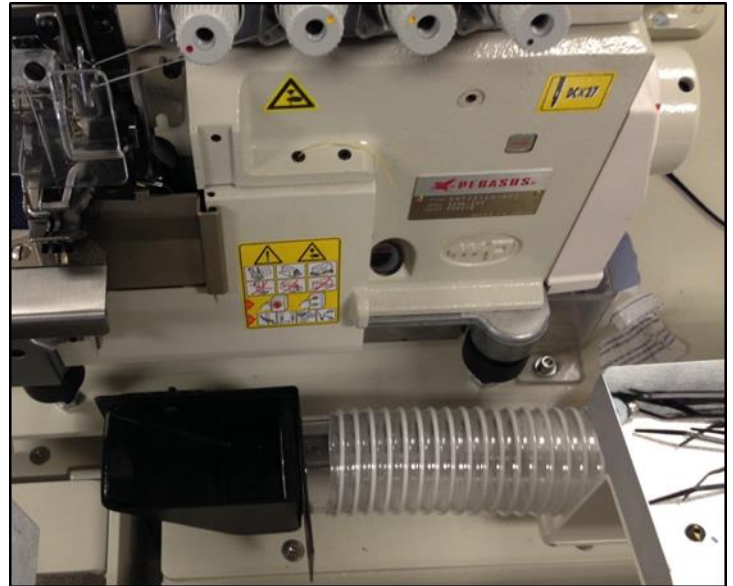
- **Skirt Position Alignment Mechanism**

– Keeps the right edge (working edge) of the Skirt Material between a pair of reflective sensors controlling a stepping motor driven lead screw. In Auto mode the roll is moved toward the right until the first (left) sensor is blocked or travel limit is reached. If the second (right) sensor becomes blocked the roll moves toward the left until the sensor is cleared. This coordinated motion keeps the material in optimum position for production with minimal waste. In Manual Mode the system is not active



Scrap Removal System

– The design of the Sewing Head incorporates a cutter to trim the edge of the pad and the skirt material during processing. There is a system to help direct this trim or scrap away from the work area. This system must be connected to some sort of vacuum system to clear scrap from the machine.

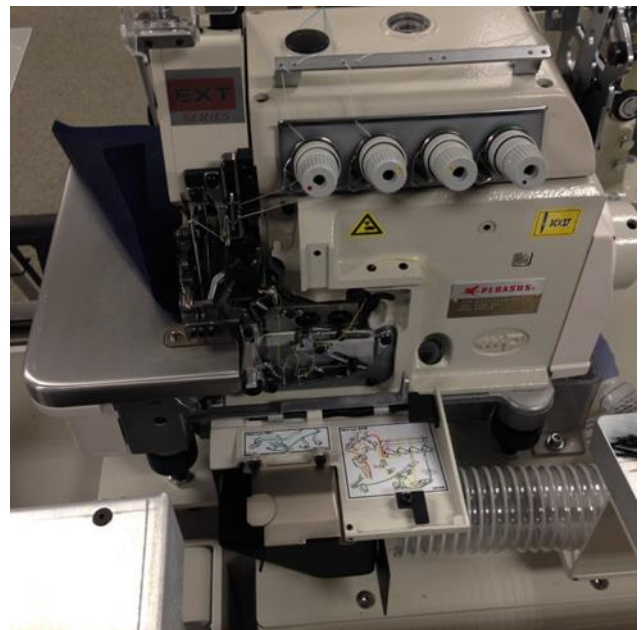
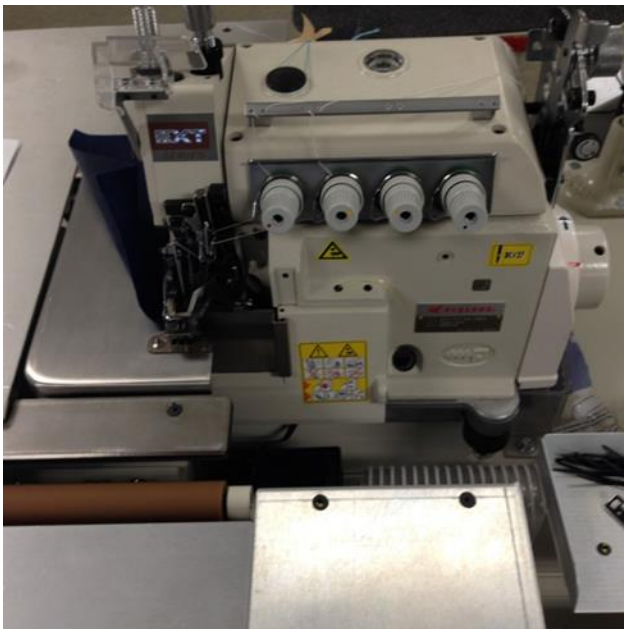


- **Sewing Head Side Shift**

– Physically moves the Sewing Head to the left for normal operation or to the right to facilitate threading and cleaning.

WARNING #1: To avoid damage to work in process (WIP) or Sewing Head, remove any Pad and Skirt Material prior to shifting the Sewing Head to the cleaning position.

WARNING #1: To avoid damage to Sewing Head ensure the access cover is closed prior to shifting the head back to the working position



- **Sewing Head**

– Please refer to the PEGASUS Sewing Head Manuals for a detailed description of Threading, Setup, Maintenance and Operation of the Sewing Head.

- **Efka Motor Control**

- Check that the On/Off switch on the Efka motor controller is Orange, and that the Display shows the RPM. If not, press the On/Off switch in the down position to turn on.
 - A detailed description for programming the Efka Motor Control is covered in a later section.



Machine Set Up

It is assumed the machine is operating normally at this point, alignment and adjustments are covered in another section. All directions (front, back, right or, left) are assumed to be from the operator position (front) facing the unit.

- **LOADING NEW ROLL OF MATERIAL**
 - Remove Skirt Tension by turning the SKIRT TENSION Off.
 - Move the Skirt Roll up to the top of the load incline with SKIRT ROLL Up.
 - Remove old roll and install new roll on the shaft from behind the machine.
 - Assuming the skirt roll sizes are the same, remove the Shaft Collar near the end of the shaft and replace the roll. Note the elastic side goes on first (to the left). Push the roll all the way to the left shaft collar and reinstall the right-hand Shaft Collar.
 - If the two material rolls are of a different length additional steps are involved. Those are covered in the **ALIGNMENT /ADJUSTMENT** section later.
 - Lower the Skirt Roll to the bottom of the incline using SKIRT ROLL - Down.
 - Turn SKIRT TENSION back on. This brings the Backpressure roller in contact with the roll and activates the brake.
 - At Operator Panel switch Feeder rollers OPEN.
 - Next From the front of the unit, reach under the front cover and pull the loose end skirt material forward. Pass it in front of the first roller and behind the second.
 - Pass Skirt Material through open roller and pull end onto work area.

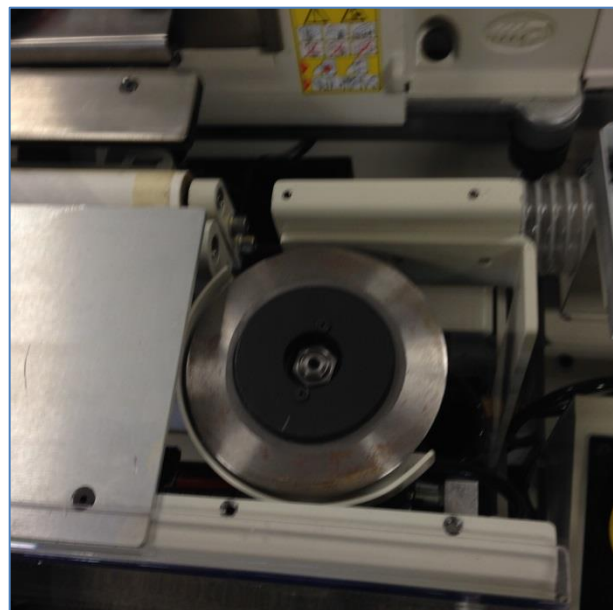
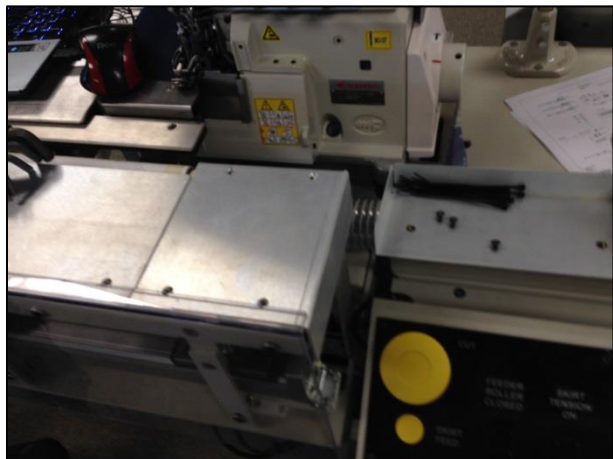
- Close Feeder Rollers at Operator Panel
- Using Skirt Feed Button feeder some material into the work area to ensure proper feeding without binding.
- **THREADING SEWING HEAD** - Threading, Setup, Maintenance and Operation of the PEGASUS Sewing Head is beyond the scope of this Publication. Please refer to the PEGASUS Sewing Head Manuals for a detailed instruction

Basic Operation

Alignment/Adjustment

- **SHARPENING CUTTER WHEEL -**
- **DO NOT OPERATE THE MACHINE WITH THE SAFETY COVERS REMOVED**

- Close Feeder Rollers at Operator Panel. Cutter Blade Sharpening – WARNING - The cutter is already sharp. Care must be taken when the Safety cover is removed.
- Remove 4 screws keeping safety cover in place. Remove Cover exposing the Cutter Blade.
- In manual mode switch Main Controller digit switch #6 to “1”. The Cutter Motor will spin up to speed.
- Using a Sharpening Stonework on cutter edges to improve keenness of edge.
- When satisfied with results. Return Main Controller digit switch #6 to “0”. The motor will spin down and come to a stop.
- Replace Cover and 4 screws. CAUTION: The rotating cutter blade is very dangerous.



- **MATERIAL POSITIONING SENSORS ADJUSTMENT**

This adjustment is product dependent. The Skirt material coming off the supply roll travels under the machine, in front of the first rolling bar, and behind the second one before passing through the feeder pinch rollers and the onto the work surface for processing. Between these two rollers is a pair of reflective photo sensors which adjust the right-hand side of the material relative to the needle and cutter on the Sewing Head.



- Align the left-hand sensor such that it is approximately one inch to the right of needle on the Sewing Head. This always keeps the right-hand edge of the material positioned to be trimmed by the Sewing Head cutter during production.
- Move this sensor more to the right to narrow the width of the skirt relative to the elastic edges.
- The right sensor limits the spool maximum travel for material.
- During operation in Automatic Mode the edge of the Skirt Material should remain between the two sensor beams.



Electrical



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

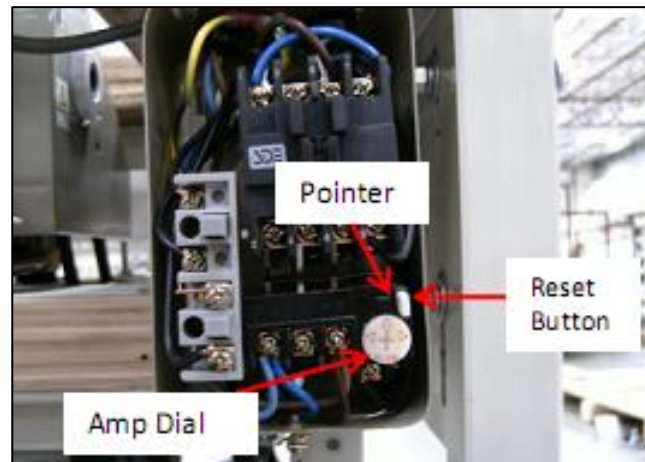
MAIN POWER SWITCH

The main power On/Off switch is located under the table and to the right. It is used to turn the power on to the whole machine. This machine requires 220V Single Phase, 5 Amp service. If you have problems with the power not coming on when the On button is pressed you may check this switch by doing the following.



Make sure that the machine is unplugged before proceeding and that all lock out/tag out procedures have been correctly followed. Loosen the cover screw found at the bottom of the switch. You do not have to remove the screw. Remove the front cover.

Check that the 5.5 reading on the Amp Dial is in line with the pointer. Press the reset button, if it “pops” back in then the contact had gotten overloaded at some point. Replace the cover, plug the machine in, and try turning the machine back on. If the contact still trips the overload, then there is a problem either with the wiring or the contactor. Use the wiring diagram for your machine in the parts manual to check the voltages. Try replacing the contactor.



Efka Motor Control-

Parameters

Parameter Programming Sheet 11337DLA

| PARAMETER | RANGE | LOCKSTITCH | CHAINSTITCH | GENERIC PARAMETER DESCRIPTION |
|---------------|--------------|------------|-------------|--|
| Do this first | ---- | | ---- | Perform a master reset before programming, see below |
| 290 | | 0 | 5 | Mode of operation. SET THIS PARAMETER FIRST! |
| 26 | 0-5 | 0 | 0 | Treadle Control -0= Digital 1= Analog |
| 111 | 200-9900 rpm | See Manual | 5000 | Recommended speed when "129" is 0, 1, or 2. (Default should be 0) |
| 119 | 1-3 | 1 | | Linear acceleration |
| 153 | 0-50 | 35 | 35 | Braking power at machine stand still - (Walking foot only) |
| 161 | 0-1 | 0* | 1 | Motor rotation, 0=CW, 1=CCW |
| 270 | 0-5 | * | 0 | External handwheel sensor configuration. (Position 2) |
| 271 | 0-255 | 180 | 180 | Refanale for Position 1 (Trim) from Position 2 |
| 272 | 0150-2550 | 1000 | 1000 | Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111. (For Yamato and Pegasus, setting should be 100; for Rimoldi, setting should be 124) |
| 362 | 0-1 | 1 | 1 | Position sensor voltage: 0 = 5V, 1 = 15V |
| 438 | | 0 | 0 | Use code "5913". This disables an input that was causing box to reset itself. |
| 401 | 0-1 | | | Change from 0 to 1 to save parameters |

See printable page at end of this manual

Front Panel LED's

LED 1 Off

LED 2 Off

LED 3 Off

LED 4 Off

LED 5 Off

LED 6 ON – (one must be on)

LED 7 Off

LED 8 Off,

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "5912"
3. Press "E" once and "2.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E".
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
- 8. Run sewing head to save parameters before powering down**

To Perform Master Reset of Parameters:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "5913"
3. Press "E" and "093" is displayed.
4. Press "+" once, "094" is displayed.
5. Wait for display to reset.
6. Press "P" to exit programming mode with all default values.

****To Save Parameters**

1. Before exiting programming mode:
2. Go to Par 401, press enter
3. Change setting from 0 to 1, press enter.
4. Wait for display to reset.
5. Press "P" to exit programming mode with all values saved.

Programming

1) Press and hold the “P” button while turning on the Efka Main Power Switch

2) Once “Code” appears in the display release the “P” button and press the “>>” button. 0000 will appear on the display with the left 0 blinking. The code to enter in is “5913”. This permits the user to change all drive code and should only be used by qualified personnel.



3) Press the “+” five times to get a “5” in the display, if you go past “5” then either continue pressing the “+” button until it cycles back to “5” or press the “-” button to go back.

4) Press the “>>” button once to move to the second “0”. Repeat this process until a “9” appears in the second position. Push “>>” to move to the third and finally fourth digit until “5913” appear in the display.

5) Display should look like picture to the left with the right “3” flashing. (It does not matter which number in the display is blinking as long as it reads “5913”) Press the “E” button to ENTER the code.

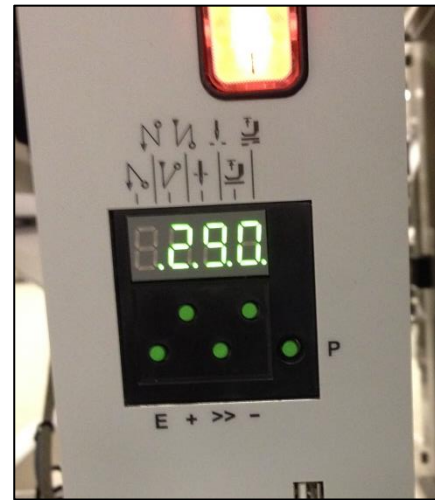


7) The display will change to “0.4.0.0.” this is a parameter number “400”. Number with the “.” between the digits are parameters.

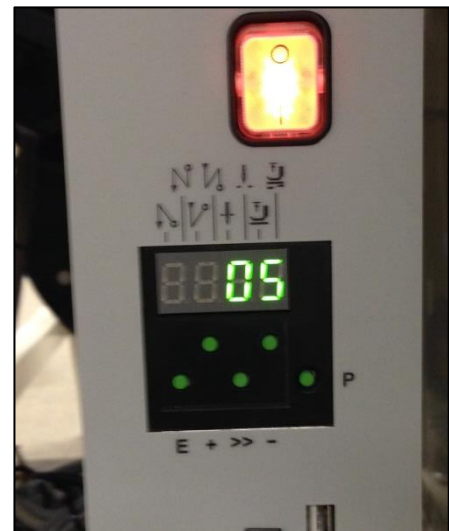
To move to the correct parameter you will press either the “+” or “-” buttons. Press and hold the “+” button, the parameter numbers will start scrolling faster the longer the button is held down, until “2.9.0.” is displayed. This is the first parameter to be programmed when starting new, only using as an example. (You may need to access a different parameter number, use the same method as above)



8) With “2.9.0.”(or parameter number you chose) in the display, which is parameter “290”, press the “E” button once to ENTER the Parameter Number .



9) The display will change from “2.9.0.” to “05” (your display may not be the same, depends on the type of sewing head being used, refer to your machines programming sheet in manual) this is the setting of parameter “2.9.0.” all displayed numbers without the “.”are values of parameters. To change this number use the “+” or “-” button. Then press the “E” button once.



10) The display will show “2.9.1.”, this is the next parameter after “290”. You will use the “+” or “-” buttons to advance to the next parameter on the list, and then follow the process in step 9. Continue this until all parameters have been set according to the programming sheet. After the last parameter has been set, if the number displayed DOES NOT have the “.” between them, press the “E” button then press the “P” button. If it DOES have the “.” between them then only press the “P” button.



11) Example: Advance the parameter number to “.1.1.1.”. This will set the maximum RPM of the machine. Press “E” once and set the value to “5000”.

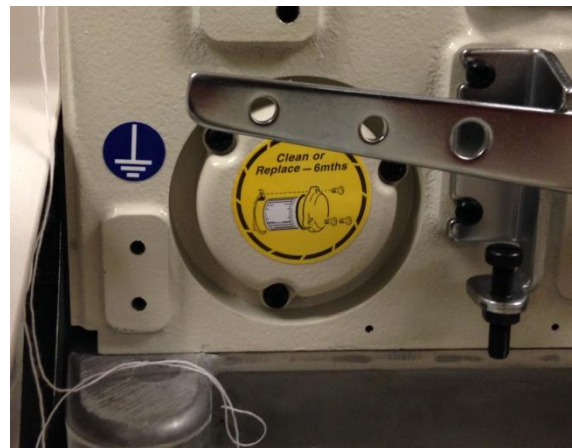
Proceed through the list of parameters provided.

Finally – Advance the parameter number to “.4.0.1.” and press “E”. Change the value from “0” to “1” to save all parameters



Maintenance

- Four Hours (2 per shift)
 - Add oil to the upper looper holder and the needle bar.
- Daily Check
 - Open all covers on the sewing head and blow out with compressed air.
 - Check oil level in machine each morning, prior to start of production. Use only manufacturer recommended sewing machine oil.
 - Clean positioning photocells with a soft nonabrasive cloth.
- Weekly Check
 - Make a general inspection of the machine as part of a preventative maintenance schedule. Check all bearing and roller to make sure everything is clean and running smoothly.
 - Check the oil level by looking into the sight glass. The oil level should be between the two red lines.
 - Sharpen cutter blade.
- Monthly Check
 - Clean air filter and remove any water in the separate filter.
 - Activate all air valves manually and check for leaks at cylinders, valves and hoses.
 - NOTE: At the end of the First month: Change oil in sewing head and clean pan including drainage filter. After first month follow manufacturer's recommendation for oil change
- 6-Month Check
 - Clean or replace Sewing Head oil Filter



Assembly Drawings & Parts Lists

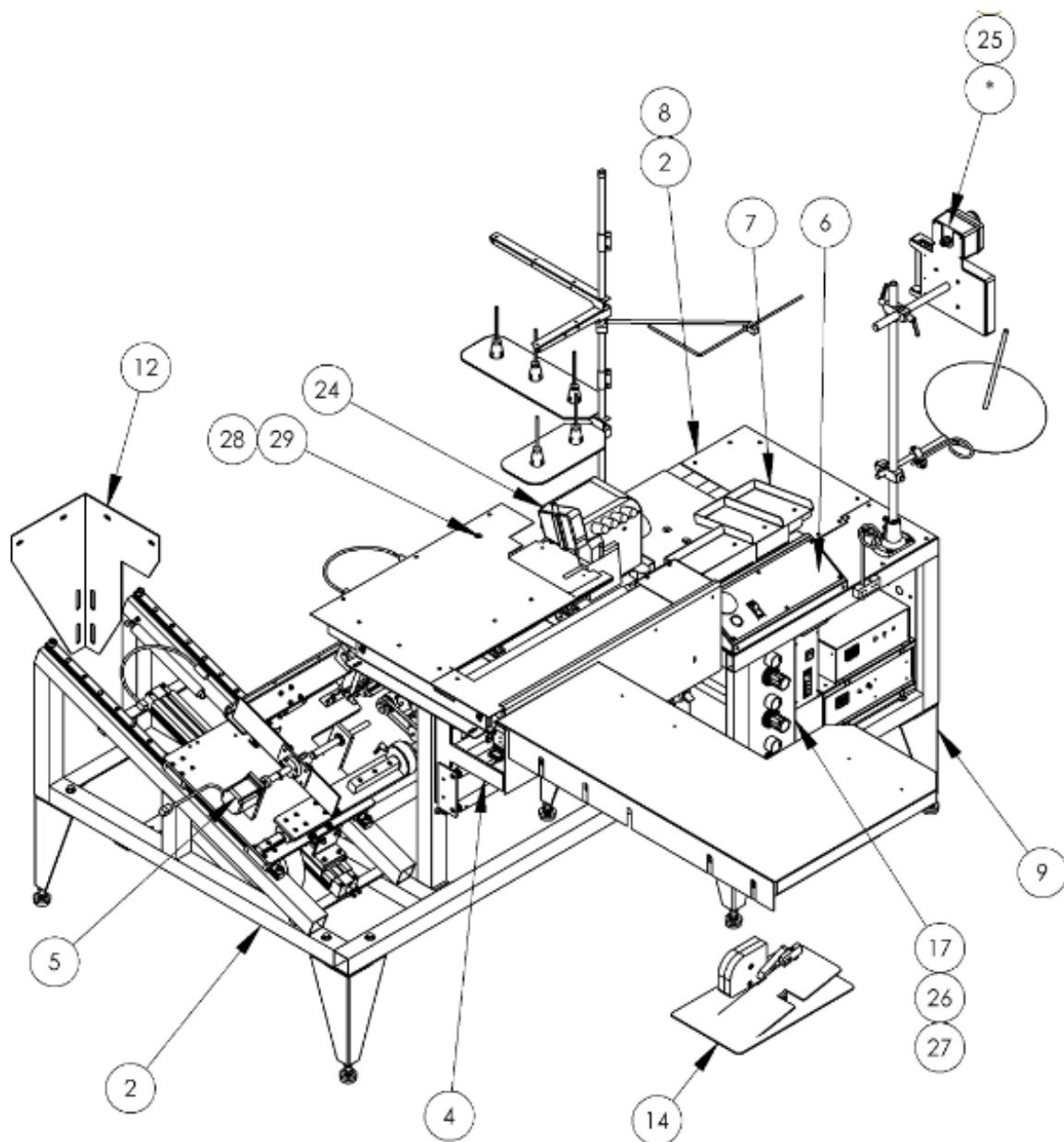
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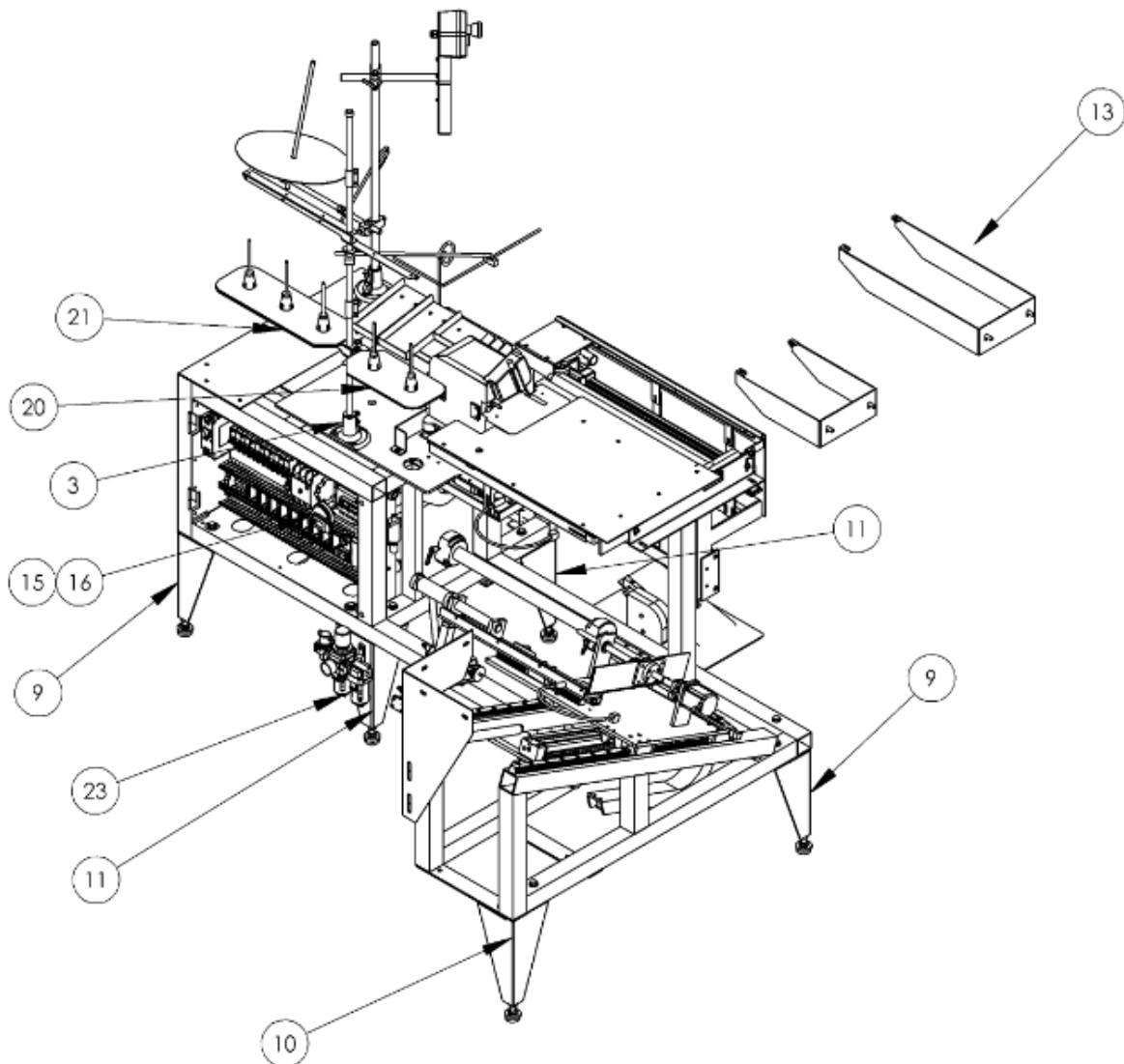
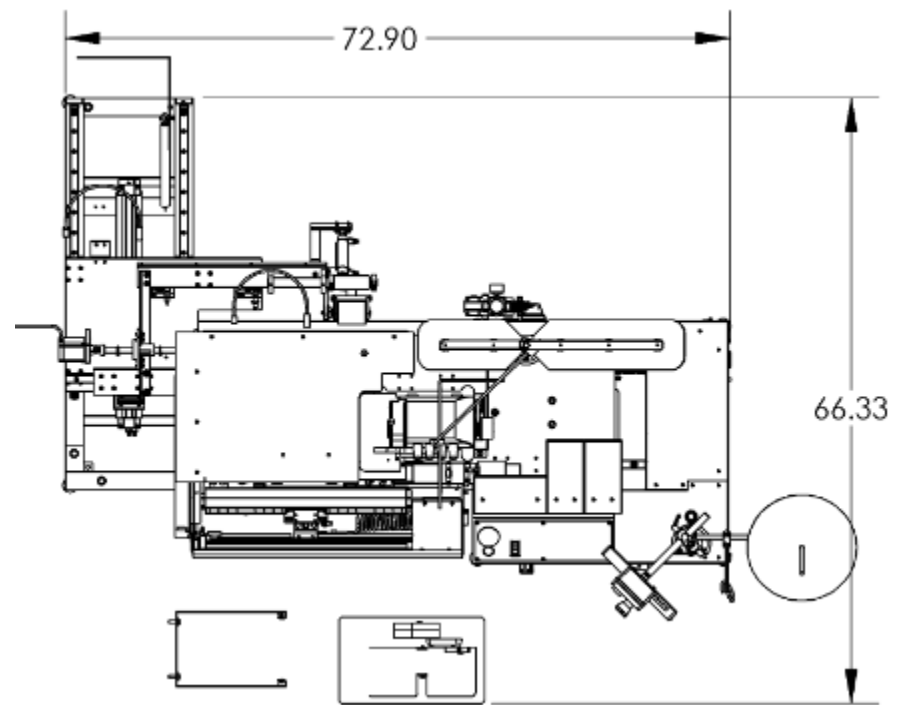


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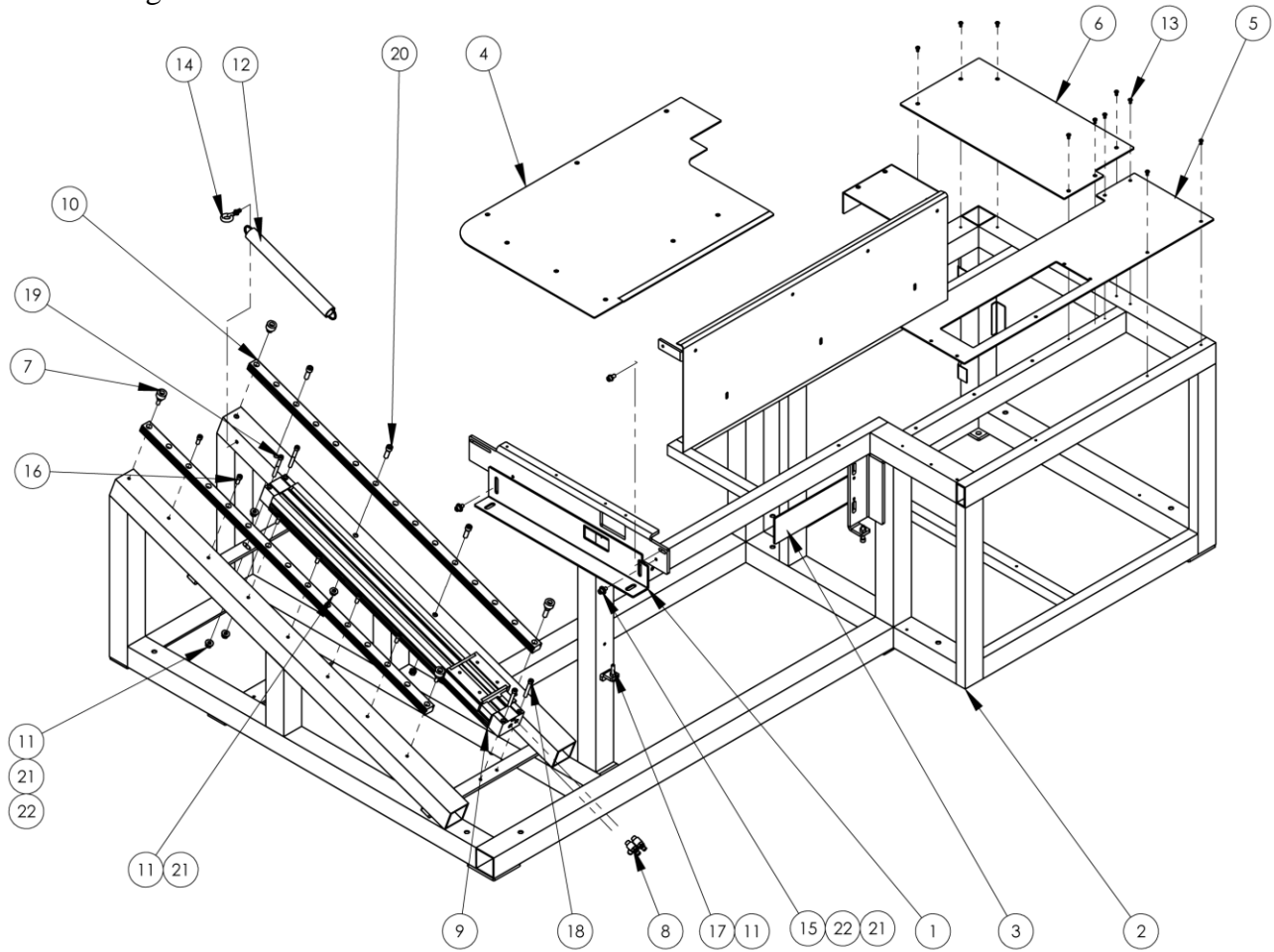


11337DLA parts list

| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|----------------|--|
| 1 | *AR | 1337-600PD | PNEUMATIC DIAGRAM |
| 2 | 1 | 1337588 | FRAME WITH COVERS |
| 3 | 1 | 1337672 | CARRIAGE, SEWING HEAD |
| 4 | 1 | 1337678 | MATERIAL FEEDER SYSTEM |
| 5 | 1 | 1337726 | CARRIER, SPOOL |
| 6 | 1 | 1337982 | CONTROL PANEL, SBUS |
| 7 | 1 | 1337800 | PARTS SHELF |
| 8 | 1 | 1337807 | DOOR SIDE COVER |
| 9 | 3 | 1337818 | LEG, ASSY PAD CORNER |
| 10 | 1 | 1337820 | LEG ASSY, REAR LEFT |
| 11 | 2 | 1337824 | LEG ASSY, CORNER W/O PAD |
| 12 | 1 | 1337831 | ANGLE, CORNER, W CUTOUT |
| 13 | 1 | 1337832 | AT FRONT SHELF 8 x 38.8 |
| 14 | 1 | 1337836 | FOOT PEDAL ASSY,EFKA |
| 15 | 1 | 1337968 | CONTROL BOX, GATEWAY, UL COMPLIANT |
| 16 | 1 | 1337972 | DOOR, CONTROL BOX |
| 17 | 1 | 1337973 | PANEL ELEC& PNEU |
| 18 | *AR | 1337DLA-WD | DIAGRAM, WIRING, SBUS |
| 19 | *AR | 1337DLPAR | EFKA PRAMETERS |
| 20 | 1 | 1959-112 | 2 POS THREAD PLATE ASSY |
| 21 | 1 | 1959-161 | 3 POS THREAD PLATE ASSY. |
| 22 | 1 | 97-1700A | TOUCH SCREEN ASSEMBLY |
| 23 | 1 | AA198-5110 | FILTER/REGULATOR/LOCKOUT |
| 24 | 1 | SPEGEXT3216HKH | SEWING HEAD,PEGASUS,HD |
| 25 | 3 | SSFC01056 | 1/4-20 X 7/8 FLAT CAP |
| 26 | 15 | SSSC98024 | 10-32 X 3/8 SOC CAP |
| 27 | 16 | WWF10 | WASHER, FLAT, #10, COM |
| 28 | 1 | AAQME-5-10 | AIR ELBOW, 10-32 X 5/32 |
| 29 | 1 | AAF01 | SOFFIE JET W/40MM EXT |
| 30 | 1 | MM9307K168 | GROMMET, BUNA-N, FOR 1" HOLE, 11/16 ID |
| 31 | 1 | MM5415K19 | CLAMP,HOSE,WORM TYPE 1-9/ |
| 32 | 1 | 1961-817 | VENTURI ASSY,2" |

1337588 FRAME WITH COVERS

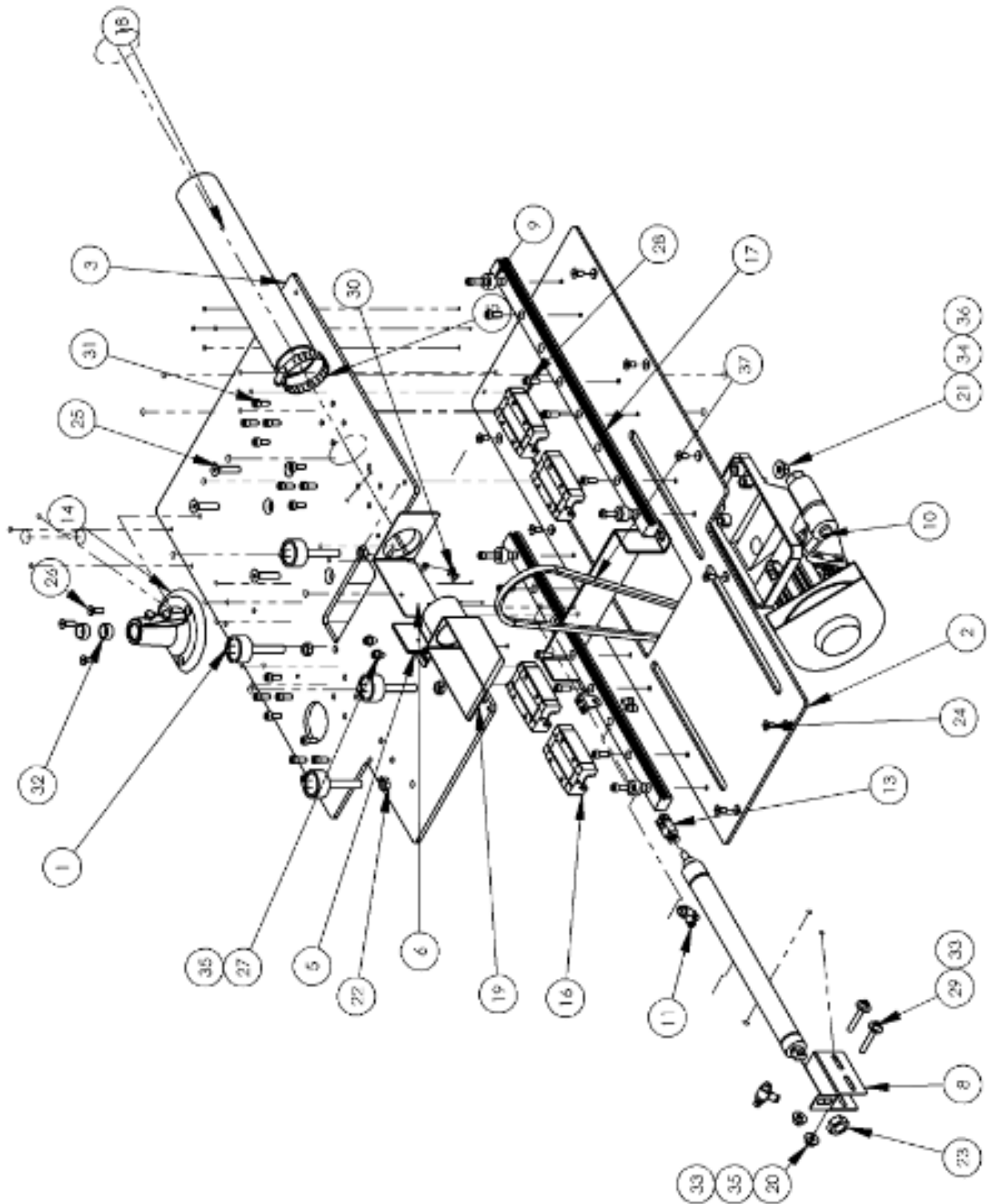
AAC Drawing Number 1337588 Rev 2



| NO | QTY | PART # | DESCRIPTION |
|----|-----|-------------|---------------------------|
| 1 | 1 | 1337024 | MOUNT, AIR TABLE |
| 2 | 1 | 1337589 | FRAME, MAIN FLANGER |
| 3 | 1 | 1337671 | PLATE, SENSOR REFLECTOR |
| 4 | 1 | 1337764 | TOP FRAME AND COVERS |
| 5 | 1 | 1337793 | COVER, FRONT CABINET |
| 6 | 1 | 1337794 | COVER REAR CABINET |
| 7 | 4 | 1493196 | STOP, LINEAR BEARING |
| 8 | 2 | AA198RA508 | FLOW CONTROL, 5/32 X 1/8" |
| 9 | 1 | AACMY25500 | CYLINDER, RDLSS, 25MM B |
| 10 | 2 | MMAGR25860N | RAIL, LINEAR, AG SERIES |
| 11 | 8 | NNH1/4-20 | NUT,HEX,1/4-20 |
| 12 | 1 | RRE9640K12 | SPRING,EXT,.080X.75X11.0 |
| 13 | 11 | SSBC90020 | 8-32X3/8 BUTTON CAP |
| 14 | 1 | SSBE01060 | EYEBOLT,1/4-20 X .88 |
| 15 | 3 | SSSC01032 | 1/4-20X1/2 SOC CAP |
| 16 | 8 | SSSC01040 | 1/4-20 X 5/8" SOC CAP SC |
| 17 | 2 | SSSC01080 | 1/4-20 X 1-1/4 SOC CAP |
| 18 | 2 | SSSC01112 | 1/4-20 X 1-3/4 SOC CAP |
| 19 | 2 | SSSC01144 | 1/4-20 X 2.5 SOC CAP |
| 20 | 4 | SSSC10064 | 5/16-18 X 1 SOCKET CAP |
| 21 | 8 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 22 | 11 | WWL1/4 | WASHER,LOCK, 1/4 |

1337672 SEWING HEAD CARRIAGE

AAC Drawing Number 1337672 Rev 3

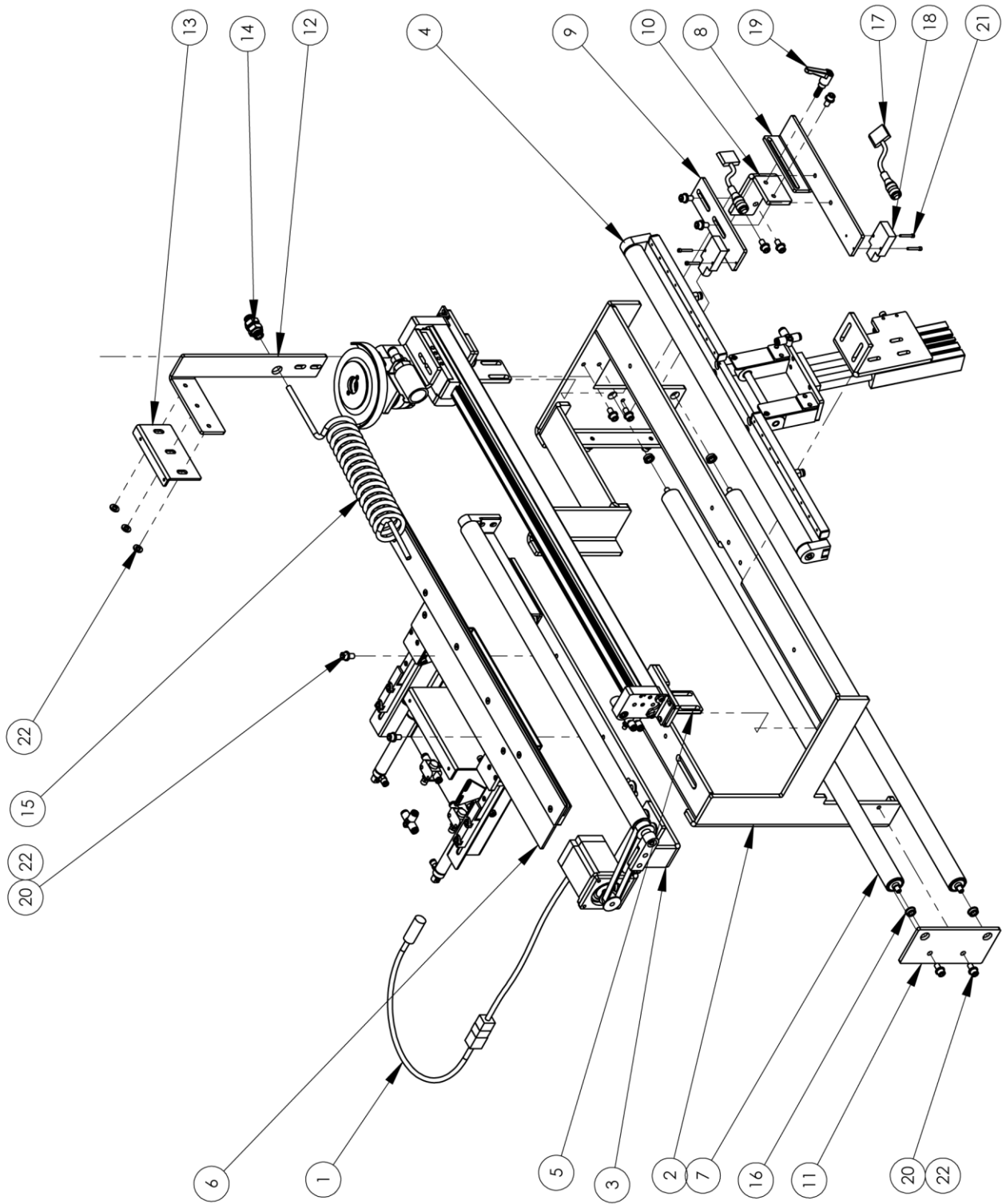


1337672 parts list

| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|---------------|---------------------------|
| 1 | 4 | 0411-128B | ISOLATOR MOUNT ASSEMBLY |
| 2 | 1 | 1337673 | PLATE, SEWING HEAD BASE |
| 3 | 1 | 1337674 | PLATE, SEWING HEAD FLOAT |
| 4 | 1 | 1337675 | MOUNT, SEWING HEAD PISTON |
| 5 | 1 | 1337676 | MOUNT, WASTE BIN LOWER |
| 6 | 1 | 1337677 | MOUNT, WASTE FUNNEL |
| 7 | 1 | 1337829 | COVER, BELTS, SEWING HEAD |
| 8 | 1 | 1337868 | MOUNT, CYLINDER |
| 9 | 4 | 1493196 | STOP, LINEAR BEARING |
| 10 | 1 | 4059-DC1500 | EFKA DC1500/AB220A |
| 11 | 2 | AA198RA508 | FLOW CONTROL, 5/32 X 1/8" |
| 12 | 1 | AAC6DP-10 | CYLINDER,AIR,DA |
| 13 | 1 | AAFD166-1 | ROD CLEVIS, 5/16- 24 T, |
| 14 | 1 | AP-1721 | STAND BASE,COMPLETE |
| 15 | 1 | MM5415K19 | CLAMP,HOSE,WORM TYPE 1-9/ |
| 16 | 4 | MMEGH25CA | LINEAR BEARING |
| 17 | 2 | MMEGR25R0480C | RAIL,LINEAR,AG SERIES |
| 18 | *6 | MMFH200 | |
| 19 | 1 | MMVLR-11T | FUNNEL, WASTE REMOVAL |
| 20 | 2 | NNH1/4-20 | NUT,HEX,1/4-20 |
| 21 | 3 | NNH5/16-18 | NUT,HEX, 5/16-18 |
| 22 | 4 | NNJ3/8-16 | 3/8-16 JAM NUT |
| 23 | 1 | NNJ5/8-18 | NUT-HEX JAM 5/8-18 |
| 24 | 8 | SSFC01032 | 1/4-20 X 1/2 FLAT ALN CAP |
| 25 | 3 | SSFC10096 | 5/16-18 X 1-1/2 FLAT CAP |
| 26 | 3 | SSFS01048 | 1/4-20 X 3/4 FHS |
| 27 | 4 | SSSC01024 | 1/4-20 X 3/8 SOC CAP SC |
| 28 | 12 | SSSC01040 | 1/4-20 X 5/8" SOC CAP SC |
| 29 | 2 | SSSC01112 | 1/4-20 X 1-3/4 SOC CAP |
| 30 | 3 | SSSC90016 | #8-32 X 1/4 SOC CAP SC |
| 31 | 16 | SSSCM6X16 | M6 X 16, SOC CAP |
| 32 | 2 | UUAA710-13 | BUSHING, BRONZE |
| 33 | 4 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 34 | 3 | WWF5/16 | WASHER,FLAT,5/16 |
| 35 | 4 | WWL1/4 | WASHER,LOCK, 1/4 |
| 36 | 3 | WWL5/16 | WASHER,LOCK, 5/16 |
| 37 | 1 | ZX3830 | V-BELT,3/8 X 30 |

1337678 MATERIAL FEEDER SYSTEM

AAC Drawing Number 1337678 Rev 0

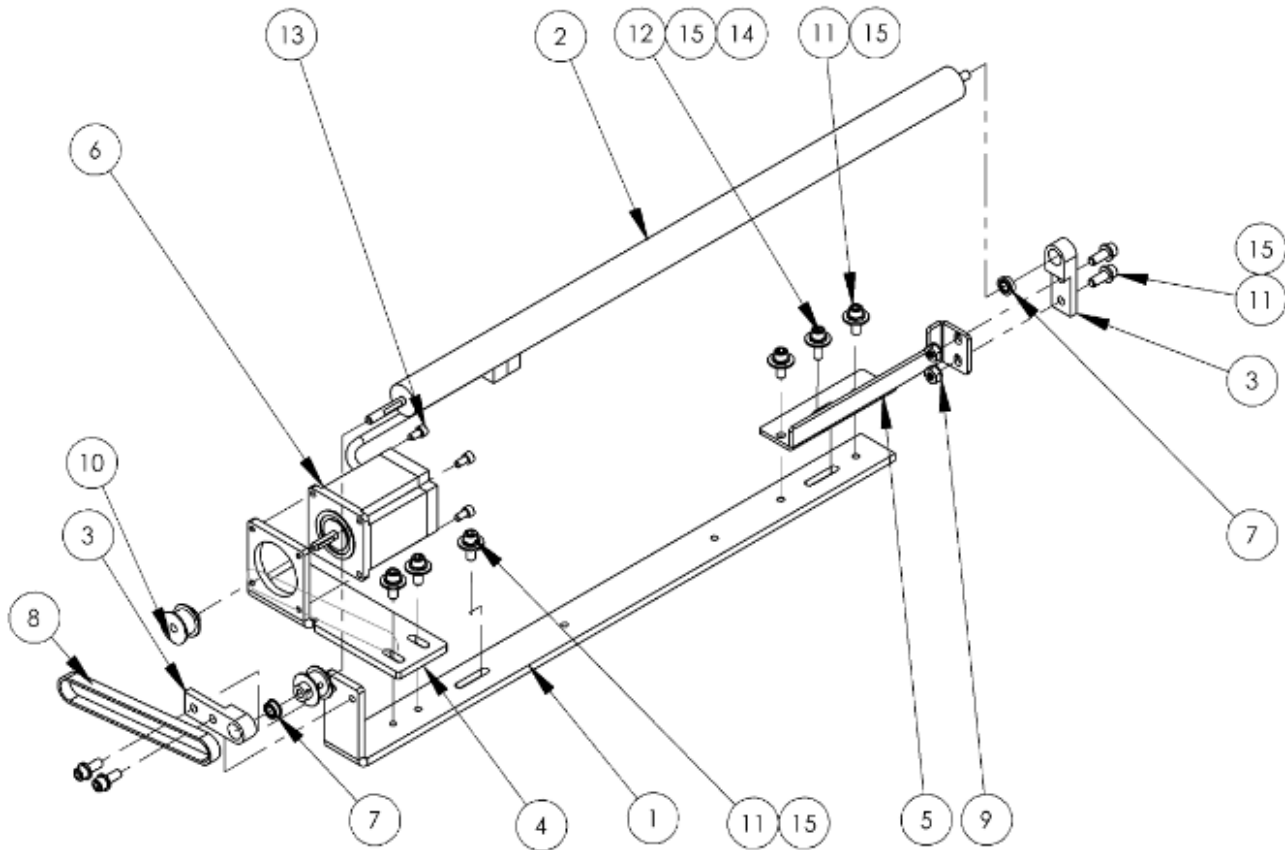


1337678 parts list

| NO | QTY | PART # | DESCRIPTION |
|----|-----|------------|---------------------------|
| 1 | 1 | 4080-4508B | CABLE,STEP MOTOR,4 AMP,7' |
| 2 | 1 | 1337679 | FRAME, MATERIAL FEEDER |
| 3 | 1 | 1337686 | FEED ROLLER DRIVE |
| 4 | 1 | 1337691 | PRESSURE ROLLER, FEED |
| 5 | 1 | 1337705 | CUTTER ASSY |
| 6 | 1 | 1337712 | SLOTTED FINGER GUARD |
| 7 | 2 | 1337752 | SHAFT, ROLLER |
| 8 | 1 | 1337755 | LOWER SENSOR MOUNT |
| 9 | 1 | 1337756 | UPPER SENSOR MOUNT |
| 10 | 1 | 1337757 | MOUNT, SENSOR TO FRAME |
| 11 | 1 | 1337758 | MOUNT, END ROLLER |
| 12 | 1 | 1337766 | SUPPORT BRACKET |
| 13 | 1 | 1337767 | SUPPORT BRACKET |
| 14 | 1 | AAQBU-4-4 | BULKHEAD UNION, 1/4X1/4 |
| 15 | 1 | AAVBG35A | HOSE, COIL, 1/4" X 10 FT |
| 16 | 4 | BBE2-13 | BEARING, BALL FLANG |
| 17 | 2 | FFRK44T4P4 | CABLE,W/ 4PM PLUG,4' |
| 18 | 2 | FFSM312LVQ | EYE,ELECTRIC,10-30VDC |
| 19 | 1 | MM64835K65 | HANDLE ADJUSTABLE |
| 20 | 19 | SSSC01032 | 1/4-20X1/2 SOC CAP |
| 21 | 4 | SSSC70048 | 4-40 X 3/4 SOCKET CAP |
| 22 | 22 | WWL1/4 | WASHER,LOCK, 1/4 |

1337686 FEED ROLLER DRIVE

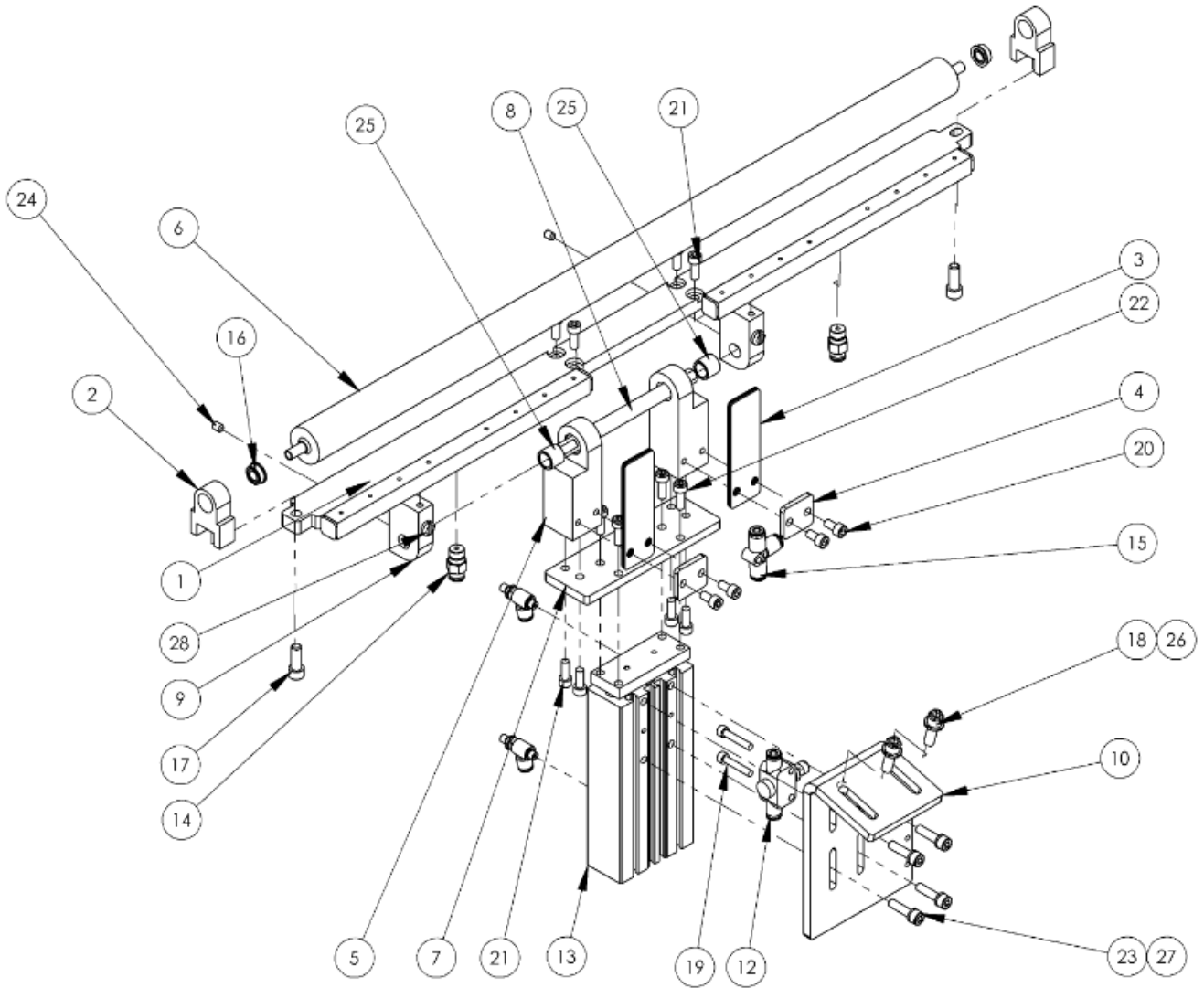
AAC Drawing Number 1337686 Rev 1



| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|-------------|---------------------------|
| 1 | 1 | 1337687 | FRAME, DRIVE ROLLER |
| 2 | 1 | 1337688 | ROLLER, DRIVE, FEEDER |
| 3 | 2 | 1337689 | BEARING MNT, DRIVE ROLLER |
| 4 | 1 | 1337690 | MOUNT, STEPPING MOTOR |
| 5 | 1 | 1337828 | ROLLER MOUNT, BACK RIGHT |
| 6 | 1 | AP-22E-103 | STEP MOTOR, 2 AMP |
| 7 | 2 | BBE2-13 | BEARING, BALL FLANG |
| 8 | 1 | GG130XL037 | BELT,GEAR,3/8P,3/8W |
| 9 | 2 | NNK1/4-20 | NUT,KEP,1/4-20 |
| 10 | 2 | PP12XL037 | PULLEY,GEAR,1/5P,12T |
| 11 | 9 | SSSC01040 | 1/4-20 X 5/8" SOC CAP SC |
| 12 | 1 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 13 | 4 | SSSC98024 | 10-32 X 3/8 SOC CAP |
| 14 | 6 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 15 | 10 | WWL1/4 | WASHER,LOCK, 1/4 |

1337691 PRESSURE ROLLER FEED

AAC Drawing Number 1337691 Rev 0

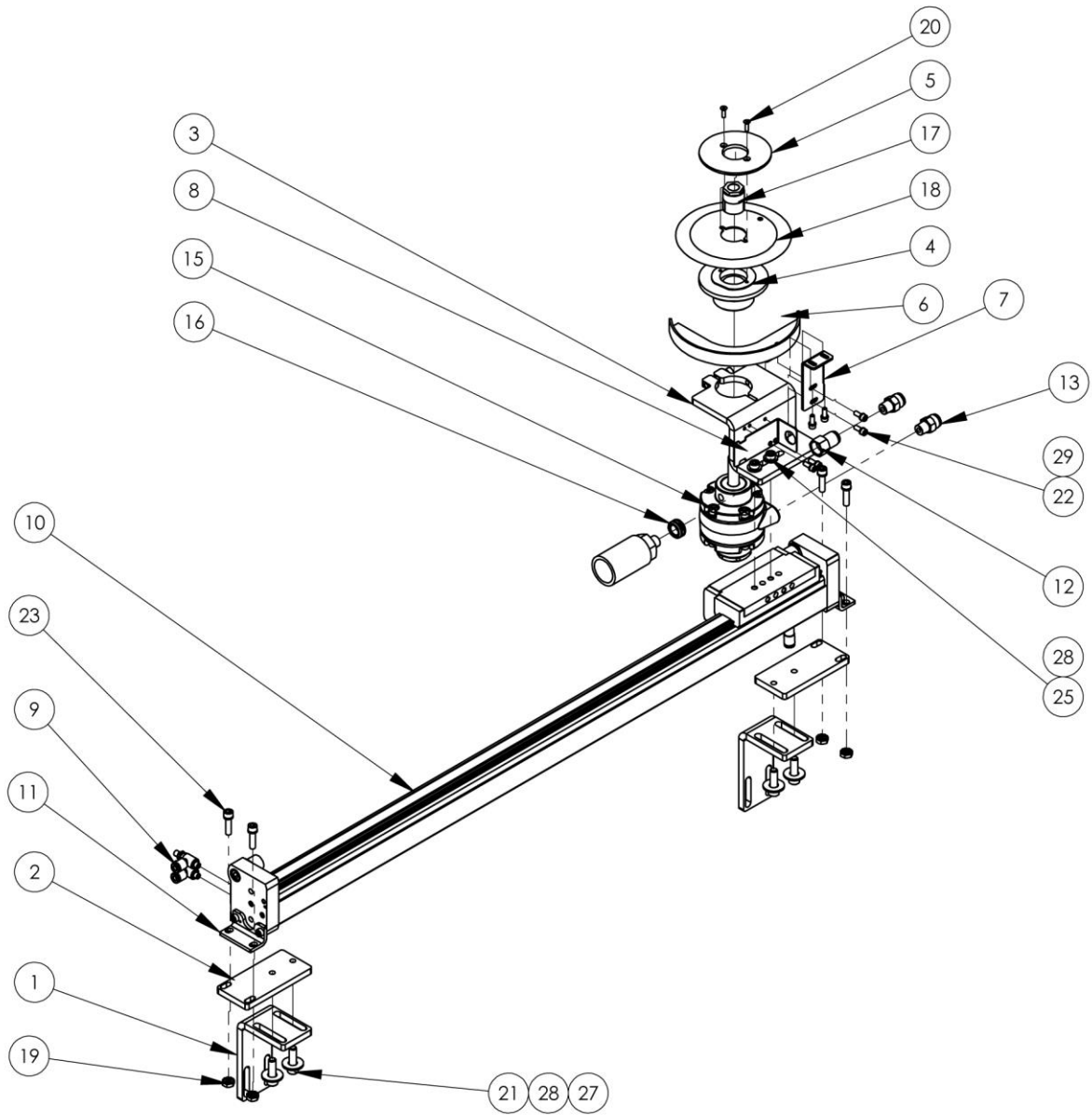


1337691 parts list

| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|----------------|---------------------------|
| 1 | 1 | 1337692 | WELDMENT, CROSSBAR W/JETS |
| 2 | 2 | 1337694 | BEARING MOUNT, DRIVE ROLL |
| 3 | 6 | 1337697 | SPRINGS FLAT |
| 4 | 2 | 1337698 | PLATE, SPRING BACKING |
| 5 | 2 | 1337699 | ROLLER PIVOT BOTTOM |
| 6 | 1 | 1337700 | ROLLER, PRESSURE |
| 7 | 1 | 1337701 | MOUNT CYLINDER / ROLLER |
| 8 | 1 | 1337702 | SHAFT, PIVOT |
| 9 | 2 | 1337703 | PIVOT, ROLLER, TOP |
| 10 | 1 | 1337704 | MOUNT, CYLINDER ROLLER |
| 11 | 2 | AA198RA5M5 | FLOW CONTROL 5/32T M5 |
| 12 | 1 | AA2000F-03 | FLOW CONTROL,IN-LINE,5/32 |
| 13 | 1 | AACMGPM1675 | CYLINDER,AIR,DUAL ROD |
| 14 | 2 | AAQMC-5-8 BODY | QU. MALE CONN 5/32X1/8 |
| 15 | 1 | AAQUT-5-5 | UNION TEE 5/32 |
| 16 | 2 | BBE2-13 | BEARING, BALL FLANG |
| 17 | 2 | SSSC01040 | 1/4-20 X 5/8" SOC CAP SC |
| 18 | 2 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 19 | 2 | SSSC90056 | #8-32 X 7/8 SOC CAP SC |
| 20 | 4 | SSSC98024 | 10-32 X 3/8 SOC CAP |
| 21 | 8 | SSSC98032 | 10-32X1/2, SOC CAP |
| 22 | 4 | SSSCM5X14 | SCREW,SOC CAP,M5-0.8 X 14 |
| 23 | 4 | SSSCM5X20 | M5-0.8X20,SCREW,SOCKET CA |

1337705 CUTTER ASSY

AAC Drawing Number 1337705 Rev 1

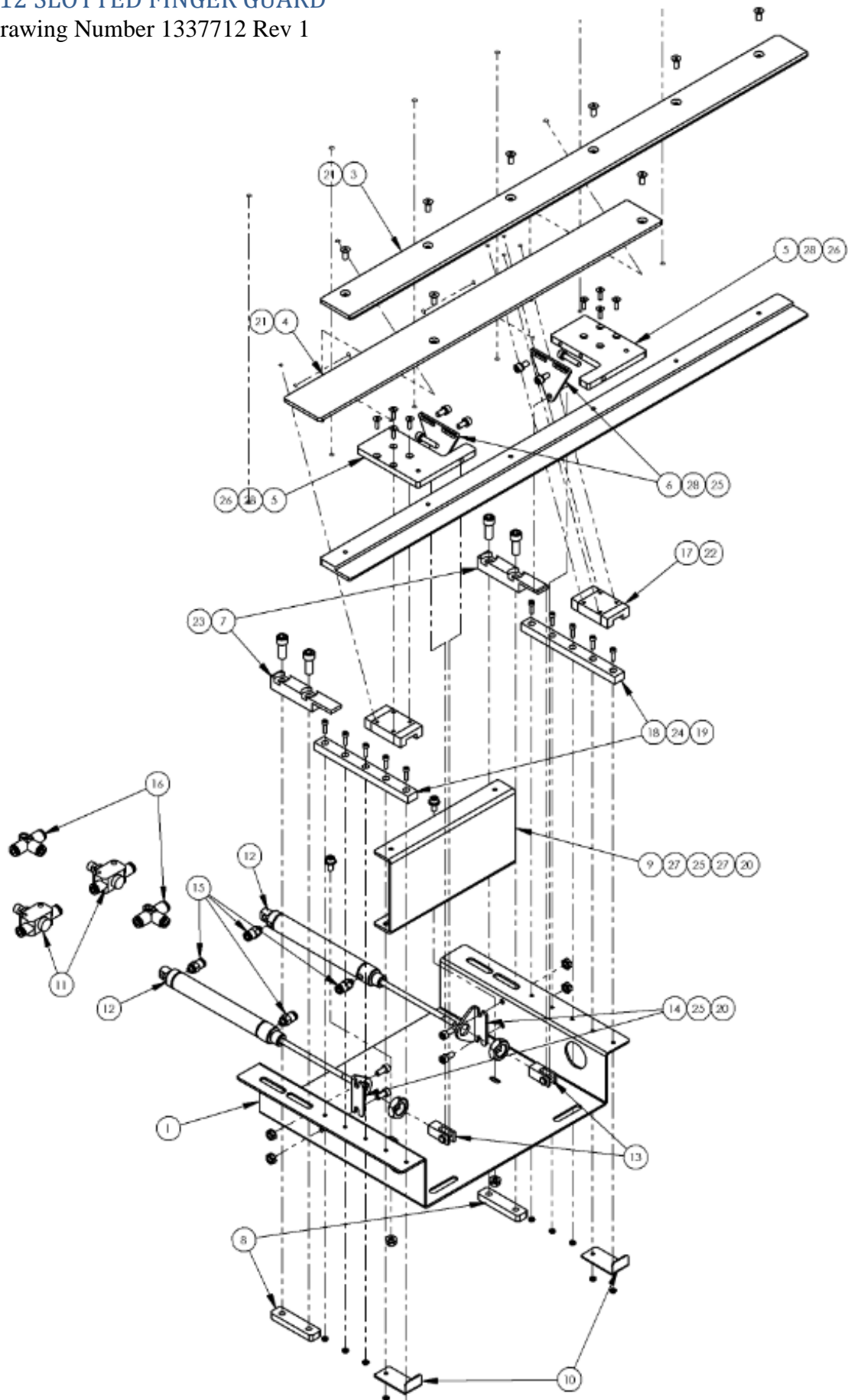


1337705 parts list

| NO | QTY | PART # | DESCRIPTION |
|----|-----|-------------|--------------------------|
| 1 | 2 | 1337706 | CYLINDER MOUNT VERTICAL |
| 2 | 2 | 1337707 | CYLINDER MOUNT HORIZ. |
| 3 | 1 | 1337708 | MOUNT, AIR MOTOR |
| 4 | 1 | 1337709 | CUTTER HUB |
| 5 | 1 | 1337710 | CUTTER TOP CAP |
| 6 | 1 | 1337711 | GUARD, CUTTER |
| 7 | 1 | 1337714 | MOUNT CUTTER GUARD |
| 8 | 1 | 1337827 | MUFFLER MOUNT |
| 9 | 2 | AA198RA5M5 | FLOW CONTROL 5/32T M5 |
| 10 | 1 | AACDGP18560 | CYLINDER, RDLS, 18MMx560 |
| 11 | 1 | AAF533667 | FOOT BRACKET HPC-18 CYL |
| 12 | 1 | AAQFC-4-8 | FITTING, 1/8NPT-F, 1/4 T |
| 13 | 2 | AAQMC-4-8 | QUICK MALE CONNECT |
| 14 | 1 | AAVAKH03 | VALVE,CHECK,5/32 QF |
| 15 | 1 | MM1AMNRV39A | MOTOR, AIR, .42HP |
| 16 | 1 | MM9600K33 | GROMMET,RUBBER,3/8ID |
| 17 | 1 | MM6410038 | TRAN TORQUE, BUSHING |
| 18 | 1 | MMR80C1-59 | CUTTER BLADE 4" DIA |
| 19 | 4 | NNK10-32 | KEP NUT, 10-32 |
| 20 | 2 | SSFC70024 | 4-40 X 3/8 FLAT SOC CAP |
| 21 | 4 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 22 | 6 | SSSC80024 | 6-32 X 3/8 SOC CAP SC |
| 23 | 4 | SSSC98048 | 10-32 X 3/4 SOC CAP |
| 24 | 1 | SSSC98064 | 10-32 X 1 SOC CAP |
| 25 | 2 | SSSCM5X12 | M5 X 12 SOC CAP SC |
| 26 | 1 | SSSS98032 | 10-32X 3/8 SOC SET SC |
| 27 | 4 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 28 | 6 | WWL1/4 | WASHER, LOCK, 1/4 |
| 29 | 6 | WWL6 | WASHER, LOCK, # 6 |
| 30 | 4 | WWL10 | WASHER, LOCK, # 10 |

1337712 SLOTTED FINGER GUARD

AAC Drawing Number 1337712 Rev 1

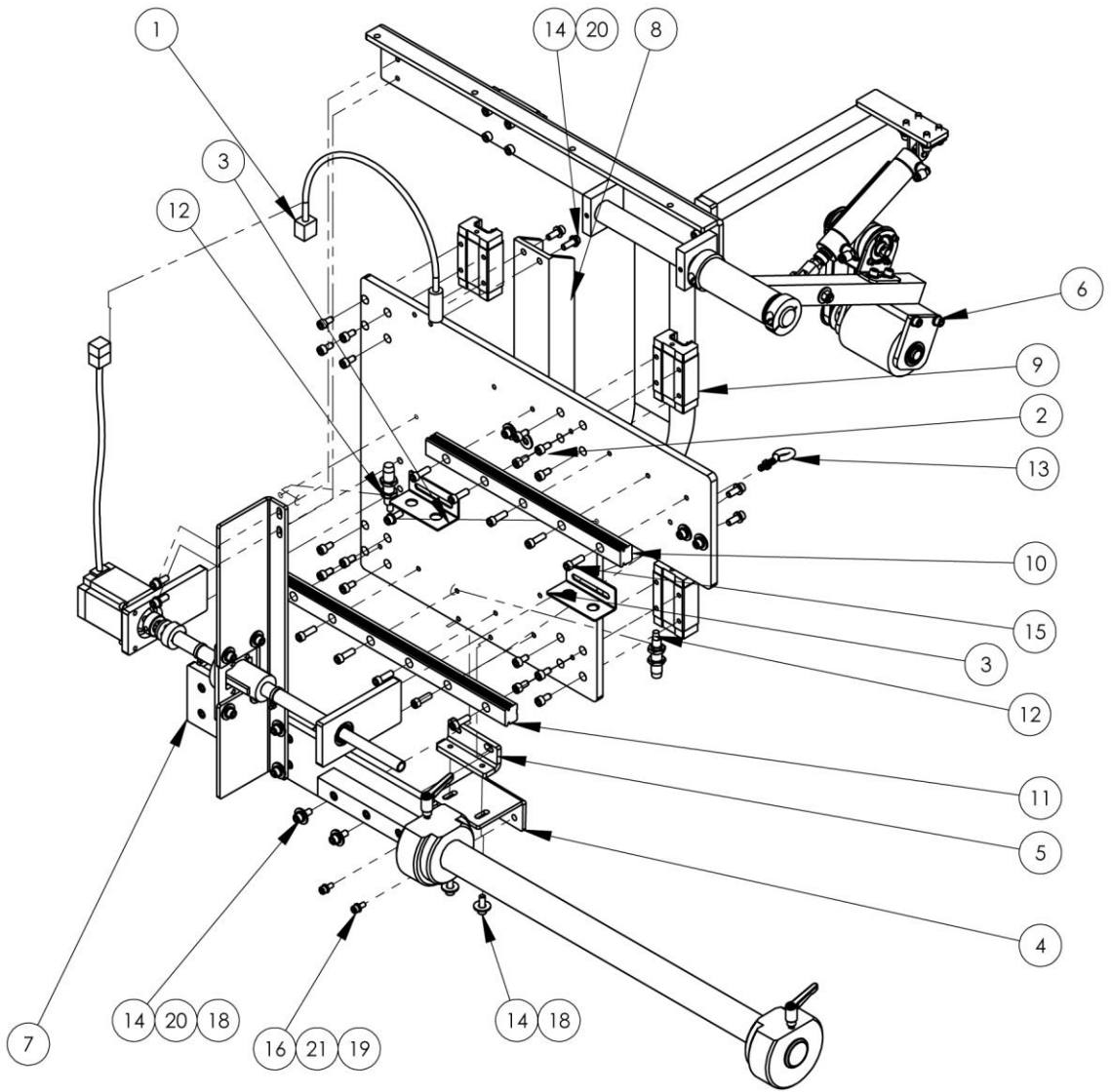


1337712 parts list

| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|----------------|---------------------------|
| 1 | 1 | 1337717 | MOUNT, CUTTER BAR MAIN |
| 2 | 1 | 1337718 | CUTTER BAR LOWER |
| 3 | 1 | 1337719 | CUTTER BAR UPPER |
| 4 | 1 | 1337720 | FINGER GUARD |
| 5 | 2 | 1337721 | MOUNT CUTTER BAR |
| 6 | 2 | 1337722 | MOUNT, CYLINDER CLEVIS |
| 7 | 2 | 1337723 | STOP BLOCK |
| 8 | 2 | 1337724 | NUT, DOUBLE |
| 9 | 1 | 1337725 | SUPPORT TOP MIDDLE |
| 10 | 2 | 1337844 | RAIL STOPS |
| 11 | 2 | AA2000F-03 | FLOW CONTROL,IN-LINE,5/32 |
| 12 | 2 | AAC8DP-3 | CYLINDER,AIR,DA |
| 13 | 2 | AAFCT-8 | CLEVIS,AIR CYL, 10-32 |
| 14 | 2 | A AFF-8 | BRKT,MOUNTING,7/16 BORE |
| 15 | 4 | AAQMC-5-10 | QUICK MALE CONNECT |
| 16 | 2 | AAQUT-5-5 | QUICK UNION T,5/32X5/32 |
| 17 | 2 | MMGN12H | MGN12H BEARING BLOCK |
| 18 | 2 | MMGNR12R0115HM | 115MM RAIL - MGN12H BLK |
| 19 | 10 | NNH4-40 | NUT,HEX,#4-40 |
| 20 | 6 | NNK8-32 | NUT,KEP,8-32 |
| 21 | 8 | SSFC90024 | 8-32 X 3/8 FL ALN CAP |
| 22 | 8 | SSFCM3X10 | M3-0.50X10, SCEW FLAT ALL |
| 23 | 4 | SSSC01040 | 1/4-20 X 5/8" SOC CAP SC |
| 24 | 10 | SSSC70024 | 4-40 X 3/8 SOCKET CAP |
| 25 | 10 | SSSC90024 | 8-32 X 3/8 SOC CAP SC |
| 26 | 2 | SSSC90048 | #8-32 X 3/4 SOC CAP SC |
| 27 | 4 | WWF8 | WASHER, FLAT, #8 |
| 28 | 6 | WWL8 | WASHER,LOCK,#8 |

1337726 SPOOL CARRIER

AAC Drawing Number 13237726 Rev 1

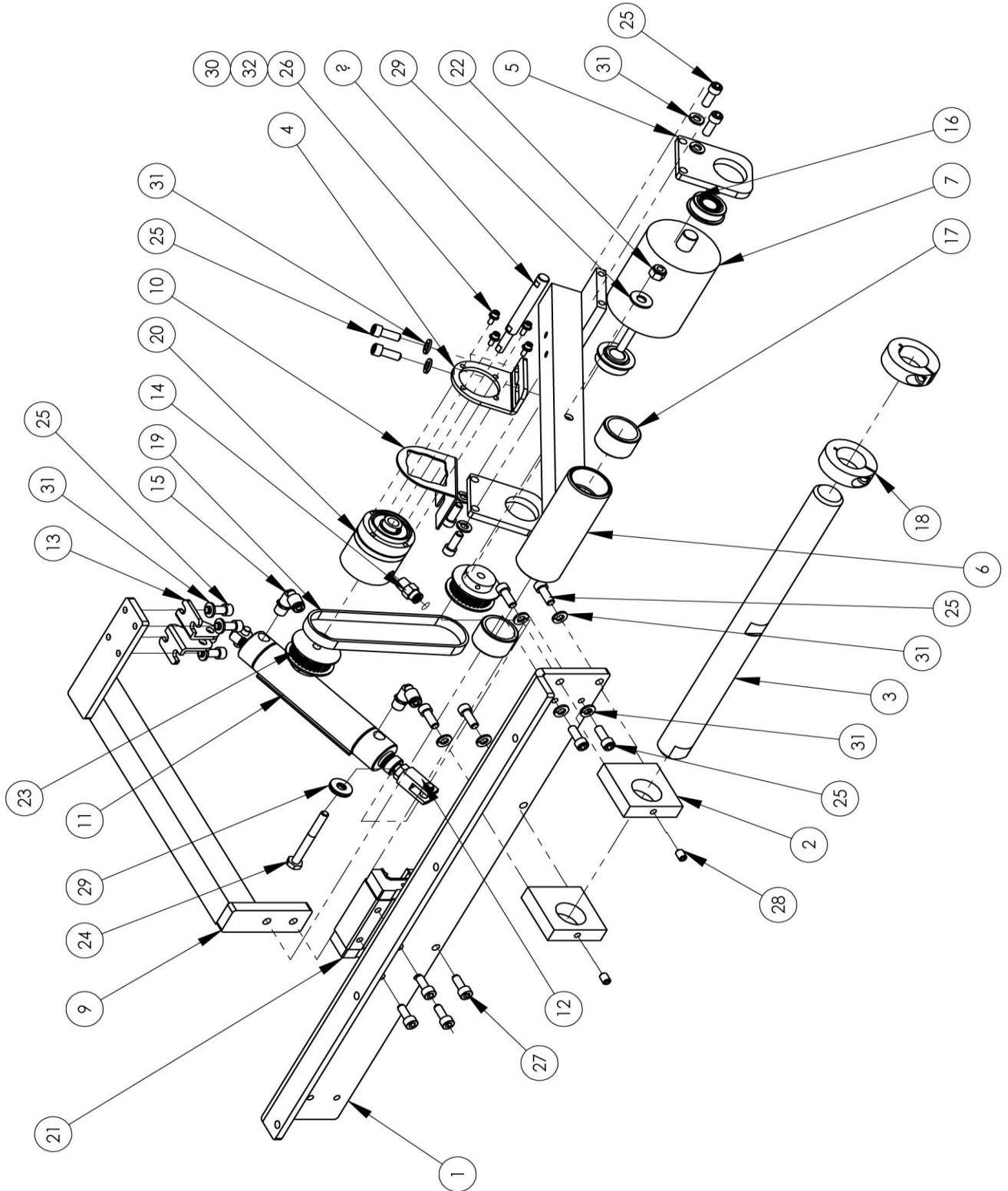


1337726 parts list

| NO | QTY | PART # | DESCRIPTION |
|----|-----|-------------|---------------------------|
| 1 | 1 | 4080-4508B | CABLE,STEP MOTOR,4 AMP,7' |
| 2 | 1 | 1337727 | SLIDING PLATE, SPOOL |
| 3 | 2 | 1337734 | MOUNT, SENSOR |
| 4 | 1 | 1337753 | CONNECTION, CYL - SLIDE 2 |
| 5 | 1 | 1337754 | CONNECTION, CYL - SLIDE 1 |
| 6 | 1 | 1337809 | BACK PRESSURE ASSEMBLY |
| 7 | 1 | 1337810 | SLIDE CARRIER SPOOL |
| 8 | 1 | MM45021-22 | DUCT,WIRE PLASTITRAK |
| 9 | 4 | MMAGH25CAN | LINEAR BEARING |
| 10 | 1 | MMAGR25303N | RAIL,LINEAR,AG SERIES |
| 11 | 1 | MMAGR25360N | RAIL,LINEAR,AG SERIES |
| 12 | 2 | MMAM1-AN-4A | PROX SWITCH, 10-30VDC |
| 13 | 1 | SSBE01060 | EYEBOLT,1/4-20 X .88 |
| 14 | 16 | SSSC01040 | 1/4-20 X 5/8" SOC CAP SC |
| 15 | 11 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 16 | 2 | SSSCM5X12 | M5 X 12 SOC CAP SC |
| 17 | 16 | SSSCM6X12 | M6X12 SOC CAP SCREW |
| 18 | 8 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 19 | 2 | WWFM5 | WASHER, FLAT, M5 I.D. |
| 20 | 16 | WWL1/4 | WASHER,LOCK, 1/4 |
| 21 | 2 | WWLM5 | M5 LOCK WASHER |

1337809 BACK PRESSURE ASSEMBLY

AAC Drawing Number 1337809 Rev 2

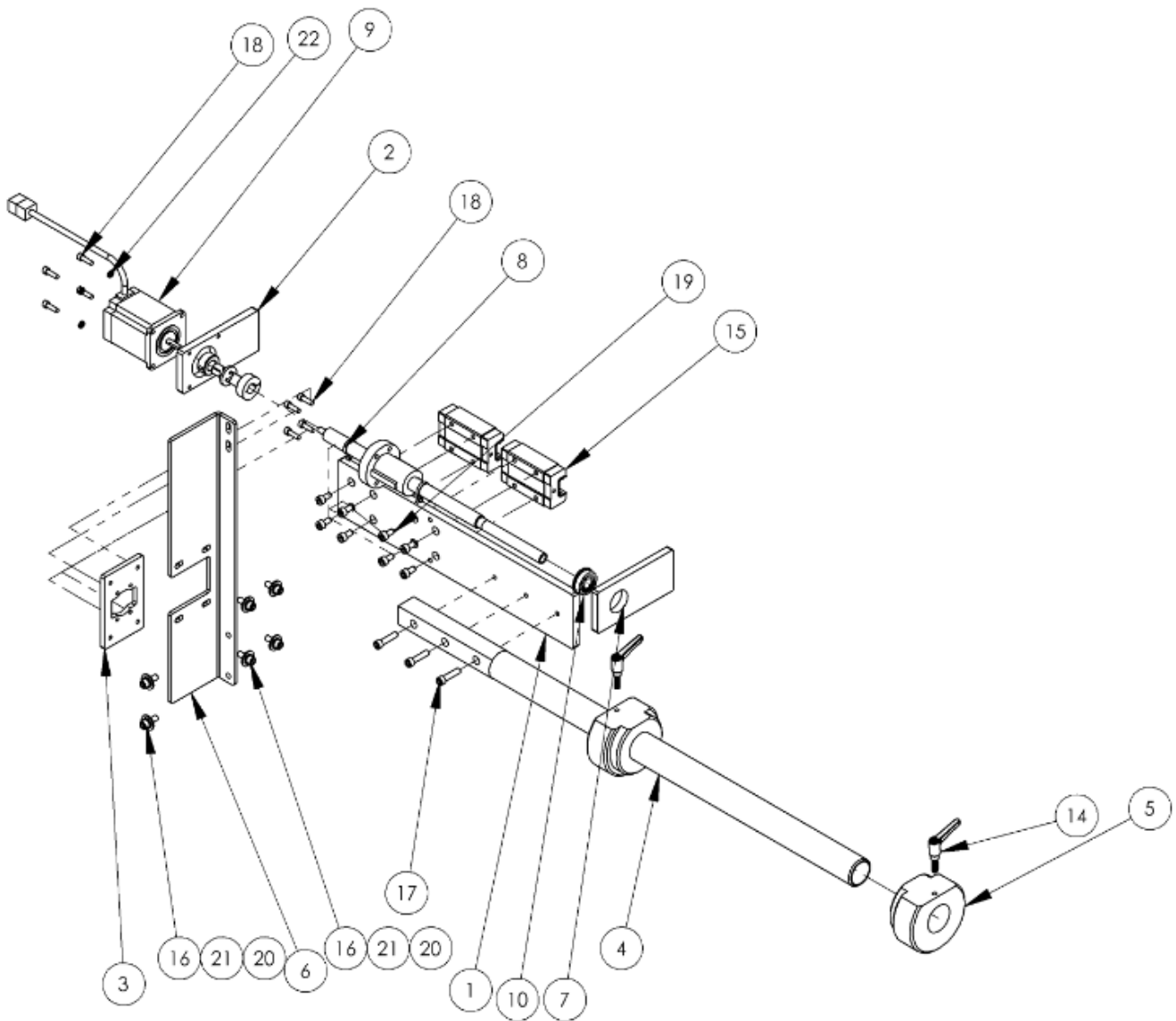


1337809 parts list

| NO | QTY | PART # | DESCRIPTION |
|----|-----|------------|----------------------------|
| 1 | 1 | 1337730 | SLIDE, BACK PRESSURE |
| 2 | 2 | 1337731 | SHAFT MNT, BACK PRESSURE |
| 3 | 1 | 1337732 | SHAFT, BACK PRESSURE |
| 4 | 1 | 1337733 | MOUNT, BRAKE |
| 5 | 2 | 1337741 | END PLATE, BACK PRESSURE |
| 6 | 1 | 1337742 | WELDMENT BACK PRESSURE |
| 7 | 1 | 1337746 | ROLLER, BACK PRESSURE 1 |
| 8 | 1 | 1337747 | SHAFT, CLUTCH BRAKE |
| 9 | 1 | 1337748 | BACK PRESSURE BASE WELD. |
| 10 | 1 | 1337817 | BRACKET, BRAKE ANTI ROTATE |
| 11 | 1 | AAC093DP | CYLINDER, DA 1.06 B 3 S |
| 12 | 1 | AAFD166-1 | ROD CLEVIS, 5/16- 24 T, |
| 13 | 1 | AAFD167 | REAR PIVOT BRACKET |
| 14 | 1 | AAQMC-5-8 | QU. MALE CONN 5/32X1/8 |
| 15 | 2 | AAQME-5-8 | QUICK MALE ELBOW |
| 16 | 2 | BB6384K361 | BEARING. BALL FLANGED |
| 17 | 2 | BBB-1612 | BEARING, NEEDLE, 1.00B |
| 18 | 2 | CCCL16F | COLLAR, 1" CLAMP TYPE |
| 19 | 1 | GG130XL037 | BELT, GEAR, 3/8P, 3/8W |
| 20 | 1 | MM856800 | BRAKE CLUTCH |
| 21 | 1 | MMAGH25CAN | LINEAR BEARING |
| 22 | 1 | NNE1/4-20 | NUT, ELASTIC LOCK, 1/4-20 |
| 23 | 2 | PP22XLB037 | PULLEY, TOP CONVEYOR |
| 24 | 1 | SSHC01144 | HEX HEAD BOLTS |
| 25 | 16 | SSSC01040 | 1/4-20 X 5/8" SOC CAP SC |
| 26 | 4 | SSSC80024 | 6-32 X 3/8 SOC CAP SC |
| 27 | 4 | SSSCM6X16 | M6 X 16, SOC CAP |
| 28 | 2 | SSSS01024 | SCREW, SET, 1/4-20 X 3/8 |
| 29 | 3 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 30 | 4 | WWFS6 | WASHER, FLAT, #6 |
| 31 | 16 | WWL1/4 | WASHER, LOCK, 1/4 |
| 32 | 4 | WWL6 | WASHER, LOCK, #6 |

1337810 SLIDE CARRIER SPOOL

AAC Drawing Number 1337810 Rev 1

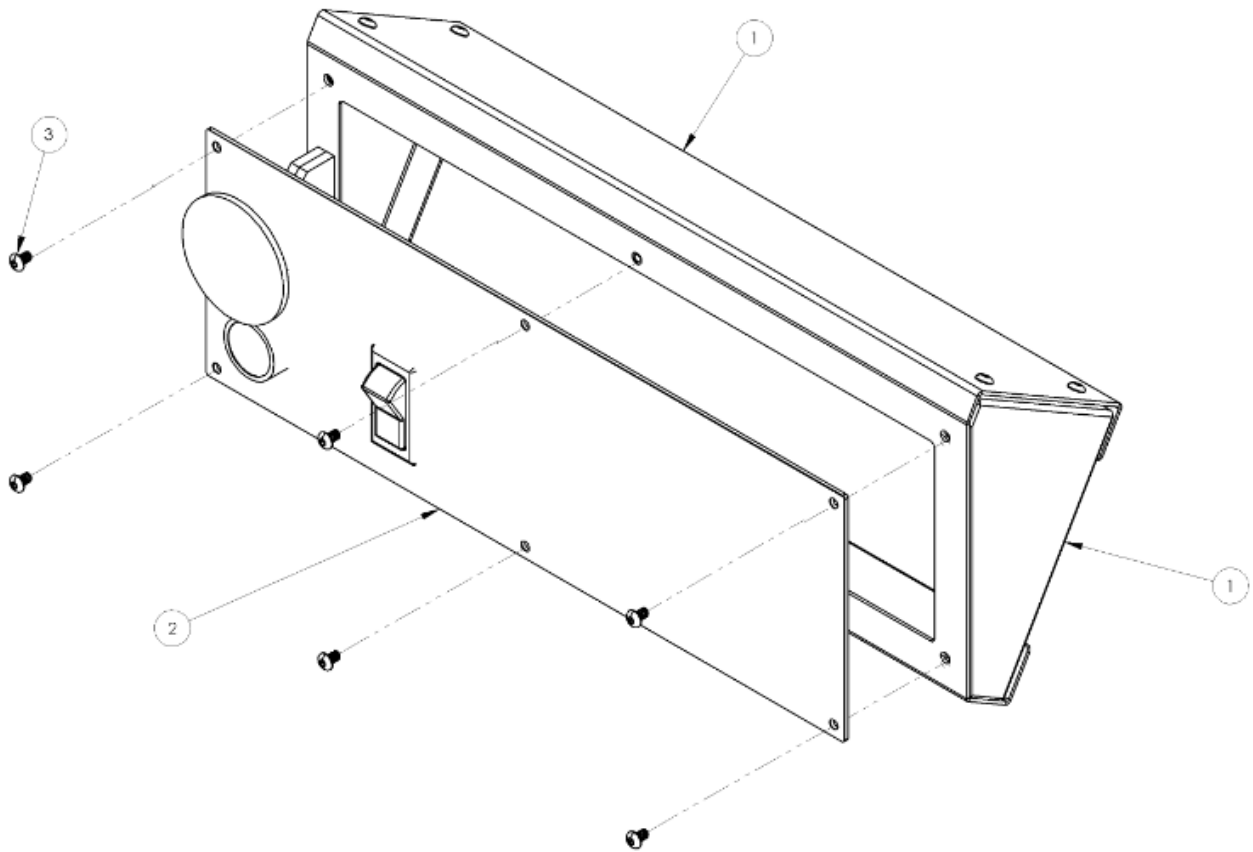


1337810 parts list

| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|-------------|--------------------------|
| 1 | 1 | 1337728 | SLIDER, SPOOL MOUNT |
| 2 | 1 | 1337729 | MOUNT, MOTOR LEAD SCREW |
| 3 | 1 | 1337735 | MOUNT, LEAD SCREW NUT |
| 4 | 1 | 1337736 | SHAFT MOUNT WELDMENT |
| 5 | 2 | 1337739 | COLLAR, SHAFT, SPOOL |
| 6 | 1 | 1337740 | CROSSBAR, SLIDE TRAVEL |
| 7 | 1 | 1337815 | MOUNT, LEAD SCREW BEARNG |
| 8 | 1 | 1337846 | BALL SCREW AND NUT |
| 9 | 1 | AP-22E-103 | STEP MOTOR, 2 AMP |
| 10 | 1 | BB6384K361 | BEARING. BALL FLANGED |
| 11 | 1 | CC2X568 | COLLAR,SET,1/2" |
| 12 | 1 | CCCL8F | CLAMP COLLAR- 1/2 |
| 13 | 1 | MM8FM | JOINT,UNIVERSAL,MOD |
| 14 | 2 | MM64835K65 | HANDLE ADJUSTABLE |
| 15 | 2 | MMEGH25CA | LINEAR BEARING |
| 16 | 6 | SSSC01040 | 1/4-20 X 5/8" SOC CAP SC |
| 17 | 3 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 18 | 8 | SSSC98040 | 10-32 X 5/8 SOC CAP |
| 19 | 8 | SSSCM6X12 | M6X12 SOC CAP SCREW |
| 20 | 6 | WWF1/4 | WASHER, FLAT, 1/4", COM |
| 21 | 6 | WWL1/4 | WASHER,LOCK, 1/4 |
| 22 | 4 | WWL10 | WASHER,LOCK,#10 |

1337982 CONTROL PANEL

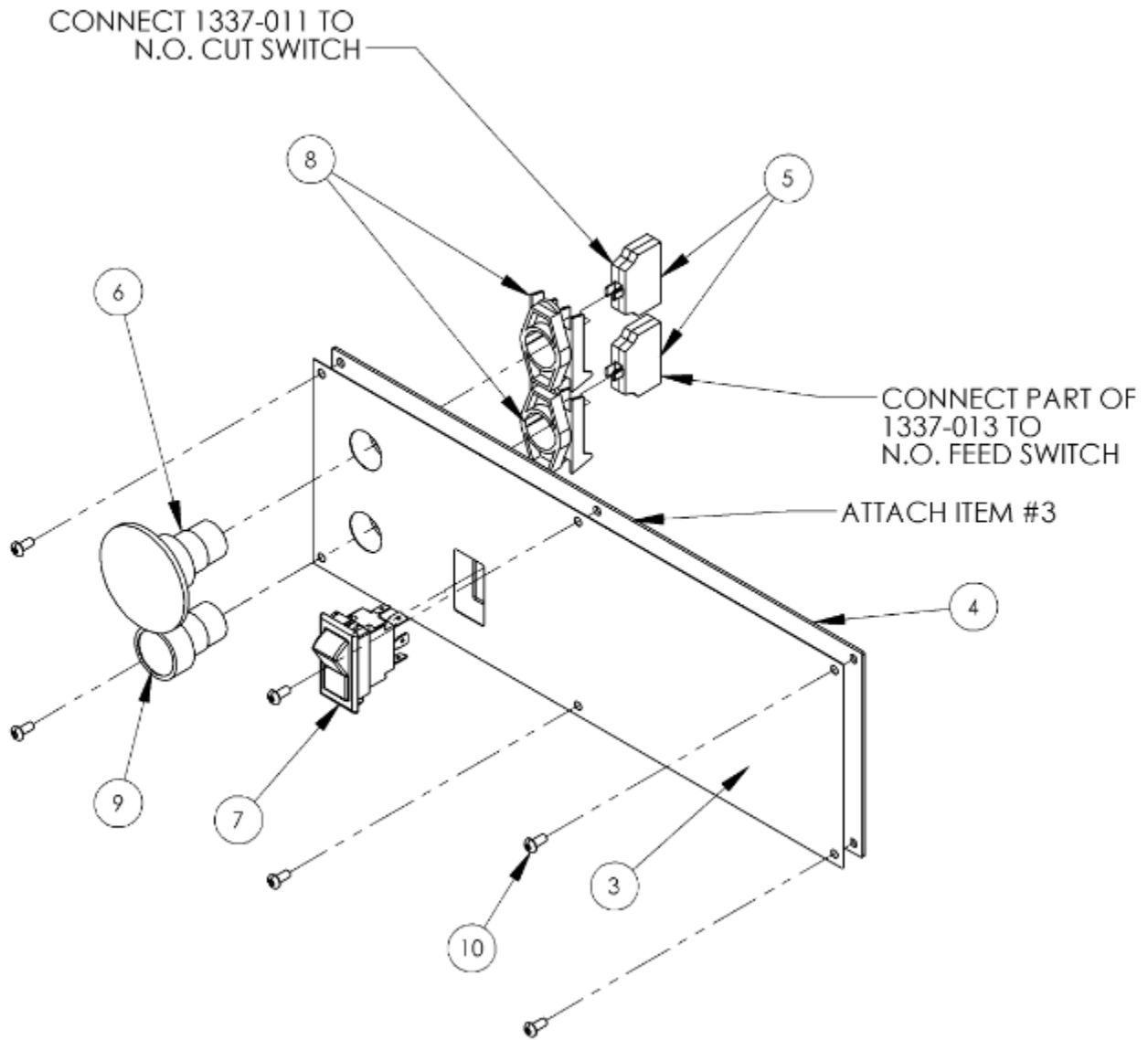
AAC Drawing Number 1337982 Rev 0



| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|-------------|-----------------------|
| 1 | 1 | 1337771 | CONTORL PANEL CASE |
| 2 | 1 | 1337983 | OPERATOR PANEL, SBUS |
| 3 | 6 | SSBC90016 | 8-32 X 1/4 BUTTON CAP |

1337983 OPERATOR PANEL

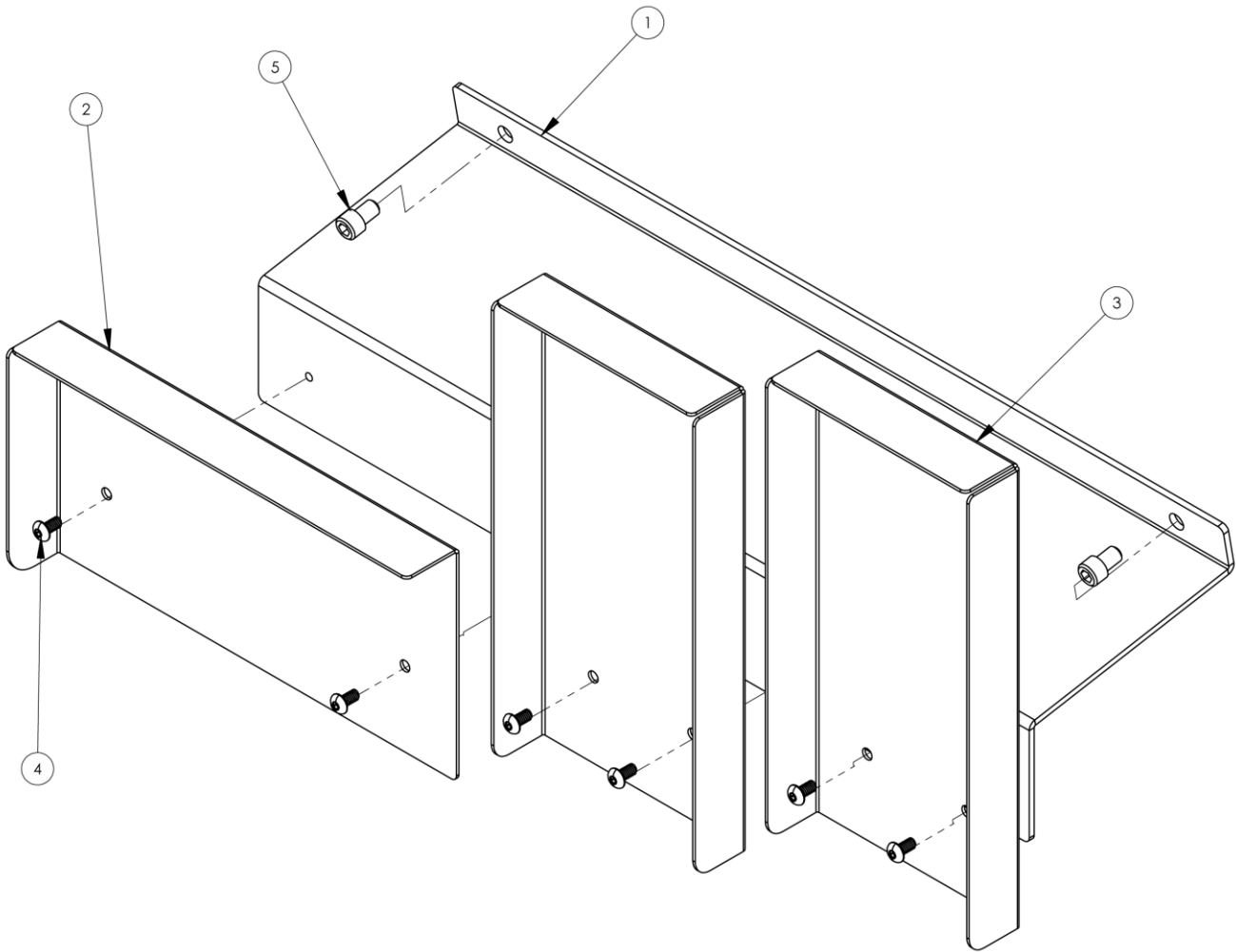
AAC Drawing Number 1337983 Rev



| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|--------------|--------------------------------|
| 1 | *1 | 1337-011 | CABLE, 2 COND TO 4P MOLEX |
| 2 | *1 | 1337-015 | CABLE E-STOP |
| 3 | 1 | 1337DLA-LAB1 | CONTROL PANEL LABEL, SBUS |
| 4 | 1 | 1337776 | CONTROL PANEL COVER |
| 5 | 2 | EE3X10 | BLOCK,P.B. CONTACT, N.O. (GRN) |
| 6 | 1 | EE800FP-MM65 | PUSHBUTTON,22MM,MOM,MUSH, |
| 7 | 1 | EE1105 | SWITCH,ROCKER, 28V ILLUM |
| 8 | 2 | EEA3L | LATCH,PUSH BUTTON |
| 9 | 1 | EPPF5 | BUTTON,PUSH,22MM,YELL,MO |
| 10 | 6 | SSBC90024 | 8-32X3/8 BUTTON CAP |

1337800 PARTS SHELF

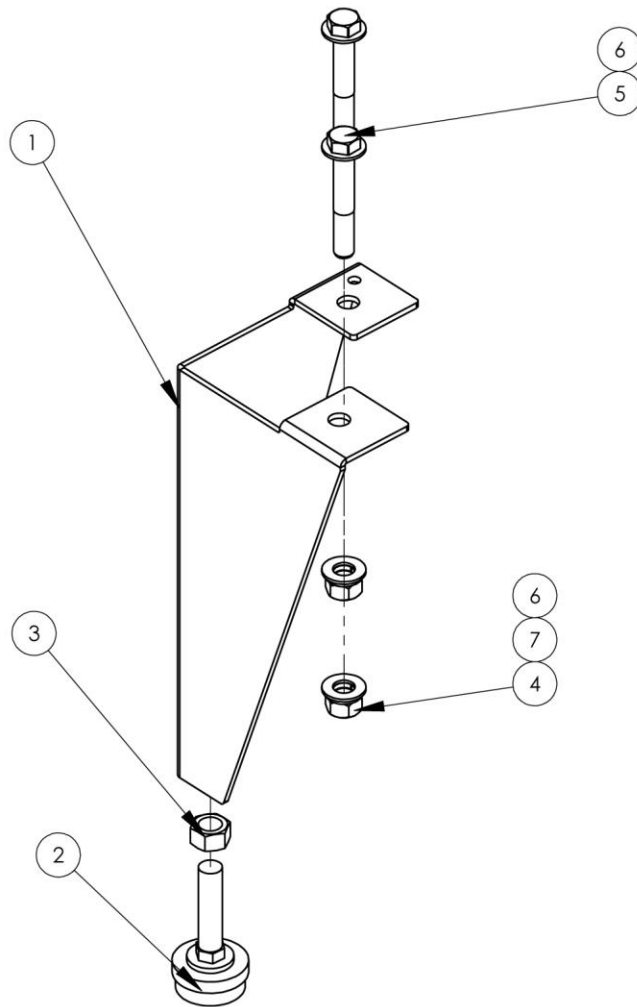
AAC Drawing Number 1337800 Rev 0



| NO | QTY | PART # | DESCRIPTION |
|----|-----|-----------|-------------------------|
| 1 | 1 | 1337799 | MOUNT SHELF |
| 2 | 1 | 1337801 | SHELF, PART LONG |
| 3 | 2 | 1337802 | SHELF, PARTS SHORT |
| 4 | 6 | SSBC90020 | 8-32X3/8 BUTTON CAP |
| 5 | 2 | SSSC01024 | 1/4-20 X 3/8 SOC CAP SC |

1337818 LEG ASSY PAD CORNER

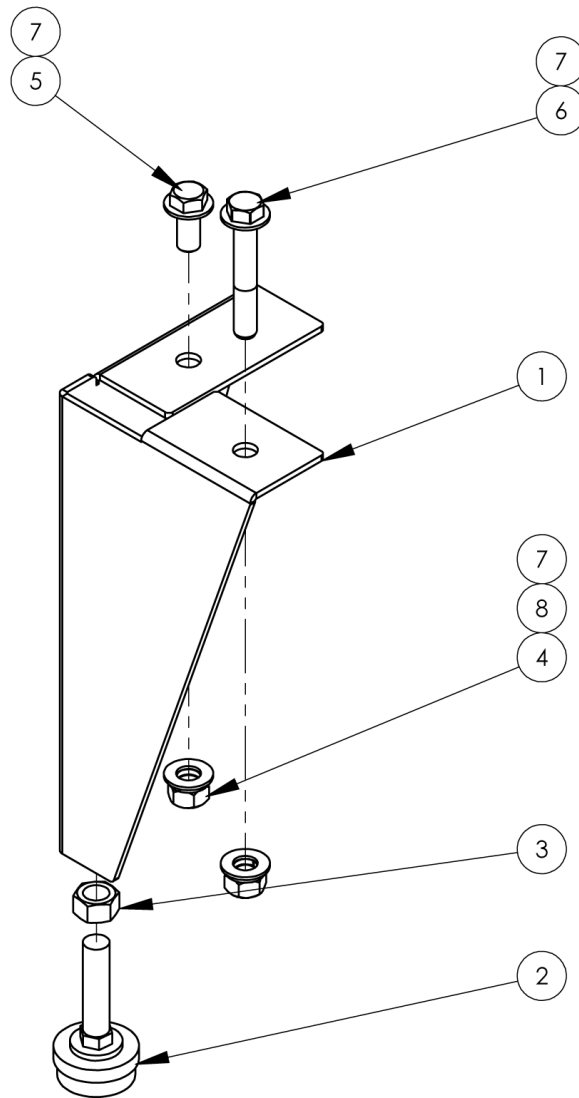
AAC Drawing Number 1337818 Rev 0



| NO | QTY | PART # | DESCRIPTION |
|----|-----|------------|---------------------------|
| 1 | 1 | 1337819 | LEG, CORNER PAD |
| 2 | 1 | MMFB4444 | FOOT, RUBBER |
| 3 | 1 | NNH1/2-13 | NUT,HEX,1/2-13 |
| 4 | 2 | NNH7/16-14 | NUT,HEX,7/16-14 |
| 5 | 2 | SSH38176 | SCREW,HEX 7/16-14 X 2-3/4 |
| 6 | 4 | WWF7/16 | WASHER,FLAT,7/16 |
| 7 | 2 | WWL7/16 | WASHER,LOCK,7/16 |

1337820 LEG ASSY, REAR LEFT

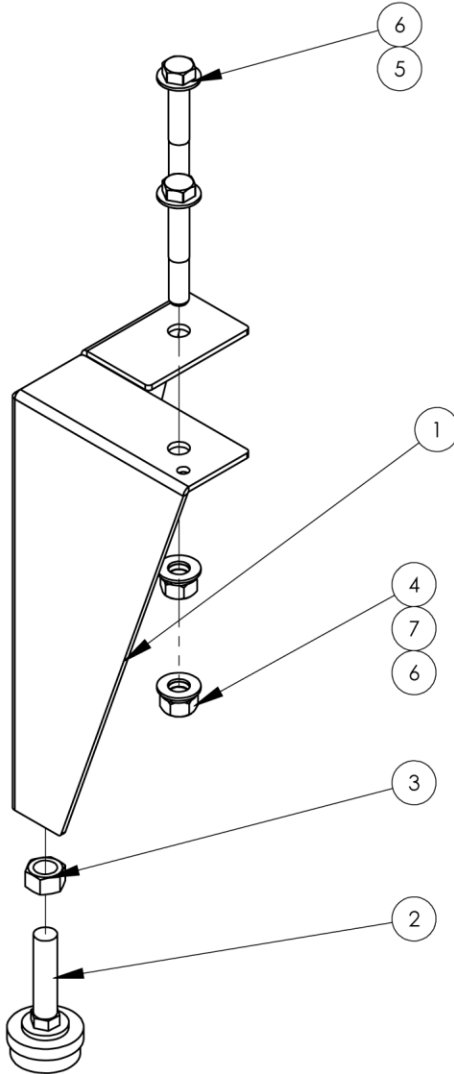
AAC Drawing Number 1337820 Rev 0



| NO | QTY | PART # | DESCRIPTION |
|----|-----|------------|---------------------------|
| 1 | 1 | 1337821 | LEG WELD REAR LEFT |
| 2 | 1 | MMFB4444 | FOOT, RUBBER |
| 3 | 1 | NNH1/2-13 | NUT,HEX,1/2-13 |
| 4 | 2 | NNH7/16-14 | NUT,HEX,7/16-14 |
| 5 | 1 | SSHC38064 | 7/16-14 X 1 HEX CAP |
| 6 | 1 | SSHC38176 | SCREW,HEX 7/16-14 X 2-3/4 |
| 7 | 4 | WWFS7/16 | WASHER,FLAT,7/16 |
| 8 | 2 | WWL7/16 | WASHER,LOCK,7/16 |

1337824 LEG ASSY, CORNER W/O PAD

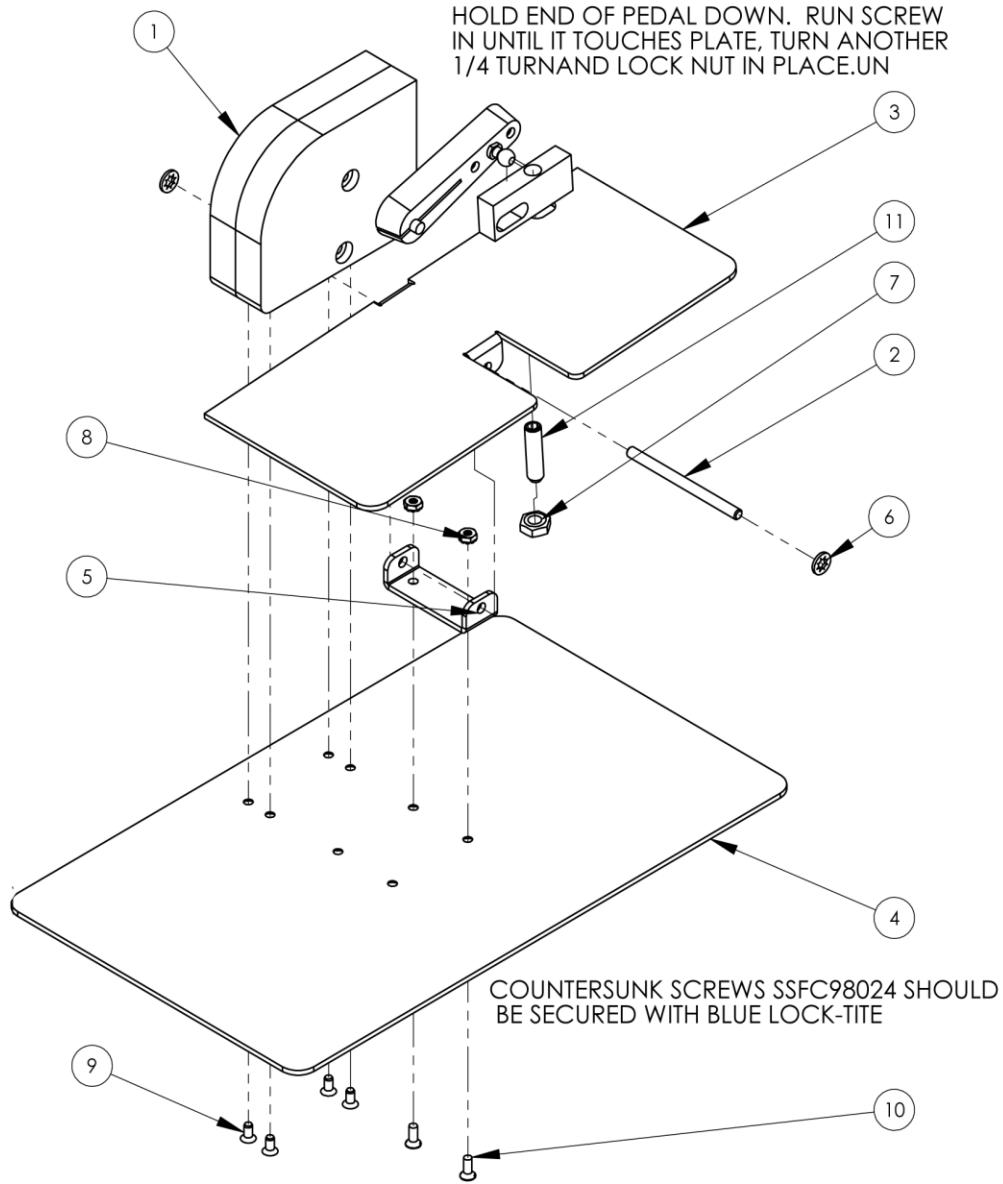
AAC Drawing Number 1337824 Rev 0



| NO | QTY | PART # | DESCRIPTION |
|----|-----|------------|---------------------------|
| 1 | 1 | 1337825 | LEG ASSY, CORNER W/O PAD |
| 2 | 1 | MMFB4444 | FOOT, RUBBER |
| 3 | 1 | NNH1/2-13 | NUT,HEX,1/2-13 |
| 4 | 2 | NNH7/16-14 | NUT,HEX,7/16-14 |
| 5 | 2 | SSHC38176 | SCREW,HEX 7/16-14 X 2-3/4 |
| 6 | 4 | WWFS7/16 | WASHER,FLAT,7/16 |
| 7 | 2 | WWL7/16 | WASHER,LOCK,7/16 |

1337836 FOOT PEDAL ASSY, EFKA

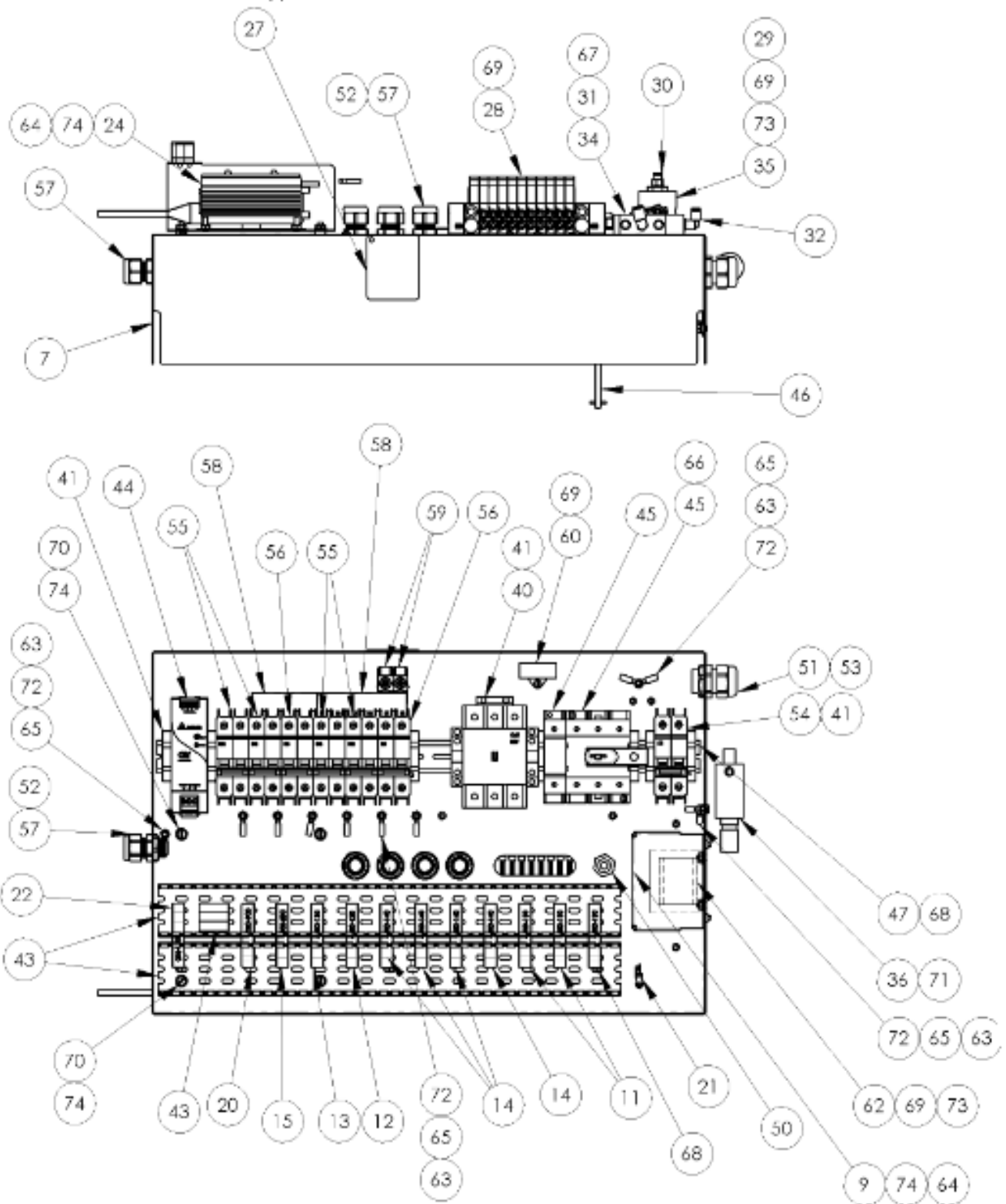
AAC Drawing Number 1337836 Rev 0



| NO | QTY | PART # | DESCRIPTION |
|----|-----|-------------|--------------------------|
| 1 | 1 | 4059-EB301A | ACTUATOR, TREADLE, 9 PIN |
| 2 | 1 | 26058 | ROD, STRAIGHT, 1018 |
| 3 | 1 | 1337837 | FOOT PEDAL WELDMENT |
| 4 | 1 | 1337839 | BASE, FOOT PEDAL, 12X18 |
| 5 | 1 | A3502-4 | FOOT PEDAL, BRACKET |
| 6 | 2 | MM94807A029 | PUSHNUT, ROUND, 1/4 DIA |
| 7 | 1 | NNJ3/8-16 | 3/8-16 JAM NUT |
| 8 | 2 | NNK10-32 | KEP NUT, 10-32 |
| 9 | 4 | SSFPM5X10 | SCREW, FLAT PHILLIPS |
| 10 | 2 | SSFS90048 | #8-32 X 3/4 FLAT SLOT |
| 11 | 1 | SSSS25096 | 3/8-16 SET SCREW, 1-1/2" |

1337968 Control Box, Gateway, UL Compliant

AAC Drawing Number 1337968 Rev 1



1337968 parts list

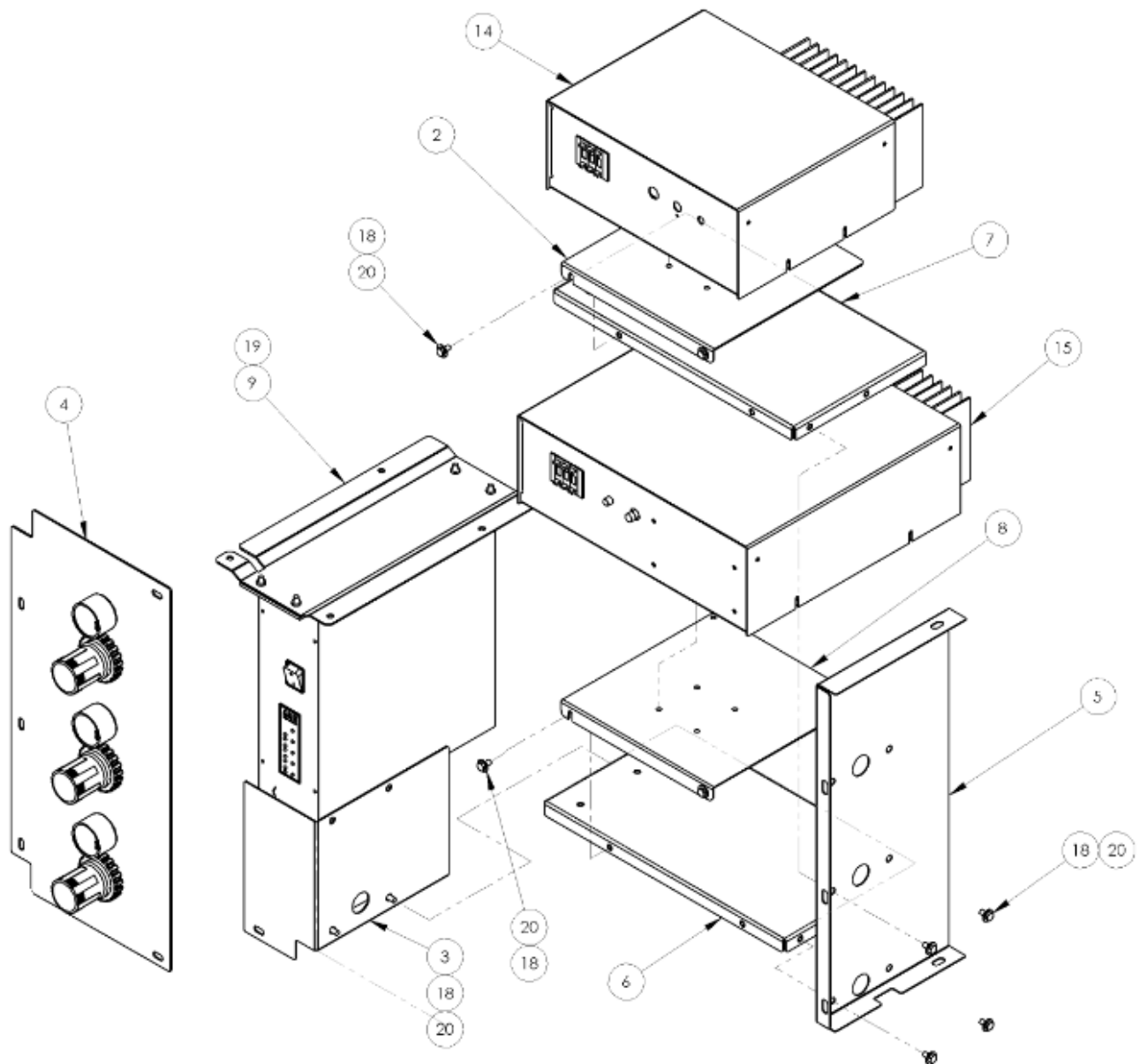
| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|-------------|--|
| 1 | *1 | 0211-702D | CABLE,POS1.SENSOR,8',DC1500 EFKA |
| 2 | *1 | 0211-705E | CABLE, TREADLE,6',SBUS |
| 3 | 1 | 0211-705N | CABLE, TREADLE, SBUS |
| 4 | *2 | 0411-3014C | CABLE,PROX SW,8' |
| 5 | 2 | 0411-3015A | CABLE,22 GA W/AE PLUG, 6.6L |
| 6 | *1 | 12788-503B | CABLE, 6' L, 2 COND 2 FAST ON, AE PLUG |
| 7 | 1 | 1337969 | CHASSIS, CTRL BX, GATEWAY, UL COMP |
| 8 | *AR | 1337DLA-WD | DIAGRAM, WIRING, SBUS |
| 9 | 1 | 3210159 | COVER, TRANSFORMER |
| 10 | 1 | 4059-EXT1 | CABLE,6 COND,SIGNAL,18" |
| 11 | 3 | 4080-110 | MODULE,QUAD INPUT |
| 12 | 1 | 4080-120 | MODULE,SBUS, DUAL OPTO-ISO, INPT |
| 13 | 1 | 4080-130 | MODULE,QUAD OPTO-ISO |
| 14 | 4 | 4080-140 | MODULE,QUAD OUTPUT |
| 15 | 1 | 4080-200 | MODULE,AIR PRESSURE |
| 16 | *1 | 4080-4502B | CABLE, JOG/SYN EN, 11337DLA |
| 17 | *1 | 4080-4502C | CABLE, JOG/DIR, 11337DLA |
| 18 | 2 | 4080-4508A | CABLE, STEPPER MOTOR, 4A, 12' |
| 19 | *1 | 4080-4631 | CABLE, SBUS ASSY. |
| 20 | 1 | 4080-900 | SBUS MODULE, USB GATEWAY, INTERFACE |
| 21 | 1 | 4080-940 | MODULE,TERMINATOR |
| 22 | 1 | 4080-950 | MODULE,POWER |
| 23 | 1 | 4082003 | CABLE, PWR,12VDC |
| 24 | 1 | 4082022 | PC GATEWAY W/ POWER SUPPLY ASSY. |
| 25 | *1 | 4082101 | CABLE, PWR,12VDC - 6MMx2.1P,2PM,12" |
| 26 | *2 | 4082102-72 | CABLE, 2C, 2PM MOLEX, NC, CABLE, 72" |
| 27 | 1 | 4300585 | CABINET TOP COVER |
| 28 | 1 | AAE1335-10 | SOLENOID ASSY,10 STATION |
| 29 | 4 | AAQMC-4-4 | QUICK MALE CONN 1/4OD, 1/4NPT |
| 30 | 2 | AAQMC-5-8 | QU. MALE CONN 5/32X1/8 |
| 31 | 1 | AAQME-4-8 | QUICK MALE ELBOW, 1/4T |
| 32 | 2 | AAQME-5-8 | QUICK MALE ELBOW |
| 33 | *1 | AAQUT-4-4 | QUICK UNION T 1/4X1/4 |
| 34 | 1 | AAV125B | PILOT VALVE |
| 35 | 2 | AAV250A | PILOT VALVE |
| 36 | 1 | AAVTBV200 | CHAIN VACUUM WASTE UNIT |
| 37 | 1 | AP-28-612JF | CABLE, SYNC, FL, NU, POWER |
| 38 | *2 | EE17518 | CORD,POWER,IEC,F |

1337968 parts list continued

| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|--------|---------------|-------------------------------------|
| 39 | 1 | EE64151B | FERRITE CORE,SPLIT,CABLE |
| 40 | 1 | EECGC85A24 | CONTACTOR,65A,24VAC |
| 41 | 9 | EECLIPFIX | ANCHOR,DIN RAIL |
| 42 | *2 | EEDC2X2 | COVER,WIRE DUCT |
| 43 | 2 | EEDF2X2 | DUCT,WIRE,2X2, MOD |
| 44 | 1 | EEDRP24V100W | POWER SUP,SW,24V 3.8A, DIN |
| 45 | 1 | EEM30U3M | DISCONNECT ASSY, 3PH, 30A |
| 46 | 1 | EESPA210-4.80 | DISCONNECT SHAFT,MOD |
| 47 | *23.5" | EETS35X7.5A | DIN RAIL-AMERICAN |
| 48 | *1 | EEUSBAMUSBCM6 | USB-A M TO USB-C CABLE M, 6' |
| 49 | *12FT | FF19509 | CABLE, 3 COND, 18 AWG |
| 50 | 1 | FF3210 | STRAIN RELIEF, PG-9, 18-.31, BLK |
| 51 | 1 | FF3460 | STRAIN RELIEF,LIQ TIGHT, 3/4NPT |
| 52 | 5 | FF8463 | NUT,LOCK, 1/2NPT,NYLON,BLK |
| 53 | 1 | FF8465 | NUT,LOCK, 3/4NPT,NYLON,BLK |
| 54 | 1 | FFFAZD12NA | BREAKER,2P,1A,UL489,240VT-MAG |
| 55 | 4 | FFFAZD22NA | BREAKER,2P, 2A,UL489,240VT-MAG |
| 56 | 2 | FFFAZD52NA | BREAKER,2P,5A,UL489, |
| 57 | 5 | FFM3200 | STRAIN RELIEF, 1/2NPT, .26-.55, BLK |
| 58 | 2 | FFM9XUP206 | BREAKER,ACC,UL489,COMB,18MM,2P6 |
| 59 | 2 | FFM9XUPC04 | BREAKER,ACC,UL489,COMB,18MM,TOP |
| 60 | 1 | FFRAV781BW | MODULE, TVS, 240 VAC |
| 61 | *2 | FFRK44TBS6 | CABLE,AE PLUG,6'LONG |
| 62 | 1 | FFTX24 | TRANSFORMER,24V,2.4AMP |
| 63 | 9 | NNH8-32 | NUT,HEX, 8-32 REG. |
| 64 | 6 | NNK10-32 | KEP NUT, 10-32 |
| 65 | 9 | NNK8-32 | NUT,KEP,8-32 |
| 66 | 2 | SSPS80020 | #6-32 X 5/16 LG PAN HD |
| 67 | 2 | SSPS80064 | #6-32 X 1 PAN HD SLOTTED |
| 68 | 12 | SSPS90016 | #8-32 X 1/4 LG PAN HD |
| 69 | 7 | SSPS90024 | SCREW, #8-32 X 3/8 LG PAN HD |
| 70 | 4 | SSPS98040 | 10-32X5/8 PAN HD SLOT |
| 71 | 1 | SSPS98056 | #10-32X 7/8 PAN HD SLTD |
| 72 | 10 | TT5811 | TERMINAL,RING,#10 STUD |
| 73 | 6 | WWF8 | WASHER, FLAT, #8 |
| 74 | 10 | WWFS10 | WASHER, FLAT, #10, SAE |
| 75 | 1 | 4080-4250-24 | CABLE,SBUS,POWER,PS - PWR MOD,24" |
| | | | |

1337973 PANEL ELEC. & PNEU.

AAC Drawing Number 1337973 Rev 0

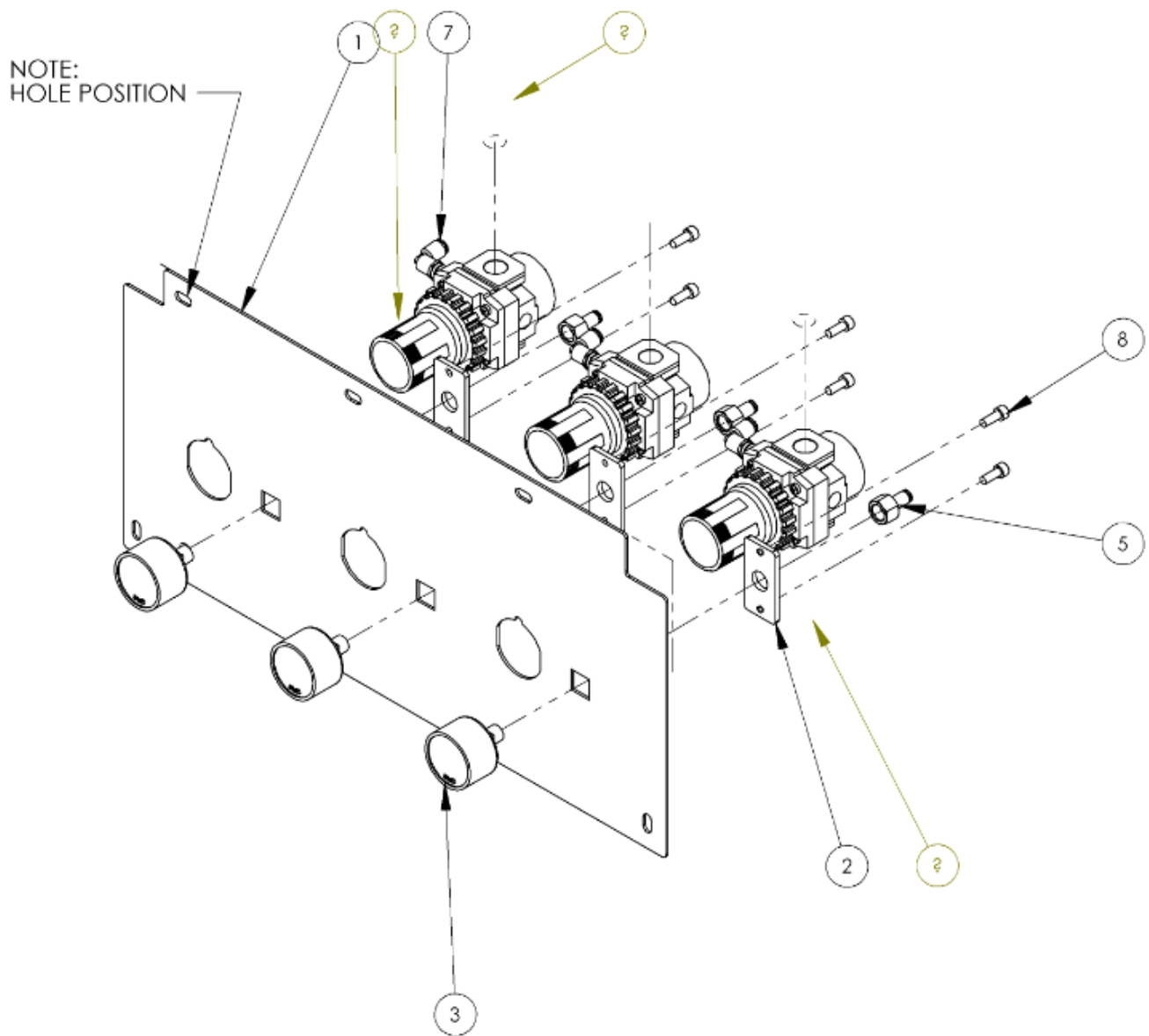


1337973 parts list

| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|-----------------|--------------------------------|
| 1 | 1 | 010-127C | REMOTE TREADLE CORD |
| 2 | 1 | 0411-1505 | BRKT,STEPPER BOX |
| 3 | 1 | 1337778 | PANEL, ELECTRICAL RIGHT |
| 4 | 1 | 1337779 | PNEUMATIC PANEL |
| 5 | 1 | 1337784 | PANEL ELECTRICAL RIGHT |
| 6 | 1 | 1337789 | SHELF. LARGER |
| 7 | 1 | 1337789 | SHELF. LARGER |
| 8 | 1 | 1337790 | BRKT,STEPPER BOX |
| 9 | 1 | 1337970 | BRKT, EFKA BOX |
| 10 | 1 | 4059-2-22E | CABLE,5 FT TREADLE |
| 11 | 1 | AP-28-610VA | CABLE, SOCKET "G" |
| 12 | 1 | AP-28-610VB | CABLE, SOCKET "I" |
| 13 | 1 | AP-28-614C | CABLE,F/L,SYNC |
| 14 | 1 | AP-28-800Y1A | BOX,STEPPER,H.S. (X5),2A,J,D,E |
| 15 | 1 | AP-28-820C | BOX, STEPPER HIGH V |
| 16 | 1 | EE16-3C2406 | CABLE,3 COND,16AWG,300V |
| 17 | 1 | FF9740 | CABLE, 2COND,18-2 AWG PVC |
| 18 | 12 | SSHC98024 | 10-32 X 3/8 HEX CAP |
| 19 | 4 | SSPS98024 | 10-32X3/8 PAN HD SLOT |
| 20 | 12 | WWF10 | WASHER, FLAT, #10, COM |
| 21 | 1 | EFKA AB BOX-REF | EFKA CONTROLLER BOX |

1337779 PNEUMATIC PANEL

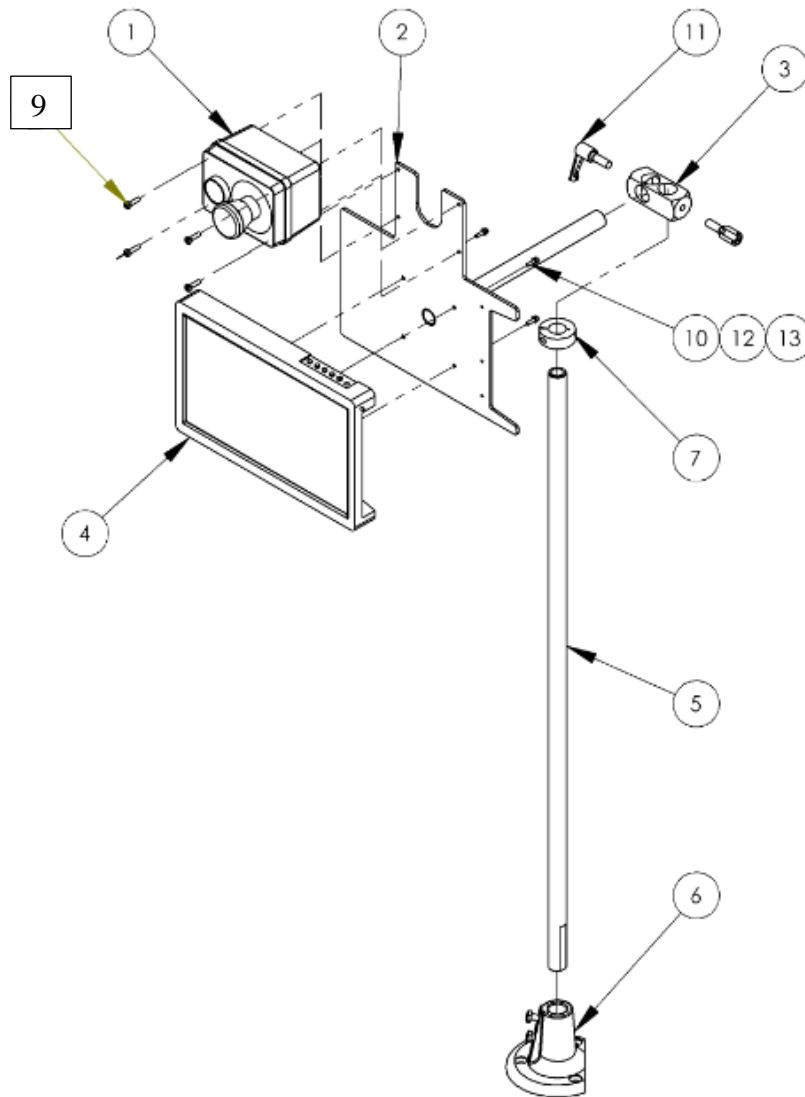
AAC Drawing Number 1337779 Rev 0



| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|-------------|-----------------------------------|
| 1 | 1 | 1337780 | PANEL, PNEUMATIC |
| 2 | 3 | 1337781 | GUAGE MOUNT BLOCK |
| 3 | 3 | AA198-5032 | 0-60PSI AIR GAGE 1/8NPT |
| 4 | 3 | AA198-RP3 | REGULATOR,PRECISION AIR |
| 5 | 3 | AAQFC-5-8 | FITTING, 1/8NPT-F, 5/32 T |
| 6 | 6 | AAQME-5-4 | ELBOW, QUICK MALE, 5/32 X 1/4 NPT |
| 7 | 3 | AAQME-5-8 | QUICK MALE ELBOW |
| 8 | 6 | SSSC98032 | 10-32X1/2, SOC CAP |

97-1700A TOUCH SCREEN ASSEMBLY

AAC Drawing Number 90071434 Rev 5



| ITEM | QTY. | PART NUMBER | DESCRIPTION |
|------|------|-------------|--------------------------------|
| 1 | 1 | 1278-6010 | START/STOP BUTTON ASSY |
| 2 | 1 | 13351060 | MOUNT, 10" TOUCH SCREEN |
| 3 | 1 | 28201 | CONNECTOR, ROD, LARGE |
| 4 | 1 | 4082105 | TOUCHSCREEN. 10", SUB ASSEMBLY |
| 5 | 1 | 97-1711 | TUBE, 3/4 OD X 30.0L |
| 6 | 1 | AP-1721 | STAND BASE, COMPLETE |
| 7 | 1 | CCCL12F | CLAMP COLLAR- 3/4 |
| 8 | 10' | EE16-3C2406 | CABLE, 3 COND |
| 9 | 4 | SSPS90040 | 8-32 X 5/8 PAN HD |
| 10 | 4 | SSSCM3X12 | M3-0.5X12 ,SOCKET CAP |
| 11 | 2 | TH6324K63 | HANDLE, THREADED, M8 X 20MM |
| 12 | 4 | WWFM3 | FLAT WASHER, M3 |
| 13 | 4 | WWLM3 | WASHER, LOCK, M3 |

1337DLPAR Efka Parameters

| PARAMETER | RANGE | LOCKSTITCH | CHAINSTITCH | GENERIC PARAMETER DESCRIPTION |
|--|------------------------|------------|-------------|---|
| Do this first | ***** | | **** | Perform a master reset before programming, see below |
| 290 | | 0 | 5 | Mode of operation. SET THIS PARAMETER FIRST! |
| 26 | 0-5 | 0 | 0 | Treadle Control - 0= Digital 1+= Analog |
| 111 | 200-9900 rpm | See Manual | 5000 | Recommended speed when "129" is 0, 1, or 2. (Default should be 0) |
| 119 | 1-3 | 1 | | Linear acceleration |
| 153 | 0-50 | 35 | 35 | Braking power at machine stand still - (Walking foot only) |
| 161 | 0-1 | 0* | 1 | Motor rotation, 0=CW, 1=CCW |
| 270 | 0-5 | * | 0 | External handwheel sensor configuration. (Position 2) |
| 271 | 0-255 | 180 | 180 | Ref angle for Position 1 (Trim) from Position 2 |
| 272 | 0150-2550 | 1000 | 1000 | Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111. (For Yamato and Pegasus, setting should be 100; for Rimoldi, setting should be 124) |
| 362 | 0-1 | 1 | 1 | Position sensor voltage: 0 = 5V, 1 = 15V |
| 436 | | 0 | 0 | Use code "5913". This disables an input that was causing box to reset itself. |
| 401 | 0-1 | | | Change from 0 to 1 to save parameters |
| Front panel LED's: | | | | |
| LED 1: | Off | | | Programming Instructions: 1. Power on holding down the "P" button till "COD" is displayed. 2. Press ">>" once and enter the number "5913" 3. Press "E" once and "2.0.0." is displayed this is a parameter 4. Proceed to the parameter to be changed and press "E". 5. The value now shows in the screen, adjust to desired value. 6. Press "E" to enter value and continue with parameter setting. 7. Repeat for other parameters, press "P" once when complete. 8. Run sewing head to save parameters before powering down |
| LED 2: | Off | | | |
| LED 3: | Off | | | |
| LED 4: | Off | | | |
| LED 5: | Off | | | |
| LED 6: | ON, Stop at needle up. | | | |
| LED 7: | Off | | | |
| LED 8: | Off | | | |
| To Perform Master Reset of Parameters: | | | | |
| | | | | 1. Power on holding down the "P" button till "COD" is displayed. |
| | | | | 2. Press ">>" once and enter the number "5913" |
| | | | | 3. Press "E" twice and "093" is displayed. |
| | | | | 4. Press "+" once, "094" is displayed. |
| | | | | 5. Press "P" to exit programming mode with all default values. |
| L:\Documents\Efka Parameters - New 4 Digit\1337DLPAR.xls | | | | |
| Instructions for using Control Panel V820 | | | | |
| To Perform Master Reset of Parameters: | | | | |
| | | | | 1. Power on holding down the "P" button till "C-0000" is displayed. |
| | | | | 2. Enter the number "5913" |
| | | | | 3. Press "E" twice and "093" is displayed. |
| | | | | 4. Press "+" once, "094" is displayed. |
| | | | | 5. Press "P" to exit programming mode with all default values. |
| Programming Instructions: | | | | |
| | | | | 1. Power on holding down the "P" button till "COD" is displayed. |
| | | | | 2. Enter the number "5913" |
| | | | | 3. Press "E" once and "F200" is displayed this is a parameter |
| | | | | 4. Enter the parameter to be changed and press "E". |
| | | | | 5. The value now shows in the screen, adjust to desired value. |
| | | | | 6. Press "E" to enter value and press "P" to continue to next setting. |
| | | | | 7. Repeat for other parameters, press "P" once when complete. |
| | | | | 8. Run sewing head to save parameters before powering down |
| | * Singer 300W is "1" | | | |

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 por 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 cambiada o modificada y no está sujeto a cualquier otra garantía implicada por otro agente o distribuidor 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 período 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 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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