Model **1315-A-UM**

Rev 0 Created 03/20/2025(wr)

Technical Manual & Parts Lists

Atlanta Attachment Company

362 Industrial Park Drive

Lawrenceville, GA 30046

770-963-7369 • www.atlatt.com

ATLANTA ATTACHMENT COMPANY, INC.

Confidential and Proprietary Information

This equipment may be protected by one or more US and foreign patents.

For a complete list visit
atlatt.com/patents.php

IMPORTANT

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

Contents

Important Safety Instruction

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

Mandatory Information

All persons operating and/or working on the 1315-A-UM Auto Tape Edge Workstation should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include.

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

Intended Use

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

Exclusion of Misuse

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

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

Liability

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

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

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

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

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!

General Safety Equipment on 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.

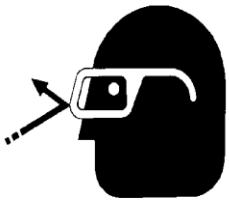
Faults or Errors

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.

General Safety Precautions

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

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

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

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

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

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

Specifications 1315-A-UM

Machine Features

- Tape edge machine
- Automatic processing system
- Design suitable for product lines
- Automatic speed synchronization
- Touch operated control panel
- Secure bed rolling system
- Work system which does not tire operator

Technical Specifications

Stitch head	Chain stitch
Stitching speed	Max. 3000 rpm.
Presser foot	Pneumatic
Control	PLC control, frequency inverters control panel
Speed control	Numerical over panel
Network	380 V 3 Phase 50 Hz.
Power	4 KW.
Motor	5x Asynchronous motor 1x Servo motor
Air pressure	6 Bars
Net Weight	
Machine	1404 Kg.
Inlet conveyor	262 Kg.
Outlet conveyor	264 Kg.
	(Aforementioned weights may vary).

ELECTRIC DANGER:
Machine power must be cut off primarily before opening machine electric switchboard, connection boxes on the machine, to connect and change cables. Any kind of electrical maintenance and repair must be carried out by trained technical staff.

PRESSURE DANGER:
Moving parts must be observed during adjustment, part replacement on stitching head. Otherwise permanent damage could arise.

MOVING PARTS WARNING:
Some parts of the machine are driven by servo motors may move intermittently. Such intermittent movements must be followed up carefully and they must not be interfered or touched without stopping machine.

USAGE WARNING:
Before using any part of the machine bearing usage warning, user manual related to these parts must be read and warnings and cautions must be taken into consideration.

ADJUSTMENT MAINTENANCE WARNING:
No adjustment, maintenance works involving risks must be carried out during the machine operation / works.

PROTECTION WARNING:
Machine must never be operated while protection covers, panel doors and guards are in place or in an open position.

- When part replacement is necessary due to failure or wearing, only those parts approved by the manufacturer must be used.
- General working system of the machine must never be modified. Otherwise acts might cause security and protections systems to fail. Remember the machine must fall within the scope of manufacturer guarantee automatically in such case.
- Keys of electric switchboard doors must be made available only to maintenance and repair staff.
- When the machine is stopped for the purpose of failure or maintenance, necessary warnings signs must be suspended on the machine and electric switchboard, general power switch and air inlet valve must be locked whenever it is necessary.
- In the event that the machine fails, it is recommended to request support from manufacturer prior to any initial work to prevent additional failure.

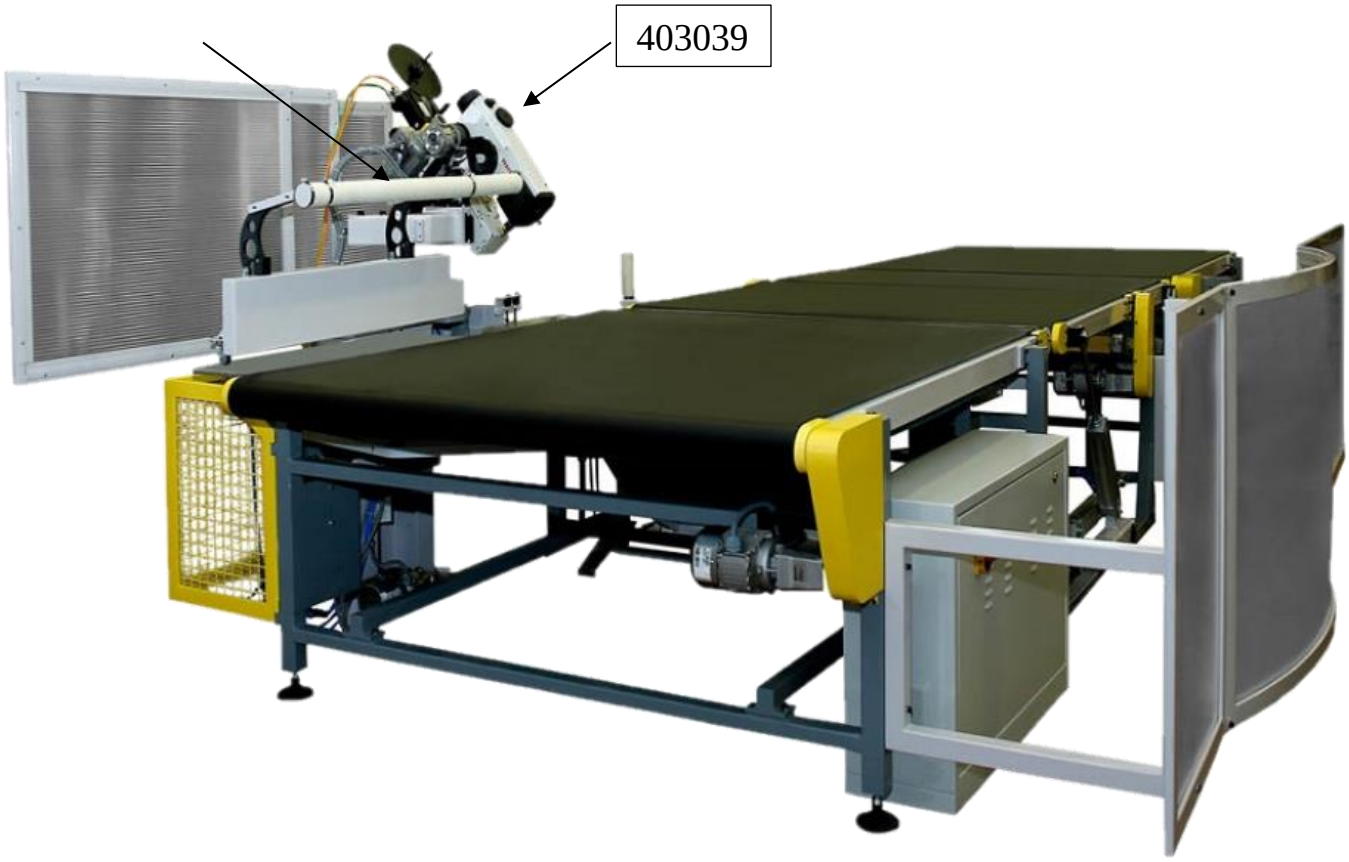
Transport and Storage 1315-A-UM

1315-A-Um automatic tape edge machine is shipped in two wooden crates as shown.

After factory disassembly, machine parts are covered by stretch film after lubricating with protective oil to prevent corrosion during shipment. Dehumidifier substances are used to prevent oxidation in electric switchboard.

- Wooden crates must be moved or loaded by forklift paying close attention to center of gravity.
- Crates must not be approached more than safe distance during forklift operation.
- Manufacturer company must be informed immediately of all events causing damage such as drop or breakage during transportation and instructions must be followed.
- During long term storage or transport, crates must be in enclosed areas which do not expose natural conditions and crates must be stored as closed and sealed on all sides.

Introduction of the Machine 1315-A-UM



Automatic tape edge machine is utilized to sew the external or edging tape around the parameter of the bed to seal the internal materials within the bed. This is normally the final operating in completing the construction of the bed during production.

In comparison to manual tape-edge / closing operation the Automatic tape-edge machine excels in ease of use, speed and operator fatigue is greatly reduced. The operator stands in one position and the bed rotates and is automatically moved/fed to the sewing head, which does not require continuous manual muscle force and less skilled experience. It is composed of following main parts:

- Operation
- Inlet conveyor
- Tumbling conveyor
- Stitch head body
- Stitch conveyor
- Outlet conveyor
- Protection panels

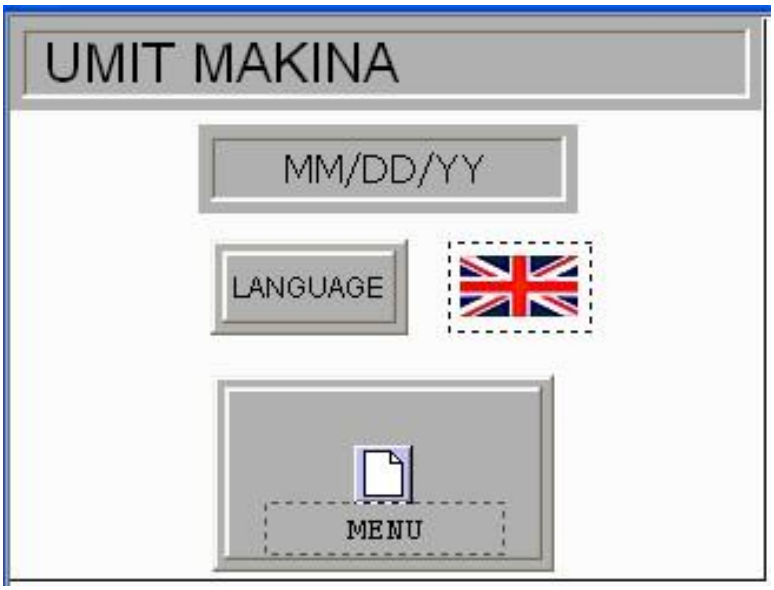
Operation

Control Panel

Operation of Control Panel **Earlier Software Release**

Start Page:

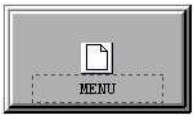
This is the page displayed when the operator starts the machine.



Symbol: Set Current Date

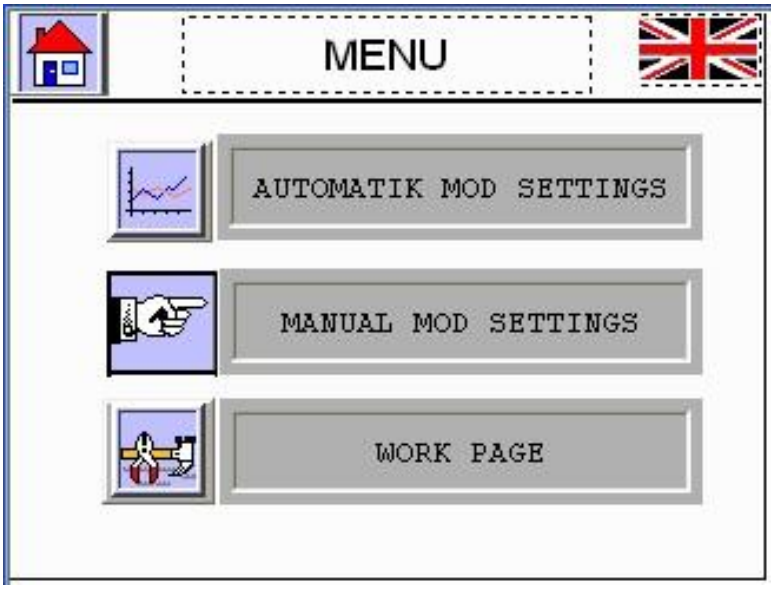
Symbol: Choose language for display.

Symbol: Switch between pages to be used for all settings related to the operation of the machine.



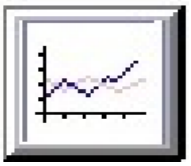
Main Menu:

Access to reach all setting and control parameters related to the machine.



Symbol: Enables to enter "homepage" seen when the machine starts.

Symbol: Used to switch speed settings pages related to automatic working. The machine switches to automatic mode when this page is switched to.

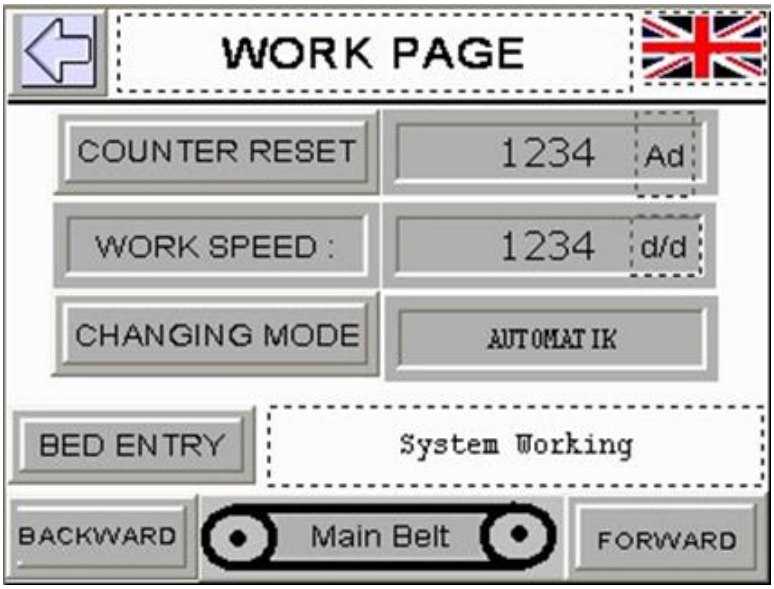


Symbol: Used to switch speed settings pages related to manual operation and settings related to said operation.

Symbol: Used to switch to the page to observe and interfere instant data related to speed and mode adjustment and number of beds stitched.

Work Page:

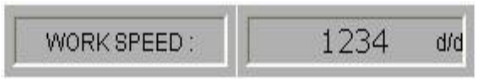
This is main window used during bed stitching process



Symbol: . Return to Main Menu or go back.

Symbol: Used to switch to the page "Main Menu". It is used to reset number of beds stitched counted in right window.

Symbol: It displays automatic stitching speed of the machine.



Symbol: Used to see and change operation mode of the machine.

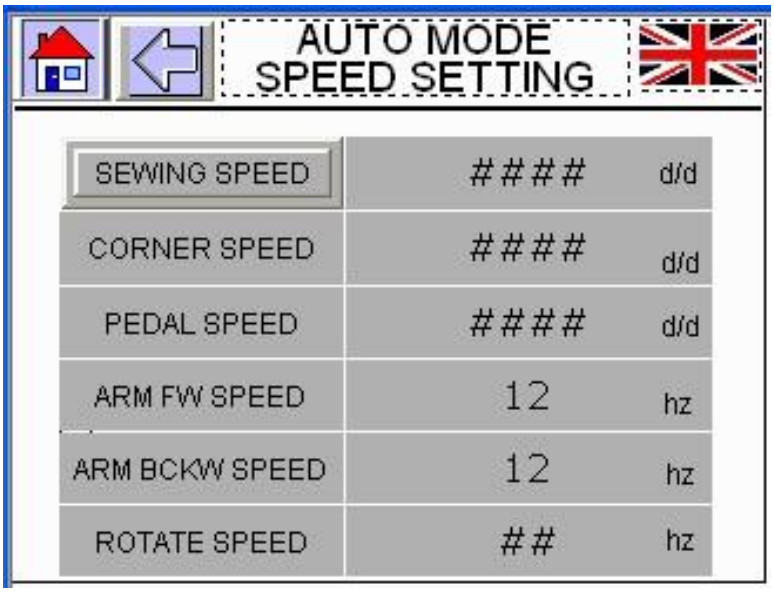
Symbol: Used to carry the bed located on the inlet conveyor automatically towards stitching head level.

Symbol: Used to interfere manually in forward or backward direction when required regardless of Main Conveyor operation mode.

Symbol: It is the message line giving data related to the operation of the machine.

Auto Speed Setting Page:

Access to all speed setting parameters utilized during automatic operation mode of the machine.



Symbol: . It is the parameter related to the maximum stitching speed of the machine.

- When the speed value written here is touched, new values are entered using keyboard displayed on the screen and "Enter" key is pushed.

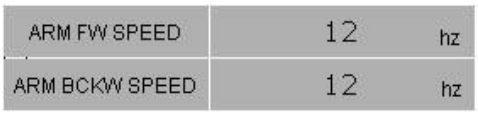
Symbol: It is the parameter related to stitching speed in the corners.

- While stitching around the corner of the bed, speeds of main conveyor and stitching head are adjusted automatically according to the values written here.

Symbol: When the operator desires to instantly slow down the machine's operation speed, he uses slowing foot switch.

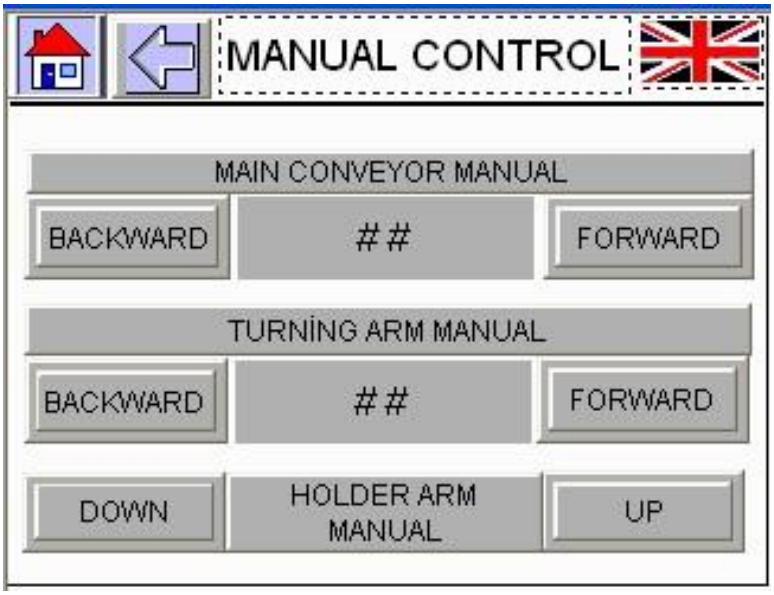
- It is the parameter adjusting stitching speed to be available when this switch is pressed.

Symbol: When stitching one edge of the bed is completed, rotation handle uses forward, and backward speed data entered in these windows to turn other edge of the bed.



Manual Control Page 1:

Access to controls that will manually operate machine functions



Symbol: . Return to Main Menu, Next Pages, or go back.

Symbol: Used to move forward or backward the main conveyor manually.

- Manual movement speed is entered on the window located between "forward" and "backward" buttons.

Symbol: Used to move forward or backward the rotation handle manually.

- Manual rotation speed is entered on the window located between "forward" and "backward" buttons.

Symbol: Used to move upward, or downward holding handle manually located on the rotating handle.

Manual Control Page 2:

This second page is used for the machine move manually.

Tumbling Conveyor

These buttons are used to ensure 1st stage of up and down movement of tumbling conveyor manually.

These buttons are used to ensure 2nd stage of up and down movement of tumbling conveyor manually.

These buttons are used to provide manual movement of reclining sheet located in the ground of tumbling conveyor.

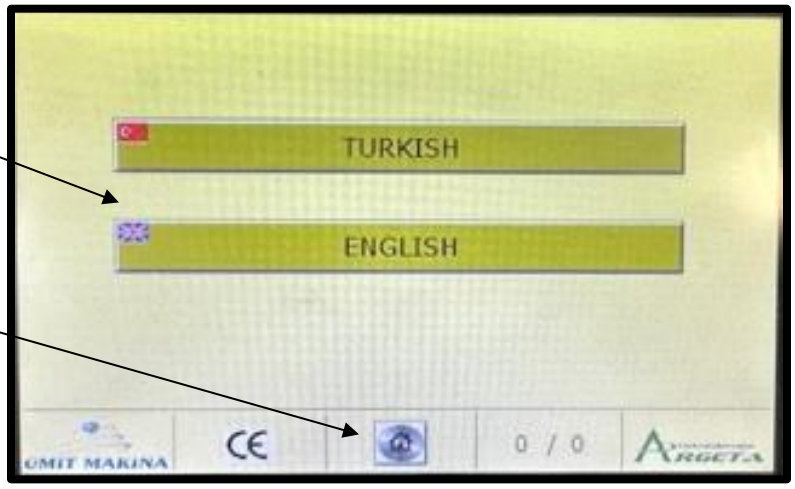
These buttons are used to ensure forward and backward movement of cylinder block located in the exit of tumbling conveyor.

Operation of Control Panel **Revised Software 2024 Release**

Language Page:

Language Option

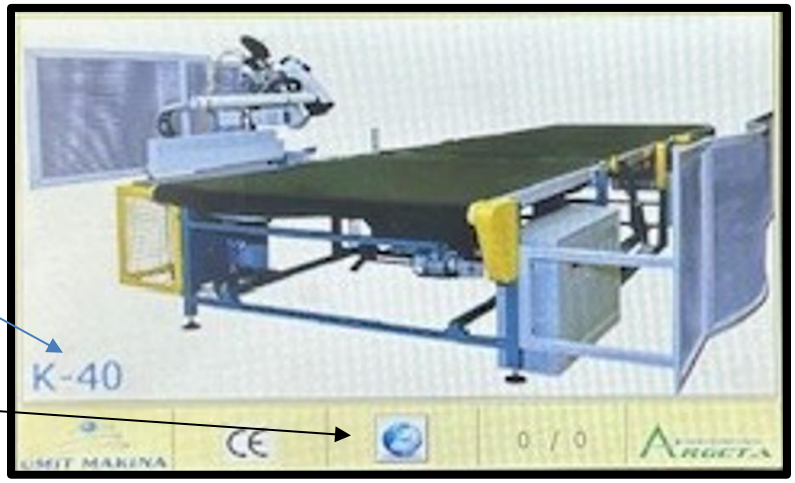
Push Button to access in center bottom of page to move forward to next page



Start Page:

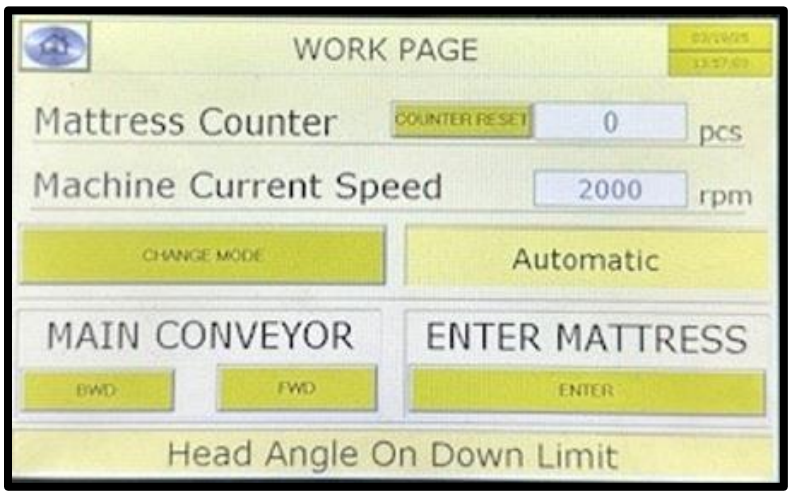
Push "**K-40**" symbol to move forward to Work page

Push "**Globe**" symbol to go back to previous page.

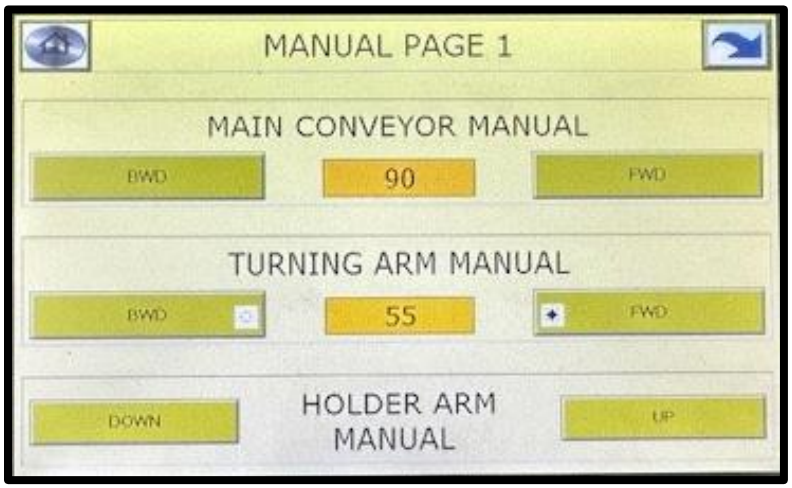


Main Menu:

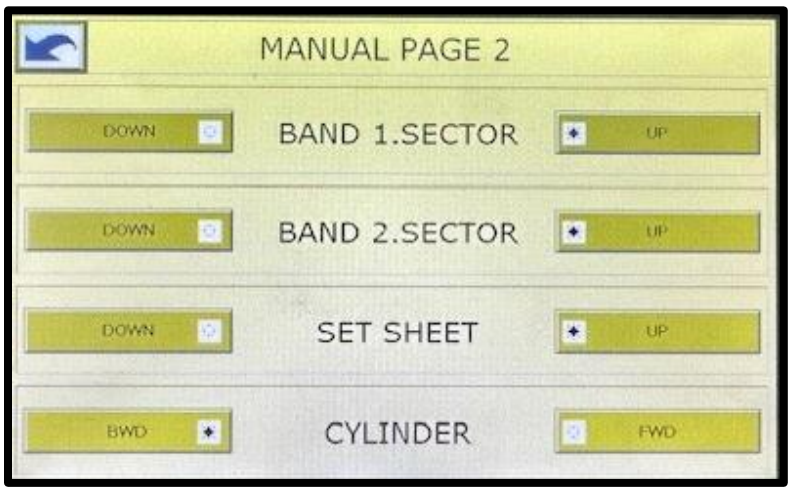
Work Page:



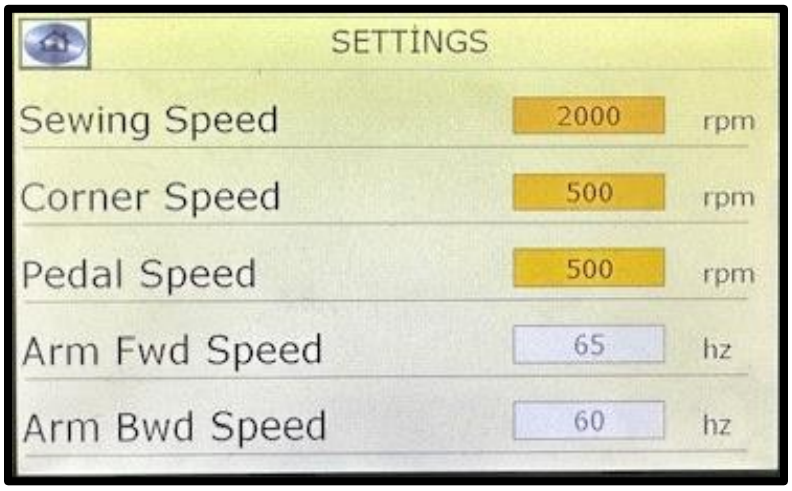
Manual Control Page 1:



Manual Control Page 2:



Settings Page:



Inlet Conveyor

This is the conveyor located in the machine inlet ensuring the bed comes in front of the operator whenever he desires or from production line (or brought manually). It ensures the bed comes to a certain point and waits until the operator calls the bed for stitching. It is controlled by the machine. When it is used on production lines, bed transfer from the line is carried out over this conveyor.

Tumbling Conveyor

After and if stitching operations are to be carried out on both faces of the bed on tape edge machine, the bed must be turned upside down during the process. Bed weights are higher than most operators capability or capacity for some types and sizes.

Our tumbling conveyor is designed to turn over such a load safely and without wearing out, it protects the machine from damage as well since it does not lift the bed up during turn over. The tumbling conveyor is composed of a two-stage conveyor and the turnover cylinder is located in between inlet conveyor and stitching conveyor.

Before the bed is turned over after completing stitching on first side, tumbling conveyor waits in two levels below. The bed returned from stitching conveyor is tumbled downwards after center of gravity goes down.

Meanwhile tumbling conveyor moves the bed forward and leans the bed towards reclining shelf.

Thus the bed is erected on the conveyor. When the sensor located on the reclining shelf, senses the leaning bed, reclining shelf rises.

Dropping cylinder located between tumbling conveyor and stitching conveyor lowers the bed on the tumbling conveyor tumbles the bed on the tumbling conveyor with pneumatic cylinder as shown in the figure.

Tumbling conveyor rises to the first level together with the bed located thereon whilst dropping cylinder returns to original position. Tumbling conveyor continues to rise up to second level pulling away at certain points to not cause pressing of the bed.

When the conveyor reaches top level, reclining shelf returns to original position and tumbling operation is completed.

Stitch Head Body

This part ensures stitch head is in correct position while stitching bed edge.
There are two extremely important settings to change position quickly for different types of beds.

Lift (height) adjustment:
This is a screw system adjusting the distance of stitching head to stitching conveyor by the thickness of the bed. It is controlled by the foot switches located in front of the operator. Two-foot switches located in the left moves the lift up and down. The foot switches are used not to occupy hands of the operator.

Movements of the lift are limited by top and bottom limit sensors for safety purposes.

Start- stop switch ensures to start and stop the machine in automatic mode. If the second speed switch is pressed during operation, machine switches to second speed as long as the switch is pressed.

Head Angle Adjustment:

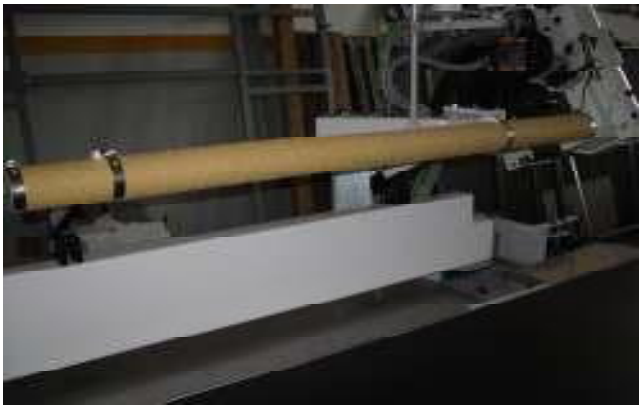
Head angle adjustment is carried out by a rachet key located on the control board. Two limit sensors are located to ensure safety during this adjustment. Limit sensors of the machine must never be decativated.

An additional sensor is used in head Angle safety system. This sensor is Used for lower limit control which Controls head angle depending on Lift height

A Servo Motor is used as the stitch head driving engine in order to allow the machine to be used efficiently and without down time, the needle must be positioned up when the machine stops. This is provided by a sensor located in head table.

Position of the sensor reading motor coupling must be checked while the coupling is dismounted and mounted.

Rotating handle is another important part located on stitching head body. It is designed to rotate the bed ninety degrees in the center of stitching needle



In order to ensure stitching continues in the corners without interruption, and in addition to synchronous movement of the stitching head and stitching band, rotating handle must move appropriate to this synchronization. Furthermore, the stitch must be made at lower speed in order to prevent the operator loss of control.

All these circumstances forms the stitching specifications of the machine.

Stitch Conveyor

Stitching conveyor is composed of a handle and rotating mechanism thereon. Rotating area is limited by two limit sensors. Motor transmits the movement to lower rotating handle by a timing belt.

If connection of upper and lower rotating handle slip for any reason (seizure of the bed, handle etc.,) during operation; Lower rotating handle is put in stitching position and conical tightening clips are loosen which is located in the center of lower handle. Conical clips is re-
tightened upper rotating handle is put into correct position.

In order for the bed not to disjoint from the handle, there is a group of handles pressing the bed. This group located on the rotating handle is moved by pneumatic cylinders. Pressing force of the handle is adjusted by air regulator located next to the machine air inlet (approximately 2 bars).

Furthermore, whenever the thickness of the bed changes, its distance to rotating handle must be adjusted, when the bed get thinner pressing handle must be pulled away from the rotating handle. This adjustment is carried out by loosening tightening rods on the handle.

Outlet Conveyor

The conveyor on which the bed is put after stitching is completed. The bed coming towards the last point of this conveyor waits here to be taken. If the machine operates on bed production line, it expects the line to request the bed. (Communication line of the bed line must be connected). It has the same structure as the inlet conveyor.

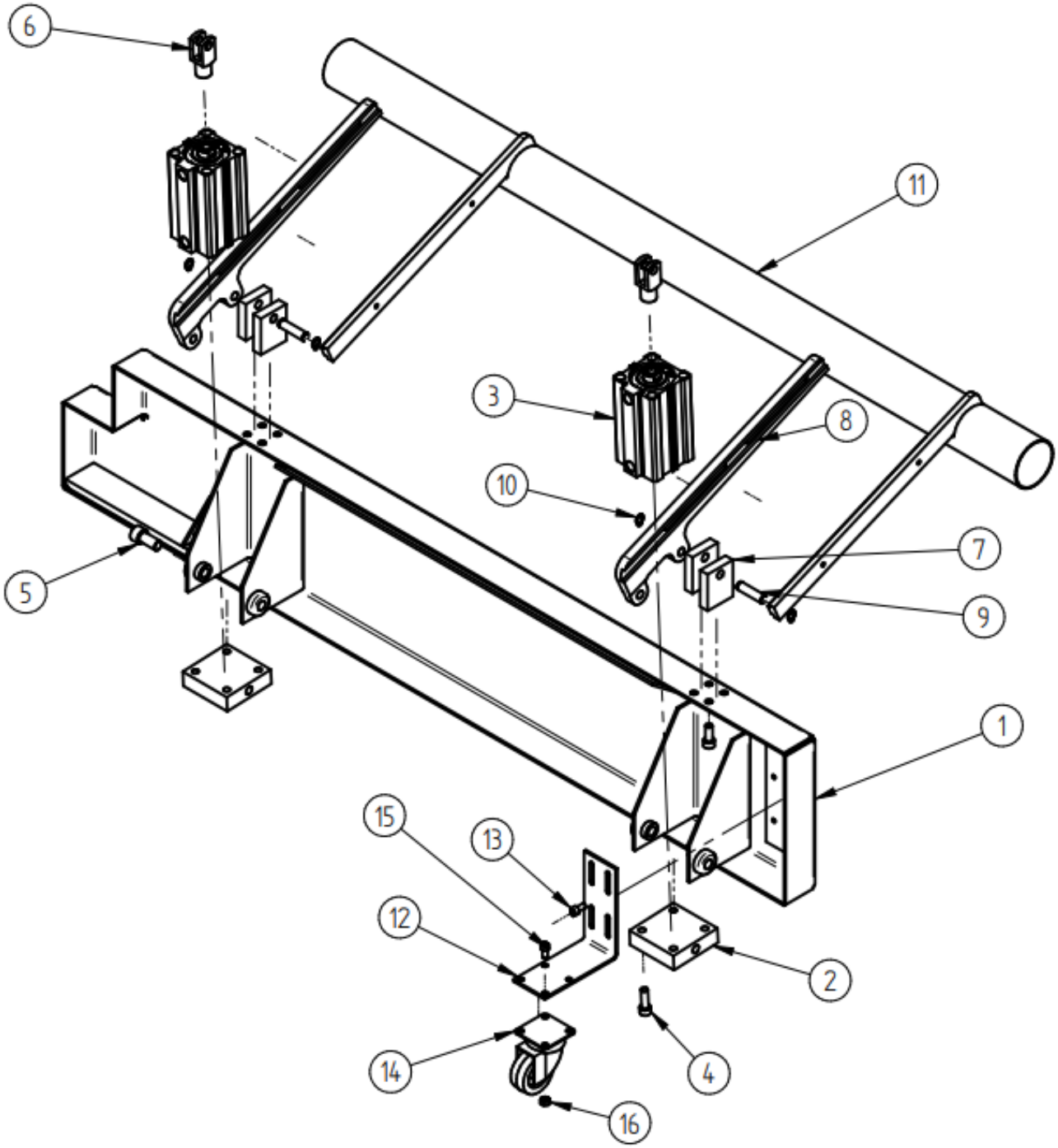
Protection Panels

The machine is surrounded by protection panels by its operating system. Bed inlet and outlet must be open. Warnings and signs must be observed at these points and protection panels must never be dismounted.

Assembly Drawings & Parts Lists

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

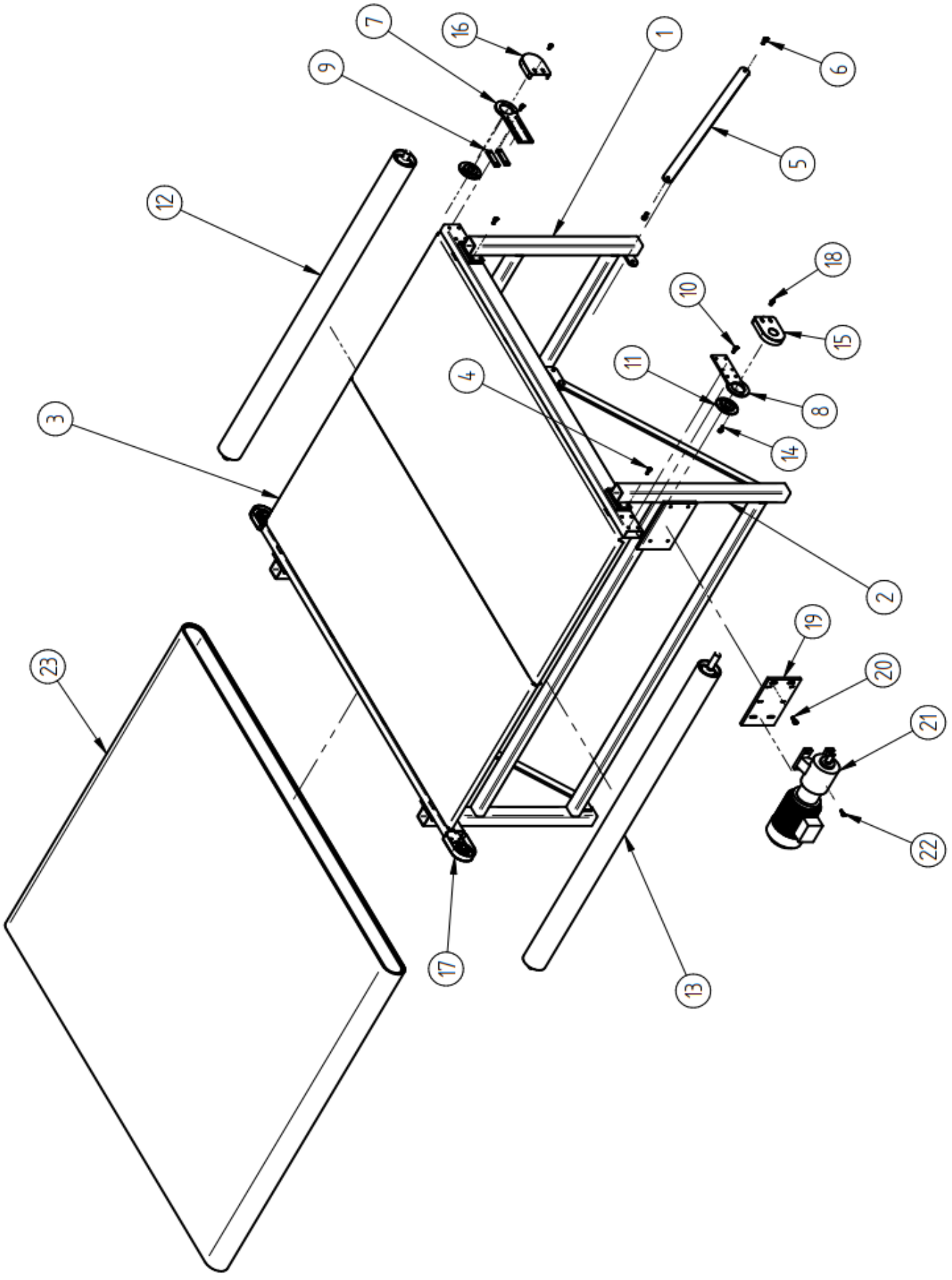
403006 Assembly



403006 parts list

No	Code	Qty
1	400723	1
2	G1425	2
3	ECDQ2B50-75D	2
4	BOLT M8 X 25	4
5	BOLT M12 X 25	2
6	G1430	2
7	G1437	4
8	G1438	2
9	K1461	2
10	CIRCLIPS 10 X 1	4
11	400739	1
12	G1449	1
13	BOLT M6 X 12	4
14	WHEEL	1
15	BOLT M6 X 12	4
16	NUT M6	4

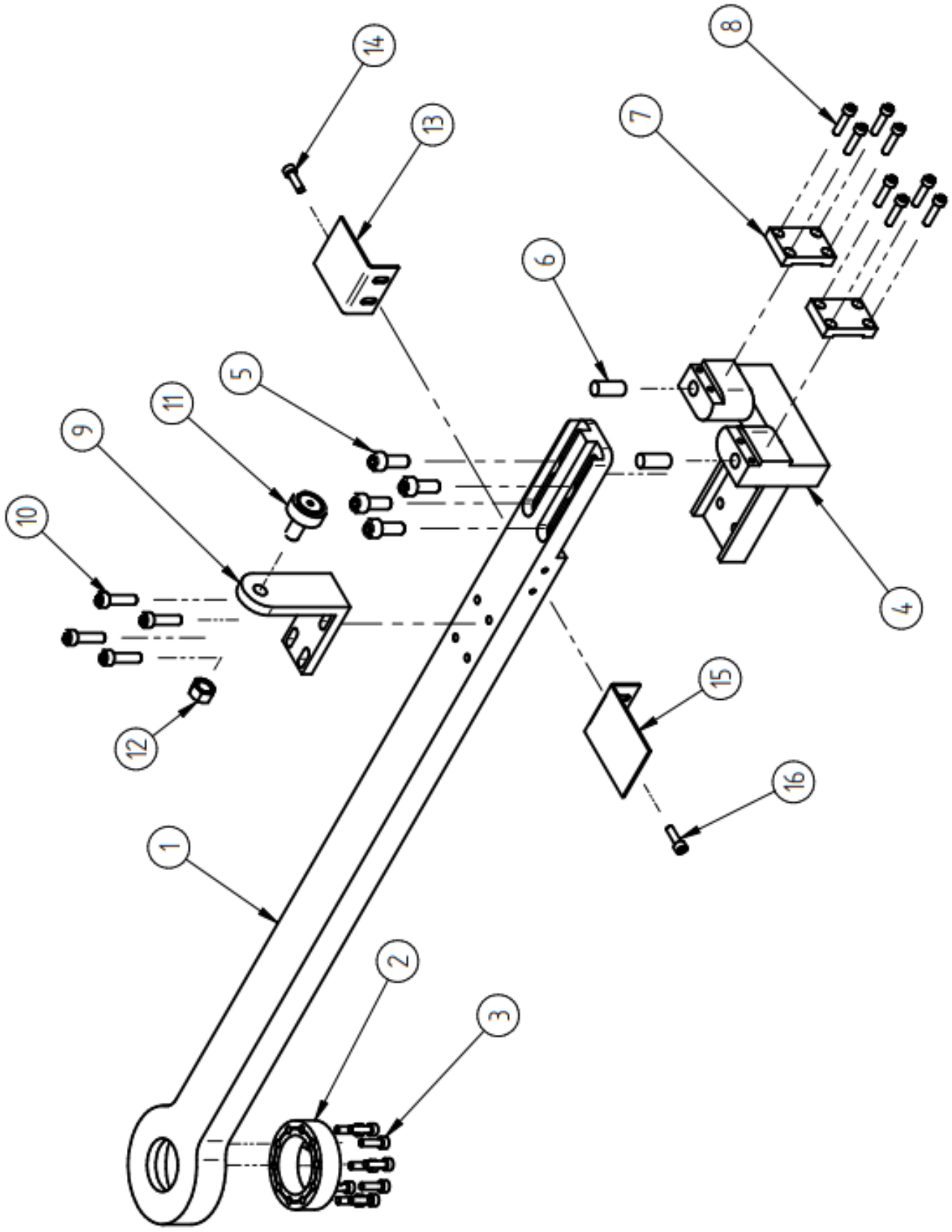
403026 Conveyor Assembly



403026 parts list

No	Code	Qty
1	400745	1
2	400744	1
3	400743	1
4	BOLT M8 X 20	16
5	P1464	4
6	BOLT M10 X 20	8
7	P1406	2
8	P1430	2
9	P1472	4
10	BOLT M8 X 20	16
11	BPF5	4
12	401492	1
13	401493	1
14	BOLT M8 X 20	12
15	400750	1
16	400749	2
17	400757	1
18	BOLT M8 X 12	8
19	P1469	1
20	BOLT M10 X 20	4
21	PRC42	1
22	BOLT M8 X 20	4
23	BELT	1

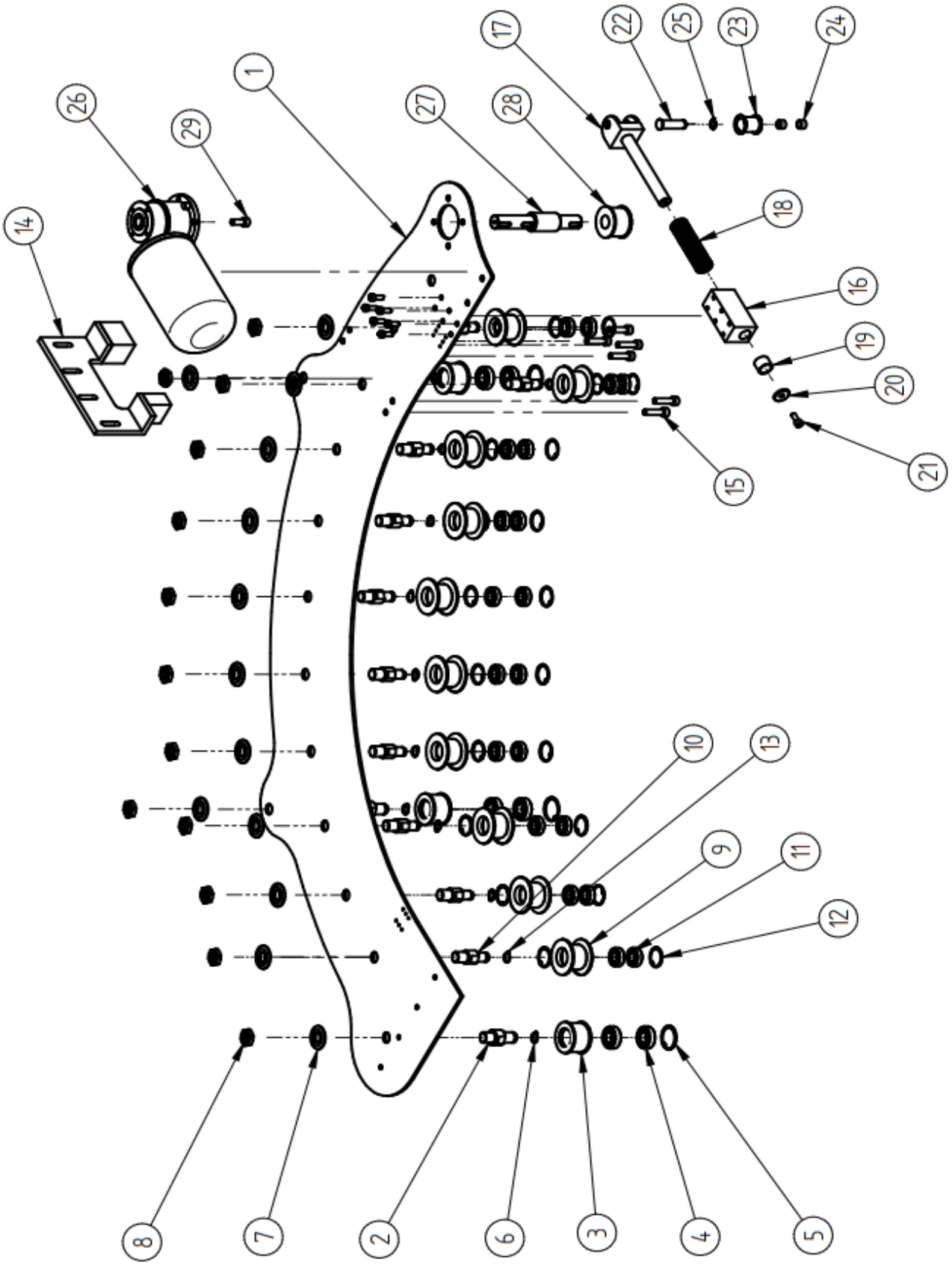
403028 Assembly



403028 parts list

No	Code	Qty
1	R1434	1
2	CLAMP 75 X 50 X 20	1
3	BOLT M6 X 20	10
4	P1473	1
5	BOLT M10 X 25	4
6	R1435	2
7	P1433	2
8	BOLT M6 X 25	8
9	R1439	1
10	BOLT M8 X 30	4
11	KR32	1
12	NUT M12	1
13	G1478	1
14	BOLT M6 X 20	2
15	G1499	1
16	BOLT M6 X 20	2

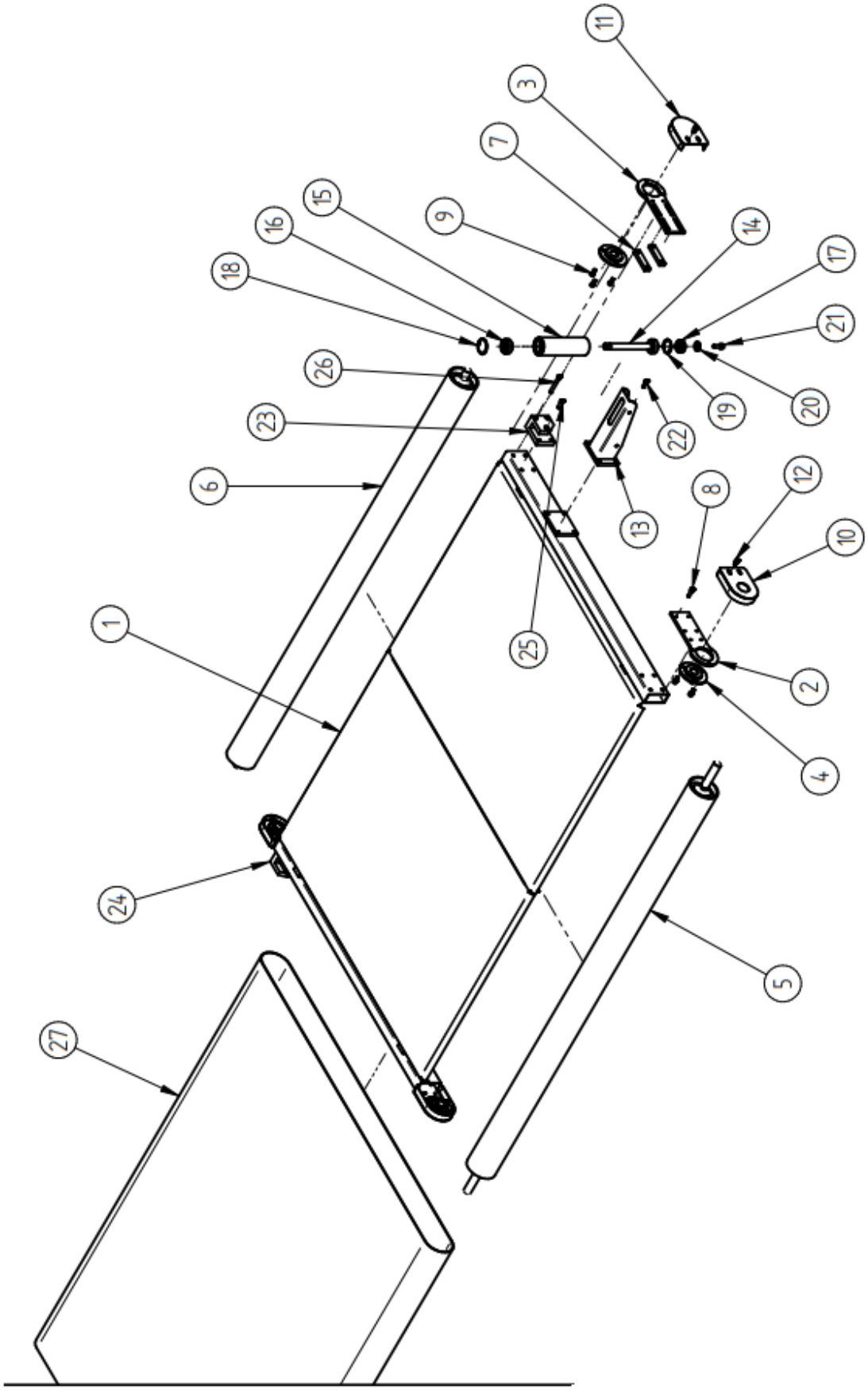
403029 Assembly



403029 parts list

No	Code	Qty
1	P1476	1
2	R1420	3
3	R1419	3
4	BEARING 6004	6
5	CIRCLIPS 42 X 1.75	3
6	CIRCLIPS 20 X 1.2	3
7	P1498	13
8	P1482	13
9	R1418	10
10	R1410	10
11	BEARING 6003	20
12	CIRCLIPS 35 X 1.5	20
13	CIRCLIPS 17 X 1	10
14	401495	1
15	BOLT M10 X 40	6
16	R1415	1
17	R1413	1
18	Y1138	1
19	R1510	1
20	R1511	1
21	BOLT M8 X 20	1
22	R1411	1
23	P1463	1
24	BEARING HK1612	2
25	CIRCLIPS 16 X 1	1
26	SC36	1
27	R1474	1
28	HTD8M-22L	1
29	BOLT M10 X 25	4

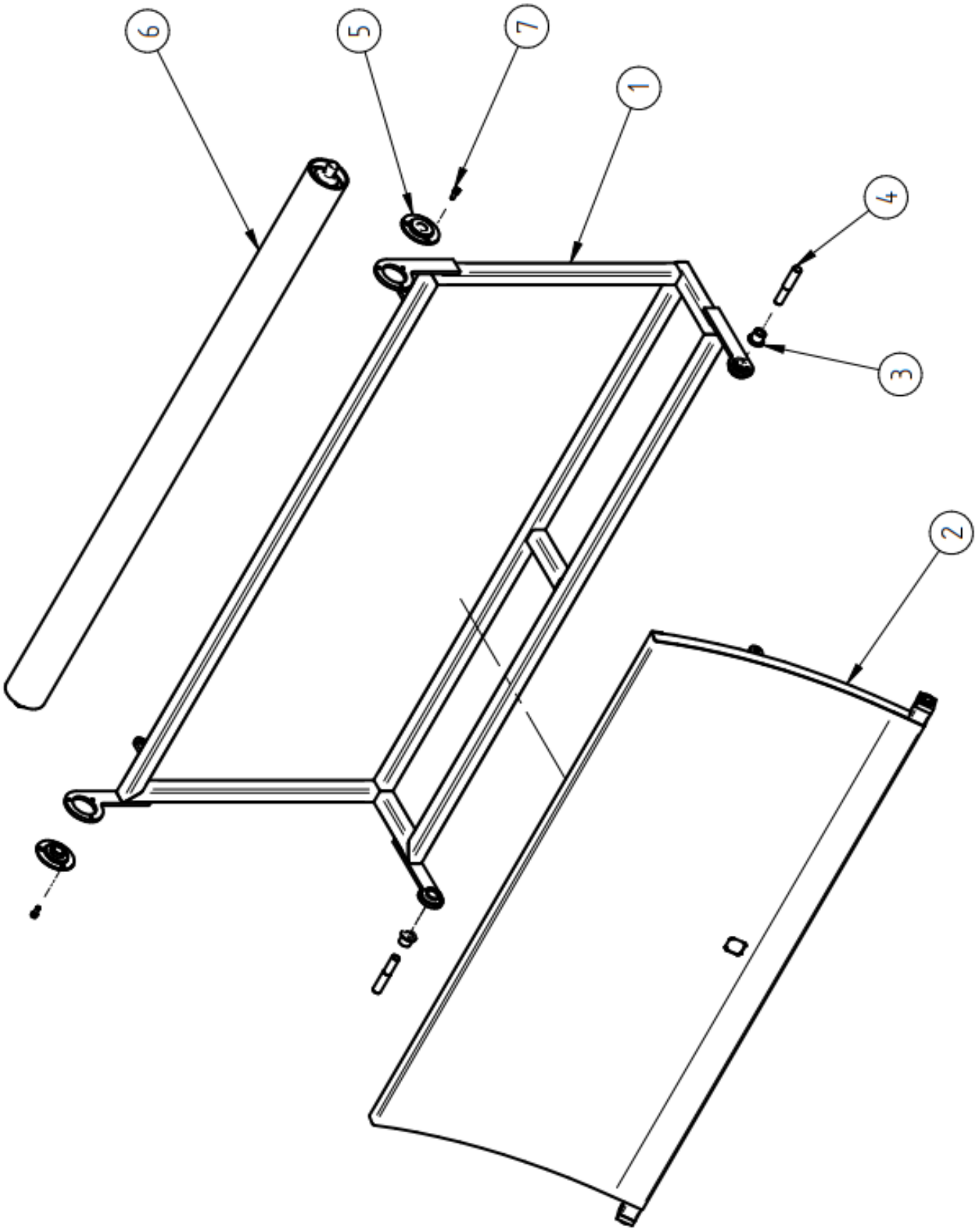
403030 Assembly



403030 parts list

No	Code	Qty
1	401499	1
2	P1430	2
3	P1406	2
4	BPF5	4
5	401462	1
6	401492	1
7	P1472	2
8	BOLT M8 X 25	16
9	BOLT M8 X 16	12
10	400750	2
11	400749	2
12	BOLT M8 X 12	8
13	401466	1
14	K1475	1
15	K1474	1
16	BEARING 6204	1
17	BEARING 6203	1
18	CIRCLIPS 47 X 1.75	1
19	CIRCLIPS 40 X 1.75	1
20	K1489	1
21	BOLT M10 X 25	1
22	BOLT M8 X 20	4
23	P1432	1
24	P1455	1
25	BOLT M8 X 25	4
26	BOLT M8 X 65	4
27	BELT	1

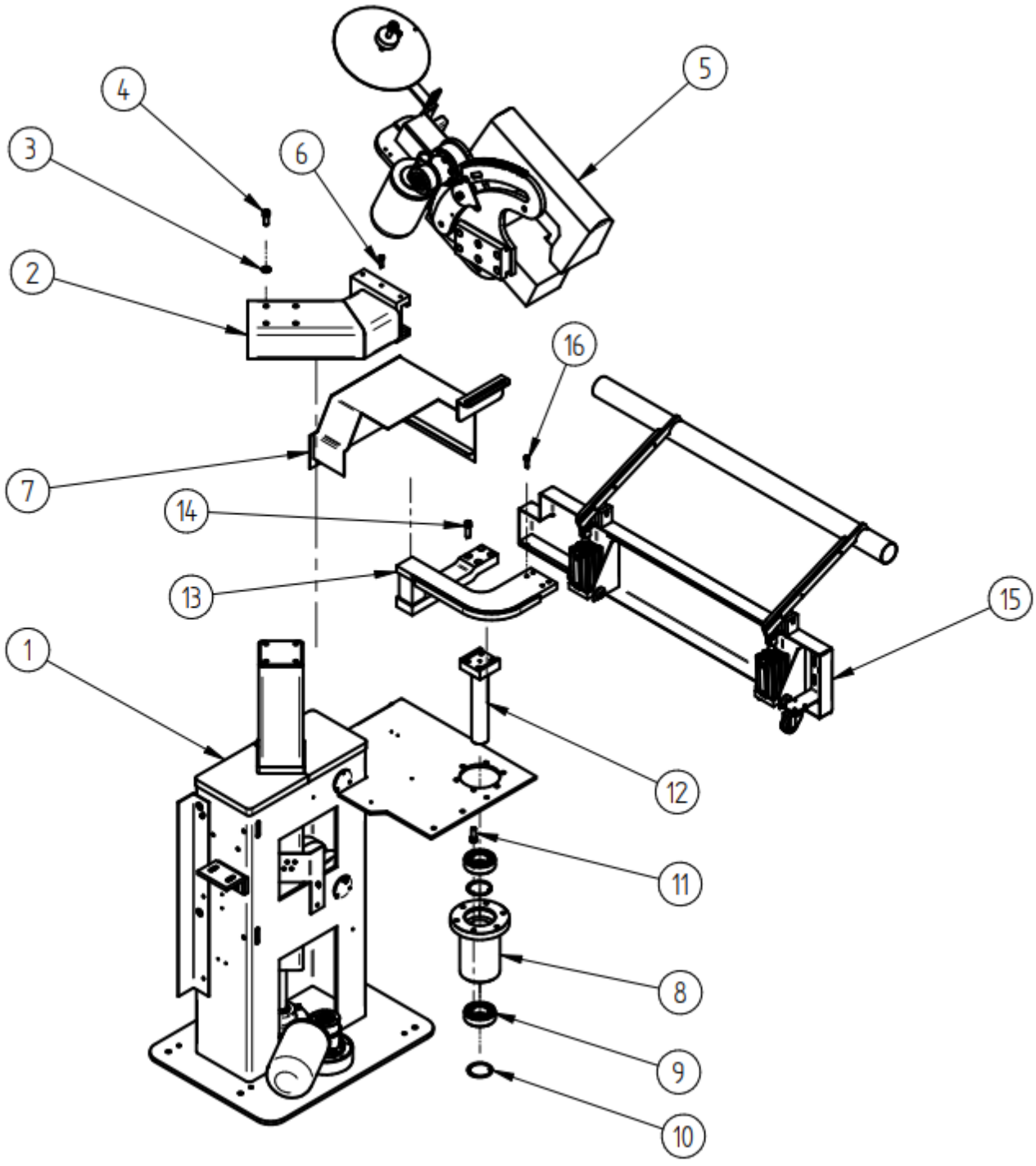
403033 Tumbling-Bed Flip Assembly



403033 parts list

No	Code	Qty
1	401488	1
2	401494	1
3	P1461	2
4	P1462	2
5	BPF5	2
6	401483	1
7	BOLT M8 X 20	6

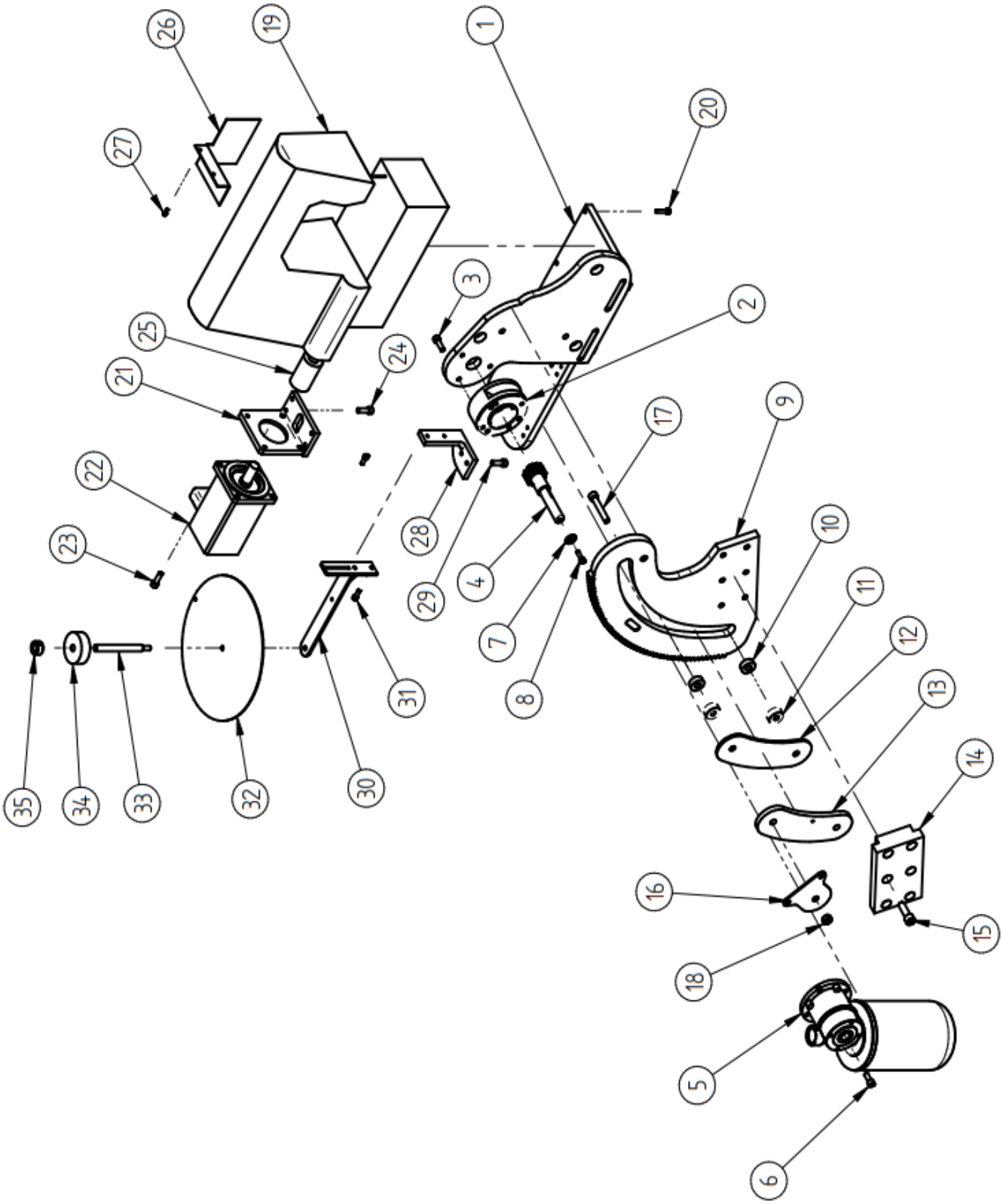
403039 Sewing Head and Tower Assembly



403039 parts list

No	Code	Qty
1	403016	1
2	400718	1
3	WASHER Ø12	4
4	BOLT M12 X 30	4
5	403040	1
6	BOLT M8 X 25	3
7	400758	1
8	P1485	1
9	CIRCLIPS 62209	2
10	CIRCLIPS 85 X 3	2
11	BOLT M12 X 30	6
12	P1486	1
13	400707	1
14	BOLT M12 X 35	4
15	403006	1
16	BOLT M8 X 25	4

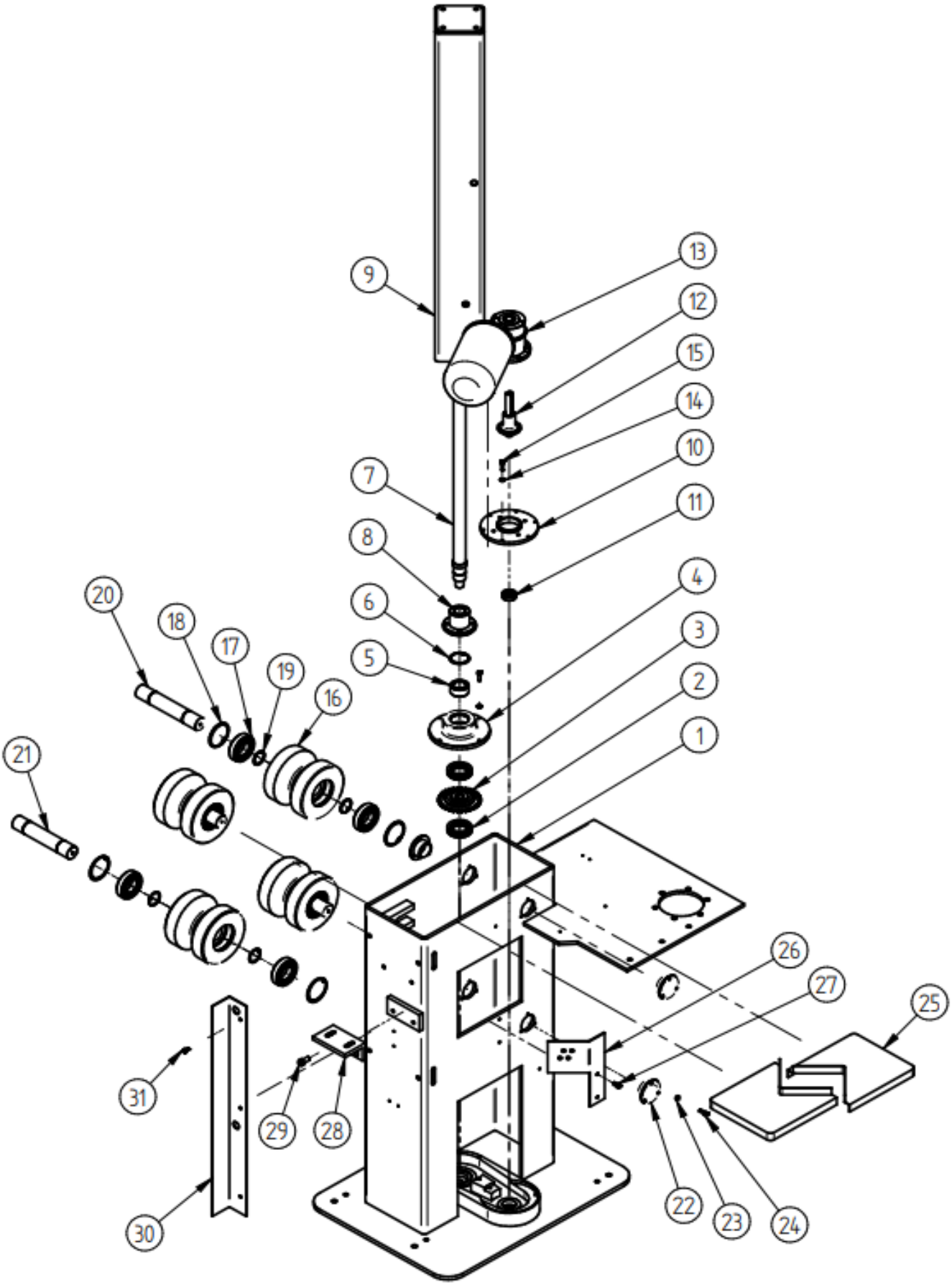
403040 Exploded Sewing Head Assembly



403040 parts list

No	Code	Qty
1	400708	1
2	G1443	1
3	BOLT M8 X 25	3
4	G1446	1
5	SC36	1
6	BOLT M8 X 20	4
7	K1451	1
8	BOLT M6 X 20	1
9	G1447	1
10	G1442	2
11	BEARING NATR 10	2
12	G1453	1
13	G1452	1
14	G1435	1
15	BOLT M12 X 35	6
16	G1463	1
17	BOLT M10 X 60	2
18	NUT M10	2
19	SEWING HEAD	1
20	BOLT M6 X 25	4
21	G1429	1
22	SMB82	1
23	BOLT M8 X 25	4
24	BOLT M8 X 25	4
25	COUPLING	1
26	G1481	1
27	BOLT M4 X 10	2
28	G1466	1
29	BOLT M8 X 25	2
30	400703	1
31	BOLT M6 X 16	2
32	K1480	1
33	K1483	1
34	K1481	1
35	K1482	1

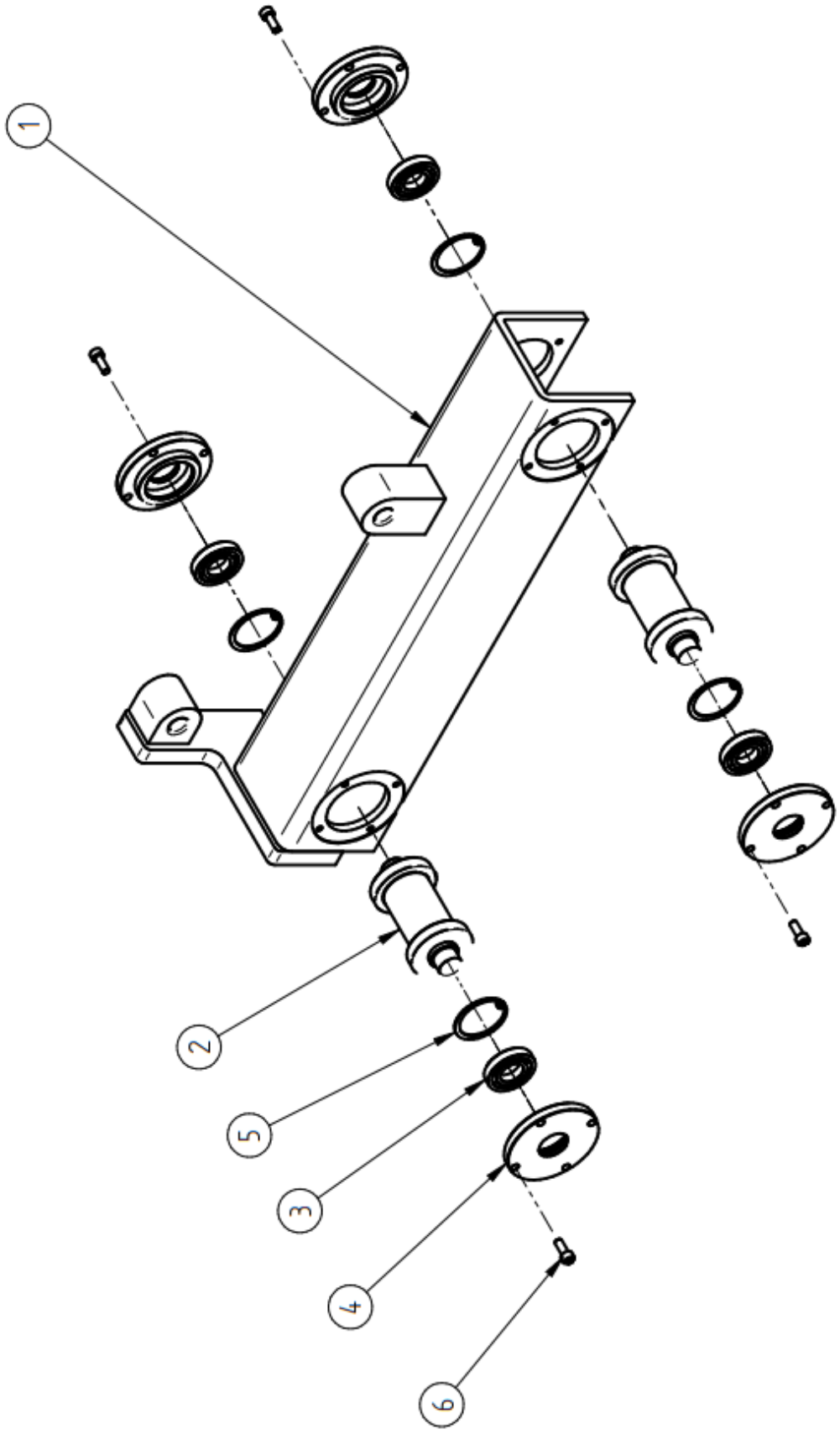
403016 Exploded Tower Assembly



403016 parts list

No	Code	Qty
1	400719	1
2	BEARING 51108	2
3	F1402	1
4	F1405	1
5	BEARING NKI 30-20	1
6	CIRCLIPS 45 X 1.75	1
7	G1416	1
8	G1417	1
9	400706	1
10	F1403	1
11	BEARING 6003	1
12	F1401	1
13	SC36	1
14	WASHER Ø6	4
15	BOLT M6 X 20	4
16	G1403	4
17	BEARING 6207	8
18	CIRCLIPS 72 X 2.5	8
19	CIRCLIPS 35 X 1.5	8
20	G1404	2
21	G1423	2
22	G1412	4
23	WASHER Ø6	12
24	BOLT M6 X 16	12
25	G1427	2
26	K1457	1
27	BOLT M6 X 12	2
28	F1408	1
29	BOLT M10 X 20	2
30	R1445	1
31	BOLT M6 X 10	3

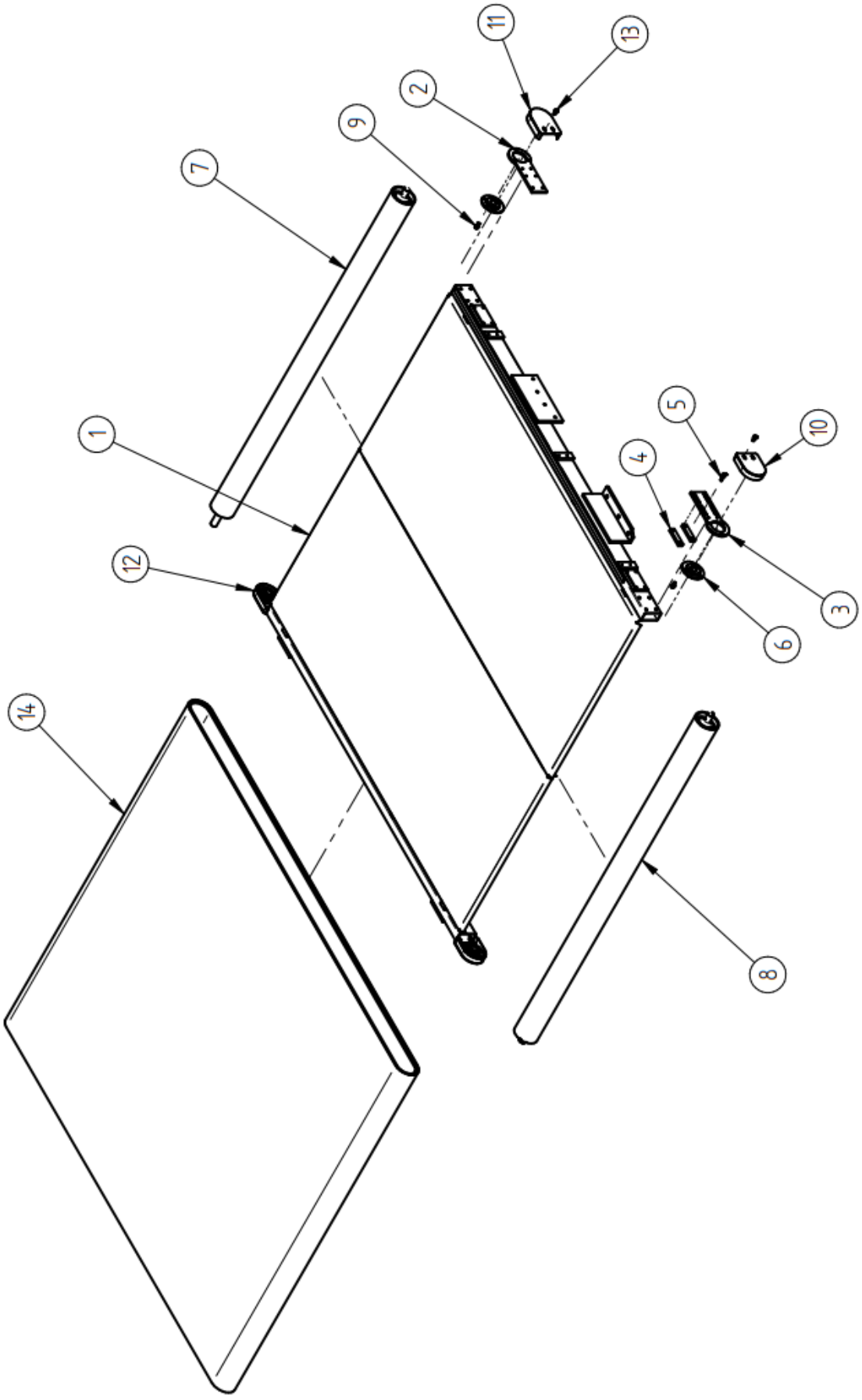
403042 Assembly



403042 parts list

No	Code	Qty
1	401486	1
2	P1435	2
3	BEARING 16004	4
4	P1442	4
5	CIRCLIPS 42 X 1.75	4
6	BOLT M6 X 16	16

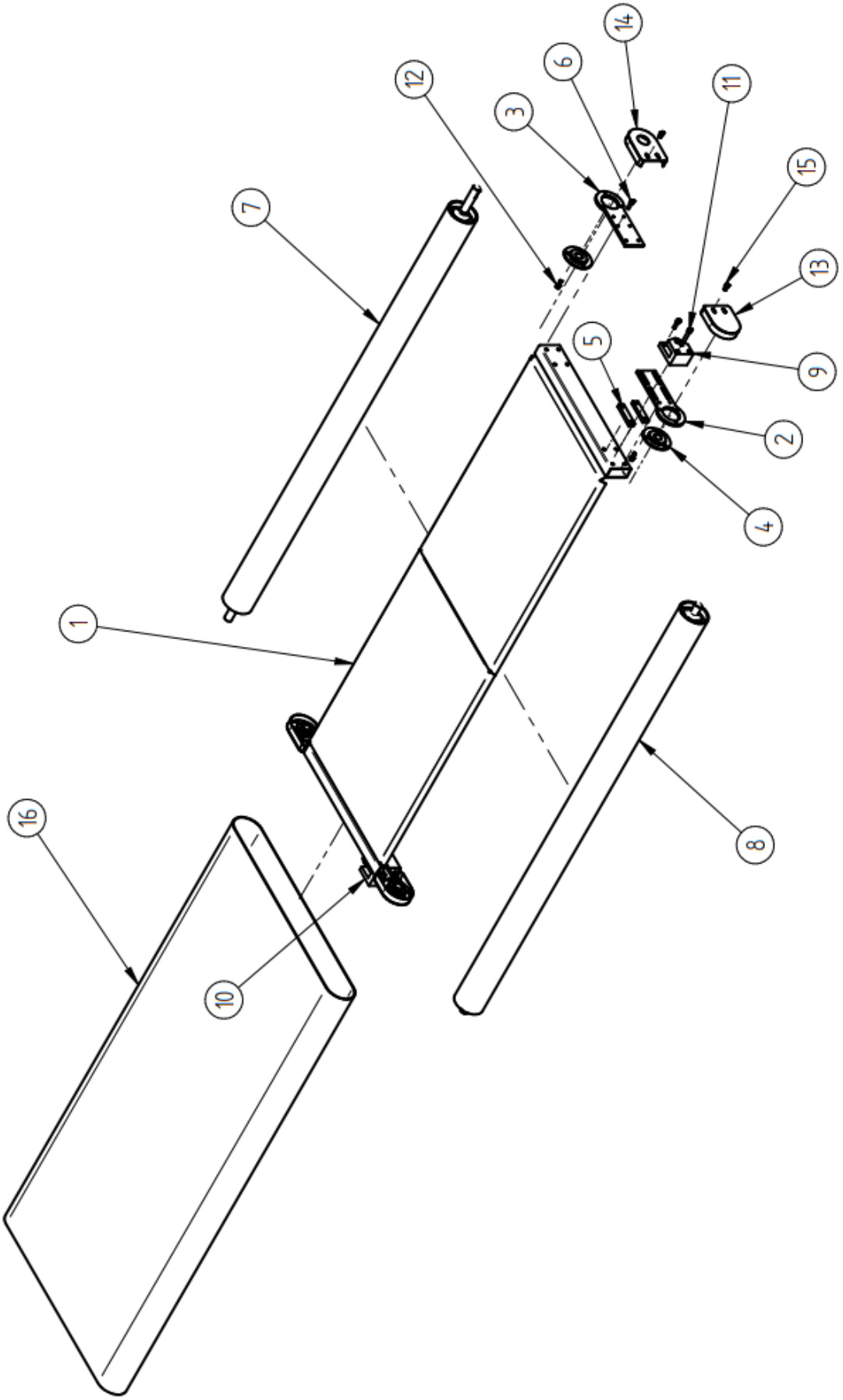
403044 Conveyor Assembly



403044 parts list

No	Code	Qty
1	401498	1
2	P1430	2
3	P1406	2
4	P1472	4
5	BOLT M8 X 25	16
6	BPF5	4
7	401493	1
8	401492	1
9	BOLT M8 X 16	12
10	400749	2
11	400757	1
12	400750	1
13	BOLT M8 X 12	8
14	BELT	1

403045 Conveyor Assembly

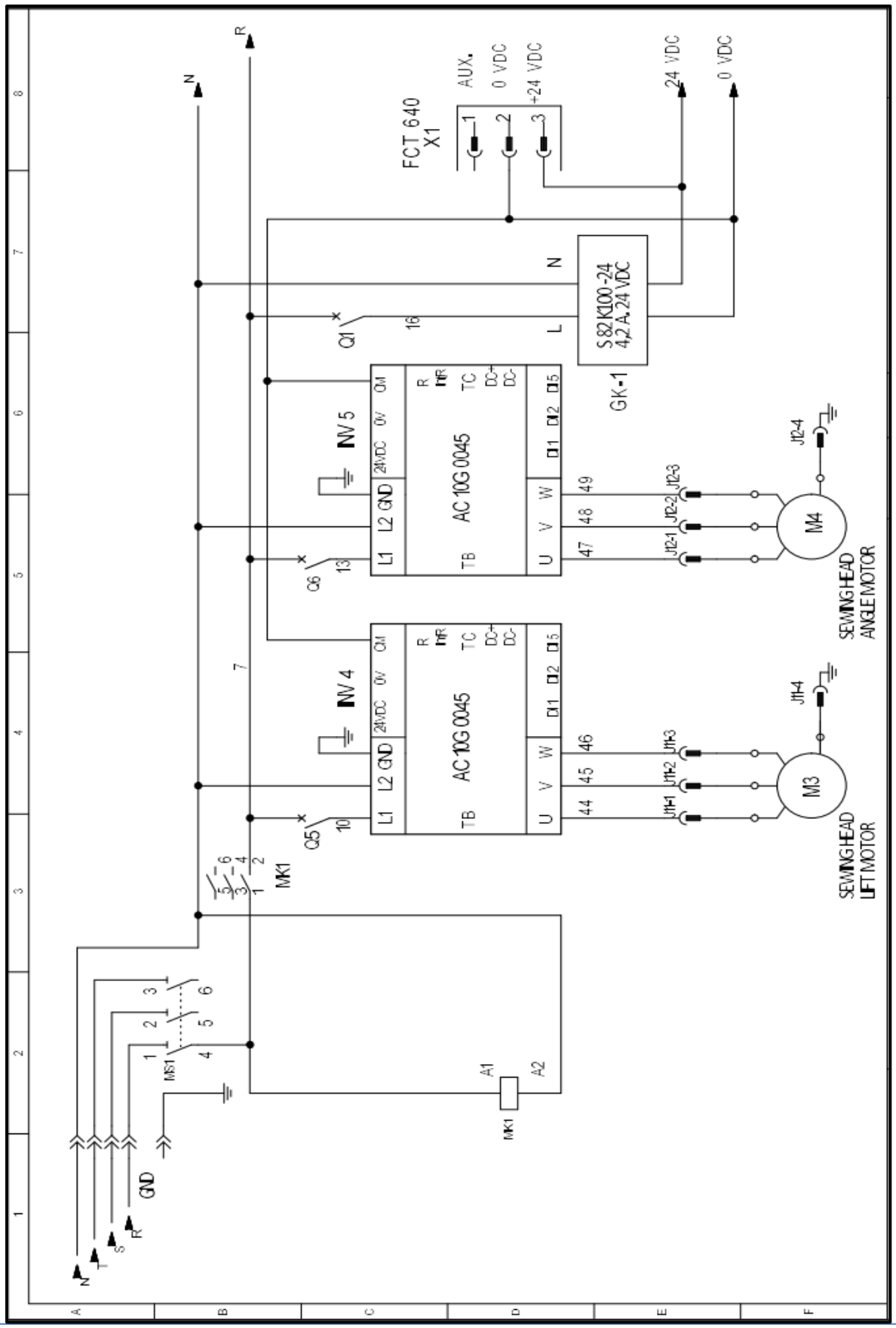


403045 parts list

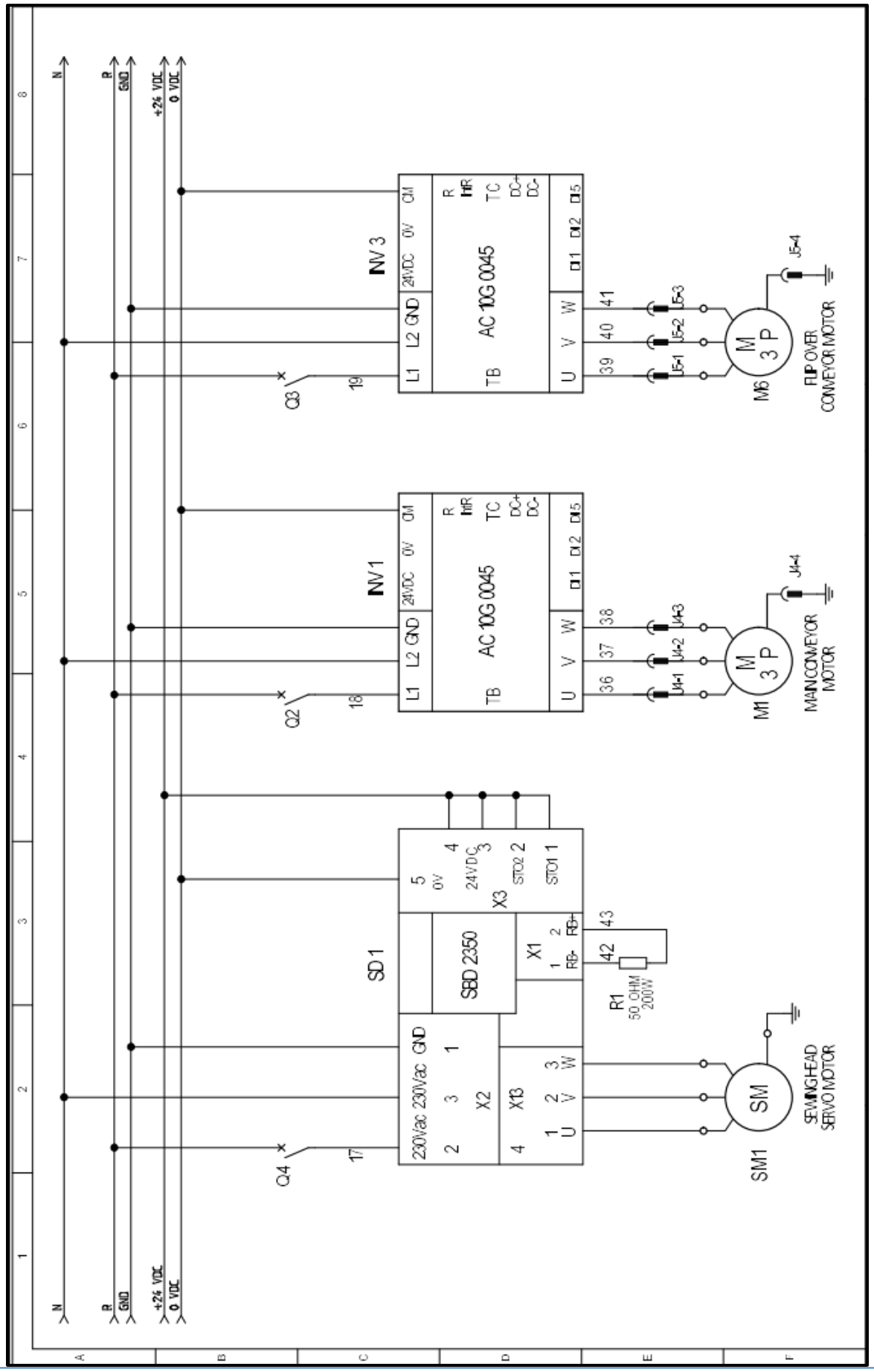
No	Code	Qty
1	401461	1
2	P1406	2
3	P1430	2
4	BPF5	4
5	P1472	4
6	BOLT M8 X 25	12
7	401482	1
8	401492	1
9	P1455	1
10	P1432	1
11	BOLT M8 X 60	4
12	BOLT M8 X 20	12
13	40749	2
14	400750	2
15	BOLT M8 X 12	8
16	BELT	1

Electrical

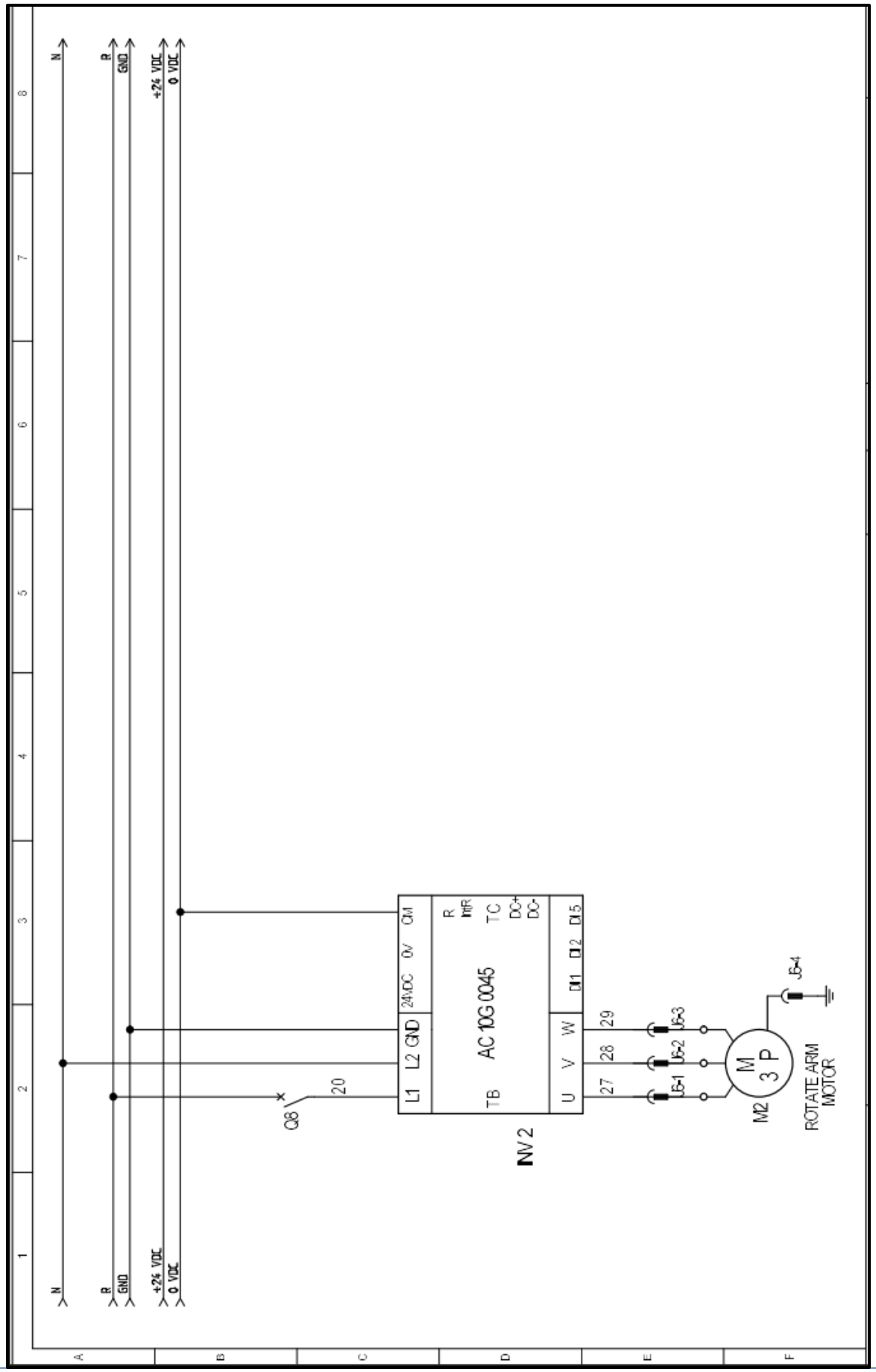
Power Diagram 1 1/10



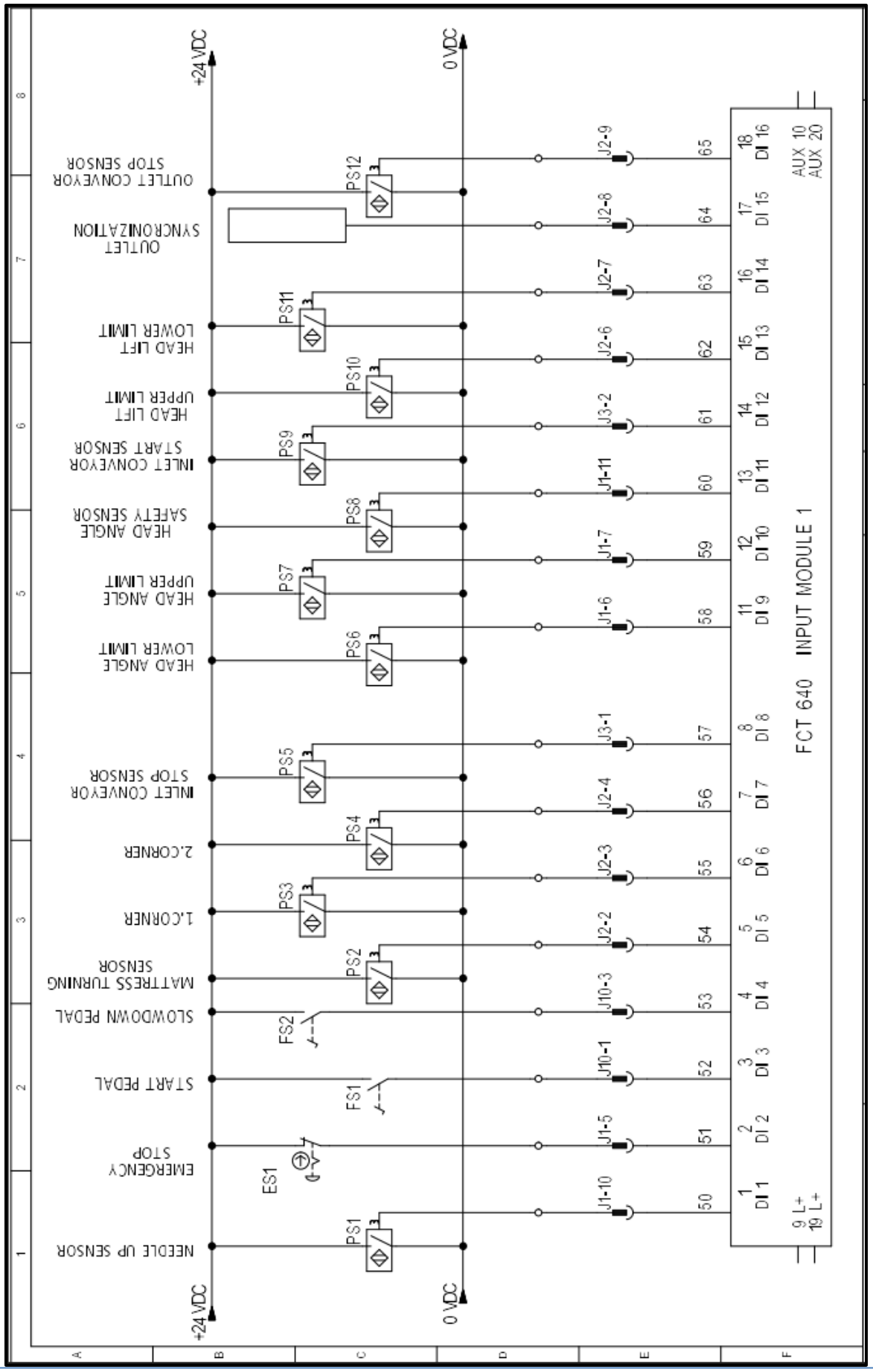
Power Diagram 2 2/10



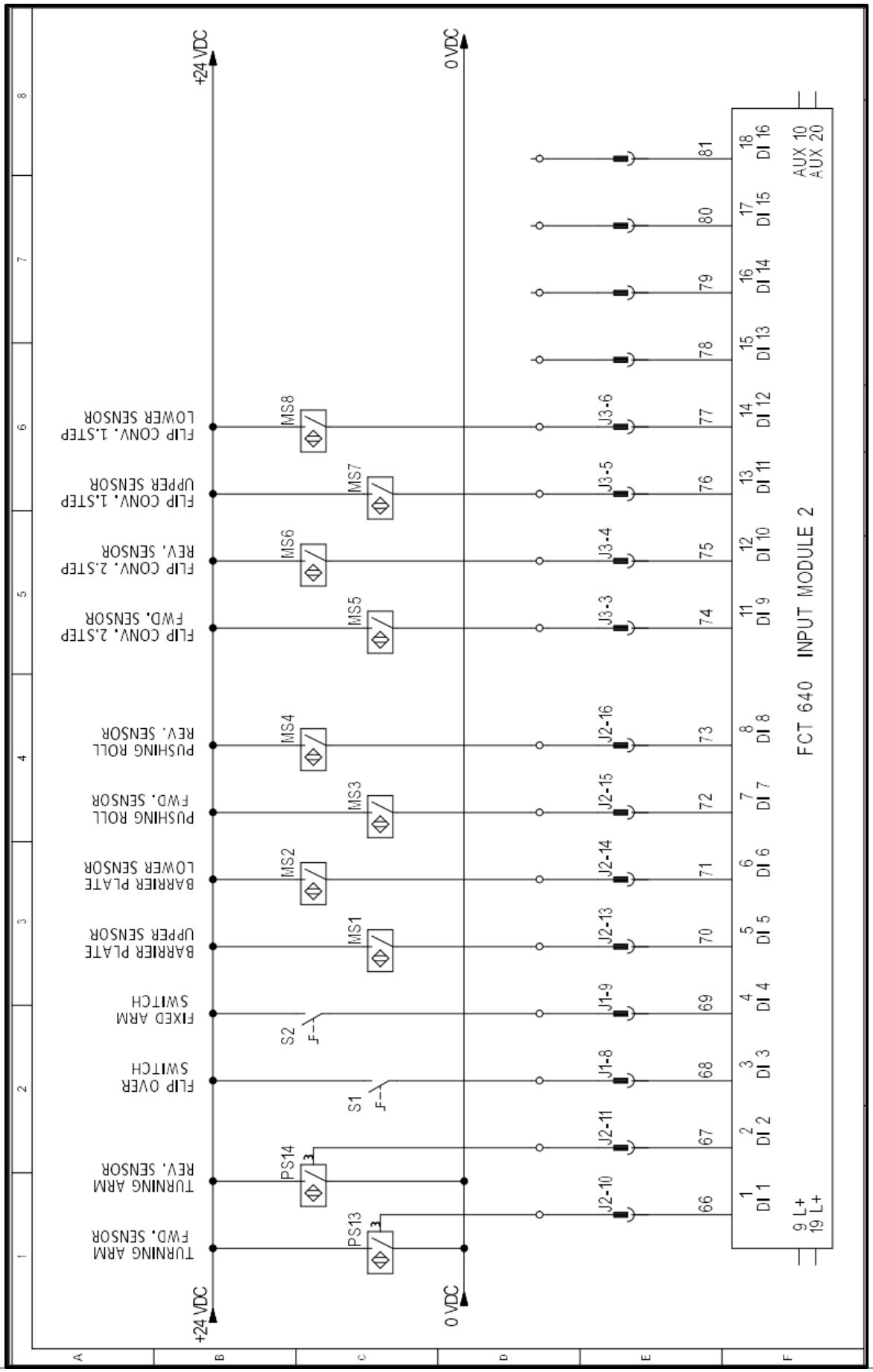
Power Diagram 3 3/10



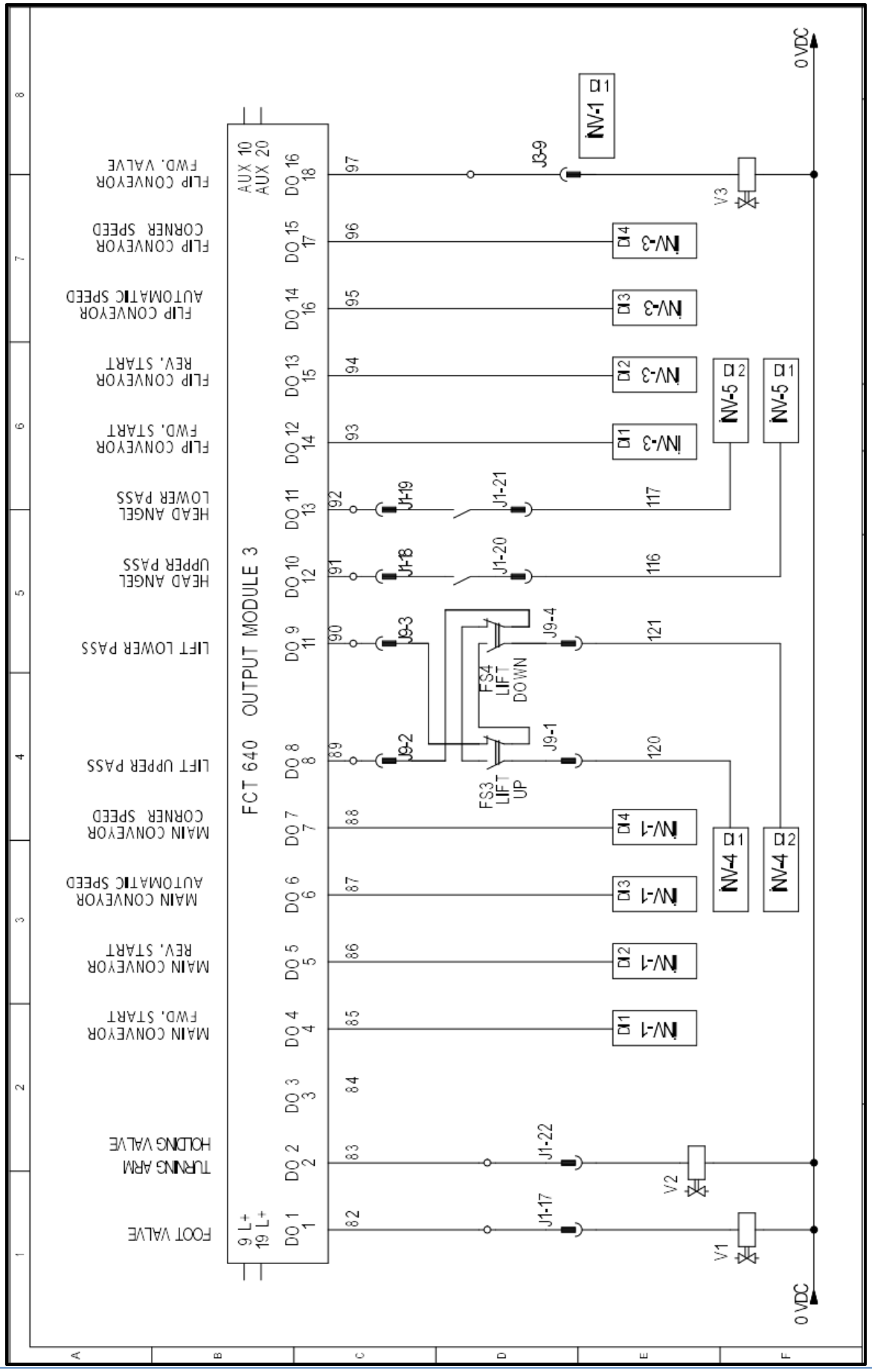
Control Diagram Inputs 1 5/10



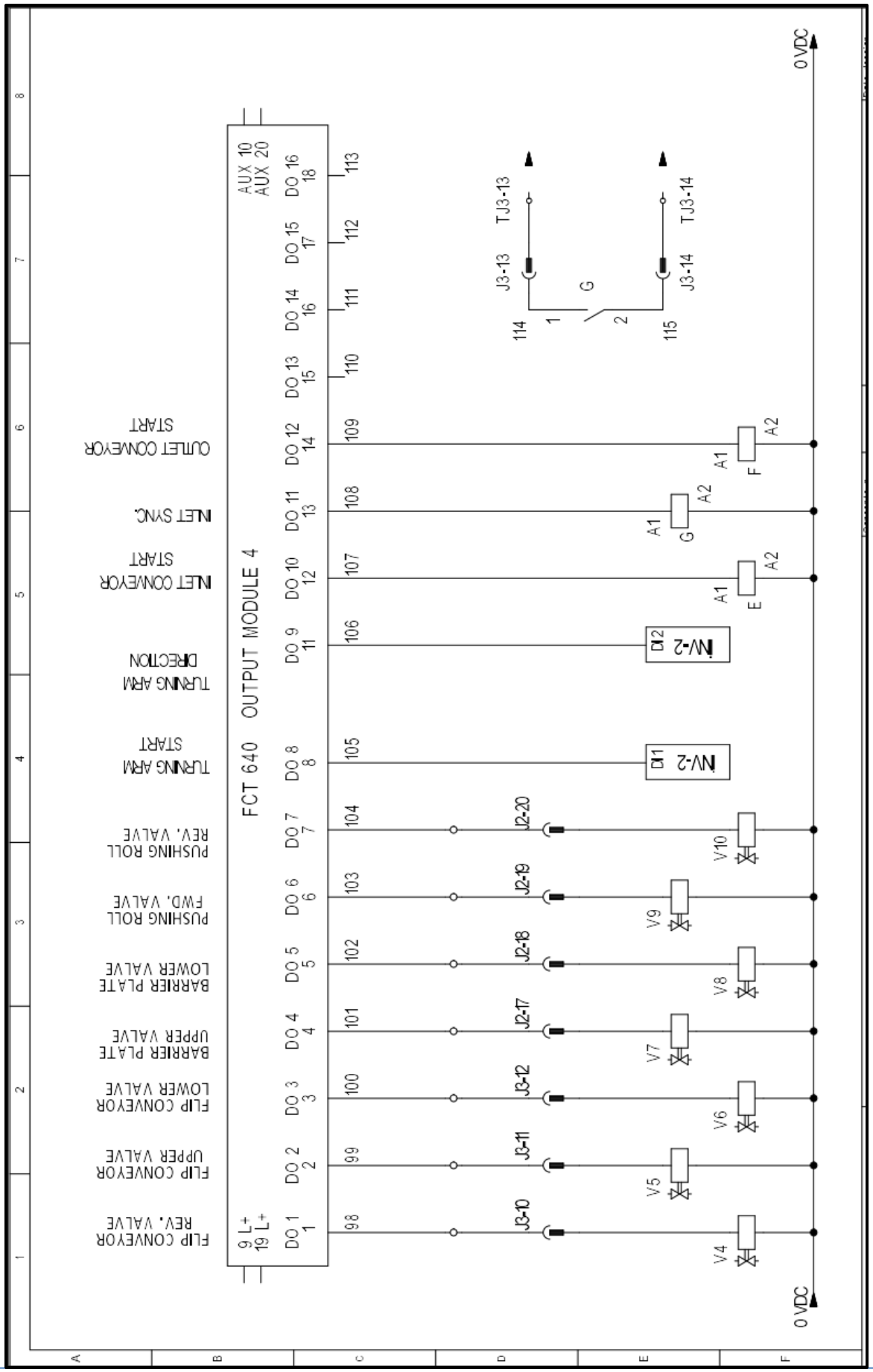
Control Diagram Inputs 2 6/10



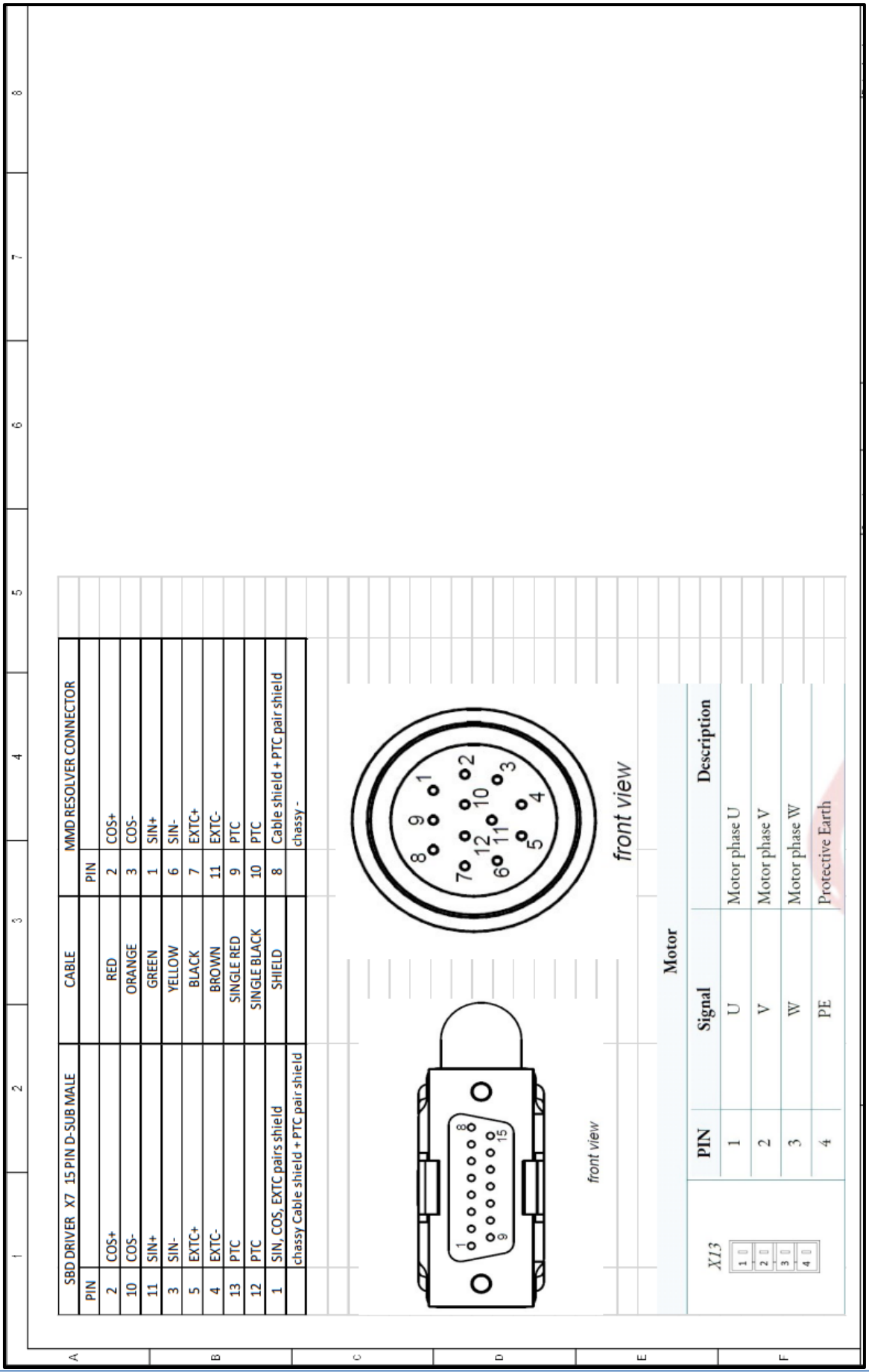
Control Diagram Output 17/10



Control Diagram Output 28/10



Servo Motor Cable Connections 9/10



SBD DRIVER X7 15 PIN D-SUB MALE		CABLE	MMD RESOLVER CONNECTOR	
PIN			PIN	
2	COS+	RED	2	COS+
10	COS-	ORANGE	3	COS-
11	SIN+	GREEN	1	SIN+
3	SIN-	YELLOW	6	SIN-
5	EXTC+	BLACK	7	EXTC+
4	EXTC-	BROWN	11	EXTC-
13	PTC	SINGLE RED	9	PTC
12	PTC	SINGLE BLACK	10	PTC
1	SIN, COS, EXTC pairs shield	SHIELD	8	Cable shield + PTC pair shield
	chassy Cable shield + PTC pair shield			chassy -

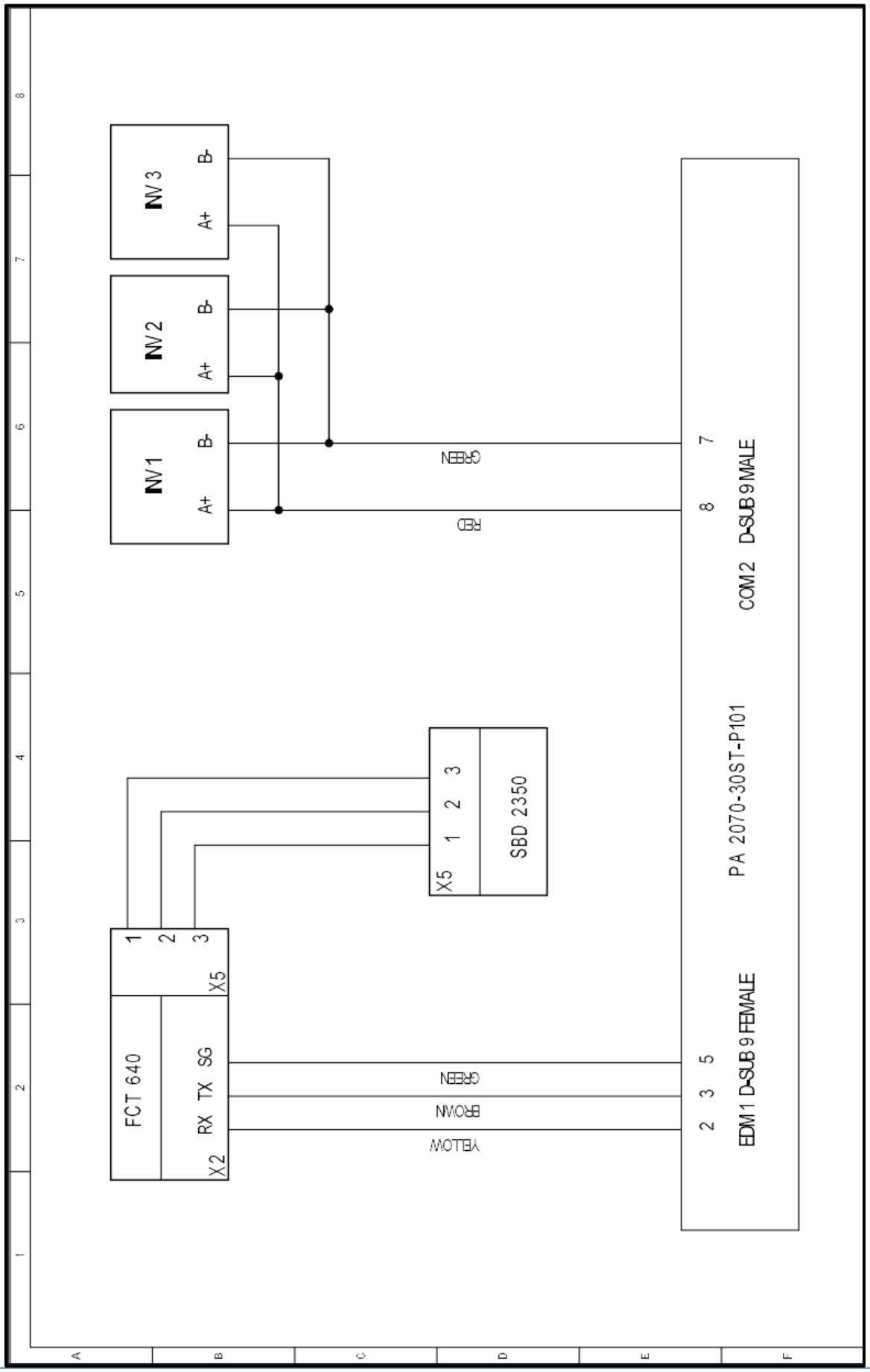
front view

front view

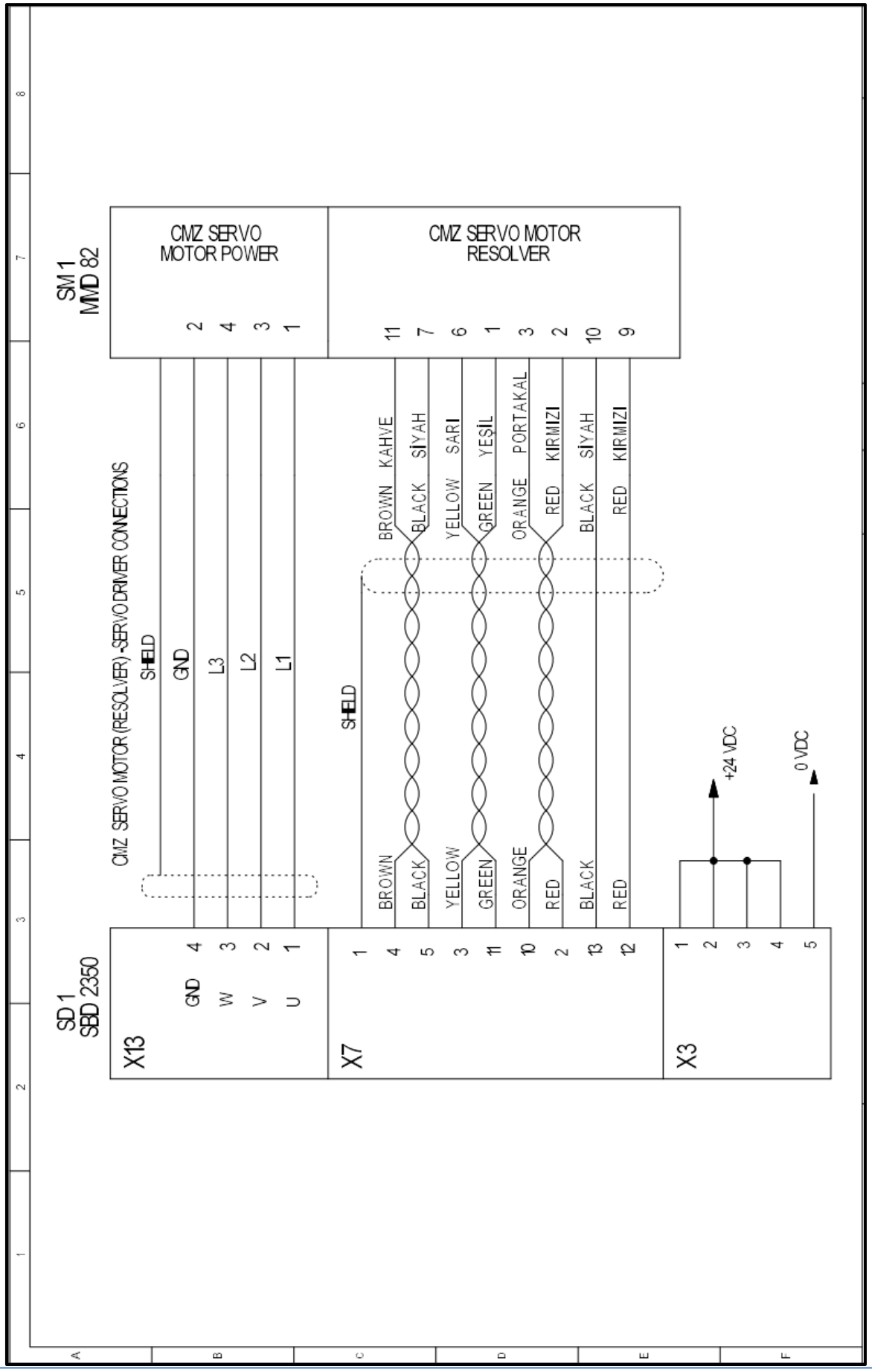
Motor

X13	PIN	Signal	Description
	1	U	Motor phase U
	2	V	Motor phase V
	3	W	Motor phase W
	4	PE	Protective Earth

Communication Diagram 10/10



Servo Motor / Driver Diagram 11/10



Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

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

Términos y Condiciones:

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

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

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

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

Printed in the USA