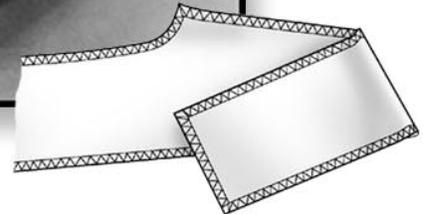
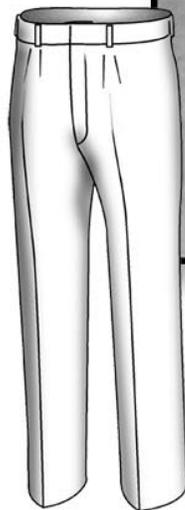


Innovative Technology For The Sewn Products Industry World Wide

ATLANTA ATTACHMENT

1100

**Automatic Pant Leg Panel Serger
TECHNICAL MANUAL**



Web Site: www.atlatt.com

Email: aac@atlatt.com

MANUAL NO. ZZ1100

1100
Automatic Panel Serger

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This equipment is protected by one or more of the following patents:

US patents:4,038,933; 4,280,421; 4,432,294; 4,466,367; 4,644,883; 4,886,005; 5,134,947; 5,159,889;
5,203,270; 5,307,750; 5,373,798; 5,437,238; 5,522,332; 5,524,563; 5,562,060; 5,634,418; 5,647,293;
5,657,711; 5,743,202; 5,865,135; 5,899,159; 5,915,319; 5,918,560; 5,924,376; 5,979,345; 6,035,794
Foreign patents - 2,084,055; 2,076,379;
2,177,389; 2,210,569; 4-504,742; 8-511,916; 9-520,472; 0,537,323; 92,905,522.6; 95,935,082.8;
96,936,922.2.

Other U.S. and Foreign Patents Pending.
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I M P O R T A N T

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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DESCRIPTION

The 1100 unit is a fully automatic panel serging workstation, utilizing a programmable microprocessor with a touch screen for operator input and style recall. Auto serge dress and casual slack panels 3 or 4 sides.

FEATURES

- Patented Serial Bus Control System
- Programmable To Sew 3 Or 4 Sides
- Easy Access To Sewing Head
- Space Saving Design
- Stitch Condensing At The Corners
- Automatic Start
- Automatic Stacking
- Operator Can Run Multiple Machines
- Electric/pneumatic Lockout-tag
- Electronic DC Motor
- Programmable Repair Cycle



UNPACKING & INSTALLATION

Prior to shipping, tie wraps are used to keep certain moveable parts from being damaged during shipping. After the unit is in its permanent location, remove the tie wraps and any other protective restraints that may be in place. Also, remove the bubble wrap from around the Touch Screen panel and place it on the mounting shaft if necessary.

Assemble and install the Thread Stand provided.

Connect the unit to an air supply with the 1/4" air line provided. A minimum air supply of 10 scfm at 70 psi is required.

Connect the unit to power source. Electrical connection requires 208/240-vAC single phase at 8 amps. Each machine is supplied with an 8 foot long, 3 conductor rubber power cord. The machine may be wired through a plug and receptacle or can be directly hard wired to the electrical power source. The Machine must be connected either to a circuit breaker of proper size or a fused disconnect switch containing fuses of the proper size. A plug and receptacle is not an adequate form of electrical disconnection according to current electrical codes.

The machine can now be threaded and the sewing head filled with the manufacturer's recommended oil.

 **CAUTION!**

This machine has thread and cloth cutting knives. These knives cut automatically. DO NOT place fingers or hands around these knives. All adjustments made to the sewing head or trimming knives should be made with the power off.

OPERATING INSTRUCTIONS

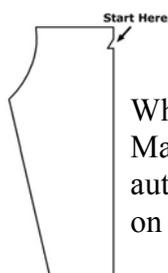
AUTOMATIC MODE: Material is loaded and the machine starts sewing. The machine will keep sewing, unless there is an error, until the panel is stacked. After loading, no input is required by the operator.

SEMI-AUTOMATIC MODE: The material is loaded the same way as in automatic mode and machine will start sewing. The machine will stop at each corner and the touch screen will show a “continue” button. When the “Continue” button is pressed, the machine will continue sewing. When the machine sews the last side, it will cut and stack automatically. This mode is helpful in setting up the stop positions of the corners.

SINGLE STEP MODE: The material is loaded the same way as in automatic mode and the machine will start sewing. The machine will then stop at every major step in the program, such as when a timer runs out or an electric eye is either covered or uncovered. When the machine stops, a “next step” button will be displayed. Pressing the “next step” button will continue the automatic cycle until the next program step is reached.

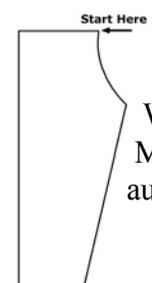
 **IMPORTANT**
Operators must be properly trained and study all manuals very carefully before operating the machine.

LOADING MATERIAL



SEWING 3 SIDES

When sewing on 3 sides, load the material to the notch located on the long side of the panel. Make sure to cover eyes A, B, and C. Once these eyes are covered the machine will start automatically. In some cases you may have to start at the top of the long side. This will depend on the garments specifications.



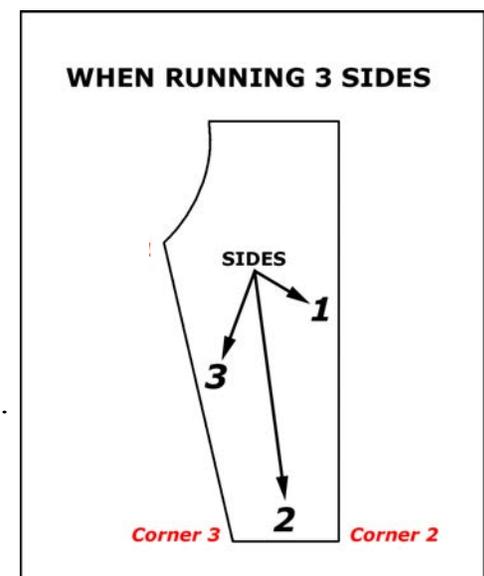
SEWING 4 SIDES

When sewing on 4 sides, it will be necessary to load the panel from the top of the seat seam. Make sure to cover eyes A, B, and C. Once these eyes are covered the machine will start automatically.

SEQUENCE OF OPERATIONS

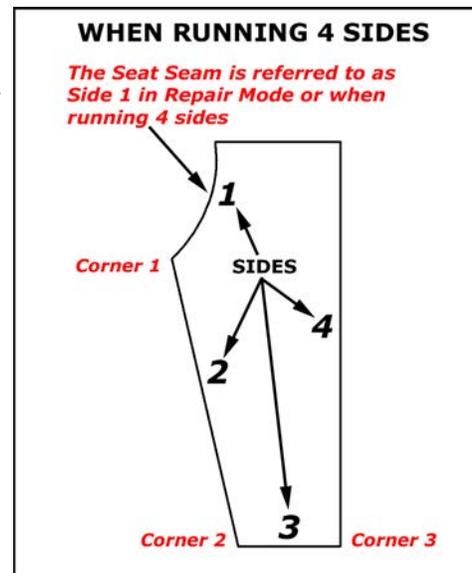
SEWING 3 SIDES

1. Number of sides is set to 3 and material is loaded.
2. Load the material to the notch on the long side, covering Eyes A, B and C.
3. Stripper Blade then drops and machine begins sewing at Full Speed. The High and Low Pressure Blowers come on.
4. Eye A uncovers and Sewing Head sews at Slow Speed.
5. Eye B uncovers and machine counts stitches to stop at the second corner. The stop position is controlled by **Advanced Setting #3** (Second Corner Stop Delay).
6. Turn Finger drops, Dome Motor reverses direction.
7. Turn Finger turns the garment until Eye C is covered.
8. Steps 3 & 4 are repeated.
9. Eye B uncovers and machine counts stitches to stop at second corner. **Advanced Setting #4** (Third Corner Stop Delay) controls the stop position.
10. Steps 6 & 7 are repeated.
11. Stacker Shield moves in and the Wiper Arm moves out.
12. Stripper Blade drops and machine begins sewing side 3.
13. Wiper Blade moves during sewing.
14. Eye A uncovers and Sewing Head sews at Slow Speed.
15. Eye B uncovers and machine counts off the chain length.
16. Seat Seam Wheel drops down and moves the trailing edge of the material to the Stacker. This also helps to insure that the chain gets cut properly.
17. Clamp Arm moves in to hold the material while the Stacker moves.
18. Chain Knife cuts.
19. Stacker moves out and the Clamp Arm releases the material.



SEWING 4 SIDES

1. Set the number of sides to 4 and material is loaded.
2. Load the panel with Seat Seam first. Make sure to cover Eyes A, B, and C.
3. Stripper Blade drops, Foot drops, High and Low Pressure Blowers turn on and the machine starts sewing.
4. While sewing the Seat Seam the sewing head stays in low speed.
5. When the contour of the fabric covers Eye D, the Seat Seam Motor drops to guide around the arc.
6. Eye B Uncovers and the machine counts to stop at the first corner. The stop position is controlled by **Advanced Setting #2 (First Corner Back Stop Delay)**.
7. The sewing head stops. The Turn Finger comes down, and the Dome Motor reverses direction.
8. The Turn Finger turns the panel until Eye C is covered.
9. The machine sews side 2. When Eye A is uncovered, the sewing head goes into low speed.
10. When Eye B is uncovered the machine counts to the stop position for corner 2. This setting is controlled by **Advanced Setting #3 (Second Corner Stop Delay)**.
11. Steps 7 & 8 are repeated.
12. The machine sews side 3. When Eye A is uncovered, the sewing head goes to slow speed.
13. When Eye B is uncovered, the machine counts to the stop position for corner 3. This setting is controlled by **Advanced Setting #4 (Third Corner Stop Delay)**.
14. Steps 7 & 8 are repeated.
15. The Wiper Arm moves out and the Stacker Shield moves in.
16. The machine sews side 4. When Eye A is uncovered, the sewing head goes to slow speed.
17. When Eye B is uncovered, the machine counts the trailing chain.
18. The Clamp Arm moves in to hold the material and the Seat Seam Motor drops down to move the trailing edge of the panel to the Stacker.
19. The sewing head stops and the chain is cut.
20. The Stacker Shield moves out and the Clamp Arm releases the panel.



TOUCH SCREEN DETAILS

MAIN SCREEN

NUMBER OF SIDES: This adjustment is used to tell the machine how many sides are being sewn. The only available options are 3 and 4.

MANUAL SEW: Used to manually sew the sewing head.

PIECE COUNT: Records the number of pieces that the machine has sewn and stacked.

TRAILING CHAIN: This controls how long of a thread chain will be left on the garment when thread is cut at the end of sew. Pressing the minus (-) button will lower the number and shorten the chain. Pressing the plus (+) button will increase the number and lengthen the chain.

MANUAL CUT: Pressing this button will manually activate the chain trimming knife.

LEADING CHAIN: This feature controls how long the sewing head runs after the chain knife has cut. Use this to give a small amount of chain at the beginning of sew. Pressing the minus (-) will lower the number and will shorten the chain. Pressing the plus (+) will increase the number and will lengthen the chain.

REPAIR PAGE: Pressing this will bring up the repair page, which gives controls to repair any mis-sewn garment. *See diagram on page 6.*

OPERATOR PAGE: Pressing this button will bring up the operator page. This page will give other buttons that can be used to manually operate the machine. *See diagram on page 7.*

RE-THREAD MODE: Pressing this button will actuate the Wipe Arm and rotate the Turn Finger around so that covers can be opened for re-threading. This button also disables the electric eyes so that when opening covers the machine will not run.

AUTOMATIC		
NO. OF SIDES - 3 +	MANUAL SEW	PIECE COUNT - 0000 +
TRAILING CHAIN - 30 +	MANUAL CUT	LEADING CHAIN - 10 +
REPAIR PAGE	OPERATOR PAGE	RE-THREAD MODE
ADVANCED FUNCTIONS	MACHINE SETUP	RUN MODE
RESET	HELP?	12:00



Do Not Open The Covers On The Machine Without The Machine Power Off Or In The Re-Thread Mode. Failing to do this may cause the machine to automatically start.

ADVANCED FUNCTIONS: Pressing this button will bring up the security page first then the Advanced Functions Page. *See diagram on page 8.*

MACHINE SETUP: Pressing this button will bring up the Machine Setup Page. This page gives access to the contrast setting, system information, language setting, and style setting. *See diagram on page 10.*

RUN MODE: Pressing this button changes the mode of operation of the machine. Press the button once and the machine is set to run in semi-automatic mode. Press the button twice and the machine is set to run in single step mode. The Mode is displayed at the top of the page.

MAIN SCREEN (continued)

RESET: Pressing this button from the “Main Screen” will reboot the system. Pressing this button from any of the other screens will bring the “Main Screen” back up.

HELP?: This feature may contain more information on how to use the Touch Screen or may provide terms and definitions used throughout the different screens.

TIME: Pressing this button will allow the user to adjust the date and time.

REPAIR PAGE

- When using repair mode, the machine runs at thought it was programmed for four (4) sides. See diagram on page 4.
- From the “Main Screen”, press the “Repair Page” button.
- Load the garment to the side that needs to be repaired.
- After the eyes are covered, the foot will drop to hold the material in place while operation is selected.
- On the screen, choose to sew only the side that needs to be repaired or sew from the side selected to finish and press the correct button.



- If sewing only the side that needs to be repaired, the operator will have to use the “Manual Sew” and “Manual Cut” buttons, to remove the garment from the machine.
- If sewing from the side of repair to finish, the machine will sew, cut, and stack automatically.
- Press “Reset” to return to the “Main Screen”.

SEW SIDE 1 ONLY: Using this button will only sew the seat seam of the panel.

SEW SIDE 2 ONLY: Using this button will only sew the tapered side of the panel.

SEW SIDE 3 ONLY: Using this button will only sew the cuff of the panel.

SEW SIDE 4 ONLY: Using this button will only sew the long side of the panel.

NOTE: After using any of the “ONLY” buttons, you will have to sew manually and cut manually to remove the panel.

FOOTLIFT: Use this button to adjust the position of the material after it has been loaded.

MANUAL SEW: Runs the sewing head manually.

MANUAL CUT: Activates the chain-cutting knife manually.

SEW SIDE 1 TO FINISH: Using this button will sew from the seat seam all the way around the panel.

SEW SIDE 2 TO FINISH: Using this button will sew from the tapered side of the panel to finish.

SEW SIDE 3 TO FINISH: Using this button will sew from the cuff of the panel to finish.

SEW SIDE 4 TO FINISH: Using this button will sew from the long side to finish.

NOTE: Using the “Finish” buttons, the machine will cut and stack automatically.

RESET: Pressing this button will return the machine back to the Main Screen.

OPERATOR PAGE

The “Operator Page” can be accessed from the “Main Screen”. It’s purpose is to allow the operator to manually activate certain functions, reset the piece count, view machine statistics, and re-thread the sewing head.

FOOTLIFT: Activates the Footlift.

MANUAL CUT: Activates the Chain Cutter.

MANUAL SEW: Starts the sewing head.

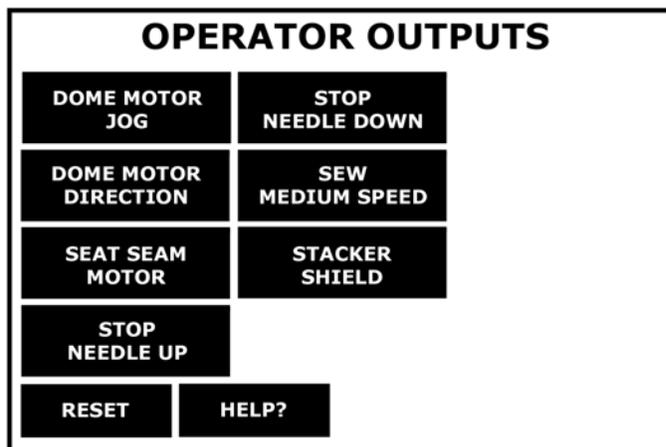
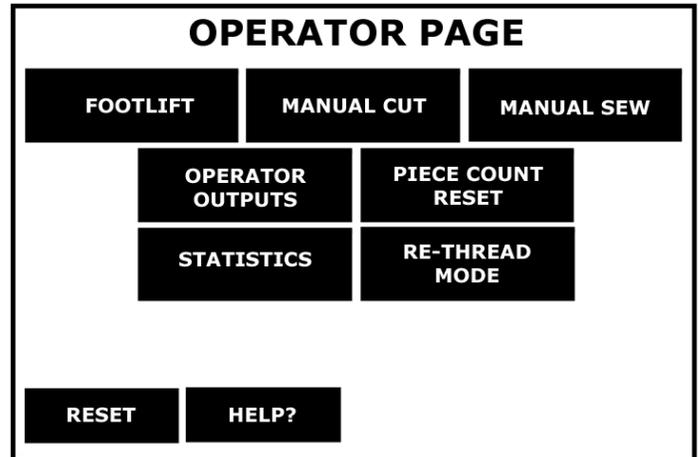
PIECE COUNT RESET: Pressing this button will reset the number of pieces sewn showing on the main screen to zero.

STATISTICS: Pressing this button will bring up the “Statistics” page. On this page you will be able to view information such as Lifetime Piece Count, Daily Piece Count, and Efficiency Monitor.

RE-THREAD MODE: Pressing this button will move out the Wipe Arm and moves the Turn Finger around so that covers can be removed for re-threading. This button also disables the electric eyes so that when removing covers the machine will not run.

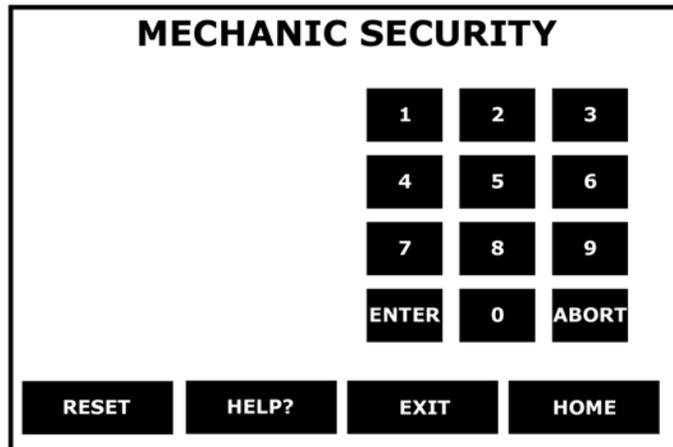
RESET: Pressing this button will return you to the Main Screen.

OPERATOR OUTPUTS: Pressing this button brings up the “Operator Outputs” screen. By pressing a button on this screen the operator or mechanic may manually control a limited amount of functions on the machine.



Pressing the “Advanced Functions” button on the main screen will bring up the “Security” page. You must enter in a pass code in order to continue on to the “Advanced Functions” page.

Enter in the pass code by pressing the number buttons. Each code has five digits. After pressing the five numbers that make up the pass code press “Enter”. This will bring up the “Advanced Functions” page. If a mistake is made in entering in the pass code, pressing “Abort” will cancel the operation and return back to the “Main Screen”. If the wrong pass code is entered, the screen will display “ACCESS DENIED”. You will have to press the “Exit” button which will return you to the “Main Screen”.



ADVANCED FUNCTIONS

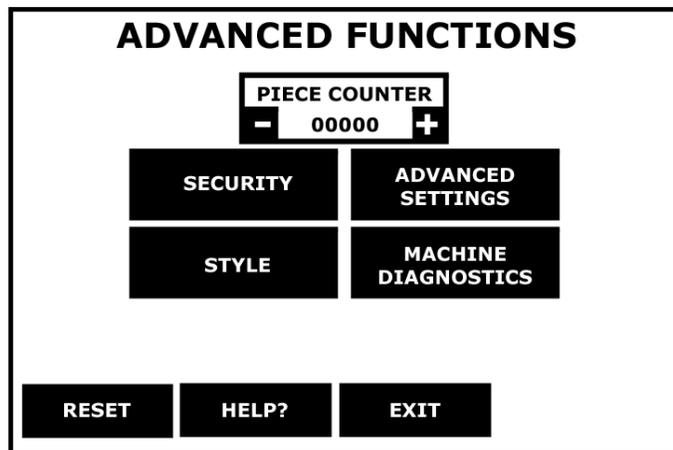
SECURITY: Allows the creation of a new mechanic security code. Enter in a new five-digit security code for the current level, listed at the top of the screen. You must press “Enter” for the computer to accept the new code. To cancel the entered code, press “Abort”. Supervisor codes must begin with a 1. Mechanic codes must begin with a 2. Head Mechanic codes must begin with a 3.

STYLE: Pressing this button will bring up the “Style” page. This page will allow you to Edit, Save, or Recall styles saved in the touch screen.

See “Style Menu” on page 9.

ADVANCED SETTINGS: Pressing this button will take the user to the first of three pages of advanced settings. Each of these settings have a button which, when pressed, will display an explanation of the settings effects. Also the settings may be adjusted by pressing the plus (+) or minus (-) buttons.

MACHINE DIAGNOSTICS: Pressing this button will enable the operator to run manual input and output tests to locate possible causes for machine errors.



STYLE MENU

Pressing the arrow in the top right corner of the screen will bring up the “Style Menu 2” page. This page displays styles 8 through 15.

Pressing any of the style buttons will bring up the “Style” page. This page has buttons that allow the user to recall the setting saved under that style or to save the setting presently programmed in the screen.

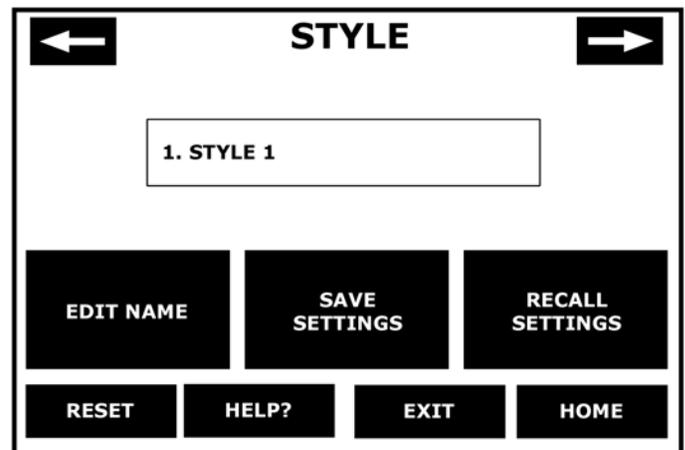


STYLE

EDIT NAME: Pressing this button will bring up the “Edit Name” page. Using this page, you will be allowed to change the name of the style such as Small, Medium, or Large.

SAVED SETTINGS: Pressing this button will save the settings currently programmed in the touch screen under the style in the text window.

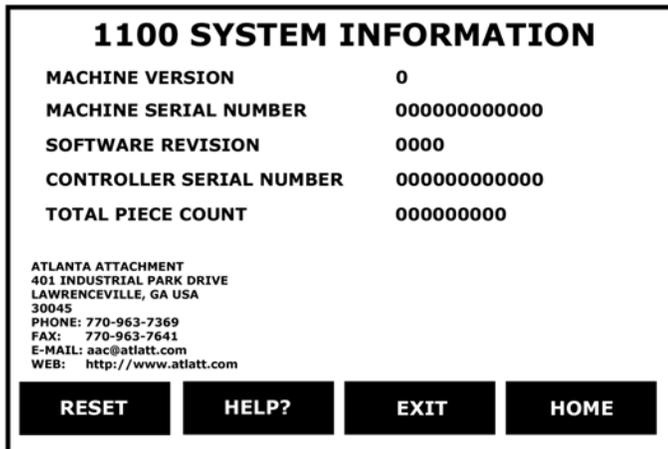
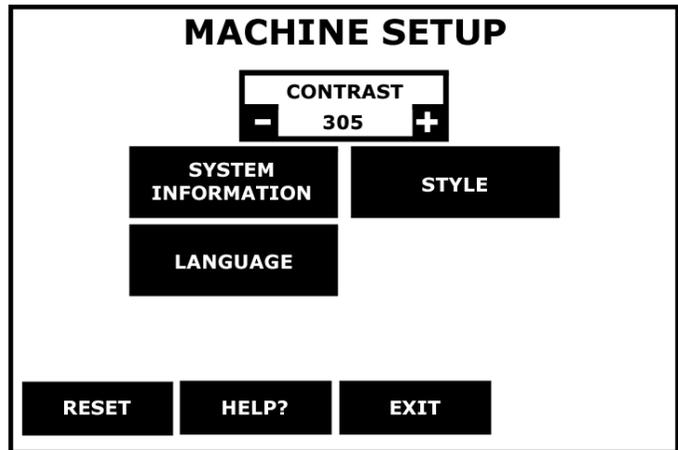
RECALL SETTINGS: Pressing this button will recall the settings that have been saved under this setting. If no settings have been saved under this setting, the machine will replace all settings with the default values.



MACHINE SETUP

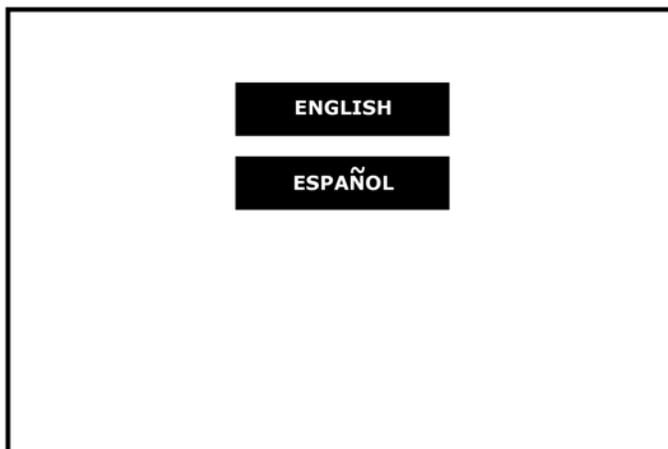
The “Machine Setup” page can be accessed from the “Main Screen”. Its purpose is to allow the operator to view system information such as the machine serial number, controller serial number, and the total piece count. The “Machine Setup” page also allows the operator to switch language and change and setup styles. The contrast of the touch screen may also be adjusted here.

SYSTEM INFORMATION: Pressing this button will display the machine version, machine serial number, software revision, controller serial number, and the total piece count.



STYLE: Pressing this button will open a page where styles may be entered and style names may be edited. *See “Style Menu” on page 9.*

LANGUAGE: Pressing this button will display the language choices for the touch screen.



MAINTENANCE



Before maintenance, adjusting, cleaning, threading or replacing the needle, and to prevent accidents, be sure the power is turned off.



Only well-qualified technicians or service/maintenance personnel should perform such maintenance as repairs and/or replacing parts.

DAILY

- Use blower gun to clean sewing head, table top, and dome.
- Dump waste can.
- Wipe off electric eyes with soft cloth.
- Drain water traps on air regulators.

WEEKLY

- Using SF oil or equivalent, place 3 drops of oil on the needle bar above and below the sleeve.
- Using SF oil or equivalent, place 3 drops of oil on the looper bar.

MONTHLY

- Check function of thread trimming knife. The knife should just travel 1/32 past the shear point.
- Check the belts for wear and tension.
- Check the speed of the rotary actuator. Should equal speed of the dome during rotation.

EVERY 6 MONTHS

- Check and replace the sewing head oil filter.

Note: For the sewing head to have a long life, the manufacturer recommends:

After the first 250 hours of operation, the oil should be changed completely. After that, the oil should be changed 2 or 3 times per year.



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