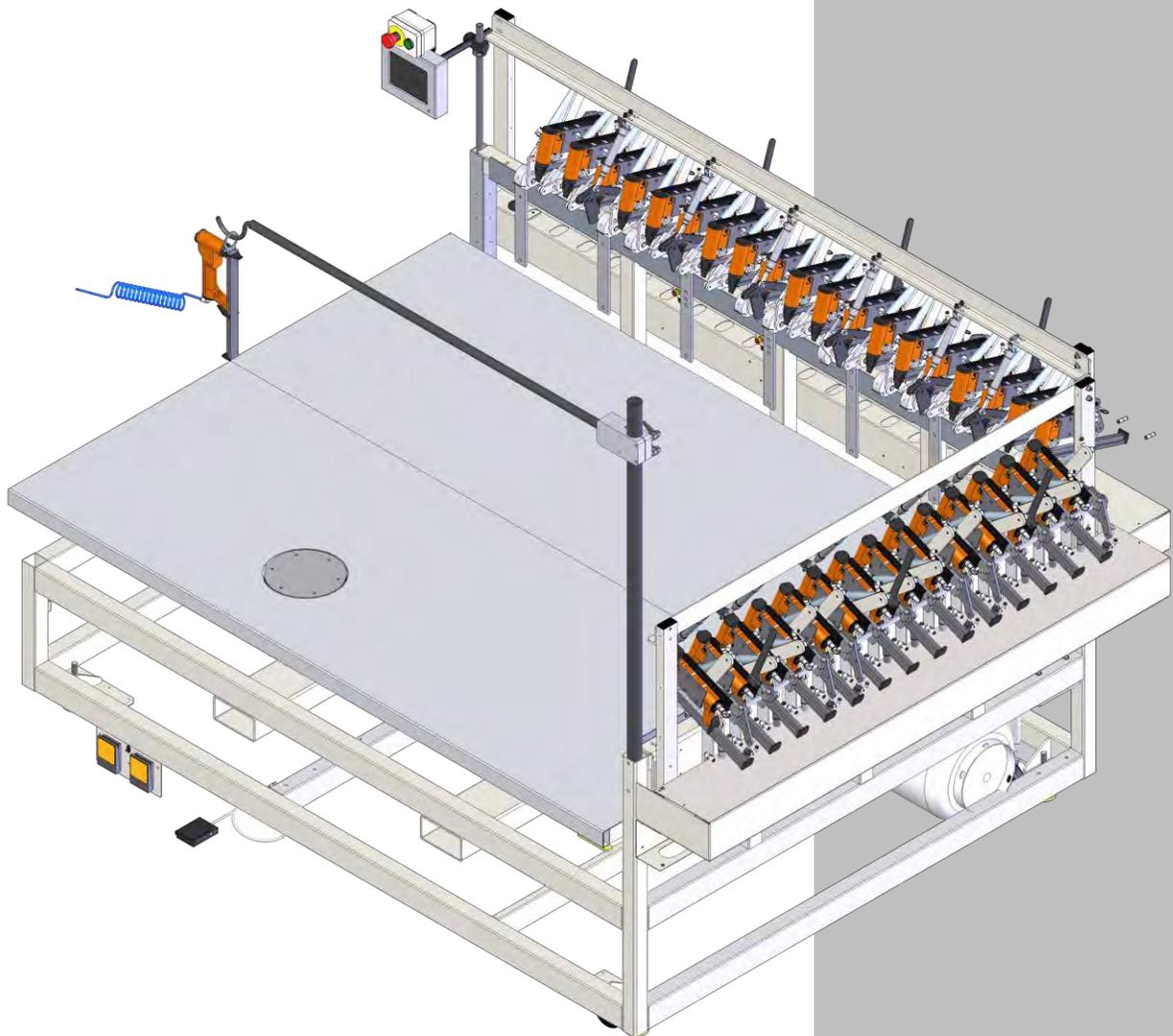




Model **1331BL**

Revision 1.5 Updated Dec 21, 2015

# Technical Manual & Parts Lists



**Atlanta Attachment Company**

362 Industrial Park Drive

Lawrenceville, GA 30046

770-963-7369 • [www.atlatt.com](http://www.atlatt.com)



# ATLANTA ATTACHMENT COMPANY, INC.

## Confidential and Proprietary Information

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.

All materials contained herein are additionally protected by United States Copyright law and may not be used, disclosed, reproduced, distributed, published or sold without the express written consent of Atlanta Attachment Company, which consent may be withheld in Atlanta Attachment Company's sole discretion. You may not alter or remove any copyright, trademark or other notice from copies of these materials.

### 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 .....	1
Liability .....	2
Safety Equipment on the Machines .....	3
Protective Eyewear .....	4
Important Notices.....	5
Maintenance .....	7
Repair .....	8
A Word to the End User.....	9
Safety Precautions.....	9

---

<b>1. INSTALLATION MANUAL</b> .....	10
1.1. Parts Description .....	10
1.2. Installation.....	11
a. Area.....	11
b. Unloading.....	11
c. Level.....	11
d. Electrical .....	11
e. Air .....	11
f. Cleaning.....	11
g. Lubrication.....	11
1.3. Lockout/Tag out Program .....	12
1.4. Technical Data .....	13
<b>2. OPERATOR’S MANUAL.</b> .....	14
2.1. Main Controls. ....	14
a. Emergency Stop (Red) .....	14
b. Start Button (Green).....	14
c. Touch Screen.....	14
d. Lift Table Adjustment Pedals: .....	14
e. Rotation Plate Height Adjustment Pedal.....	14
2.2. Serial Bus Operation (Serial Bus).....	15
a. Basic Modes of Operation.....	15
b. Startup Sequence.....	15
c. Navigation .....	15
d. Operation Screens. ....	17
e. Set up Screen.....	18
f. Warning Messages.....	19
2.3. Operation Description.....	20
a. Foundation Edge Stapling Cycle.....	20
b. Dust Cover Stapling Cycle.....	21
2.4. Reloading the Staplers. ....	22
2.5. Basic Preventive Maintenance. ....	24
a. Daily Maintenance (8 hours):.....	24
<b>3. MAINTENANCE MANUAL</b> .....	25
3.1. Operation Sequence. ....	25
3.2. Control Panel .....	26
a. Advanced Set Up.....	27
b. Advanced Manual .....	31

---

c. Calibrating the Touch Screen.....	32
d. Installation of a new Touch Screen.....	33
e. Standard Modules.....	34
1. Program Module... 4080-150.....	34
2. Memory Module... 4080-970.....	34
3. Output Module... 4080-140.....	34
4. Input Module... 4080-110.....	34
5. Update a Machine using a New Program Module.....	35
3.3. Mechanical Adjustments.....	36
a. Table.....	36
b. Staplers.....	37
c. Staple Position.....	37
d. Firing Cylinder.....	38
e. Tension Wheel.....	38
f. Border Clamp Fingers.....	39
3.4. Pneumatic Pressure.....	40
3.5. Preventive Maintenance.....	41
a. Daily Maintenance (Every 8 hours):.....	41
b. Weekly Maintenance (Every 40 hours):.....	41
c. Monthly Maintenance (Every 160 hours):.....	42
d. Quarterly Maintenance (Every 960 hours):.....	42
3.6. Problems and Solutions.....	43
Notes.....	44
Assembly Drawings & Parts Lists.....	45
1331230 Main Assembly.....	47
1278-6010 Start / Stop Button Assembly.....	48
1331042 Pivot Lift Assembly.....	49
1331178 Pneumatic Panel.....	50
1331185 Overhead Staple Gun Holder.....	51
1331219 Staple Gun Assembly, Short SD.....	53
1331349 Staple Gun Assembly.....	54
1331094 Top Clamp.....	55
1331079 Cover Stretch Roller Assembly.....	57
1331080 Cover Stretch Roller Assembly.....	59
1331220 Long Side Staple Gun Assembly.....	61
1331081 Cover Stretch Roller Assembly.....	63
1331249 Corner Support Assembly.....	64

---

**Technical Manual & Parts Lists**

---

1331504 Table Lift Pedal Assembly.....	65
1331900 Control Box.....	67
1331914 Manual Stapler Assembly.....	68
1331916 Long Side Track Assembly.....	69
1331918 Short Side Track Assembly.....	70
1536-069A Footswitch Assembly.....	71
13452000C Square Table Lift Assembly.....	73
26254C Air Reservoir.....	74
1331-PD2 Pneumatic Diagram.....	76
1331-WD Wiring Diagram.....	77

## 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 1331BL Foundation Stretcher 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.

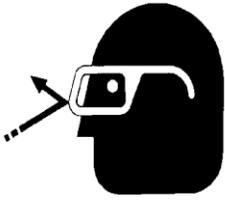
## Signs on the Machine

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 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.**

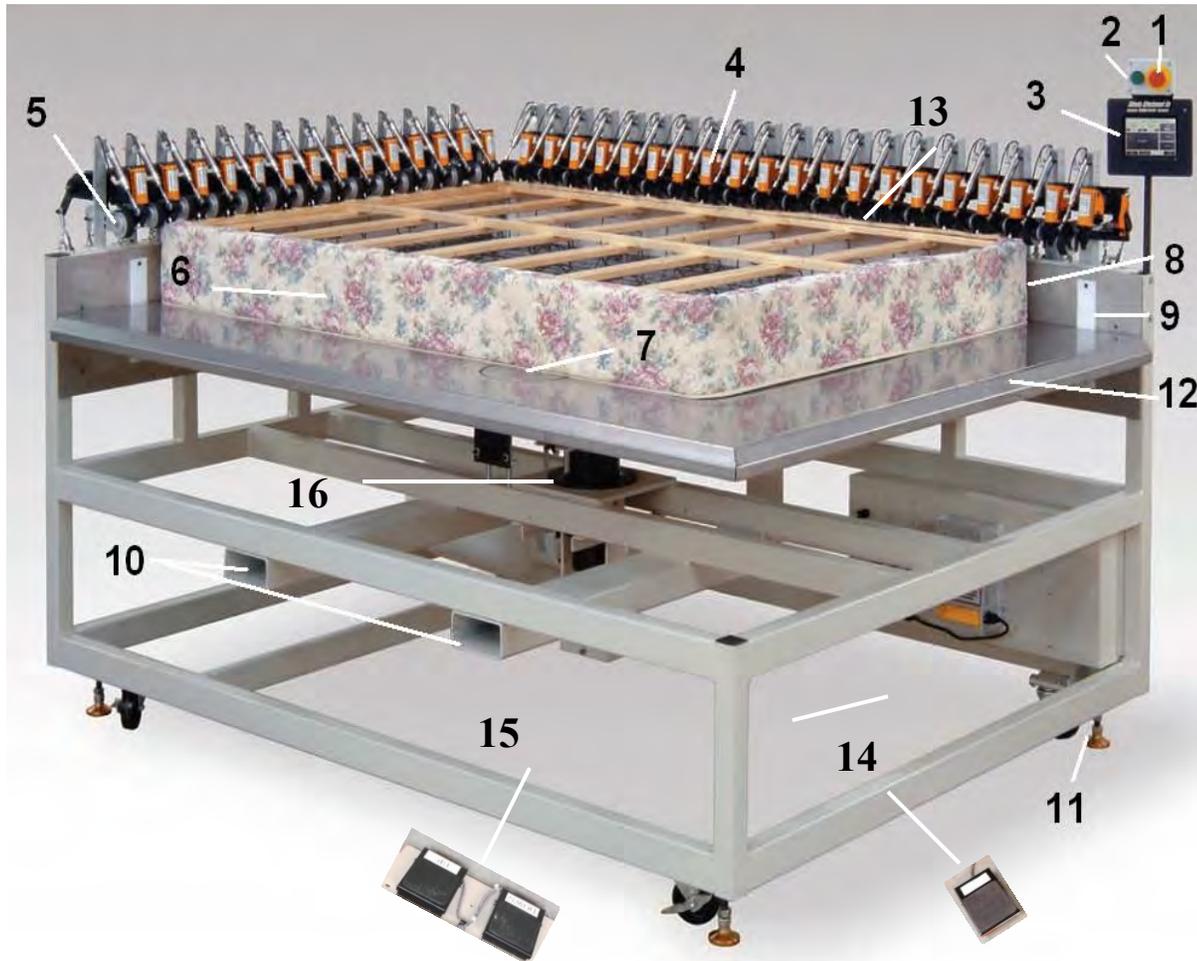
**It is the owner's responsibility to make certain that the operator reads and understands this manual before operating this equipment. It is also the owner's responsibility to make certain that the operator is a qualified and physically able individual, properly trained in the operation of this equipment.**

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.

# 1. INSTALLATION MANUAL

## 1.1. Parts Description



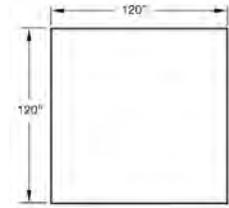
1	Emergency Stop	9	Feed Stops
2	Start Button	10	Forklift Channels
3	Touch Screen Panel	11	Leveling Bolts
4	Staplers	12	Stainless Steel Table
5	Tension Wheels	13	Border Clamps
6	Foundation	14	Rotary Table Foot Pedal
7	Rotary Table	15	Table Foot Pedal
8	Load Sensors	16	Table Column Lifter

## 1.2. Installation



**CAUTION:** Please read all instructions prior to installing equipment. Keep in mind that the weight of this machine is approximately 2,300 lbs. (1.043 Kg.).

**a. Area:** A work space around the perimeter of this machine of no less than 120 x 120 inches (304 x 304 cm) is required.



**b. Unloading:** Open all shipping crates and verify that no items have been damaged due to transportation. Immediately report any damaged or missing parts to your supervisor and if possible take photographs of the affected area. Remove all bolts and screws used for shipping purposes.



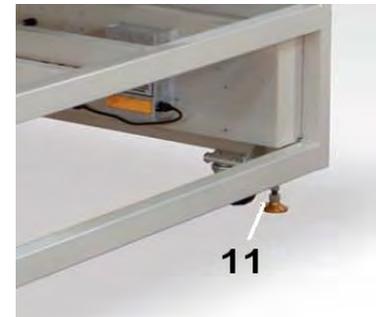
**ATTENTION:** DO NOT STAND OR PLACE ANY HEAVY OBJECTS ON THE STAINLESS STEEL TABLE

The machine is equipped with two channels (10) to allow insertion of fork lift blades. Lift the machine from the shipping pallet and place in the final work area utilizing these lifting channels.



**ATTENTION:** Proceed according to the policies and regulations governing proper use of forklift equipment in your plant.

**c. Level:** Level and adjust the machine height using the four leveling bolts (11) at the base of the machine.



**d. Electrical:** Have a qualified electrician connect 208-230 volts, single-phase, 50/60Hz electrical power protected by a 20Amp circuit breaker to the machine. Verify proper electrical installation and grounding per local and national electrical and fire protection requirements.

**e. Air:** Connect a ½ inch airline supply to the main air inlet. The machine must have a minimum of 80 psi (6 bars) pressure and at least 20 SCFM supply.

**f. Cleaning:** Clean the machine components of any rust preventative shipping oils in accordance to the manufacturer's specifications.

**g. Lubrication:** The machine is normally shipped with all oils and lubricants drained. Proceed to the section on Preventive Maintenance – Weekly 40-Hour Maintenance for the location and proper adjustment of lubrication.

### 1.3. Lockout/Tag out Program



"Lockout/Tag out (LOTO)" refers to specific practices and procedures to safeguard employees from the unexpected energization or startup of machinery and equipment, or the release of hazardous energy during service or maintenance activities. This requires that a designated individual turn off and disconnect the machinery or equipment from its energy source(s) before performing service or maintenance and that the authorized employee(s) either lock or tag the energy-isolating device(s) to prevent the release of hazardous energy and take steps to verify that the energy has been isolated effectively. The following references provide information about the LOTO process.

<b>Equipment Energy Control Procedure</b>				
Lockout/Tag out Program				
Description:		Border Workstation	Model:	<b>1331B</b>
Manufacturer:		Atlanta Attachment Co.	Location:	
Energy		Location	Magnitude	Control Method
Electrical:	X	Disconnect/Ctrl Box	220V	Lockout & Tag
Pneumatic:	X	Main Regulator	80 PSI	Lockout & Tag
Gravity:	X	Folder Assy, Knife Assy, Transfer Clamp		
<b>Remember to Release All Stored Energy!</b>				
<b>Shutdown Procedure:</b>				
<ol style="list-style-type: none"> <li>1. Inform all affected personnel that the machine will be in Lockout status.</li> <li>2. Turn the power and pneumatic disconnects to the OFF position.</li> <li>3. Fill out the tag with necessary information of the Lockout.</li> <li>4. Install the Lockout device.</li> <li>5. Verify all stored electrical energy has been released by pressing the power on button.</li> </ol> <p>Also, use a meter to test circuits in the electrical panel to insure stored energy is released there as well.</p> <p>Perform necessary maintenance, services and/or repairs.</p>				
<b>Startup Procedure:</b>				
<ol style="list-style-type: none"> <li>1. Inform all affected personnel that the Lockout of this machine is being removed.</li> <li>2. Replace any guards or safety devices which may have been removed during maintenance.</li> <li>3. Remove the Lockout device and tag.</li> <li>4. Turn the power and pneumatic disconnects to the ON position.</li> <li>5. Push the green button on the back of the control panel to turn the machine on.</li> <li>6. Inform all affected personnel that the Lockout has been removed and that the machine is ready for normal production operation.</li> </ol>				

Approved By: \_\_\_\_\_

Date: \_\_\_\_\_

### 1.4. Technical Data

<b>Machine</b>	<b>1331B / BL</b>	<b>1331BH</b>
Voltage	220V 1PH 50/60HZ	
Amperage	1.3 Amps	
Air Pressure	80 Psi / 6 bar	
Air Flow	20 SCFM	
<b>Staple</b>		
Manufacturer	Stanley-Bostitch	
Model:	TU21671LM	
Staples:		
BA-7110	STAPLE,3/8"LFOR TU21671LM 3/8 CROWN,25000/BOX	
BA-7112	STAPLE,1/2"LFOR TU21671LM 3/8 CROWN, 25000/BOX	
<b>Foundation Measurements:</b>		
Max Height	13 ½ inches / 34.29 cm	19.5 inches / 49.53 cm
Min Height:	5 inches / 12.7 cm	
Height Variation	6 inches / 15.24 cm	12 inches / 30.48
<b>Weight and Measurement</b>		
Shipping Weight	2.370 lbs. / 885 Kg	2.570 Lb. / 959 Kg
Shipping Dimensions	60 x 105 x 92 inches / 152 x 266 x 233 cm	60 x 105 x 98 inches / 152 x 266 x 248 cm
Working Area	120 x 120 inches / 304 x 304 cm	
<b>Estimated Production</b>		
Foundation and Dustcover	80 per hour	
Foundation	150 per hour	

## 2. OPERATOR'S MANUAL.



CAUTION: READ ALL INSTRUCTIONS PRIOR TO OPERATING THIS MACHINE

### 2.1. Main Controls.

#### a. Emergency Stop (Red)

Depressing this button will lock it in the down position and shut the machine off. To unlock this button, twist lightly to the right until the button pops back up.

#### b. Start Button (Green)

Momentarily pushing this button will begin the machine startup cycle. If the machine does not start, check that the emergency stop button is not locked down.



#### c. Touch Screen.

The touch screen is used to control and monitor all functions in the machine.



CAUTION: DO NOT TOUCH THE SCREEN WITH ANY METAL OBJECTS, SHARP POINTS OR ROUGH EDGES. This may damage the screen or reduce its performance.



#### d. Lift Table Adjustment Pedals:

Pressing these pedals will raise or lower the lift table. These pedals are initially bolted to the frame but may be moved to a convenient location that is more comfortable to the operator.



#### e. Rotation Plate Height Adjustment Pedal

This pedal raises or lowers the rotation plate. It may only be used when the machine is in training mode since the machine's controller will adjust the height during automatic cycles.

## 2.2. Serial Bus Operation (Serial Bus).



**CAUTION: DO NOT TOUCH THE SCREEN WITH ANY METAL OBJECTS, SHARP POINTS OR ROUGH EDGES** This may damage the screen or reduce its performance.

### a. Basic Modes of Operation

The operator accessible functions allow control of the normal production cycles and capture of production data. It also displays fault messages and guides the operator to choose the appropriate fault recovery functions. It allows the operator to adjust basic machine parameters.

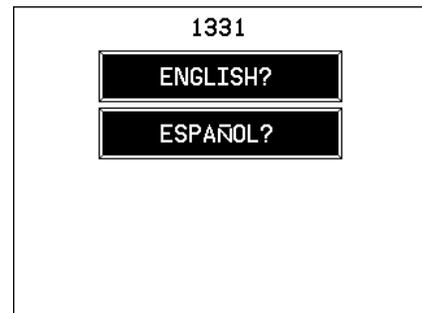
The screen images display 3-dimensional (3D) buttons that may be pushed to move to other screens, change production counters or timers or activate various machine functions. Any screen window that is not 3D is used to display information or machine status only.

### b. Startup Sequence

When the touch screen is powered up, the first screen displays the machine's model information and requests that the operator choose a language.

Lightly tap on the screen button to select the desired language

**NOTE: Lightly tap, never use a metal object or excessive force to operate the screen to prevent scratching or breakage of the glass surface**



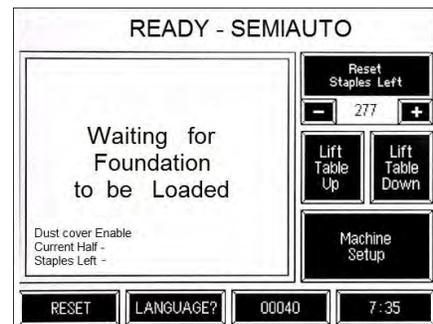
Upon receiving the operator's language selection, the touch screen displays the OPERATION screen

### c. Navigation

**NOTE** The buttons on the bottom row of the touch screen are multi-purpose buttons. These buttons will change functions depending on which screen is viewed and the current state of the machine. The more common functions include:

Counters are identified with the "+" and "-" buttons in the corners. These counters may be adjusted by touching the "+" and "-" boxes.

**RESET:** This button always places the machine in its initial startup configuration. It is equivalent to cycling machine power off then back on.



**LANGUAGE:** This field is located in almost all the available screens. Select at any time to access other languages.



**PIECE COUNT:** The field on the left of the clock button is the piece counter that increases every time the border cycle is complete. Touching this area will bring up a screen to reset this count. This counter can be used for a daily production monitor, also located on this screen is an efficiency monitor that displays the machine run time vs. the machine on time and displays it as a percentage.



**ARROWS:** Pressing the arrows right or left will take you to the next or previous pages.

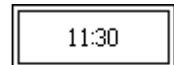


**NOTES:** When a button has a white background the function is on or enabled. A dark background indicates off or disabled. Some buttons may toggle on or off, others must be held on.

Special screens will display machine errors or other conditions that prohibit the operation of the machine. Simply follow the instructions on the screen to resolve the problem.

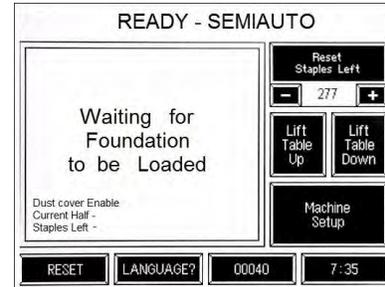
There are also “ADVANCED” settings and functions available. These functions are only accessible by a password, and include: timers that control machine hardware, input and output test screens, and machine statistics. To activate the advanced functions the appropriate password must be entered at the security screen. Security access is reset whenever the main power is turned off, or the RESET button on the main page is pressed. The factory default access code is "22222".

**TIME:** While on the MAIN screen, this button allows the operator to adjust the system time and date. Any other screen may only view the time and date.



## d. Operation Screens.

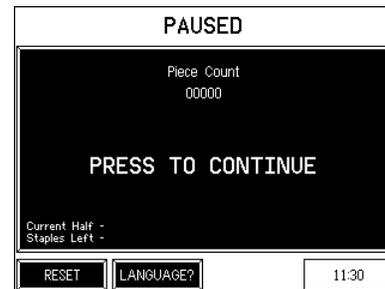
**READY SEMI-AUTOMATIC.** This screen is the main operating screen. The entire cycle of clamping, table lifting, material tensioning, stapling and rotary plate lifting are sequenced automatically by the computer.



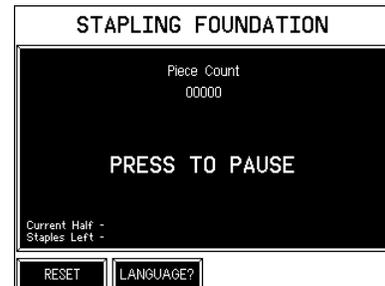
**READY- TRAINING:** The machine will cycle through the following sequences: CLAMP, LIFT TABLE, STRETCH MATERIAL and hold.



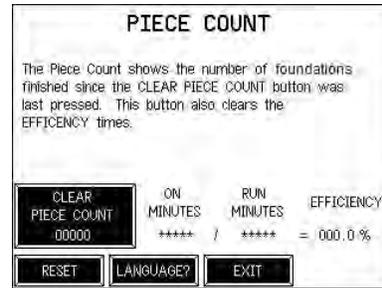
**PAUSED:** The operator must tap on this screen to continue the staple cycle. This screen only appears while in TRAINING mode.



**STAPLING FOUNDATION.** The operator must tap on this screen to stop the automatic staple cycle.



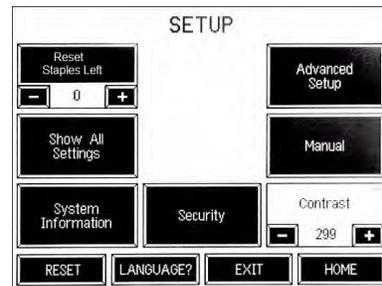
**PIECE COUNTER.** This screen displays production data including time, piece counts, efficiency, etc. The screen includes a count RESET button witch zeros out the production counters.



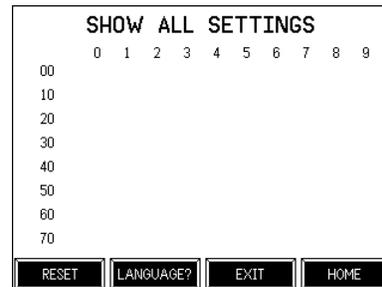
### e. Set up Screen

From the Semiautomatic Screen, the operator may adjust various machine parameters by tapping the button [SET UP]. Some adjustments may be restricted and require a security password to allow changes.

Reset remaining staple count: Returns the remaining staple count to the maximum value. The maximum value may be increased or decreased using the buttons labeled “+” or “-“



**SHOW ALL SETTINGS:** This button moves to a screen that displays all current machine adjustments.



**SYSTEM INFORMATION:** Displays general machine information including software version.



**SECURITY:** This screen is used to change key codes. It is recommended that the key codes be stored in a safe area.

### ADVANCED ADJUSTMENTS:

This button will open the Technician’s Adjustment Screen. Proceed to the TECHNICAL MANUAL for a detailed explanation of this area.

**CONTRAST:** Adjust the brightness of the screen. Please note: the screen becomes brighter after warming up. Allow at least 5 minutes prior to making any brightness adjustments.

## f. Warning Messages

**NO FOUNDATION LOADED**

In training mode, when the start button is pressed, all three side eyes must be covered before automatic operation can begin.

**OUT OF STAPLES**

The Staple guns are out of staples. Reload the guns and press Continue.

**LIFT TABLE ERROR**

The Lift Table did not reach the Pull Wheels in a reasonable amount of time.

**Low Air Pressure**

The Air Pressure module has detected that the current pressure level is below the Main Air Low setting.

Check air supply.

**Dual Staple**

Press any Pedal or the Staple button below to staple the dustcover the second time.

Press the Skip button below to continue without stapling.

**RESETTING MACHINE**

## 2.3. Operation Description

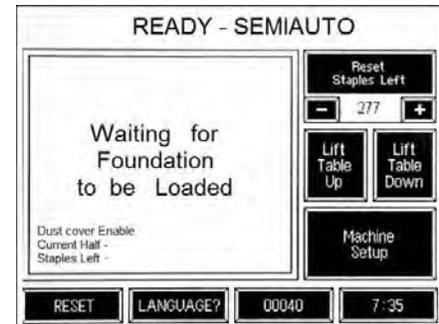
The machine has been designed to perform two main functions:

- a. Tension the sides of the Foundation and staple it to the wood border.
- b. Attach the dust cover using staples to the Foundation wooden frame.

These operations may be performed individually or sequentially depending on the program selected.

### a. Foundation Edge Stapling Cycle

Be sure that the touch screen displays READY\_SEMIAUTO and the “CURRENT SIDE” displays “1”



- Handling the Foundation by the corner, press against the two machine edge guides making sure that the three load sensors are activated.
- The machine will automatically activate the Border Clamps which will press the Foundation against the machine’s sides, the tension wheels will lower and the table will rise.
- After activation the tension wheels will stretch the material. Next the stapler guns will activate securing the border to the wooden frame.
- The Foundation will be unclamped and the rotation table will rise allowing the operator the opportunity to rotate the unit to the next side. The computer touch screen will then display “CURRENT SIDE 2”
- The previous cycle will repeat stapling the other edges of the Foundation
- Remove the unit from the machine and insert a new Foundation.



## b. Dust Cover Stapling Cycle

To use this cycle, the option [Enable Dustcover] in the Advanced Options Screen (Screen #8) must be in position 1. When activated the touch screen displays Semi-Automatic Mode ARMED and that the “CURRENT SIDE” is displaying a “1”

- Handling the Foundation by the corner, press against the two machine edge guides making sure that the three load sensors are activated.
- The machine will automatically activate the Border Clamps which will press the Foundation against the machine’s sides, the tension wheels will lower and the table will rise.
- After activation the tension wheels will stretch the material. Next, the staple guns will activate securing the border to the wooden frame.
- The Foundation will be unclamped and the rotation table will rise allowing the operator the opportunity to rotate the unit to the next side. The computer touch screen will then display “CURRENT SIDE 2”.
- The previous cycle will repeat stapling the other edge of the Foundation.
- While the machine is stapling side 2, take a dustcover and begin securing its corners to the wooden frame using the manual stapler. Try to align and stretch the dust guard as much as possible to prevent tangling in the machine and having an insufficient area to staple.
- After the second stapling cycle finishes, the machine will advance to the “CURRENT SIDE 3”. Turn the Foundation push it back into the machine. This time only the staplers will activate.
- While the machine is performing “SIDE 3”, begin securing the dust guard corners to the wooden frame using the manual stapler. Try to align and stretch the dust guard as much as possible to prevent tangling in the machine and having insufficient area to staple.
- After the third stapling cycle is complete, the machine will advance to “SIDE 4”. Turn the Foundation or push it back into the machine. Once again only the staplers will activate
- Once the machine completes the fourth sequence, remove the Foundation from the machine. The computer touch screen will automatically return to “SIDE 1”



## 2.4. Reloading the Staplers.

 CAUTION: BE SURE THAT THE MACHINE POWER IS OFF BEFORE INITIATING THIS PROCEDURE. IF THE POWER IS NOT REMOVED, THE STAPLER MAY DISCHARGE A STAPLE.

a. Pull the two security pins from the Stapler Block and rotate  $\frac{1}{4}$  turn until it unlocks from the block. (Fig 1)



Fig 1

b. Lift the Stapler Block and rotate 180-degrees. (Fig 2)



Fig 2

c. Perform the same operation on the remaining Stapler Blocks. (Fig 3)



Fig 3

d. Squeeze the locking lever on the Stapler magazine and open the stapler compartment. (Fig 4)



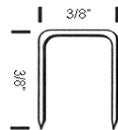
Fig 4

e. Introduce a new strip of staples into all of the staplers. Depending on the usage, the staplers on the ends may have sufficient staples. Add more staples as required. (Fig 5)



Fig 5

The machine uses the following types of staples:



following

# Part	Description
BA-7110	STAPLE, 3/8"LFOR TU21671LM 3/8 CROWN, 25000/BOX
BA-7112	STAPLE, 1 / 2" LFOR TU21671LM 3/8 CROWN, 25000/BOX

f. Close the staple compartment until the magazine's locking lever is secured in the LOCK position. Return all staplers back to their operating positions.

g. Rotate the security pins 1/4 turn until they snap back into the LOCK position. Repeat this task on the remaining stapler blocks. Verify that all of the staplers are properly LOCKED and that their magazines are properly LOCKED.

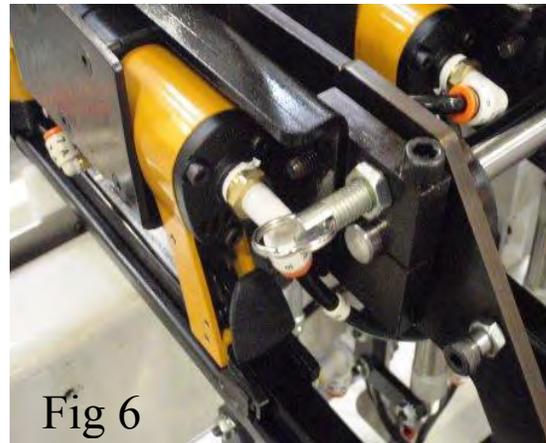


Fig 6



**NOTE:** Be carefully do not to drop the guns damaging the pins

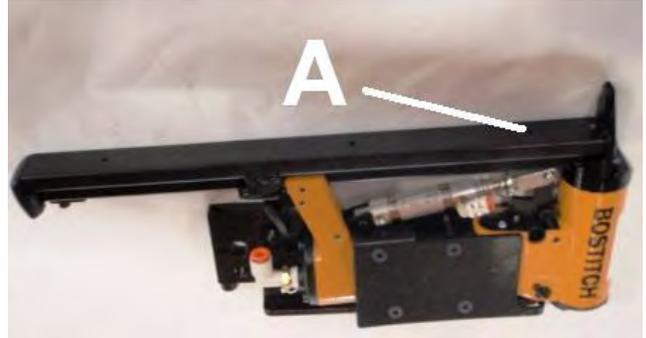
h. Turn the machine back ON and initialize the touch screen's Remaining Stapler Counter.

## 2.5. Basic Preventive Maintenance.

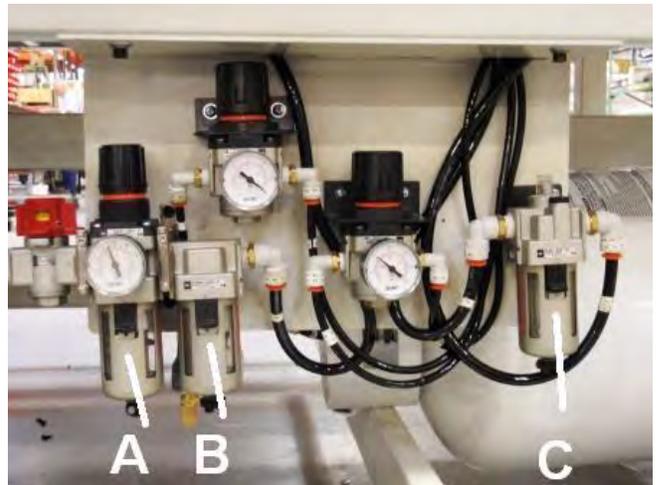
A good preventive maintenance schedule will allow for the proper functioning of the equipment. A basic preventative maintenance procedure may be performed by the operator prior to the start of each work shift.

### a. Daily Maintenance (8 hours):

- Add a drop of lubricating oil to the stapler's magazine.



- Check the state of the two air filters “A” and “B” and drain any water if necessary.
- Check the level of air tool oil in the bowl “C”. Notify the maintenance department if necessary.



- Clean the machine to remove any dirt or accumulated dust.

## 3. MAINTENANCE MANUAL.

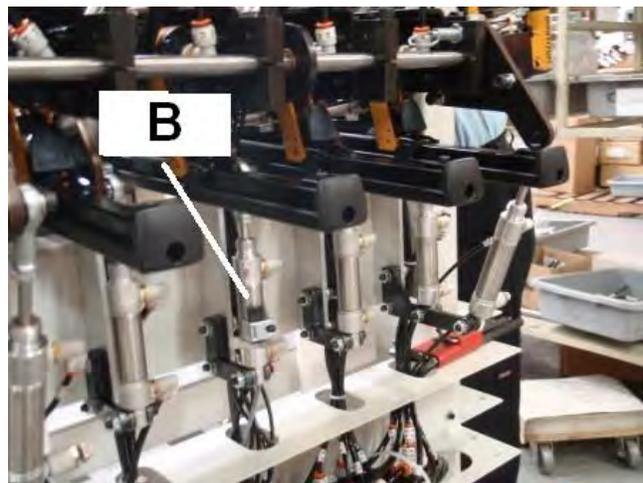
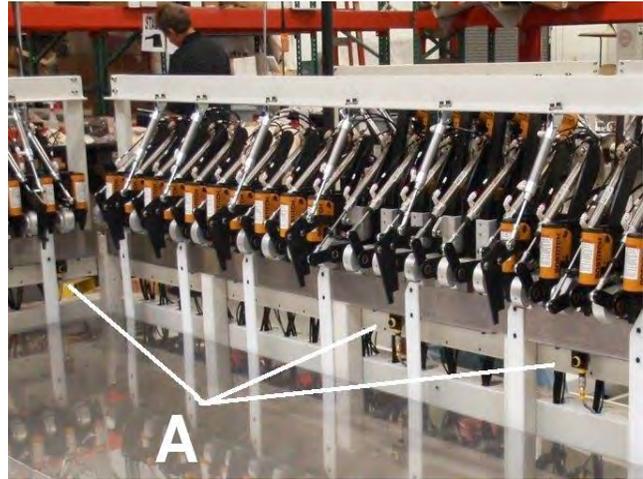


CAUTION: READ ALL OF THESE INSTRUCTIONS PRIOR TO OPERATING THIS MACHINE!

### 3.1. Operation Sequence.

The operator introduces a Foundation into the machine until the load sensors “A” on the sides of the machine are activated.

1. The tension wheels lower, the clamps lower, and the table begins the raising sequence.
2. At the moment the Foundation touches the tension wheels, the travel sensor “B” detects and halts the table from raising any further.
3. The clamp sequence begins followed by the tensioning sequence.
4. After finishing the tension sequence, the staplers are activated.
5. The clamp, tension and staplers return to their initial position.
6. The rotary plate lift up, allowing the operator to turn the Foundation to the other side.
7. The table returns automatically to the last stapler position.
8. The operator repeats the cycle.

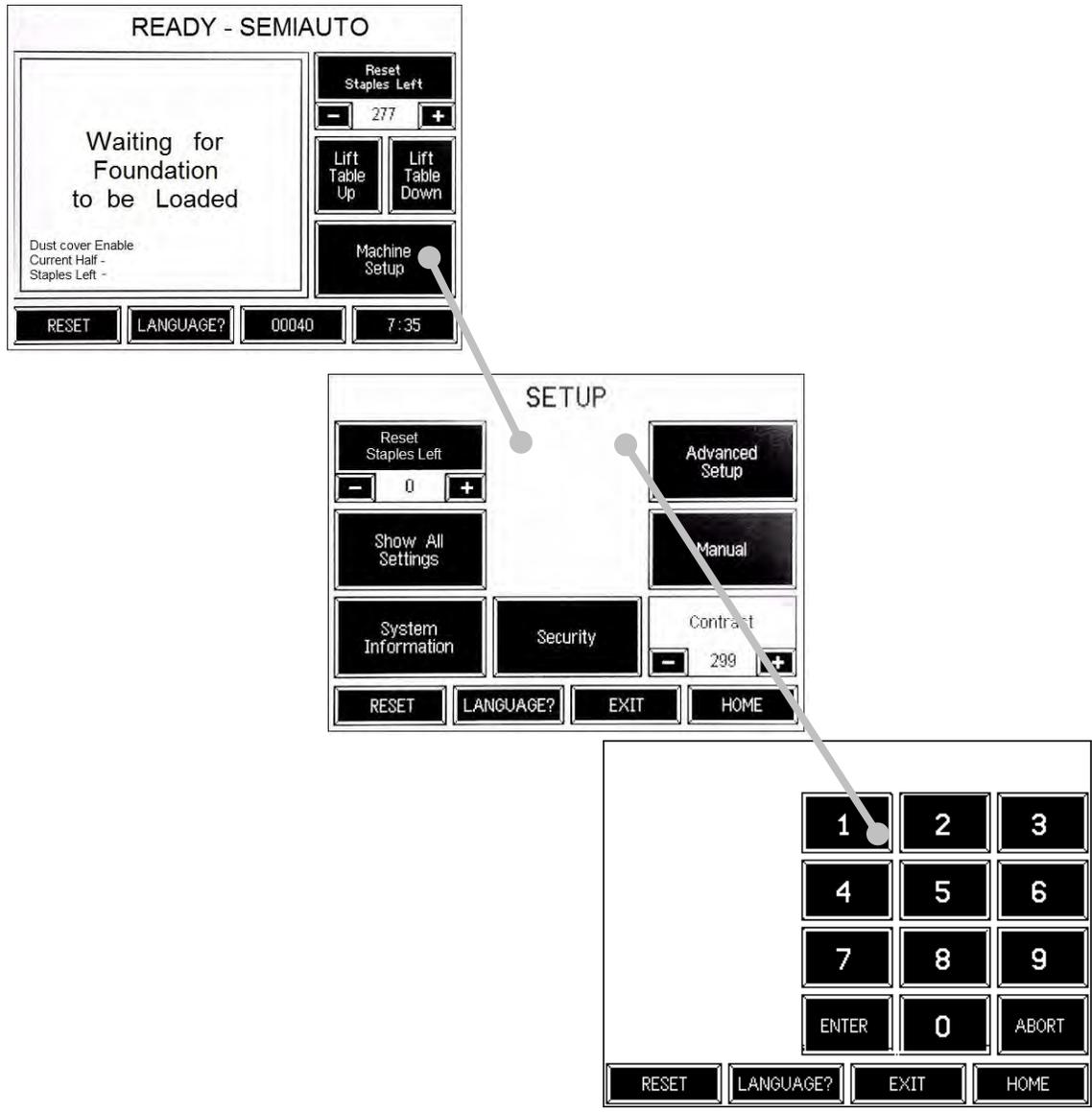


### 3.2. Control Panel

The touch screen is divided into two major categories: Functions accessible to the operator and advanced functions accessible to the technician. The advanced functions consist of five security levels: Supervisor, Mechanic, Chief Mechanic, Technician, and Engineer. To access the technical functions, a security key must be entered

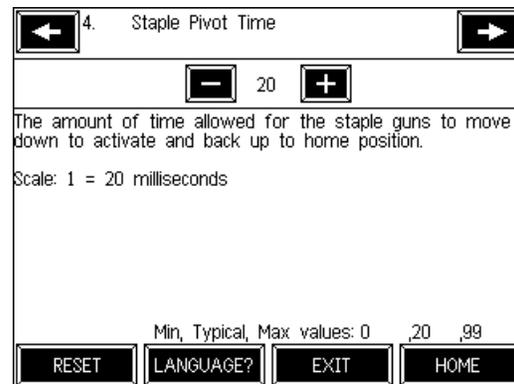
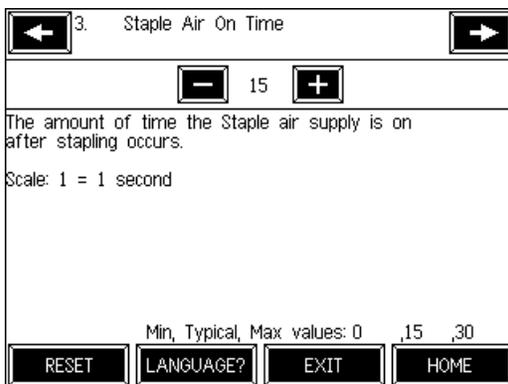
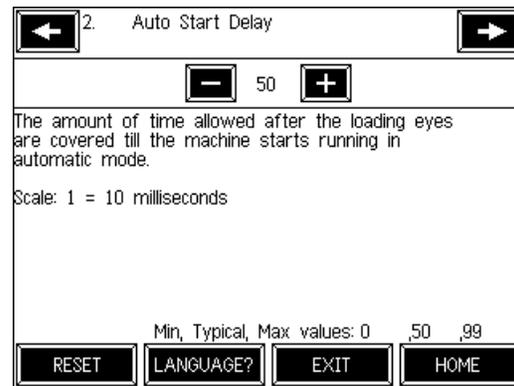
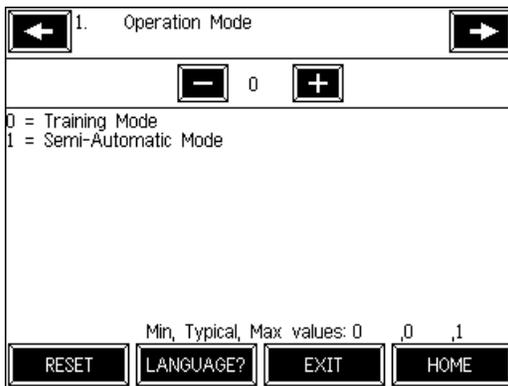
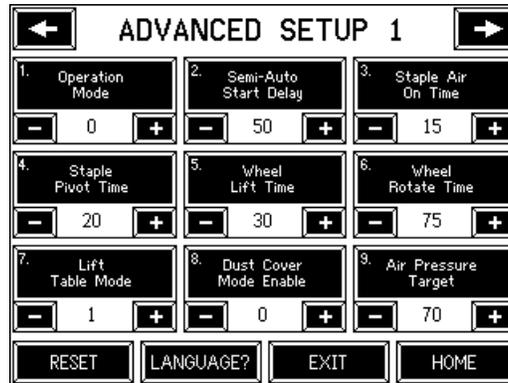
The [MACHINE ADJUSTMENTS] screen and [ADVANCED ADJUSTMENTS] screen require a verification key code. Using the correct key code will allow the [ADVANCED OPTIONS] screen to appear. The key code may be changed to any 5-digit number at the [SECURITY] screen.

In the normal operator's mode, a warning message is displayed when the machine encounters an error and presents various options to the operator to continue the resolve or continue machine's cycles.



## a. Advanced Set Up

This consists of two major series of screens. [ADVANCED SET UP 1] and [ADVANCED SET UP 2.] To navigate to the various screens, lightly tap the arrow buttons located at the upper corners of the touch screen.



5. Wheel Lift Time

- 30 +

The amount of time allowed for the wheel assemblies to move to the appropriate position. If set too low the table lift will not raise the table when needed.

Scale: 1 = 20 milliseconds

Min, Typical, Max values: 20 ,30 ,99

6. Wheel Rotate Time

- 75 +

The amount of time allowed for the wheel assemblies to pull the material tight.

Scale: 1 = 20 milliseconds

Min, Typical, Max values: 0 ,75 ,99

7. Lift Table Mode

- 1 +

0 = No Table Lift  
1 = Automatic Table Lift

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

8.- Dust Cover Cycle Enable

- 0 +

0 = DISABLE  
1 = Dust cover Mode  
2 = Staple Only Mode  
3 = Dual Staple Dust. Cover

Note: Mode 3 is and optional. Call Atlanta Attachment for more information

Valores Min, Normal, Max: 0 ,0 ,3

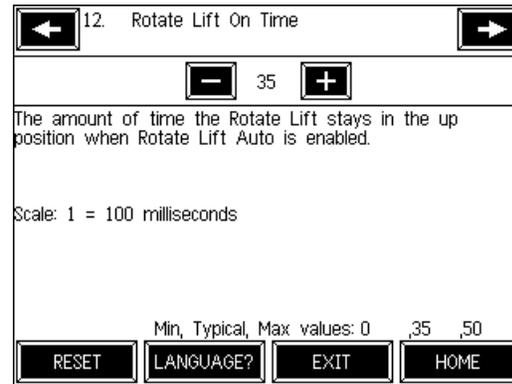
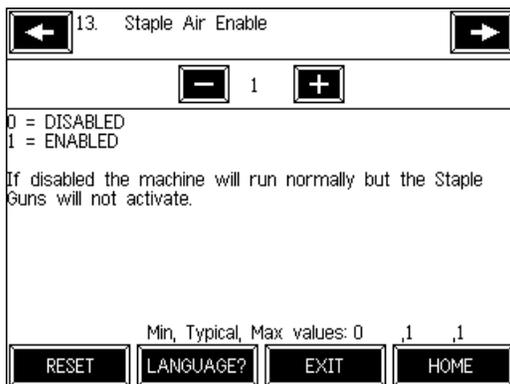
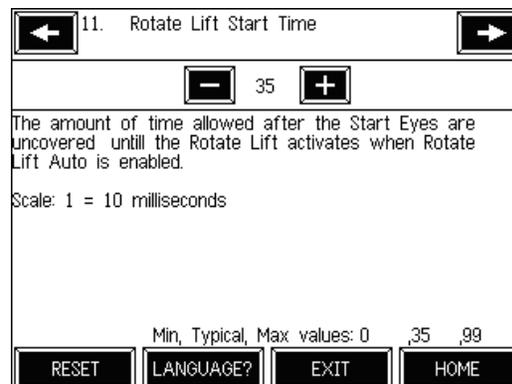
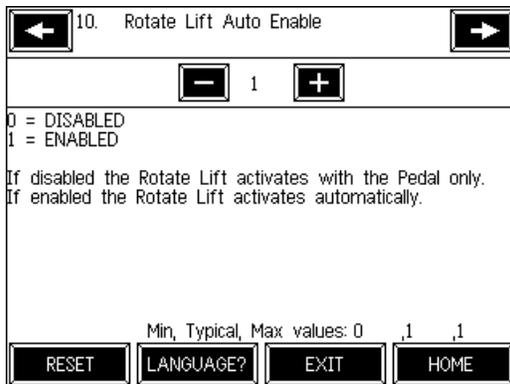
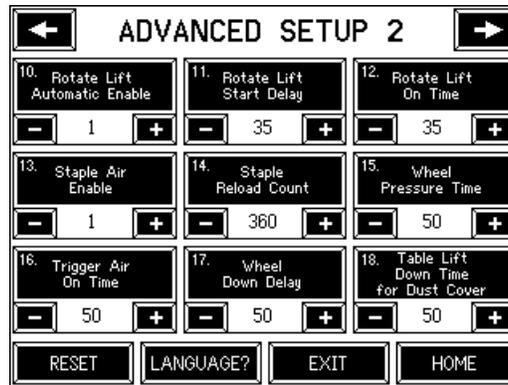
9. Air Pressure Target

Lower - 70 + Higher

This sets the minimum PSI of main air pressure that is normally supplied to the machine. If the air pressure is below this value, a warning will be displayed. Set to zero to disable checking.

Min, Typical, Max values: 0 ,70 ,100

The tension wheel counter is an option that is not found in most machines.



14. Staple Reload Count

- 360 +

The number of staples in each gun when it fully loaded.

Min, Typical, Max values: 150 ,360 ,500

RESET LANGUAGE? EXIT HOME

15. Wheel Pressure Time

- 50 +

The amount of time allowed for the wheel assemblies to re-apply pressure before stapling.

Scale: 1 = 2 millisecond

Min, Typical, Max values: 0 ,50 ,99

RESET LANGUAGE? EXIT HOME

16. Trigger Air On Time

- 50 +

The amount of time allowed for the Trigger mechanism to press the staple gun trigger.

Scale: 1 = 20 milliseconds

Min, Typical, Max values: 0 ,50 ,99

RESET LANGUAGE? EXIT HOME

17. Wheel Down Delay

- 50 +

The amount of time allowed between when the Edge Clamp moves down and the Wheels move down.

Scale: 1 = 20 milliseconds

Min, Typical, Max values: 0 ,50 ,99

RESET LANGUAGE? EXIT HOME

18. Table Down Time for Dust Cover Modes

- 50 +

The amount of time allowed for the table to move down during Dust Cover staple.

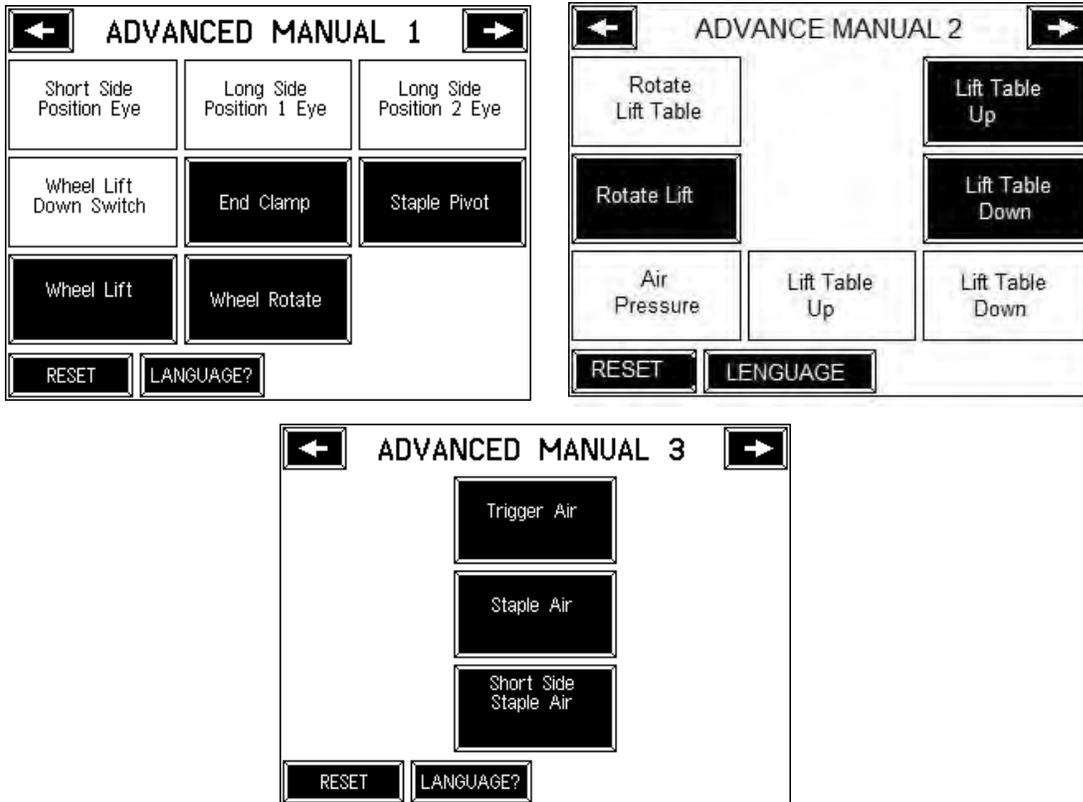
Scale: 1 = 10 milliseconds

Min, Typical, Max values: 0 ,50 ,99

RESET LANGUAGE? EXIT HOME

## b. Advanced Manual

This area of the program allows access to the Input and Output modules. There are three principal screens. To move between screens, tap the arrow buttons on the upper top corners of the touch screen



In the Input Sensor screen you can verify the function of the input sensors. A double line will appear on the sensor’s window indicating that the sensor is activated.

In the output screen you may activate the machine’s output devices (such as valves) by tapping the corresponding output control window.

 **ATTENTION:** Be extremely careful while manually activating output devices since this will activate various parts of the machine without any interlocking or safety controls of the main program. This may in some cases cause damage to the machine or to personnel.

 **NOTE:** The SHORT SIDE function in the advanced manual 3 is optional. Disconnect the short side of the stapling area. Work only if the correct hardware has been installed.

### c. Calibrating the Touch Screen

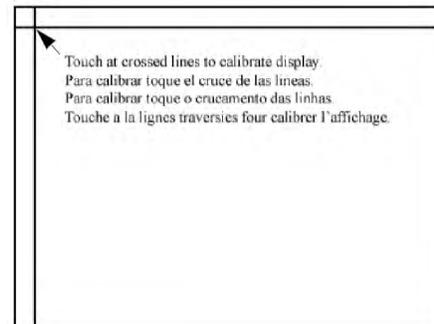
If you are having trouble with activation or button functions when touching the screen, a screen calibration may be required.

Proceed as following:

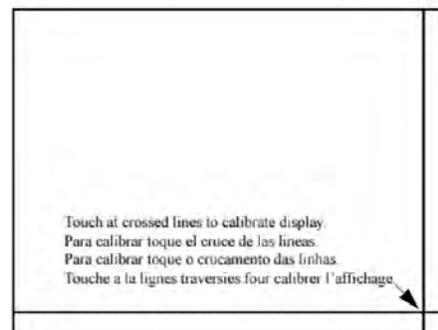
1. Place one finger on the screen and hold it while pushing the Green “ON” button.
2. When the screen turns light, remove your finger and the screen will display two lines, one vertical and one horizontal, intersecting at the top left corner. The text “Touch at the crossed lines to calibrate display” should appear in various languages. In older machines, there will be no text.
3. Using a small pointing device that will not puncture or damage the screen (such as a pencil eraser), touch the screen where the two lines intersect. Do this with as much accuracy as possible.



**NOTE:** Do not touch the screen with your palm or any other part of your hand during this process.



4. When the screen is touched, the display will change to two lines intersecting at the lower right of the screen.



5. Repeat step 4 where these lines intersect.



**NOTE:** The implementation of step 3 and step 4 directly affects the validity of all the buttons in the entire program. It is very important to be accurate.

Press the language button of your choice.

Press the RESET button at the lower left corner of the screen.



#### d. Installation of a new Touch Screen.

To program a new screen, these directions must be followed.

1. Install the new screen and turn the power on.
2. When the screen displays "Fatal Error Message" press continue.
3. Enter Mechanic Security Code.
4. After reading the "Warning Message" press continue again.
5. The screen will begin to process the up-loading of the existing program. This will take 60 - 90 seconds. Do not turn power off for any reason during this process.
6. After reading the "Last Warning Message" press continue again.
7. The Screen will begin to process information again for 15 - 30 seconds.
8. The reset routine will follow. Special note: Machine assemblies will reset or move to home positions.
9. The Screen will return to the Main Display and is ready to run.

## e. Standard Modules

### 1. Program Module...4080-150

Stores the program information. It is also used to load program modifications or updates. For update procedures please refer to the next chapter.



### 2. Memory Module...4080-970

Stores the unique data required to operate this particular machine; such as serial number, original factory parameters, etc. This module should never be exchanged with another machine.



### 3. Output Module...4080-140

Responsible for transferring signals from the computer to the working elements such as valves, motors and relays, etc.



### 4. Input Module...4080-110

Responsible for transferring signals from the machine to the computer such as switches, electric eyes, sensors, etc.



#### NOTE:

1. Even though all output and/or input modules within the machine are identical, they cannot be moved to another location on the serial bus cable, as the computer automatically assigns a working address for each one.
2. If a replacement is necessary, always replace with a new or loaner module from another machine.
3. Electrical Power to the machine must be turned "OFF" while replacing modules.
4. The computer will show an error if one or more modules are missing.

#### Procedure:

Remove the old module and connect the new one, after turning on the power, the computer will reassign the address to this new module.

## 5. Update a Machine using a New Program Module



**NOTE: Very Important**

Before starting the procedure below, go to Advanced Settings and write down all the settings shown in these screens. Do not skip this process!!

1. Turn off power to the machine.
2. Replace the existing Program Module with the Program Module that contains the updated program.
3. With your finger on the screen, turn power on to the machine. When the screen changes from dark to light, remove your finger from the screen.
4. Carefully calibrate the screen. See screen calibration.



**ATTENTION:** Do not turn off the machine during this process for any reason! Vital information will be corrupted and it will be necessary to the call manufacturer for assistance and/or return the touch screen and module for basic programming.

5. Press the “Update Controller” button. Input mechanic security code (33333). This process takes up to 5 minutes and will ask you to press the “Continue” button once during this time. When complete the Controller will contain the updated program.

Now that the process is complete, go to Advanced Settings and verify that the settings you wrote down at the beginning of the process were not changed. Make any necessary corrections.



**NOTE:** Continue to item 6 only if you need to reprogram the original module.

6. Turn off power to the machine.
7. Replace the Program Module that you installed in step #2 with the original Program Module that came with the machine.
8. With your finger on the screen, turn power on to the machine. When the screen changes from dark to light, remove your finger from the screen.
9. Carefully calibrate the screen.
10. Press the “Update Program Mod” button. Input the technician security code (xxxxx). This process takes up to 5 minutes. When complete the original Program Module that came with the machine and the Controller will contain the updated program.

## 3.3. Mechanical Adjustments

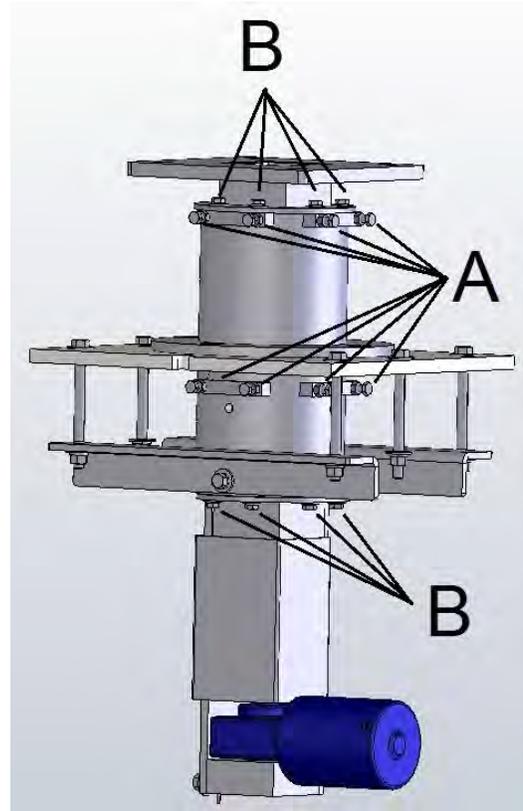
### a. Table

#### Readjustment of the Column Lift

**Rule:** The square table column has a lift height of 6 inches (15.24 cm). With time and usage, there may be wearing of the interior Teflon guides that support it and this may present problems at the moment of stretching or stapling the Foundation material. If the table begins to show signs of wear, then readjustment may be necessary.

**Adjustment:** Raise the table to its maximum height; loosen the nuts of the eight adjustment bolts “A”. Loosen the upper four bolts and the lower four bolts “B” of the Teflon support bars.

Lower the table to its lowest height. Lightly tighten the eight bolts “A” with decrease the areas of wear within the assembly. Raise and lower the table using the appropriate pedal to verify that the table moves freely. Adjust the bolts “A” again until the play in the table is as little as possible without binding the lift motor in its raised or lowering directions. Tighten the eight nuts of bolts “A” and the eight bolts “B” of the Teflon support bars.



#### Alignment and Leveling

**Rule:** The table should be aligned and leveled with respect to the machine’s frame.

**Adjustment:** Loosen the four bolts that support the table to the column lift “C” and rotate the table until it is square with the machine’s frame. If necessary, introduce shims under the table to realize the best parallelism as possible. Once you are square and parallel with the machine’s frame, secure the two white plastic blocks underneath the corners of the table to lightly touch the machine frame.



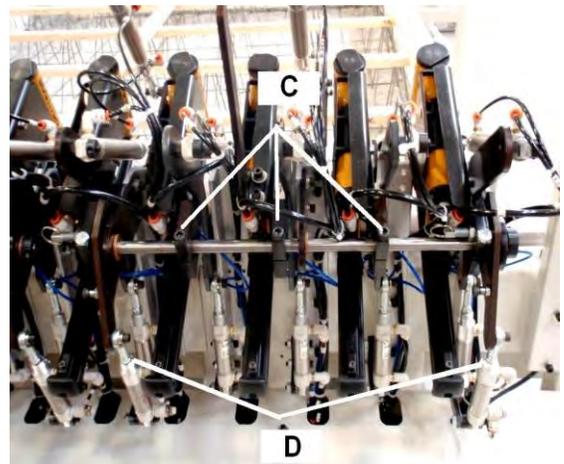
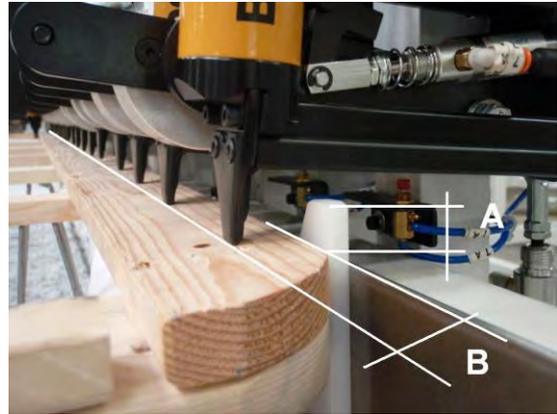
## b. Staplers.

**Rule:** The components and movement of the staplers should be free with no play.

Assuming that the table has been leveled and aligned with respect to the machine (see adjustment 3.2-a) and the staplers are all in the firing position, then all of the stapler's end points should be at the same height with respect to the table.

**Adjustment:** Introduce a Foundation frame into the machine and raise it until the distance "A" is 1/2 inch.

With the staplers located in their firing position, loosen the bolts on the activation cylinder shafts "D" and adjust the shaft until the exterior staplers rest on the wooden frame of the Foundation. Next, loosen the supports of the three interior staplers "C" and rest them on the wood as shown in the previous image. Tighten all of the bolts in this group and proceed to the next group until all of the staplers are at the same height. Remove the Foundation and verify that all of the staplers are at the same height.



**NOTE:** This should be checked weekly, as movement may occur, if guns assembly clips are not gently lowered back into position after staple loading



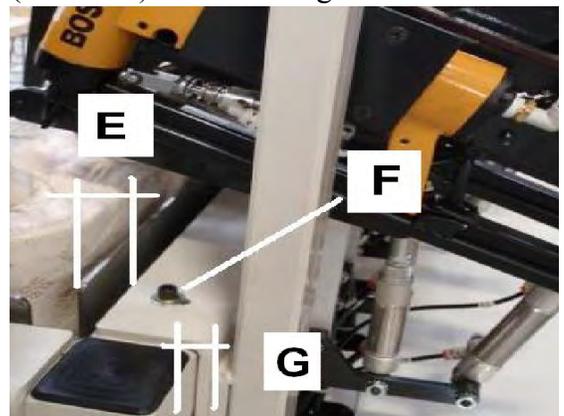
## c. Staple Position

**Rule:** The staples have been factory adjusted to 1/2 inch (12.7 mm) from the edge of the Foundation wooden frame ("B" in the previous image). The final position of the staples with respect to the Foundation's wooden border will depend on the customer's requirements.

**Adjustment:** The adjustment may be performed using two different methods

a. - Modifying the distance "E" from the stainless steel bar used as a stop for the Foundation sides and the machine's frame. To perform this method, loosen the bolts supporting the stainless steel bar underneath the machine.

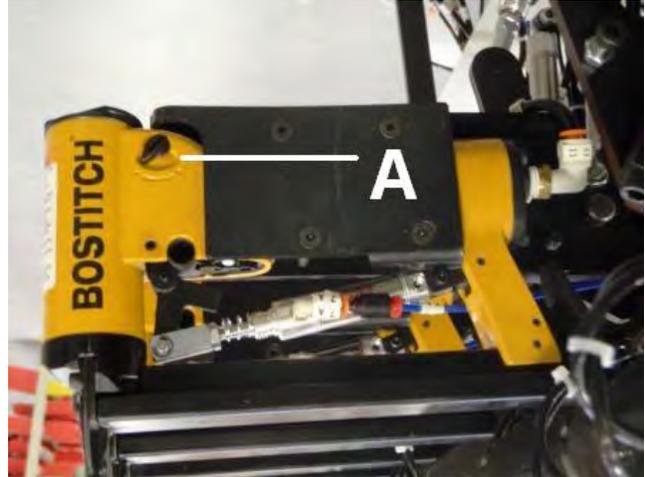
b. - Modifying the distance "G" from the stapler support and the machine's frame. To perform this method, loosen the bolts "F" and move until you achieve the required position.



## d. Firing Cylinder

**Rule:** The stapler should fire with sufficient speed and enough force for so that the staples penetrate deeply and securely into the wood.

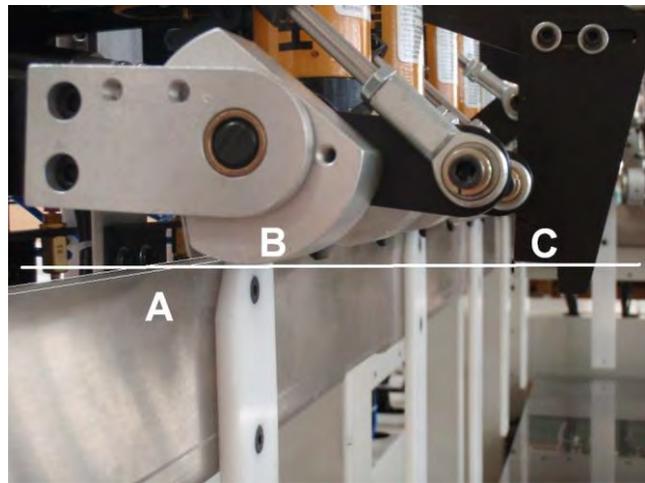
**Adjustment:** The stapler has an adjustment lever that controls the flow of air into the cylinder “A”. Move this lever toward the Maximum position (+)



## e. Tension Wheel.

**Rule:** The components and movement of the tension wheels should move freely but with no play.

In the activated position, the bottom of the tension wheels should be at the same height as the stainless steel bar “A” used as the Foundation stop.



**Adjustment:** Readjust all of the motion components of the tension wheels. Loosen the bolts on cylinders “A” and adjust the heights to comply with the rule.



**Rule:** The teeth of the tension wheels should rotate and stretch the material sufficiently to maintain adequate tension.

**Adjustment:** Adjust the stop rings on the tension wheel cylinder to measure 2.5 inches (6.35mm) as shown.



**Proximity Sensor.**

**Rule.** The table has a sensor to detect the material “A” that activates during the automatic cycles. The sensor should be activated when the tension wheel cylinder is fully extended and deactivated at 1/16 inch (2mm) on the cylinder return stroke.

**Adjustment:** Loosen the sensor and move to the recommended height.

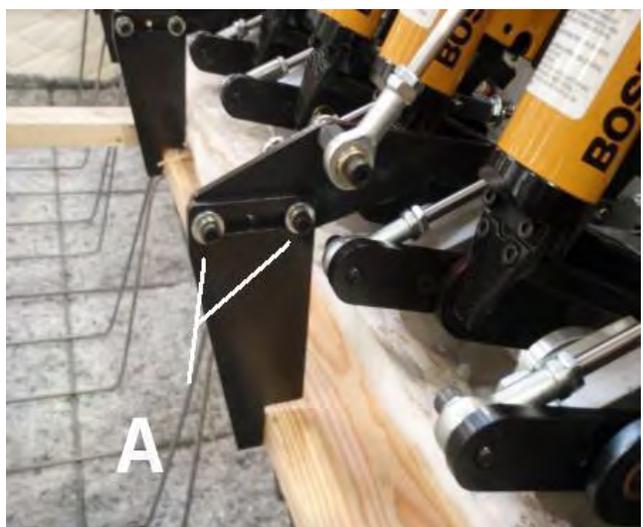


**f. Border Clamp Fingers**

**Rule:** The position of the fingers depends on the structure of the Foundation. The function is to maintain the frame against the machine nylon stops. The fingers should never sink in. There are many variations of clamp fingers and they may be modified to fit the profile of the wooden frame of the Foundation.

**Adjustment:** Lower the border clamp fingers, loosen the bolts “A” and position the fingers in the correct location. Generally the lateral arms are located in a different manner than those of the head border. Upon activation, the clamp arms should press the Foundation against the feed stops.

The clamp arms should only hold the Foundation. It



## 3.4. Pneumatic Pressure

The machine has four pressure regulators.

1. - Regulator “A” Controls the main pressure entering the machine. This pressure should be adjusted to 80 psi and should not decrease during machine operations. Should this happen then the air supply to the machine does not have sufficient capacity to run this machine.

2. - Regulator “B” Low Pressure for the Tension Wheel Down. Controls the force applied by the cylinder to the tension wheels at the moment of rotation.

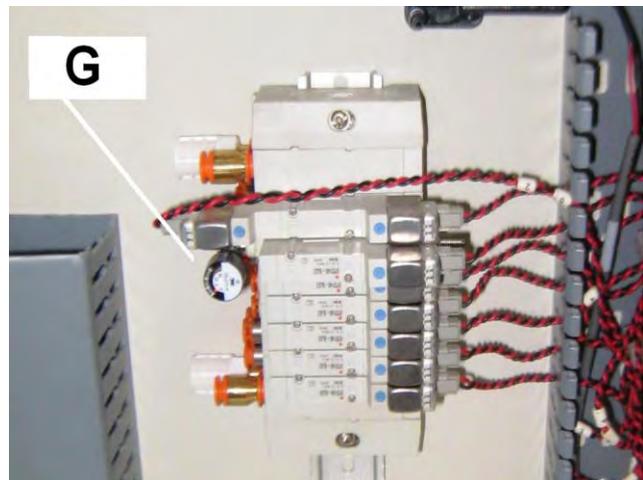
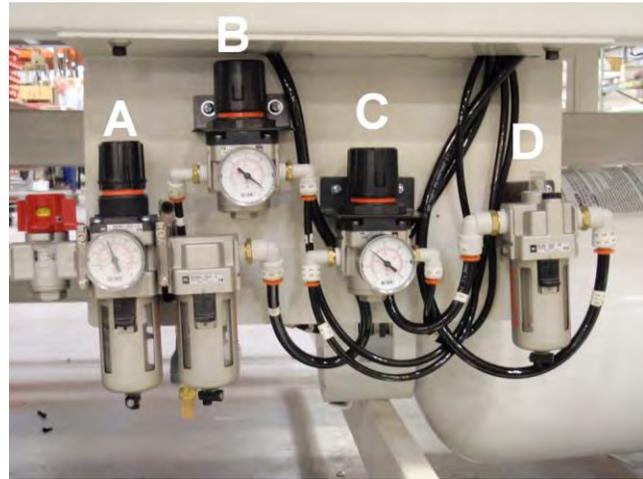
If the pressure is set too high then material damage may occur and the fingers may embed themselves into the wooden frame of the Foundation. If the pressure is too low then the tension wheels may slip while tensioning and may leave the material too loose. Factory setting 5-15 Psi

3. - Regulator “C” High Pressure for the Tension Wheel Down. Controls the force applied by the cylinder to the tension wheels down and up. Factory setting 30-40 psi

4. - Pressure Regulator “G” for the rotation of the tension wheels. The regulator is found in the wiring control cabinet at the rear of the machine. The factory setting is 55 psi.

If the pressure is too high then the border may be excessively stretched or the foundation may be pushed so hard that the end clamps cannot hold the foundation in. If the air pressure is too low, the material will not pull tight or will stay too loose or baggy.

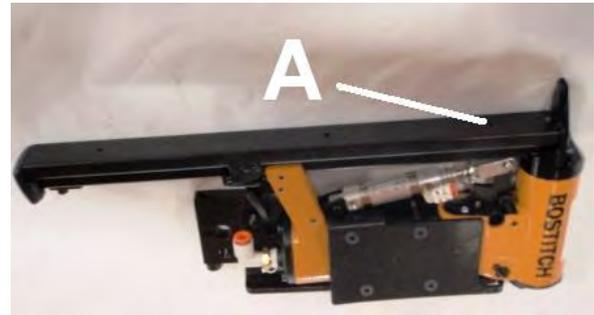
In the case of box spring Foundation, the Foundation will be flattened and in the case of material that does not stretch, this may cause a tear in that material.



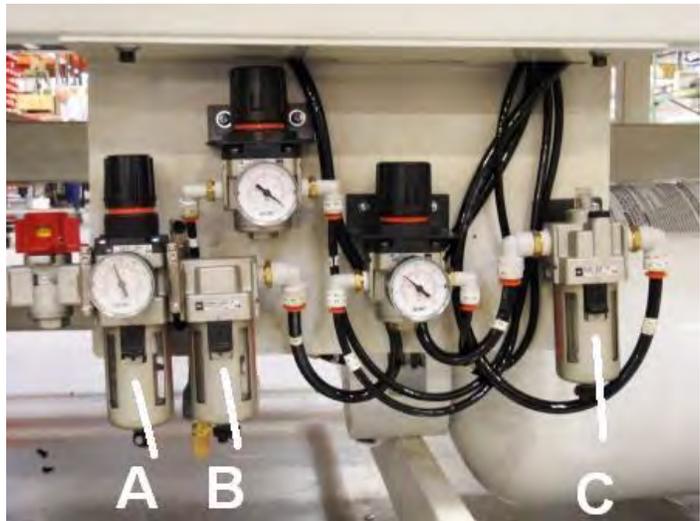
## 3.5. Preventive Maintenance

### a. Daily Maintenance (Every 8 hours):

- Place one drop of lubricant in the stapler magazine prior to the start of each work shift.
- Clean the machine of any dust or dirt that has accumulated.



- Check the state of air filters “A” and “B”. Drain water if necessary.
- Check the level of the lubricant in bowl “C”



### b. Weekly Maintenance (Every 40 hours):

- Lubricate all machine slides in the staplers, stretchers and Tension wheels.
- Use compressed air to blow out any dirt or debris that has accumulated in the machine.
- Check the state of air filters “A” and “B” and clean or replace as required. Drain water if necessary.
- Check the condition and level of the lubricating oil in bowl “C” and add or replace as required Adjust the oiler for one oil drop per every five (5) cycles. The oil drops may be viewed with sight glass “D” and adjusted with screw “E”.
- Check height and alignment of the gun assemblies



### **c. Monthly Maintenance (Every 160 hours):**

- Lubricate all machine slides in the staplers, stretchers and tension wheels.
- Use compressed air to blow out any dirt or debris that has accumulated in the machine.
- Check the state of air filters “A” and “B” and clean or replace as required. Drain water if necessary.
- Check the condition and level of the lubricant oil in bowl “C” and add or replace as required. Adjust the oiler for one oil drop per every five (5) cycles. The oil drops may be viewed with sight glass “D” and adjusted using screw “E”.
- Lubricate the column lifter and adjust the stabilizers if required.

### **d. Quarterly Maintenance (Every 960 hours):**

- Lubricate all machine slides in the staplers, stretchers and tension wheels.
- Use compressed air to blow out any dirt or debris that has accumulated in the machine.
- Replace air filter “A” and “B”. Drain the air accumulator
- Drain and refill the lubricant oil in bowl “C” Adjust the oiler for one oil drop per every five (5) cycles. The oil drops may be viewed with sight glass “D” and adjusted using screw “E”.
- Lubricate the column lifter and adjust the stabilizers

## 3.6. Problems and Solutions

### Problem

Machine will not start

Screen too light or too dark

Stapler does not function

Staples placed in wrong location

Automatic cycle will not activate

Cycle stops in middle of process

### Solution

Verify that the Emergency STOP button is not in the locked down position.

Verify electrical supply voltages

Adjust the screen CONTRAST.

Verify that the machine is not in a manual mode Verify that the machine is supplied with the proper air pressure.

Check stapler adjustments

Verify that the load sensors are functioning properly

Refer to error messages displayed in touch screen

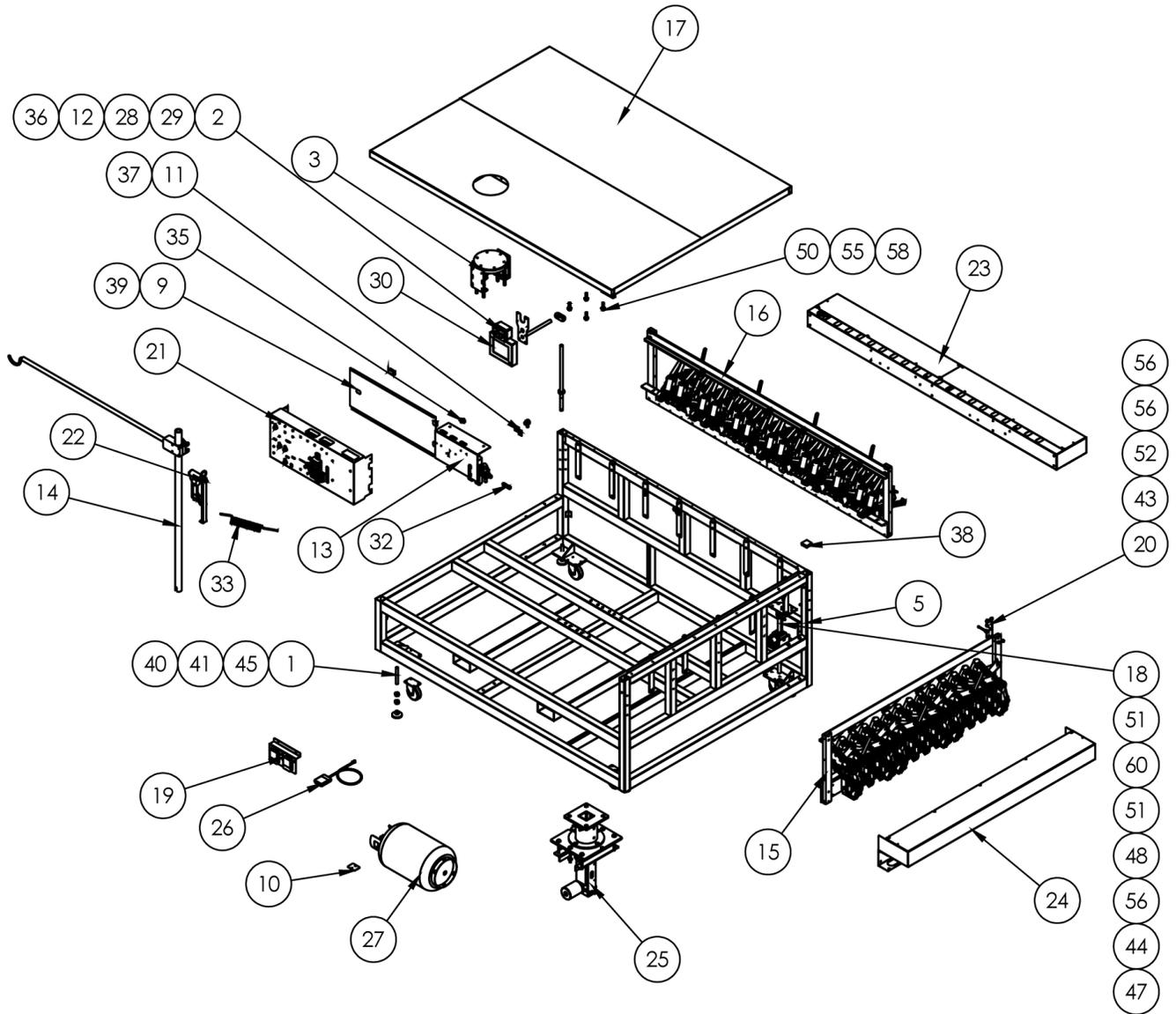


## Assembly Drawings & Parts Lists

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.



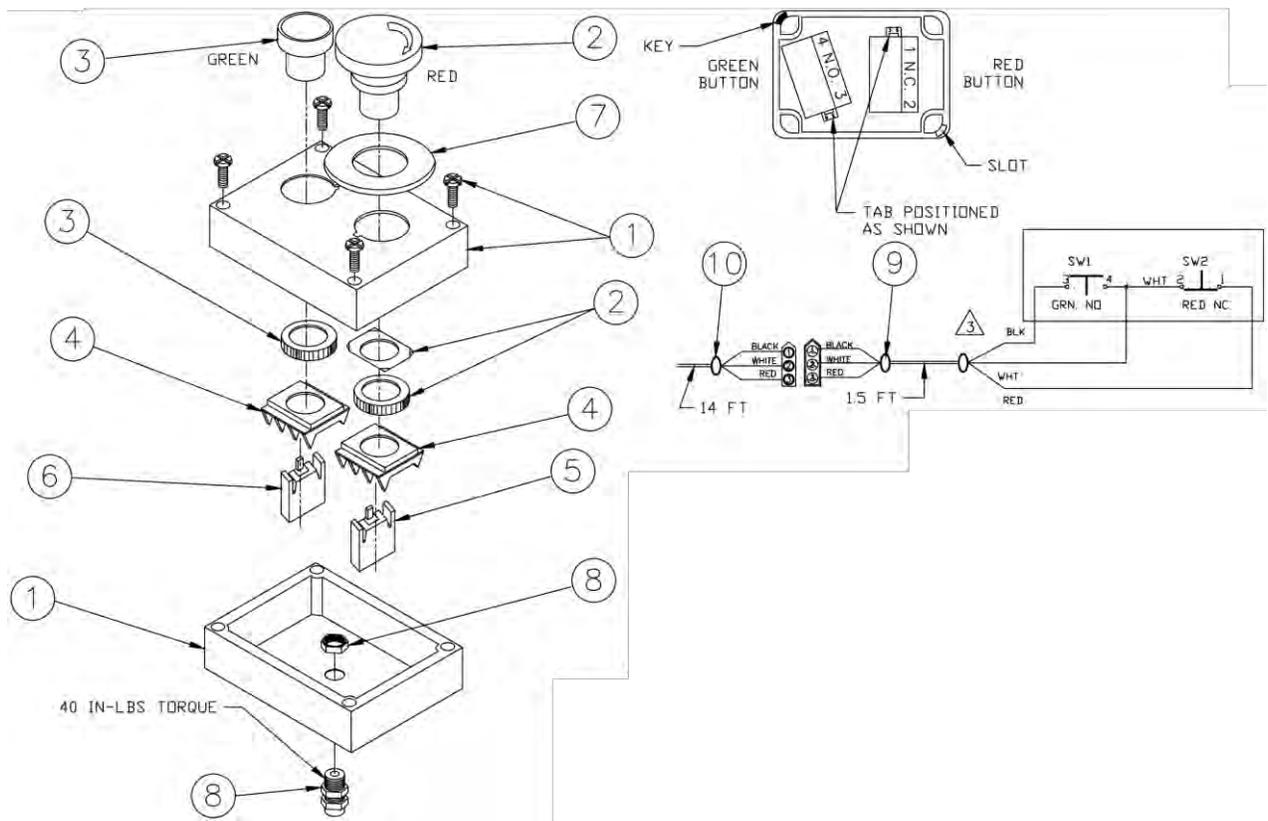
**One-Stop Shopping**  
For Expendable Replacement Parts for AAC & Other Bedding Equipment Suppliers  
Toll Free: **1-866-885-5100**  
[www.atlantapartsdepot.com](http://www.atlantapartsdepot.com) • [sales@atlantapartsdepot.com](mailto:sales@atlantapartsdepot.com)



# 1331230 Main Assembly

AAC Drawing Number 1331230 Rev 3

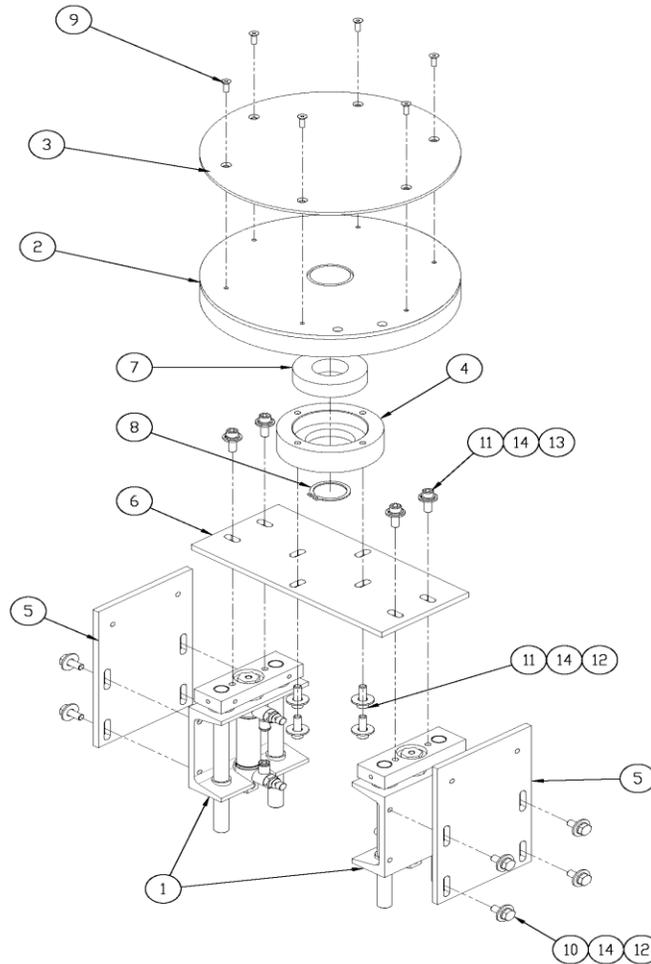
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION	
				32	1	AAVAKH11	VALVE,CHECK,3/8 TUBE	
Page 48	1	4	0411-1063	ROD, THREADED, 5/8-11 X 5	33	1	AAVBG35A	HOSE, COIL, 1/4" X 10 FT
Page 49	1	1	1278-6010	START/STOP BUTTON ASSY	34	1	AAVMJTV-3	VALVE,TOGGLE
	1	1	1331042	PIVOT LIFT ASSY.	35	1	AAVS125	SHUTTLE VALVE,1/8"PORT
	9	1	1331065	BUMPER, POSITION	36	1	CCCL12F	CLAMP COLLAR- 3/4
	1	1	1331127	BASE FRAME ASSY.	37	3	FFT18FF25Q	EYE,FIXED FIELD, 1IN
	1	1	1331136	BRKT,SIDE SUPPORT,SHORT	38	1	MM132-2X2A	END CAP, SQUARE, BLACK
	1	1	1331137	BRKT,SIDE SUPPORT,LONG	39	1	MM40450010	FASTENER,SLIDE LOCK
	3	1	1331138	BUMPER, POSITION, W/ EYE	40	4	MM431-4	CASTER,4",W/LOCKS
	1	1	1331158	DOOR	41	4	MML-2	LEVELING PAD, 5/8-11
	1	1	1331159	PLATE, AIR TANK LOCKING	42	2	MMSLD-ECH	1/2" DIA RUBBER BUMPER
	3	1	1331171A	BRKT, EYE, 1331B	43	4	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
	1	1	1331172	ROD,FLATTED,CRS,3/4ODX20L	44	4	NNK1/4-20	NUT,HEX,KEP,1/4-20,W/LOCK
Page 50	1	1	1331178	PNEUMATIC PANEL	45	8	NNSH5/8-11	NUT, SQUARE, 5/8-11
Page 51	1	1	1331185	OVERHEAD STAPLE GUN HLDR	46	24*	SSFC98024	#10-32 X .375 FLAT CAP
Page 53	1	1	1331219	STAPLE GUN ASSY,SHORT SD	47	2	SSHC01192	HEX HEAD BOLTS, 1/4-20 X
Page 61	1	1	1331220	LONG SIDE STAPLE GUN ASSY	48	2	SSHC01256	SCREW,HEX CAP
	1	1	1331224	TABLE TOP ASSY.,LEFT HAND	49	21*	SSHC05032	1/4-28 X 1/2 HEX CAP
Page 64	1	1	1331249	CORNER SUPPORT ASSY., LH	50	4	SSHC45112	1/2-13X1-3/4 HEX CAP
Page 65	1	1	1331504	PEDAL ASSY,TABLE LIFT	51	6	SSHC98048	SCREW, HEX CAP #10-32X.75
	1	1	1331556	BRKT,CORNER	52	4	SSSC01128	1/4-20 X 2 SOC CAP
Page 67	1	1	1331900	CONTROL BOX	53	2	SSSC90064	#8-32 X 1 SOC CAP SC
Page 68	1	1	1331914	MANUAL STAPLER ASSY.	54	2	WWF8	WASHER, FLAT, #8
Page 69	1	1	1331916	LONG SIDE TRACK ASSY.	55	4	WWFS1/2	WASHER,FLAT,SAE,1/2
Page 70	1	1	1331918	SHORT SIDE TRACK ASSY.	56	29*	WWFS1/4	WASHER,FLAT,SAE,1/4
Page 73	1	1	13452000C	TABLE, LIFT ASSY, SQUARE	57	6	WWFS10	WASHER, FLAT, #10, SAE
Page 71	1	1	1536-069A	FOOTSWITCH ASSEMBLY	58	4	WWL1/2	1/2 LOCK WASHER
Page 74	1	1	26254C	AIR RESERVOIR	59	21*	WWL1/4	WASHER,LOCK,1/4
	1	1	28201	CROSS BLOCK, LARGE	60	6	WWL10	WASHER,LOCK,#10
	1	1	40-112A	MOUNT, TOUCH SCREEN	61	2	WWL8	WASHER,LOCK,#8
	1	1	4080-004	CONTROLLER,SBUS,6.5",VGA				
	1	1	AAQMC-3-4	QUICK MALE CONNECTOR				



## 1278-6010 Start / Stop Button Assembly

AAC Drawing Number 191058B Rev 3

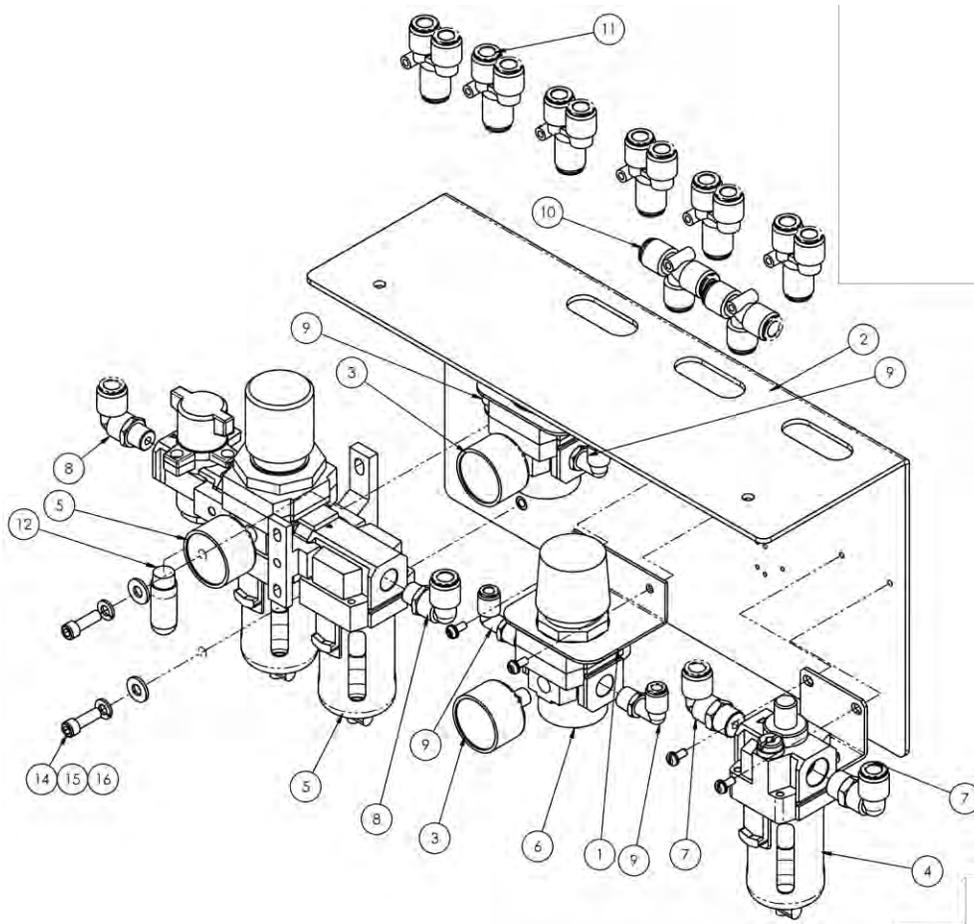
NO.	QTY	PART #	DESCRIPTION
1	1	EEPCB65GM	Enclosure Modif.
2	1	EEPMTS44	E-Stop Button
3	1	EEPF3	Start Button
4	2	EEA3L	Mounting latch
5	1	EE3X01	Contact Block N.C.
6	1	EE3X10	Contact Block N.O.
7	1	EE15Y	Legend Plate
8	1	FF3210	Strain Relief
9	1	4080-4214	Cable
10	1	4080-4215	Cable



## 1331042 Pivot Lift Assembly

AAC Drawing Number 1331042 Rev 1

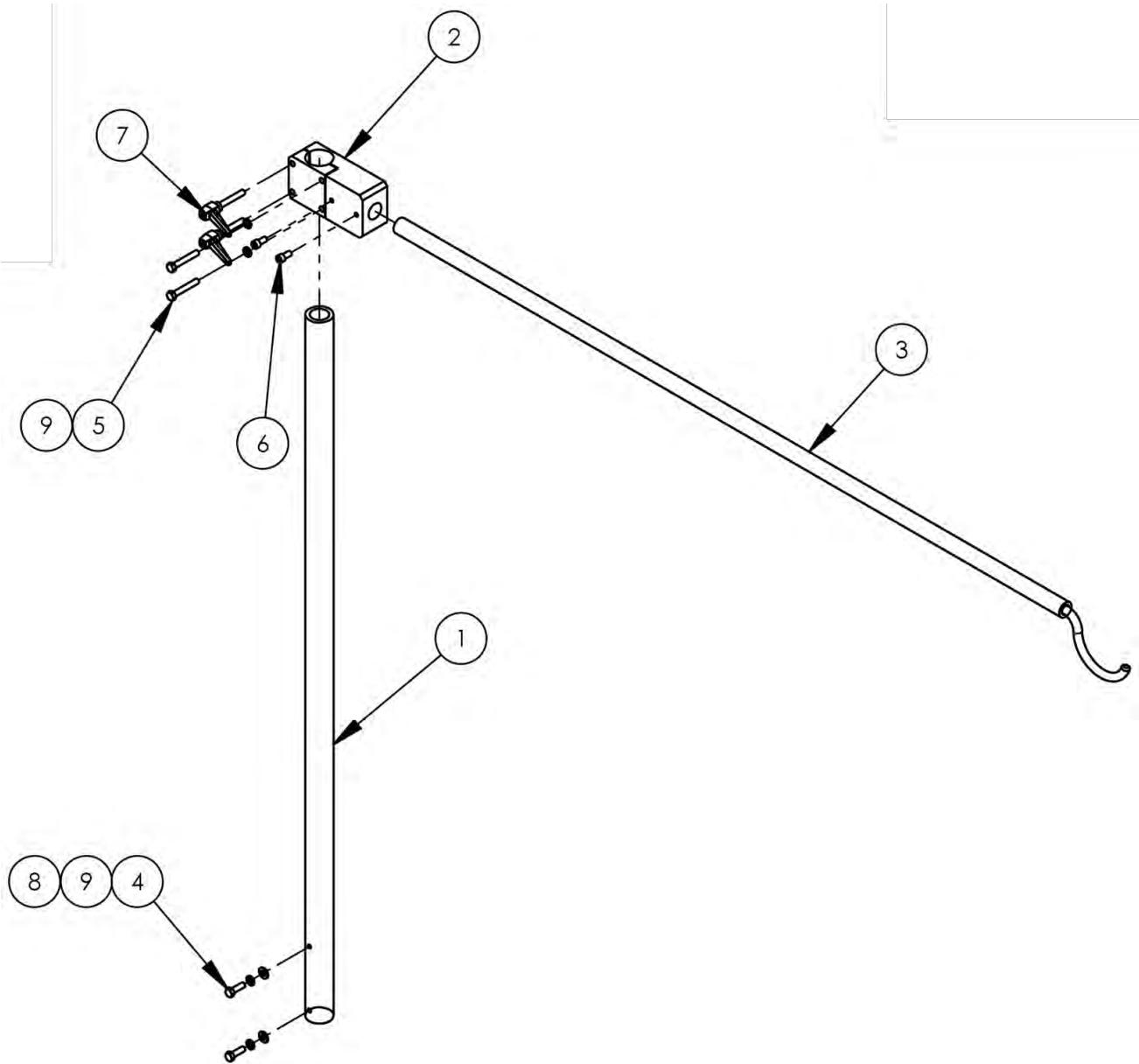
NO.	QTY	PART#	DESCRIPTION
1	2	1331040	ROTATE LIFT CYL ASSY.
2	1	1331041	ROTATION PLATE ASSY
3	1	1331068	PLATE, TABLE TOP, UPPER
4	1	1331071	HUB, BEARING
5	2	1331111	MOUNT, FOUNDATION LIFT
6	1	1331161	MOUNT, ROTATION PLATE
7	1	BB62062RS1	BEARING,BALL,DP GROOVE
8	1	MMSH-118	RING,SNAP,EXT.1.188S,
9	6	SSFC90032	8-32 X 1/2 FLAT ALLEN CA
10	8	SSHC01040	1/4-20 X 5/8 HHCS
11	8	SSSC01048	1/4-20 X 3/4" SOC CAP SC
12	12	WWF1/4	WASHER, FLAT, 1/4", COM
13	4	WWFS1/4	WASHER,FLAT,SAE,1/4
14	16	WWL1/4	WASHER,LOCK,1/4



## 1331178 Pneumatic Panel

AAC Drawing Number 1331178 Rev 4

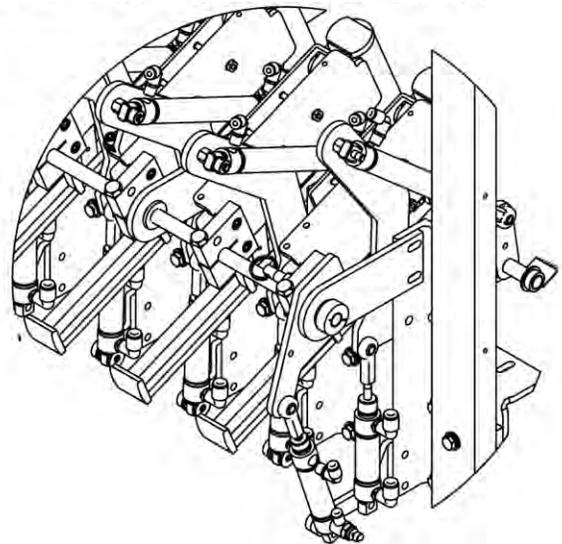
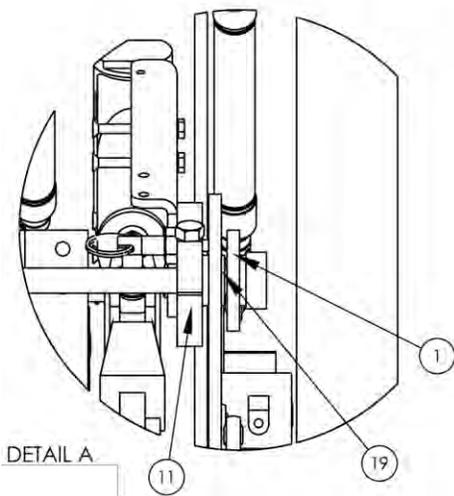
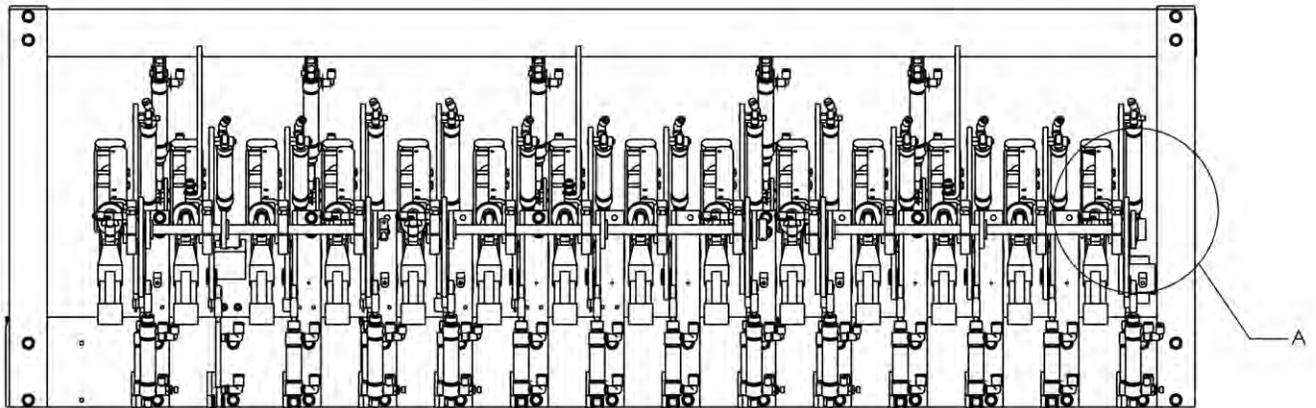
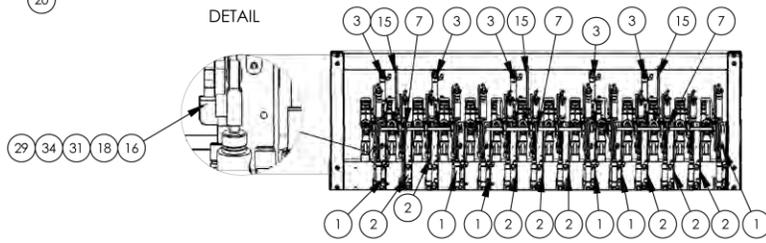
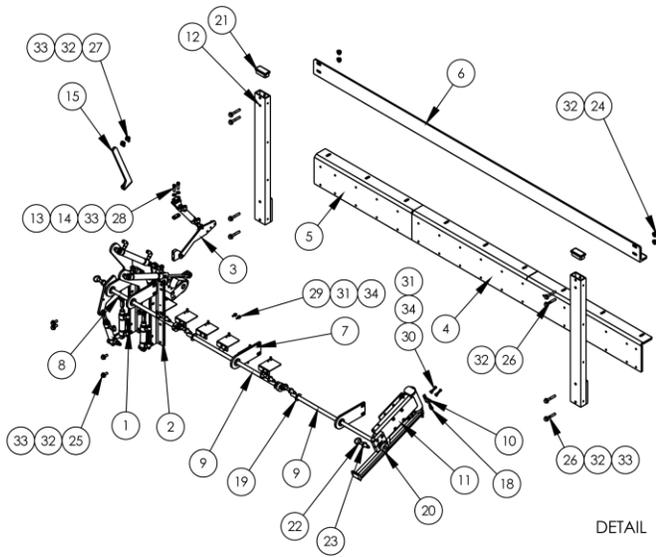
NO.	QTY	PART #	DESCRIPTION
1	2	0411-071	BRKT,REGULATOR
2	1	1331175	BRKT, AIR REGULATOR
3	2	AA198-503	0-30PSI AIR GAGE 1/8NPT
4	1	AA198-509A	LUBRICATOR,AIR,3/8" PORT
5	1	AA198-5110	FILTER/REGULATOR/LOCKOUT
6	2	AA198-RP3	REGULATOR,PRECISION AIR
7	2	AAQME-3-3	MALE ELBOW 3/8 OD TUBE
8	2	AAQME-3-4	MALE ELBOW 3/8OD TUBE
9	4	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT
10	2	AAQUT-3-3	QUICK UNION T 3/8X3/8
11	6	AAQUY-3-3	QUICK UNION Y 3/8 X 3/8
12	1	MMU002A	MUFFLER,PAPER,1/4"
13	6	SSPS90024	#8-32 X 3/8 LG PAN HD
14	2	SSSC01048	1/4-20 X 3/4" SOC CAP SC
15	2	WWFS1/4	WASHER,FLAT,SAE,1/4
16	2	WWL1/4	WASHER,LOCK,1/4
17	6	WWSI8	WASHER,INT. TOOTH,8



## 1331185 Overhead Staple Gun Holder

AAC Drawing Number 1331185 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1331186	TUBE, 1-5/8 OD X 54 L
2	1	1331188	BLOCK, CLAMP-T
3	1	1331192	ARM WELDMENT, GUN HLDR
4	2	SSH10064	5/16-18 X 1" HEX HEAD
5	2	SSH10128	5/16-18 X 2 HEX HEAD
6	4	WWL10	WASHER, LOCK, #10, S/S
7	2	TTH32429	HANDLE, THRD, 5/16-18X2.0
8	2	WWFS5/16	WASHER, FLAT, 5/16



# 1331219 Staple Gun Assembly, Short SD

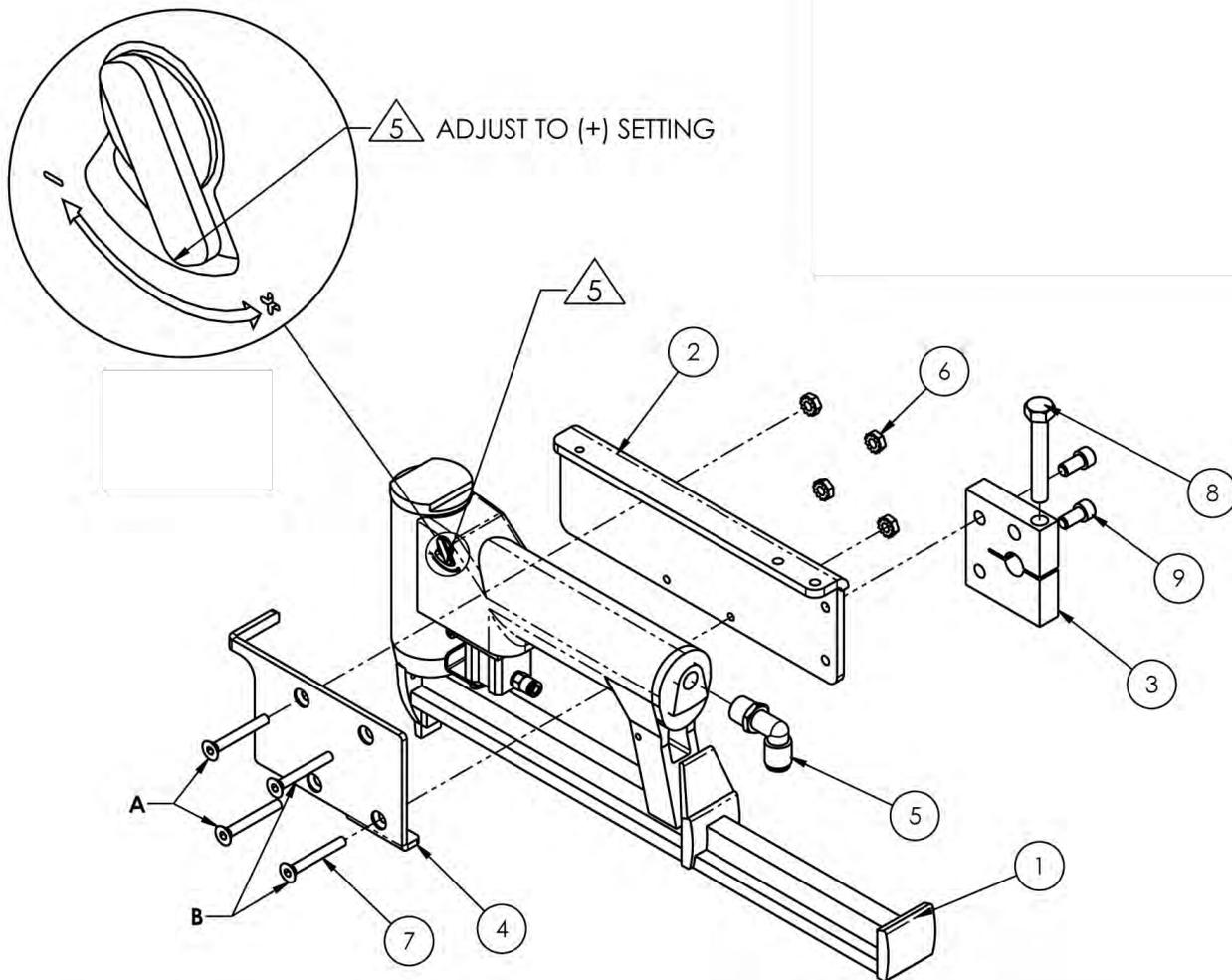
AAC Drawing Number 1331219 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	6	1331079	COVER STRETCH ROLLER ASSY
2	8	1331080	COVER STRETCH ROLLER ASSY
3	5	1331094	TOP CLAMP
4	1	1331133	MOUNT,WHEEL ASSY,INNER
5	1	1331134	MOUNT, WHEEL ASSY, OUTER
6	1	1331196	BEAM,CLAMP CYL MTG,SHORT
7	3	1331312	PLATE, SUPPORT STAPLE
8	1	1331318	ROD,STR,60C1/2X14.0L
9	2	1331319	ROD,STR,60C,1/2X18.0L
10	1	1331345	BRKT,VALVE MNT
11	14	1331349	STAPLE GUN ASSY
12	2	1331720	WELDMENT,CLAMP FRAME SUPP
13	5	1331724	PLATE,NUT,1/4-20X2
14	5	1331725	PLATE,WASHER,.266@.75
15	3	1331727	HANDLE
16	7	1331730	BKRT, VALVE MNTG.
17	10.5	AATP1/16B	1/16 ID TUBING
18	8	AAVSMVAV-3	VALVE,SUB MIN,3-WAY SPOOL
19	5	BBTT1001	WASHER,THRUST,BRONZE
20	3	CCCL8F	CLAMP COLLAR- 1/2
21	2	MM132-1496	PLUG 1 X 2
22	6	MM8487A31M	PIN,QUICK RELEASE, MOD.
23	6	NNJ3/8-16	3/8-16 JAM NUT
24	4	NNK1/4-20	NUT,HEX,KEP,1/4-20,W/LOCK
25	38	SSHC01048	1/4-20 X 3/4 HEX CAP
26	8	SSHC01112	HEX HEAD BOLT 1/4-20X1.75
27	6	SSSC01040	1/4-20 X 5/8" SOC CAP SC
28	10	SSSC01048	1/4-20 X 3/4" SOC CAP SC
29	14	SSSC90032	#8-32 X 1/2 SOC CAP SC
30	2	SSSCM4X12	SCREW,SOC CAP,M4-0.7X12
31	16	WWF8	WASHER, FLAT, #8
32	56	WWFS1/4	WASHER,FLAT,SAE,1/4
33	58	WWL1/4	WASHER,LOCK,1/4
34	16	WWL8	WASHER,LOCK,#8

Page 57

Page 59

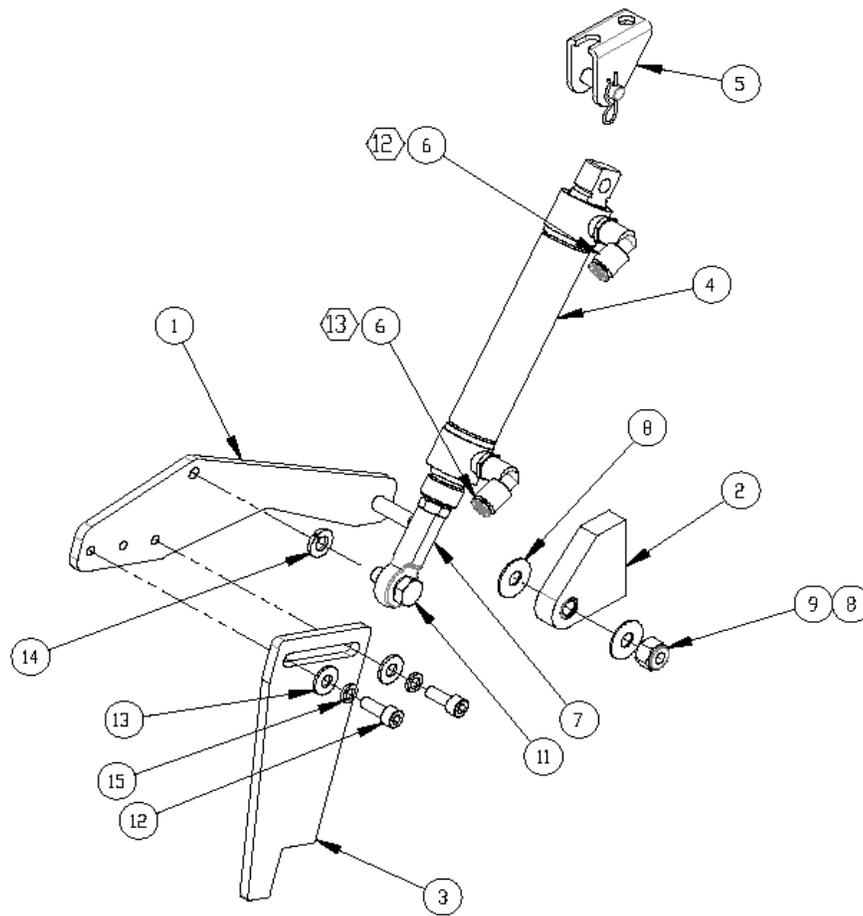
Page 54



## 1331349 Staple Gun Assembly

AAC Drawing Number 1331349 Rev 5

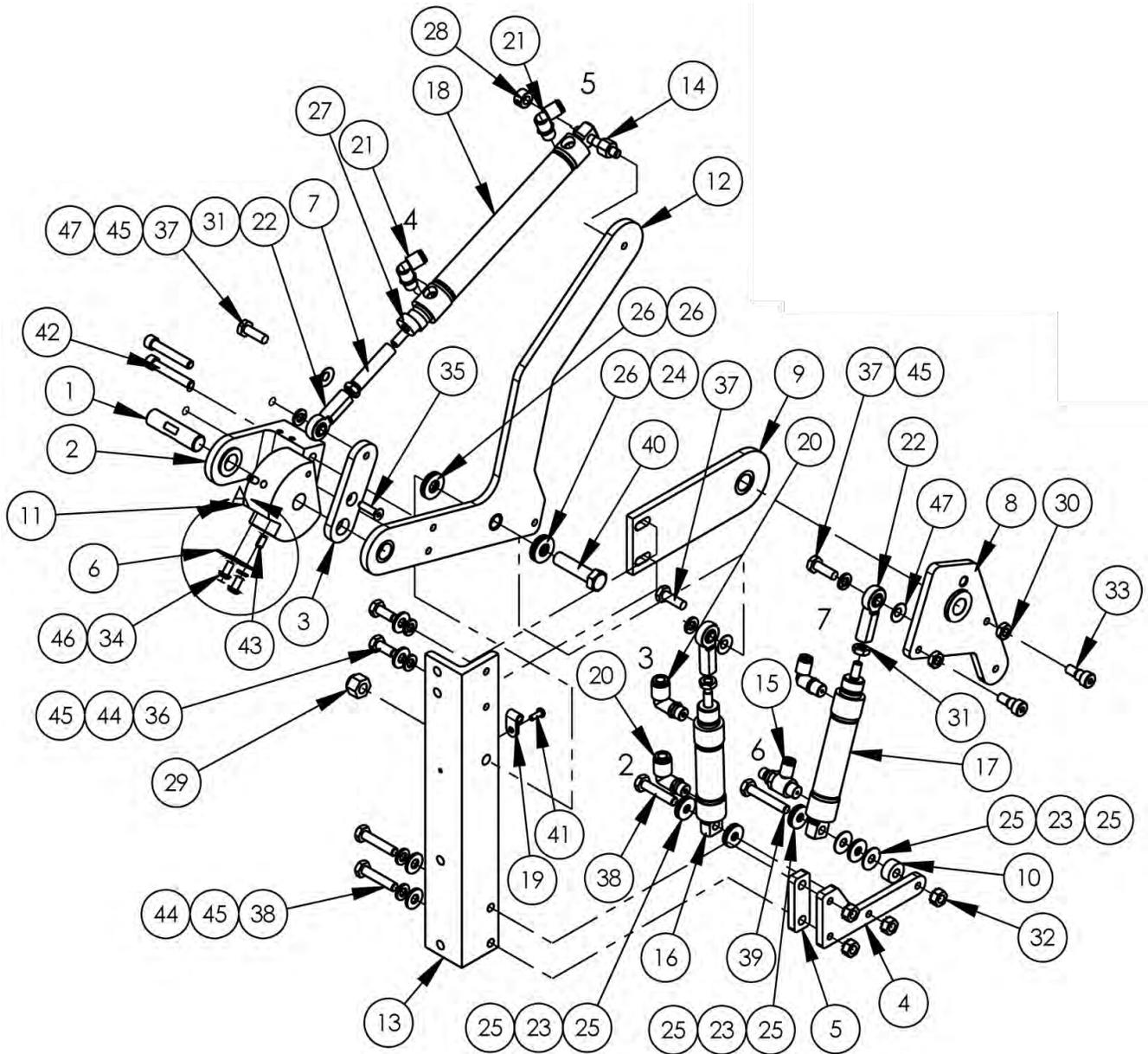
NO.	QTY	PART #	DESCRIPTION
1	1	1331282	STAPLER ASSY WITH CYL
2	1	1331308	PLATE, MNT. STAPLE GUN
3	1	1331310	CLAMP, STAPLE PIVOT
4	1	1331338	PRESSURE PLATE
5	1	AAQME-4-4	ELBOW, MALE, 1/4X1/4NPT
6	4	NNK10-32	KEP NUT, 10-32
7	4	SSFC98096	10-32 X 1-1/2 FLAT ALLEN
8	1	SSHC10128GR8	SCREW, HEX CAP, 5/16-18X2, GR8
9	2	SSSC01032	1/4-20X1/2 SOC CAP



## 1331094 Top Clamp

AAC Drawing Number 1331094 Rev 4

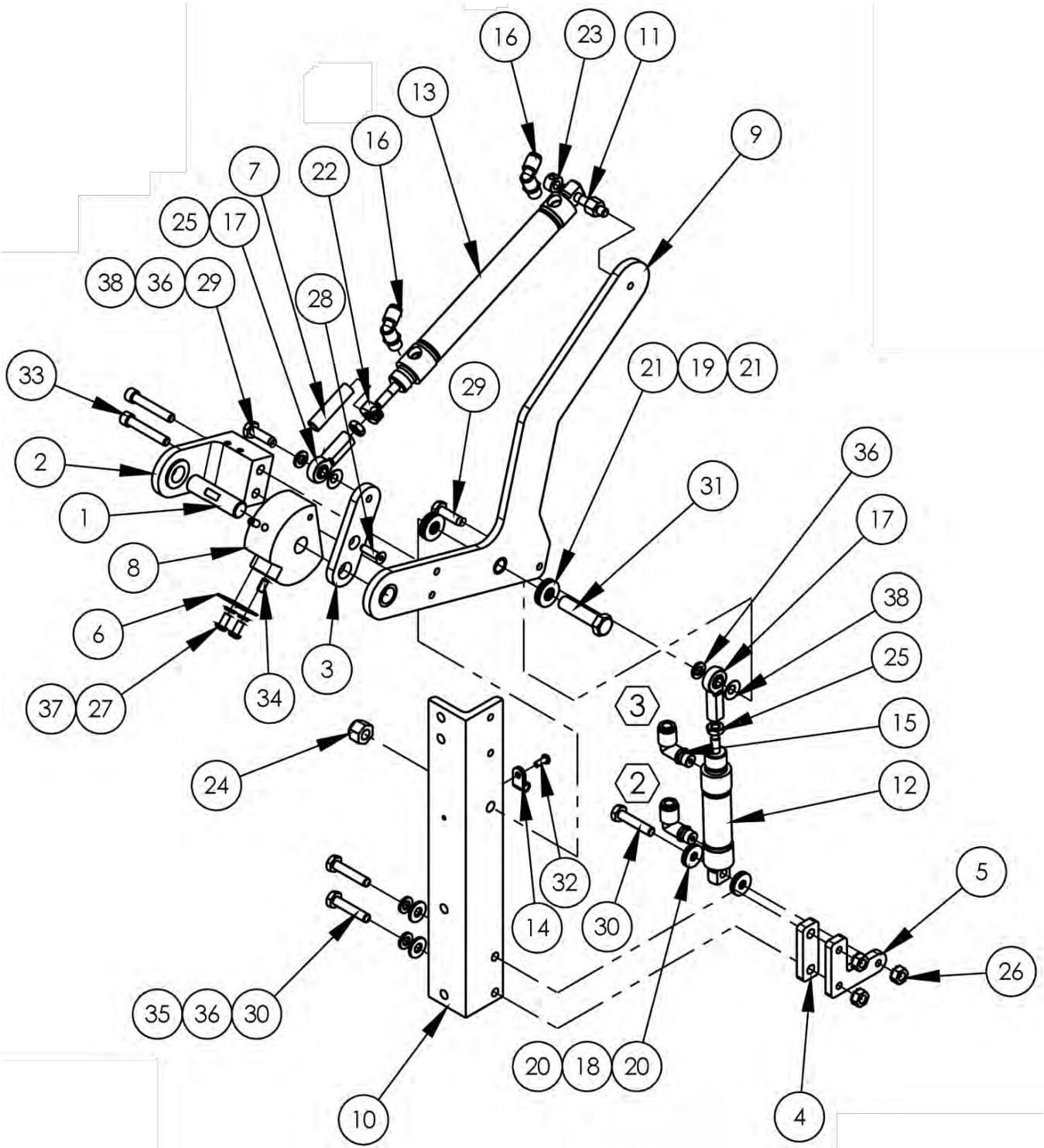
NO.	QTY	PART#	DESCRIPTION	NO.	QTY	PART#	DESCRIPTION
1	1	1331262	FINGER,CLAMP	9	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
2	1	1331263	BAR,SLIDE MTG	10	1	NNJ1/4-28	1/4-28 HEX JAM NUT
3	1	1331269	FINGER,CLAMP	11	1	SSHCO1040	1/4-20 X 5/8 HHCS
4	1	AAC7DP-2	CYLINDER,AIR,DA	12	2	SSSC98032	10-32X1/2, SOC CAP
5	1	AAFBP-11C	BRKT,PIVOT,1/4 BORE	13	2	WWFS10	WASHER, FLAT #10
6	2	AAQME-5-8	QUICK MALE ELBOW	14	1	WWL1/4	WASHER,LOCK,1/4
7	1	BBAW-4	BEARING,ROD END	15	2	WWL10	WASHER,LOCK,#10
8	2	BBTRA411	WASHER,THRUST,STEEL				



# 1331079 Cover Stretch Roller Assembly

AAC Drawing Number 1331079 Rev 5

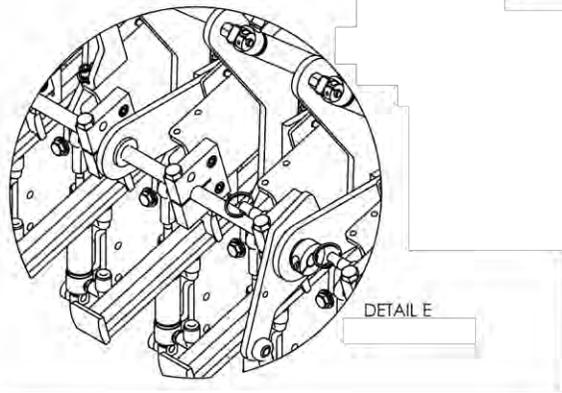
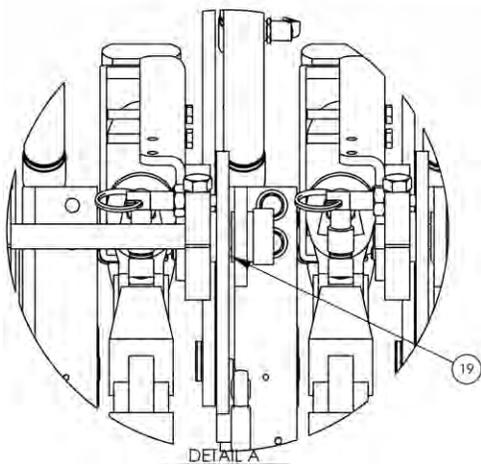
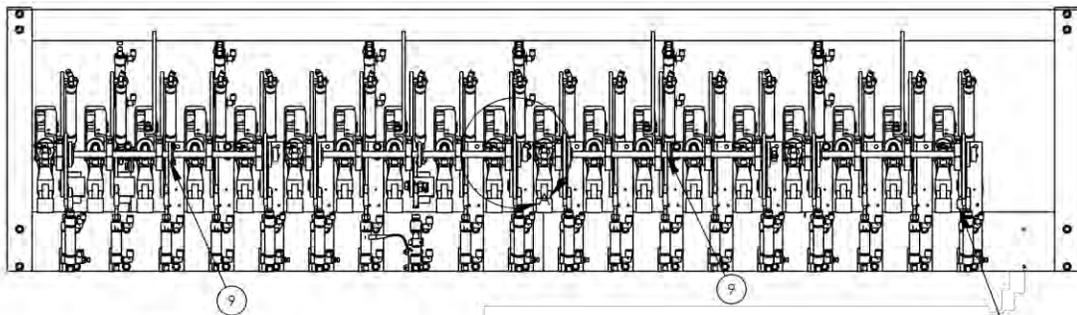
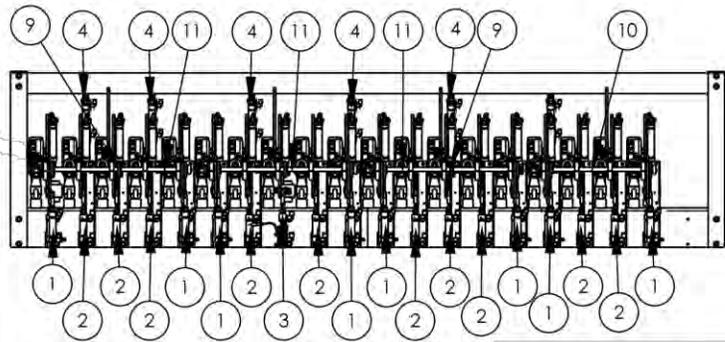
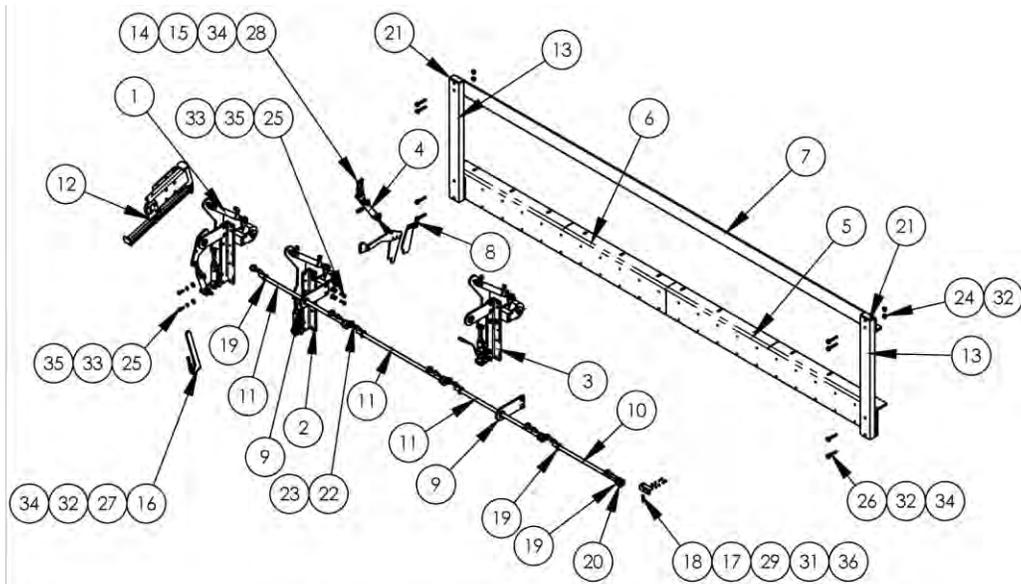
NO.	QTY	PART #	DESCRIPTION
1	1	1331204	SHAFT, TENSION WHEEL
2	1	1331205	YOKE, TENSION WHEEL
3	1	1331206	PIVOT ARM, TENSION ROLLER
4	1	1331210	BRKT, AIR CYL
5	1	1331212	SPACER,1/4X5/8X1.88X1.250
6	1	1331216	BLADE, BORDER TENSION
7	1	1331285	SLEEVE,STOP,TENSION CYL.
8	1	1331311	ARM, STAPLE PIVOT
9	1	1331312	PLATE, SUPPORT STAPLE
10	1	1331313	SPACER, .257IDX.63OD
11	1	1331712	WHEEL, TENSION
12	1	1331714	ARM,TENSION WHEEL
13	1	1331715	TENSION ROLLER MT ANGLE
14	1	1331718	STUD,CYL MTG
15	1	AA198RA508	FLOW CONTROL,5/32 X 1/8"
16	1	AAC7DP-.5	CYLINDER,AIR,DA
17	1	AAC7DP-1	CYL.,AIR,DA 3/4 BORE,1STR
18	1	AAC7DP-4R	CYL,AIR,DA,90 DEG PORTS
19	1	AAF3/16	CLAMP, BLACK PLASTIC
20	2	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8
21	3	AAQME-5-8	QUICK MALE ELBOW
22	3	BBAW-4	BEARING,ROD END,FEMALE
23	4	BBNTA411	BEARING,THRUST,.250B
24	2	BBNTA613	BEARING,THRUST,375BORE
25	8	BBTRA411	WASHER,THRUST,STEEL
26	4	BBTRA613	WASHER,THRUST,STL, .375B
27	1	CCCL4F	COLLAR,1/4,CLAMP
28	1	CCSC41/4	COLLAR,SET 1/4"
29	1	NNE3/8-16	NUT, ELASTIC 3/8-16
30	2	NNJ1/4-20	NUT, HEX, JAM, 1/4-20
31	3	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
32	4	NNK1/4-20	KEP NUT, 1/4-20
33	2	SSAS020016	SHOULDER BOLT 1/4 X 1/4L
34	2	SSBC98024	10-32 X 3/8 BUTTON CAP SC
35	1	SSFC98048	#10-32 X .75 SHCSF
36	2	SSHC01040	1/4-20 X 5/8 HHCS
37	3	SSHC01048	1/4-20 X 3/4 HEX CAP
38	3	SSHC01080	1/4-20 X 1-1/4 HHCS
39	1	SSHC01096	1/4-20 X 1-1/2 HHCS
40	1	SSHC25096	3/8-16 X 1 1/2 HEX HEAD
41	1	SSPS80024	#6-32 X 3/8 LG PAN HD
42	2	SSSC01096	1/4-20 X 1-1/2 SOC CAP
43	2	SSSS98024	10-32X 3/8 SOC SET SC
44	4	WWFS1/4	WASHER,FLAT,SAE,1/4
45	7	WWL1/4	WASHER,LOCK,1/4
46	2	WWL10	WASHER,LOCK,#10,S/S
47	3	WWS307-1	WASHER,SPRING,BELVEL



# 1331080 Cover Stretch Roller Assembly

AAC Drawing Number 1331080 Rev 2

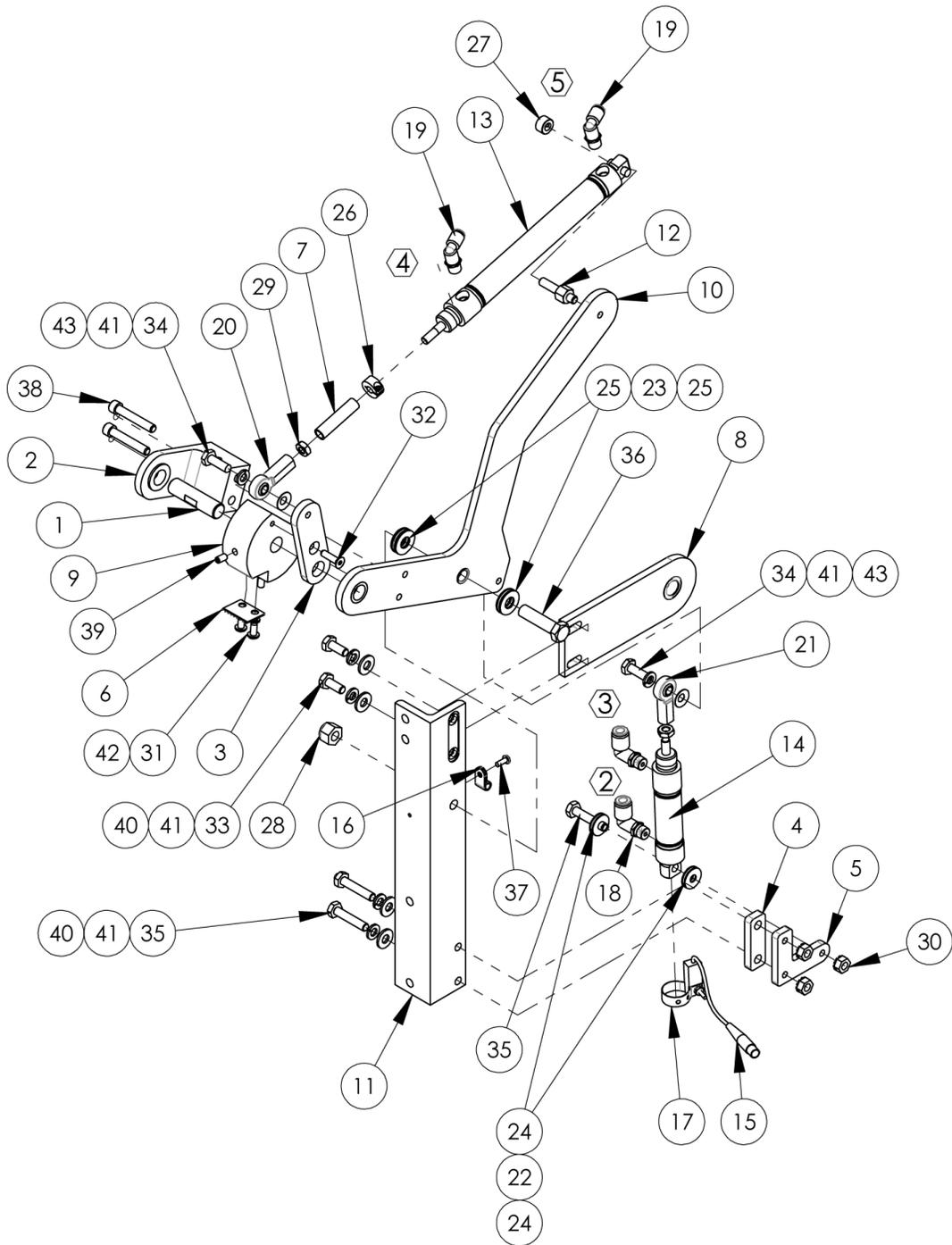
NO.	QTY	PART #	DESCRIPTION
1	1	1331204	SHAFT, TENSION WHEEL
2	1	1331205	YOKE, TENSION WHEEL
3	1	1331206	PIVOT ARM, TENSION ROLLER
4	1	1331212	SPACER,1/4X5/8X1.88X1.250
5	1	1331213	BRKT, AIR CYL
6	1	1331216	BLADE, BORDER TENSION
7	1	1331285	SLEEVE,STOP,TENSION CYL.
8	1	1331712	WHEEL, TENSION
9	1	1331714	ARM,TENSION WHEEL
10	1	1331715	TENSION ROLLER MT ANGLE
11	1	1331718	STUD,CYL MTG
12	1	AAC7DP-.5	CYLINDER,AIR,DA
13	1	AAC7DP-4R	CYL,AIR,DA,90 DEG PORTS
14	1	AAF3/16	CLAMP, BLACK PLASTIC
15	2	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8
16	2	AAQME-5-8	QUICK MALE ELBOW
17	2	BBAW-4	BEARING,ROD END,FEMALE
18	2	BBNTA411	BEARING,THRUST,.250B
19	2	BBNTA613	BEARING,THRUST,375BORE
20	4	BBTRA411	WASHER,THRUST,STEEL
21	4	BBTRA613	WASHER,THRUST,STL, .375B
22	1	CCCL4F	COLLAR,1/4,CLAMP
23	1	CCSC41/4	COLLAR,SET 1/4"
24	1	NNE3/8-16	NUT, ELASTIC 3/8-16
25	2	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
26	3	NNK1/4-20	KEP NUT, 1/4-20
27	2	SSBC98024	10-32 X 3/8 BUTTON CAP SC
28	1	SSFC98048	#10-32 X .75 SHCSF
29	2	SSHC01048	1/4-20 X 3/4 HEX CAP
30	3	SSHC01080	1/4-20 X 1-1/4 HHCS
31	1	SSHC25096	3/8-16 X 1-1/2 HEX HEAD
32	1	SSPS80024	#6-32 X 3/8 LG PAN HD
33	2	SSSC01096	1/4-20 X 1-1/2 SOC CAP
34	2	SSSS98024	10-32X 3/8 SOC SET SC
35	2	WWFS1/4	WASHER,FLAT,SAE,1/4
36	4	WWL1/4	WASHER,LOCK,1/4
37	2	WWL10	WASHER,LOCK,#10,S/S
38	2	WWS307-1	WASHER,SPRING,BELVEL



# 1331220 Long Side Staple Gun Assembly

AAC Drawing Number 1331220 Rev 0

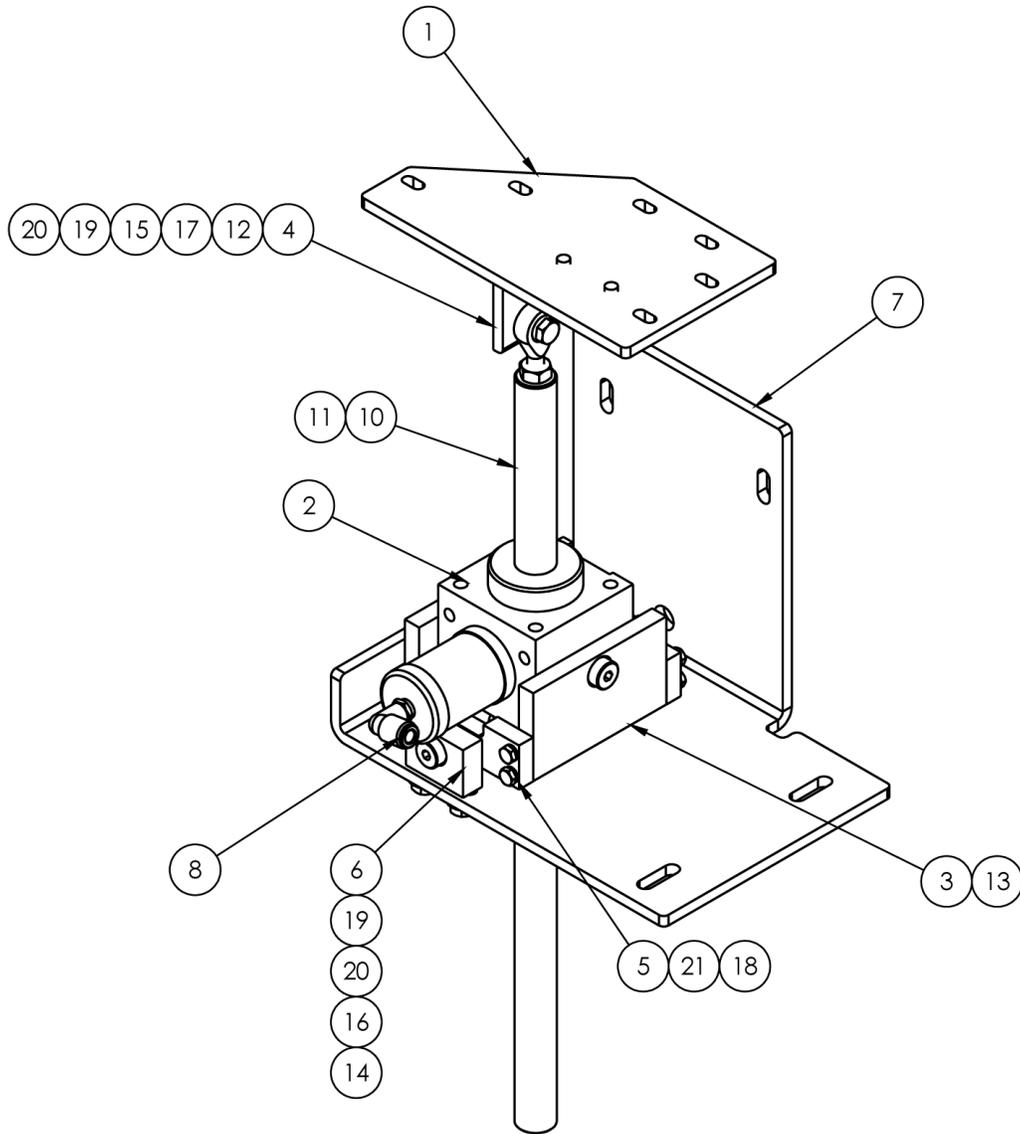
NO.	QTY	PART #	DESCRIPTION	
1	8	1331079	COVER STRETCH ROLLER ASSY	Page 57
2	10	1331080	COVER STRETCH ROLLER ASSY	Page 59
3	1	1331081	COVER STRETCH ROLLER ASSY	Page 63
4	6	1331094	TOP CLAMP	Page 55
5	1	1331131	MOUNT, WHEEL ASSY, OUTER	
6	1	1331132	MOUNT,WHEEL ASSY,INNER	
7	1	1331195	BEAM,CLAMP CYL MTG,LONG	
8	6	1331266	FINGER, LONG CLAMP	
9	2	1331312	PLATE, SUPPORT STAPLE	
10	1	1331318	ROD,STR,60C1/2X14.0L	
11	3	1331319	ROD,STR,60C,1/2X18.0L	
12	19	1331349	STAPLE GUN ASSY	Page 54
13	2	1331720	WELDMENT,CLAMP FRAME SUPP	
14	6	1331724	PLATE,NUT,1/4-20X2	
15	6	1331725	PLATE,WASHER,.266@.75	
16	4	1331727	HANDLE	
17	1	1331730	BKRT, VALVE MNTG.	
18	1	AAVSMVAV-3	VALVE,SUB MIN,3-WAY SPOOL	
19	8	BBTT1001	WASHER,THRUST,BRONZE	
20	4	CCCL8F	CLAMP COLLAR- 1/2	
21	2	MM132-1496	PLUG 1 X 2	
22	8	MM8487A31M	PIN,QUICK RELEASE, MOD.	
23	4	NNK1/4-20	NUT,HEX,KEP,1/4-20,W/LOCK	
24	54	SSHC01048	1/4-20 X 3/4 HEX CAP	
25	8	SSHC01112	HEX HEAD BOLT 1/4-20X1.75	
26	8	SSSC01040	1/4-20 X 5/8" SOC CAP SC	
27	12	SSSC01048	1/4-20 X 3/4" SOC CAP SC	
28	74	WWFS1/4	WASHER,FLAT,SAE,1/4	
29	78	WWL1/4	WASHER,LOCK,1/4	
30	8	NNJ3/8-16	3/8-16 JAM NUT	
31	12	WWFS10	WASHER, FLAT, #10, SAE	
32	12	WWL10	WASHER,LOCK,#10	
33	6	SSSC98032	10-32X1/2, SOC CAP	



# 1331081 Cover Stretch Roller Assembly

AAC Drawing Number 1331081 Rev 6

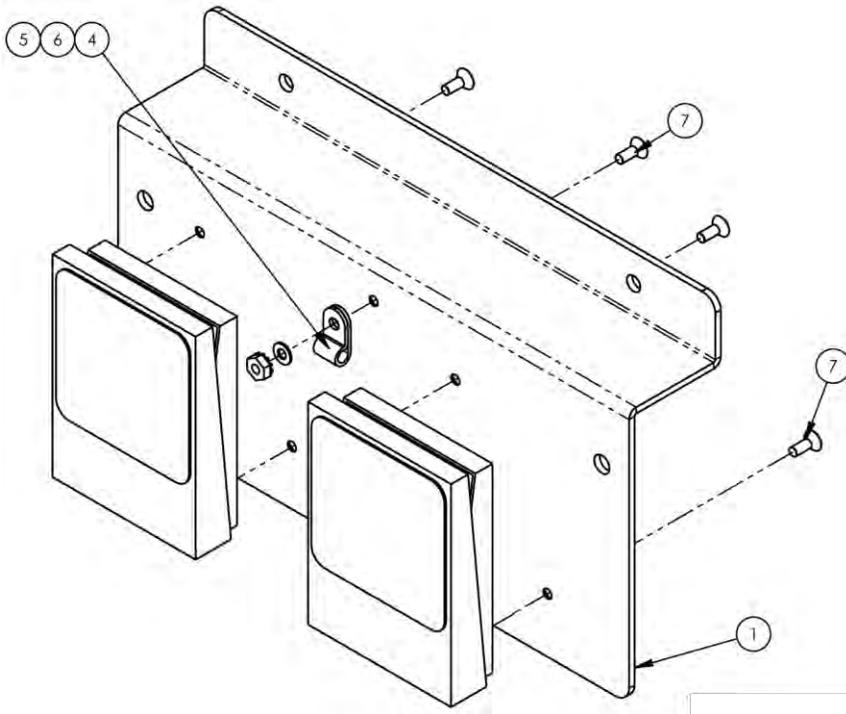
NO	QTY	PART #	DESCRIPTION
1	1	1331204	SHAFT, TENSION WHEEL
2	1	1331205	YOKE, TENSION WHEEL
3	1	1331206	PIVOT ARM, TENSION
4	1	1331212	SPACER, 1/4X5/8X1.88X1.2
5	1	1331213	BRKT, AIR CYL
6	1	1331216	BLADE, BORDER TENSION
7	1	1331285	SLEEVE, STOP, TENSION
8	1	1331312	PLATE, SUPPORT STAPLE
9	1	1331712	WHEEL, TENSION
10	1	1331714	ARM, TENSION WHEEL
11	1	1331715	TENSION ROLLER MT
12	1	1331718	STUD, CYL MTG
13	1	AAC7DP-4R	CYL, AIR, DA, 90 DEG PORTS
14	1	AACM040.5-	CYLINDER, AIR, 3/4X1/2 STR
15	1	AAEHSKQ	SWITCH, HALL
16	1	AAF3/16	CLAMP, BLACK PLASTIC
17	1	AAFD35000	BAND, UNIVERSAL, AAEHSK
18	2	AAQME-4-8	QUICK MALL ELBOW, 1/4 T
19	2	AAQME-5-8	QUICK MALE ELBOW
20	1	BBAW-4	BEARING, ROD
21	1	BBAW-4M1	BEARING, ROD
22	2	BBNTA411	BEARING, THRUST, .250B
23	2	BBNTA613	BEARING, THRUST, .375BORE
24	4	BBTRA411	WASHER, THRUST, STEEL
25	4	BBTRA613	WASHER, THRUST, STL, .375B
26	1	CCCL4F	COLLAR, 1/4, CLAMP
27	1	CCSC41/4	COLLAR, SET 1/4"
28	1	NNE3/8-16	NUT, ELASTIC 3/8-16
29	2	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
30	3	NNK1/4-20	KEP NUT, 1/4-20
31	2	SSBC98024	10-32 X 3/8 BUTTON CAP
32	1	SSFC98048	#10-32 X .75 SHCSF
33	2	SSHC01040	1/4-20 X 5/8 HHCS
34	2	SSHC01048	1/4-20 X 3/4 HEX CAP
35	3	SSHC01080	1/4-20 X 1-1/4 HHCS
36	1	SSHC25096	3/8-16 X 1 1/2 HHCS
37	1	SSPS80024	#6-32 X 3/8 LG PAN HD
38	2	SSSC01096	1/4-20 X 1-1/2 SOC CAP
39	2	SSSS98024	10-32X 3/8 SOC SET SC
40	4	WWFS1/4	WASHER, FLAT, SAE, 1/4
41	6	WWL1/4	WASHER, LOCK, 1/4
42	2	WWL10	WASHER, LOCK, #10
43	2	WWS307-1	WASHER, SPRING, BELVEL



## 1331249 Corner Support Assembly

AAC Drawing Number 1331249 Rev 0

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1331234	BRKT,BRAKE CYL,UPPER	12	1	NNJ5/16-18	NUT,JAM,5/16-18
2	1	1331237	ROD BRAKE ASSY, MOD.	13	2	SSAS024024	SHOULDER BOLT 3/8 X 3/8L
3	2	1331239	PLATE,PIVOT,VERTICAL	14	2	SSAS024032	SHULDER BOLT 3/8 X .50L
4	1	1331240	ANGLE,HRPO,3/8X2X3	15	2	SSHCO1048	1/4-20 X 3/4 HEX CAP
5	2	1331242	BAR,TIE	16	4	SSHCO1056	1/4-20 X 7/8 HEX CAP
6	2	1331244	PLATE,PIVOT HORIZONTAL	17	1	SSHCO1064	1/4-20 X 1 HHCS
7	1	1331251	BRKT,BRAKE CYL, LOWER,LH	18	8	SSHCO98048	SCREW, HEX CAP #10-32X.75
8	1	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8	19	6	WWFS1/4	WASHER,FLAT,SAE,1/4
9	1	MMPHSOM8	BEARING,ROD END,8MM	20	6	WWL1/4	WASHER,LOCK,1/4
10	1	MMPSFCT20500	ROD,20MM,500MM L	21	8	WWL10	WASHER,LOCK,#10
11	1	NNHM8X1.25	M8 X 1.25 HEX NUT				



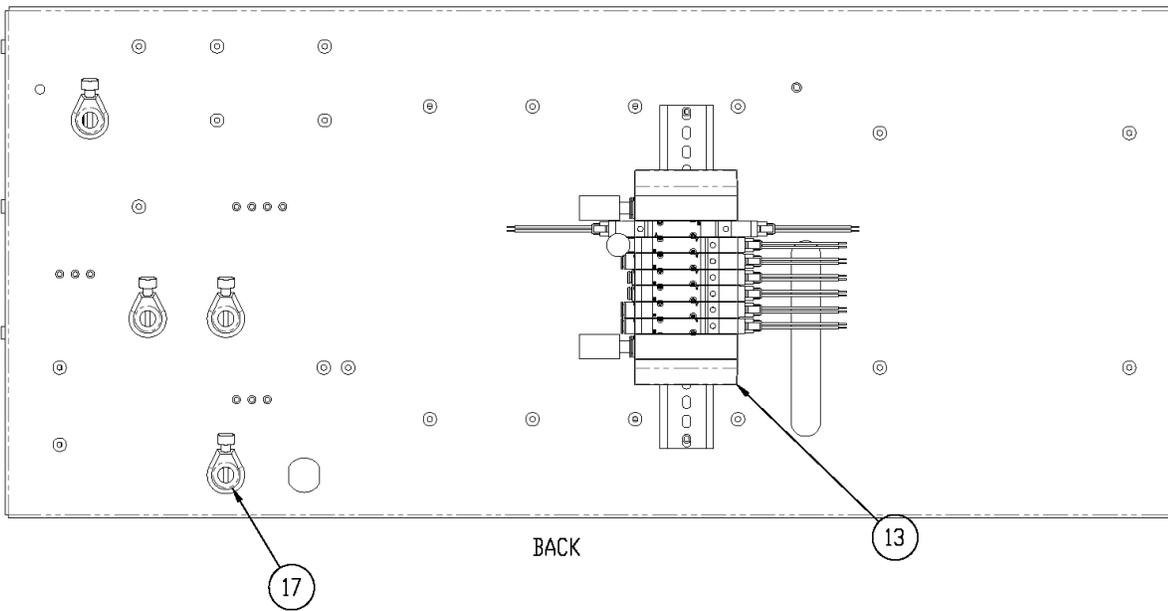
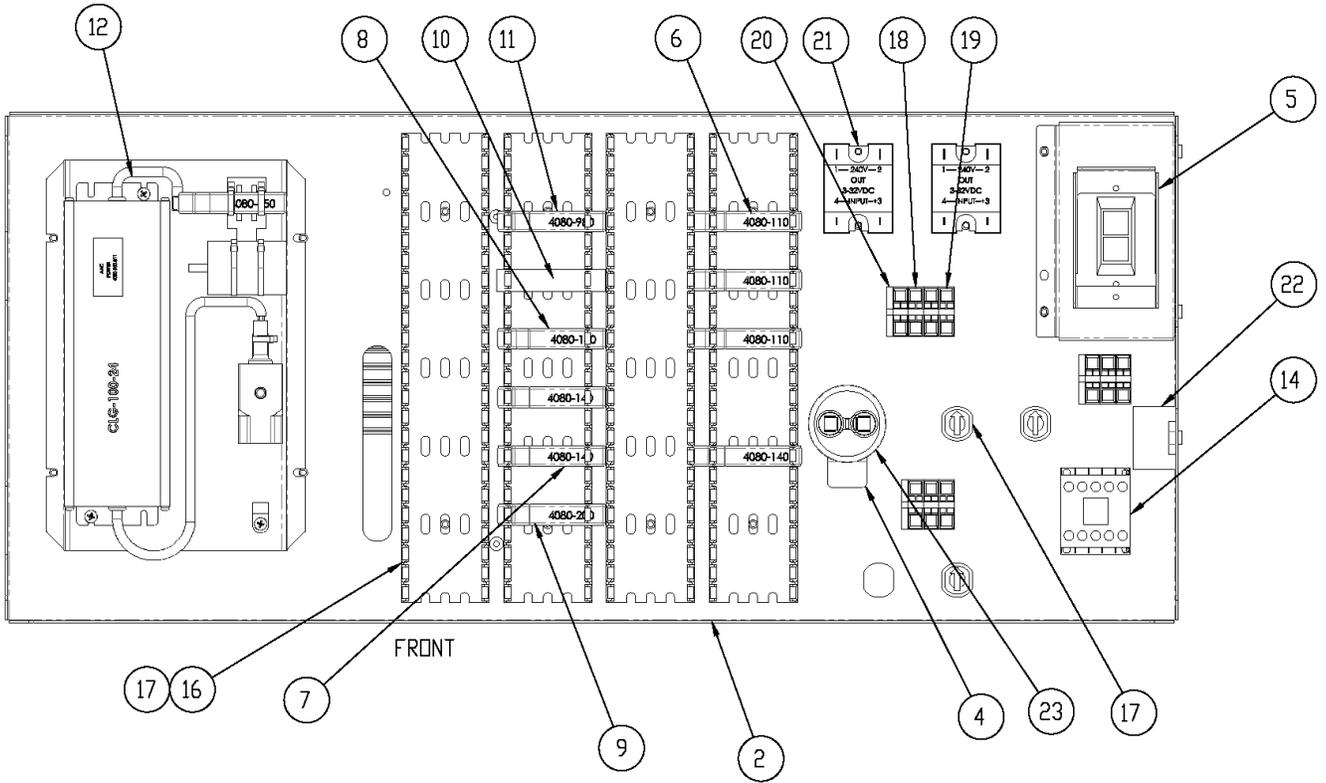
WIRE LIST - UP	
1278-6161	COLOR
N.O.	GREEN
COMMON	RED

WIRE LIST - DOWN	
1278-6161	COLOR
N.O.	WHITE
COMMON	BLACK

## 1331504 Table Lift Pedal Assembly

AAC Drawing Number 1331504 Rev 2

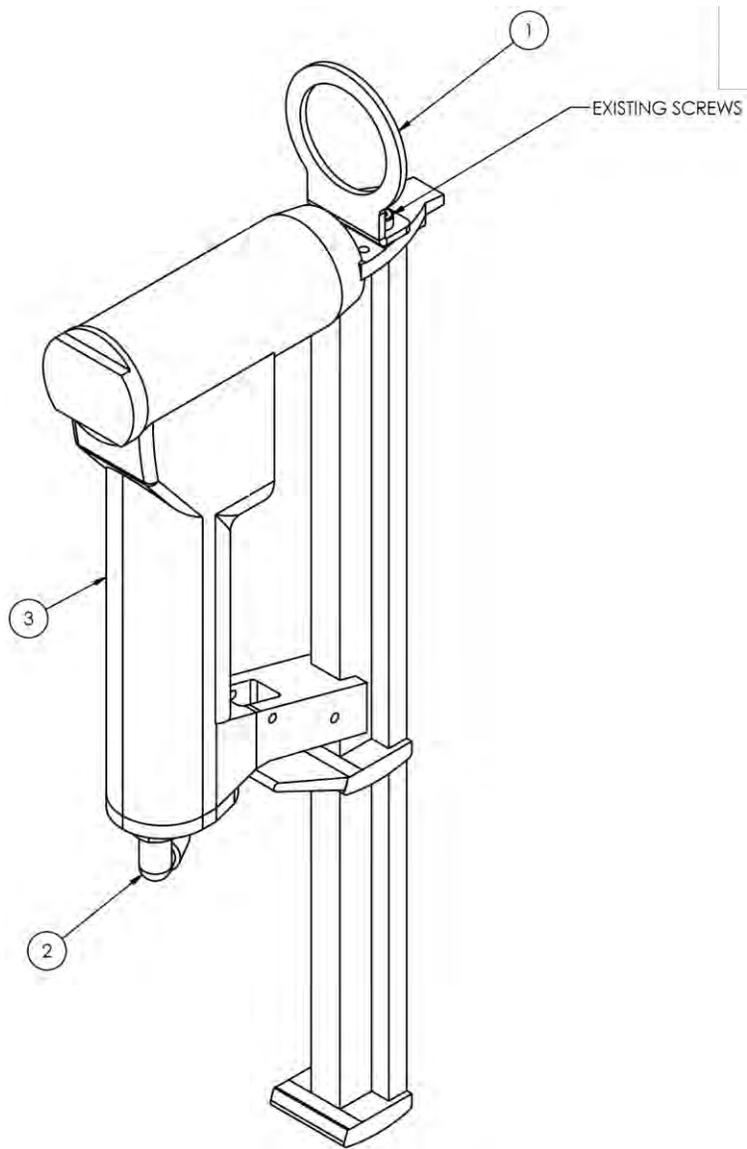
NO.	QTY	PART #	DESCRIPTION
1	1	1278-5051A	PLATE, FOOT SW, DUAL
2	2	1278-6161	FOOT SWITCH MODIFICATION
NS	1	12788-502A	CABLE, DUAL FOOT SWITCH
4	1	AAF3/16	CLAMP, BLACK PLASTIC
5	1	WWFS6	WASHER, FLAT, #6
6	1	NNK6-32	KEP NUT, 6-32
7	5	SSFC80024	6-32 X 3/8 FLAT CAP



# 1331900 Control Box

AAC Drawing Number 1331900 Rev 6

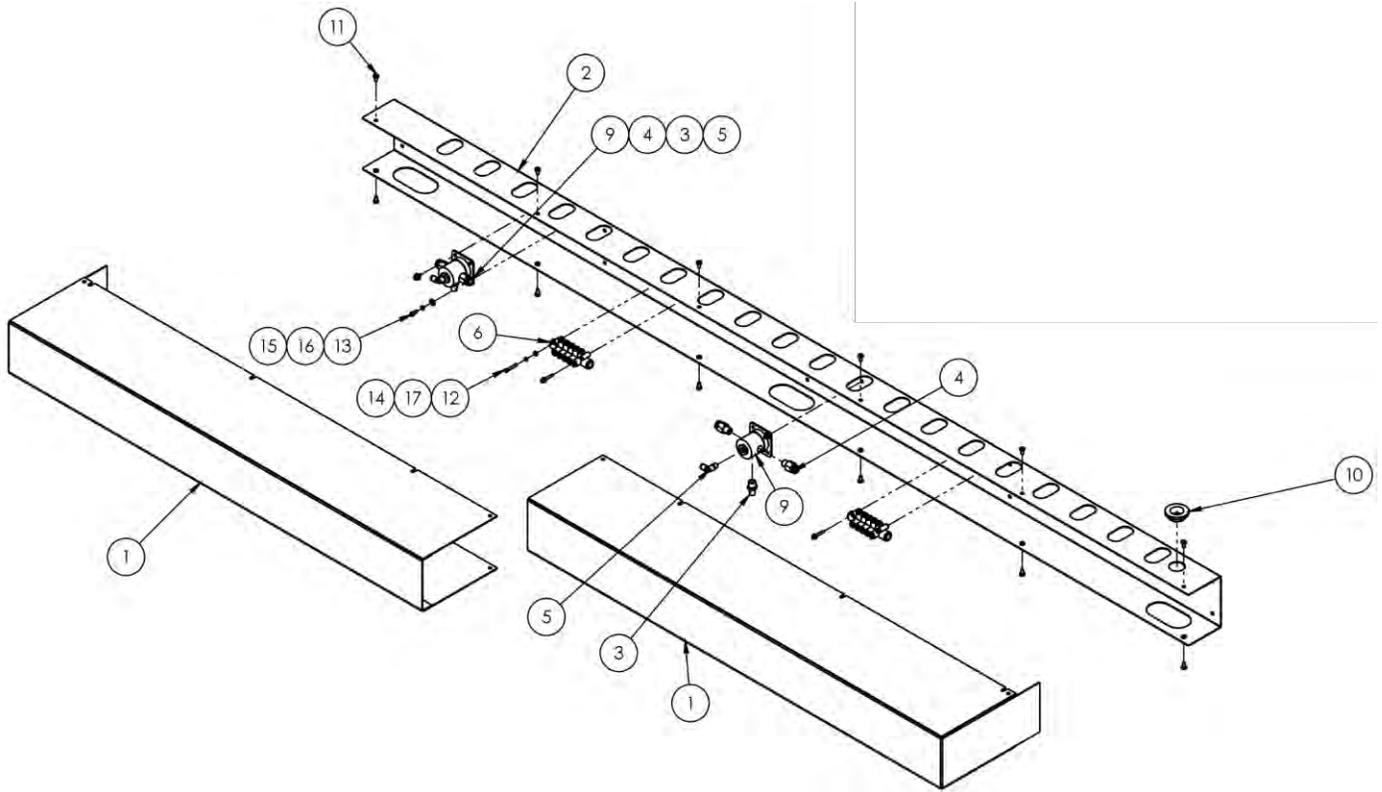
NO.	QTY	PART#	DESCRIPTION
NS	1	1331-WD	DIAGRAM, WIRING
2	1	1331901	BACK CONTROL PANEL, BACK-PLATE
NS	1	1331920	CABLE PACKAGE
4	1	13459004	MOUNTING BRACKET, CAPACIT
5	1	40-320	AC POWER DISCONNECT ASSY
6	3	4080-110	MODULE, QUAD INPUT
7	3	4080-140	MODULE, QUAD OUTPUT
8	1	4080-150	MODULE, PROGRAM
9	1	4080-200	MODULE, AIR PRESSURE
10	1	4080-930	MODULE, DATA
11	1	4080-980	MODULE, ADAPTER
12	1	4080-990R	POWER SUPPLY, SBUS, CLASS 2
13	1	AAE1331-7A	HI-FLOW 7 STATION VALVE
14	1	EECA491024	CONTACTOR, MINI, 240V
15	4FT*	EEDC2X2	COVER, WIRE DUCT
16	4FT*	EEDF2X2	DUCT, WIRE
17	4	FF1724	STRAIN RELIEF
18	7	FF264-341	TERMBLK, WAGO, TOP, DUAL, GRY
19	3	FF264-347	TERMBLK, WAGO, TOP, DUAL, GRN
20	3	FF264-371	TERMBLK, WAGO, TOP, END
21	2	FFD2425F	RELAY, SSR, 24VAC, 25A
22	1	FFRAV781BW	MODULE, TVS, 240 VAC
23	1	MM74472-010	CAPACITOR, 17.5 MF
NS	1	1331-WD	DIAGRAM, WIRING



## 1331914 Manual Stapler Assembly

AAC Drawing Number 1331914 Rev 1

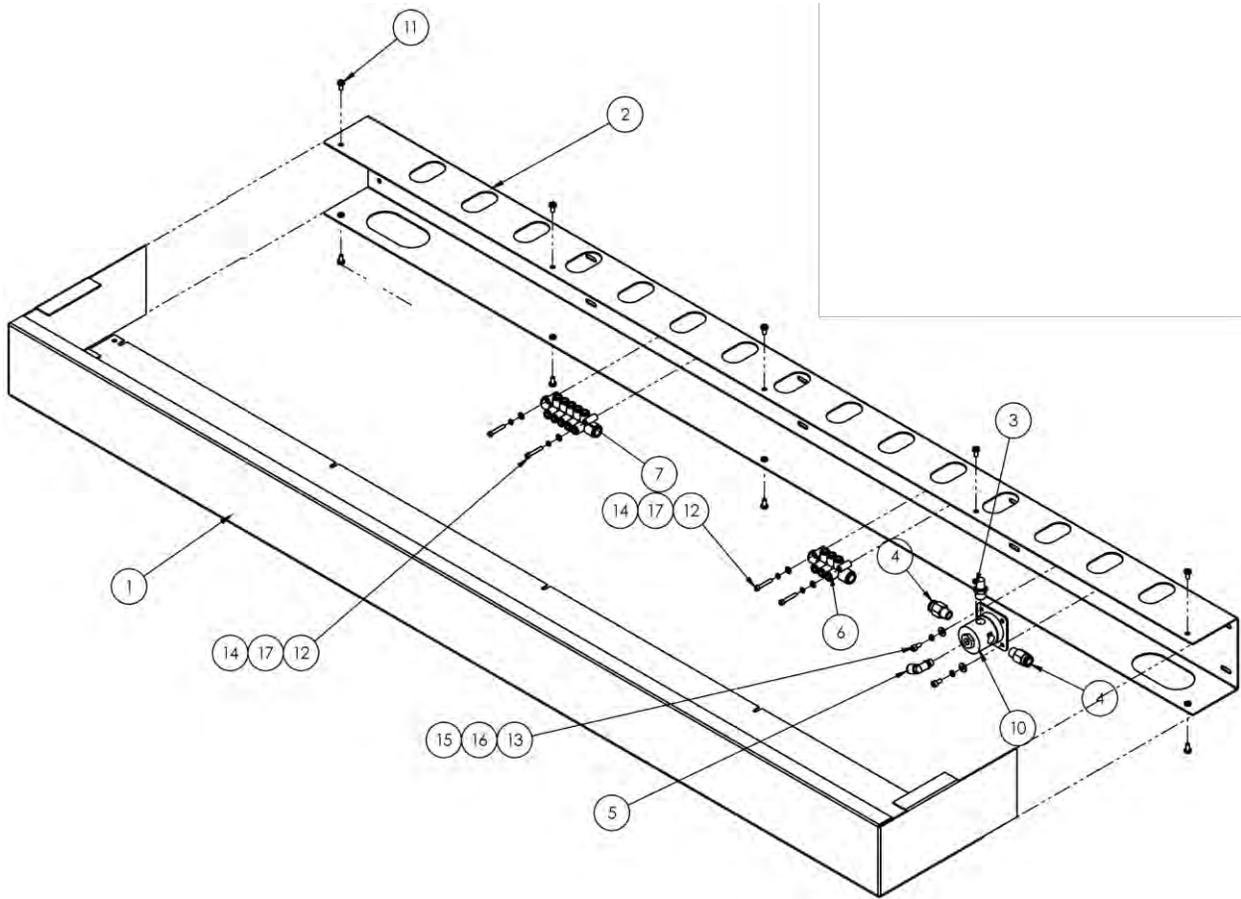
NO.	QTY	PART #	DESCRIPTION
1	1	1331735	BRKT, RING
2	1	AAQME-4-4	ELBOW, MALE, 1/4X1/4NPT
3	1	TU21671B-ALM	STAPLER, UPHOLSTERY



## 1331916 Long Side Track Assembly

AAC Drawing Number 1331916 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	2	1331905	COVER HALF, LONG CHANNEL
2	2	AAFP28	MUFFLER,1/4 NPT
3	4	AAQMC-3-4	QUICK MALE CONNECTOR
4	2	AAQME-5-8	QUICK MALE ELBOW
5	2	AAQMF-145	10-STATION AIR MANIFLD
NS	84	AAQPR-5-4	REDUCER
NS	114	AAQUT-4-4	QUICK UNION T
8	2	AAV250A	PILOT VALVE
9	1	MM9280K33	GROMMET,FLANGE,1.03 ID
10	12	SSPS98024	10-32X3/8 PAN HD SLOT
11	4	SSSC90064	#8-32 X 1 SOC CAP SC
12	4	SSSC98024	10-32 X 3/8 SOC CAP
13	4	WWF8	WASHER, FLAT, #8
14	4	WWFS10	WASHER, FLAT, #10, SAE
15	4	WWL10	WASHER,LOCK,#10
16	4	WWL8	WASHER,LOCK,#8
17	1	1331915	CHANNEL, AIRLINES, LONG

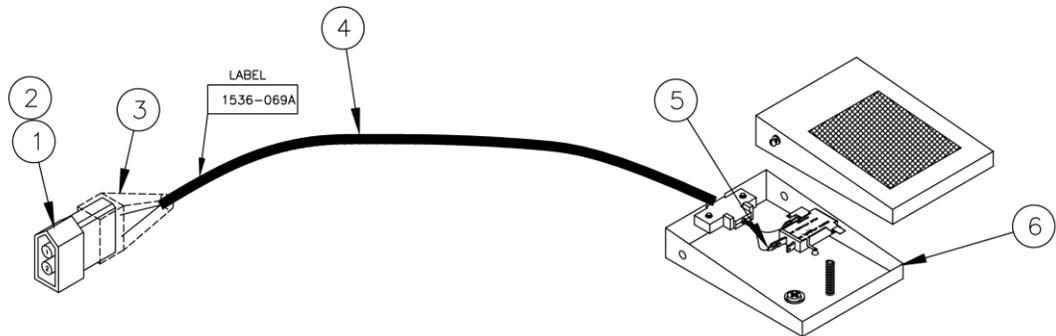
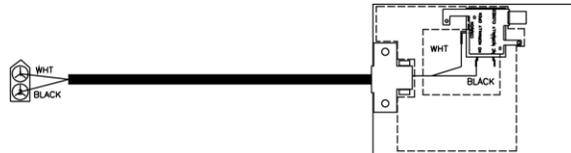


## 1331918 Short Side Track Assembly

AAC Drawing Number 1331918 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1331906	COVER, SHORT SIDE CHANNEL
2	1	1331917	CHANNEL, AIRLINES, SHORT
3	1	AAFP28	MUFFLER,1/4 NPT
4	2	AAQMC-3-4	QUICK MALE CONNECTOR
5	1	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8
6	1	AAQMF-144	6-STATION AIR MANIFOLD
7	1	AAQMF-145	10-STATION AIR MANIFLD
8	64	AAQPR-5-4	REDUCER
9	84	AAQUT-4-4	QUICK UNION T
10	1	AAV250A	PILOT VALVE
11	10	SSPS98024	10-32X3/8 PAN HD SLOT
12	4	SSSC90064	#8-32 X 1 SOC CAP SC
13	2	SSSC98024	10-32 X 3/8 SOC CAP
14	4	WWF8	WASHER, FLAT, #8
15	2	WWFS10	WASHER, FLAT, #10, SAE
16	2	WWL10	WASHER,LOCK,#10
17	4	WWL8	WASHER,LOCK,#8

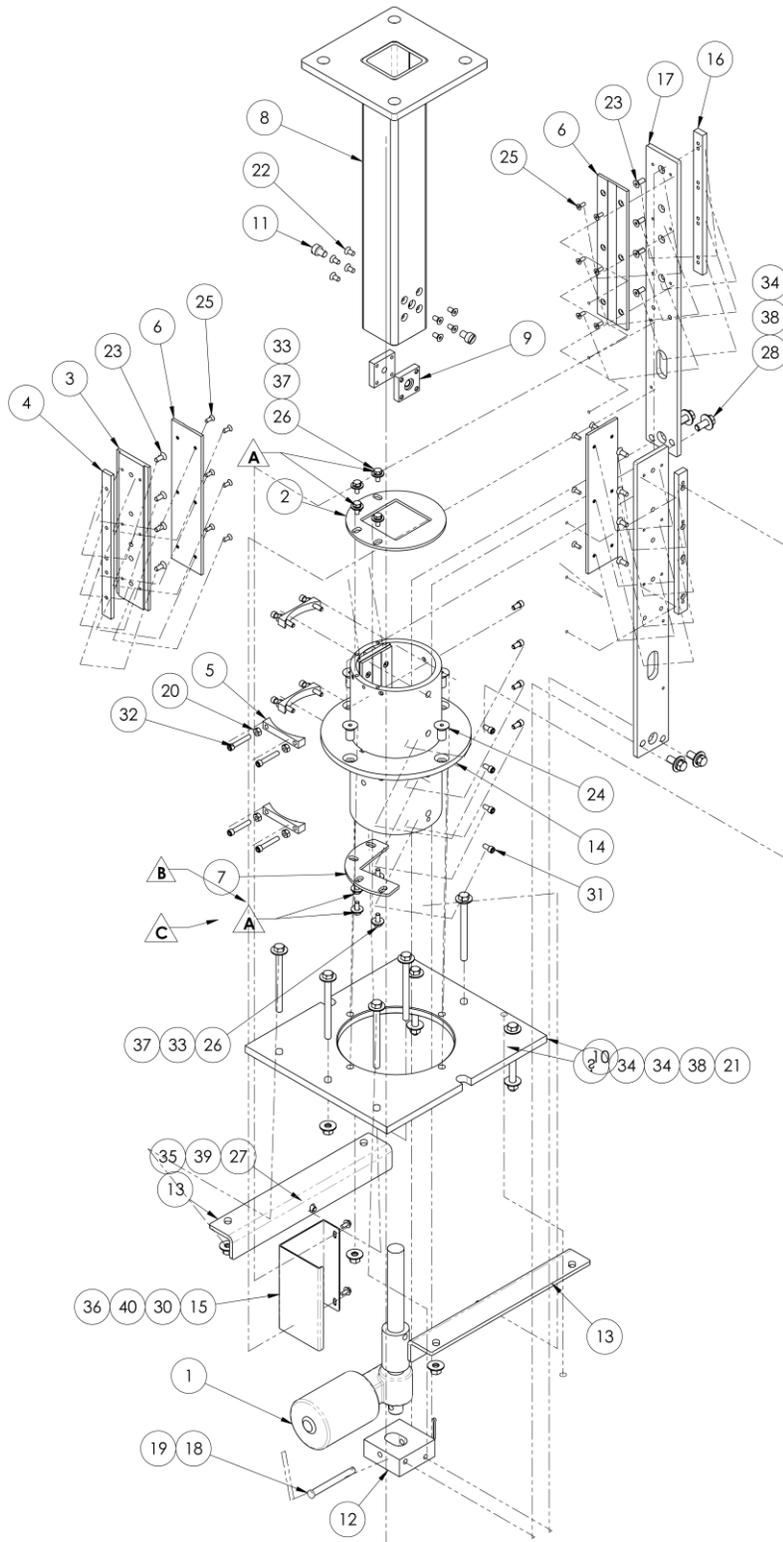
WIRE LIST		
EE24F163	COLOR	FF31F1023
COMMON	WHITE	1
NORMALLY OPEN	BLACK	2



## 1536-069A Footswitch Assembly

AAC Drawing Number 125863A Rev 0

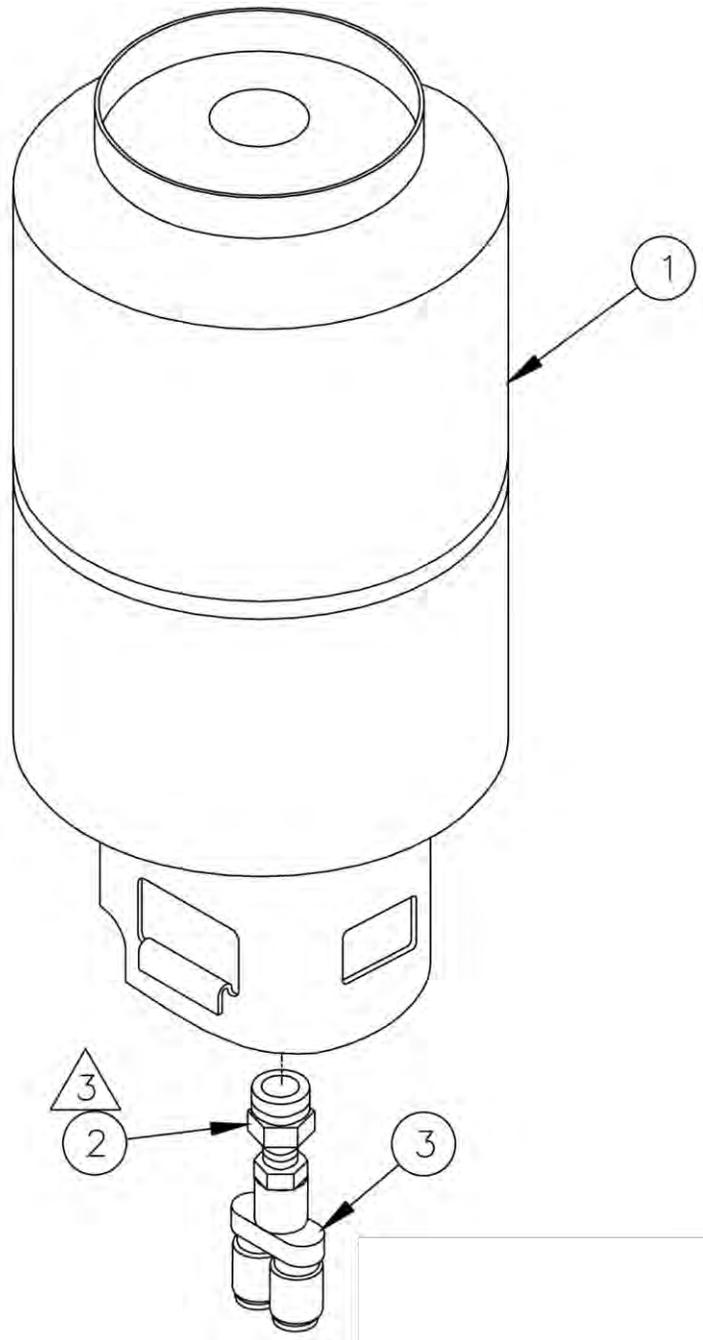
NO.	QTY	PART #	DESCRIPTION
1	1	FF59F1802	2 Pin Male Conn.
2	2	FF31F1022	Male Pin .093
3	2"	ZTH1/2B	Boot Material
4	6'	EE18-2	2 Cond 18AWG
5	2	TT1818	Female Quick Slide
6	1	EE24F163	Threadlite Footswitch



# 13452000C Square Table Lift Assembly

AAC Drawing Number 9003089 Rev 7

NO	QTY	PART #	DESCRIPTION
1	1	1322020	ACTUATOR,ELEC,6"
2	1	1345093	BKT,EDGE GUIDE
3	2	1345131	PLATE,SLIDE, ADJ
4	2	1345132	BAR, BRACE,.25 THK
5	4	1345134	SPACER,COLUMN CONCAVE
6	4	1345135	PLATE, SLIDE
7	1	1345136	BKT,LOWER GIB STOP
8	1	1345231	COLUMN ASSY
9	2	1345234	PLATE,ACTUATOR MNTNG,UPR
10	1	13451003	PLATE, COLUMN SUPPORT
11	2	13452004A	PIN, COLUMN
12	1	13452006B	PLATE, ACTUATOR
13	2	13452008A	SUPPORT, COLUMN HUB
14	1	13452020B	COLUMN, HUB ASSY.
15	1	13452023A	COVER, ACTUATOR
16	2	13452040	BAR, BRACE
17	2	13452044A	PLATE,SLIDE SUPPORT
18	1	MM98306A289	PIN,CLEVIS,3/8X3-1/2
19	1	MM98338A445	COTTER PIN, 1/8 X 2 1/2
20	8	NNH1/4-20	NUT,HEX,1/4-20
21	7	NNH3/8-16	NUT,HEX,3/8-16
22	8	SSFC01032	1/4-20 X 1/2 FLAT ALN CAP
23	16	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
24	4	SSFC45064	1/2-13 X 1 SOC FLAT CAP
25	24	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
26	8	SSHC01040	1/4-20 X 5/8 HHCS
27	2	SSHC10048	5/16-18 X 3/4 HHCS
28	4	SSHC25064	3/8-16 X 1 HHCS
29	7	SSHC25288	3/8-16X4-1/2,HEX CAP
30	2	SSHC98032	10-32X1/2 HEX HD
31	8	SSSC01032	1/4-20X1/2 SOC CAP
32	8	SSSC01096F	1/4-20 X 1-1/2 SOC CAP
33	8	WWF1/4	WASHER, FLAT, 1/4", COM
34	18	WWF3/8	WASHER,FLAT,3/8 OR 10MM
35	2	WWF5/16	WASHER,FLAT,5/16
36	2	WWF10	WASHER, FLAT, #10, COM
37	8	WWL1/4	WASHER,LOCK,1/4
38	11	WWL3/8	WASHER,LOCK, 3/8
39	2	WWL5/16	WASHER,LOCK, 5/16
40	2	WWL10	WASHER,LOCK,#10



## 26254C Air Reservoir

AAC Drawing Number 298348B Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	261007	Air Tank
2	1	MM44605K24	Reducer
3	1	AAQBY-3-2	1/2 x 3/8 "Y"







# 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 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 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 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 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](http://www.atlatt.com)

**Printed in the USA**