

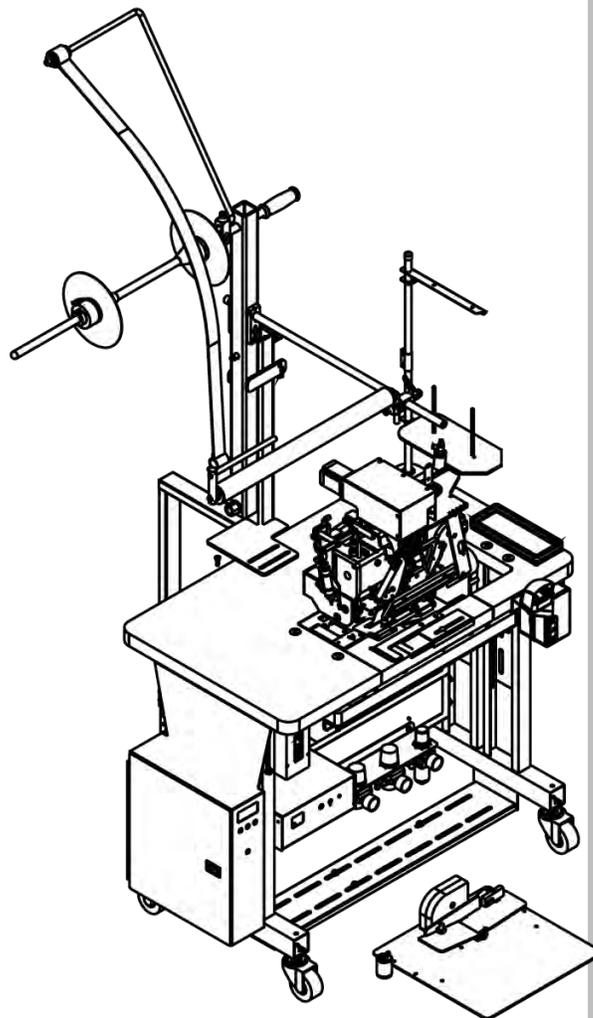


Model

1335ET

Revision 4.2 Updated Sept 19, 2016

Technical Manual & Parts Lists



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ATLANTA ATTACHMENT COMPANY, INC.

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

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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 1335E Manual Ruffler Workstation should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include;

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

Intended Use

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

Exclusion of Misuse



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

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

Liability

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

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

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

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

The personnel's awareness of the dangers and compliance with the safety regulations should be checked at irregular intervals.

Choice and Qualification of Personnel

Ensure that work on the machine is only carried out by reliable persons who have been appropriately trained for such work - either within the company, by our field staff or at our office - and who have not only been duly appointed and authorized, but are also fully familiar with the local regulations. Work on

the machine should only be carried out by skilled personnel, under the management and supervision of a duly qualified engineer.

This not only applies when the machine is used for production, but also for special work associated with its operation (start-up and maintenance), especially when it concerns work on the hydraulic or electrical systems, as well as on the software/serial bus system.

Training

Everyone working on or with the machine should be duly trained and informed with regard to correct use of the safety equipment, the foreseeable dangers which may arise during operation of the machine and the safety precautions to be taken. In addition, the personnel should be instructed to check all safety mechanisms at regular intervals.

Responsibilities

Clearly define exactly who is responsible for operating, setting-up, servicing and repairing the machine. Define the responsibilities of the machine operator and authorize him to refuse any instructions by third parties if they run contrary to the machine's safety. This applies in particular for the operators of machines linked to other equipment. Persons receiving training of any kind may only work on or with the machine under the constant supervision of an experienced operator. Note the minimum age limits permitted by law.

A Word to the Operator

The greatest danger inherent in our machines:
is that of fingers, hands or loose clothing being drawn into a machine by live, coasting or rotating tools or assemblies or of being cut by sharp tools or burned by hot elements.

ALWAYS BE CONSCIOUS OF THESE DANGERS!

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.

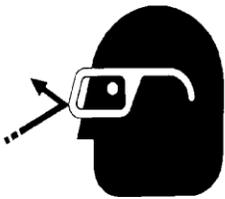
Signs on the Machine

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.

General Machine Data

Electrical & Pneumatic Specifications

Electrical:	220 VAC, 5amp, 50/60 Hz Single Phase
Pneumatic:	70-80 PSI, 2 SCFM avg.
Sewing Speed:	2500 RPM
Needle (Standard):	SN62X5722
Stitch Density:	6 SPI

Installation & Setup

Provide a 220VAC, single phase, 5 Amp electrical drop and 1/4" air supply line (80 PSI).

Remove any shipping straps from machine.

Mount and adjust the Guide Roller Assembly.

Check the oil level in the oil pan.

Control Box Operation

Main Control Box:

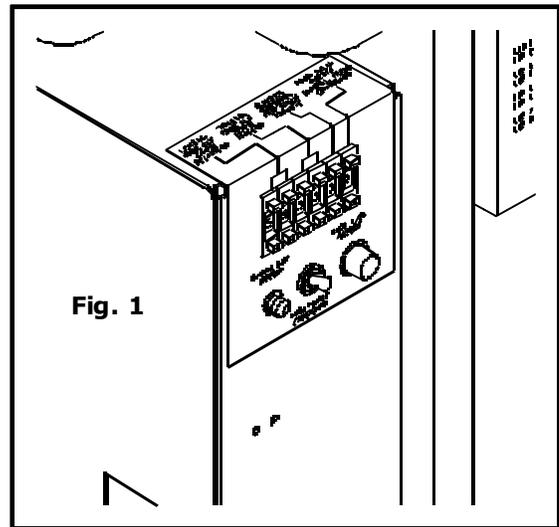
The front of the main control box has an Auto/Manual Switch, a Manual Ruffle Pushbutton, an Unwinder Reverse Switch, a Fuse Holder, and 6 Thumbwheels. On the back is the power entry socket and an on/off switch. Be sure the on/off switch is always on.

Note: The on/off switch only switches one line and does not make the box safe to work on. Always disconnect the main power cord before servicing the control box.

The Auto/Manual Switch turns on the automatic ruffling cycles for the corners. When this switch is in Manual, the ruffling is disabled and the machine will only sew, trim, and foot lift.

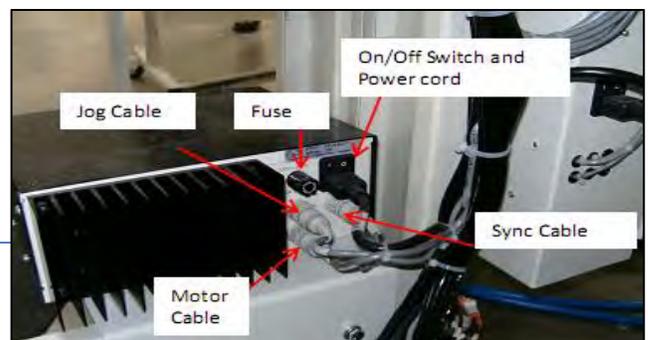
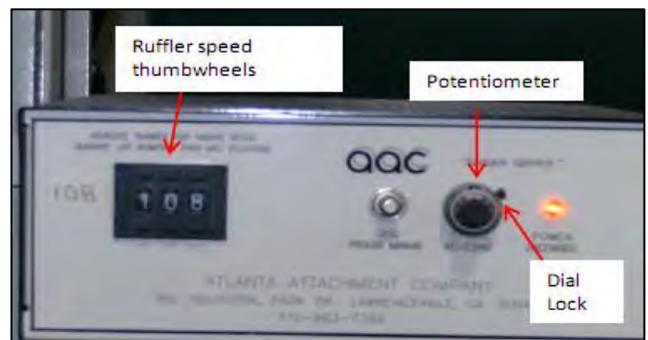
The Manual Ruffle pushbutton turns on one ruffle cycle and also functions as the Reset button for the automatic cycle. Pushing this button once will turn on the ruffle cycle. Pushing it a second time will reset the automatic program and cause the ruffle hardware to reset and go to its "Home" position. Use this button to reset the ruffler after adjusting the ruffle size.

The Fuse Holder fuses the entire machine. Replace the fuse with a 5A Slow Blow 250v as necessary.



Stepping Motor Control Box

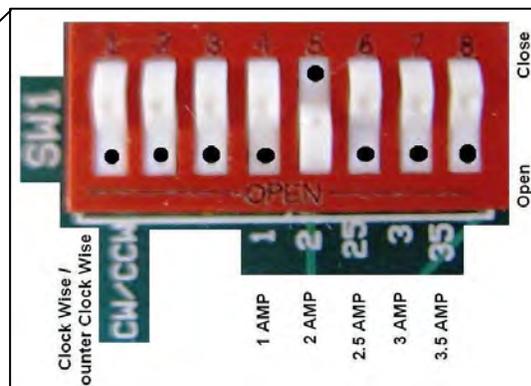
The stepping motor box is located under the table. The Ruffler box has three thumbwheels on the front which are set to synchronize the Ruffler to the sewing head. The number is proportional to the stitch length and is not affected by sewing speed. The 10-turn potentiometer is used to set the speed of the Ruffler during the feed in to pleat and feed out to make the next ruffle. It is set based on the thickness and type of material being sewn, if the ruffler blade stalls while feeding in or out you will need to lower the setting on this control. To adjust unlock the dial and turn counter clockwise to reduce the speed turn clockwise to increase.



The back of the box has an on/off switch, fuse, and cables. Leave the on/off switch on all the time. When working on the box always disconnect the power cord before servicing.

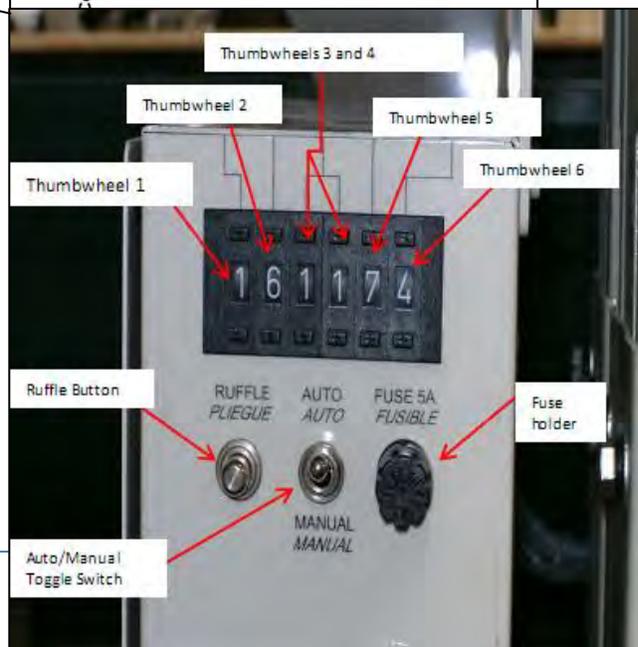
Mini Switch (SW1)

- **Switch # 1:** Control the rotations of the motor CW: Clock wise rotation. CCW: Counter close wise rotation For 1335 Ruffler 2 AMPS motors set to position Open (CW)
- **Switch 2:** No function
- **Switch 3:** No function
- **Switch 4:** For 1 amps motors. For 1335 Ruffler 2 AMPS motors set to position Open
- **Switch 5:** For 2 Amps Motors. For 1335 Ruffler 2 AMPS motors set to position Close
- **Switch 6:** For 2.5 Amps Motors. For 1335 Ruffler 2 AMPS motors set to position Open
- **Switch 7:** For 3 Amps Motors. For 1335 Ruffler 2 AMPS motors set to position Open
- **Switch 8:** For 3.5 Amps Motors. For 1335 Ruffler 2 AMPS motors set to position Open



Ruffler Control Box

Thumbwheel 1 on the left sets the stitch count for the slow start feature after the last ruffle. This reduces the sewing speed for a few stitches to help the material to feed to the puller before the machine goes to high speed. The stitch count equals twice the number shown on the thumbwheel. This feature can be turned off by setting thumbwheel 1 to “0”.



Thumbwheel 2 controls the sewing speed of the sewing head during ruffling. Each increment is approximately 100 rpm. The normal setting is “6”.

Thumbwheels 3 and 4 together make up the Stop count for the corners. This is the stitch count (00-99 stitches) from when the front eye uncovers until the sewing stops in the corner to start the ruffling cycle. This should be adjusted to stop the panel so that when the corner turn is finished the right edge of the panel is flush against the edge guide, decrease the stitch count to stop the panel sooner. If, after turning the corner, the right edge of the panel is to the right of the edge guide, increase the stitch count to stop the panel closer to the foot.

Thumbwheel 5 has two functions. When it is set to 1-6, it sets the number of ruffles to be sewn in the corner. The panel must be turned while ruffling to form a round corner. When this thumbwheel is set to 7, 8, or 9 the ruffler will sew in “square corner” mode. In this mode, with the thumbwheel set to 7 the ruffle will sew to the corner, and make one ruffle while still sewing straight. The ruffler will then stop, the presser foot and puller will raise. The operator must keep the treadle pressed as the panel is turned 90 deg without sewing. When the treadle is released and pressed again the ruffler will make one ruffle straight ahead and the start sewing at regular speed. This creates a “square” or “straight” corner instead of the rounded corner. The stopping stitches must be adjusted for this mode to form a correct corner. If the thumbwheel is to 8, two ruffles will be made on each side for a total of four ruffles per corner. If the thumbwheel is set to 9, three ruffles will be made on each side for a total of six ruffles per corner.

Thumbwheel 6 sets the number of stitches sewn in each ruffles and is adjusted according to the ruffle size. There should be enough stitches to sew to the folded edge of each ruffle.

The **Auto/Manual Switch** turns on the automatic ruffling cycles for the corners. When this switch is set to Manual, the ruffling is disabled and the machine will only sew, trim, and foot lift.

The **Manual Ruffle** push button turns on the ruffle cycle and also functions as the Reset button for the automatic cycle. Pushing this button once will turn on the ruffle cycle. Pushing it a second time will reset the automatic program and cause the ruffle hardware to reset and go to its “home” position. Use this button to reset the ruffler after adjusting the ruffle size.

The **Fuse Holder** fuses the entire machine. Replace the fuse with a 5A Slow Blow 250V as necessary.

The back of the control box has the power cord plug and on/off switch. Be sure the on/off switch is always on. Always disconnect the main power cord before servicing the control box.



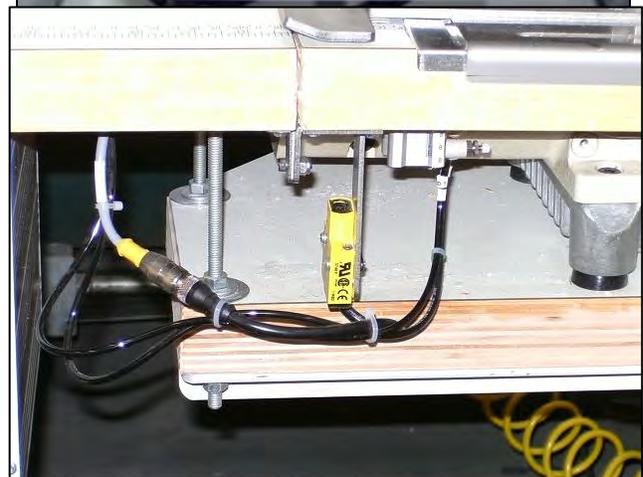
The door on the left side of the ruffler control box gives access to the electronic components. The on/off switch (1), the unwinder relay (2), the computer board (3), the thumbwheels (4), the valve assembly (5), the WAGO blocks (6). Do not service this part of the machine while power is still connected. Unplug the power cable from the back of the control box, follow all lock out/tag out procedures.



Eyes

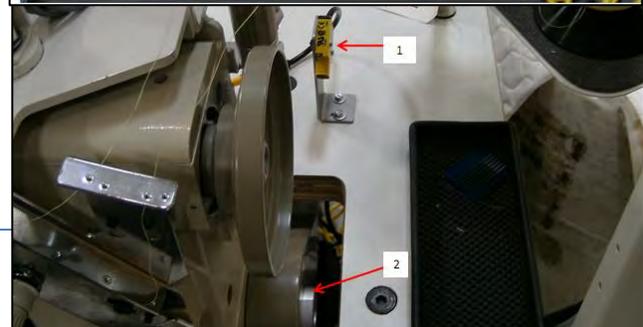
1.- Panel End Sew Eye

The panel end sew eye is located under the table top, part of the flip down access. The panel end eye, “looks” for the end of the panel. When the end of the panel goes by it sends a signal to the ruffler control box to start counting stitches for the stop count, thumbwheels 3 and 4.



2.- Hand wheel Eye

The Hand wheel eye (1) is mounted to the top of the table, behind and to the right of the sewing

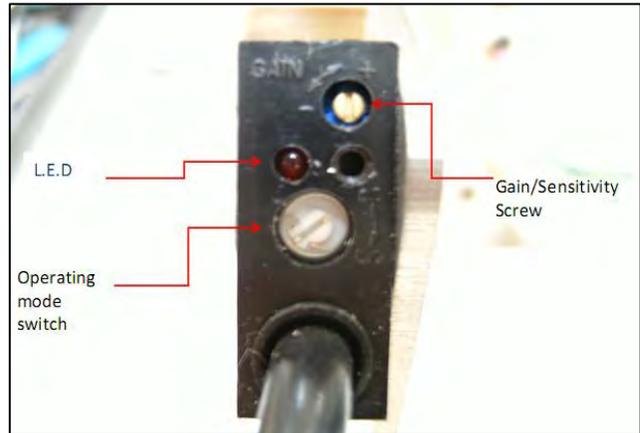


head. The Hand wheel eye (1) reads a piece of reflective tape located on the pulley disks (2). The Hand wheel eye is responsible for reporting to the Efka motor that the sewing head is sewing at the set RPM, stitch counting for all counters, and for needle position when stopping.

3.- Adjustments

Hand wheel and Panel Eye

To set the eye, first remove the cover (not shown), make sure that the operating mode switch is set to L.O. or all the way clockwise, with the eye “seeing” the reflective tape, turn the Gain/Sensitivity Screw to the “+” or clockwise until the L.E.D starts blinking, the L.E.D should blink about 2 times per second when set correctly.

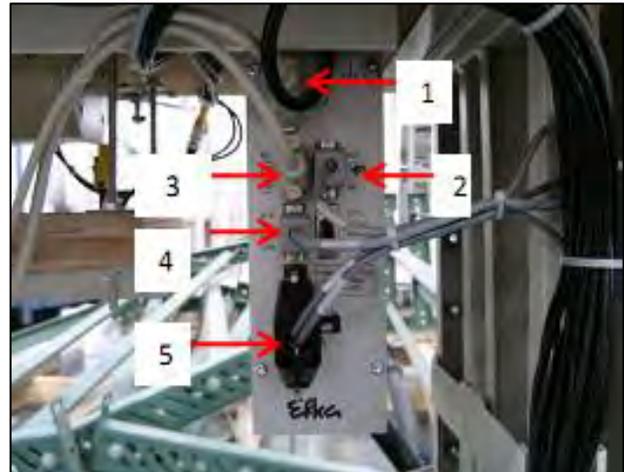


Efka Motor

Connections

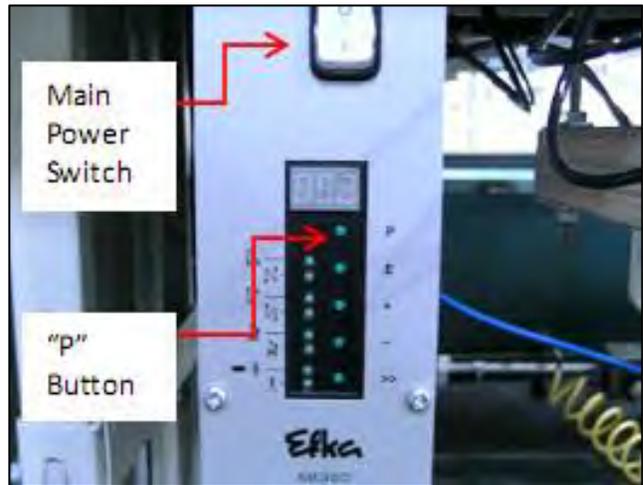
The back of the Efka Motor has all of the cables.

- 1.- Power Cable for the Efka Motor.(Goes to the Efka Motor)
- 2.-Foot Pedal Cable
- 3.- Commutation Transmitter (goes to the Efka Motor)
- 4.-Hand wheel Eye
- 5.-Socket for solenoid inputs and outputs, solenoid valves, displays, keys and switches

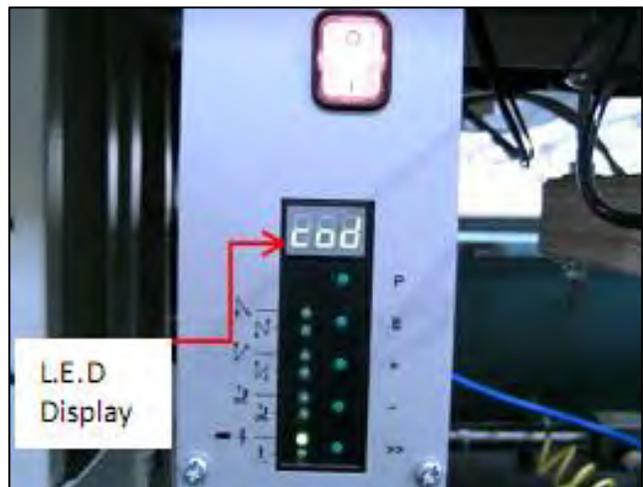


Programming

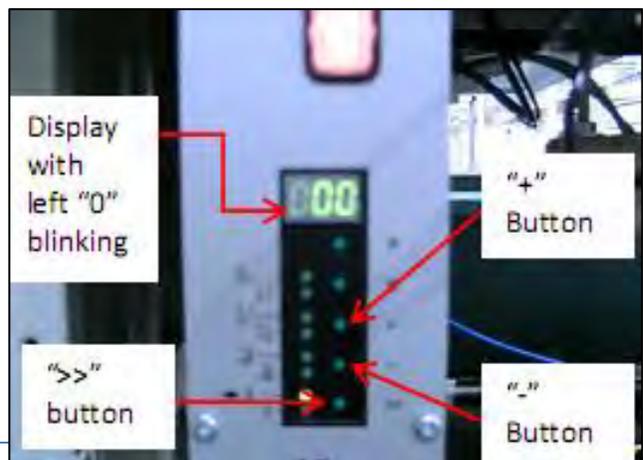
1) Press and hold the “P” button while turning on the Main Power Switch.



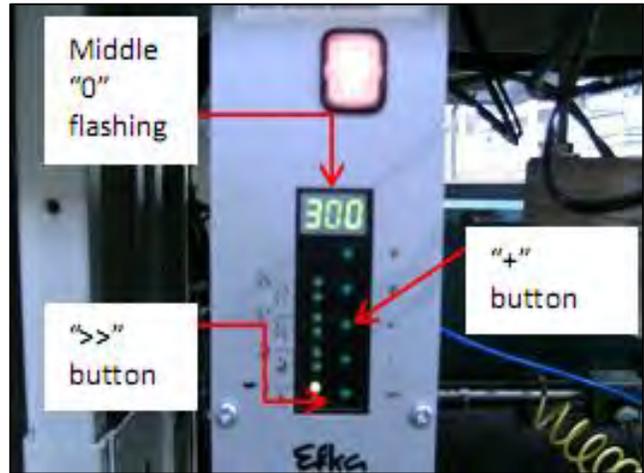
2) Once “cod” (short for code) appears in the display release the “P” button and press the “>>” button. The code to enter in is “311”



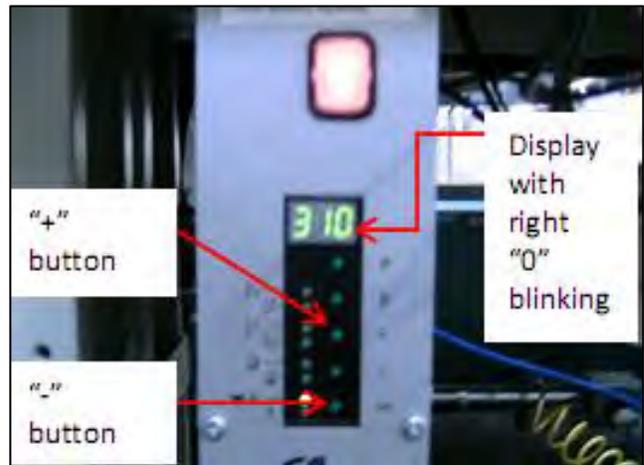
3) 000 will appear on the display with the left 0 blinking. Press the “+” three times to get a “3” in the display, if you go past “3” then either continue pressing the “+” button until it cycles back or press the “-” button to go back. Then press the “>>” button. Page 1



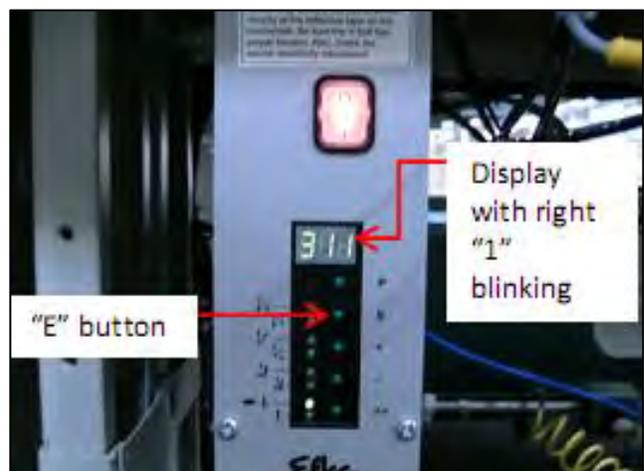
4) Display should look like picture to the left with the middle “0” blinking, if not press the “>>” button until the middle “0” is blinking. Press the “+” button once to get a “1” as the middle number. Then press the “>>” button.



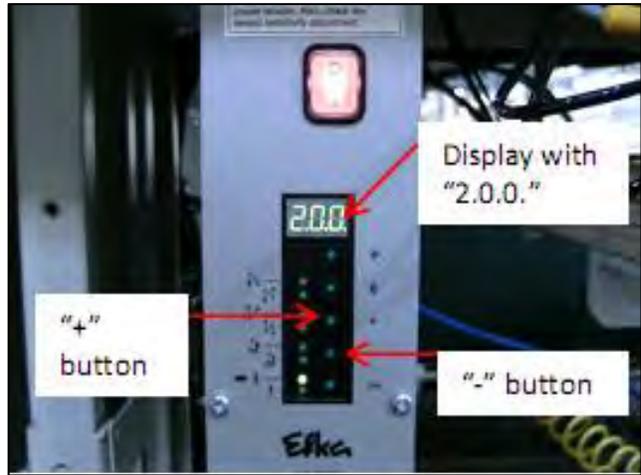
5) Display should look like picture to the left with the right “0” blinking, if not press the “>>” button until the right “0” is blinking. Press the “+” button once to get a “1” as the right number.



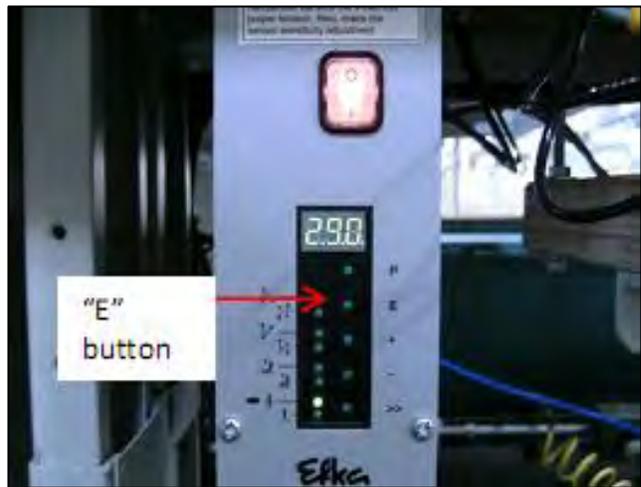
6) Display should look like picture to the left with the right “1” flashing. (It does not matter which number in the display is blinking as long as it reads “311”) Press the “E” button.



7) The display will change to “2.0.0.” this is a parameter number “200”. Any number with the “.” between the digits will be a parameter. To move to the correct parameter you will press either the “+” or “-” buttons. Press and hold the “+” button, the parameter numbers will start scrolling faster the longer the button is held down, until “2.9.0.” is displayed. This is the first parameter to be programmed when starting new, only using as an example. (You may need to access a different parameter number, use the same method as above)



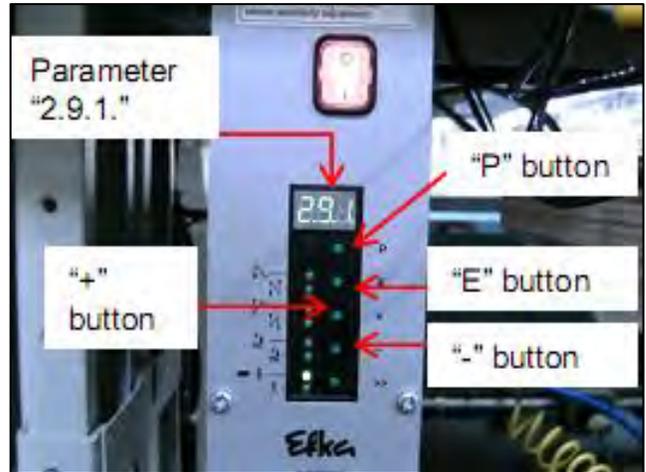
8) With “2.9.0.”(or parameter number you chose) in the display, which is parameter “290”, press the “E” button once.



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



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



11) The display will now show the set maximum RPM. The display only shows three numbers the actual RPM in the example picture is 3200 RPM. You will need to sew at least one stitch to lock in the changes to the parameters and complete the process.



Basic Machine Operation

Loading the Roll Holder

Remove the outer disc from the upper rod. Place a roll of material on the rod and replace the outer disc. Feed the material over the top roller and down to the folder with the good side toward the sewing head. (When making continental foundations, the good side will face the operator)

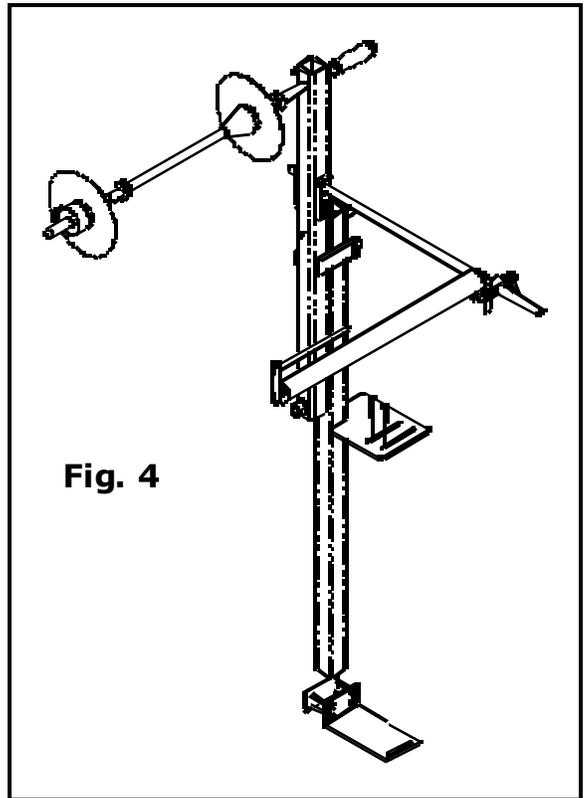


Fig. 4

Loading and Adjusting the Folder

Feed the gusset through the top portion of the folder with the flange to the right and under the right flange guide. Adjust the left guide to make a snug fit to the gusset width. Adjust the folder left or right as necessary to set the desired stitch margin. Normally, with the folder positioned to its right most position in its slots, a 6" wide gusset will be centered on the needle. The folder spacers should be sized as required to fit the thickness of the gusset. Extra spacers can be ordered to fit any thickness gusset from 1/8" to 9/16". Adjust the lower portion of the folder in the same manner.

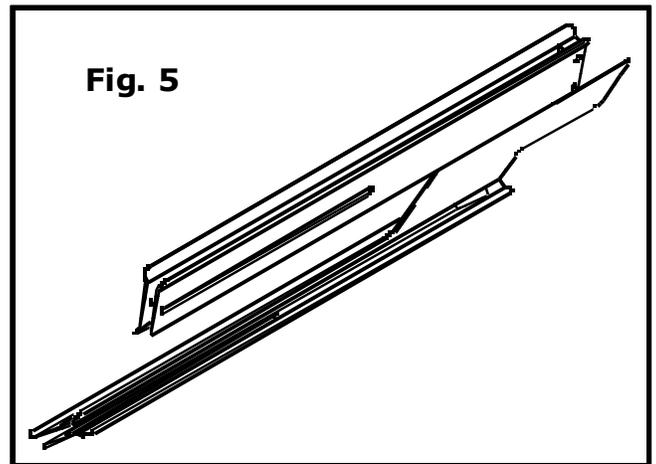


Fig. 5

Adjusting the Edge Guide

The edge guide located on the front of the table should be set so its left edge aligns with the right edge of the gusset. This is the guide for the right edge of the panel.

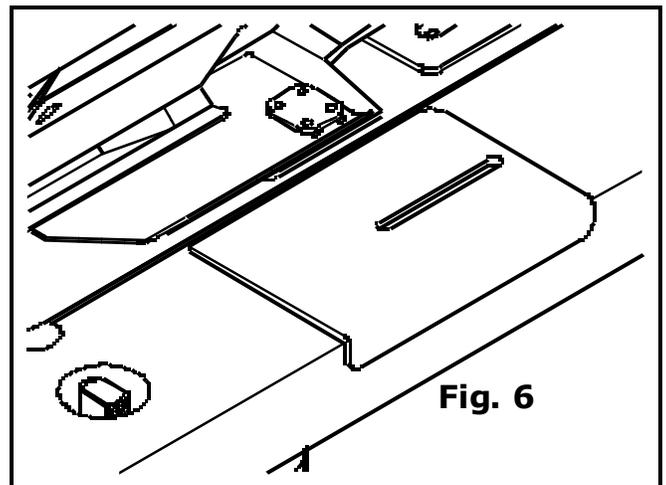


Fig. 6

Loading the Panel

Heal back the treadle or step on the foot lift pedal to raise the presser foot. Swing in the stripper blade and the folder/ruffler assembly. Be sure the sensor at the back of the swing-out bracket is lit indicating that the bracket is all the way in to the detent. Activate the "Wipe" switch to raise the folder for easier loading. Pull the gusset through the folder, under the presser foot and under the puller. Activate the "Wipe" switch again to lower the folder. Load the panel under the gusset with the center of the short side even with the needle and the edge of the panel against the edge guide. Lower the presser foot. Be sure the Auto/ Manual switch is in its Auto position (up). Be sure the folder is "Down". The automatic cycle will not function while the folder is up.

Sewing the Panel with Rounded Corners

Set thumbwheel #5 to any ruffle setting between 1 and 6 as desired.

Sew the panel to the corner being sure not to get your hands in the way of the electric eye mounted under the table which must "see" the edge of the panel as it nears the presser foot. The machine will stop automatically at the corner. Go to neutral treadle as you position your hands for turning. Place your right hand on the panel near the presser foot and your left hand about 1 foot to the left on the panel. Treadle forward and allow the machine to make the first ruffle sewing straight. Begin to rotate the panel as the rest of the ruffles are formed. Try to turn an equal amount with each ruffle so that when the ruffles are complete the panel has turned 90 degrees and the right edge of the panel is resting against the left edge of the edge guide. The ruffles can be made one at a time by going to neutral treadle between each ruffle. Complete all four corners.

Sewing the Panel with Straight Corners

Set thumbwheel #5 to "7" for 1 ruffle per side, "8" for 2 ruffles per side, or "9" for 3 ruffles per side. Sew the panel to the corner being sure not to get your hands in the way of the electric eye mounted under the table, which must "see" the edge of the panel as it nears the presser foot. The machine will pause momentarily as the ruffler engages and then continue to sew straight as it makes the ruffles.

After the last ruffle is finished on the first side of the corner the machine will continue to sew slow stitches based on the setting of thumbwheel #1. The number of slow stitches sewn is equal to twice the setting of thumbwheel #1. Setting the thumbwheel to "0" will disable this slow sew function. After the slow stitches the machine will stop with the presser foot lifted. Turn the panel 90 degrees. Release and depress the treadle. The foot will drop and the machine will again make slow stitches based on the setting of thumbwheel #1, and then begin making the ruffles on the second side of the corner. When the ruffles are complete the machine will resume sewing at treadle speed. Adjust the stop count as necessary to achieve the desired corner finish.

Adjusting the Corner Ruffles

The ruffles should be set so the outer edge of the gusset lays flat for taping. A typical ruffled gusset will have ruffles which butt against each other without overlapping or gaps between them. Adjust Thumbwheels #5 and #6 and the ruffle size knob to achieve the desired finish. Euro style gussets typically have 3 or 4 small ruffles with extra stitches between them.

Finishing the Panel

After the last corner, sew the panel until the starting edge of the gusset is almost to the presser foot. Stop and activate the "Wipe" switch to raise the folder. Cut the gusset so that there is enough overlap of gusset for finishing. Swing out the stripper blade. Fold the trailing edge of the gusset under itself, lay it on top of the starting edge and oversew the two together. Heal back and remove the panel. Reload the gusset under the foot and puller and lower the folder. Note: The automatic functions will not operate with the folder up!

Efka Control Box Settings

The Efka control has been preprogrammed to operate the sewing head in conjunction with the ruffler. The maximum sewing speed has been preset to 4000 RPM. The maximum sewing speed can be temporarily reduced by holding in the "-" button on front of the control box while sewing. To restore maximum speed use the "+" button. Be sure the needle down LED is the only LED lit on front of the control box. The LED's can be changed only immediately after power on or a full healback. Refer to the appendix for complete Efka programming parameters.

General Machine Adjustments

Air Pressure

Set all air supply pressure regulators (Right to left):

Main Pressure:	70 PSI
Puller Pressure:	30 PSI
Ruffle Blade Pressure:	10 PSI
Foot Sew Pressure:	15 PSI

Sewing Head

See the manufacturer's manuals for normal adjustments and parts. The presser foot spring pressure should be set very light so that the ruffling blade can feed under the foot while ruffling. The Efka motor should be set for stopping needle down at neutral treadle to help hold the ruffle in place while turning the corners. The auxiliary foot pressure cylinder should be set to provide added foot pressure while sewing straight.

Ruffler Drive

Set the Ruffler blade position left to right. The slot in the Ruffler blade should align with the sewing needle. Loosen the 4 clamp screws and adjust ruffler blade left or right as needed.

Set the Ruffler blade IN position so that the front edge of the blade is even with the needle when the ruffler drive is positioned at the IN sensor. To position the drive at the sensor, press the manual ruffle button once and quickly tap the treadle or sew pedal. The Ruffler should position itself at the IN sensor. Adjust the sensor position in its slot, press the manual ruffle button to reset the ruffler and repeat the cycle to test the setting.

Set the Ruffler blade OUT position by turning the adjusting knob on the front cover of the ruffler drive. This controls how big each ruffle will be. After making an adjustment, always reset the ruffler by pressing the manual ruffle button twice.

The swing-out stripper blade protects the panel from the ruffler blade while ruffling so that the panel does not get pleated by the blade. It should be positioned as close to the presser foot as possible. The ruffling air pressure should be set as high as practical without it pressing the stripper blade down and pinching the panel while turning.

Puller Drive

Set the puller down position as low as practical without actually touching the cloth plate. The roller should be centered on the needle. Set the Puller air pressure as needed to provide positive feeding without the puller stalling at high speed.

General Machine Maintenance

Daily

- Clean machine at the end of every shift
- Clean lint etc. from the Looper/bobbin area on the sewing head
- Remove any threads wrapped around moving parts of the handwheel, puller, and ruffler.
- Wipe all photo eye lenses with clean, nonabrasive, dry cloth
- Use blow-off hose to get rid of excess lint, thread and other clippings
- Follow manufactures recommendations and guidelines for daily maintenance and lubricating of the sewing head.

Weekly

- Check all belts for tightness and condition. Adjust or replace as necessary.
- Check oil level in oil pan.
- Put one drop of machine oil on all moving Ruffler parts.

Reflective Tape Maintenance

Use a soft cloth for cleaning.

Do not use chemicals or abrasives to clean it.

Avoid any contact with oils and liquids.

Do not touch the tape with bare fingers.

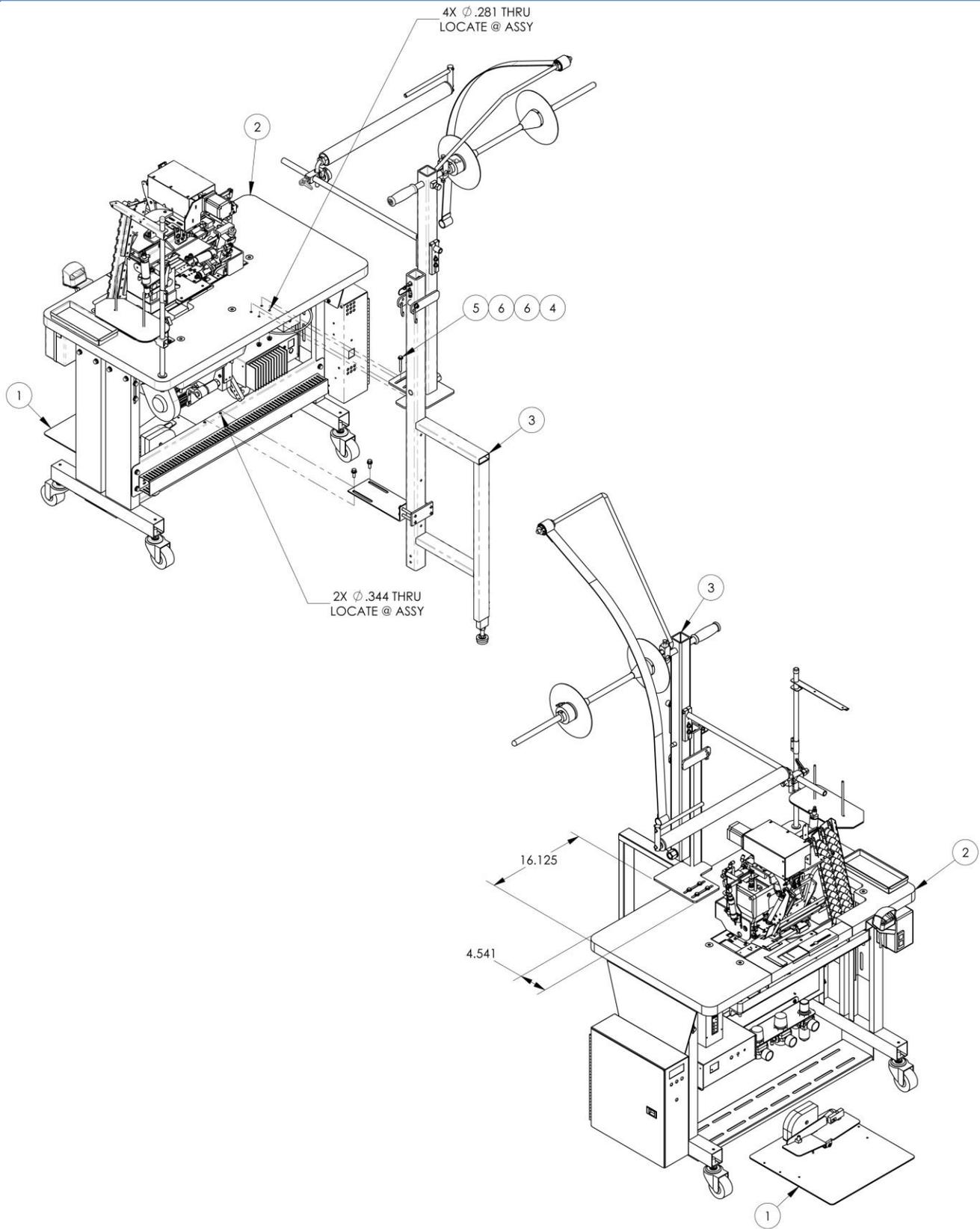
If tape is dirty or opaque, the eye may not function correctly.

Assembly Drawings & Parts Lists

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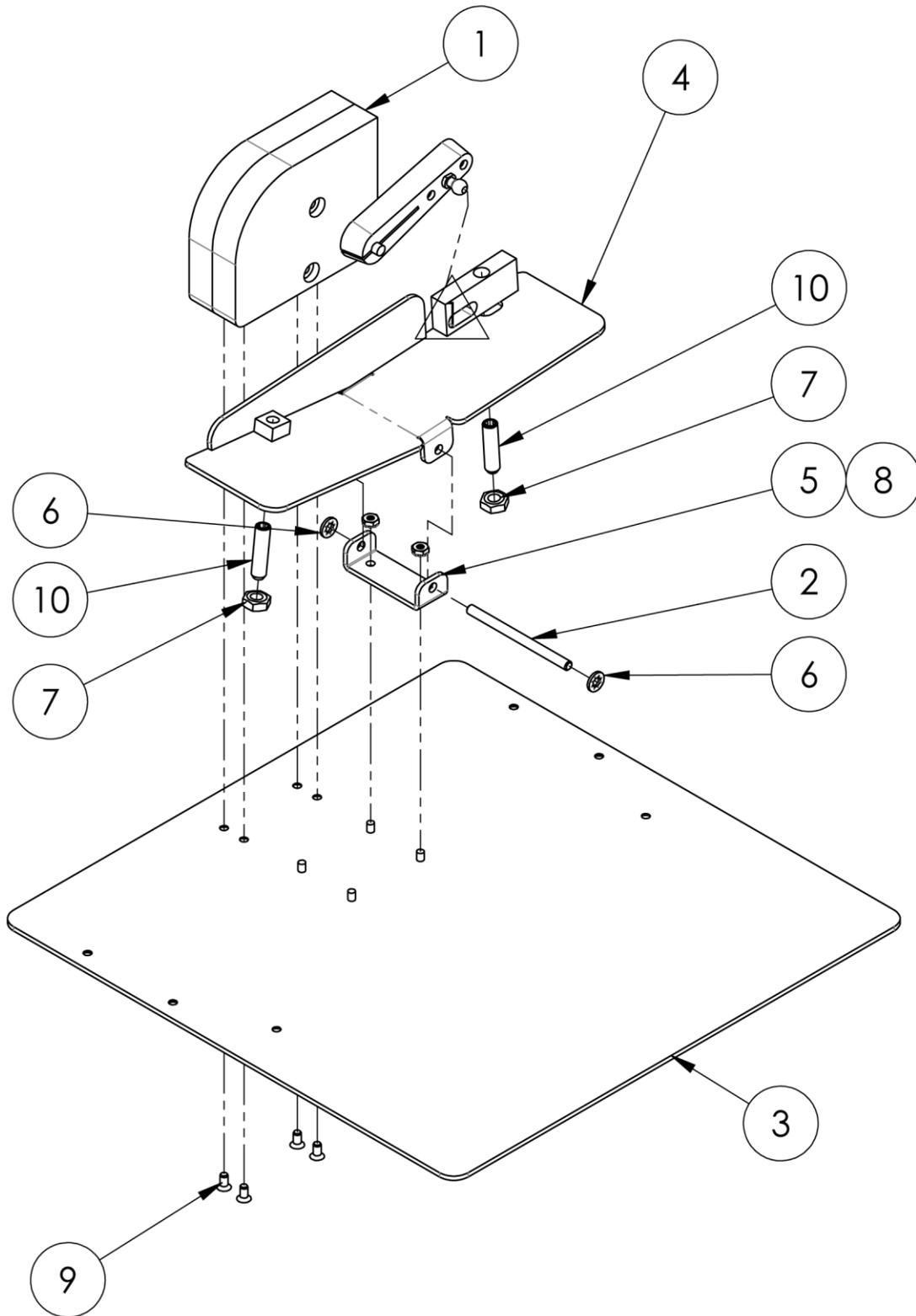
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11335ET-RUFFLER WORK STATION, ECONOMY

AAC Drawing Number 9004646 Rev 0

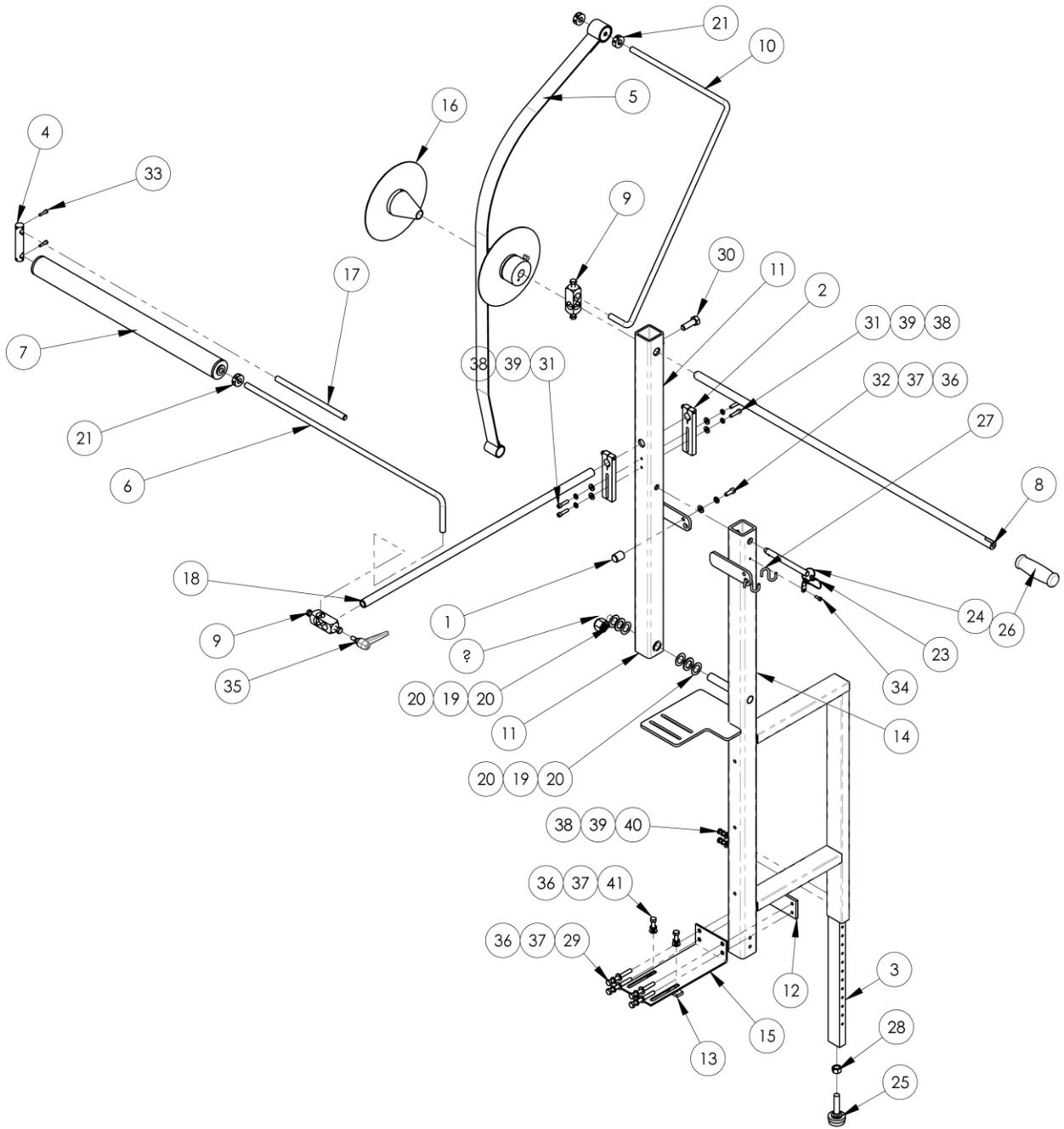
NO	QTY	PART #	DESCRIPTION
1	1	4059-FP301D	FOOT PEDAL ASSY,EFKA
2	1	1325145	BASE CONSOLE,TYPICAL
3	1	1335930	ROLLHOLDER ASSY,OVERHEAD
4	4	NNK1/4-20	NUT,KEP,1/4-20
5	4	SSHC01144	HEX HEAD BOLTS
6	8	WWFS1/4	WASHER,FLAT,SAE,1/4



4059-FP301D FOOT PEDAL ASSY, EFKA

AAC Drawing Number 9000033 Rev 5

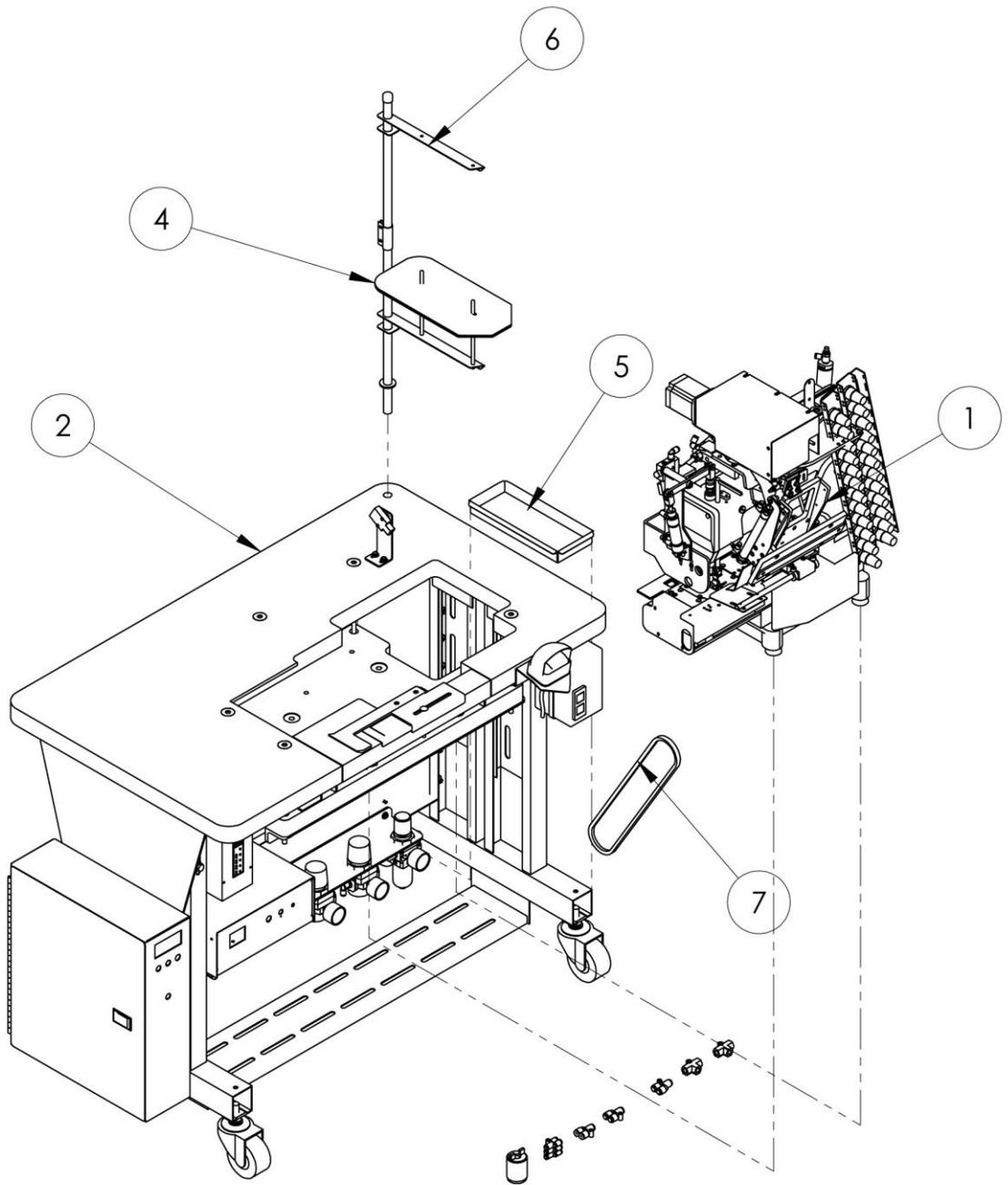
NO	QTY	PART #	DESCRIPTION
1	AR	4059-EB301A	ACTUATOR,TREADLE,9 PIN
2	1	26058	ROD, STRAIGHT, 1018
3	1	4059030	BASE, FOOT PEDAL, 12X18
4	1	4059033	FOOT PEDAL WELDMENT
5	1	A3502-4	FOOT PEDAL, BRACKET
6	2	MM94807A029	PUSHNUT,ROUND,1/4 DIA
7	2	NNJ3/8-16	3/8-16 JAM NUT
8	2	NNK10-32	KEP NUT, 10-32
9	4	SSFPM5X10	SCREW,FLAT PHILLIPS
10	2	SSSS25096	3/8-16 SET SCREW, 1-1/2"



1335930 ROLL HOLDER ASSY. OVERHEAD

AAC Drawing Number 1335930 Rev 4

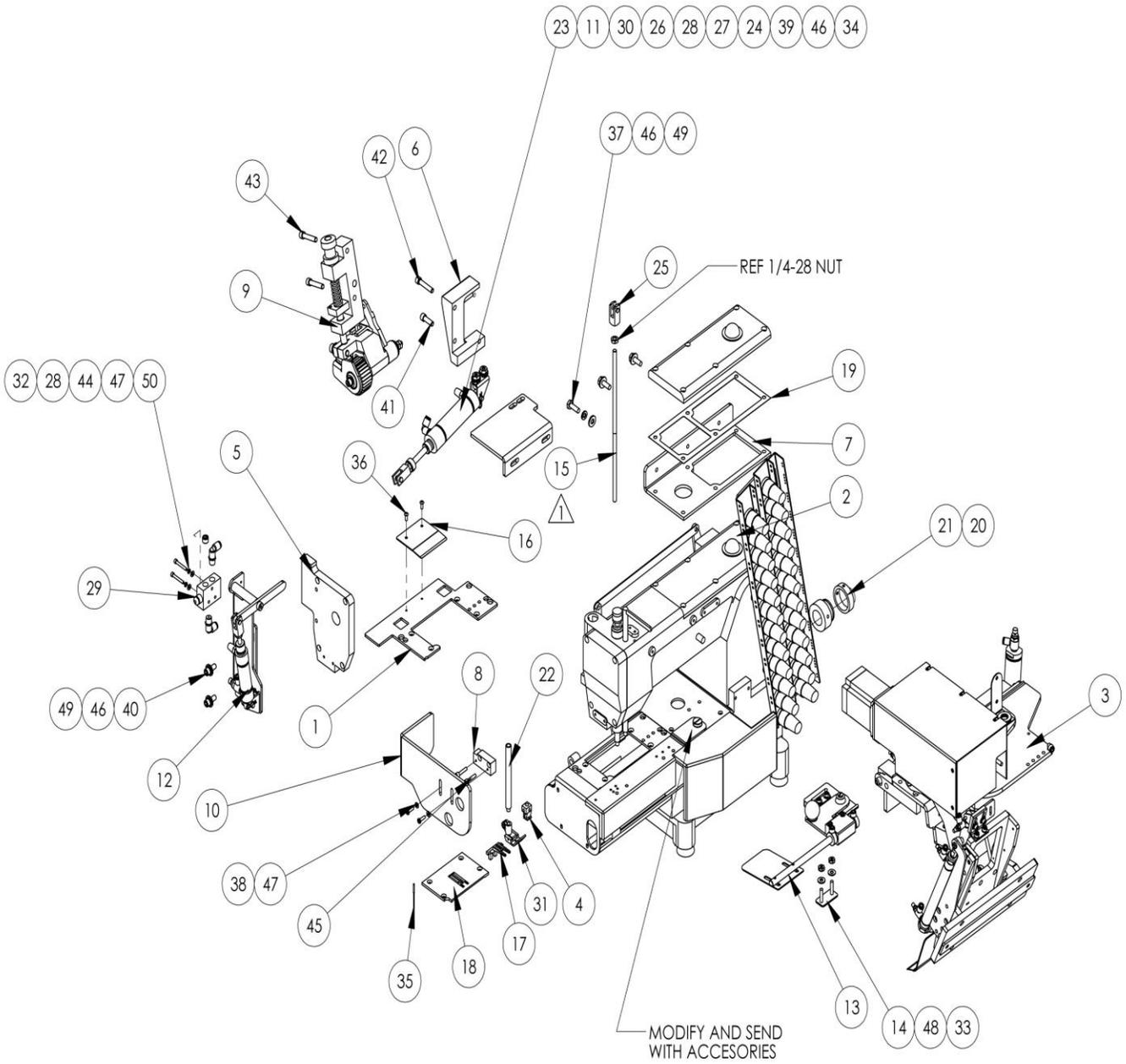
NO	QTY	PART #	DESCRIPTION
1	1	11200A	BUMPER 5/16-24
2	2	1325-346A	HOLDER, ROD, 3/4", SLOT
3	1	132556-273	LEG, 3/4 X 1-1/2 X 15 LG
4	1	1335-319B	ARM, 1/2" ROD CLAMP
5	1	1335-825	DRAG TENSION ASSEMBLY
6	1	1335-835A	ROD,1/2 DIA, 90 DEG
7	1	1771-205	ROLLER,2.0ODX.51DX23.38L
8	1	1961-252E	ROD,ROLL,38.0L
9	2	28201	BLOCK,CROSS,(LARGE)
10	1	1335179	ROD,BENT,CRS,1/2 OD
11	1	1335664	PIVOT,SWING
12	1	1335667	NUT,PLATE,5/16-18 4X
13	1	1335794	NUT,PLATE,5/16-18,2@3.0
14	1	1335931	MAIN SUPPORT,UNWINDER
15	1	1335932	STABILIZER,UNWINDER,1335E
16	2	33008708	DISC ASSY,8"
17	1	8732-0576	ROD, STRAIGHT, SS, 1/2 X
18	1	97-1711	TUBE, 3/4 X 30 X 1/8 WALL
19	2	BBNTA1220	BEARING,THRUST,.750B
20	4	BBTRA1220	WASHER,THRUST,STEEL
21	3	CCCL8F	CLAMP COLLAR- 1/2
22	2 FT	K-3594T47	CHAIN, .190, .34W
23	1	MM30345T21	LANYARD,6"LONG
24	1	MM98320A525	QUICK RELEASE PIN,1/2"DIA
25	1	MMFB4444	FOOT, RUBBER
26	1	MMGP-105	GRIP HANDLE-FOAM 3/4 ID
27	2	MMS096	HOOK,S,3/16 X 1-1/2"
28	1	NNH1/2-13	NUT,HEX,1/2-13
29	4	SSHC10176	5/16-18 X 2-3/4 HEX HEAD
30	1	SSHC45096	1/2-13 X 1-1/2 HEX HEAD
31	4	SSSC01064	1/4-20 X 1 SOC CAP
32	1	SSSC20048	5/16-24 X 3/4 SOC CAP
33	2	SSSC95048	# 10-24 X 3/4 SOC CAP
34	1	SSSC98032	# 10-32 X 1/2 SOC CAP
35	1	TH32425	HANDLE,THRDED,5/16-18X3/4
36	7	WWFS5/16	WASHER, FLAT, 5/16
37	7	WWL5/16	5/16 LW
38	6	WWFS1/4	WASHER,FLAT,SAE,1/4
39	6	WWL1/4	WASHER,LOCK, 1/4
40	2	SSHC01064	1/4-20 X 1 HHCS
41	2	SSHC10064	5/16-18 X 1 HHCS
42	1	NNE.75-16	NUT,ELASTIC LOCK,3/4-16



1325145 BASE CONSOLE, TYPICAL

AAC Drawing Number 1325145 Rev 0

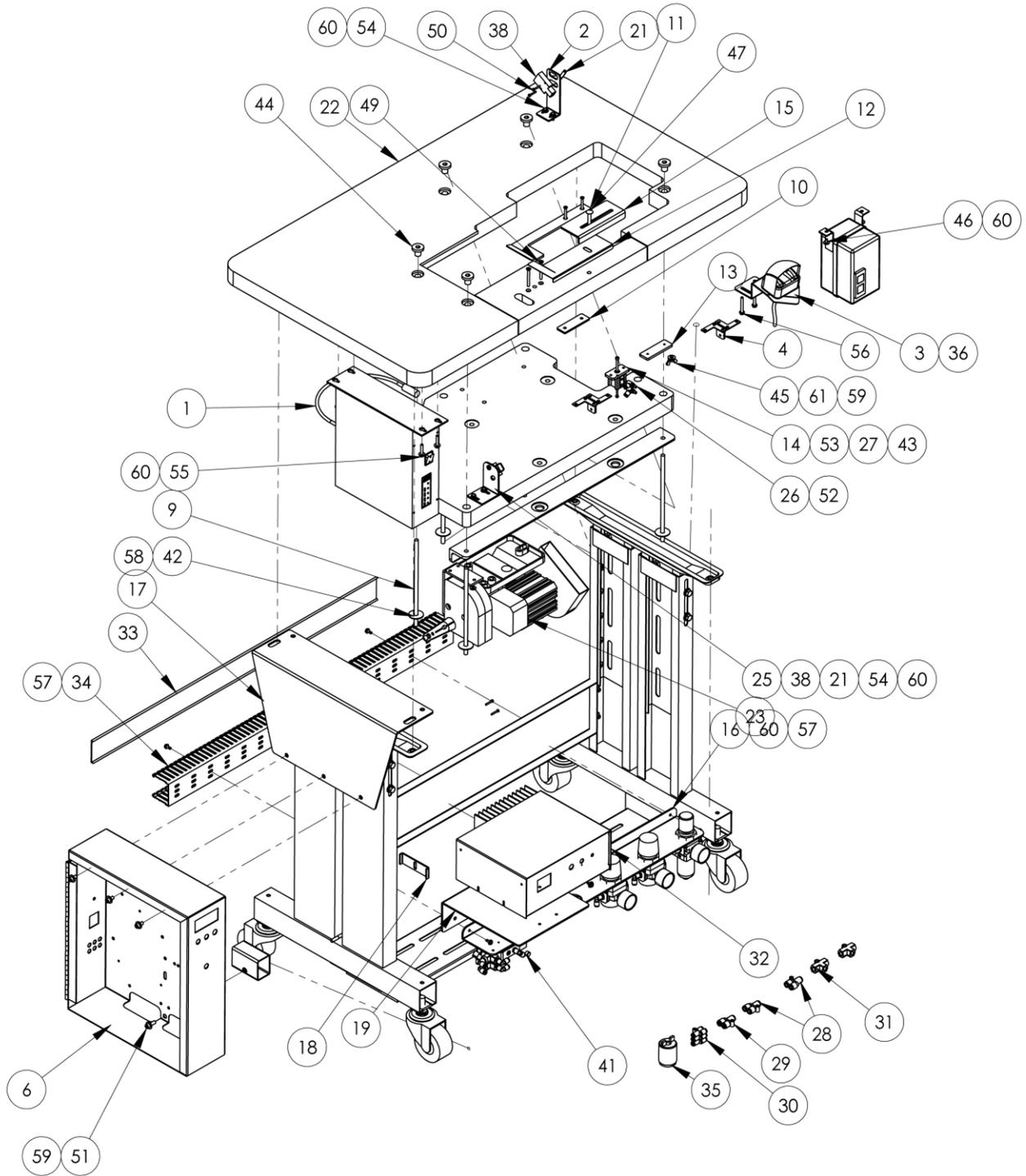
NO	QTY	PART #	DESCRIPTION
1	1	1325144	SEW HEAD SUBASSEMBLY
2	1	1325165	STAND / MOTOR ASSY
NS	AR	1335MF-PD	DIAGRAM, PNEUMATIC
4	1	1959-112	2 POS THREAD PLATE ASSY
5	1	26151	TOOL TRAY, 1X3.5X9
6	1	D-2	THREAD STAND, 2 THREAD
7	1	ZX3833	V-BELT, 3/8 X 33



1325144 SEW HEAD SUB-ASSEMBLY

AAC Drawing Number 1325144 Rev 1

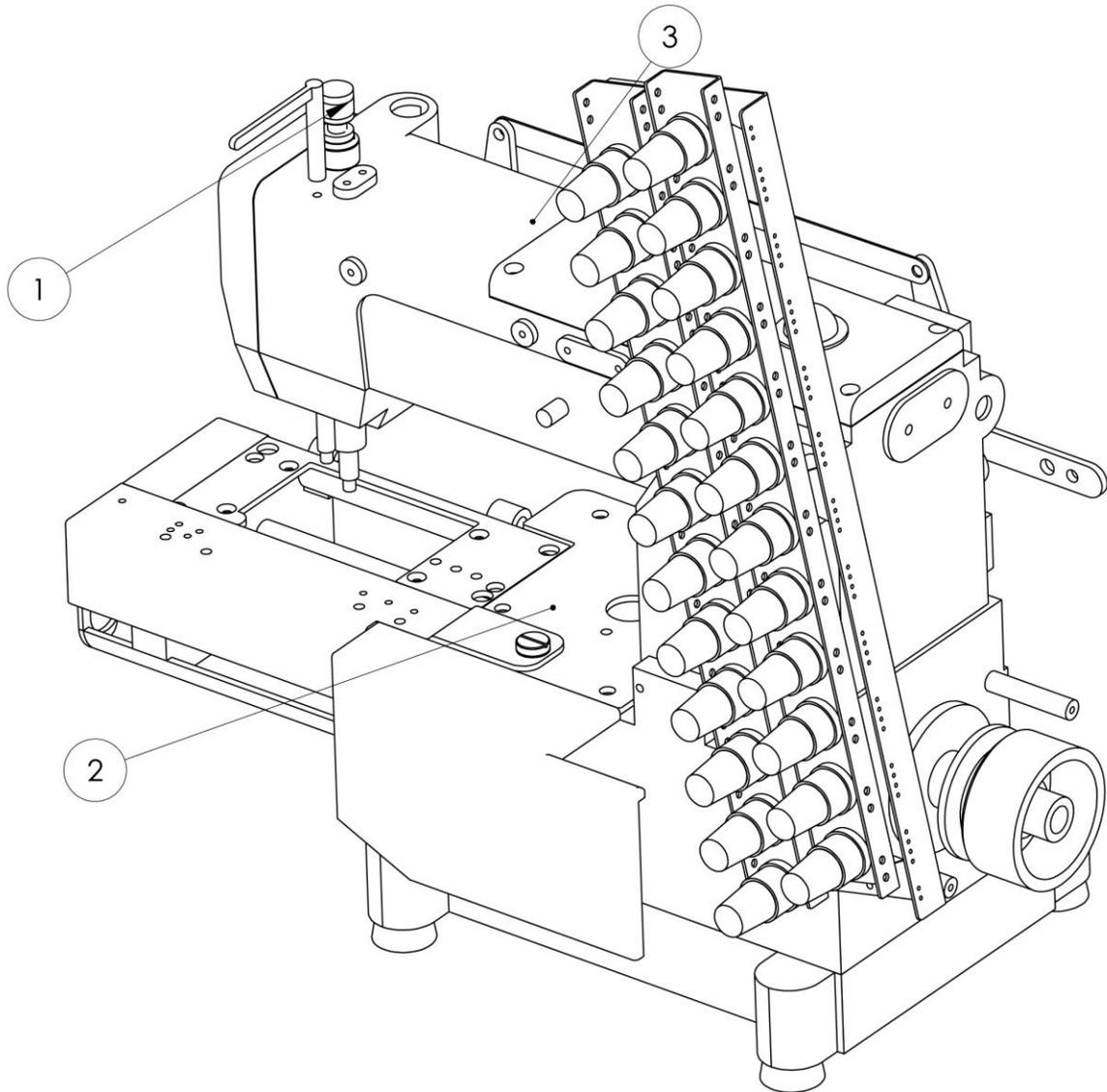
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	1325146	SEW HEAD PLATE	26	1	AAFCT-11	CLEVIS, CYL, 5/16-24, 1/4
2	1	1325147	SEWING HEAD, MODIFIED	27	1	AAFP18	MUFFLER, 1/8 NPT, BRONZ
3	1	1325148	RUFFLER ASSEMBLY, TYP	28	3	AAQME-5-8	QUICK MALE ELBOW
4	1	1325151	NEEDLE CHUCK, 1N TYP	29	1	AAV41-P	HUMPHREY VALVE, 4 WAY
5	1	1325152	FACE PLATE, TYP	30	1	CCCL5F	CLAMP COLLAR, 5/16" BORE
6	1	1325153	BRKT, PULLER MOUNT, TYP	31	1	M1V67-016	FOOT, 1N, RUFFLER
7	1	1325154	RUFFLER MOUNTING BKT, TYP	32	1	MM4554K11	PLUG, 1/8" PIPE
8	1	1325159	SPACER, GUARD, TYPICAL	33	2	NNK10-32	KEP NUT, 10-32
9	1	1325160	PULLER SUB-ASSY	34	2	NNK1/4-20	NUT, KEP, 1/4-20
10	1	1325163	PULLER GUARD-HD	35	10	SN62X5721	NEEDLE, SIZE 130/21
11	1	1325166	BRACKET PULLER LIFT-HD	36	2	SSBC80024	6-32 X 3/8 BUTTON HEAD
12	1	1325173	FOOT PRESSURE ASSY	37	3	SSHC05048	1/4-28 X 3/4 HEX CAP
13	1	1325175	STRIPPER BLADE ASSY	38	2	SSPP80032	#6-32X1/2 PAN PHILLIPS
14	1	1325177	PLATE, 10-32 PEM STUD	39	2	SSSC01032	1/4-20 X 1/2 SOC CAP
15	1	1335209	FOOT LIFT PIN	40	2	SSSC01040S	1/4-20 X 5/8" SOC CAP SS
16	1	1335418	PULLER WEAR PLATE	41	1	SSSC01048	1/4-20 X 3/4" SOC CAP SC
17	1	1888N12S01	FEED DOG 1N	42	1	SSSC01080	1/4-20 X 1-1/4 SOC CAP
18	1	1889N13000	THROAT PLATE, 1 NDL	43	2	SSSC05080	SCREW, SOCKET CAP 1/4-28X1-
19	1	197100005	HEAD GASKET	44	2	SSSC80064	6-32 X 1 SOC CAP SC
20	1	311-128	HUB, HANDWHEEL, TAPE MOUN	45	2	SSSCM4X20	SCREW, SOC CAP, M4-0.7X20
21	1	311-129	SLEEVE TAPE MOUNT ADJUST	46	7	WWFS1/4	WASHER, FLAT, SAE, 1/4
22	1	3300015	PRESSER BER, 1804 YAMATO	47	4	WWFS6	WASHER, FLAT, #6
23	1	AAC6DP-1.5	CYLINDER, AIR, DA, PIVOT	48	2	WWFS10	WASHER, FLAT, #10, SAE
24	1	AAFBP-11C	BRKT, PIVOT, 1/4 BORE	49	5	WWL1/4	WASHER, LOCK, 1/4
25	1	AAFCT-7	HUMPHREY CLEVIS	50	2	WWL6	WASHER, LOCK, #6



1325165 STAND / MOTOR ASSY

AAC Drawing Number 1325165 Rev 2

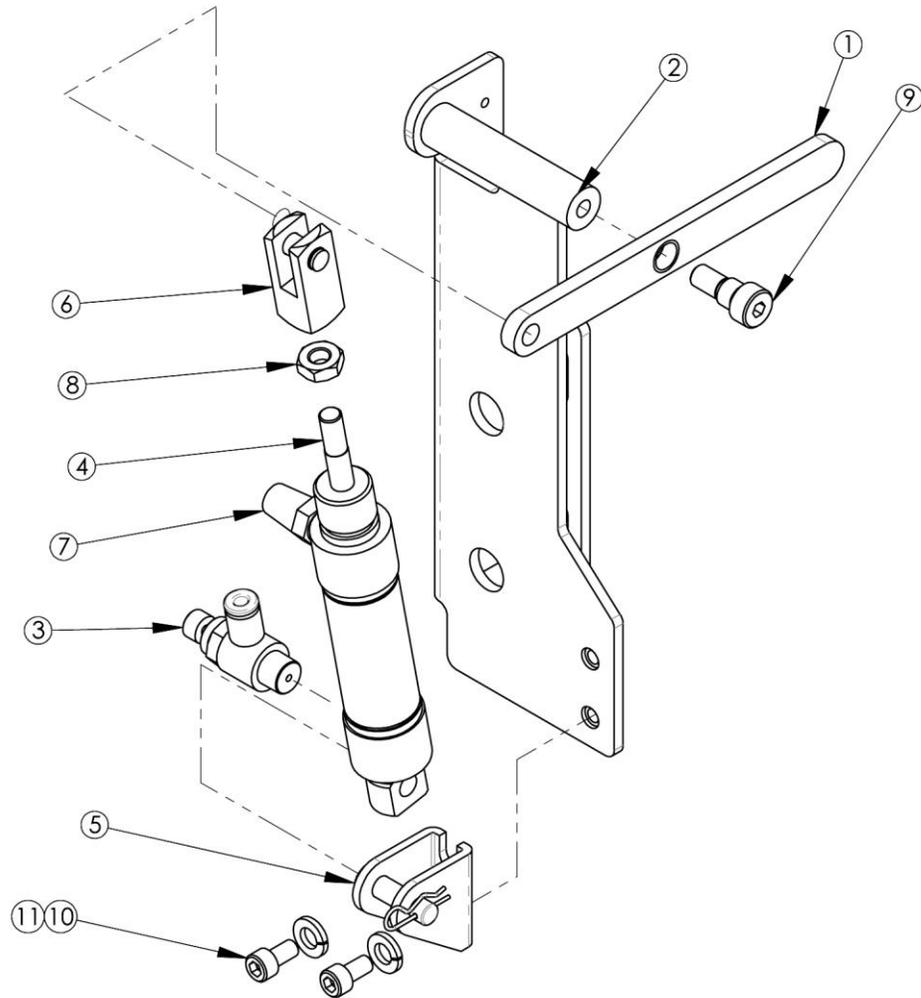
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	0211-702A	CABLE,POS. SENSOR,6'	34	2.8 FT	EEDF2X2	DUCT,WIRE,2X2, MOD
2	1	1278-6689B	BRACKET, EYE MOUNT	35	1	FFHBL4579C	RECEPTACLE,3 POLE,3W
3	1	1278-6718A	BRKT,OPTO TOUCH SWITCH	36	1	FFOTBVN6	SWITCH,OPTO-TOUCH
4	4	1335M-114	HINGE BRACKET	37	1	FFRK44T3P5	CABLE, EURO-3P
NS	AR	1335M-LAB	LABELS	38	2	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
6	1	1335MF-500	CONTROL BOX ASSY	39	1	K-4D	HD TLEG ADJ STAND
NS	AR	1335MF-PD	PNEUMATIC DIAGRAM	40	1	K-CB600	MOTOR STARTER,ELEC
NS	AR	1335MF-WD	WIRING DIAGRAM	41	1	MM4554K11	PLUG, 1/8" PIPE
9	5	1335244	ROD THRD,5/16-18 X 8.75	42	5	NNH3/8-16	5/16-18 HEX NUT
10	1	1335274	WASHER PLATE - PANEL TENS	43	1	NNHM4X0.7	M4 X 0.7 HEX NUT
11	1	1335275	TOP PLATE- PANEL TENSION	44	5	NNM103	NUT,RECESSED,5/16-18
12	1	1335278	PANEL TENSION FINGER	45	1	NNW1/4-20	NUT, WING, 1/4-20
13	1	1335280	NUT PLATE - PANEL TENSION	46	2	SSBC90024	#8-32 X 3/8 BUTHEAD
14	1	1335281	NUT PLATE - PANEL TENSION	47	1	SSBK01160	1/4-20 X 2 1/2 BOLT, CARG
15	1	1335284	EDGE GUIDE	48	2	SSFS90128	#8-32 X 3/4 FLAT SLOT
16	1	1335716	PNEUMATIC, SHELF	49	2	SSFS98112	#8-32 X 3/4 FLAT SLOT
17	1	1335784	BRKT,ANGLE,CONTROL BOX	50	4	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
18	1	1335786	SPACER HOLDER	51	1	SSSC01048	1/4-20 X 3/4 SOC CAP
19	1	1335936	BRKT,MNT,STEP BOX	52	2	SSSCM3X30	M3-0.5 X 30 SOC CAP
20	1	1347683	LOWER TABLE SUPPORT ANG.	53	1	SSSCM4X40	M4-0.7 X 40 SOC CAP
21	2	1975-412A	PLATE,NUT,4-40,.95CTC	54	4	SSZH#10032	#10 X 1/2 HSMS
22	1	4048-GK321FR	TABLE TOP,MAIN,W/SUPPORT	55	4	SSZH#10064	#10 X 1 HSMS
23	1	4059-DC1500	MOTOR & CONTROLLER	56	2	SSZH#10096	#10 X 1-1/2 HSMS
24	1	4080-4508B	CABLE,STEP MOTOR,4 AMP,7'	57	6	SSZS93032	SCREW, SHT.METAL 10 ZIP
25	1	98205010	BRKT,SENSOR,982A	58	5	WWFE020	WASHER,FENDER,5/16
26	2	AA198RA510	FL CONT,5/32X10-32	59	5	WWFS1/4	WASHER FLAT, 1/4
27	1	AACNCQ2B16-10D	COMPACT, 16MM BORE, 10MM	60	12	WWFS10	WASHER, FLAT #10
28	2	AAQUY-4-4	Y UNION, 1/4X1/4	61	1	WWL1/4	1/4 LW
29	1	AAQUY-5-4	Y UNION, 5/32X1/4	62	3	SSSC01032	1/4-20X1/2 SOC CAP
30	3	AAQUY-5-5	QUICK UNION Y, 5/32	63	1	1335785	SPACER BLOCK
31	2	AAVS125	SHUTTLE VALVE,1/8"PORT	64	1	WWFS1/4	WASHER,FLAT,SAE,1/4
32	1	AP-28-800Y1A	BOX,STEPPER,H.S. (X5),2A	65	1	WWL1/4	WASHER,LOCK,1/4
33	2.8 FT	EEDC2X2	COVER,WIRE DUCT	66	1	SSHC01160	1/4-20 X 2-1/2 HHCS



1325147 SEWING HEAD, MODIFIED

AAC Drawing Number 1325147 Rev 0

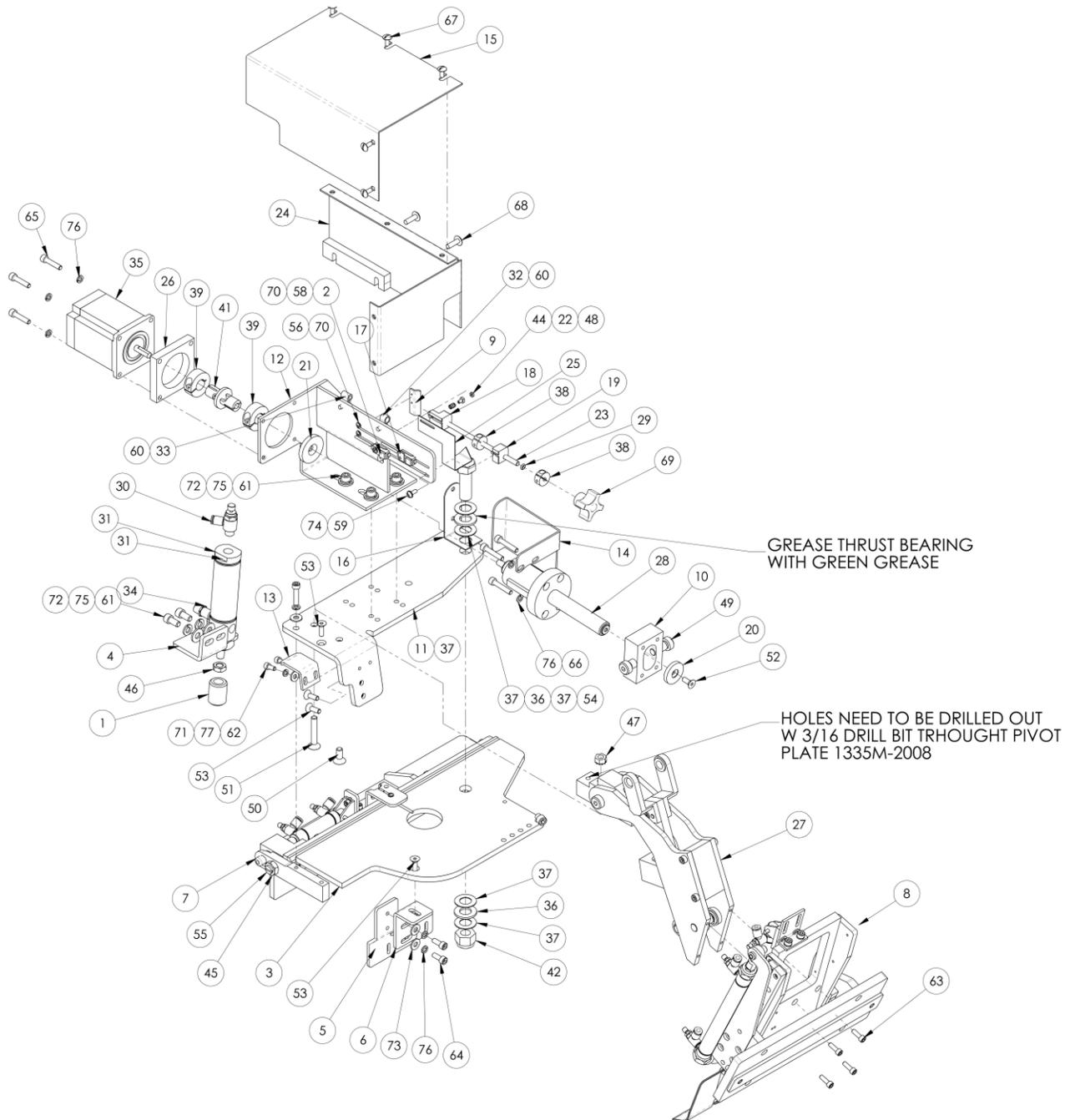
NO	QTY	PART #	DESCRIPTION
1	1	1325164	FOOT LIFT ADJ - MOD
2	1	1325176	CLOTH PLATE NODIFIED
3	1	STYP-GK321-12	SEWING HEAD WITH PULLER
4	1	321KIT01	OIL WICK KIT



1325173 FOOT PRESSURE ASSEMBLY

AAC Drawing Number 1325173 Rev 0

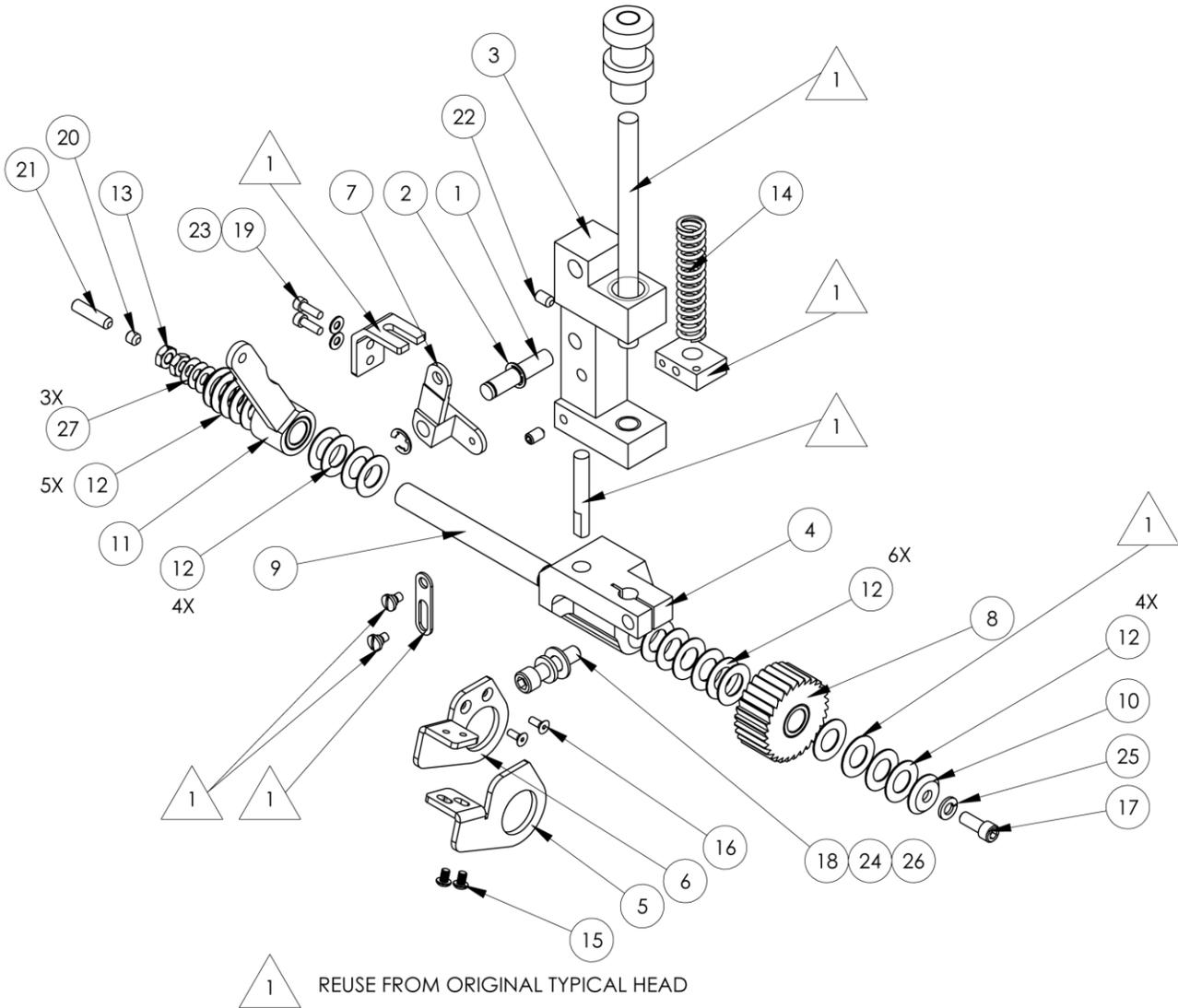
NO	QTY	PART #	DESCRIPTION
1	1	1335M-108	LEVER
2	1	1325171	MTG BRKT, FOOT LIFT
3	1	AA198RR508	FLOW CONTROL, 5/32 X 1/8"
4	1	AAC7DP-.5	CYLINDER, AIR, DA
5	1	AAFBP-11C	BRKT, PIVOT, 1/4 BORE
6	1	AAFCT-7	HUMPHREY CLEVIS
7	1	AAFP18	MUFFLER, 1/8 NPT, BRONZ
8	1	NNJ1/4-28	1/4-28 HEX JAM NUT
9	1	SSAS020016	SHOULDER BOLT 1/4 X 1/4L
10	2	SSSC98024	#10-32 X 3/8 Lg. SHCS
11	2	WWLM6	WASHER, LOCK, M6



1325148 RUFFLER ASSEMBLY

AAC Drawing Number 1325148 Rev 0

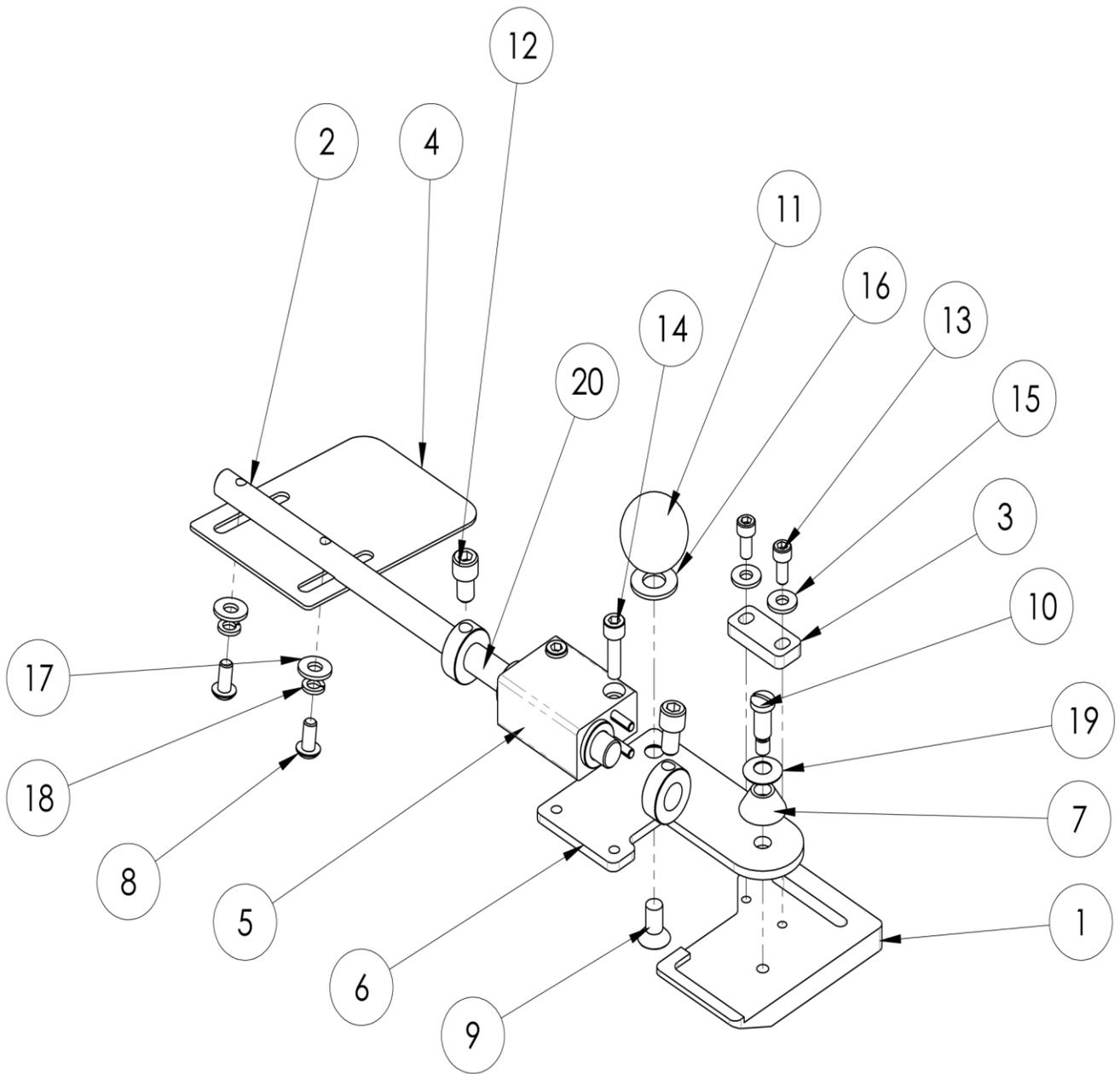
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	11200A	BUMPER 5/16-24	40	11*	MM130-10A1	TAPE, UHMW , 1" W X .01 TK
2	2	1278-7055D	PROX SWITCH W /PLUG,12"	41	1	MM8FM	JOINT,UNIVERSAL,MOD
3	1	1325149	RUFFLER MNT ASSY, TYP	42	1	NNE1/2-13	NUT, ELASTIC 1/2-13
4	1	1325156	FOOT LIFT BRKT	43	1	NNH10-32	#10-32 HEX NUT
5	1	1325170	SUPPORT BRKT-RUFFLER	44	1	NNH2-56	#2-56 HEX NUT
6	1	1335218	ADJ ANGLE-RUFFLER SUPP	45	1	NNJ3/8-16	3/8-16 HEX JAM NUT
7	1	1335324	LOCKING LEVER	46	1	NNJ5/16-24	NUT,JAM,5/16-24
8	1	1335332	RUFFLER CYL LIFT ASSY	47	1	NNK1/4-20	KEP NUT, 1/4-20
9	1	1335M-001	BRACKET, STOP, PRX SWITCH	48	1	RRLC026B1	SPRING,COMP .026X.18X.25
10	1	1335M-2006	BLOCK, NUT TRUNION	49	2	SSAS024024M	3/8 X 3/4 X 5/16-18
11	1	1335M-2008	PIVOT PLATE	50	1	SSFC01040	1/4-20 X 5/8 FLAT ALLEN
12	1	1335M-2016	WELDMENT,MOTOR BRKT	51	1	SSFC01096	1/4-20 X 1-1/2 FLAT ALLEN
13	1	1335M-2020	HLD DWN BRKT	52	1	SSFC98032	#10-32 X 1/2 FLAT ALLEN
14	1	1335M-2021	VANE, SWITCH ACTUATING	53	4	SSFC98040	#10-32 X 5/8 FLAT ALLEN
15	1	1335M-2030	MOTOR COVER, CLEAR	54	1	SSHC45096	1/2-13 X 1 1/2 L HHCS
16	1	1335M-2031	PIVOT BRKT AIR LINE	55	1	SSMB58N	PLUNGER,BALL,3/8-16X5/8L
17	1	1335M-2034	PLATE, NUT #2-56	56	2	SSPS50020	#2-56 X 5/16 PAN HD SLOT
18	1	1335M-2035	ADJUSTMENT NUT, 10-32	57	1	SSPS50032	#2-56 X 1/2 PAN HD SLOT
19	1	1335M-2036	SUPPORT BLOCK	58	1	SSPS50048	#2-56 X 3/4 PAN HD SLOT
20	1	1335M-2037	WASHER, STOP	59	1	SSPS80024	#6-32 X 3/8 LG PAN HD
21	1	1335M-2038	STOP WASHER	60	2	SSPS90024	#8-32 X 3/8 LG PAN HD
22	1	1335M-2039	NUT,SPRING RETAINER	61	6	SSSC01032	1/4-20X1/2 SOC CAP
23	1	1335M-2040	SCREW , ADJUSTMENT	62	2	SSSC90024	#8-32 X 3/8 SOC CAP
24	1	1335M-2042	COVER	63	4	SSSC90032	#8-32 X 1/2 SOC CAP
25	1	1335M-2047	POINTER, RUFFLE SIZE	64	2	SSSC98032	#10-32 X 1/2 SOC CAP
26	1	1335M-2049	SPACER, MOTOR, 3/8	65	5	SSSC98056	#10-32 X 7/8 SOC CAP
27	1	1335M-2300B	PIVOT ASSY	66	4	SSSC98064	#10-32 X 1 SOC CAP
28	1	1335M-2400	BALL SCREW AND NUT	67	5	SSTS90024	#8-32 X 3/8 TRUSS HD
29	1	AA198-7006	O RING, 1/8 ID, 1/4 OD	68	2	SSTS98040	#10-32 X 5/8 TRUSS HD
30	1	AA198RR508	FLOW CONTROL,5/32 X 1/8"	69	1	TTCL1 APPK1	PLASTIC KNOB, #10-32
31	1	AAC6D-1.5	CYL, AIR, DA 1-1/16 B,1.5 S	70	4	WW F2	WASHER, FLAT #2
32	1	AAF1/8	CLAMP,PLASTIC 1/8	71	2	WW F8	WASHER, FLAT #8
33	1	AAF3/16	CLAMP, BLACK PLASTIC	72	6	WW FS 1/4	WASHER FLAT, 1/4
34	1	AAQME-5-8	QUICK MALE ELBOW	73	4	WW FS 10	WASHER, FLAT #10
35	1	AP-22E-103	STEP MOTOR, 2 AMP	74	1	WW FS 6	WASHER, FLAT, #6
36	2	BBNTA815	BEARING,THRUST,1/2BORE	75	6	WW L1/4	1/4 LW
37	4	BBTRA815	WASHER,THRUST,STEEL 1/2	76	12	WW L10	#10 LW
38	2	CCCL10T	CLAMP COLLAR TRD, 10-32	77	2	WW L8	#8 LW
39	2	CCCL8F	CLAMP COLLAR- 1/2				



1325160 PULLER SUB-ASSEMBLY

AAC Drawing Number 1325160 Rev 2

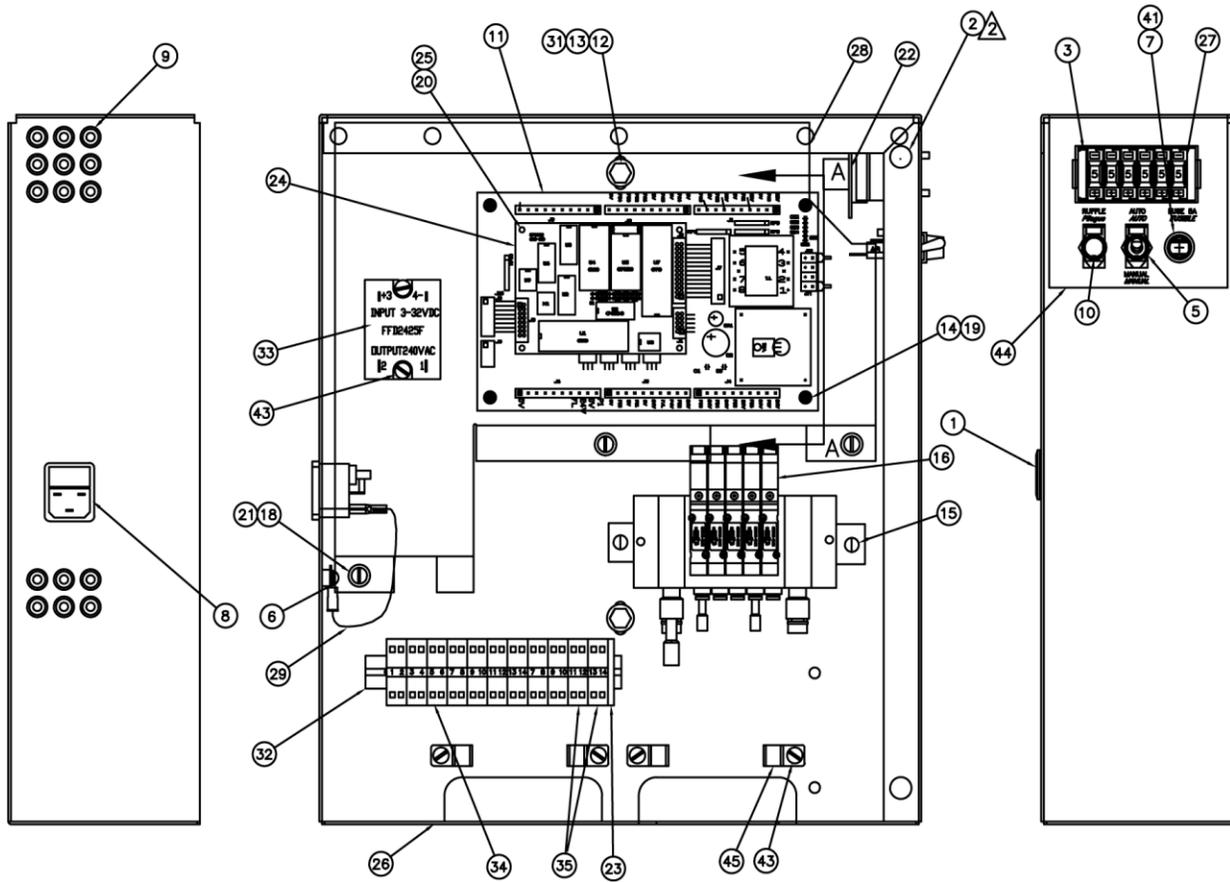
NO	QTY	PART #	DESCRIPTION
1	1	65375	UPPER ROLLER LIFT PIN
2	2	95027	RING,RETAINING,YAMATO
3	1	1325157	PULLER BRACKET
4	1	1325158	YOKE, PULLER-HD
5	1	1325161	STRIPPER PLATE, EXTENDED
6	1	1325162	STRIPPER PLATE,EXTENDED
7	1	1334056	PULLER LIFT LINK,11-64-40
8	1	1335397	PULLER ROLLER, HD, 2002MG
9	1	1335399	SHAFT, PULLER, HD
10	2	1335400	WASHER, HUB CAP, 1/4
11	1	1335414	DRIVE ARM, PULLER,HD
12	18	BBTRA815	WASHER,THRUST,STEEL 1/2
13	2	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
14	1	RRLC092H11M	SPRING,COMP, .092X.60X2.75
15	2	SSBC90016	8-32 X 1/4 BUTTON CAP
16	2	SSFC80024	6-32 X 3/8 FLAT CAP
17	1	SSSC05040	1/4-28 X 5/8, SOC CAP
18	1	SSSC20080	5/16-24 X 1-1/4 SOC CAP
19	2	SSSC90032	#8-32 X 1/2 SOC CAP SC
20	1	SSSS05016	1/4-28 X 1/4 KNURL PT
21	1	SSSS05064	SET SCREW 1/4-28X1
22	2	SSSSM6X10	M6 SET SCREW, 10MM L
23	2	WWB5/32	WASHER, FLAT, 5/32", BRAS
24	1	WWFS5/16	WASHER,FLAT,SAE,5/16
25	1	WWL1/4	WASHER,LOCK,1/4
26	1	WWL5/16	WASHER,LOCK, 5/16
27	3	WWS307-1	WASHER,SPRING,BELVEL



1325175 STRIPPER BLADE ASSEMBLY

AAC Drawing Number 1325175 Rev 0

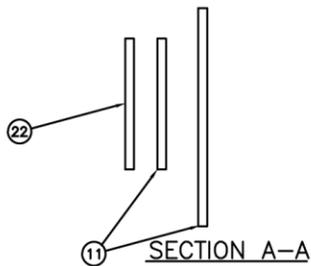
NO	QTY	PART #	DESCRIPTION
1	1	1325174	MOUNT PLATE, SWING-OUT
2	1	1335154	PIVOT ROD, STRIP BLADE
3	1	1335239	STOP BLK-STRIPPER BLADE
4	1	1335475	STRIPPER BLADE-1804P
5	1	1335624	BLOCK, MOUNTING
6	1	1335627	MOUNT ARM, STRIPPER BLADE
7	1	RRBEEHIVEH	SPRING,HEAVY BEEHIVE
8	2	SSBC98024	#10-32 X 3/8 BUT HEAD
9	1	SSFC01032	1/4-20 X 1/2 FLAT ALN CAP
10	1	SSM200246	SCREW,SHLDR,SLT.248X.437L
11	1	SSMBK13	KNOB,BLACK PLASTIC
12	2	SSSC01024	1/4-20 X 3/8 SOC CAP
13	2	SSSC90024	#8-32 X 3/8 SOC CAP
14	2	SSSC98040	10-32 X 5/8 SOC CAP
15	2	WWF8	WASHER, FLAT #8
16	1	WWFS5/16	WASHER,FLAT,SAE,5/16
17	2	WWFS10	WASHER, FLAT #10
18	2	WWL10	#10 LW
19	1	WWS307-1	WASHER,SPRING,BELVEL
20	2	CCSC6F3 8	COLLAR,SET 3/8



NOTES:

⚠ NOT SHOWN, SEE 125665C

⚠ ON INSIDE OF DOOR.



VALVE DESIGNATION
La DESIGNACION de la VALVULA

FOOT LIFT	1
PULLER LIFT	2
FOLDER UP/DNS	3
RUFFLER LOCK	4
RUFFLER UP/DNS	5

1335MF-500 CONTROL BOX ASSEMBLY

AAC Drawing Number 192909B

ON	QTY	PART #	DESCRIPTION	ON	QTY	PART #	DESCRIPTION
1	1	MM40450010	SLIDE LOCK	29	1	1981A-511	WIRE, GROUND
2	2	MMSLD-ECH	BUMPER	30	1	EE37F3312	CEE POWER CORD
3	1	FFC5S1	END CAP, PAIR	31	2	WWFS1/4	WASHER, FLAT, SAE
4	1	1987149F3	CABLE, 26 COND X 3	32	1	FF264-3BKT6	MOUNT, WAGO
5	1	FF23F385	SWITCH, TOGGLE	33	1	FFD2425F	SOLID STATE RELAY
6	1	SSPS98016	SCREW, PAN HD SLOTTED 10-32 X 1/4	34	9	FF264-341	WAGO, DUAL, GREY
7	1	FF342838A	FUSE HOLDER	35	2	FF264-347	WAGO, DUAL GRN
8	1	FF10ESB1C	CONN, POWER ENTRY	36	1	FFRK44T-4	CABLE, EYE. 12 FT.
9	15	EESB-375-3	HEYCO BUSHING	37	1	0211-703D	CABLE, PULLER SYNC
10	1	FF23F118	SWITCH, PUSH BUTTON	38	1	0211-705C	CABLE, TREADLE
11	1	1987-149JC	PC BOARD	39	1	0211-705D	CABLE REMOTE
12	2	WWL1/4	LOCK WASHER, 1/4"	40	3	0411-1906B	CABLE, PROX SWITCH
13	2	SSHC01032	SCREW, HEX CAP 1/4-20 X 1/2	41	1	FF3133005	FUSE, 5A, SLOW
14	4	SSPP80016	SCREW, PAN HD PHILLIPS 6-32 X 1/4	42	AR	1335MF-WD	WIRING DIAGRAM
15	2	SSPS98032	SCREW, PAN HD SLOTTED 10-32 X 1/2	43	6	SSPS90024	SREW, PAN SLOTTED 8-32 X 3/8
16	1	AAE1335-5	SOLENOID ASSY	44	AR	1335MF-LAB1	LABEL, CONTROL BOX
17	1	1987-513A	CABLE, THWL	45	4	AAF1/8	1/8 IN. PLASTIC CLAMPS
18	3	WWFS10	WASHER, #10 SAE	46	1	AP-28-610UA	CABLE, JOG/DIR/ENABLE
19	4	FF67F4078	SPACER, THREADED	47	1	AP-28-612RA	CABLE, SYNC, FL
20	4	FF89F2609	SPACER	48	1	FF250LA40A	MTL OXIDE VARISTOR
21	3	SSPS98024	SCREW, PAN HD SLOTTED 10-32 X 3/8	49	6	SSPS90080	SCREW, PAN SLOTTED 8-32 X 1-1/4
22	1	1987-517	PC BOARD, THWL	50	2	1335-022	CABLE, 3SPIN FM MOLEX
23	1	FF264-371	WAGO, END CAP	51	1	1987149F5	CABLE, JUMPER
24	1	FF1035-02	PC BOARD, ISOLATION	52	1	1987149F	CABLE, 26 CON RIBBON
25	4	SSPP80096	SCREW, PAN PHIL 6-32 X 1-1/2	53	9	FF12F1042	BARRIER STRIP
26	1	1335M-505	CONTROL BOX WELDMENT	54	AR	FF1024A-PGM	INS, FF1024A POT SETTINGS
27	6	FFC5.2LST1	THUMB WHEEL SWITCHES	55	1	EE2633DP43	PLASTIC HOLE PLUG
28	1	1335M-501	COVER, CONTROL BOX				

Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

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

Términos y Condiciones:

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

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

- Falla de repuestos al 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.



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