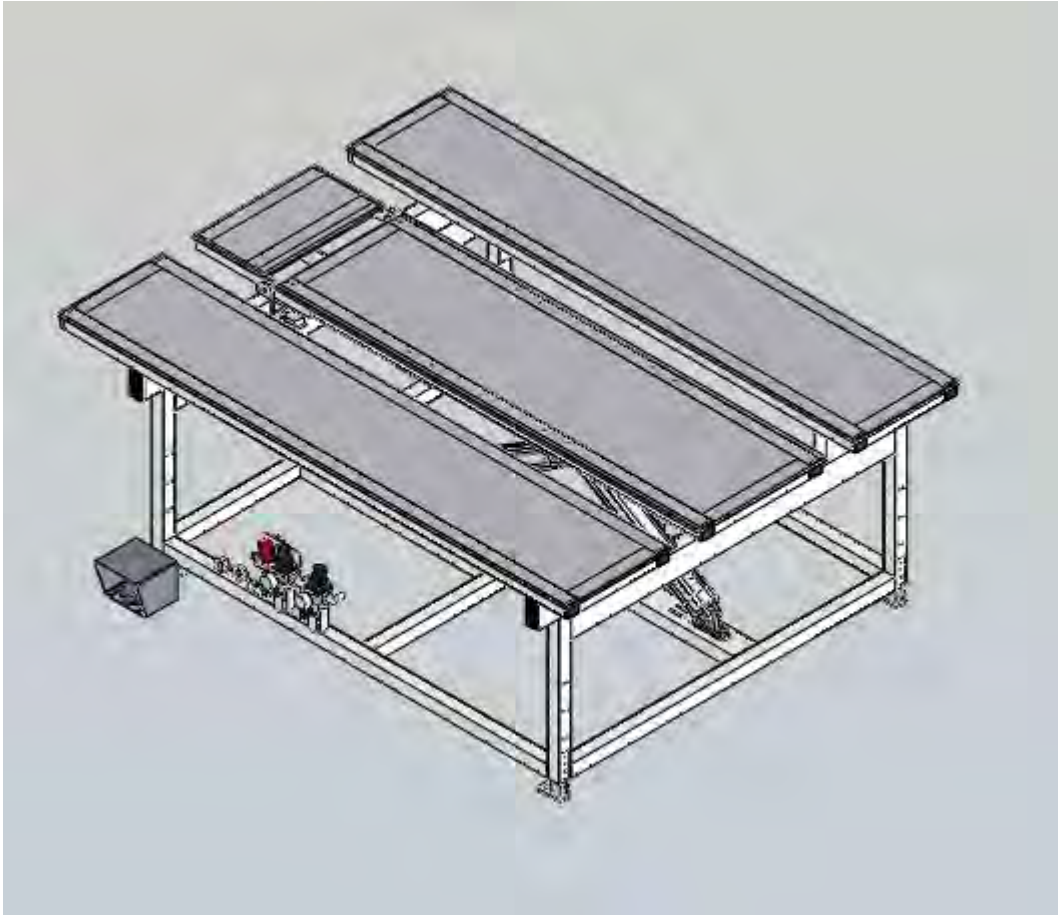


model 11346QFT Queen Flip Table

Technical Manual & Parts List

Revision 0, October 17, 2013



Atlanta Attachment Company

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6,523,488 • 6,574,815 • 6,802,271 • 6,834,603 • 6,968,794 • 6,994,043 • 7,543,364
7,574,788 • 7,647,876 • 7,735,439

Foreign Patents: 9-520,472 • 0,537,323 • 92,905,522.6 • 96,936,922.2
2,076,379 • 2,084,055

Other U.S. and Foreign Patents Pending.

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 your machine and describes the dangers inherent in machinery. Some of these dangers are obvious, while others are less evident.

Mandatory Information

All persons working on the machine should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only work on the machine 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
- Serial Bus Control system Operator instructions
- 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 pneumatic 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

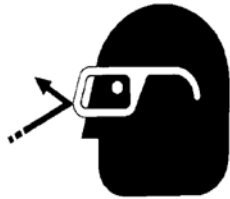
The machine must be switched off and all moving or rotating parts allowed to come to a standstill and secured against accidental restart before starting to remedy any faults or errors.

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 set-up 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 us and/or your transport insurer without delay. 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.

Machine Installation

This equipment must be installed by an Atlanta Attachment Co. technician, or by a properly trained and authorized technician/mechanic. Atlanta Attachment Co. reserves the right to void any machine warranty if the machine is installed by anyone other than a qualified person as stated above

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.

Connection, Reconnection

Energy feed and discharge lines must be routed so that they do not run through the operator's working area, are not compressed, crushed or buckled, are not subjected to tensile stresses and cannot rub against anything. This is particularly important in the case of pneumatic, hydraulic and electricity lines or hoses. Always take the machine movements into account when routing such lines.

Electrical Connection

The machine shall only be connected to the factory power supply by a qualified electrician who is familiar with the local regulations. Before switching on the master switch, check that all fasteners are secure.

Pneumatic Connection

Only use dry filtered compressed air. Ensure that the air pressure always remains within the range specified, otherwise malfunctions may occur.

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.

General Machine Data

Pneumatic Specifications

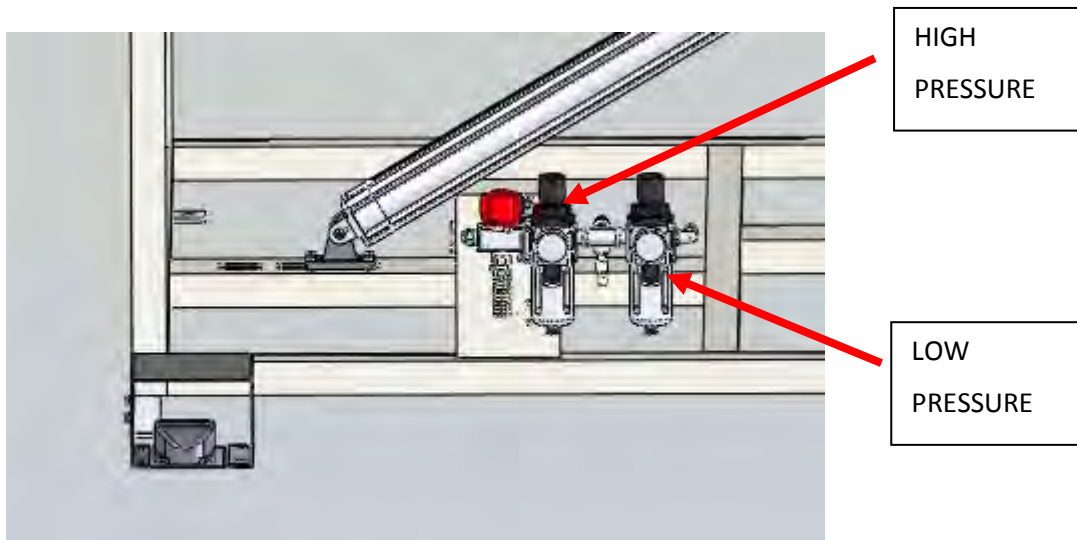
Pneumatic: 80 PSI, 2 SCFM avg. (3/8" Airline).

Installation & Setup

1. Remove all packing material (bubble wrap, foam padding, etc.).
2. Position the machine in a desired location on a sound and reasonably level floor.
3. Make sure that there is sufficient lighting over the machine.
4. Clean the machine of any dust that may have accumulated during shipping.
5. Make required pneumatic connections using only appropriate connectors.

Adjustments / Controls

Controls – Consist of one foot switch (pneumatic) and two pressure regulators and flow controls. The left pressure regulator sets the HIGH pressure for lifting and flipping the mattress. Set as needed. The right regulator controls the down pressure of the flipper and is set LOW to reduce the possibility of injury when the table returns to the normal rest position. Set as low as possible to still provide proper table motion. Adjust the flow controls so the flipper rises just fast enough for the mattress to fall over from the flipper to the next station.

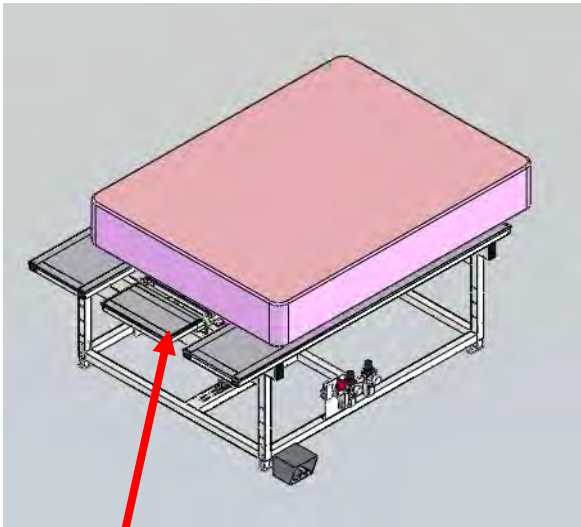


Foot Pedal – The foot pedal has a dual function. If you just tap it, the table will extend, flip the mattress, and return to normal rest position by itself. If you maintain the foot pedal pressed, the flipper will stay “up” until you release the pedal.

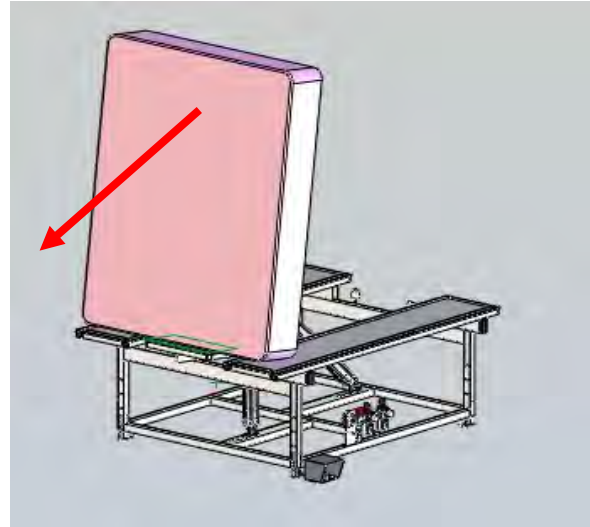
Operating procedure

1. Place the mattress on the table, centered on the flipper arm, but do not cover the end plate.
2. Tap the foot pedal to activate the flipping action.

DO NOT TRY TO ASSIST THE MATTRESS, ALLOW THE MACHINE TO DO ALL THE WORK. STAY CLEAR OF THE TABLE WHILE THE FLIPPER IS MOVING AND UNTIL THE TABLE HAS RESET TO ITS NORMAL REST POSITION.



END PLATE



Mattress should fall out of flipper at top of stroke.

Troubleshooting

Machine doesn't activate when foot pedal depressed

1. Verify the air is on.
2. Adjust the HIGH pressure regulator.
3. Check and adjust flow controls.
4. Check for kinked air lines.

Flipper will not close

1. Check the “table down” switch located under the table is activating at the top of the stroke.
2. Adjust LOW pressure regulator and flow controls.

General Machine Maintenance**Daily (8-10 hrs. of operation)**

Clean machine of any debris with an air blower.

Weekly

1. Drain water from regulator traps.
2. Apply slight amount of oil to cylinder rods and pivot points.

Monthly

Check cylinder mounts and pivot points for loose fasteners.

Drawings:

ITEM NO.	Hardware Shown/Qty.	PART NUMBER	DESCRIPTION
1	1	1337285	BRKT.PEDAL
2	1	1346121	TABLE TOP
3	1	1346122	TOP TABLE
4	1	1346129	WELDMENT, TABLE
5	1	1346130	WELDMENT, TABLE
6	4	1346136	WELDMENT, FOOT
7	2	1346137	PIVOT MOUNT, 63MM BORE
8	1	1346138	SPACER, PIVOT
9	2	1346146	WELDMENT, CLEVIS PLATE
10	2	1346147	COVER FOOT PEDAL SINGLE
11	1	1346149	ARM LEVERUP
12	1	1346152	BRACKET PNEU SWITCH
13	1	1346153	WELDMENT, FRAME
14	1	1346154	WELDMENT, FRAME
15	2	1346157	TABLE TOP
16	2	1346162	2" BUMPER
17	2	1346163	ROD, BUMPER ADJ.
18	1	1346169	ASSY. AIR CONTROL
19	AR	1346GRI-PD	DIAGRAM, PNEUMATIC
20	2	AA 1988A-304	FLOW CONTROL, 3/8" TUBE 1/4"
21	1	AA L21-400P	CYLINDER, AIR 2" BORE, 4" STK.
22	2	AA CDN-18-38000PPV	CYLINDER, AIR 1/8", 68XV 6005
24	1	AA BVNM/230	SWITCH, PNEUMATIC
25	1	AA RD-229	BRKT. PIVOT, 3/8" BORE
26	2	AA RSG M16X1.5	CLEVIS ROD M16X1.5
27	2	AA RNC63	REAR PIVOT BRKT. 63MM BORE FEBEIO
28	2	AA GMC-58	OIL MALE CONN. 5/32X 1/8
29	4	AA GME-53	MALE ELBOW, 3/800 X 3/8" NPT
30	2	AA GME-54	ELBOW, MALE 5/32X 1/4" NPT
31	2	AA GUT-33	QUICK UNION, 3/8X3/8
32	1	BAW-40	BEARING, ROD END, PNEUM.
33	1	K-3-C30A-25	FOOT AIR SWITCH PURCHASED
34	10	MM1-32-292	END CAP, 292 10-16GA
35	4	MM1-32-294	END CAP, RECT, BLACK
36	1	NNH5/16-18	NUT, ELASTIC, LOCK, 5/16-18
37	4	NNH5/8-16	NUT, HEX, 5/8-16
38	16	NNH5/16-18	5/16-18 HEX NUT
39	1	SSAS1024064	SHOULDER BOLT, 3/8 X 1.00
40	3	SSAC032064	SHOULDER BOLT, 1/2 X 1.00
41	4	SSHC063032	1/4-28 X 1/2 HEX CAP
42	8	SSHC063045	1/4-28 X 3/4 HEX CAP
43	24	SSHC10064	5/16-18 X 1 PHCS
44	4	SSHC-96032	10-32X 1/2 HEX HD
45	2	SSHFH10032	SCREW, SHI, METAL, HEX 10
46	4	UUFF707-05	BEARING BRK-WL, 5020D
47	8	WWF1/4	WASHER, FLAT, 1/4", COM
48	4	WWF10	WASHER, FLAT, #10, COM
49	16	WWF5/16	WASHER, FLAT, 5/16
50	8	WWF5/16S	WASHER, FLAT, 5/16 NARROW
51	4	WWL1/4	WASHER, LOCK, 1/4
52	12	WWL1/4	WASHER, LOCK, 1/4
53	24	WWL5/16	WASHER, LOCK, 5/16

5/13/06 11346 QFT

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20: POLISHED					
30: BLACK OXIDE					
40: ZINC PLATE					
50: ANNEAL					
60: COAT OXIDIZING					
70: BURN					
80: OTHER					

NAME	DATE	REV
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SCALE		

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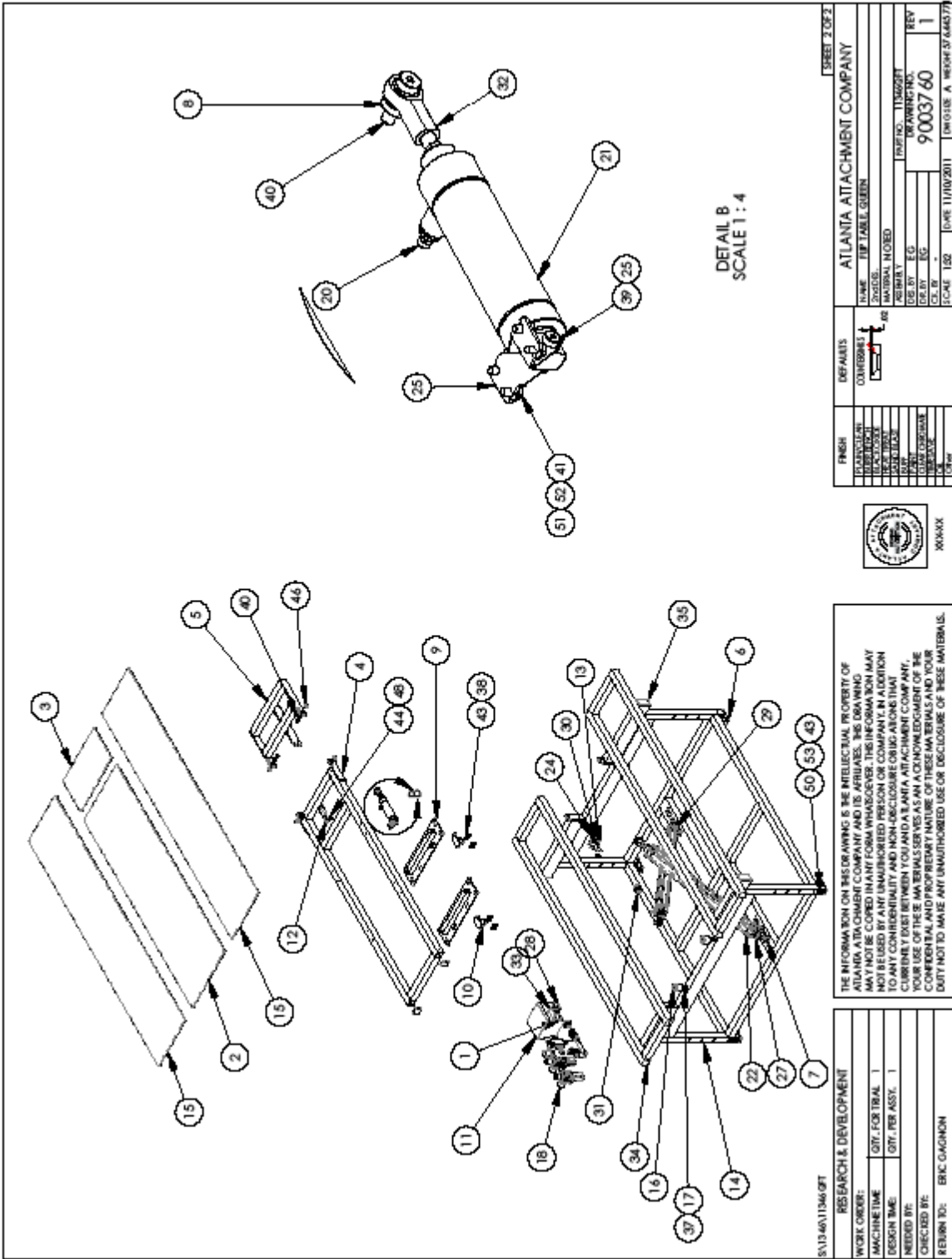
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DATE 11/10/2011

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11/10/2011

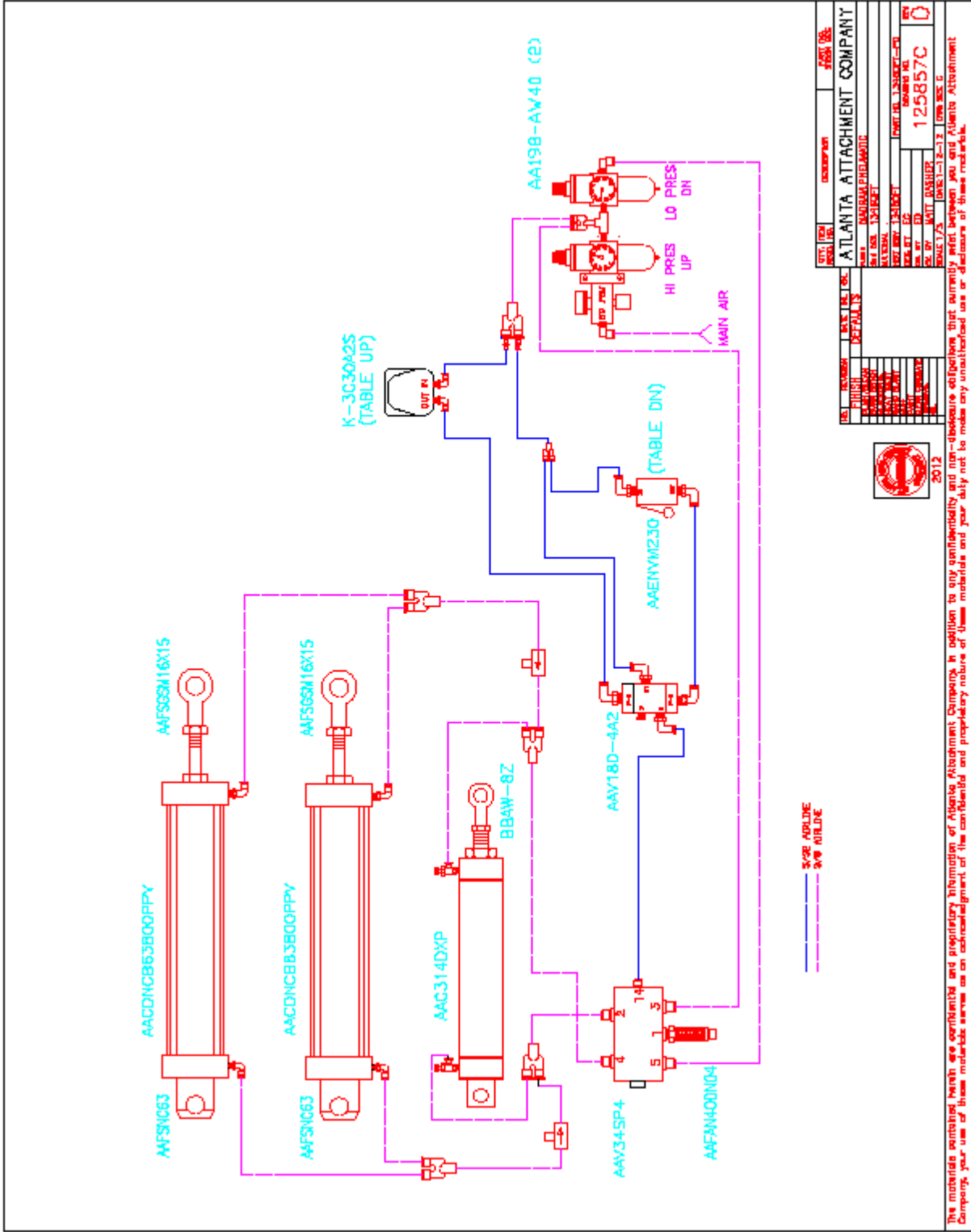


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DESIGNED BY:	
CHECKED BY:	
REVISION NO.:	ERIC GAGNON



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REV	DATE	DESCRIPTION	
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002	08/04/2010	REVISED	
003	08/04/2010	REVISED	
004	08/04/2010	REVISED	
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