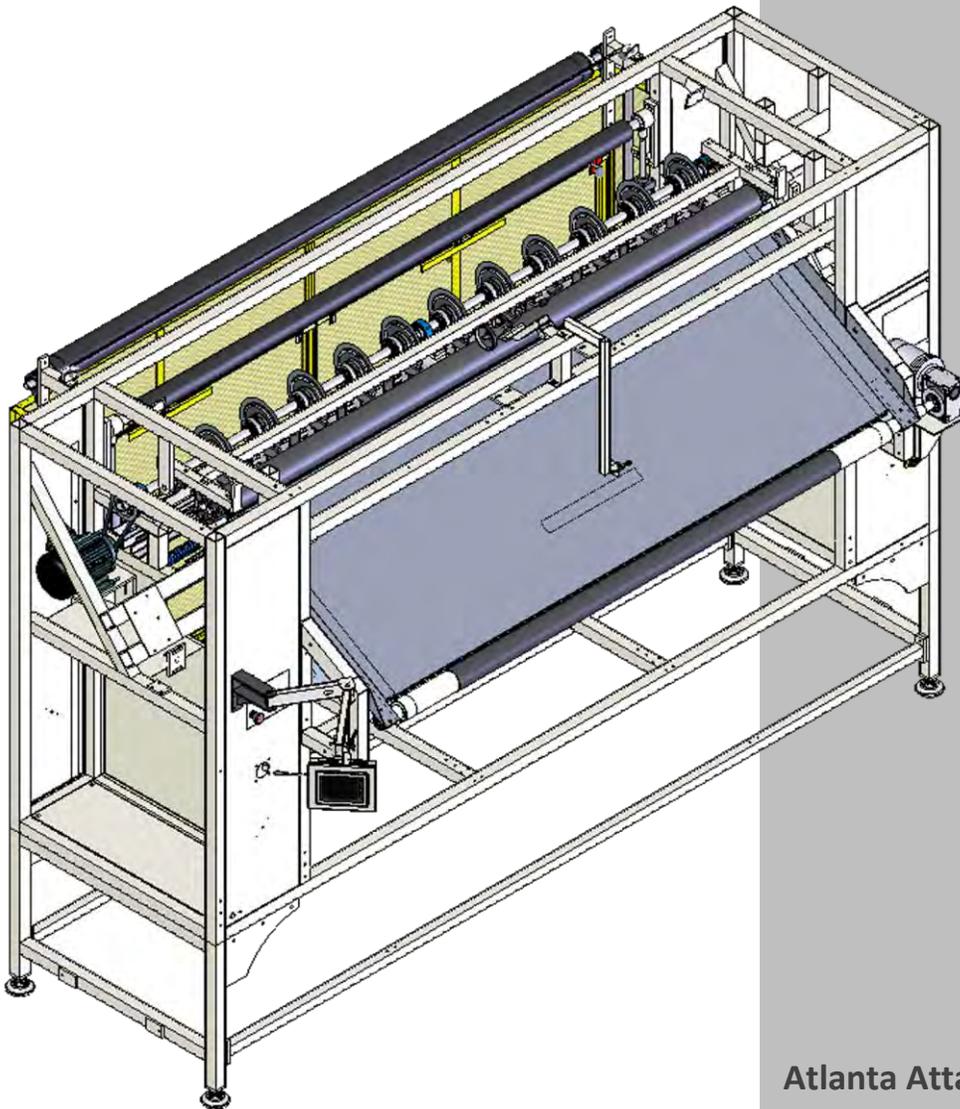




Model **1393BSA**

Revision 1.2 Updated Feb 5, 2015

# Technical Manual & Parts Lists



**Atlanta Attachment Company**

362 Industrial Park Drive

Lawrenceville, GA 30046

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



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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 1393BSA Border Slitter should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

### Scope of the Instruction Material

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

And may also include;

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

### Intended Use

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

### Exclusion of Misuse



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

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

## Liability

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

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

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

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

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

## Choice and Qualification of Personnel

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

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

## Training

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

## Responsibilities

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

## A Word to the Operator

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

### **ALWAYS BE CONSCIOUS OF THESE DANGERS!**

## Safety Equipment on the Machines



All machines are delivered with safety equipment, which shall not be removed or bypassed during operation.

The correct functioning of safety equipment on machines and systems should be checked every day and before every new shift starts, after maintenance and repair work, when starting up for the first time and when restarting (e.g. after prolonged shutdowns).

If safety equipment has to be dismantled for setting-up, maintenance or repair work, such safety equipment shall be replaced and checked immediately upon completing the maintenance or repair work. All protective mechanisms shall be fitted and fully operational whenever the machine is at a standstill or if it has been shut down for a longer period of time.

## Damage

If any changes capable of impairing safety are observed in the machine or its mode of operation, such as malfunctions, faults or changes in the machine or tools, appropriate steps must be taken immediately, the machine switched off and a proper lockout tagout procedure followed. The machine should be examined for obvious damage and defects at least once per shift. Damage found shall be immediately remedied by a duly authorized person before resuming operation of machine.

The machine should only be operated when in perfect working order and when all protective mechanisms and safety equipment, such as detachable protective mechanisms, emergency STOP systems, etc. are in place and operational.

## Faults or Errors

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

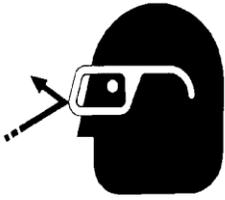
## Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.

### Clothing, Jewelry, Protective Equipment

Long loose hair, loose-fitting clothes, gloves and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

## Protective Eyewear



Protective eyewear that has been tested by the local authorities should be worn whenever there is a possibility of loose or flying objects or particles such as when cleaning the machine with compressed air.

## Tools

Always count the number of tools in your possession before starting work on the machine. This will allow you to check that no tools have been left behind inside the machine. Never leave a tool in the machine while working.

## Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

## No Smoking, Fire, Explosion Hazard

Smoking and open flame (e.g. welding work) should be prohibited in the production area due to the risk of fire and explosions.

## Workplace

A clear working area without any obstructions whatsoever is essential for safe operation of the machine. The floor should be level and clean, without any waste.

The workplace should be well lit, either by the general lighting or by local lights.

## Emergency STOP

The emergency STOP buttons bring all machine movements to a standstill. Make sure you know exactly where they are located and how they work. Try them out. Always ensure easy access to the nearest emergency STOP button while working on the machine.

## First Aid

1. Keep calm even when injured.
2. Clear the operator from the danger zone. The decision of what to do and whether to seek additional assistance rests entirely with you, particularly if someone has been trapped.
3. Give First Aid. Special courses are offered by such organizations as the employers' liability insurance association. Your colleagues should be able to rely on you and vice versa.
4. Call an ambulance. Do you know the telephone numbers for the ambulance service, police and fire service?

## Important Notices

### Reporting and Fighting Fires

Read the instructions posted in the factory with regard to reporting fires and the emergency exits. Make sure you know exactly where the fire extinguishers and sprinkler systems are located and how they are operated. Pass on the corresponding information to the firemen when they arrive. Ensure there are enough signs to avoid fire hazards.

The following fire extinguishers may be used:

- Dry powder extinguishers, ABC fire-extinguishing powder.
- Carbon dioxide fire extinguishers to DIN 14461 for electronic components. Great care must be exercised when using carbon dioxide fire extinguishers in confined, badly ventilated rooms (see DIN 14406 and 14270).

Isolate the machine from the power supply if a fire breaks out. Do not use water on burning electrical parts until it is absolutely certain that they have been completely disconnected from the power supply. Burning oils, lubricants, plastics and coatings on the machine can give off gases and vapors that may be harmful to your health.

A qualified person should be consulted to repair the damage after a fire.

### Electrical Power Supply



Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.

In practice, this may mean that the technician, electrician and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.

Energy sources (electrical/pneumatic/hydraulic, etc.) for the equipment shall be turned off or disconnected and the switches locked or labeled with a warning tag. It is the responsibility of the employer to establish control procedures. Follow lockout/tagout procedures before, setup and/or any service or maintenance work is performed, including lubrication, cleaning or clearance of jams.

**Caution: The machine is still not completely de-energized even when the master switch is off.**

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.
- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

- Kinetic energy - Note that some motors or spindles, for example, may continue to run or coast run on after being switched off.
- Potential energy - Individual assemblies may need to be secured if necessary for repair work.

## Delivery of the Machine/Packaging

Note any markings on the packaging, such as weights, lifting points and special information. Avoid temperature fluctuations. Condensation may damage the machine.

## Transport Damage

The packaging and machine must immediately be examined for signs of damage in transit. Such damage must be reported to the shipper/transporter within the applicable time limits. Contact Atlanta Attachment Company and/or your transport insurer immediately, if signs of damage are visible. Never operate a damaged machine.

## Interim Storage

If the machine has to be stored temporarily, it must be oiled or greased and stored in a dry place where it is protected from the weather in order to avoid damage. A corrosion-inhibiting coating should be applied if the machine has to be stored for a longer period of time and additional precautions taken to avoid corrosion.

## Transporting the Machine

Disconnect the machine from all external connections and secure any loose assemblies or parts. Never step under a suspended load. When transporting the machine or assemblies in a crate, ensure that the ropes or arms of a forklift truck are positioned as close to the edge of the crate as possible. The center of gravity is not necessarily in the middle of the crate. Note the accident prevention regulations, safety instructions and local regulations governing transport of the machine and its assemblies.

Only use suitable transport vehicles, hoisting gear and load suspension devices that are in perfect working order and of adequate carrying capacity. Transport should only be entrusted to duly qualified personnel.

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.

All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

## Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.

Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.

Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.

Protect against unauthorized access.

Ensure that the machine and accessories are set up in a stable position.

Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

## Local Regulations

Particular attention must be paid to local and statutory regulations, etc. when installing machines and the plant (e.g. with regard to the specified escape routes). Note the safety zones in relation to adjacent machines.

## Maintenance

### General Safety Instructions

The machine shall be switched off, come to a standstill and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.

Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.

Retighten all screw connections that have to be loosened for the maintenance and repair work. Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

### Maintenance, Care, Adjustment

The activities and intervals specified in the Instruction Manual for carrying out adjustments, maintenance and inspections must be observed and parts replaced as specified.

All hydraulic and pneumatic lines should be examined for leaks, loose connections, rubbing and damage whenever the machine is serviced. Any defects found must be remedied immediately.

### Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard. Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control.

When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

# Repair

## Replacement Parts

We cannot accept any liability whatsoever for damage due to the use of parts made by other manufacturers or due to unqualified repair or modification of the machine.

## Repair, Electrical

The power supply must be switched off (master switch off) and secured so that it cannot be switched on again inadvertently before starting any work on live parts.

Those parts of the machine and plant on which inspection, maintenance or repair work is to be carried out must be isolated from the power supply, if specified. The isolated parts must first be checked to determine that they are truly de-energized before being grounded and short-circuited. Adjacent live parts must also be isolated.

The protective measures implemented (e.g. grounding resistance) must be tested before restarting the machine after all assembly or repair work on electric parts.

Signal generators (limit switches) and other electrical parts on the safety mechanisms must not be removed or bypassed. Only use original fuses or circuit overloads with the specified current rating. The machine must be switched off immediately if a fault develops in the electrical power supply.

The electrical equipment of our machines must be checked at regular intervals and any defects found must be remedied immediately.

If it is necessary to carry out work on live parts, a second person should be on hand to operate the emergency OFF switch or master switch with voltage release in the event of an emergency. The working area should be cordoned off and marked by a warning sign. Only use electrically insulated tools.

## Ventilation/Hazardous Gases

It is the end users responsibility to ensure adequate ventilation is provided to exhaust any and all noxious or hazardous gases that may be present in the working environment.

## Hydraulic and Pneumatic Systems

Work on hydraulic or pneumatic equipment shall only be carried out by persons with training, knowledge and experience of hydraulic systems. Pressure lines shall be depressurized before starting any repair work.

## General Liability

Liability for machine damage and personal injury is extinguished completely if any unauthorized conversions or modifications are undertaken. The machine must not be modified, enlarged or converted in any way capable of affecting safety without the manufacturer's prior approval.

## Starting Machine Movements

Read the Instruction Manual carefully to establish which keys and functions start machine movements.

## A Word to the End User

The end user has sole responsibility to enforce the use of safety procedures and guards on the machine. Any other safety devices or procedures due to local regulations should be should be retrofitted in accordance to these regulations and/or the EC Directive on the safety of machines.

Operator's position must always be readily accessible. Escape routes must always be kept clear and safety areas should be identified.

## Safety Precautions

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

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

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

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

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

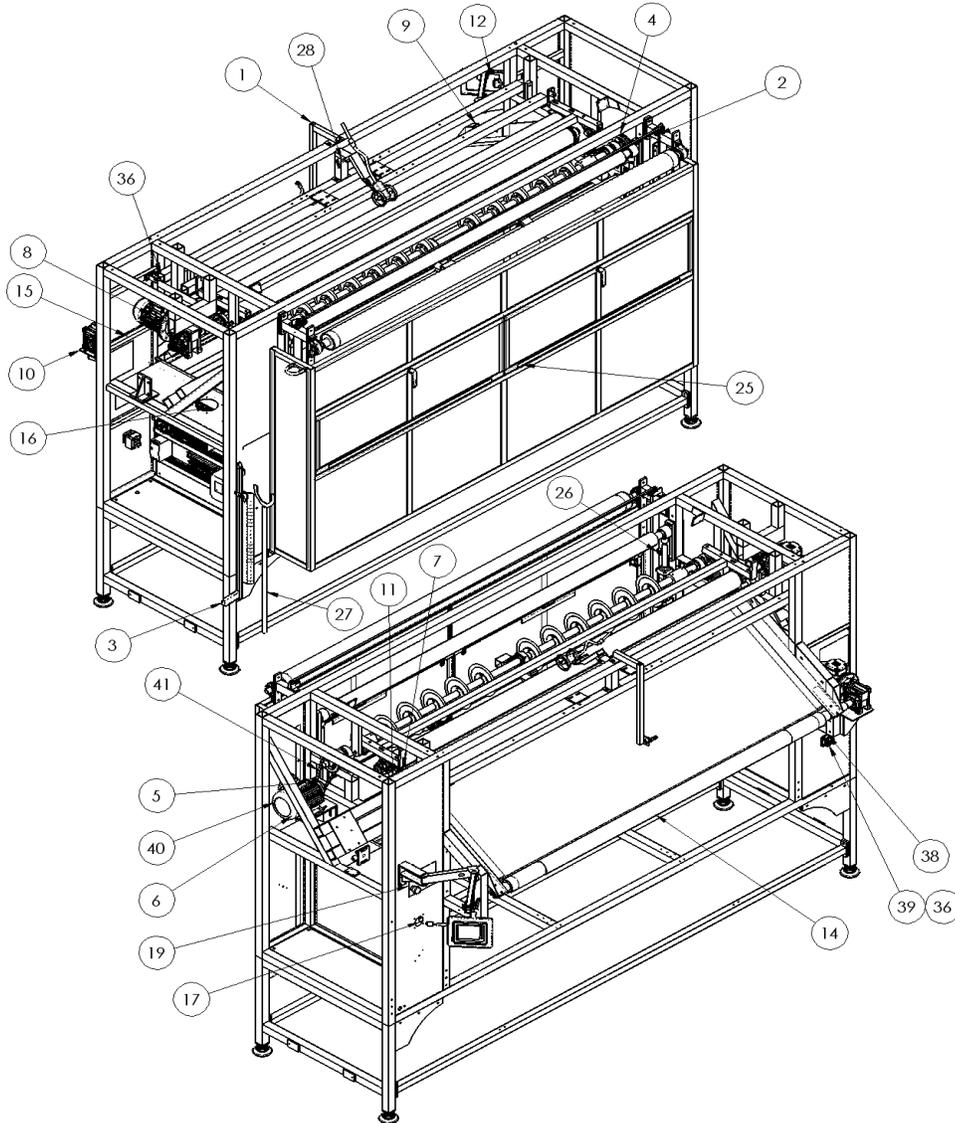
- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS operate equipment in daylight or with adequate working lights.
- Follow daily and weekly checklists, making sure hoses are tightly secured and bolts are tightened.
- ALWAYS watch and avoid holes or deep depressions.
- ALWAYS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

# 1.- INSTALLATION MANUAL



It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating.

## 1.1.- Parts and Components

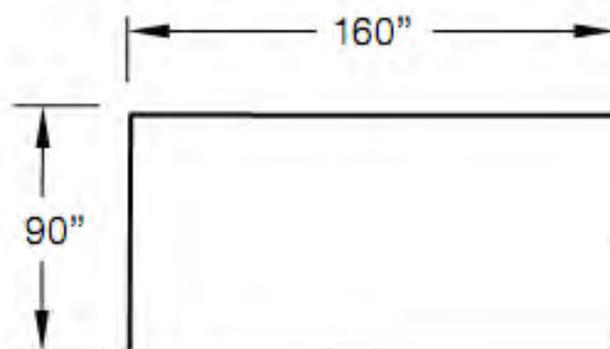


- |                            |                          |                        |
|----------------------------|--------------------------|------------------------|
| 1.- Material Exit Sensor   | 15.- Plate               | 25.- Rear Guard        |
| 2.- Dancer Bar Asm         | 16.- Electrical Panel    | 26.- Dancer Bar Sensor |
| 3.- Nudge Tool             | 17.- Solenoid Asm        | 27.- Grabber Tool      |
| 4,5.- Slitter Pulley       | 18.- Knife Sharpen Reg.  | 28.- Encoder Asm       |
| 6.- Motor Mount            | 19.- Button Assembly     | 36.- Machine Frame     |
| 6.- Discharge Plate        | 20.- Slitter Shaft Asm   | 37.- Power Disconnect  |
| 8,9,11.- Discharge Support | 21.- End Mount Asm       | 38.- Ground Terminal   |
| 10.- Gearmotor             | 22.- 30MM Shaft          | 39.- Disconnect Handle |
| 12.- Swivel Arm Asm        | 23.- 30MM Tube Support   | 40.- Slitter Motor     |
| 13,14.- Center Support     | 24.- Slitter Sharpen Asm | 41.- Slitter V-Belt    |

**1.2.- Technical Data**

<b>SPECIFICATIONS</b>	
Max cutting thickness (inch)	1 1/2" (Compressed)
Min cutting thickness (inch)	1/4"
Max cutting width (inch)	102
Min cutting width (inch)	N/A
Max length (inch)	84
Min length (inch)	N/A
Voltage (v/ph/hz)	220V 3PH 50/60HZ
Current (amps)	20
Air pressure (psi)	80
Air consumption (cfm)	3
Shipping Weight (lbs)	5200
Shipping Dimensions (w/l/h, Inch)	144 x 65 x 78

<b>PRODUCTION</b>	
Output speed (Ft/Min.)	45



Foot Print

### 1.3.- Installation & Set Up



**It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating**

- 1.- Unpack the machine frame and install it with help of crane and forklift.
- 2.- Remove any shipping straps from machine.
- 3.- Inspect the machine for any damage that may have occurred during shipping. If damage is found, report this immediately to your supervisor. Document the damage and provide details and photographs.
- 4.- Install the rollers onto the frame and be sure they can rotate freely.
- 5.- Install the back safety guard onto the frame.
- 6.- Adjoin the inner and outer board and install onto the frame, adjust them to in one plane.
- 7.- Adjust all rollers to be sure the midlines of them are parallel.
- 8.- Connect power source and compressed air.
-  9.- Provide a 220VAC, single phase, 20 Amp
-  10.- Provide 3/8" air supply line (80 PSI).

## 2.- OPERATION MANUAL



It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating

### 2.1 Individual components

#### a.- Main Power

It is located below the touch screen panel. Is the main power switch ¼ turn to the right will supply power to the machine. This switch has provision to lockout the power when performing maintenance.

#### b.- Emergency Stop

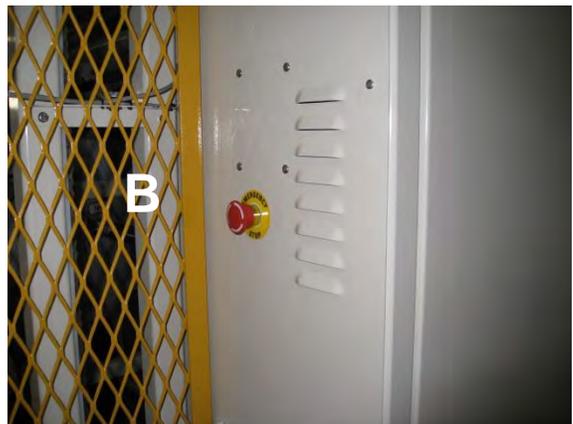
There are red push buttons located in 4 places around the machine. After pushing it the machine will be disconnected from the energy source. You will need to turn the knob 1/8 revolution before reactivating the power

#### c.- Touch Screen / Control

1.- Emergency Stop - This button serves the same function as the other 3 red “E-Stop” push buttons located on each of the four corners of the machine.

2.- Power Off – Push off button for turning off power to the control panel and the machine.

3.- Power On – Activates main power to the control panel and machine (not control power)



## 2.2.- Touch Screen

### Main Menu

It is displayed at the start up of the machine. Press any of the buttons on the screen and you will be transferred to the following sub-menus

#### [BORDER MODE]

Press this button to access the auto border cutting mode & menu page

#### [MANUAL MODE]

Press this button to access the manual border cutting & menu page.

#### [SHARPEN BLADES]

Press this button to access the slitter blade sharpening mode & menu page

#### [MAINT MENU]

Press this button to access the maintenance mode & menu page

#### [CONTROL POWER START]

Press this button to energize the control power to the machine

#### [POWER OFF / POWER ON]

This is an indicator to show when the control power is energized (Not a Button)

#### [PRESS POWER START]

This indicator message will be displayed only when control power is de-energized

#### [CONTROL POWER OFF]

Press this button to de-energize all the control power to the machine.

**(PLEASE NOTE: THIS IS NOT THE SAME AS THE MAIN POWER)**

#### [OPEN IN FEED ROLLER]

Press this button to open the main top infeed roller. Mainly used when loading material into the machine. **(MAKE SURE THE DANCER BAR IS AT THE BOTTOM POSITION SO MATERIAL IS NOT PULLED OUT OF THE MACHINE WHEN THIS ROLLER IS OPENED.)**

#### [CLOSE INFEED ROLLER]

Press this button to close the main top infeed roller.

**(PLEASE NOTE: USE CAUTION WHEN CLOSING THIS ROLLER)**



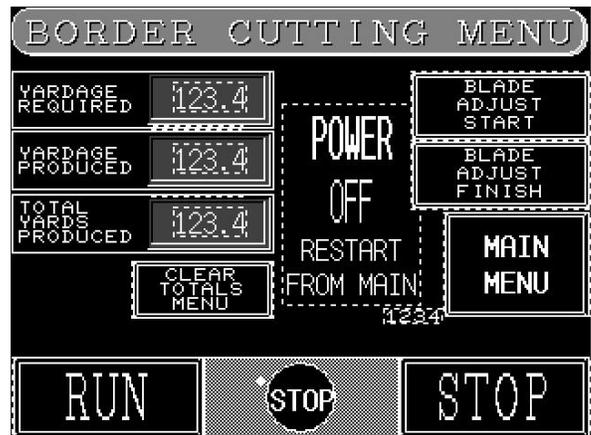
## a.- Border Mode

Starting at Main Menu

- Select [BORDER MODE] from the Main Menu screen
- After pressing [BORDER MODE] from the main menu, you will arrive at the border cutting menu.

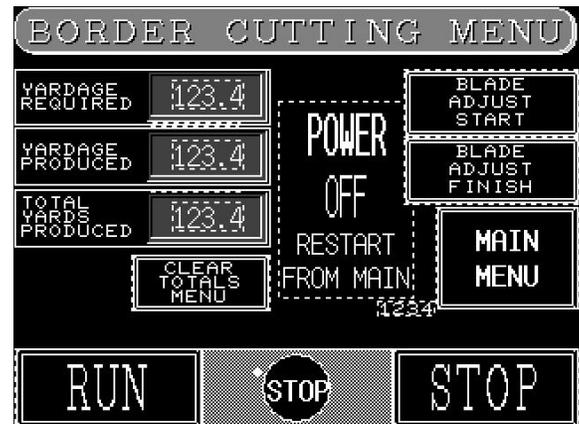
The Border Cutting Menu consists of three input boxes on the left hand side of the screen. These boxes are used to enter and display production data.

- [YARDAGE REQUIRED]  
The quantity of material needed to cut is displayed (displayed in yards) Data can be entered by touching this box. (Max Setting: 999.9 yards) Pressing the number box you will get a keyboard were you can change the numbers of yards to be produced. It is important to note that the machine will automatically stop at the desired length of border. To deactivate the measuring function set the quantity to zero.
- [YARDAGE PRODUCED]  
The quantity of material already produced during the current order.  
Data can be entered or corrected by touching this data field box.
- [TOTAL YARDS PRODUCED]  
The TOTAL quantity of material produced. (Accumulated Quantity)
- [CLEAR TOTALS MENU]  
Displays a sub-menu that allows the resetting of production data.



PLEASE NOTE: After selecting a number field a number pad will come up. Enter the desired number and select [ENT] button when finished. The keyboard will then disappear and return to the border cutting menu. The entered data will then be displayed in the box.

- [BLADE ADJUST START]  
When you press this button the slitters will disable and the material will feed forward until the dancer bar reaches the upper sensor. At this position the operator will have access via the front access doors to reposition the slitter blades as desired. Note: When the access doors are opened the power will automatically shut off to the motors to prevent any possibility of the power being inadvertently turned on to the slitters while the operator is making adjustments.



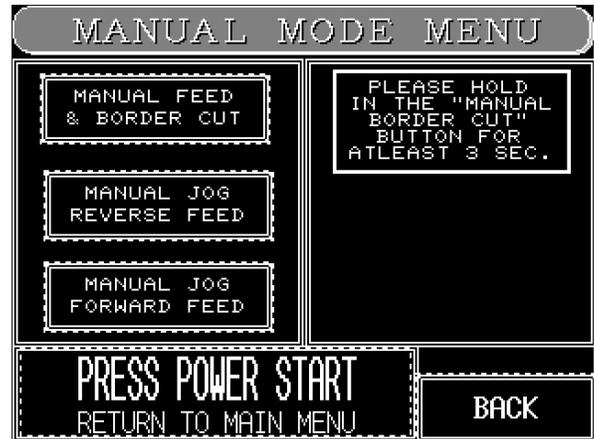
- [BLADE ADJUST FINISH]  
When the operator is finished adjusting the blades he/she will have to reset the power on button in the Main Menu to re-energize the panel. Once the power is on, press Border Mode. In the Border Mode select Blade Adjust Finish and the material will reverse feed until the dancer bar returns to the middle position. Note: if it is necessary to feed more material through to get back to where the slitters were reset this will have to be done in the Manual mode.
- [MAIN MENU]  
Return to Main Menu screen
- [PRESS POWER START]  
This indicator message will be displayed only when control power is de-energized
- [RUN]  
Press this button to start border cutting in the automatic mode. The machine will start cutting border and winding the material and will not stop until the YARDAGE REQUIRED quantity is reached or the [STOP] button is pressed.
- [STOP]  
Press this button to stop the automatic border cutting mode. The machine will stop cutting and the winder will stop.

## b.- Manual Mode

Starting at Main Menu

- Select [MANUAL MODE] from the Main Menu screen  
After pressing [MANUAL MODE] from the main menu, you will arrive at the manual mode menu

The Manual Mode Menu consists of four buttons that allow the user to cut border manually or to jog the feed roller and winder as needed.



- [MANUAL FEED & BOARDER CUT]  
Press this button to manually feed and cut border at normal feed rate. For safety issues, please hold button for more than 3 seconds to start manual border slitting. The feed rate is the same as if operation in auto border cut mode.



**(PLEASE NOTE: USE EXTREME CAUTION, SLITTER BLADES WILL OPERATE IN THIS MODE.)**

- [MANUAL JOG REVERSE FEED]  
Press this button to manually jog the feed roller in the reverse direction. The feed rate will be slower when using the JOG buttons. The slitter blades will not turn on when using this button.
- [MANUAL JOG FORWARD FEED]  
Press this button to manually jog the feed roller in the forward direction. The feed rate will be slower when using the JOG buttons. The slitter blades will not turn on when using this button.
- [PRESS POWER START]  
This indicator message will be displayed only when control power is de-energized
- [BACK]  
Press this button to return to the main menu screen.

## c.- Sharpen Blades

Starting at Main Menu

- Select [SHARPEN BLADES] from the Main Menu screen  
After pressing [SHARPEN BLADES] from the main menu, you will arrive at the sharpen blades menu.

The Sharpen Blades Menu consists of three sub-menus that allow the user to access the rear safety doors and sharpen the slitler blades.



- [SHARPEN SLITTER BLADES]  
Press this button to access the slitler blade sharpener warning and acknowledgement page.
- [PRESS POWER START]  
This indicator message will be displayed only when control power is de-energized
- [BACK]  
Press this button to return to the main menu screen



- [SHARPENER ACKNOWLEDGEMENT]  
This page will be display before entering the slitler blade sharpening page. Carefully read the warning and acknowledgement instructions. Proceed by pressing the [RETURN] or [CONTINUE] buttons. [RETURN] will bring you back to the main sharpen blades menu. [CONTINUE] will take you to the sub-menu that will disable the rear safety guards and allow blade sharpening.



- [SHARPEN SLITTER BLADES]  
Press this button to start the slitler blade sharpening cycle. The rear guards can be opened when this menu is displayed.

**(PLEASE NOTE: USE EXTREME CAUTION, SLITTER BLADES WILL OPERATE IN THIS MODE.)**



- [SHARPENER CYCLE STOP]  
Press this to stop the sharpening cycle.
- [RETURN TO MENU]  
Press this button to return to the sharpen blades menu screen.



**DO NOT FORGET TO CLOSE THE REAR GUARDS BEFORE PRESSING THIS BUTTON; OTHERWISE, THE CONTROL POWER WILL BE TURNED OFF.**



## d.- Maintenance Menu

### Starting at Main Menu

- Select [MAINT. MENU] from the Main Menu screen.  
After pressing [MAINT. MENU] from the main menu, you will arrive at the maintenance menu screen.

The Maintenance Menu consists of 8 buttons that allow the user to manually operate air cylinders and motors. The remaining buttons allow the user to access the PLC I/O monitoring page or return to the main menu screen.



- [JOG INFEED ROLL FWD]  
Press this button to manually jog infeed roll forward
- [JOG INFEED ROLL REV]  
Press this button to manually jog infeed roll reverse



- [OPEN INFEED ROLL]  
Press this button to open the infeed roller
- [CLOSE INFEED ROLL]  
Press this button to close the infeed roller

- [LIFT BORDER ROLLER]  
Press this button to lift the border roll cylinders
- [LOWER BORDER ROLLER]  
Press this button to lower the border roll cylinders

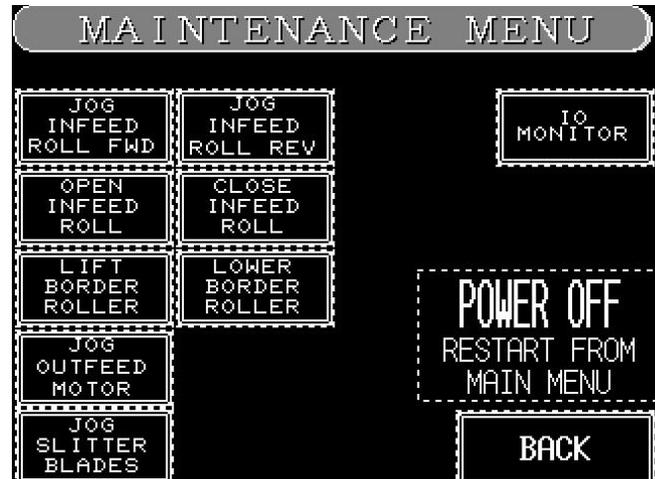


- [JOG OUTFEED MOTOR]  
Press this button to manually jog the material outfeed motor.



- [JOG SLITTER BLADES]  
Press this button to manually jog the slitter blades motor.  
**(PLEASE NOTE: USE EXTREME CAUTION, SLITTER BLADES WILL OPERATE IN THIS MODE.)**

- [PRESS POWER START]  
This indicator message will be displayed only when control power is de-energized



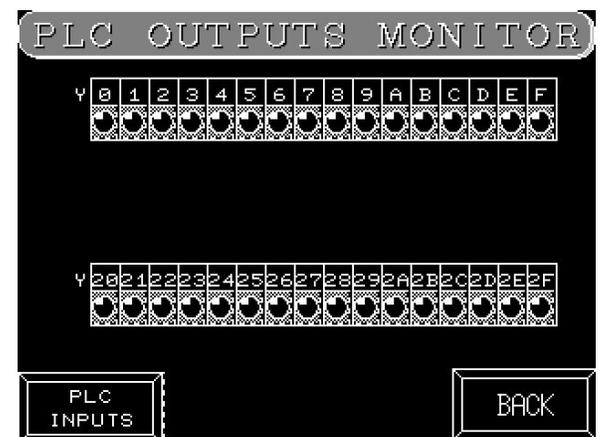
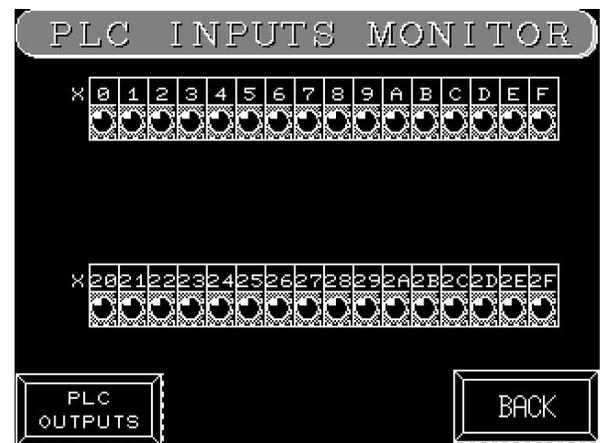


- [BACK]  
Press this button to return to the main menu screen. When leaving the maintenance menu, a warning screen will appear. Two options are given to exit or return to the maintenance menu. [BACK TO MAINT. MODE] will not disturb the state of any cylinder or motor changed during maintenance mode. [BACK TO MAIN MENU] will return all cylinders and motors to their HOME state or power off condition and return to the main menu screen.

- [I/O MONITOR]  
Press this button access the PLC I/O monitor screens. The first screen displayed after pressing the [I/O MONITOR] button will be the PLC inputs monitor. PLC inputs X0~X2F will be displayed. This is useful when troubleshooting machine issues.

[PLC OUTPUTS] button will access the outputs page. PLC outputs Y0~Y2F will be displayed. Reference the electrical drawings for further reference of the PLC I/O signal numbers.

[BACK] button will return to the maintenance menu.



## 2.3.- Operating



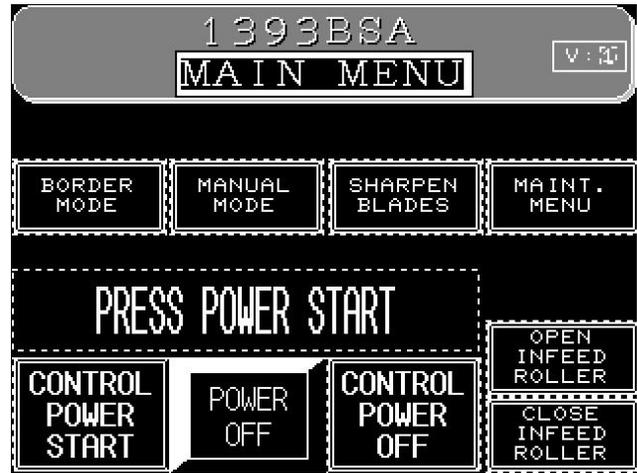
It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating

### a.- Turning ON

- a.- Make Sure that the Main Power switch is on the “ON” position
- b.- Press the “ON” button on the Control Panel Machine will show Atlanta Attachment logo and will power ON

### b.- Load the material

- a.- With the machine ON navigate to the main menu page
- b.- Press [OPEN IN FEED ROLLER],
- c.- Open the safety doors You will be able to load material through the machine. Follow the picture for a correct loading of the material.
- d.- Close the safety doors and press [CLOSE IN FEED ROLLER] from the loading menu.

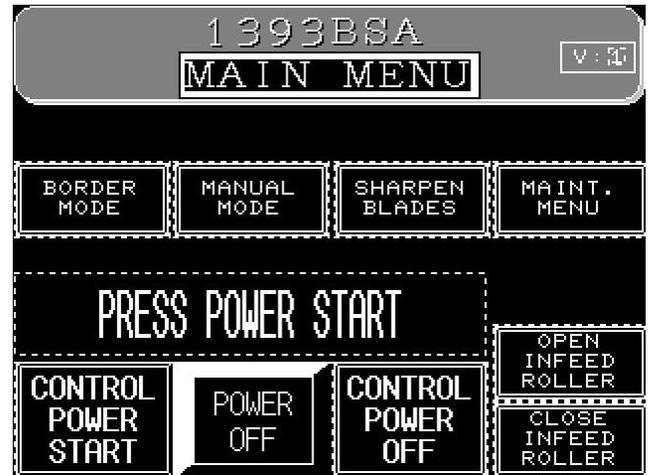


### c.- Border Cutting



- a.- Carefully: manually adjust the cutting blades to the right border width.
- b.- Make sure machine is loaded with material and all doors are close
- c.- Press [CONTROL POWER START] from the Main Menu Screen
- d.- Press [BORDER MODE] on the same screen.
- e.- Load the production required (Border quantity, length, etc.)
- f.- Press [RUN].

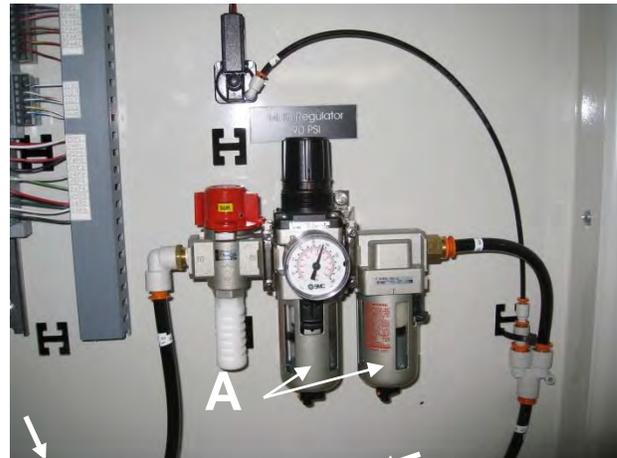
**“ATTENTION “Never leave the machine unattended”**



## 2.4.- Maintenance

### a.- Daily

- 1.- Drain water from water trap in air pressure regulator.
- 2.- Clean any lint or debris from around bearings, blades and motors.
- 3.- Clean work area and check for any signs of abnormality or wear.



### b.- Weekly

- 1.- Clean dancer bar guide chains and sprocket.
- 2.- Clean lint and debris from inside machine around XCut linear rail bearings and belt.
- 3.- Check for any areas of wear or potential problems.



### c.- Monthly

- 1.- Thoroughly clean machine inside and out.
- 2.- Check condition of all drive belts.
- 3.- Check security of all blades.
- 4.- Check setting of blade sharpening stones.
- 5.- Clean threads from around all shafts and rollers.
- 6.- Clean cabinet cooling fan and filter.
- 7.- Check condition of dancer bar guide chain and sprocket alignment on both sides..
- 8.- Check and grease pillow block bearings as needed. (Look for rust or fine metal particles)



## 3.- SERVICE MANUAL

 It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating.

### 1.- Pneumatic

#### a.- Main air regulator

Sets the pressure for the entire machine.

Factory adjustment 90 psi

#### b,- In feed regulator

Controls the pressure of the top in feed roll.

Factory adjustment 20 to 40 psi



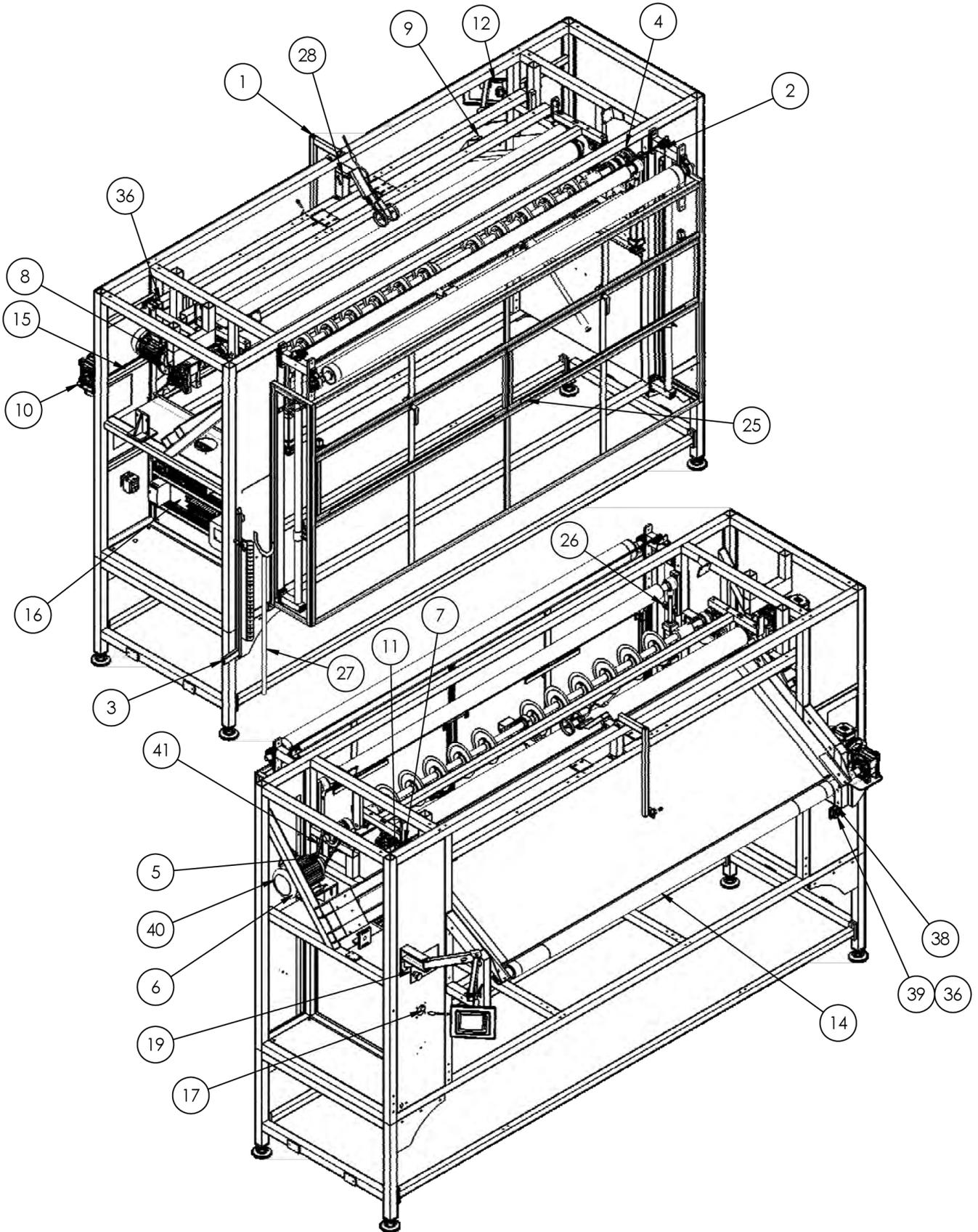


## Assembly Drawings & Parts Lists

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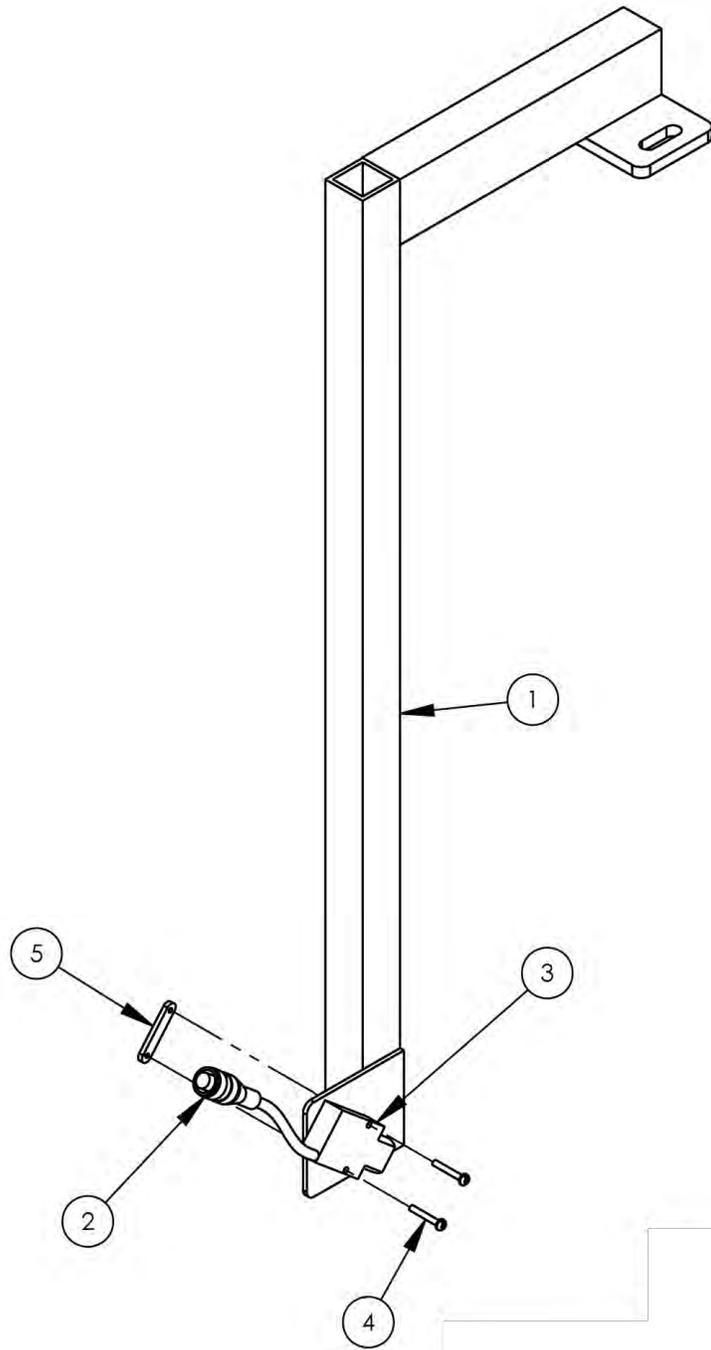
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# 11393BSA Border Splitter

AAC Drawing Number 9001071 Rev 1

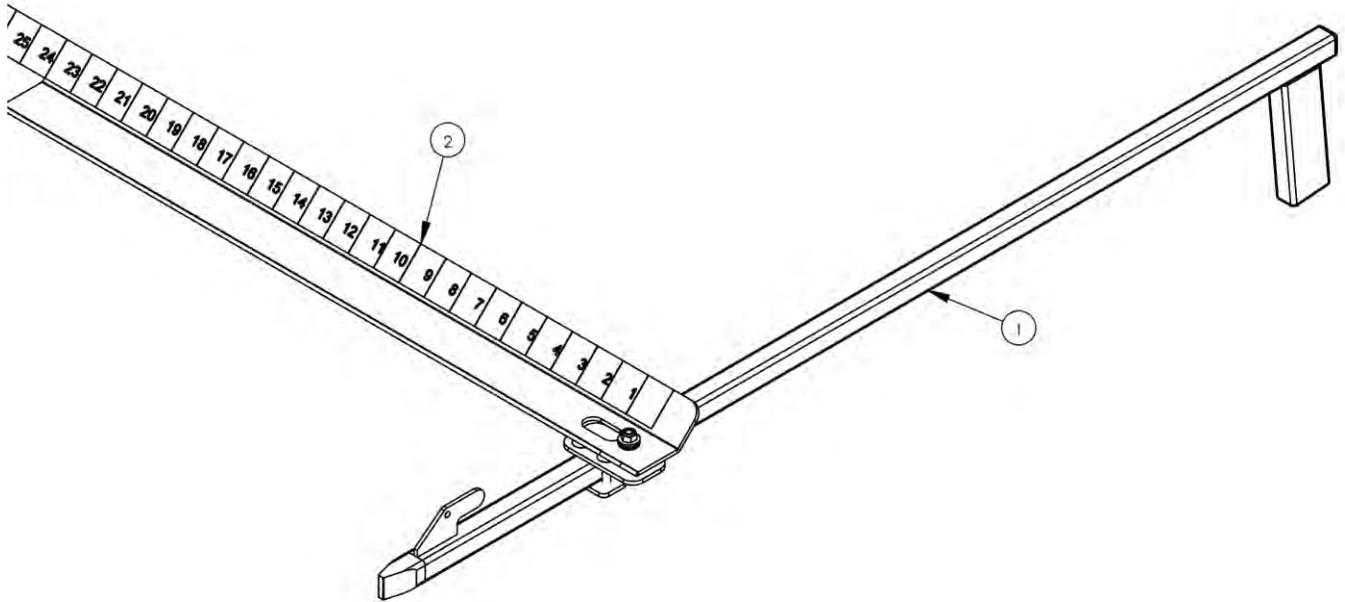
NO.	QTY	PART #	DESCRIPTION	
1	1	1389078	MATERIAL SENSOR, X CUT	Page 29
2	1	1389224	DANCER ASSY 1393	Page 31
3	1	1389415	TOOL, NUDGE POSITIONING	Page 30
4	1	1389605	PULLEY, SLITTER MOTOR	
5	1	1389606	PULLEY, SLITTER MOTOR	
6	1	1389610	MOTOR MOUNT, MODIFICATION	
7	1	1389641	PLATE,DISCHARGE	
8	1	1389664	WLDMT,DISCHARGE SUPPORT,R	
9	2	1389667	WLDMT,DISCHARGE SUPPORT	
10	1	1389672	WLDMT,GEARBOX MTG	
11	1	1389676	WLDMT,DISCHARGE SUPPORT,L	
12	1	1389680	SWIVEL ARM ASSEMBLY	Page 34
13	1	1389690	WLDMT,CENTER SUPPORT	
14	1	1389693	WLDMT,CTR SUPPORT TOP	
15	1	1389694	PLATE,BLANKING	
16	1	1389715	BACK PANEL ELECTRICAL ASM	Page 38
17	1	1389717	SOLENOID ASSEMBLY	Page 39
18	1	1389718	REGULATOR ASBLY	Page 32
19	1	1389720	BUTTON ASSEMBLY	Page 40
20	1	1389860	SLITTER ASBLY,SPLIT SHAFT	Page 41
21	2	1389875	MOUNT, END, 30MM SHAFT	
22	1	1389877	ROD,30MMX2720,60 CASE	
23	1	1389879	TUBE SUPPORT, 30MM	
24	1	1389884	SHARPENER ASBLY, SLITTERS	Page 42
25	1	1393160	REAR GUARD	Page 46
26	1	1393372	DANCER BAR, PROX ASM	Page 36
27	1	1393615	GRABBER TOOL, 36"	
28	1	1393676	ENCODER ASSEMBLY	Page 43
29	AR	1393BSA-PD	PNEUMATIC DIAGRAM	Page 48
30	AR	1393BSA-WD1	DIAGRAM,WIRING,PAGE 1	Page 49
31	AR	1393BSA-WD2	DIAGRAM,WIRING,PAGE 2	Page 50
32	AR	1393BSA-WD3	DIAGRAM,WIRING,PAGE 3	Page 51
33	AR	1393BSA-WD4	DIAGRAM,WIRING,PAGE 4	Page 52
34	AR	1393BSA-WD5	DIAGRAM,WIRING,PAGE 5	Page 53
35	AR	1393BSA-WD6	DIAGRAM,WIRING,PAGE 6	Page 54
36	1	CJ-2-BSA	CJ-2 FRAME MODIFIED	
37	1	EE194EE631753	63AMP DISCON	
38	1	EE194EE63PE	GROUND TERMINAL	
39	1	EE194LHE6N175	DISCONNECT HANDLE,RED/YEL	



## 1389078 X Cut Material Sensor

AAC Drawing Number 1389078 Rev 1

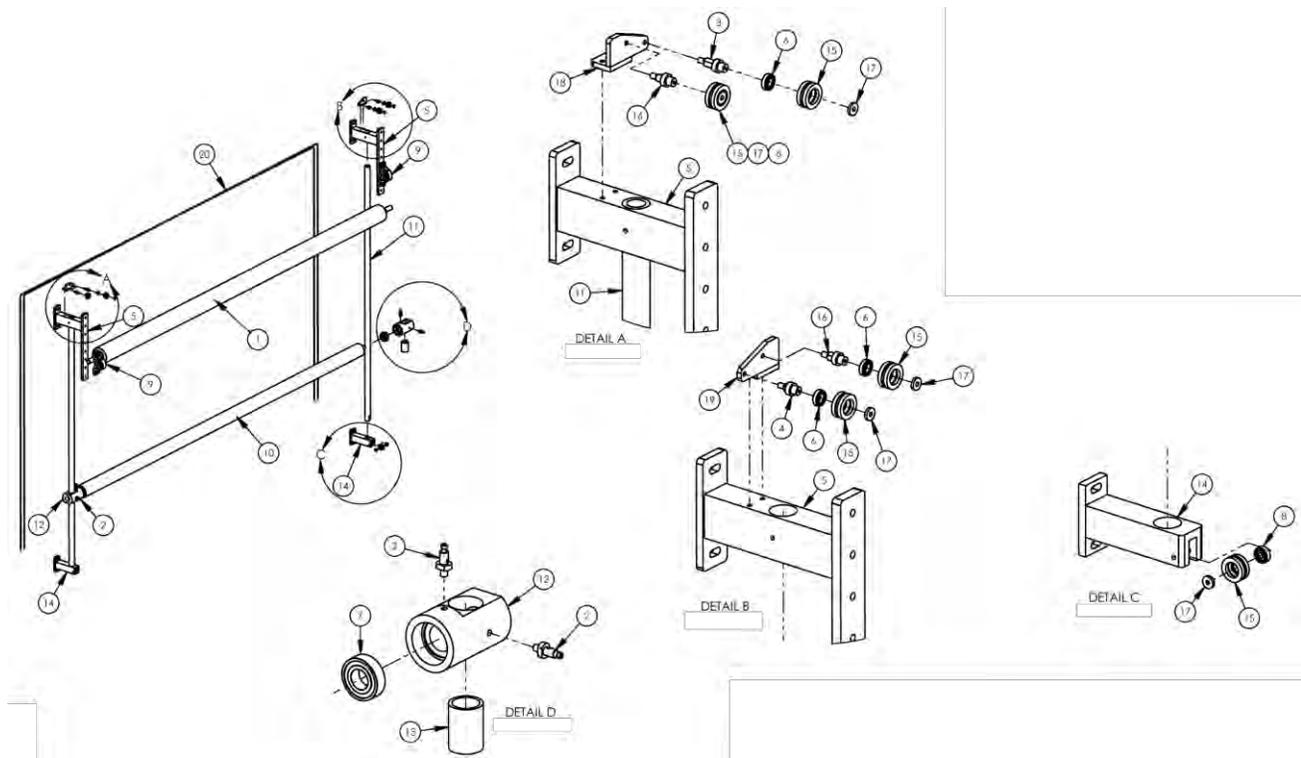
NO.	QTY	PART #	DESCRIPTION
1	1	1389075	EYE MOUNTING BRACKET
2	1	FFRK44T-4	CABLE,EYE,12',NO END
3	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
4	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
5	1	1975-412A	PLATE,NUT,4-40,.95CTC



## 1389415 Nudge Positioning Tool

AAC Drawing Number 1389415 Rev 0

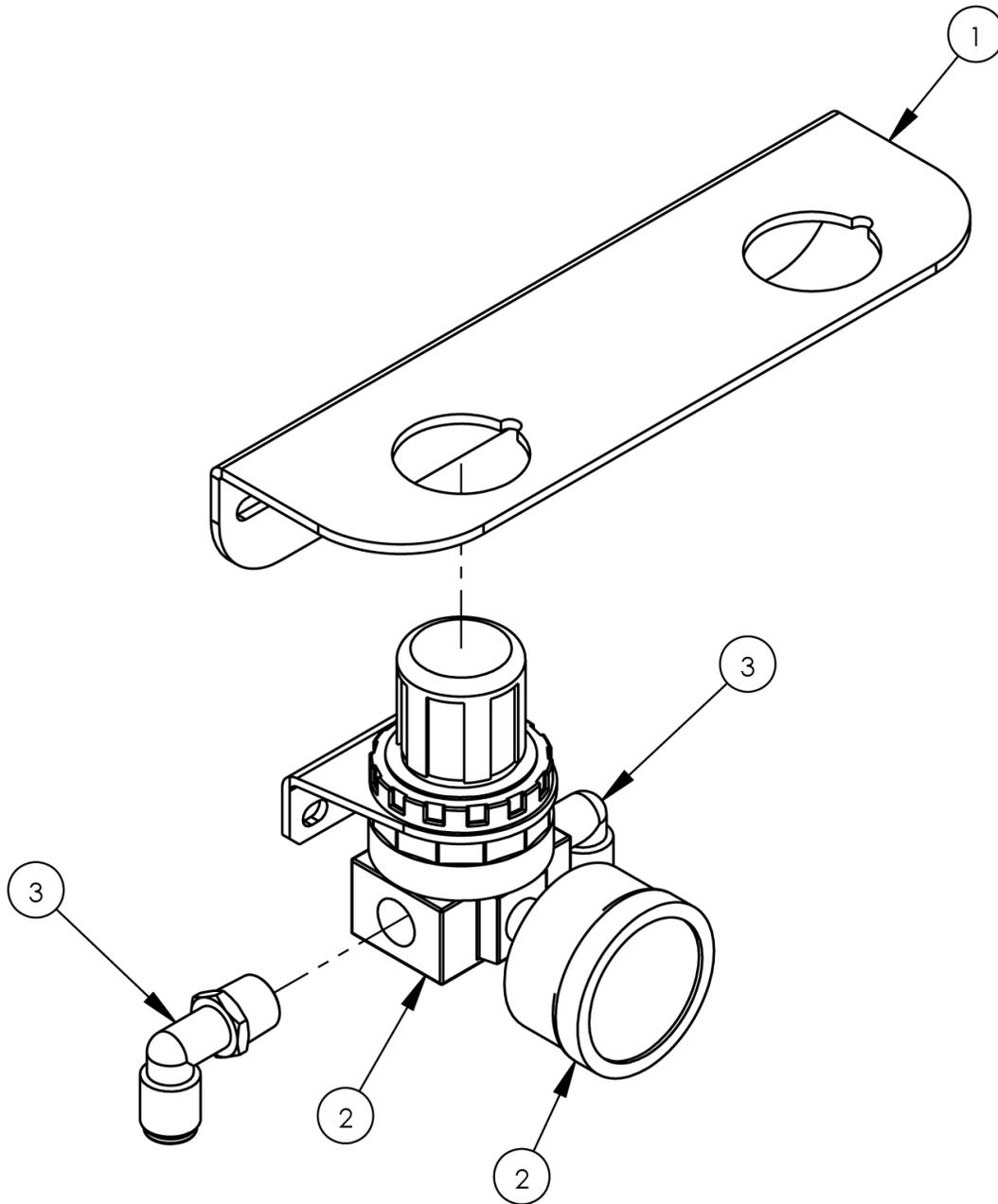
NO.	QTY	PART #	DESCRIPTION
1	1	1389411	HANDLE, NUDGE-POSITIONING
2	1	1389430	SCALE, POSITIONING ASSY



## 1389224 Dancer Assembly

AAC Drawing Number 1389224 Rev 3

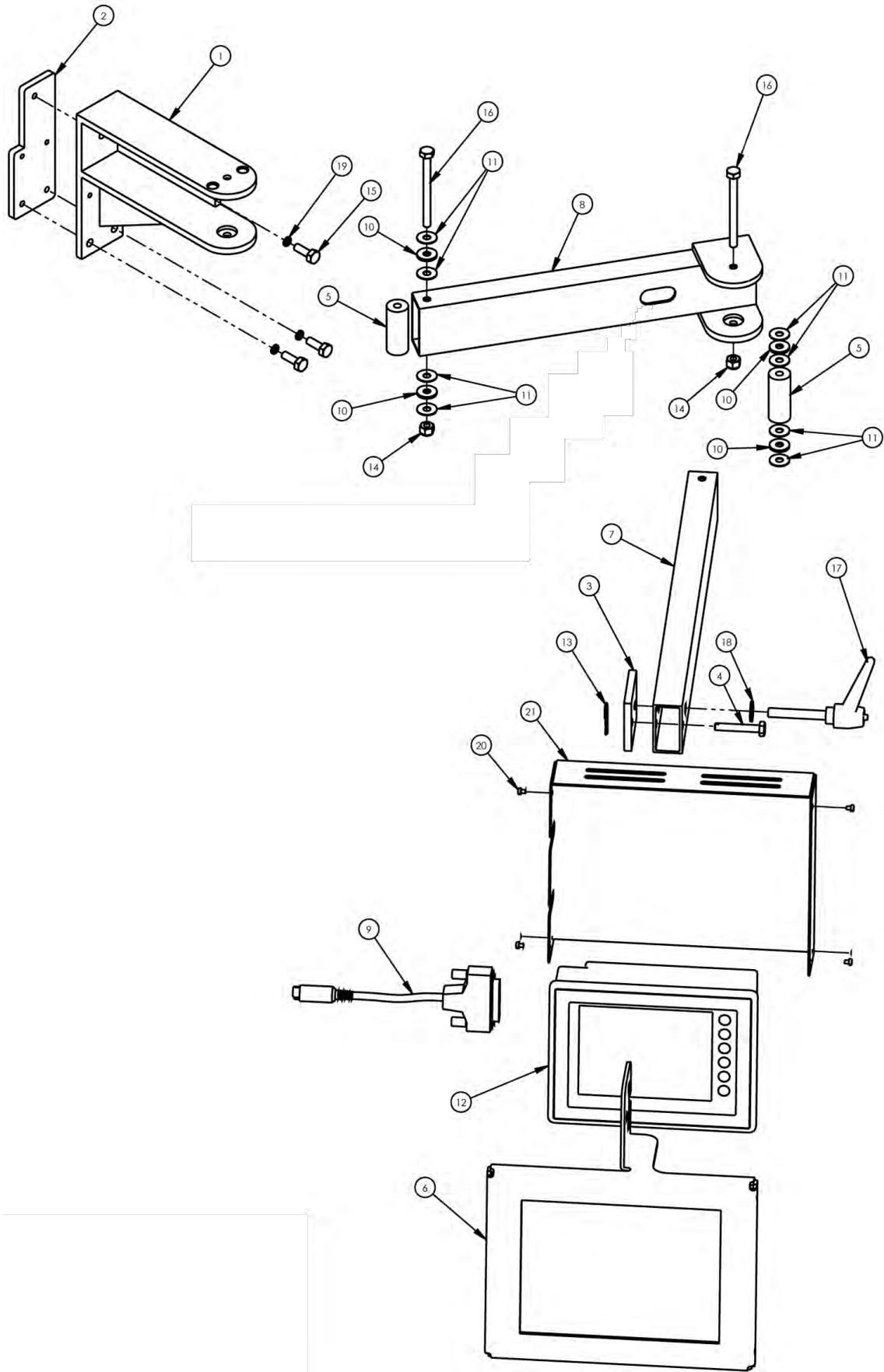
NO.	QTY	PART #	DESCRIPTION
1	1	1389110	ROLLER, BSW
2	4	1389225	GRIPPER ASSY, WIRE ROPE
3	1	1389441	STANDOFF, CABLE 14MM
4	1	1389442	STANDOFF, CABLE 5MM
5	2	1393805	STAND-OFF, DANCER , TOP
6	4	BB618002RS	BEARING,10mm, 19mmOD
7	2	BB62052RS	BEARING,25mm ID, 52mmOD
8	2	BB6262RS	BEARING,6mm ID, 19mmOD
9	2	BBNAP205-25	BEARING, P BLOCK, 25MM
10	AR	CJ-2-8-002A	ROLLER, DANCER
11	AR	CJ-2-8-007	FLOATING BEARING ROD
12	AR	CJ-2-8-008A	BEARING MOUNT, DANCER
13	AR	CJ-2-8-009	BUSHING, DANCER
14	AR	CJ-2-8-011A-1	FIXTURE, LOWER DANCER RAI
15	AR	CJ-2-8-012	CABLE PULLEY
16	AR	CJ-2-8-015	STANDOFF, CABLE PULLEY
17	AR	CJ-2-8-016	BEARING RETAINER
18	AR	CJ-2-8-019B-1	BRACKET, 8-019B-1 -RIGHT
19	AR	CJ-2-8-019B-2	BRACKET, 8-019B-LEFT
20	** 44'	MM3458T46	ROPE,WIRE,SS,3/32",PLAIN



## 1389718 Regulator Assembly

AAC Drawing Number 1389718 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1393392	BRACKET, VALVE MOUNTING
2	1	AAMSR20008	REG,0-140 W/GAUGE& BRKT
3	2	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT

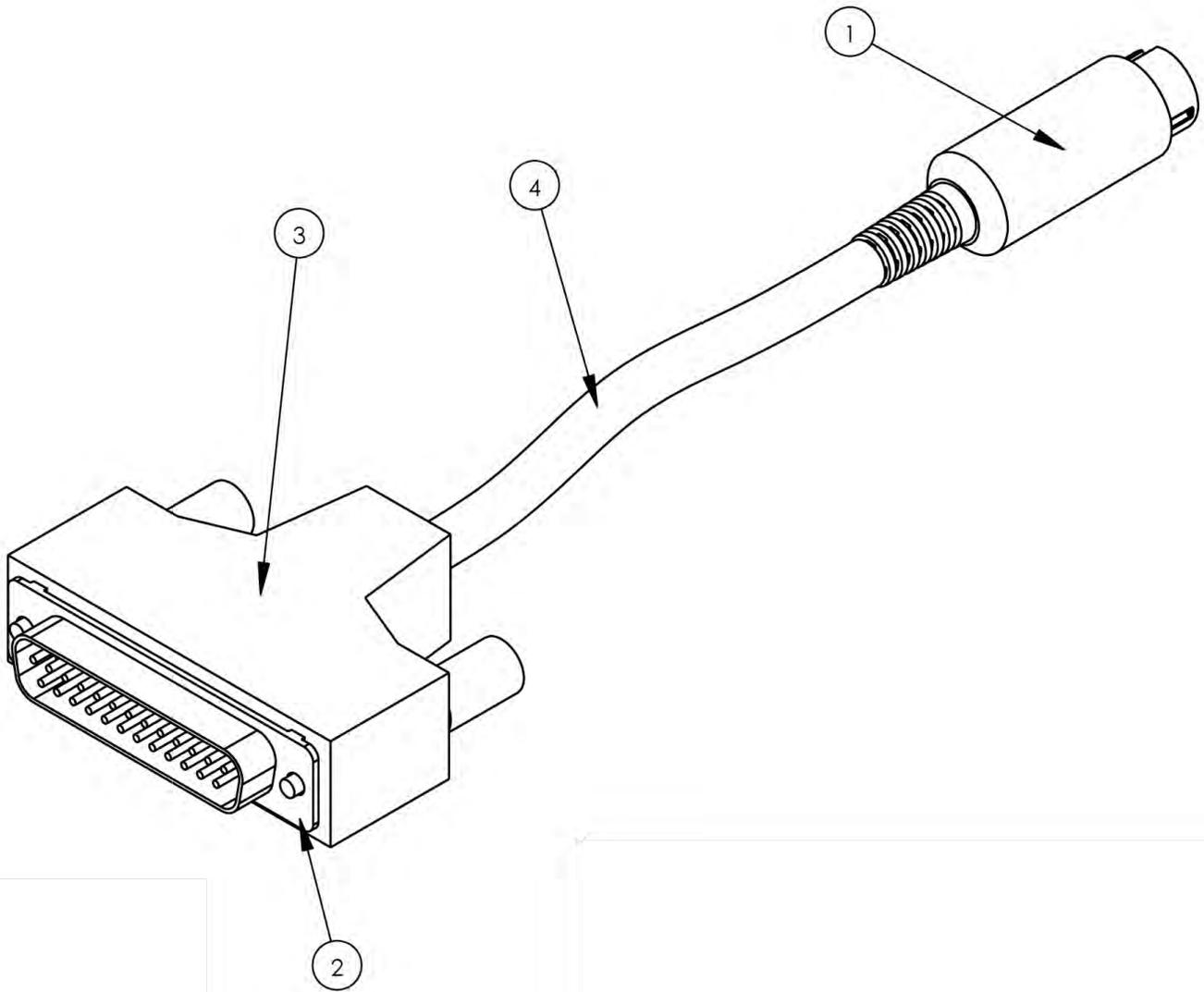


# 1389680 Swivel Arm Assembly

AAC Drawing Number 1389680 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	0411-114	WELDMENT,SWIVEL BASE
2	1	0411-3705	NUT PLATE,BASE MOUNT
3	1	0411-3708	NUT PLATE,BOX MOUNT
4	1	0411-3709	LOCK PIN
5	2	0411-3712	TUBE, SPACER, TALL
6	1	1389677	MOUNT,TOUCHSCREEN
7	1	1389681	TUBE,12 L,PIVOT ARM
8	1	1389701	WLDMT,PIVOT ARM
9	1	1389747	CABLE, TOUCHSCREEN, ASSY
10	4	BBNTA411	BEARING,THRUST,.250B
11	8	BBTRA411	WASHER,THRUST,STEEL
12	1	EEUG221H-LE4	TOUCH SCREEN FOR CJ-2
13	1	MM98335A04	SPRING CLIP, .06 WIRE
14	2	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
15	3	SSHCO1048	1/4-20 X 3/4 HEX HEAD
16	2	SSHCO1192	1/4-20 X 3 HEX HEAD
17	1	TTH32429	HANDLE,THRD,5/16-18X2.0
18	1	WWFS5/16	5/16" FW
19	3	WWL10	#10 LW
20	4	SSPSM3X4	M3-0.5 X 4 PAN HD SLOT
21	1	1389687	COVER,BACK,TOUCHSCREEN

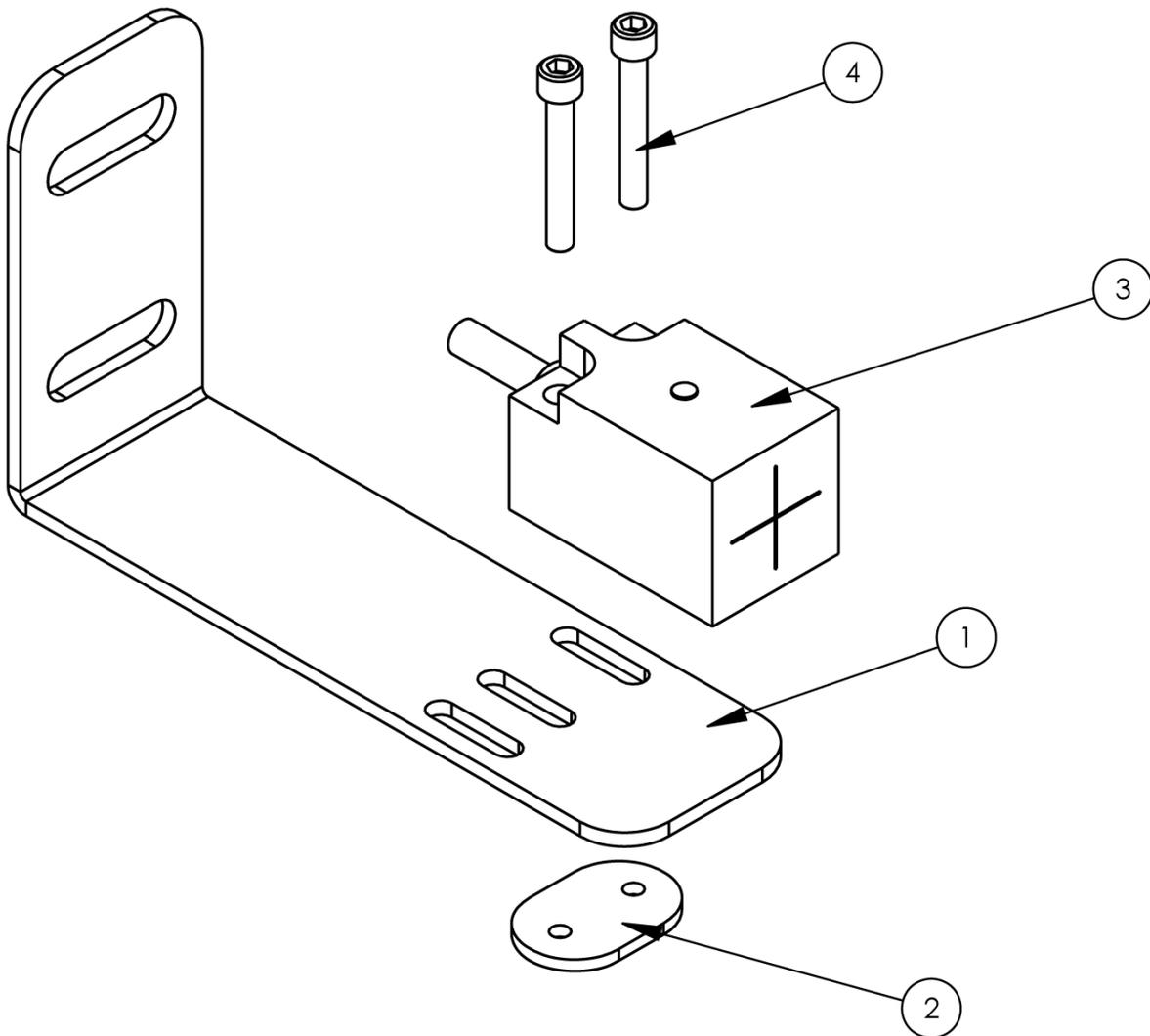
Page 35



## 1389747 Touchscreen Cable Assembly

AAC Drawing Number 1389747 Rev 1

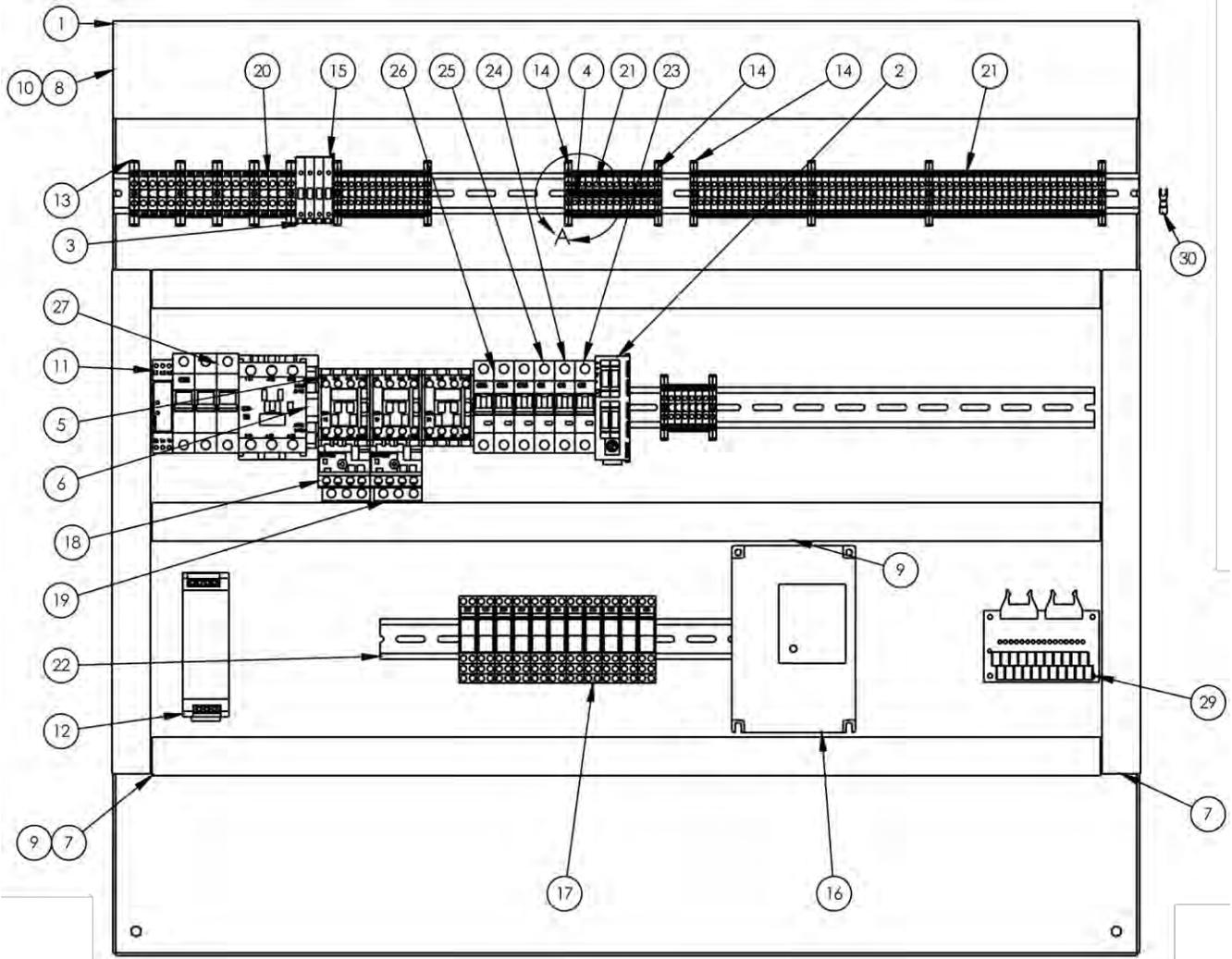
NO.	QTY	PART #	DESCRIPTION
1	1	EEMD50	CONN, MINI DIN, 5 PIN, F
2	1	FF17454968	CONN, 25 PIN D, M, IDC, 22-2
3	1	FF7451341	CONN, 25 PIN D, F, SHIELD, BLK
4	* 20 FT	FF8302	CABLE, 4 COND, 22 AWG



## 1393372 Dancer Bar Sensor Assembly

AAC Drawing Number 1393372 Rev 0

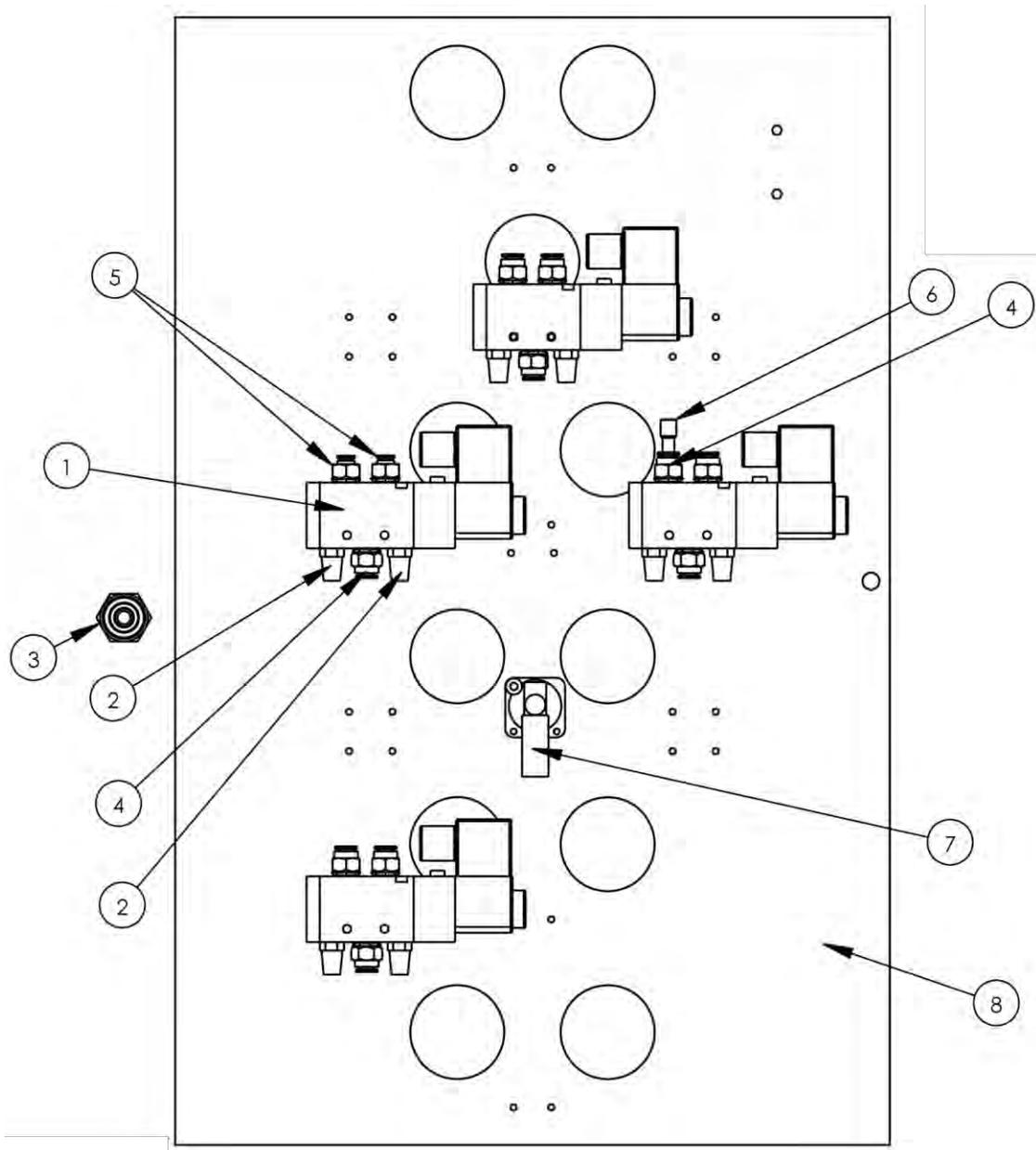
NO.	QTY	PART #	DESCRIPTION
1	1	1393371	BRACKET, SENSOR
2	1	1393373	PLATE, NUT, 4-40
3	1	EENI5Q18AN6X	SENSOR, PROX. NPN, 10-30DC
4	2	SSSC70048	4-40 X 3/4 SOCKET CAP



# 1389715 Back Panel Electrical Assembly

AAC Drawing Number 1389715 Rev 2

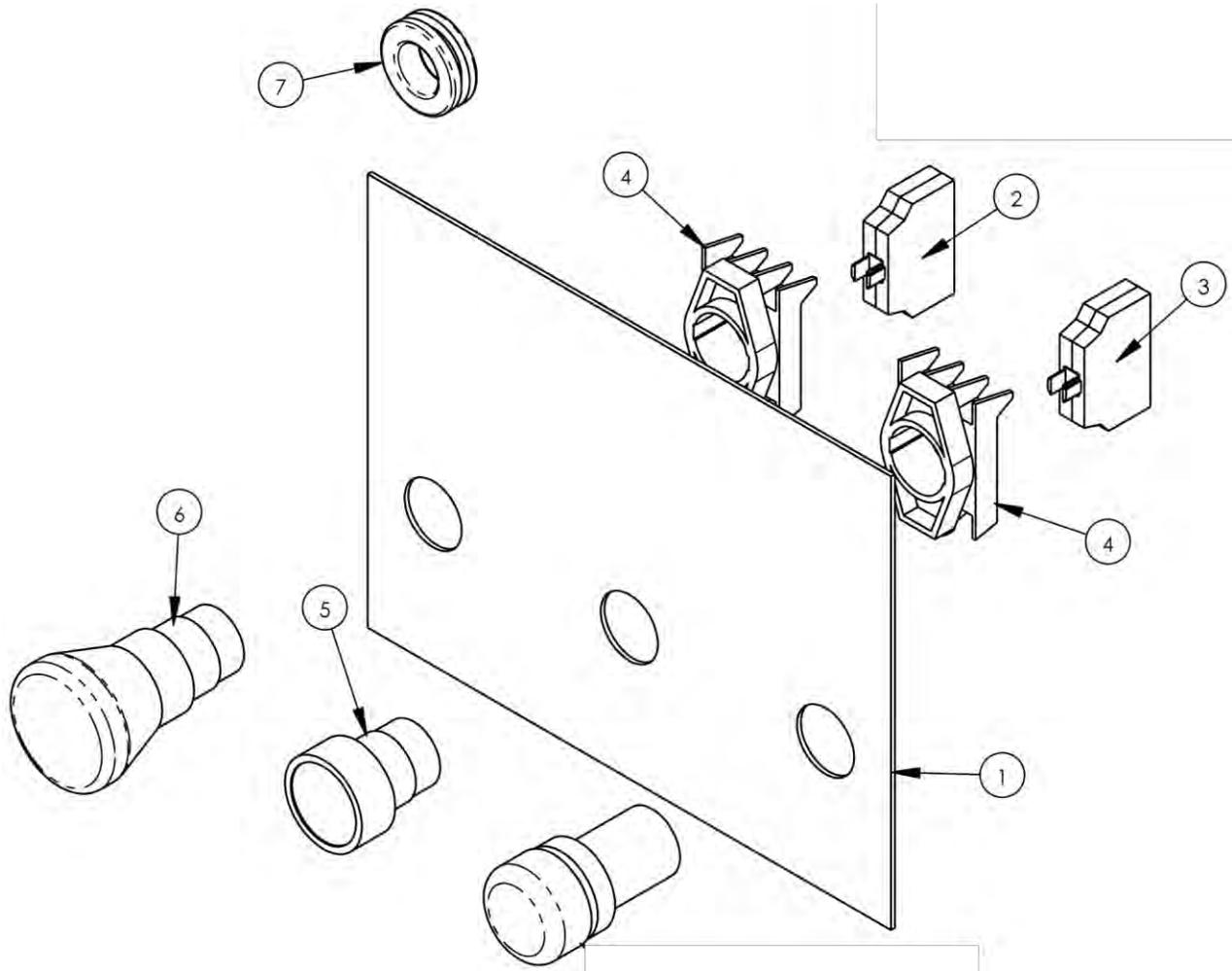
NO.	QTY	PART #	DESCRIPTION
1	1	1-035	BACK PANEL
2	1	AAFP0-C32T-A	CONTROLLER,PLC,W/32 I/O
3	4	EEASK1	BLOCK, FUSE,TERMINAL,ASK1
4	6	EECC252	JUMPER BAR,TERMINAL BLOCK
5	3	EECN11I6-NO	CONTACTOR,IEC,230VAC COI
6	1	EECN25RI6	CONTACTOR,IEC,230VAC COI
7	5	EEDC1LG	DUCT,WIRE COVER,1"
8	1	EEDC3X2	DUCT,WIRE COVER,3"
9	5	EEDF1X2	DUCT,WIRE,1X2
10	1	EEDF3X2	DUCT,WIRE,3X2
11	1	EEDPA51CM44	MONIT, RELAY, 3 PHASE
12	1	EEDR12024	POWER SUPPLY, 24VDC
13	5	EEEEK635	TERMINAL BLOCK, EK2.6/35
14	10	EEEEK2535	TERMINAL BLOCK, EK2.5/35
15	1	EEEPF2	END PLATE, FUSE BLOCK
16	1	EEN2201H	DRIVE,VARIABLE FREQUENCY
17	11	EEP18524DC	RELAY, INTERFACE 24VDC, 1
18	1	EERHN105A	RELAY,OVERLOAD,3.5-5.0A
19	1	EERHN1027A	RELAY,OVERLOAD,1.8-2.7A
20	13	EESAK6EN	TERMINAL BLOCK, SAK6/EN
21	86	EESAK25EN	TERMINAL BLOCK, SAK2.5/EN
22	3	EETS35X7.5A	DIN RAIL-AMERICAN
23	1	FFL721C	CIRCUIT BREAKER,THERM-MAG
24	1	FFL741C	CIRCUIT BREAKER,THERM-MAG
25	1	FFL761C	CIRCUIT BREAKER,THERM-MAG
26	3	FFL7161C	CIRCUIT BREAKER,THERM-MAG
27	1	FFL7323C	CIRCUIT BREAKER,THERM-MAG
28	4	MM6986K617	FUSE,2A,250VAC
29	1	NAIS-IN16P	INTERFACE, INPUT, 16B
30	* 100	WTBM00220	TERMINAL, FORK,14-16 AWG



## 1389717 Solenoid Assembly

AAC Drawing Number 1389717 Rev 1

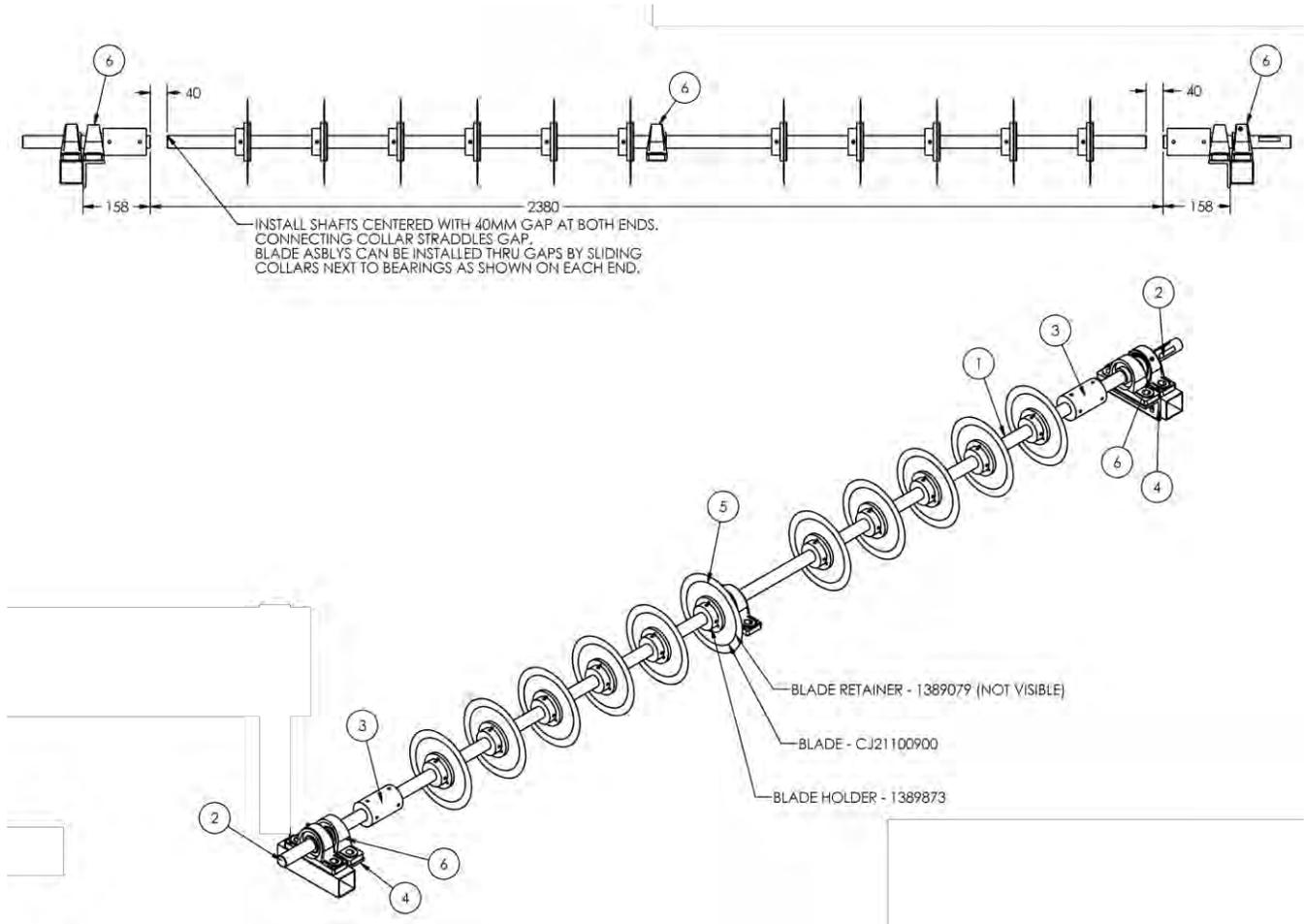
NO.	QTY	PART #	DESCRIPTION
1	4	AAE4V210-14	VALVE, BODY PORTED
2	8	AAFP18	MUFFLER,1/8 NPT, BRONZ
3	1	AAQBU-3-3	Bulkhead Union
4	10	AAQMC-4-4U	QU MALE CONN,1/4X1/4PT
5	2	AAQMC-5-4U	QU MALE CONN,5/32X1/4PT
6	1	AAQPP-07	QUICK PLUG 1/4
7	1	AAVF51FM1B	AIR/ELEC PRESSURE SW
8	1	CJ-2-1-017A	PLATE, VALVE MOUNT



## 1389720 Button Assembly

AAC Drawing Number 1389720 Rev 0

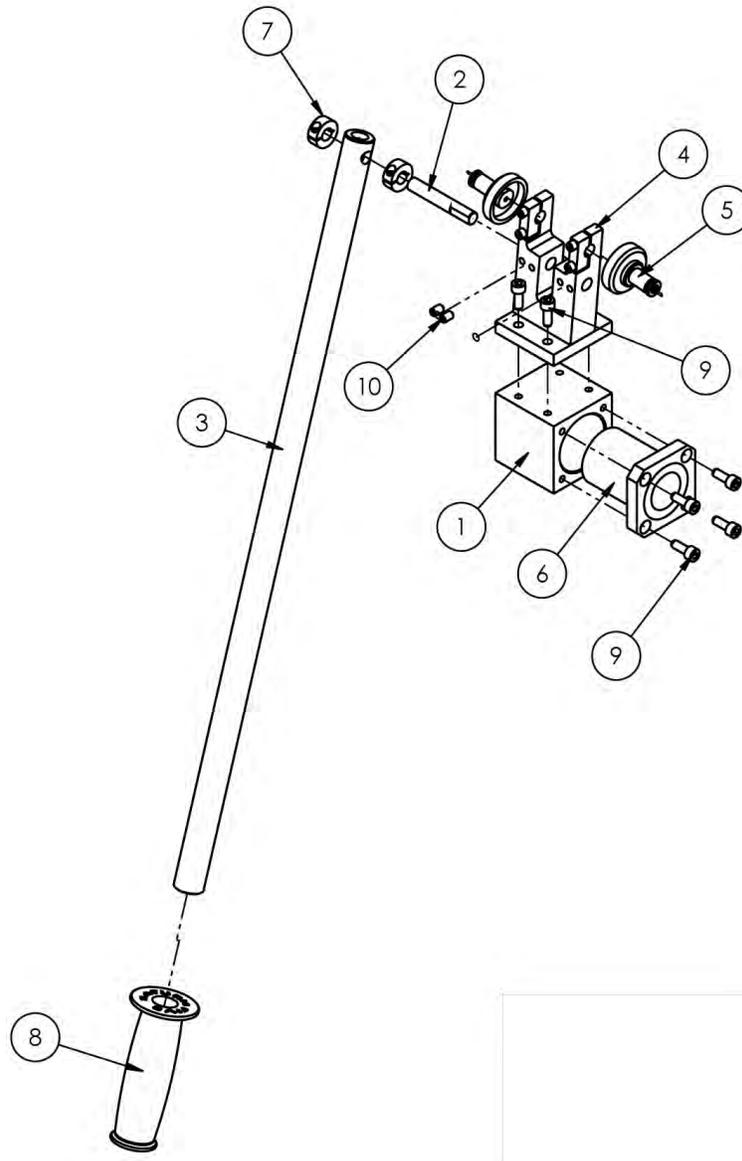
NO.	QTY	PART #	DESCRIPTION
1	1	1393BSA-LAB1	LABEL,PANEL,LASER ENG
2	1	EE3X01	BLOCK,P.B. CONTACT, N.C.
3	1	EE3X10	BLOCK,P.B. CONTACT, N.O.
4	2	EEA3L	LATCH,PUSH BUTTON
5	1	EEPF3	BUTTON, PUSH 22MM, GREEN MO
6	1	EEPMTS44	E-STOP BUTTON, TWIST REL.
7	1	MM9307K65	GROMMET,5/8,1.125,.125GV



## 1389860 Split Shaft Splitter Assembly

AAC Drawing Number 1389860 Rev 2

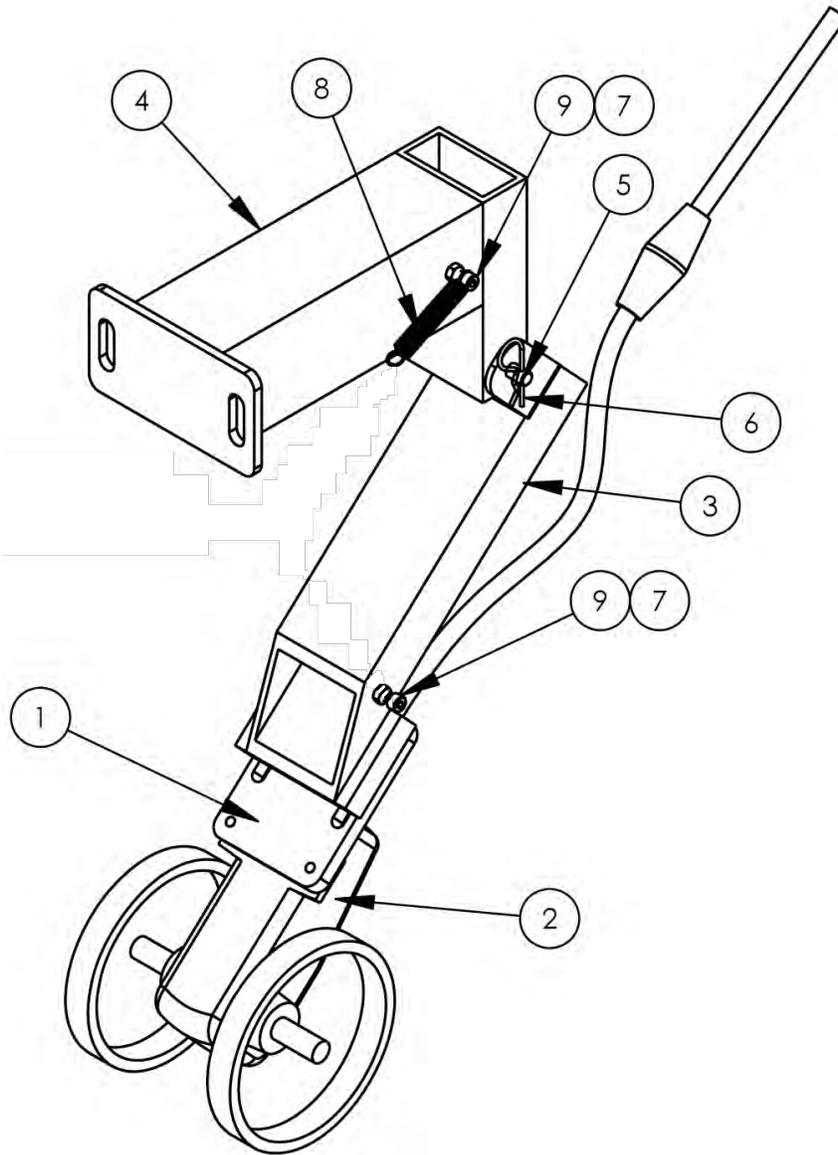
NO.	QTY	PART #	DESCRIPTION
1	1	1389857	DRIVE SHAFT,30MM X 2300MM
2	2	1389858	DRIVE SHAFT, 30MM X 300MM
3	2	1389859	COUPLING,30MM X 4 IN
4	2	1389874	MOUNT,ANGLE,BEARING
5	11	1393149	BSW SLITTER ASSEMBLY
6	5	BUCP206	BEARING, PILLOWBLOCK



## 1389884 Slitters Sharpener Assembly

AAC Drawing Number 1389884 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	1389883	BLOCK,SLIDE,SHARPENER
2	1	1389889	ROD,10MM X 63MM
3	1	1389890	TUBE,HANDLE,7/8X24
4	1	1389892	SHARPENER STONE HOLDER
5	2	1393003	SHARPENER STONE MT
6	1	BBSMK30GUU	BEARING,LIN,FLG,30MM
7	2	CCCLM10F	COLLAR,10MM CLAMP
8	1	PPP97045K57	GRIP,RIBBED VINYL
9	8	SSSCM6X16	M6X16 SOC CAP SCREW
10	2	SSSSM6X10	M6 SET SCREW, 10MM L

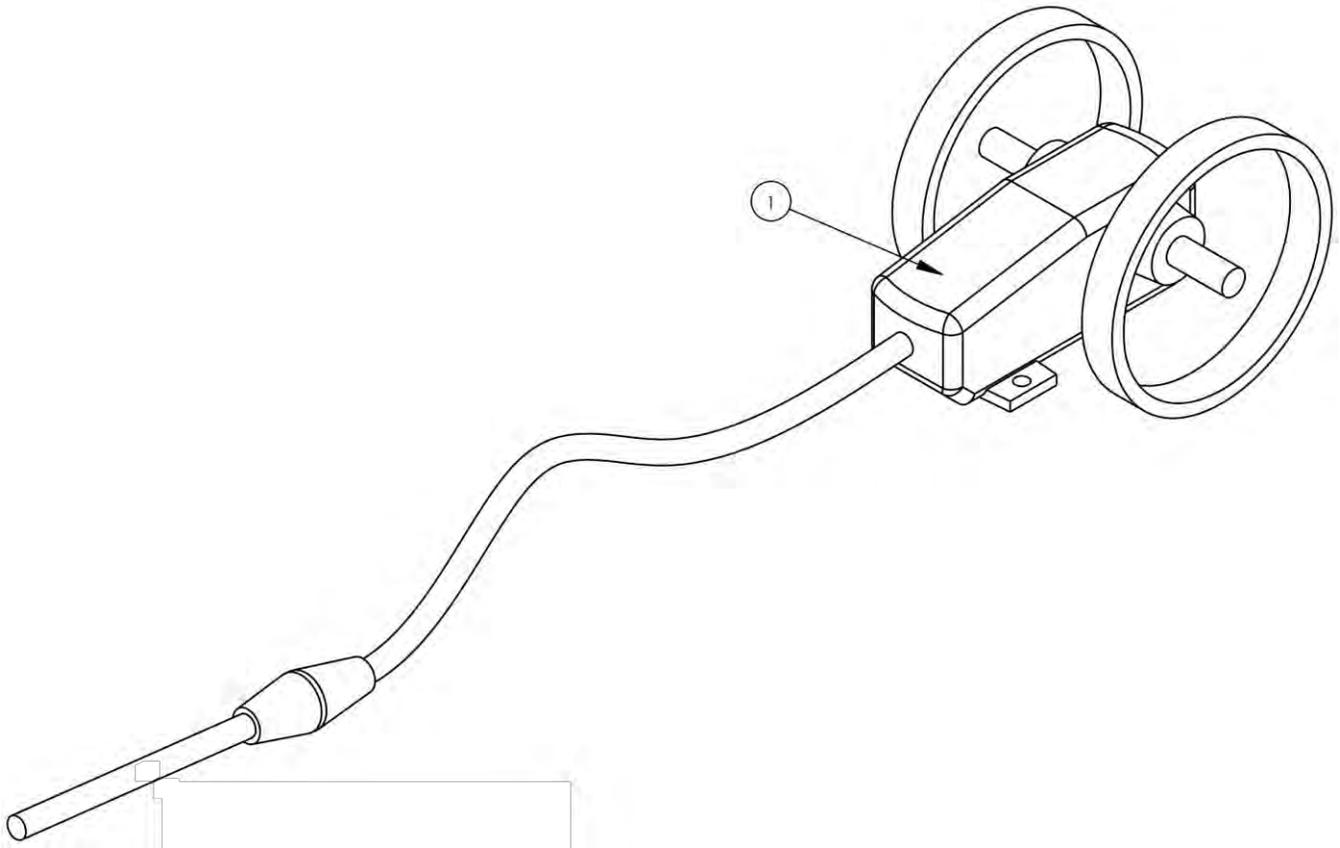


## 1393676 Encoder Assembly

AAC Drawing Number 1393676 Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1	1388420	PLATE, ENCODER MOUNT
2	1	1389794	CABLE, ENCODER, ASSEMBLY
3	1	1393668	COUNTER ARM, MOVING
4	1	1393670	BRACKET, STAND-OFF WELD
5	1	1393675	PIVOT PIN ASSEMBLY
6	1	MM98335A04	SPRING CLIP, .06 WIRE
7	2	NNHM4X0.7	NUT, HEX, M4-0.7
8	1	RRLE030CD7	SPRING, EXT, .030X.31X2.0
9	2	SSSCM4X16	SCREW, SOCKET CAP

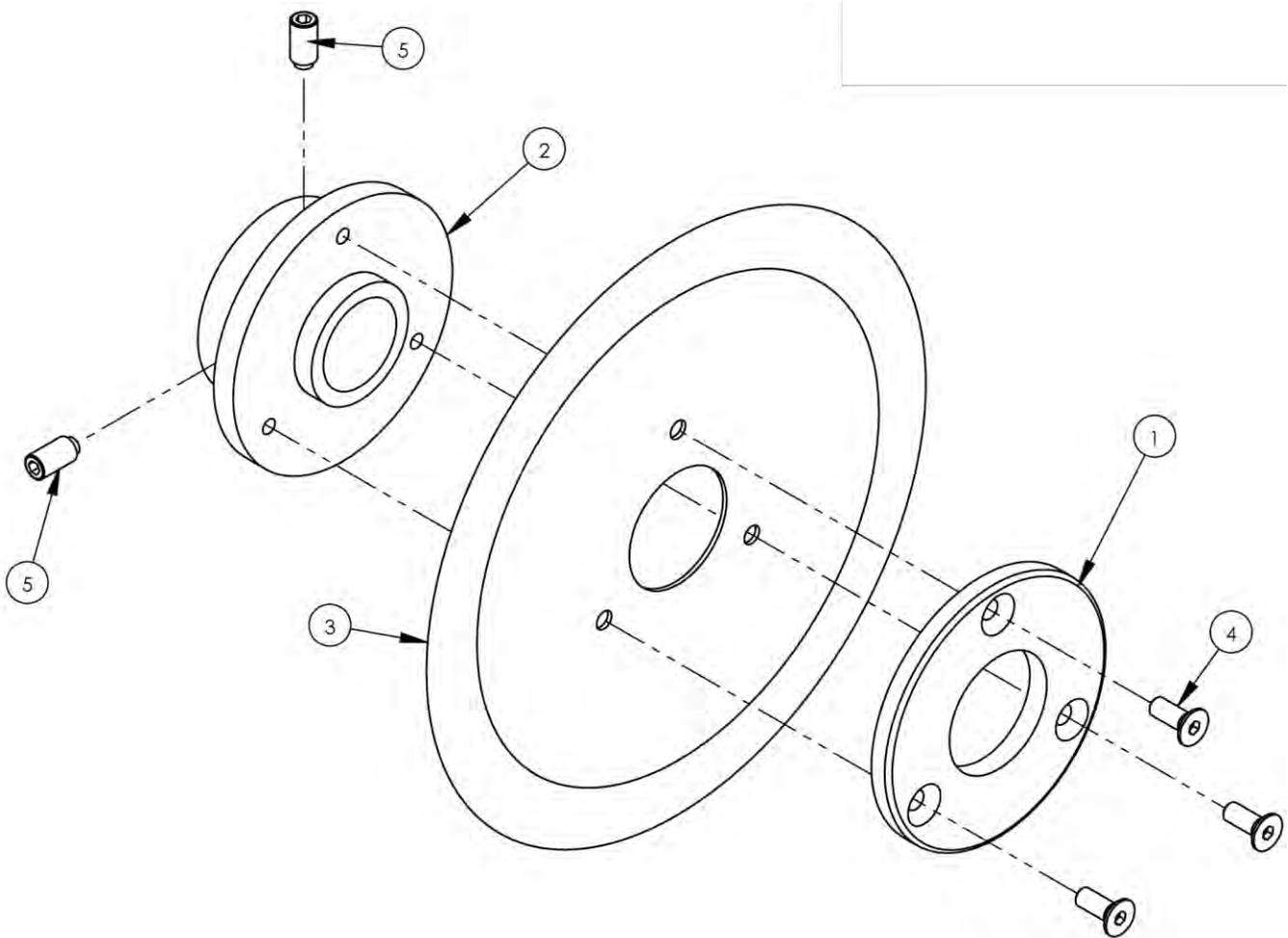
Page 44



## 1389794 Encoder Cable Assembly

AAC Drawing Number 1389794 Rev 0

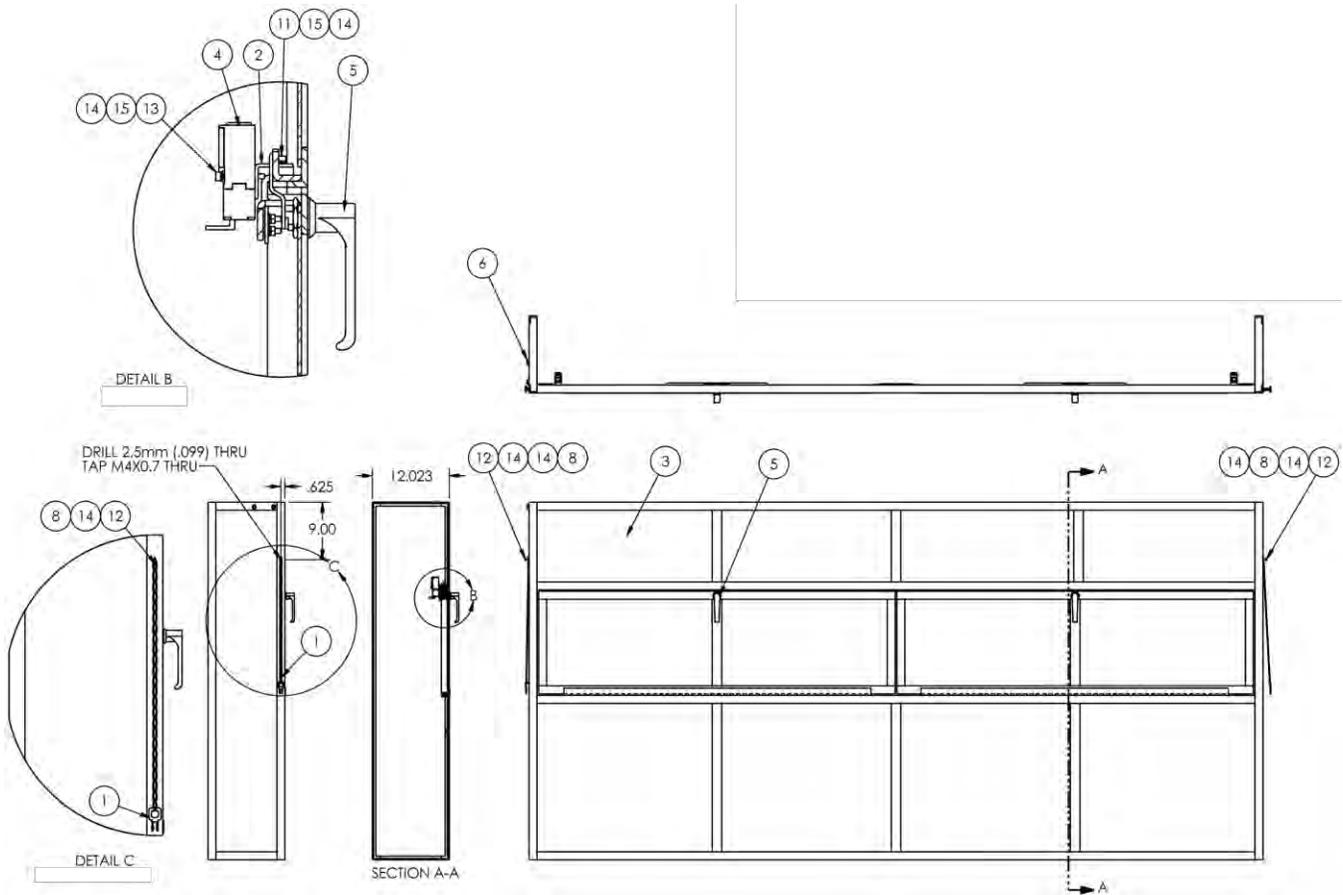
NO.	QTY	PART #	DESCRIPTION
1	1	PL-D3M	ENCODER
2	1	1389794 (125627B)	WIRING DIAGRAM



## 1393149 BSW Slitter Assembly

AAC Drawing Number 1393149 Rev 2

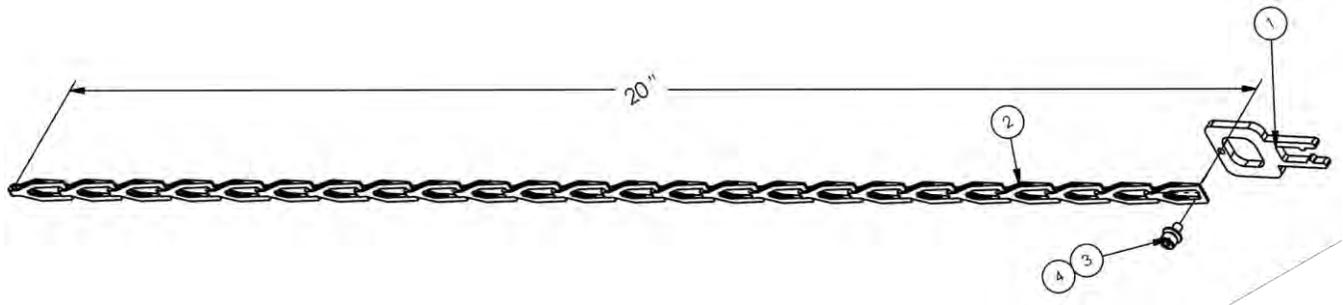
NO.	QTY	PART #	DESCRIPTION
1	1	1389079	BLADE RETAINER
2	1	1389873	BLADE HOLDER
3	1	CJ21100900	BLADE,40MM ID,205MM OD
4	3	SSFCM6X16	M6-1.0 X 16 FLAT ALLEN
5	2	SSSSM8X16BT	M8X16 SOC SET, BRASS TIP



## 1393160 Rear Guard

AAC Drawing Number 1393160 Rev 8

NO.	QTY	PART #	DESCRIPTION
1	2	1388683	SAFETY SWITCH KEY ASM
2	2	1389632	LOCKOUT BKT, FRAME
3	1	1393899	REAR, GUARD
4	2	MM65665K32	SWITCH, SAFETY, DOOR
5	2	MMELH149	LATCH HANDLE
6	2	NNH3/8-16	NUT, HEX, 3/8-16
7	4	NNHM4X0.7	NUT, HEX, M4-0.7
8	2	NNJM4	NUT, JAM, M4, ZINC PLATED
9	24	SSFC90024	8-32 X 3/8 FL ALN CAP
10	4	SSPSM4X16	M4-0.70X16 PAN HS SLOTTED
11	4	SSSCM4X10	SCREW, SOC CAP, M4-0.7X8
12	2	SSSCM4X16	SCREW, SOCKET CAP
13	4	SSSCM4X35	SCREW, SOC CAP, M4-0.7X30
14	20	WWFM4.3	WASHER, FLAT, M4
15	12	WWL8	WASHER, LOCK, #8

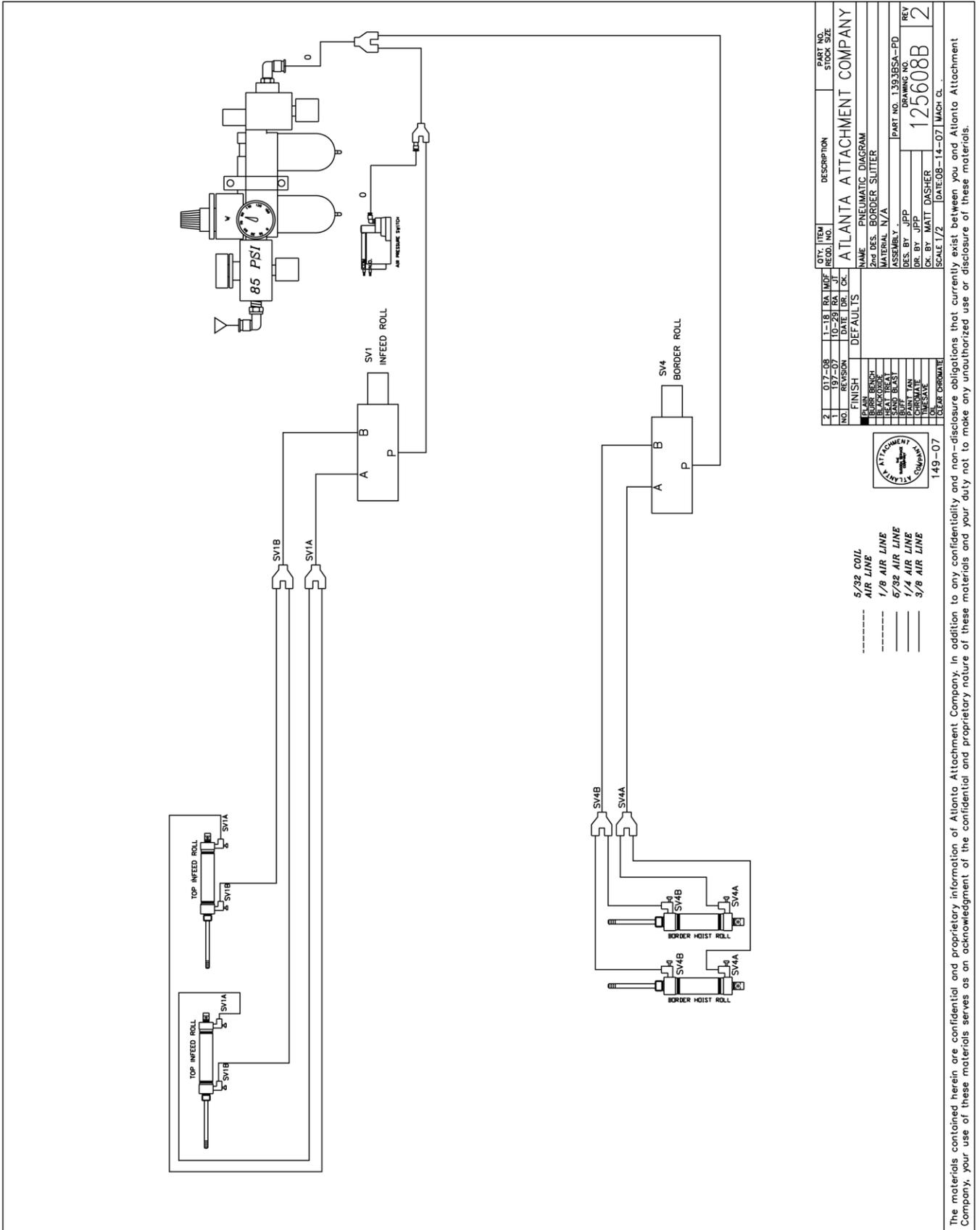


## 1388683 Safety Switch Key Assembly

AAC Drawing Number 1388683 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1389214	KEY, SAFETY DOOR
2	* 20"	K-3607T511	SASH CHAIN
3	1	SSSCM3x6	M3-0.5X__SCREW,SOCKET CAP
4	1	WWFM3	FLAT WASHER, M3

# 1393BSA-PD Pneumatic Diagram



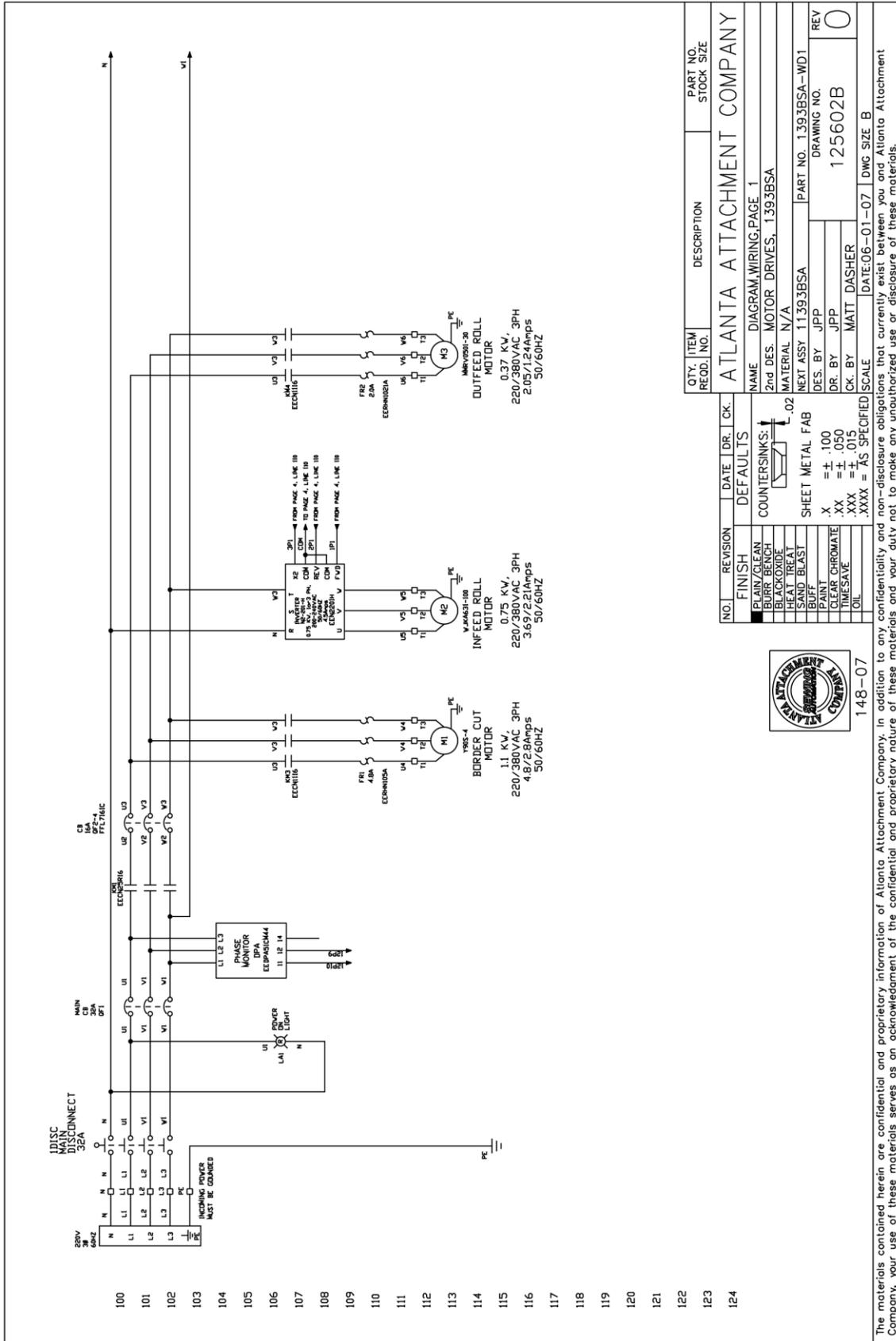
QTY.	ITEM	DESCRIPTION	PART NO.
2	017-08	1-18 TRA MOD	STITCH SIZE
1	197-07	10-29 RA JI	
1	REVISION	DATE	DR. CK.
NAME ATLANTA ATTACHMENT COMPANY 2nd DES. PNEUMATIC DIAGRAM MATERIAL N/A ASSEMBLY N/A DES. BY JPP DR. BY JPP CK. BY MATT DASHNER SCALE 1/2 DATE 08-14-07 MACH. CL.			
FINISH BLACK BENCH UNLACQUERED SAND BLAST BUFF POLISH CHROMIUM TUMESAVE CLEAR CRUMATE			PART NO. 1393BSA-PD DRAWING NO. 125608B REV. 2



- 5/32 COIL AIR LINE
- 1/8 AIR LINE
- 5/32 AIR LINE
- 1/4 AIR LINE
- 3/8 AIR LINE

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# 1393BSA-WD1 Wiring Diagram



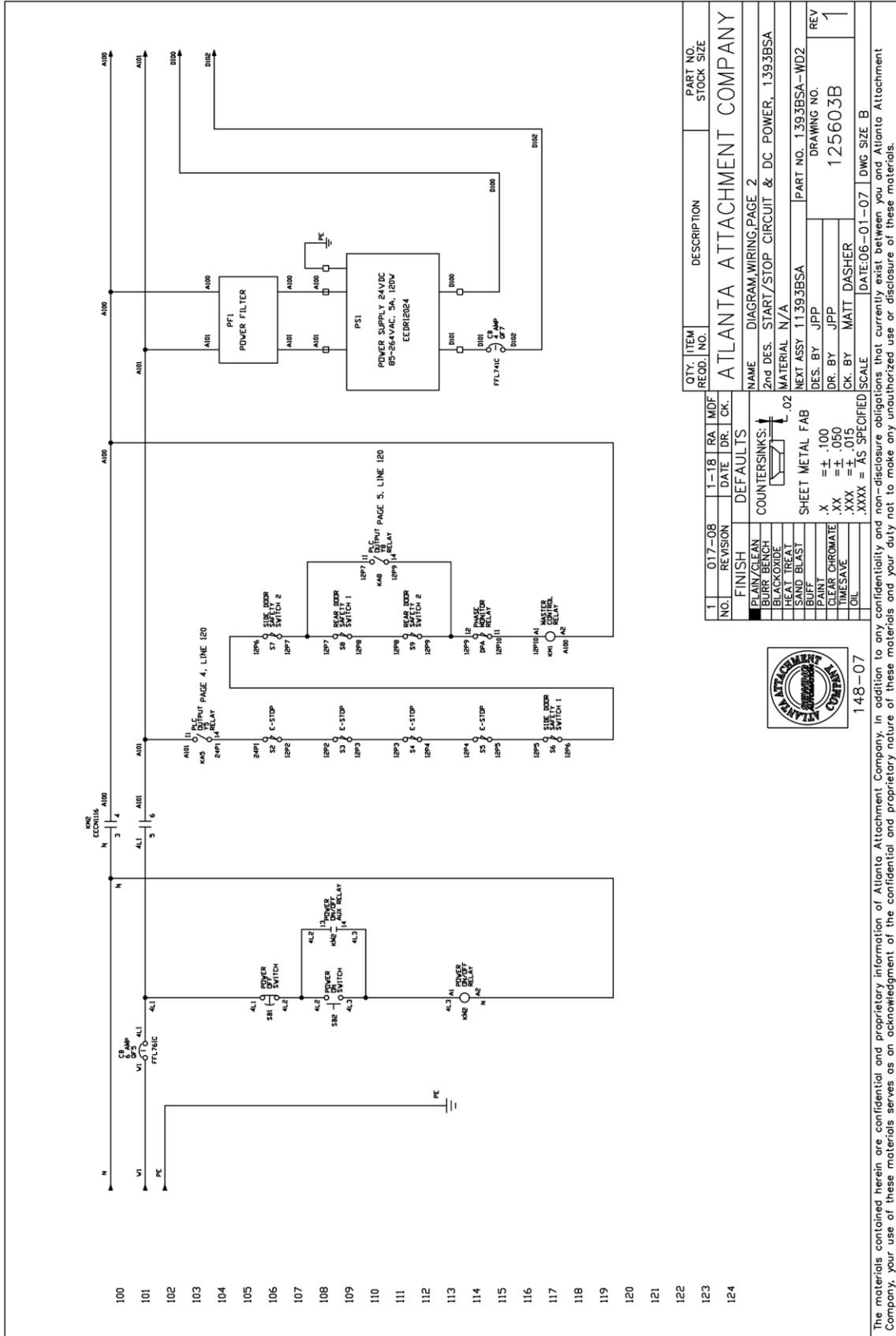
NO.	REVISION	DATE	DR.	CHK.	DESCRIPTION	PART NO.	STOCK SIZE
1	FINISH				DIAGRAM, WIRING, PAGE 1		
	BLANK/CLEAN						
	BURR/BENCH						
	BLACKOXIDE						
	HEAT TREAT						
	SAND BLAST						
	BUFF						
	PAINT						
	CLEAR CHROMATE						
	PHOSPHATE						
	OIL						
	COUNTERSINKS:						
	SHEET METAL FAB						
	.X = ± .100						
	.XX = ± .050						
	.XXX = ± .015						
	.XXXX = AS SPECIFIED						
	SCALE						
	DATE: 06-01-07						
	DWG SIZE						
	B						
	DES. BY	JPP					
	DR. BY	JPP					
	CK. BY	MATT DASHER					
	DRAWING NO.	125602B					
	PART NO.	1393BSA-WD1					
	DESCRIPTION	ATLANTA ATTACHMENT COMPANY					
	NAME	DIAGRAM, WIRING, PAGE 1					
	2nd DES.	MOTOR DRIVES, 1393BSA					
	MATERIAL	N/A					
	REV						



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# 1393BSA-WD2 Wiring Diagram



QTY.	ITEM	RECD.	NO.	DESCRIPTION	PART NO.	STOCK SIZE
1	017-08	1-18	RA	MDF		
FINISH						
BLANK/BENCH						
BLACKOXIDE						
HEAT TREAT						
SAND BLAST						
PAINT						
CLEAR CHROMATE						
PRESERVE						
OIL						
COUNTERSINKS:						
.02						
SHEET METAL FAB						
.X = ± .100						
.XX = ± .050						
.XXX = ± .015						
.XXXX = AS SPECIFIED						
SCALE DATE:06-01-07 DWG SIZE B						
REV 1						
DR. BY JPP						
CK. BY MATT DASHER						
DRAWING NO. 125603B						
PART NO. 1393BSA-WD2						
NEXT ASSY 11393BSA						
MATERIAL N/A						
NAME DIAGRAM WIRING PAGE 2						
2nd DES. START/STOP CIRCUIT & DC POWER, 1393BSA						
ATLANTA ATTACHMENT COMPANY						



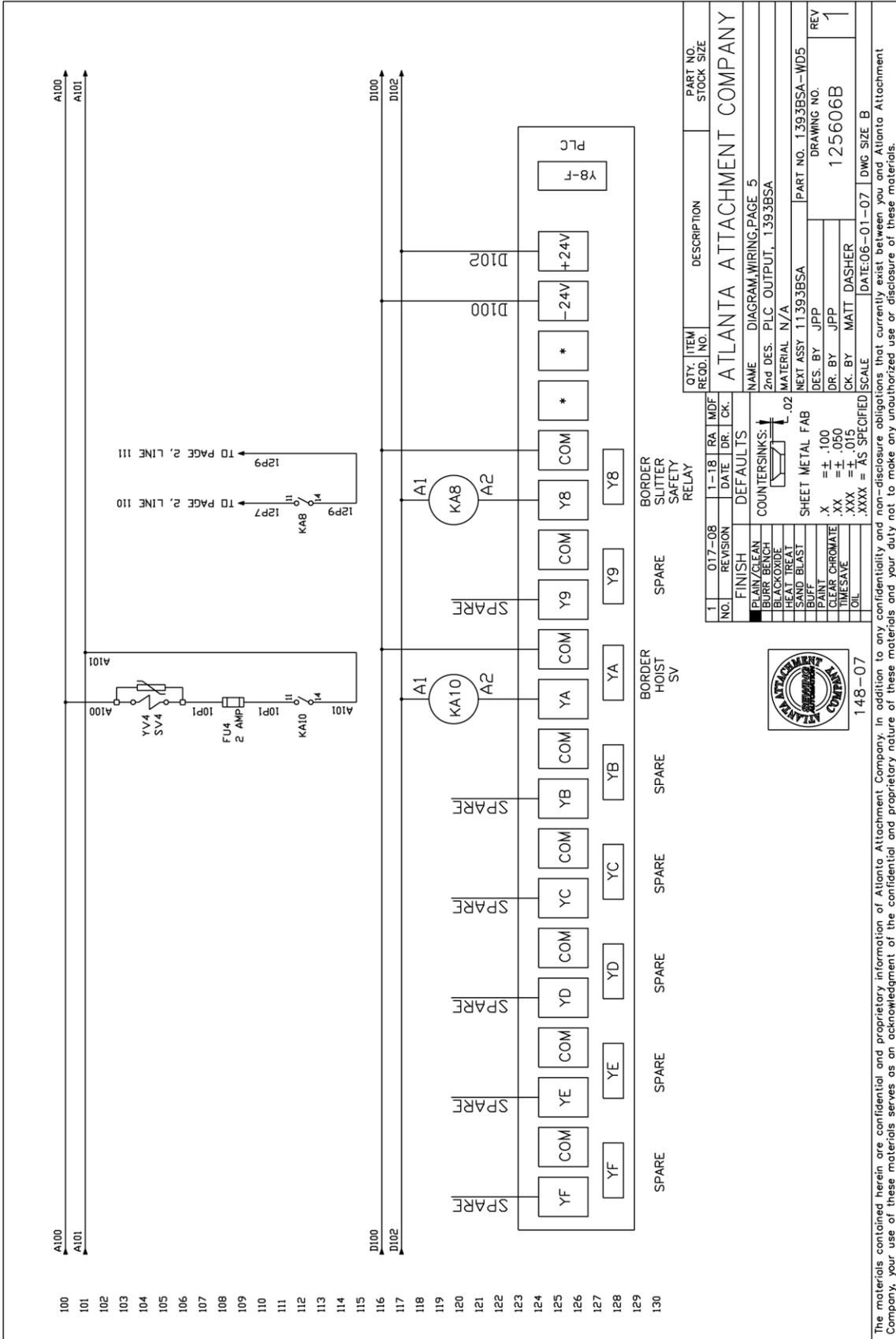
148-07

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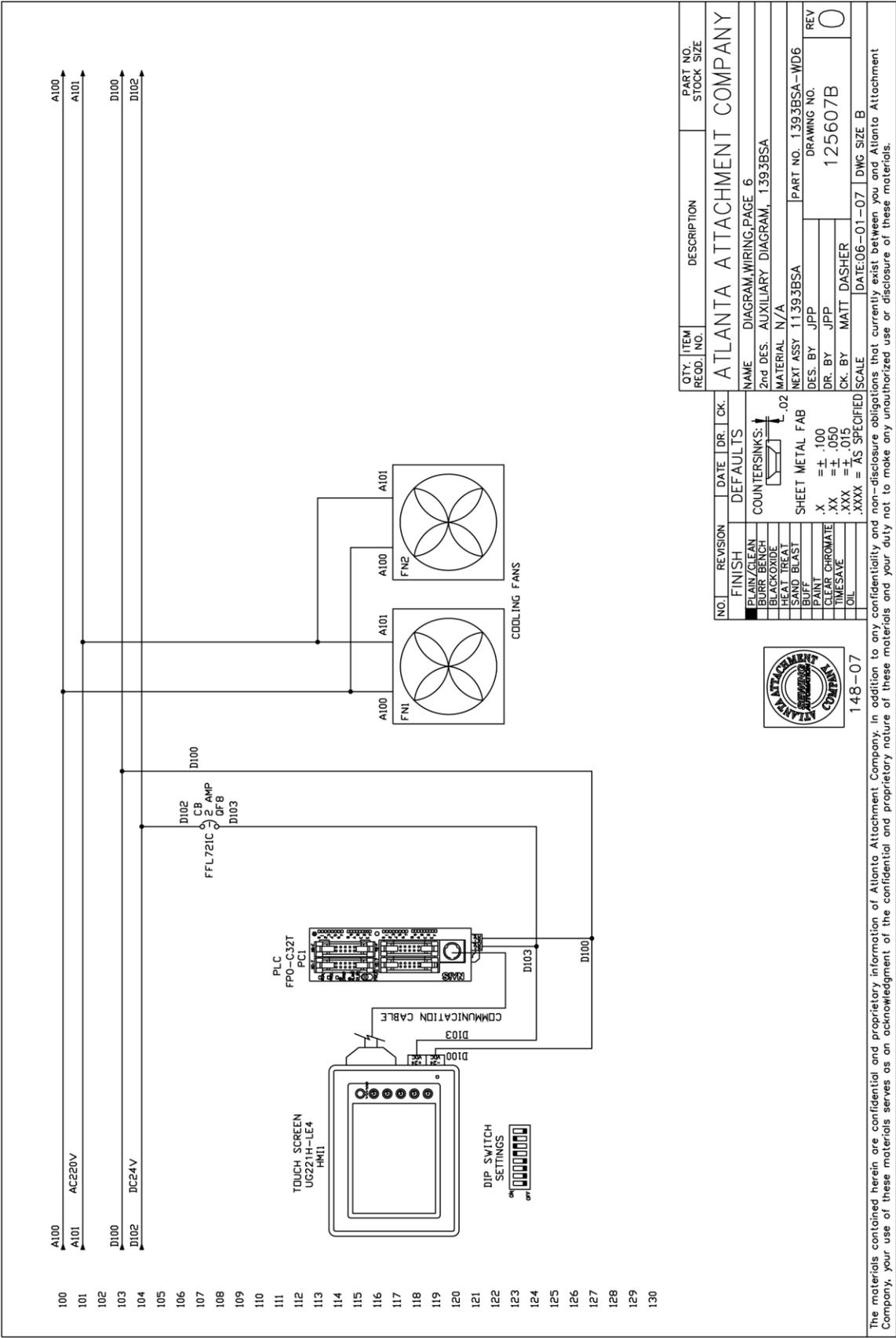




# 1393BSA-WD5 Wiring Diagram



# 1393BSA-WD6 Wiring Diagram



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NO.	REVISION	DATE	DR.	CK.	DESCRIPTION	PART NO.	STOCK SIZE
	FINISH				ATLANTA ATTACHMENT COMPANY		
	PLAIN/CLEAN				DIAGRAM, WIRING, PAGE 6		
	BURR/BENCH				2nd DES. - AUXILIARY DIAGRAM, 1393BSA		
	HEAT TREAT				MATERIAL N/A		
	SAND BLAST				NEXT ASSY 1393BSA		
	PAINT				DATE:06-01-07		
	BUFF				SCALE		
	CLEAR CHROMATE				DR. BY JPP		
	TIMESAVE				CK. BY MATT DASHER		
	OIL				DRAWING NO.		
					125607B		
					REV		
					0		



148-07

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## Atlanta Attachment Company (AAC) Statement of Warranty

### Manufactured Products

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

### Terms and Conditions:

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

### What Is Covered

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

### What Is Not Covered

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

# Declaración de Garantía

## Productos Manufacturados

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

## Términos y Condiciones:

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



**Atlanta Attachment Company**  
362 Industrial Park Drive  
Lawrenceville, GA 30046  
770-963-7369  
[www.atlatt.com](http://www.atlatt.com)

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