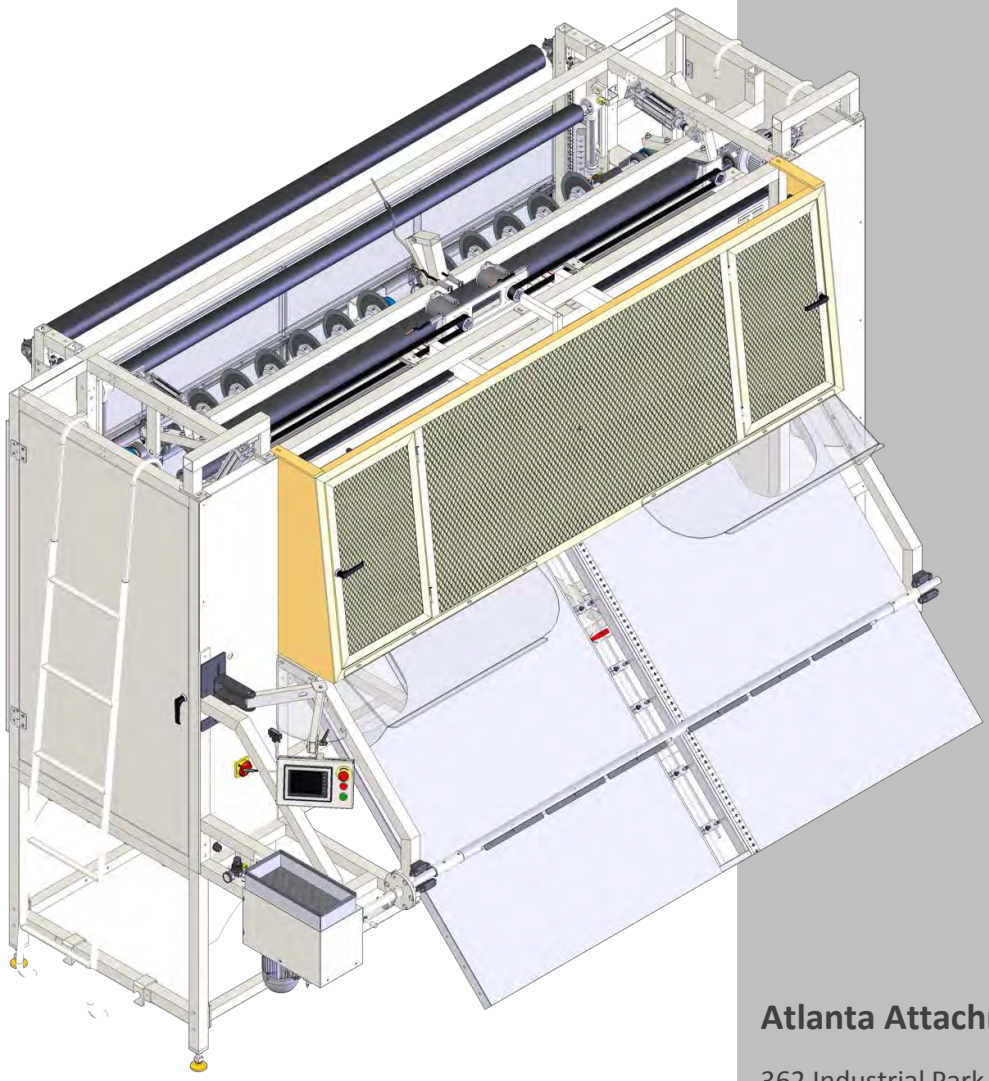
model **1393E**

Revision 2.7 Updated July.17, 2016

Technical Manual & Parts Lists



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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.

Contents

Important Safety Instruction 1
Liability 2
Safety Equipment on the Machines 3
Protective Eyewear 4
Important Notices 5
Maintenance 7
Repair 8
A Word to the End User 9
Safety Precautions 9
1.- INSTALLATION MANUAL 10
1.1.- Parts and Components 10
1.2.- Technical Data 11
1.3.- Installation & Set Up 12
2.- OPERATION MANUAL 13
2.1 Individual components 13
a.- Main Power 13
b.- Emergency Stop 13
c.- Touch Screen / Control 13
d.- Table Lift Operation. 14
e.- Panel Width Sensors 14
2.2.- Touch Screen 15
Main Menu 15
2.2.1 Edge Blade Setup & Adjustment Procedure 16
a.- Panel Cut Mode 18
b.- Border Cut Mode 23
c- Position Trim Blades 27
d- Maintenance Menu 30
e- Panel Cut Batch 34
g.- Select Cut length 38
h.- Sharpen Blades 39
i.- Timer settings menu 40
j.- Control Power Start 41
k.- POWER OFF / POWER ON 41
l.- Control power off 41
m.- Load Material in feed roller 41
2.3.- Operating 42

c.- Panel Cutting 43
d.- Border Cutting 43
2.4.- Maintenance 44
a.- Daily 44
b.- Weekly 44
c.- Monthly 44
3.- SERVICE MANUAL 45
1.- Pneumatic 45
1393E Panel Cutter Spare Parts Kit 46
XCut Drive Motor Parameters Menu (INV1) 48
Infeed Drive Motor Parameters Menu (INV2) 51
Assembly Drawings & Parts Lists 55
11393E PANEL CUTTER/SLITTER 57
1388232 SUB-FRAME ASSEMBLY 60
1393160 FRONT GUARD 62
1388303 BACK PANEL ELECTRICAL ASSEMBLY 64
1388415 SWIVEL ARM ASSEMBLY 66
1388549 SIDE DOOR ASSEMBLY, RH 67
1388559 DOOR STOP/BUMPER ASSEMBLY 68
1388594 BOTTON PANEL, ELEC, ASSEMBLY 69
1388650 PNEUMATIC ASSEMBLY 71
1388664 CROSS CUT ASSEMBLY 73
1389245 WINDER ASSEMBLY 75
1389258 PANEL TABLE ASSEMBLY 76
1389860 SLITTER ASSEMBLY, SPLIT SHAFT 77
1389896 SLITTER SHARPENER ASSEMBLY 78
1393-KIT06 WEIGHTED SLITTER BAR ASSEMBLY 79
1393310 TABLE STOP ASSEMBLY 80
1393312 LOCK PIN VALVE ASSEMBLY 81
1393360 TABLE PIVOT ASSEMBLY 82
1393394 KNIFE SHARPENER, REG. ASSEMBLY 83
1393676 ENCODER ASSEMBLY 84
1393770 REAR GUARD ASSEMBLY 85
1388233 FRAME ASSEMBLY 88
1388276 SLITTER, MOTOR DRIVE ASSEMBLY 89
1388317 TOP ROLLER ASSEMBLY 90
1388331 INFEED ROLL DRIVE ASSEMBLY 91

1388333 BORDER LIFT ROLL ASSEMBLY 92
1388337 OUTFEED MOTOR DRIVE ASSEMBLY 93
1388347 XCUT CLAMP ASSEMBLY 94
1388351 PANEL CUTTER LEG ASSEMBLY 95
1393029 SLITTER SHARPENER ASSEMBLY 98
1393058 CRADLE ASSEMBLY 99
1393301 TABLE LOCKING ASSEMBLY 100
1393125 EYE ADJUSTMENT ASSEMBLY 101
1393149 BSW SLITTER ASSEMBLY 102
1389884 SHARPENER ASSEMBLY, SLITTERS 103
1388385 SIDE TRIM RAIL ASSEMBLY 105
1388530 CUT TABLE ASSEMBLY 107
1388665 XCUT ASSEMBLY, 1393E 109
1388571 DANCER FRAME ASSEMBLY 110
1388391 GEAR PULLEY, EDGE TRIM, ASSEMBLY 111
1388589 EDGE TRIM SENSOR ASSEMBLY 112
1388671 UNFEED SENSOR ASSEMBLY 113
1388490 XCUT SENSOR ASSEMBLY 114
1388541 XCUT DRIVER IDLER PULLEY ASSEMBLY 115
1388542 XCUT DRIVE BELT IDLER ASSEMBLY 116
1388666 CROSS CUT MOTOR DRIVE ASSEMBLY 117
1393E-PD1 PNEUMATIC DIAGRAM 118
1393E-WD1 WIRING DIAGRAM, PAGE 1 119
1393E-WD2, WIRING DIAGRAM, PAGE 2 120
1393E-WD3, WIRING DIAGRAM, PAGE 3 121
1393E-WD4, WIRING DIAGRAM, PAGE 4 122
1393E-WD5, WIRING DIAGRAM, PAGE 5 123
1393E-WD6, WIRING DIAGRAM, PAGE 6 124
1393E-WD7, WIRING DIAGRAM, PAGE 7 125
1393E-WD8, WIRING DIAGRAM, PAGE 8 126
1393E-WD9, WIRING DIAGRAM, PAGE 9 127
1393E-WD10, WIRING DIAGRAM, PAGE 10-1 128
1393E-WD10, WIRING DIAGRAM, PAGE 10-2 129
1393E-WD10, WIRING DIAGRAM, PAGE 10-3 130
1393E-WD10, WIRING DIAGRAM, PAGE 10-4 131
1393E-WD10, WIRING DIAGRAM, PAGE 10-5 132
1393E-WD10, WIRING DIAGRAM, PAGE 10-6 133

1393E-WD10, WIRING DIAGRAM, PAGE 10-7 134
1393E-WD10, WIRING DIAGRAM, PAGE 10-8 135
1393E-WD10, WIRING DIAGRAM, PAGE 10-9 136

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 1393E Panel Cutter 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.

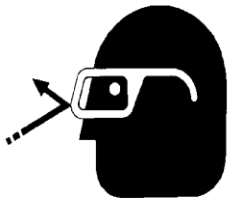
Faults or Errors

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.

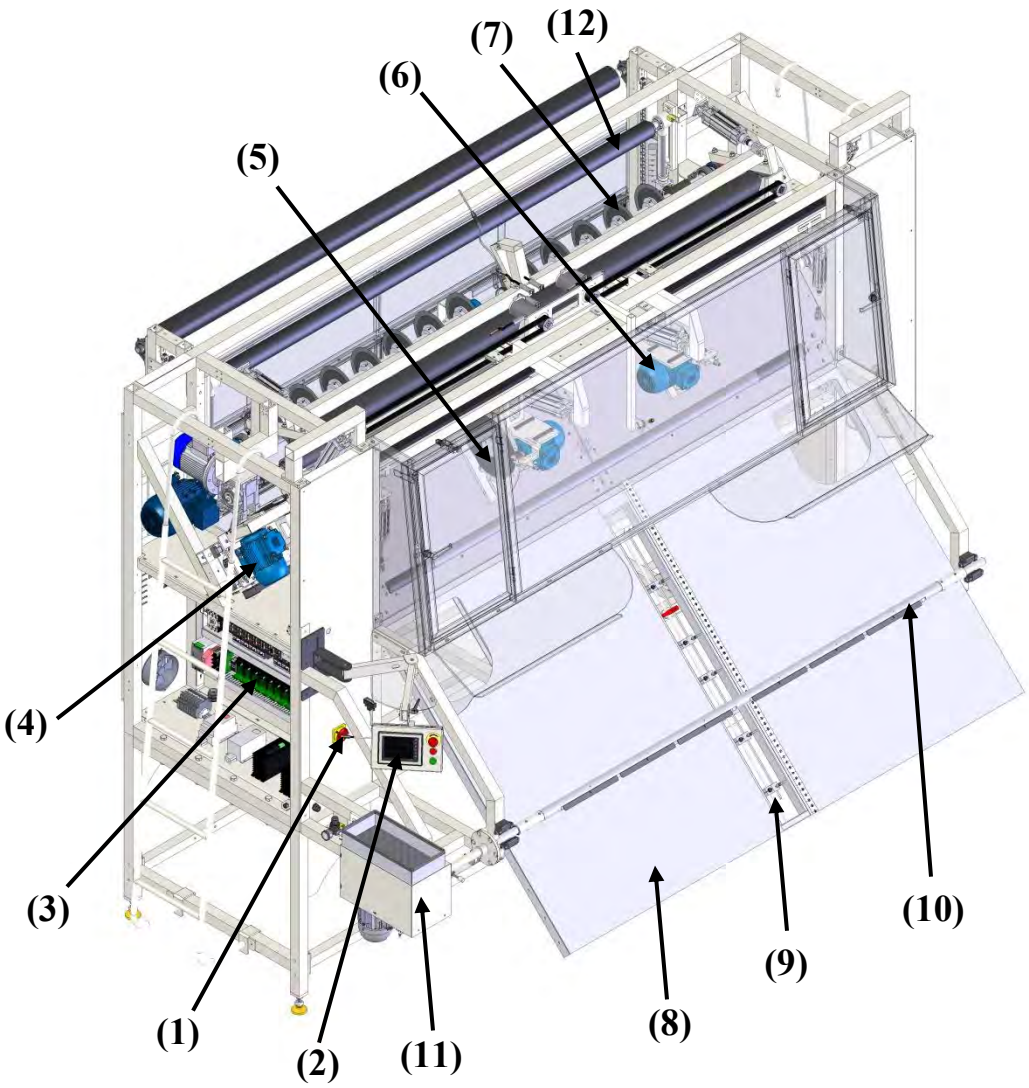
Specific safety warning decals are located on the equipment near the immediate areas of potential hazards. These decals should not be removed or obliterated. Replace them if they become non-readable.

- 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

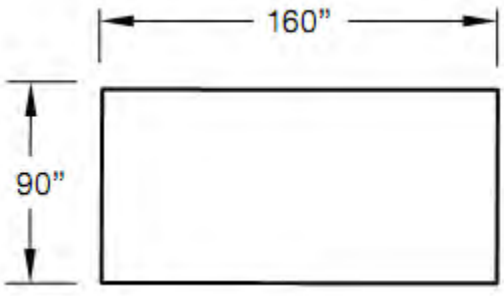


1.- Main Power
2.- Touch Screen
3.- Control Panel
4.- Cross cut
5.- Right Edge cut
6.- Left Edge cut
7.- Slitter knife
8.- Panel Table
9.- Width Sensors
10.- Drive Rod
11.- Winder
12.- Border Roll

1.2.- Technical Data

SPECIFICATIONS	
Max cutting thickness (inch)	1 1/2" (Compressed)
Min cutting thickness (inch)	1/4"
Max cutting width (inch)	102
Min cutting width (inch)	47 3/4
Max length (inch)	84
Min length (inch)	28 1/2
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

PRODUCTION	
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.- Install the front safety guard shield onto the frame.

8.- Install the left and right protective shield onto the frame.

9.- Adjust all rollers to be sure the midlines of them are parallel.

10.- Connect power source and compressed air.

11.- Provide a 220VAC, Three phase, 20 Amp

12.- Provide 3/8" air supply line (90 PSI).

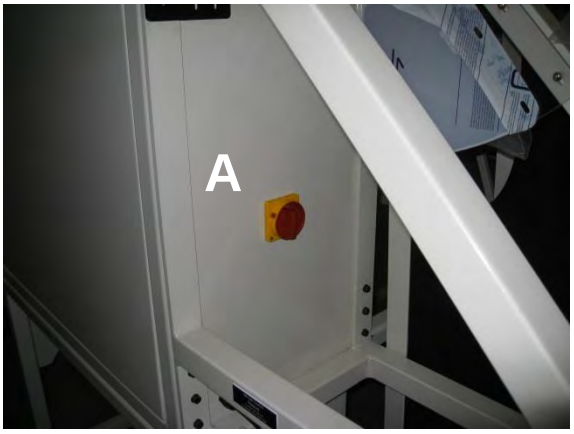
2.- OPERATION MANUAL

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

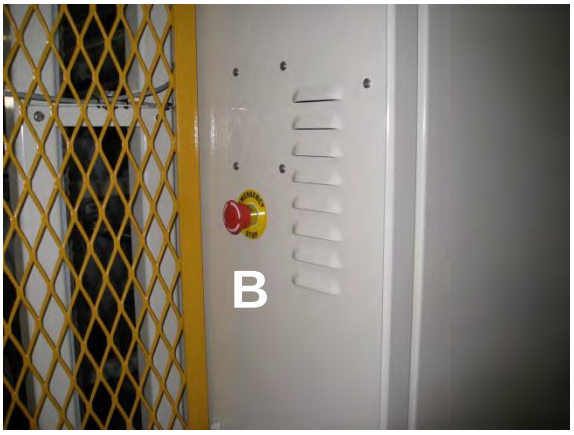
a.- Main Power

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)

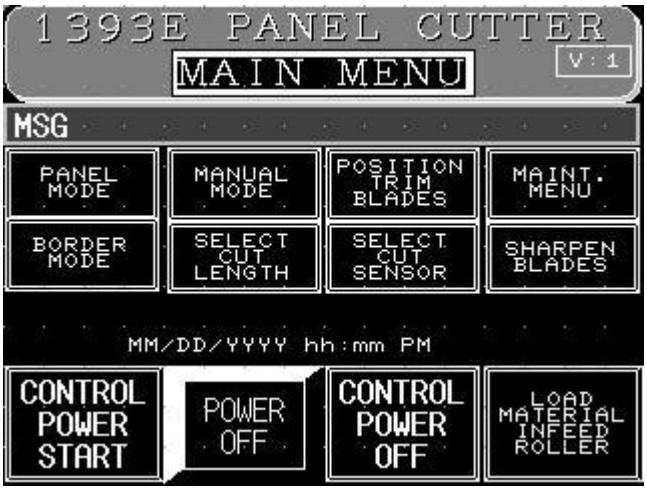
d.- Table Lift Operation.

This allows the operator to select the position of the out-feed table. If "Table Lift Up" is selected, the table will lift and lock in place for cutting panels. If "Table Lift Down" is selected, the table will lower to allow the windup roller to be used to wind up material. This option is available on 3 different menu screens. (Panel Mode, Border Mode, & Maint. Menus)

e.- Panel Width Sensors

These sensors are what determine the width of the panel being cut. The top sensor is for Twins, the 2nd for Fulls, The 3rd for Queens, The 4th for Cal Kings, and the bottom for Kings. These sensors are only active when in the Panel mode with the table in the UP position. The scale next to the sensors is the actual width of the panel being cut. When switching to a different thickness of panel the widths can be adjusted by moving the lever at the right of the table.

2.2.- Touch Screen



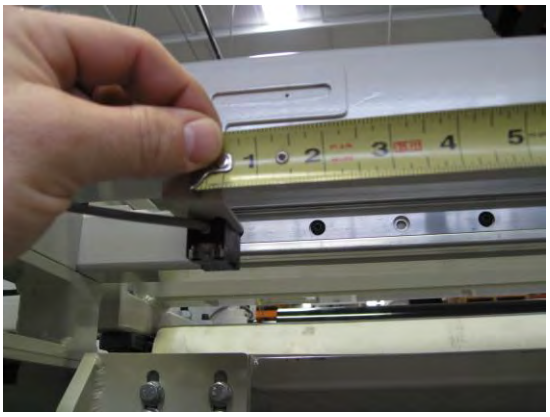
Main Menu

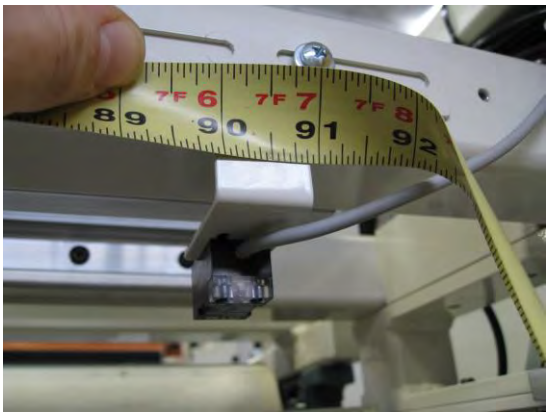
This menu is displayed at the startup of the machine. Press any of the frames in the screen and you will be transfer to the following sub-menu

- PANEL MODE
- BORDER MODE
- MANUAL MODE
- SELECT CUT LENGTH
- POSITION TRIM BLADES
- SELECT CUT SENSOR
- MAINTENANCE MENU
- SHARPEN BLADES
- CONTROL POWER START
- POWER ON/OFF INDICATOR
- CONTROL POWER OFF
- LOAD MATERIAL IN FEED ROLLER

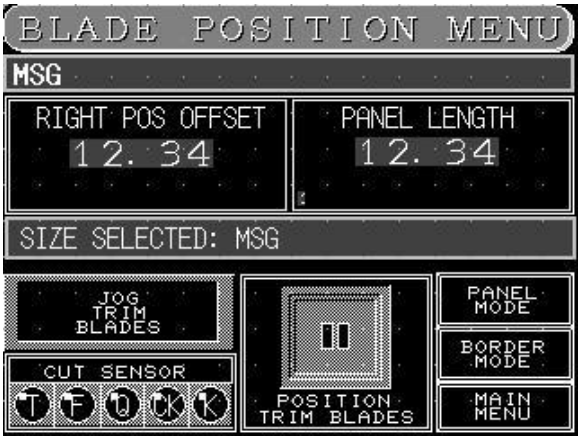
2.2.1 Edge Blade Setup & Adjustment Procedure

1) Set the center distance between the LEFT and RIGHT edge trim blade home position proximity switches to 90.5” (2300mm)



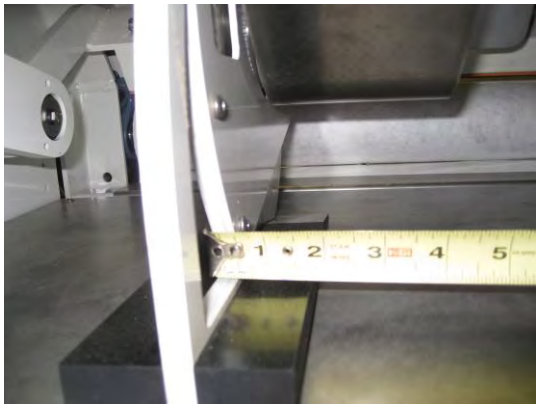


2) On the touchscreen menu……Select Blade Position. Set a Left Offset value to 5.00” (127mm) and Cut Length value to 85.00” (2159mm).



3) Press the Blade Position button. As soon as the edge trim blades are at the LEFT and RIGHT home position proximity switches press the E-Stop button. YOU WILL HAVE ONLY A FEW SECONDS TO HIT THE E-STOP. If the trim blades come off the proximity switches, then retry again.

4) Assuming Step 3 was completed correctly, measure the center distance (blade to blade) between the blades. It should measure 90.5” (2300mm).



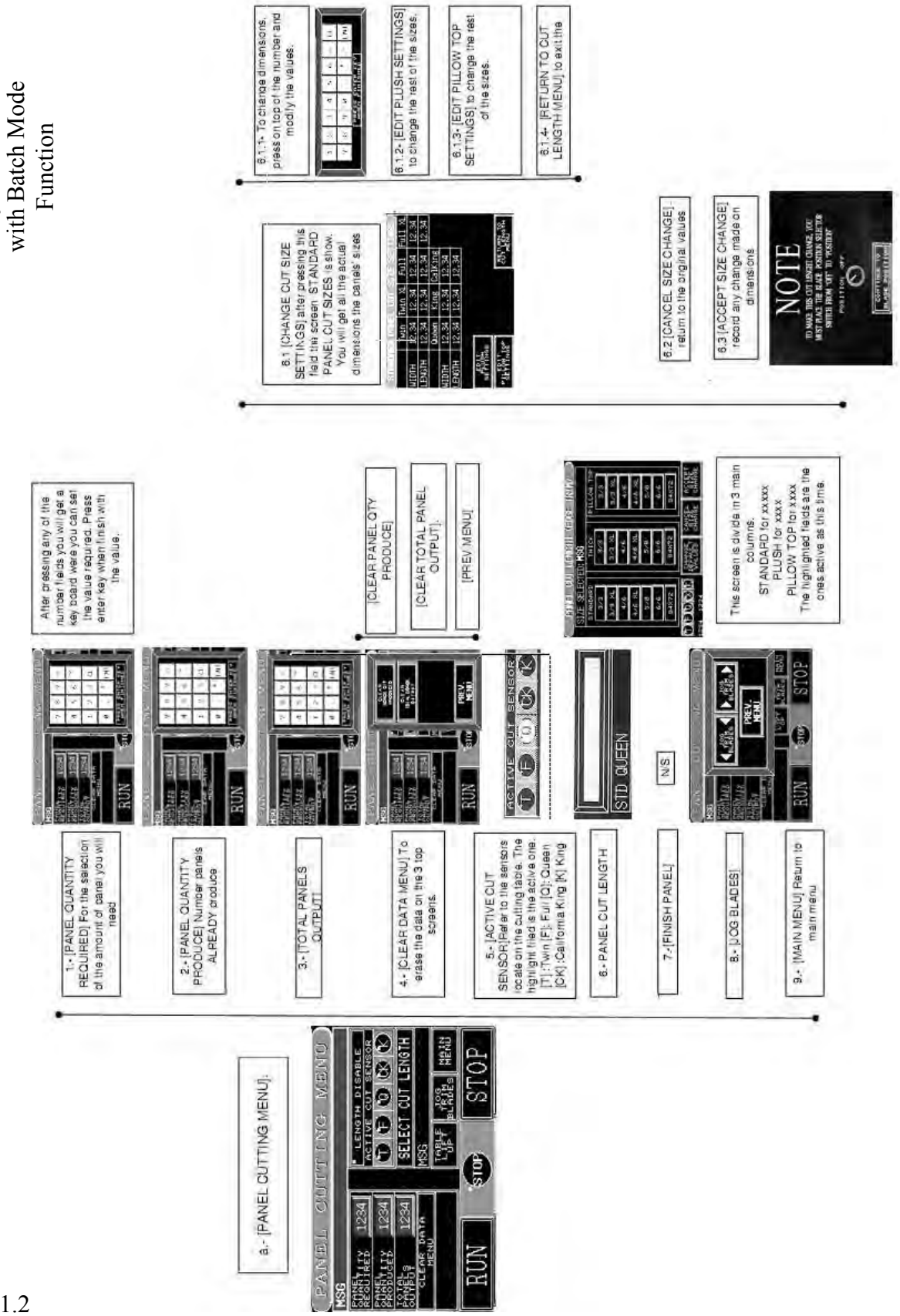
5) If the distance between the blades is not 90.5” (2300mm) recheck the center distance between the home left and right home position proximity switches. Move the proximity target / flag on each edge trim blade in the direction needed to get 90.5” (2300mm) and repeat Steps 3 & 5 until the distance between the blades measure 90.5” (2300mm).

6) Once Step 5 is completed, return to the Blade Position menu and confirm your settings from Step 2 are still 5.00” (127mm) and 85.0” (2159mm).
If these values have changed please reset to 5.00” (127mm) and 85.0” (2300mm).

7) Press the Blade Position button and measure the distance between the blades to confirm a cut length of 85.0” (2159mm). If they are off, adjust the edge trim proximity target / flag and repeat Step 7 again.

a.- Panel Cut Mode

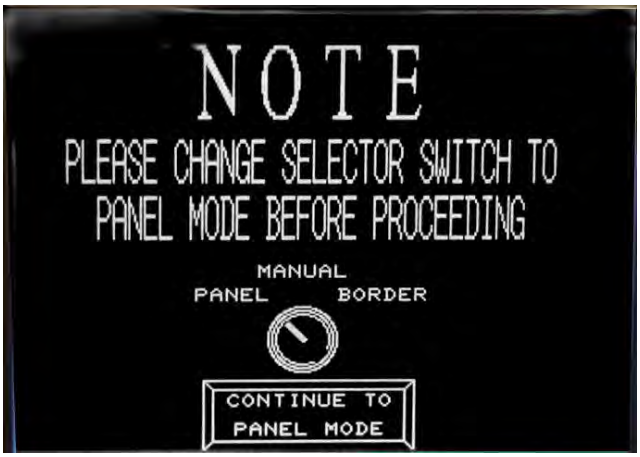
Only on machine
with Batch Mode
Function



cuchCC6.1.2

Starting at Main Menu

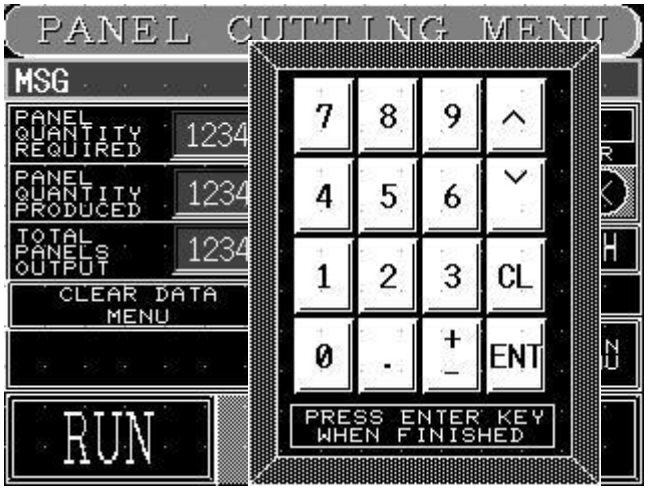
- Select **PANEL CUT MODE** from the Main Menu screen
- You will get a NOTE Screen
- Manually change the position of the Selector to PANEL
- Press **CONTINUE TO PANEL MODE**



PANEL CUTTING MENU:

1.- PANEL QUANTITY REQUIRED
Enter the number of panels to cut. Machine will stop automatically when that number is reached.

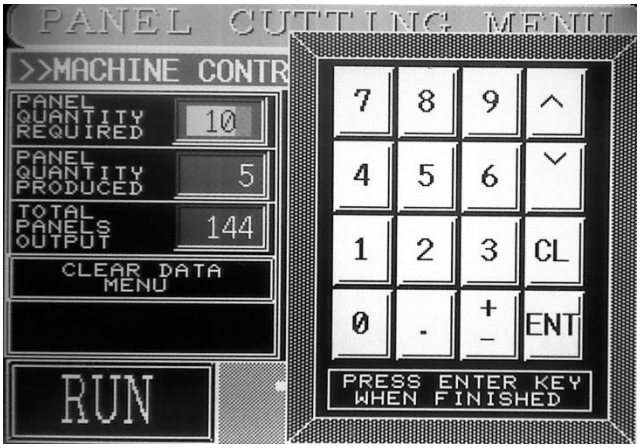
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



2.- PANEL QUANTITY PRODUCED

The number of panels ALREADY produced since that number was last cleared.

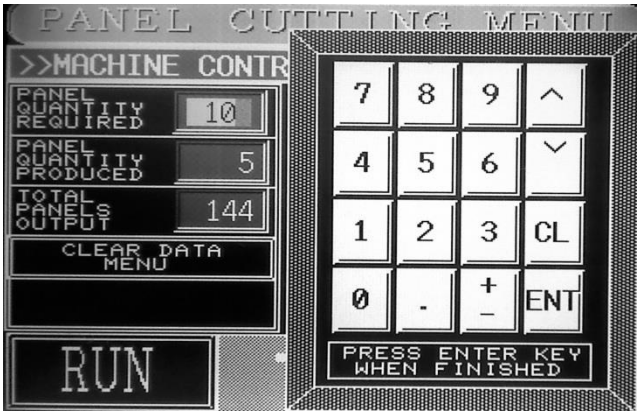
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



3. TOTAL PANELS OUTPUT

The number of panels produced since the total output number was last cleared.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



4. CLEAR DATA MENU

To erase the data on the 3 top screens.

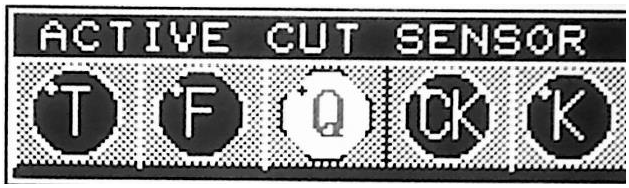
You will get 3 options:

- CLEAR PANEL QTY PRODUCED
- CLEAR TOTAL PANEL OUTPUT
- PREV MENU

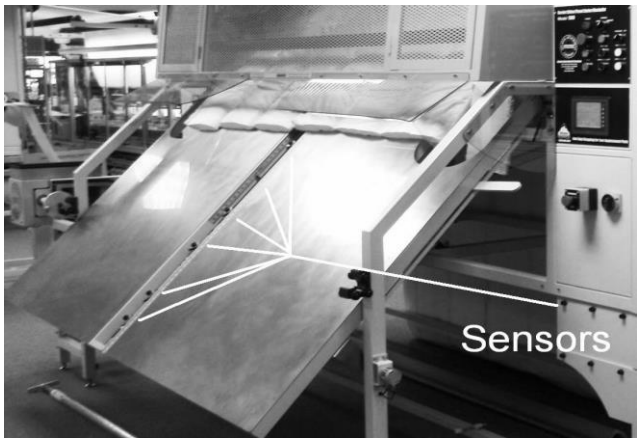
5. ACTIVE CUT SENSOR

Refers to the sensors located on the cutting table. The highlighted field is the active one.

[T]: Twin [F]: Full [Q]: Queen [CK]: California King [K] King



Location of the sensors on the panel table.



After pressing the blank space you will get the

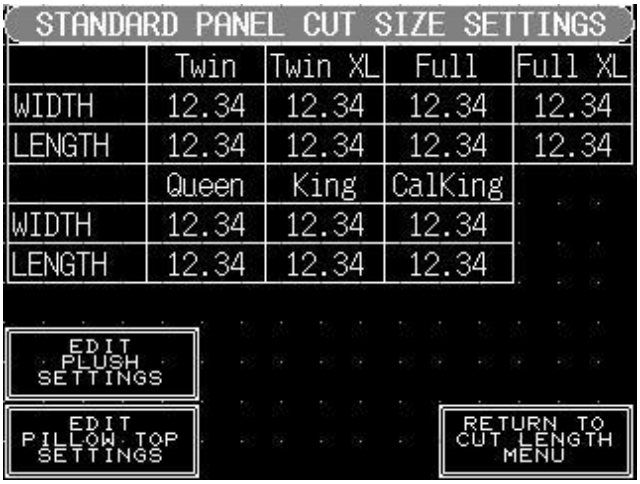
6. PANEL CUT LENGTH screen

This screen is divided in 3 main columns.

- STANDARD for normal thickness.
- PLUSH for thick panels.
- PILLOW TOP for extra thick panels.

The highlighted fields are the ones active as this time.

6.1 CHANGE CUT SIZE SETTINGS after pressing this field the screen STANDARD PANEL CUT SIZES is shown. You will get all the actual dimensions of the panels' cut sizes.



6.1.1- To change dimensions, press on top of the number and modify the values

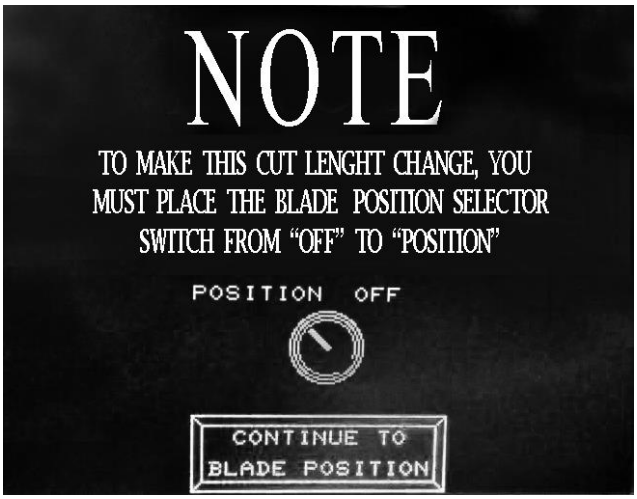
6.1.2- **EDIT PLUSH SETTINGS** to change the rest of the sizes.

6.1.3- **EDIT PILLOW TOP SETTINGS** to change the rest of the sizes.

6.14.- **RETURN TO CUT LENGTH MENU** to exit the screen

6.2 CANCEL SIZE CHANGE return to the original values.

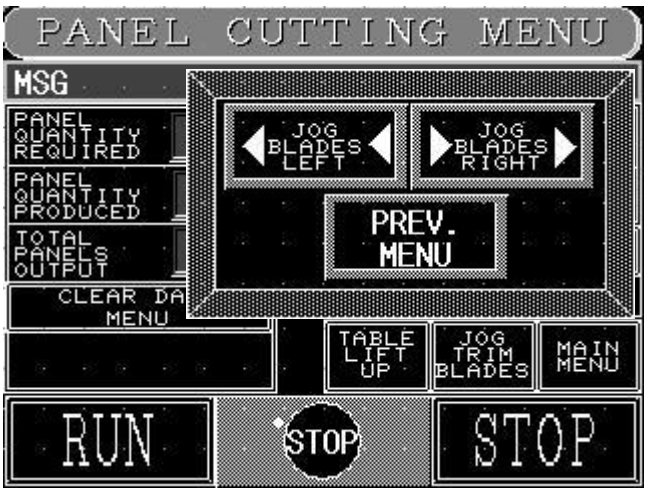
6.3 ACCEPT SIZE CHANGE record any change made on dimensions



7.- FINISH PANEL allows operator to finish the panel that is presently in the machine.

8.- JOG BLADE allows the operator to jog both side trim blades equally in either direction to allow for shifting of the quilted material without changing the dimension.

9.- MAIN MENU Return to main menu



b.- Border Cut Mode

b.- [BORDER CUT MODE]

1.-[BORDER YARDAGE REQUIRED] pressing the number field you will get a keyboard were you can change the numbers of pieces to be produce

2.- [CURRENT YARDAGE OUPUT]

3.- [COMBINED YARDAGE OUTPUT]

4.- [CLEAR DATA MENU]

5- [ENTER "I" TO DISABLE ENCODER]

6.- [BLADE ADJUST START]

7.- [BLADE ADJUST FINISH] — Blink

8.- [TABLE LIFT DOWN]

9.- [SLITTERS DISABLE] — Blink

10.- [WINDER DISABLE] — Blink

11.- [TRIM BLADES HOME] — N/S

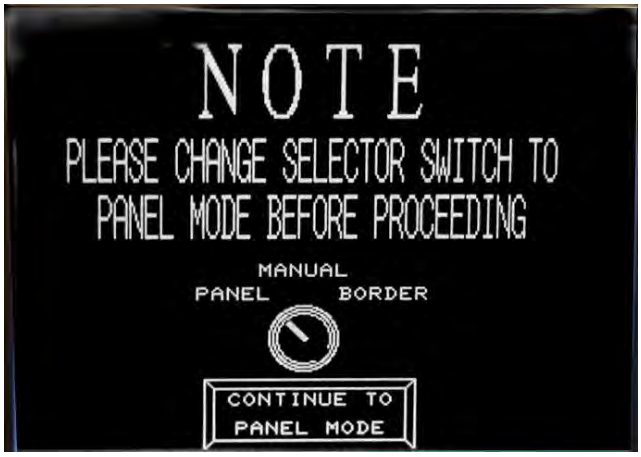
12- [MAIN MENU] Return to Main Menu

13.- [RUN]

14.- [STOP]

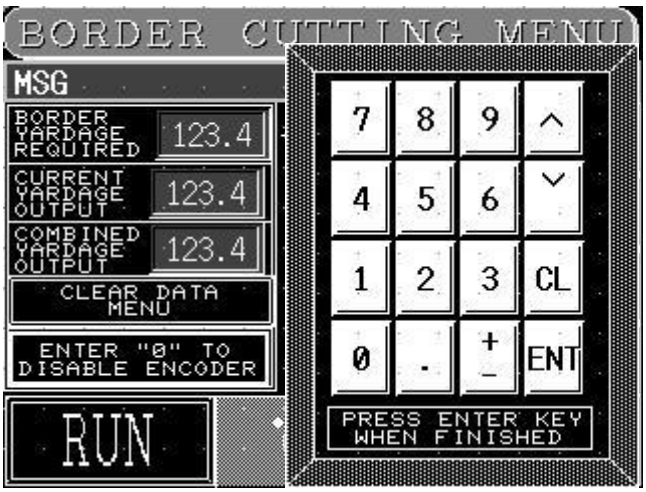
Starting at Main Menu

- Select **BORDER CUT MODE** from the Main Menu screen
- You will get a NOTE Screen
- Manually change the position of the Selector to BORDER
- Press **CONTINUE TO BORDER MODE**



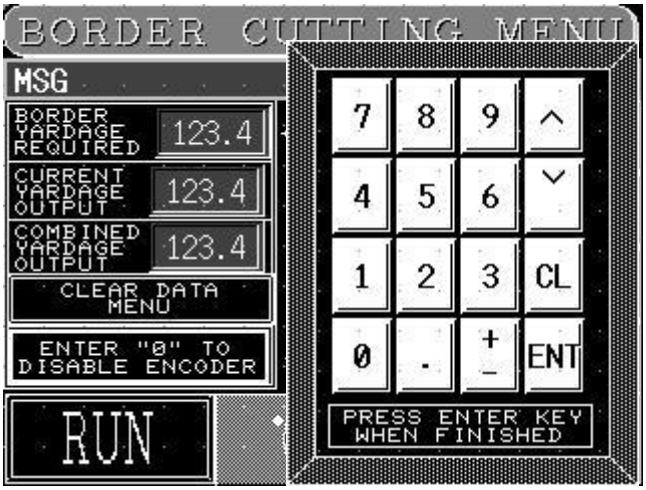
After pressing **BORDER CUT MODE** from the MAIN MENU you will arrive to the **BORDER CUTTING MENU**

1. - **BORDER QUANTITY SET** pressing the number field you will get a keyboard were you can change the numbers of pieces to be produced. It is important to note that the machine will do a cross cut at the desired length of border. To deactivate the measuring function set the quantity to zero.



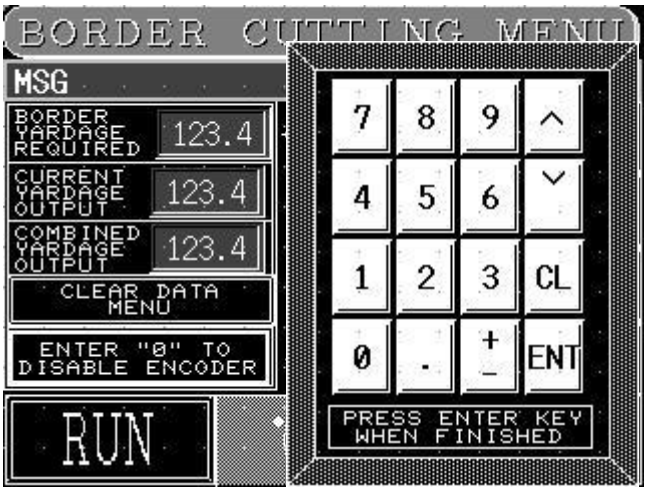
2.- BORDER QUANTITY PRODUCED
This is the number of preselected border lengths produced since this value was last cleared.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



3- TOTAL BORDER OUTPUT
This is the total number of border lengths produced since this value was last cleared.

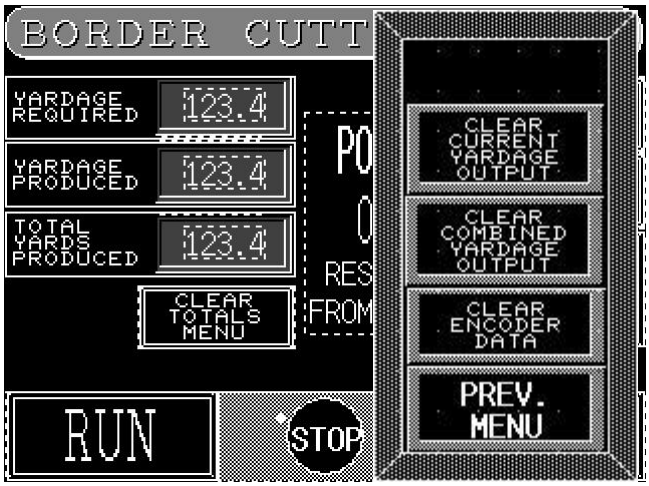
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



4- CLEAR DATA MENU
To erase the data on the 3 top screens.

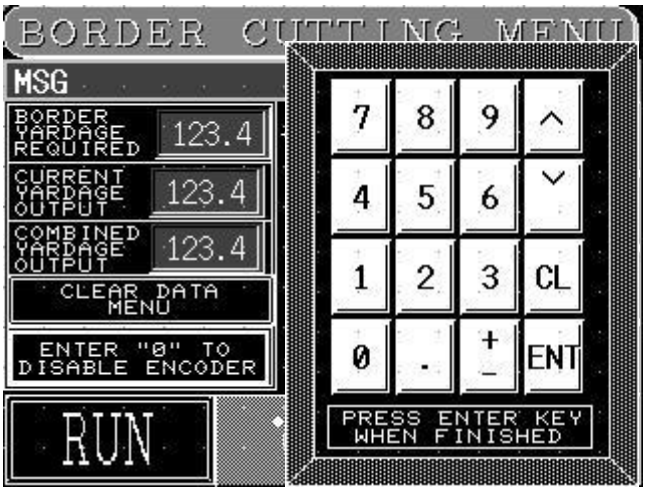
You will get 4 options:

- CLEAR BORDER QTY PRODUCED.
- CLEAR TOTAL BORDER OUTPUT.
- CLEAR ENCODER.
- PREV. MENU.



5- BORDER CUT LENGTH
This is to set the length of border to be produced. When this length is reached the border will be cross cut. The units are in inches.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



6- BLADE ADJUST START
When you press this button it will start blinking and 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.

7- 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.

8- SLITTERS DISABLE
When this button is pressed the IN-FEED guide roller will lift to prevent the border from coming in contact with the slitters. This is useful if rolling border to be slit at a later date.

9- WINDER DISABLE
When this button is pressed the winder will be disabled. This is useful if slitting border into a box rather than winding it on a roll.

10- BORDER LENGTH SINCE LAST CUT
The distance in inches since the cross cut was last activated.

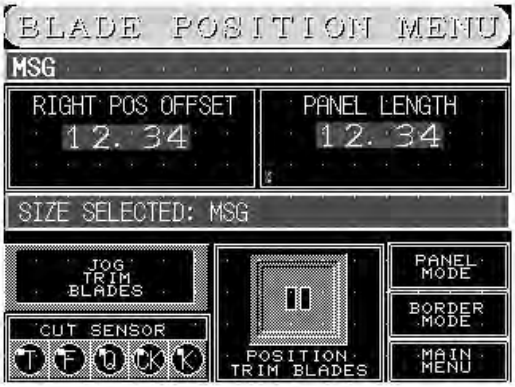
11- MAIN MENU Return to Main Menu

12- RUN Machine will start running on this mode

13- STOP Machine will Stop

c- Position Trim Blades

c.- [POSITION TRIM BLADES]



1.- RIGHT POS OFFSET

2.- PANEL LENGTH

3.- SIZE SELECT

4.- CUT WIDTH

N/S

5.- CUT SENSOR. Press Letter and size will be highlighted

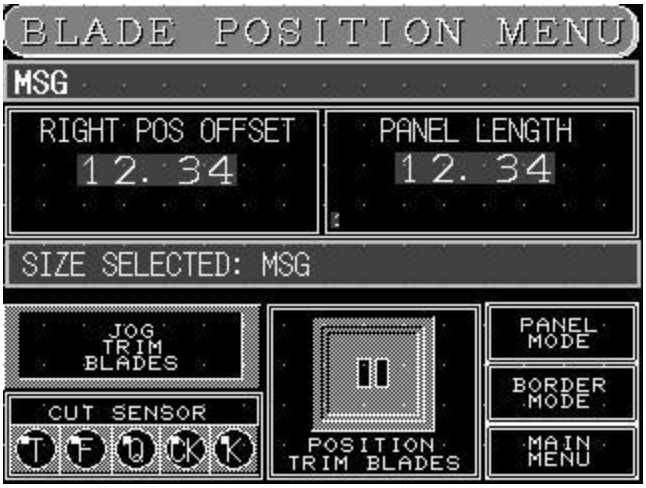
6.- POSITION TRIM BLADES

7.- CONTROL POWER START

8.- MAIN MENU

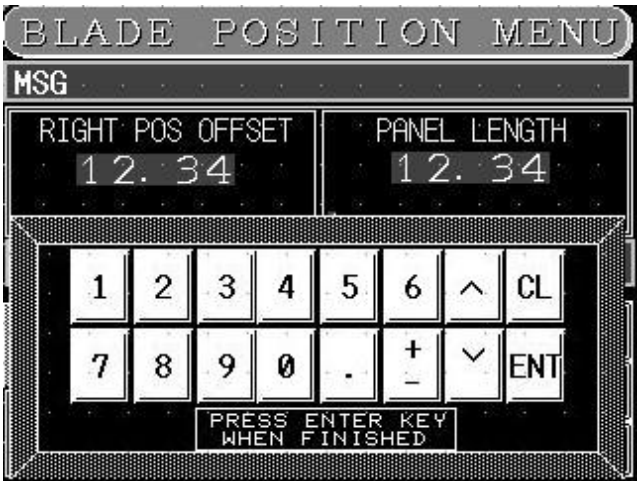
Starting at Main Menu

Press **POSITION TRIM BLADES**
you will get the **BLADE POSITION MENU** screen.



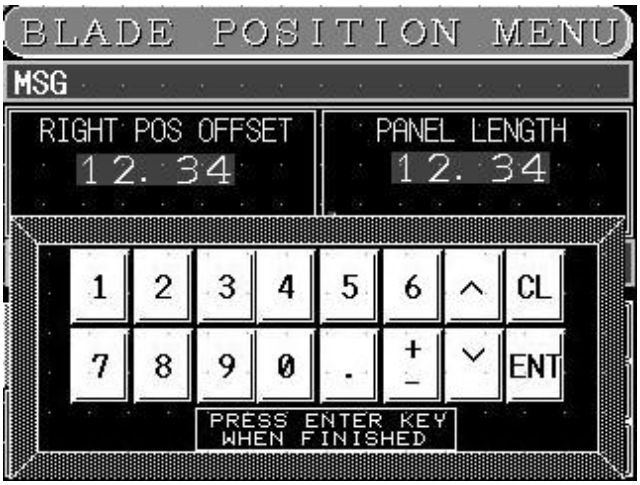
1.- RIGHT POSITION OFFSET
This sets the distance from the right side (near the touch screen) that the trim knife will be set.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.

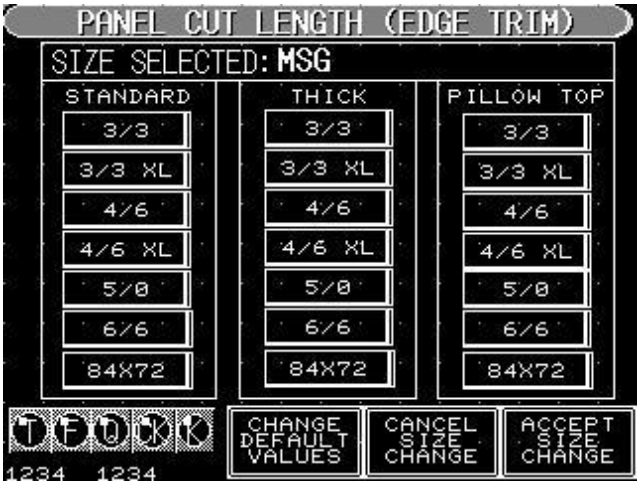


2.- PANEL LENGTH
This sets the actual length of the panel to be cut (the distance between the two trim knives)

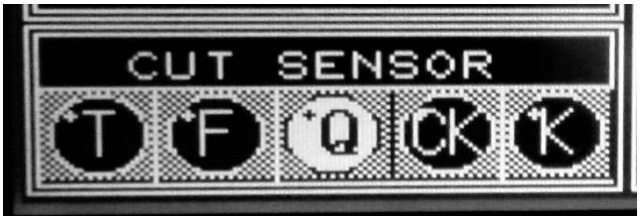
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



3.- SIZE SELECT.
This is useful to select a preset cut setting for a desired panel length.



4.- CUT WIDTH Show the value of the actual cut width according to the width sensor selected.



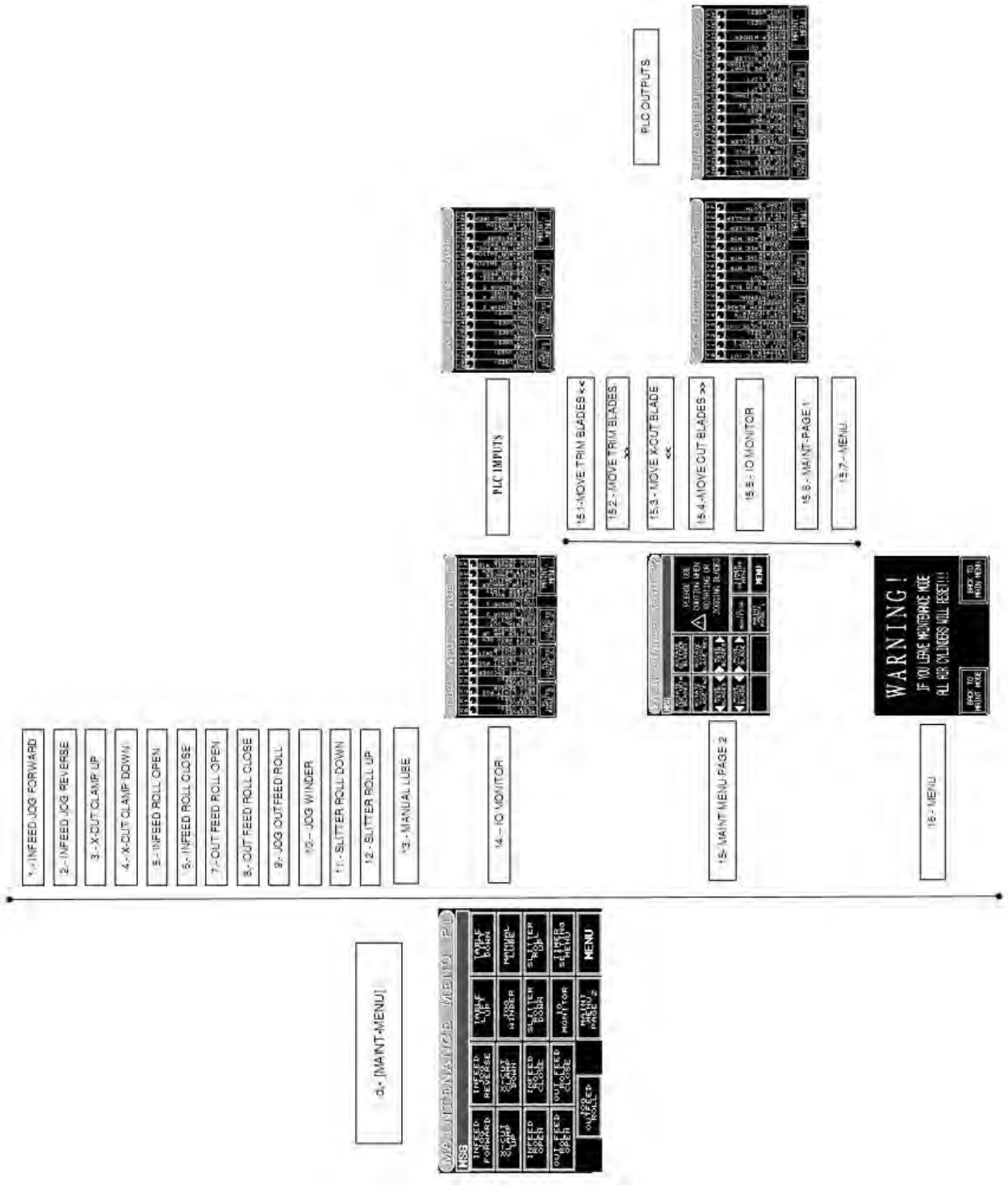
5.- CUT SENSOR Press Letter and size will be highlighted

6.- POSITION TRIM BLADES
When the desired changes have been entered move the "Position/Off" selector on the panel to "Position" and push "Position Trim Blades". The blades will now readjust to the new setting.

7.- CONTROL POWER START
If the power was shut off for whatever reasons this will need to be pressed to restore control panel power.

8.- MAIN MENU Return to main Menu.

d- Maintenance Menu



Technical Manual & Part List

Starting at Main Menu

Press **MAINT. MENU**
you will get the MAINTENANCE MENU P1 screen.

1.- IN-FEED JOG FORWARD The main rollers will turn in the direction to advance material.

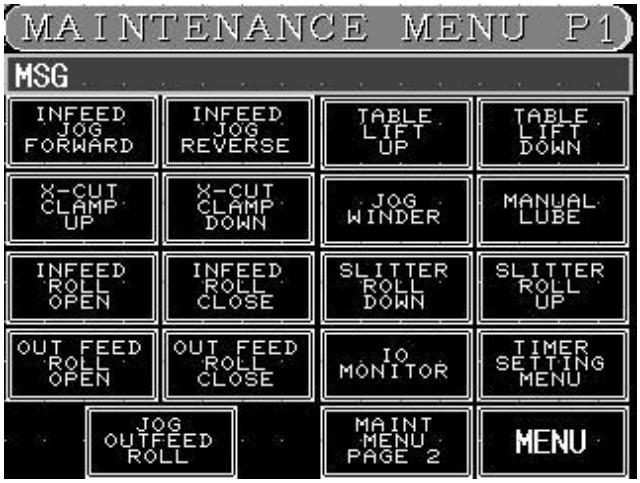
2.- IN-FEED JOG REVERSE The main rollers will turn in the direction to reverse the material

3.- X-CUT CLAMP UP The crosscut clamp bar will rise.

4.- X-CUT CLAMP DOWN The crosscut clamp bar will lower.

5.- IN-FEED ROLL OPEN The main IN-FEED pressure rollers will open.

6.-IN-FEED ROLL CLOSE The main IN-FEED pressure rollers will close



7.- OUT FEED ROLL OPEN The pressure roller at the back of the machine will rise.

8.- OUT FEED ROLL CLOSE The pressure roller at the back of machine will drop.

9.- JOG OUT FEED ROLL The lower OUT FEED roller will turn in the normal direction of movement.

10.- JOG WINDER The windup roller motor will activate.

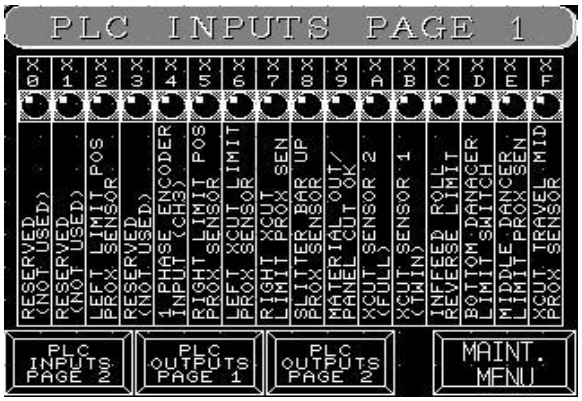
11.- SLITTER ROLL DOWN The slitter bypass roller will lower.

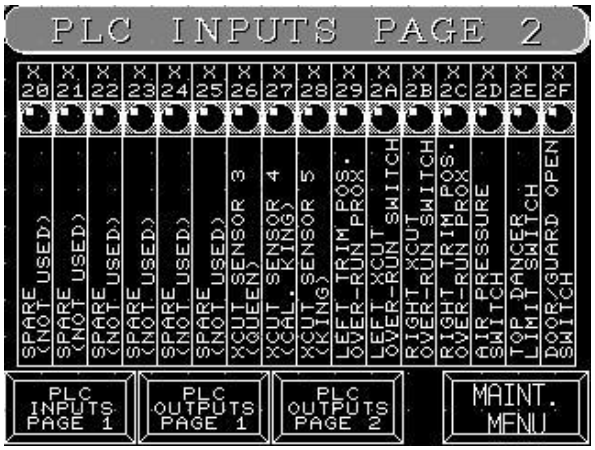
12.- SLITTER ROLL UP The slitter bypass roller will lift.

13.- MANUAL LUBE The automatic lubrication cycle will activate momentarily.

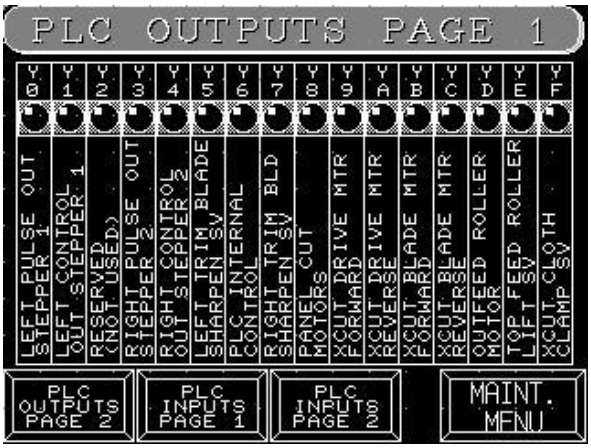
14.- IO MONITOR Has two pages, INPUTS and OUTPUTS from the PLC.

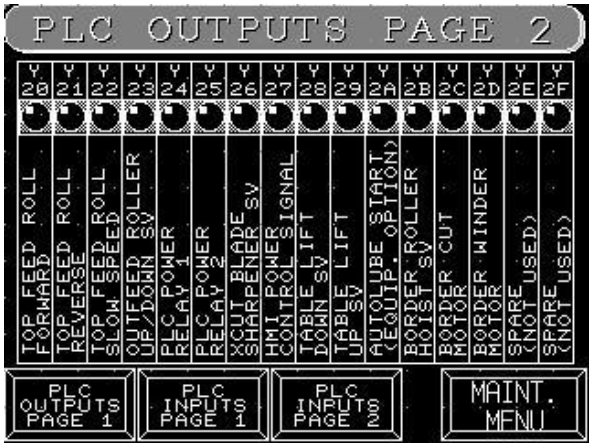
14.1 - PLC INPUTS



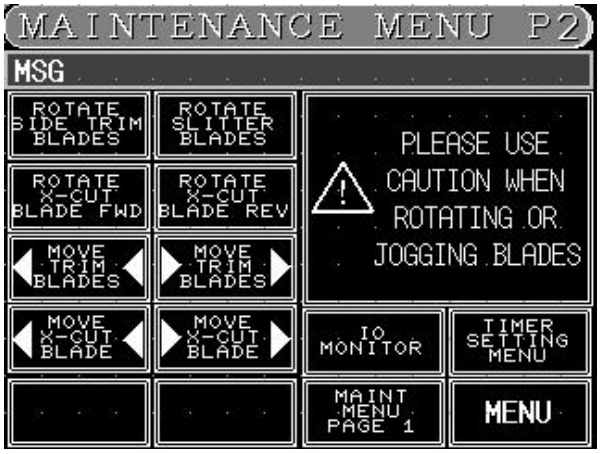


14.2 – PLC OUPUTS





15- MAINT MENU PAGE 2



15.1-ROTATE SIDE TRIM BLADES

15.2-ROTATE SLITTER BLADES

15.3-ROTATE X-CUT BLADES FORWARD

15.4-ROTATE X-CUT BLADES REVERSE

15.5-MOVE TRIM BLADES LEFT

15.6-MOVE TRIM BLADES RIGHT

15.7-MOVE X-CUT BLADE LEFT

15.8-MOVE X-CUT BLADE RIGHT

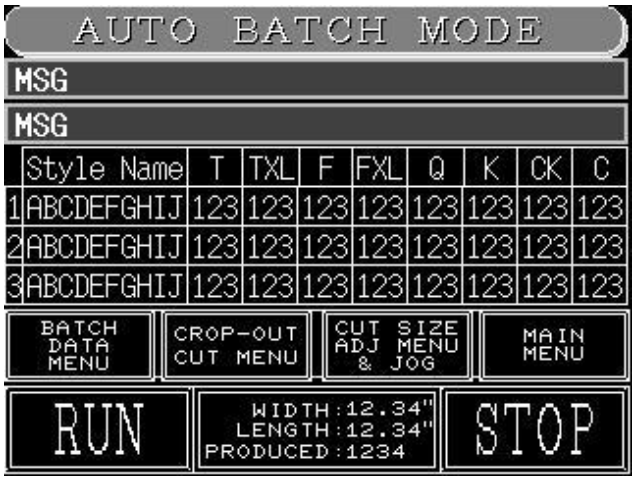
15.9-IO MONITOR

16.0-TIMER SETTING MENU

16.1-MAINT. MENU PAGE 1

16.2-MENU (Return to the Main Menu)

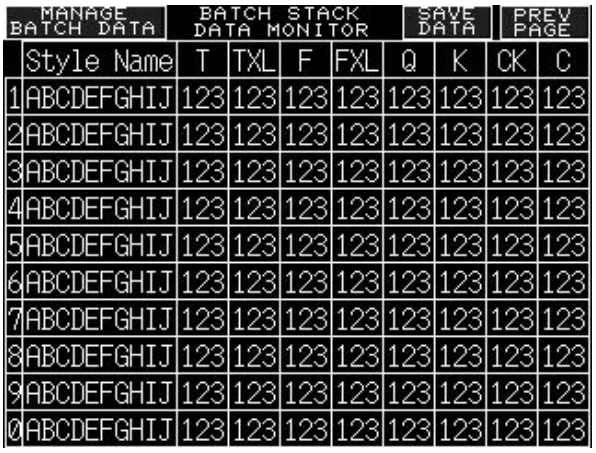
e- Panel Cut Batch



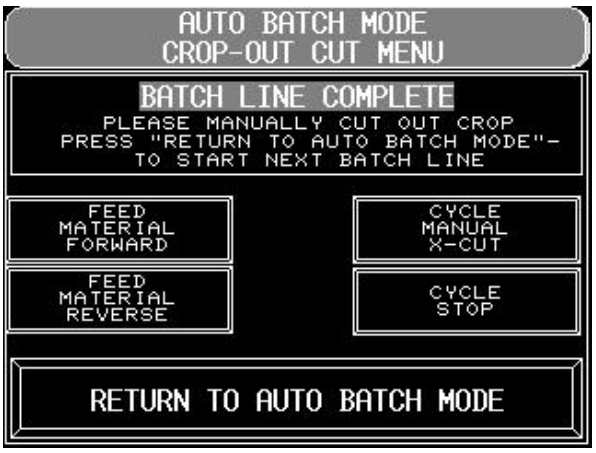
1- NUMBER FIELDS

2- BATCH DATA MENU

2.1 VIEW DATA MENU



3.- CROP-OUT CUT MENU



4.- CUT SIZE ADJUST MENU

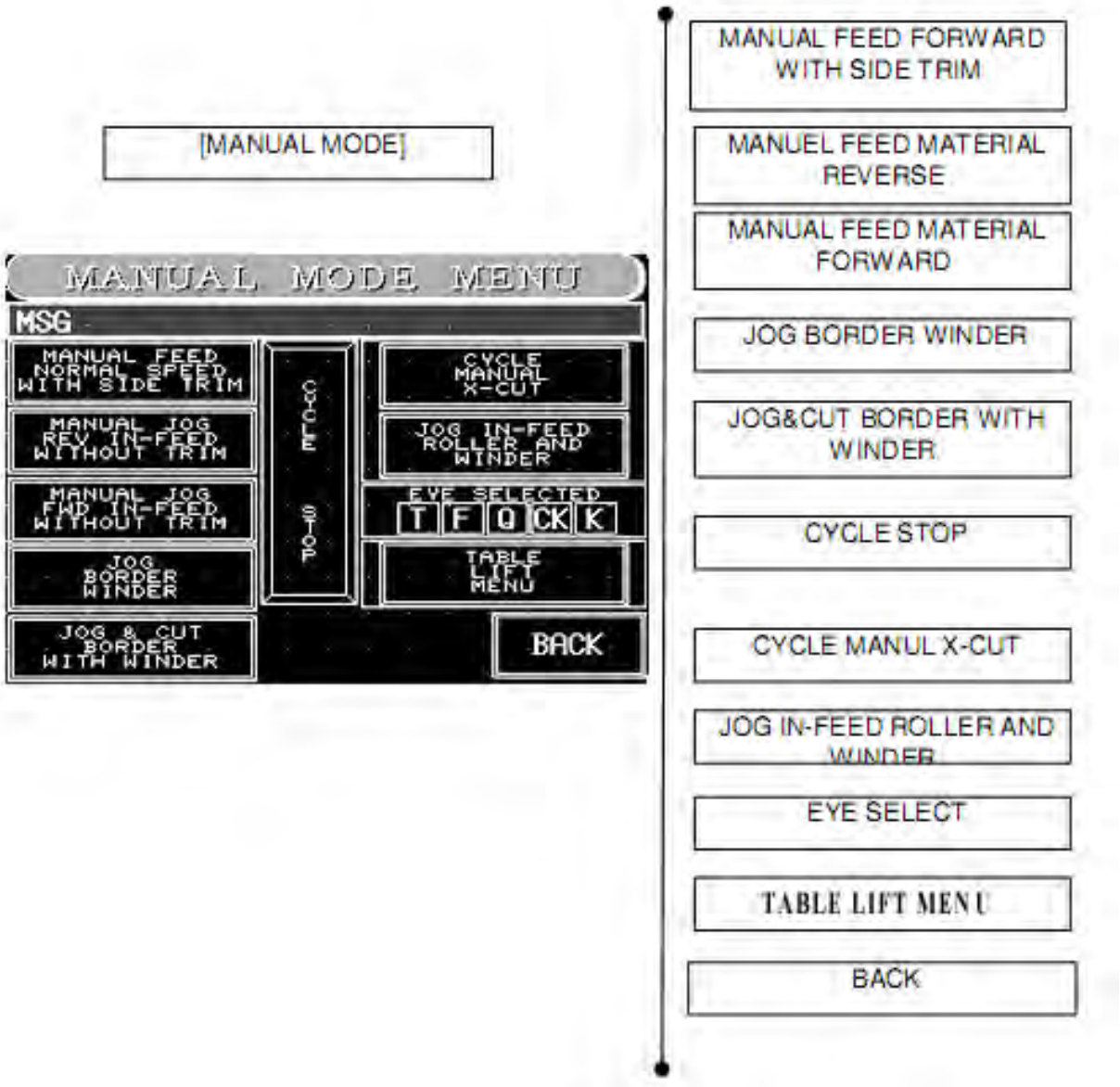
5.- MAIN MENU

6.- RUN

7.- WITH : LENGTH : PRODUCE

8.- STOP

f.- Manual Mode



1.- MANUAL FEED FORWARD WITH SIDE TRIM Will advance material while side trimming.

2.- MANUAL FEED MATERIAL REVERSE Will reverse material with side trim knives not running.

3.- MANUAL FEED MATERIAL FORWARD Will advance material without side trimming.

4.- JOG BORDER WINDER The border winder motor will turn.

5.- JOG &CUT BORDER WITH WINDER The material will feed and side trim with winder motor turning.

6.- CYCLE STOP Interrupt selected cycle.

7.- CYCLE MANUAL X-CUT Performs one cross cut cycle.

8.- JOG IN-FEED ROLLER AND WINDER Will advance material without trimming while the windup motor turns.

9.- EYE SELECTED Shows which cut sensor is active.

10.- CUT SENSOR DISABLE Disables cut sensor.

11.- BACK Return to previous screen

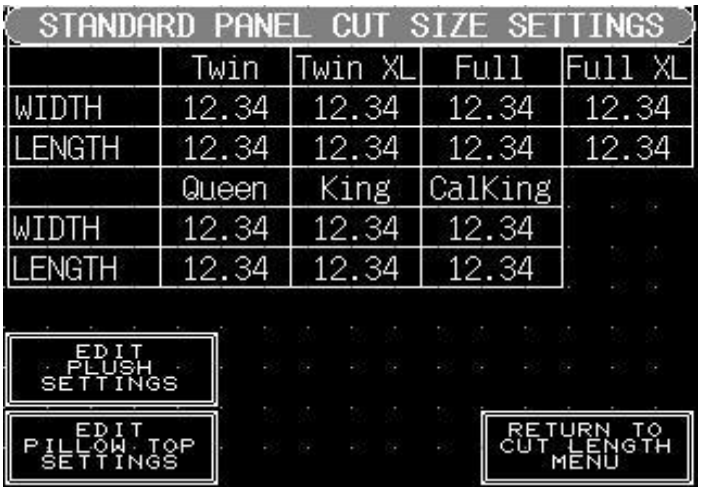
g.- Select Cut length

This screen is divided in 3 main columns.

- STANDARD for normal thickness
- PLUSH for thick panels
- PILLOW TOP for extra thick

The highlighted fields are the ones active as this time

1.- CHANGE CUT SIZE SETTINGS after pressing this field the screen STANDARD PANEL CUT SIZES is shown. You will get all the actual dimensions the panels' sizes



To change dimensions, press on top of the number and modify the values.

1.1.- EDIT PLUSH SETTINGS To change the rest of the sizes

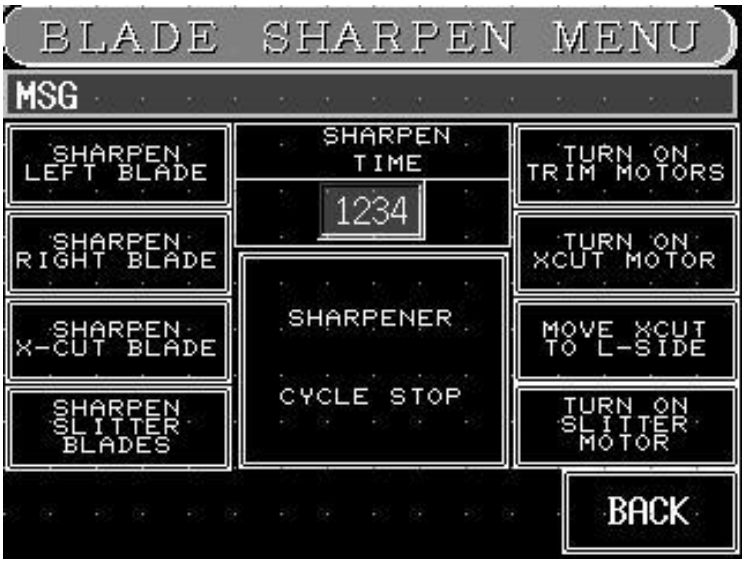
1.2.- EDIT PILLOW TOP SETTINGS to change the rest of the sizes.

1.3.- RETURN TO CUT LENGTH MENU to exit the screen

2.- CANCEL SIZE CHANGE . Return to the original values without accepting the changes.

3.- ACCEPT SIZE CHANGE record any change made in dimensions

h.- Sharpen Blades



1.- SHARPEN LEFT BLADE – This will turn on the left trim knife motor and activate the sharpener for the predetermined time.

2.- SHARPEN RIGHT BLADE – This will turn on the right trim knife motor and activate the sharpener for the predetermined time.

3.- SHARPEN X-CUT BLADE

4.- SHARPEN SLITTER BLADE

5.- SHARPEN TIME

6.- SHARPEN CYCLE STOP

7.- TURN ON TRIM MOTORS

8.- TURN ON XCUT MOTOR

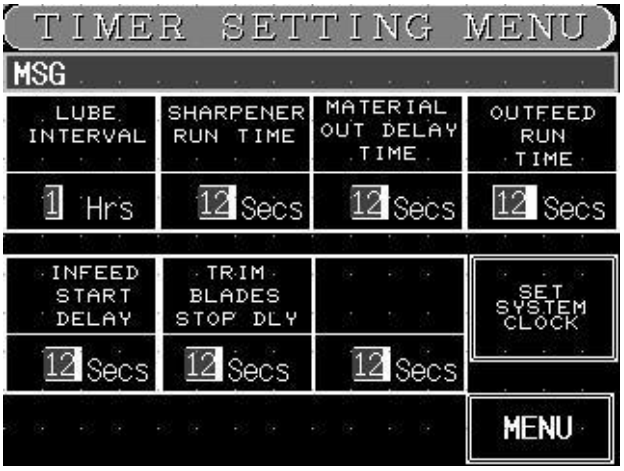
9.- MOVE XCUT TO L-SIDE

10.- TURN ON SLITTER MOTOR

11.- BACK

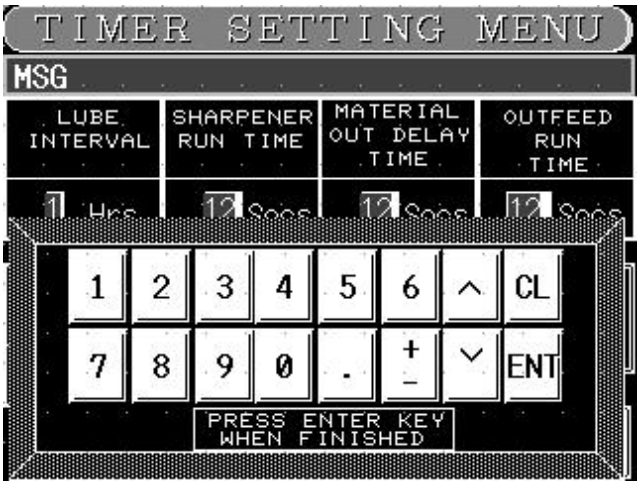
i.- Timer settings menu

1.- LUBE INTERVAL Control the activation trimming of the automatic grease system. (OPTIONAL EQUIP.)



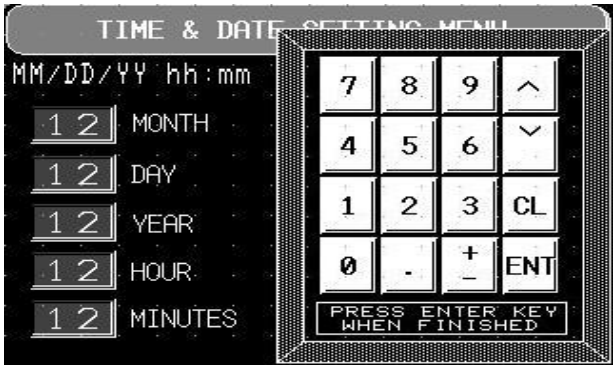
2.- SHARPENER RUN TIME

3.- OUT FEED RUN TIME



4.- SET SYSTEM CLOCK
Press any of the field and change values on the Keypad. Press enter Key when finish

5.- MENU Return to Main Menu



j.- Control Power Start

Press this button to energize the control power to the machine

k.- POWER OFF / POWER ON

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

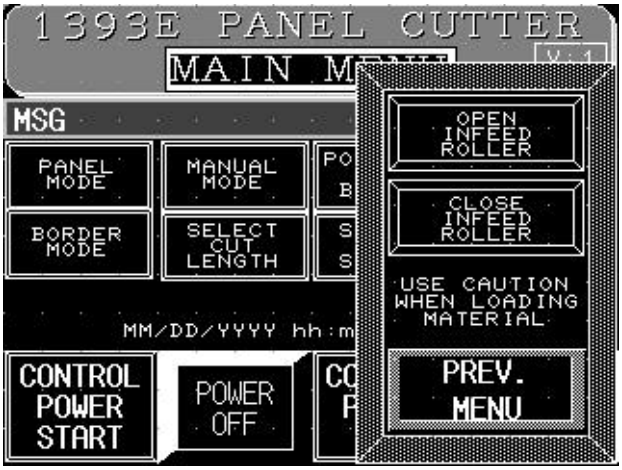
l.- Control power off

Press this button to de-energize all the control power to the machine.
(PLEASE NOTE: THIS IS NOT THE SAME AS THE MAIN POWER)

m.- Load Material in feed roller

Press **LOAD MATERIAL IN FEED** on the Main Menu roller and you will get 3 options

- OPEN IN FEED ROLLER
- CLOSE IN FEED ROLLER
- PREV MENU Return to the Main menu

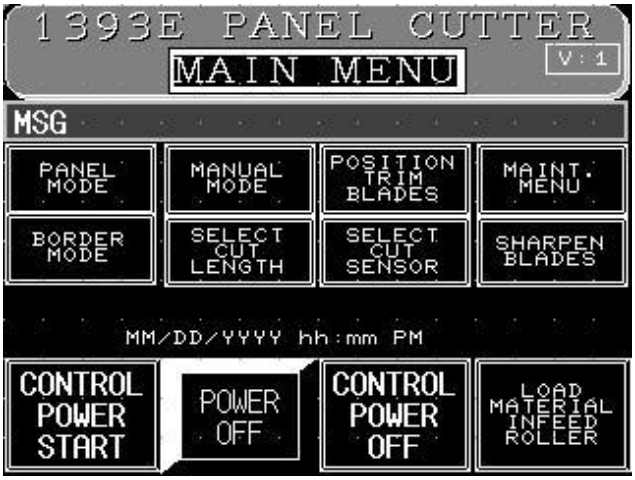


2.3.- Operating

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

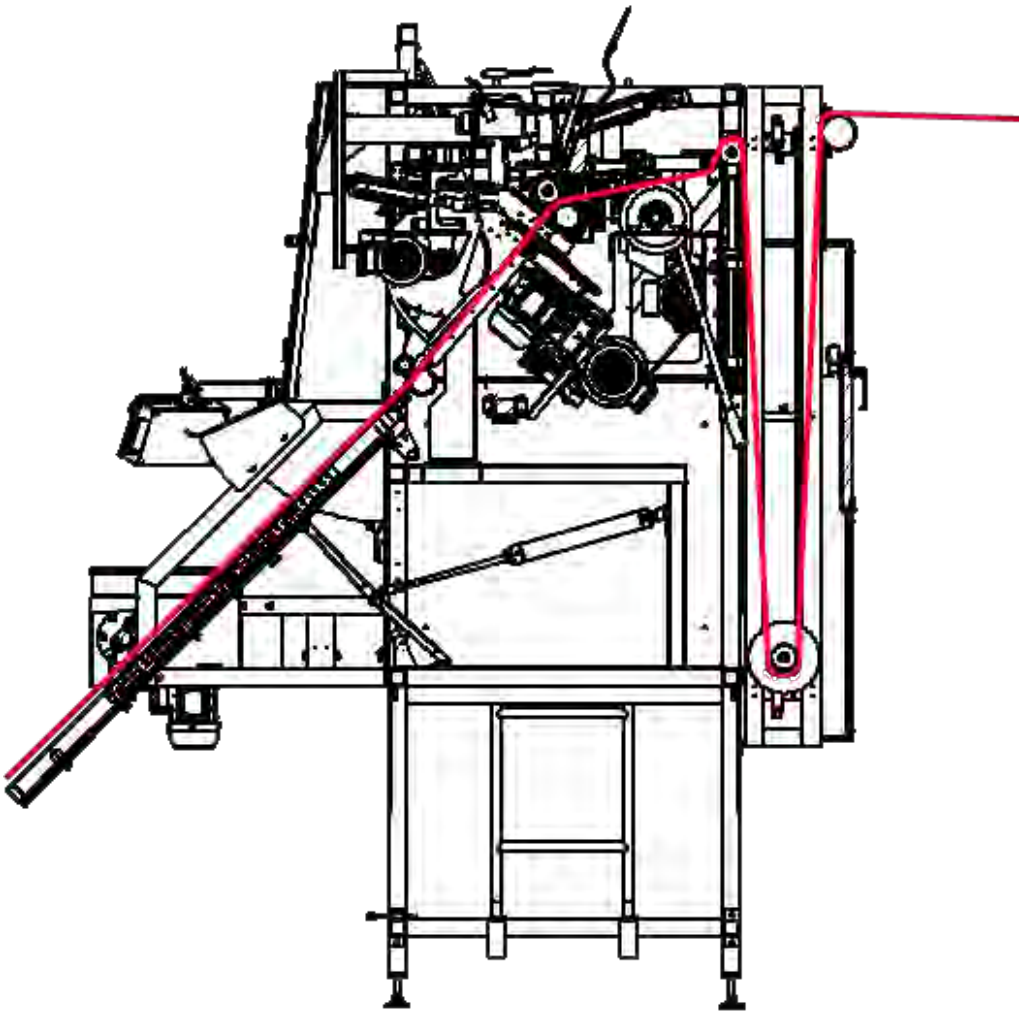
A.- Turning ON

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



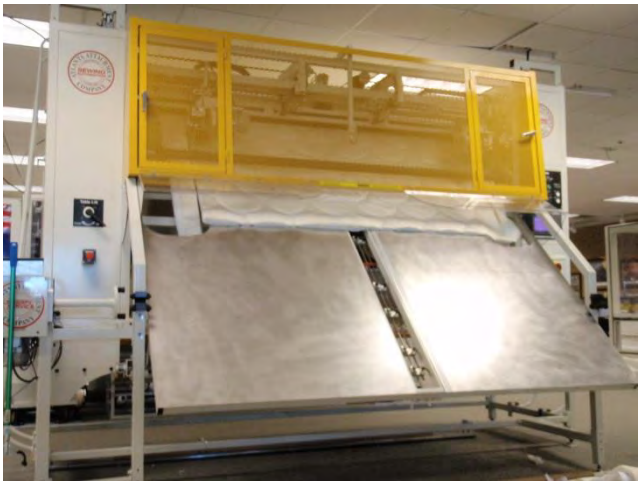
B.- Load the material

a.- With the machine ON, Press **LOAD MATERIAL IN FEED** on the Main Menu
b.- Press **OPEN INFEED ROLLER**,
c.- Open the safety doors You will be able to load material thought 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.
e.- Press **PREV MENU** to Return to the Main menu

c.- Panel Cutting



a.- Set the table Lift switch to "Up" and remove the re-winder shaft
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 **PANEL MODE** on the same screen.
e.- Load the production required (Panel quantity, dimensions, etc.)
f.- Press **RUN**.

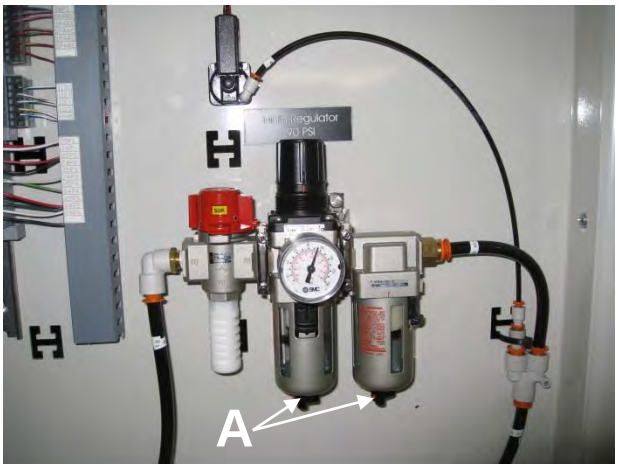
"ATTENTION "Never leaves the machine unattended"

d.- Border Cutting

a.- Carefully adjust manually the cutting blades to the right border width.
b.- Set the table Lift switch to "down" and install the re-winder shaft
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**.
g.- Readjust the re-winder air pressure if required.

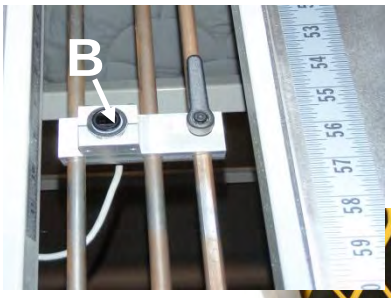
"ATTENTION "Never leaves the machine unattended"

2.4.- Maintenance



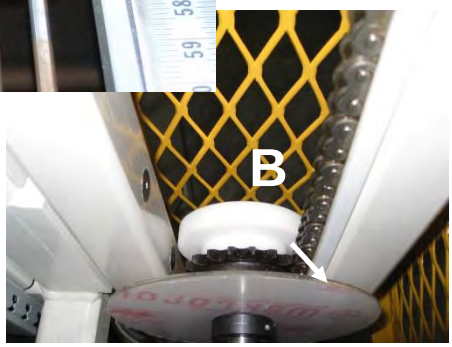
a.- Daily

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 X-Cut linear rail bearings and belt.
3.- Clean lint and debris from Right & Left Trim blade bearing rails and belts.
4.- Clean panel width sensors.
5.- Check for any areas of wear or potential problems.



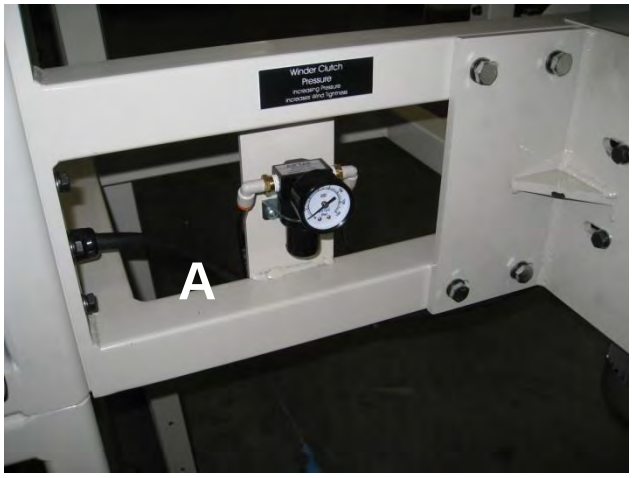
c.- Monthly

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

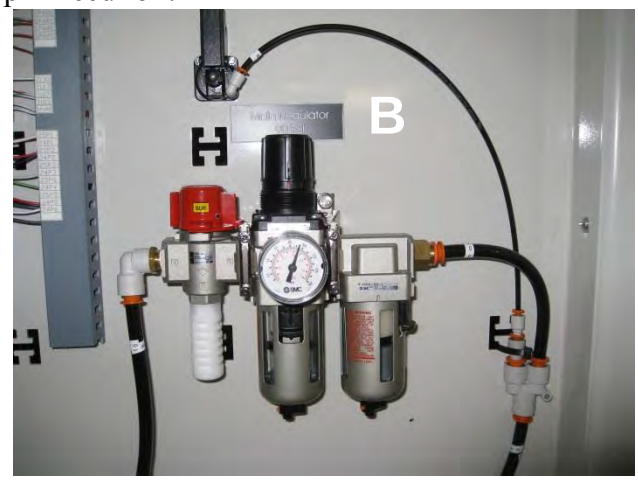


a.- Re-winder pressure.
Control the pressure of the clutch Determine how tight the roll will be winder.
(Factory adjustment: 30 psi)

b.- Main air regulator
Determine the pressure for the whole machine.
(Factory adjustment 90 psi)

c.- Blade Sharpeners.
Control the reassure of the blade sharpeners.
(Factory adjustment 30 psi)

d,- Infeed Roll regulator. Control de pressure of the top in feed roll.
(Factory adjustment 20 to 40 psi)



1393E Panel Cutter Spare Parts Kit

NO.	QTY	PART #	DESCRIPTION
1	2	1393003	SHARPENER STONE MNT
2	1	AAE4V21008	VALVE,1/4" PORTED,24VDC
3	2	BBGER205-25	BEARING,BALL,25MM B,CLAMP
4	2	CJ2090200	BLADE, TRIM & XCUT,280MM OD
5	2	CJ21100900	BLADE, SLITTER, 205MM OD
6	1	EEMC12B11	CONTACTOR,IEC,230VAC
7	1	EEMC32A22	CONTACTOR,IEC,230VAC
8	1	EENI5Q18AN6X	LIMIT SW SENSOR
9	1	EERM699V3011	RELAY,REPLACEMENT

Programming ACTech SCL/SCM Drive (1393E Only)

The drive is already pre-programmed** with settings specifically for the 1393E Unit by Atlanta Attachment Co. These settings are listed in the chart on the following page. Password protection is currently disabled so that control of the parameters is immediately available to the user. After the controller settings have been "fine-tuned", you can use parameter 44 to set a password value between 1-999 to "lock" the control setting for the motors.

The buttons and display on the front of the motor controller can be used to change any specific parameter. Pressing the mode button will take you to the last parameter viewed. Parameters are designated with a "P" as the first character on the display. The arrow up and arrow down buttons will scroll through to the desired parameter. Pressing "Mode" displays the current parameter setting (point "above" decimal point blinks). This setting can be changed by using the arrow up and arrow down buttons. When the desired setting is found press the mode button to store the new value. This will store the new value and exit the program mode. To change another parameter value, press the mode key again and repeat the procedure.

**In the event the controller has not been pre-programmed by AAC, the default password from the factory is 225.

Every SCL/SCM Series drive has an Electronic Programming Module (EPM) installed on the main control board. The EPM stores the user's parameter settings and special OEM default settings (if programmed). The EPM is removable, allowing it to be installed in another drive for quick set-up. For example, if a drive is being replaced with a new one, the EPM can be taken out of the first drive and installed in the new drive. Downtime is minimized because the new drive does not require programming - it is ready to run when the EPM is installed.

NOTE: The drive will not operate without the EPM installed. The drive will display "F1" if the EPM is missing or damaged.

WARNING!

Do not remove the EPM while power is applied to the drive. Damage to the EPM and/or drive may result.

See tables on following pages...

XCut Drive Motor Parameters Menu (INV1)

AAC custom setting shown in last column.

NO.	PARAMETER NAME	RANGE OF ADJUSTMENT	FACTORY DEFAULT	AAC SETTING
01	LINE VOLTAGE	High (01), LOW (02)	HIGH (01)	02
02	CARRIER FREQUENCY	4kHz (01), 6kHz (02), 8 kHz (03), 10 kHZ (04)	6 kHZ (02)	04
03	START METHOD	NORMAL (01), START ON POWER UP (02), START WITH DC BRAKE (03), AUTO RESTART WITH DC BRAKE (04), FLYING RESTART 1 (05), FLYING RESTART 2 (06), FLYING RESTART 3 (07)	NORMAL (01)	---
04	STOP METHOD	COAST (01), COAST W/ DC BRAKE (02), RAMP (03), RAMP W/ DC BRAKE (04)	COAST (01)	04
05	STANDARD SPEED SOURCE	KEYPAD (01), PRESET #1 (02), 0-10VDC (03), 4-20mA (04)	KEYPAD (01)	02
06	RELAY OUTPUT	NONE (01), RUN (02), FAULT (03), INVERSE FAULT (04), FAULT LOCKOUT (05), AT SET SPEED (06), ABOVE PRESET #3 (07), CURRENT LIMIT (08), AUTO SPEED (09), REVERSE (10)	NONE (01)	06
10	TB-13A FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #1 (04), START FORWARD (05), RUN REVERSE (06), START REVERSE (07), EXTERNAL FAULT (08), INVERSE EXT FAULT (09), AUXILARY STOP (10), ACCEL/DECEL #2 (11)	NONE (01)	06
11	TB-13B FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #2 (04), DECREASE FREQ (05), START FORWARD (06), JOG FORWARD (07), JOG REVERSE (08), EXTERNAL FAULT (09), INVERSE EXT FAULT (10), AUXILARY STOP (11), ACCEL/DECEL #2 (12), REMOTE KEYPAD (13)	NONE (01)	04
12	TB-13E INPUT FUNCTIONS TB-13 OUTPUT FUNCTIONS OTHER FUNCTIONS	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #3 (04), INCREASE FREQ (05), START FORWARD (06), EXTERNAL FAULT (07), INVERSE EXT FAULT (08), AUX STOP (09), ACCEL/DECEL #2 (10), RUN (11), FAULT (12), INVERSE FAULT (13), FAULT LOCKOUT (14), AT SET SPEED (15), ABOVE PRESET #3 (16), CURRENT LIMIT (17), AUTO SPEED (18), REVERSE (19), DYNAMIC BRAKING (20), REMOTE KEYPAD (21)	NONE (01)	---

14	CONTROL	TERMINAL STRIP ONLY (01) REMOTE KEYPAD ONLY (02)	TERMINAL STRIP ONLY (01)	---
16	UNITS EDITING	TENTHS OF UNITS (01), WHOLE UNITS (02)	WHOLE UNITS (02)	---
17	ROTATION	FORWARD ONLY (01), FORWARD AND REVERSE (02)	FORWARD ONLY (01)	02
19	ACCELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	1.0
20	DECELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	0.2
21	DC BRAKE TIME	0.0 - 3600.0 SEC	0.0 SEC	0.3
22	DC BRAKE VOLTAGE	0.0 - 30.0%	0.0 %	1.5
23	MINIMUM FREQUENCY	0.0 - MAXIMUM FREQUENCY	0.0 Hz	---
24	MAXIMUM FREQUENCY	MINIMUM FREQUENCY - 240 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	80
25	CURRENT LIMIT	30 - 180 %	180 %	150
26	MOTOR OVERLOAD	30 - 100 %	100 %	---
27	BASE FREQUENCY	25.0 - 500 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	60
28	FIXED BOOST	0.0 - 30.0 %	1.0 %	20
29	ACCEL BOOST	0.0 - 20.0 %	0.0 %	---
30	SLIP COMPENSATION	0.0 - 5.0 %	0.00%	---
31	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	70
32	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	35
33-37			0.0	0.0
38	SKIP BANDWIDTH	0.0 - 10 Hz	0.0 Hz	---
39	SPEED SCALING	0.0 - 6500.0	0.0	---
42	ACCEL/DECEL #2	0.1 - 3600.0 SEC	20.0 SEC	---
44	PASSWORD	000 - 999	225	*000
45	SPD AT MIN SIGNAL	MINIMUM FREQUENCY - 999 Hz	0.0 Hz	---
46	SPD AT MAX SIGNAL	MINIMUM FREQUENCY - 999 Hz	SCL = 50.0Hz SCM = 60.0Hz	---
47	CLEAR HISTORY	MAINTAIN (01), CLEAR (02)	MAINTAIN (01)	---

48	PROGRAM SELECTION	USER SETTINGS (01), OEM SETTINGS (02), RESET OEM (03), RESET 60 (04), RESET 50 (05), TRANSLATE (06)	SCL = RESET 50 (05) SCM = RESET 60 (04)	---
50	FAULT HISTORY	(VIEW ONLY)	(N/A)	---
51	SOFTWARE CODE	(VIEW ONLY)	(N/A)	---
52	DC BUS VOLTAGE	(VIEW ONLY)	(N/A)	---
53	MOTOR VOLTAGE	(VIEW ONLY)	(N/A)	---
54	LOAD VOLTAGE	(VIEW ONLY)	(N/A)	---
55	0-10 VDC INPUT	(VIEW ONLY)	(N/A)	---
56	4-20mA INPUT	(VIEW ONLY)	(N/A)	---
57	TB STRIP STATUS	(VIEW ONLY)	(N/A)	---
58	KEYPAD STATUS	(VIEW ONLY)	(N/A)	---
* PASSWORD IS SET TO “000” WHICH DISABLES THE PASSWORD FUNCTION				

Infeed Drive Motor Parameters Menu (INV2)

AAC custom setting shown in last column.

NO.	PARAMETER NAME	RANGE OF ADJUSTMENT	FACTORY DEFAULT	AAC SETTING
01	LINE VOLTAGE	High (01), LOW (02)	HIGH (01)	02
02	CARRIER FREQUENCY	4kHz (01), 6kHz (02), 8 kHz (03), 10 kHZ (04)	6 kHZ (02)	04
03	START METHOD	NORMAL (01), START ON POWER UP (02), START WITH DC BRAKE (03), AUTO RESTART WITH DC BRAKE (04), FLYING RESTART 1 (05), FLYING RESTART 2 (06), FLYING RESTART 3 (07)	NORMAL (01)	---
04	STOP METHOD	COAST (01), COAST W/ DC BRAKE (02), RAMP (03), RAMP W/ DC BRAKE (04)	COAST (01)	04
05	STANDARD SPEED SOURCE	KEYPAD (01), PRESET #1 (02), 0-10VDC (03), 4-20mA (04)	KEYPAD (01)	02
06	RELAY OUTPUT	NONE (01), RUN (02), FAULT (03), INVERSE FAULT (04), FAULT LOCKOUT (05), AT SET SPEED (06), ABOVE PRESET #3 (07), CURRENT LIMIT (08), AUTO SPEED (09), REVERSE (10)	NONE (01)	06
10	TB-13A FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #1 (04), START FORWARD (05), RUN REVERSE (06), START REVERSE (07), EXTERNAL FAULT (08), INVERSE EXT FAULT (09), AUXILARY STOP (10), ACCEL/DECEL #2 (11)	NONE (01)	06
11	TB-13B FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #2 (04), DECREASE FREQ (05), START FORWARD (06), JOG FORWARD (07), JOG REVERSE (08), EXTERNAL FAULT (09), INVERSE EXT FAULT (10), AUXILARY STOP (11), ACCEL/DECEL #2 (12), REMOTE KEYPAD (13)	NONE (01)	04
12	TB-13E INPUT FUNCTIONS TB-13 OUTPUT FUNCTIONS OTHER FUNCTIONS	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #3 (04), INCREASE FREQ (05), START FORWARD (06), EXTERNAL FAULT (07), INVERSE EXT FAULT (08), AUX STOP (09), ACCEL/DECEL #2 (10), RUN (11), FAULT (12), INVERSE FAULT (13), FAULT LOCKOUT (14), AT SET SPEED (15), ABOVE PRESET #3 (16), CURRENT LIMIT (17), AUTO SPEED (18), REVERSE (19), DYNAMIC BRAKING (20), REMOTE KEYPAD (21)	NONE (01)	---

14	CONTROL	TERMINAL STRIP ONLY (01) REMOTE KEYPAD ONLY (02)	TERMINAL STRIP ONLY (01)	---
16	UNITS EDITING	TENTHS OF UNITS (01), WHOLE UNITS (02)	WHOLE UNITS (02)	---
17	ROTATION	FORWARD ONLY (01), FORWARD AND REVERSE (02)	FORWARD ONLY (01)	02
19	ACCELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	1.0
20	DECELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	0.3
21	DC BRAKE TIME	0.0 - 3600.0 SEC	0.0 SEC	0.5
22	DC BRAKE VOLTAGE	0.0 - 30.0%	0.0 %	1.0
23	MINIMUM FREQUENCY	0.0 - MAXIMUM FREQUENCY	0.0 Hz	---
24	MAXIMUM FREQUENCY	MINIMUM FREQUENCY - 240 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	80
25	CURRENT LIMIT	30 - 180 %	180 %	150
26	MOTOR OVERLOAD	30 - 100 %	100 %	---
27	BASE FREQUENCY	25.0 - 500 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	60
28	FIXED BOOST	0.0 - 30.0 %	1.0 %	20
29	ACCEL BOOST	0.0 - 20.0 %	0.0 %	---
30	SLIP COMPENSATION	0.0 - 5.0 %	0.00%	---
31	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	60
32	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	35
33-37			0.0	0.0
38	SKIP BANDWIDTH	0.0 - 10 Hz	0.0 Hz	---
39	SPEED SCALING	0.0 - 6500.0	0.0	---
42	ACCEL/DECEL #2	0.1 - 3600.0 SEC	20.0 SEC	---
44	PASSWORD	000 - 999	225	*000
45	SPD AT MIN SIGNAL	MINIMUM FREQUENCY - 999 Hz	0.0 Hz	---
46	SPD AT MAX SIGNAL	MINIMUM FREQUENCY - 999 Hz	SCL = 50.0Hz SCM = 60.0Hz	---
47	CLEAR HISTORY	MAINTAIN (01), CLEAR (02)	MAINTAIN (01)	---

48	PROGRAM SELECTION	USER SETTINGS (01), OEM SETTINGS (02), RESET OEM (03), RESET 60 (04), RESET 50 (05), TRANSLATE (06)	SCL = RESET 50 (05) SCM = RESET 60 (04)	---
50	FAULT HISTORY	(VIEW ONLY)	(N/A)	---
51	SOFTWARE CODE	(VIEW ONLY)	(N/A)	---
52	DC BUS VOLTAGE	(VIEW ONLY)	(N/A)	---
53	MOTOR VOLTAGE	(VIEW ONLY)	(N/A)	---
54	LOAD VOLTAGE	(VIEW ONLY)	(N/A)	---
55	0-10 VDC INPUT	(VIEW ONLY)	(N/A)	---
56	4-20mA INPUT	(VIEW ONLY)	(N/A)	---
57	TB STRIP STATUS	(VIEW ONLY)	(N/A)	---
58	KEYPAD STATUS	(VIEW ONLY)	(N/A)	---
* PASSWORD IS SET TO "000" WHICH DISABLES THE PASSWORD FUNCTION				

Assembly Drawings & Parts Lists

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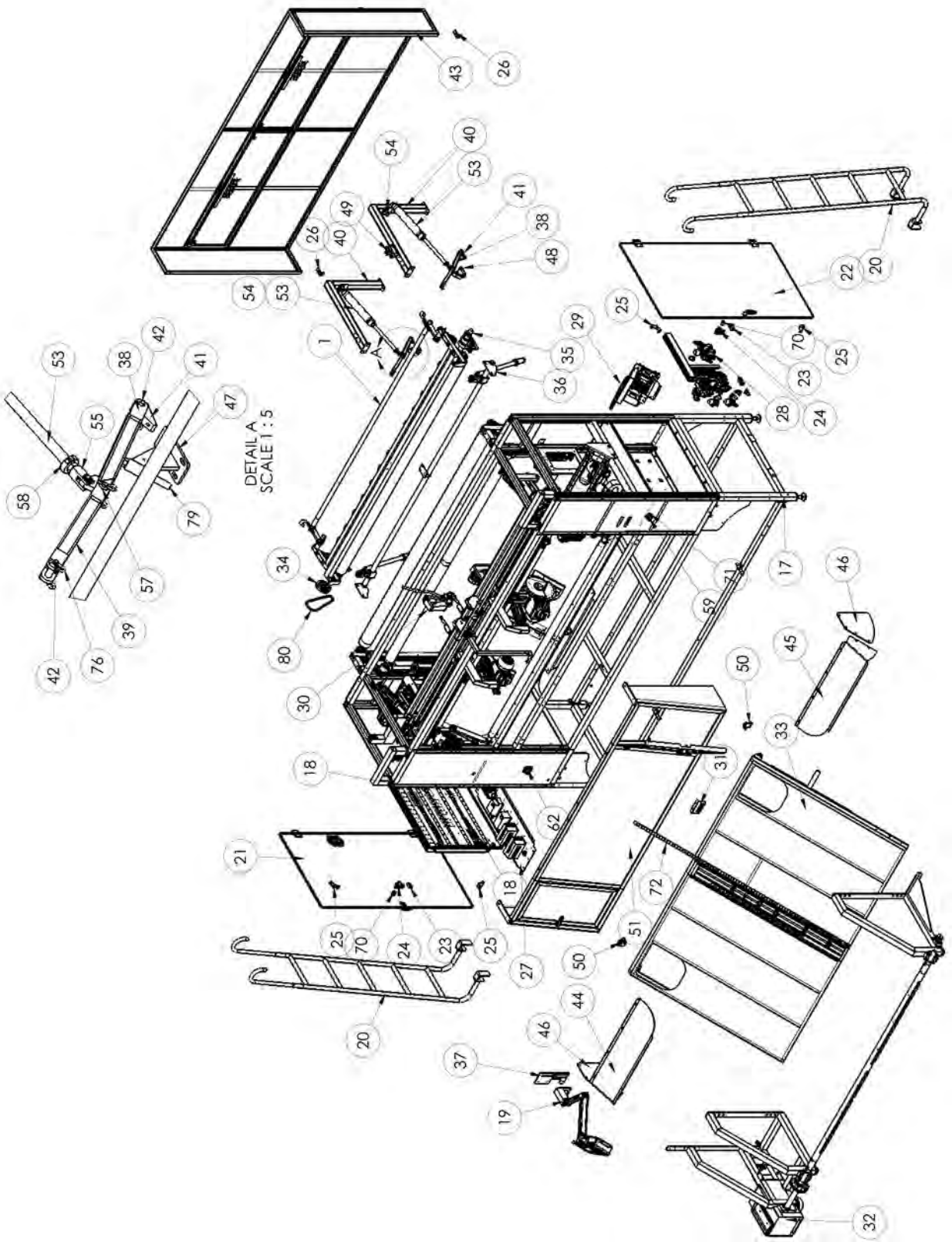
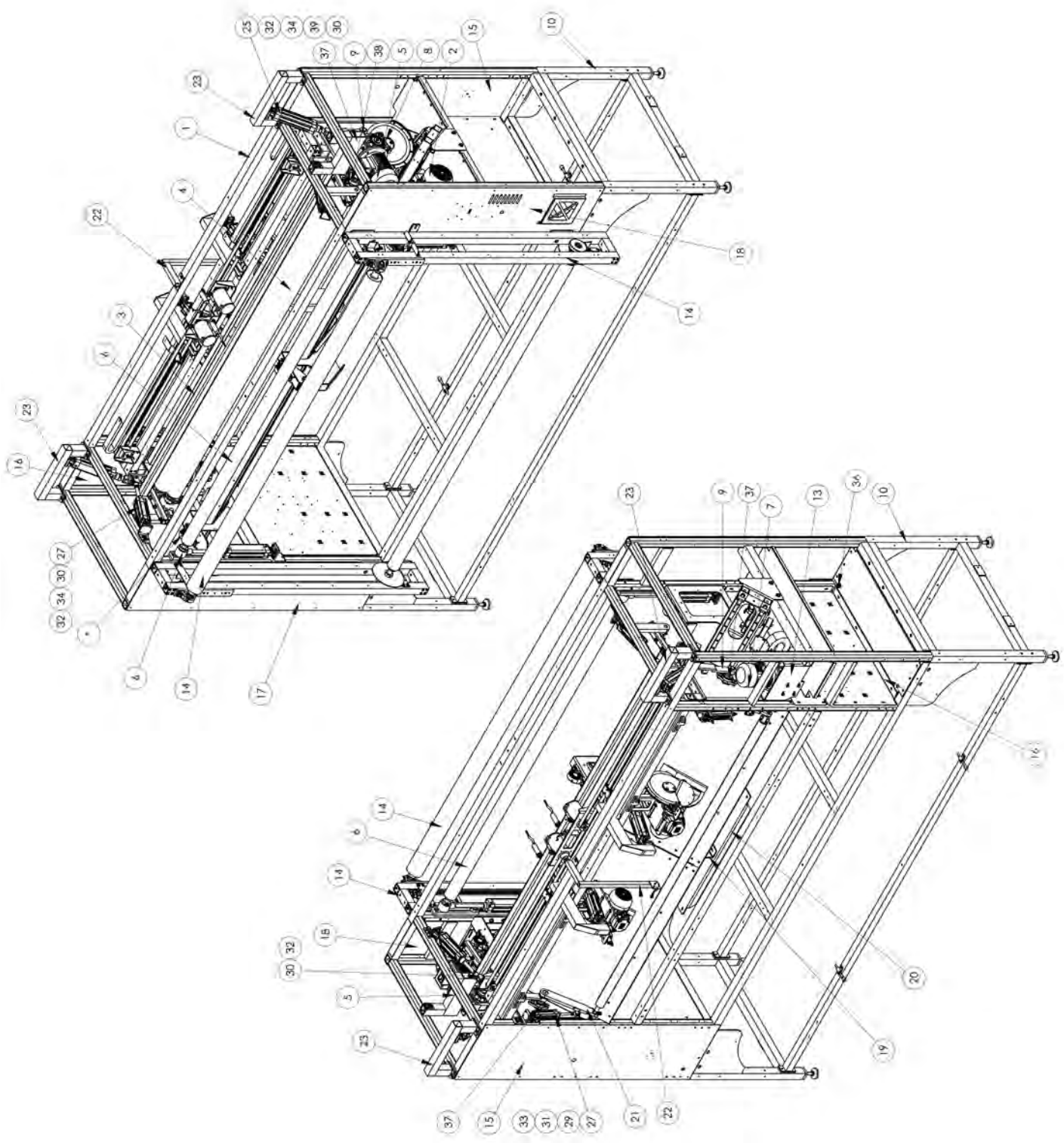

DETAIL A
SCALE 1 : 5

Technical Manual & Part List

11393E PANEL CUTTER/SLITTER

AAC Drawing Number 9002885 Rev 8

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	1393-KIT06	WEIGHTED SLITTER BAR ASM	41	2	1393109	PIVOT, BOLT ON
2	*1	1393-LAB4	LABELS,DOORS CLOSED	42	6	1393133	PIVOT PIN
3	* 1	1393E-CAB1	CABLE PACKAGE, 1393E	43	1	1393160	FRONT GUARD
4	* 1	1393E-LAB1	BACK PLATE,LABEL	44	1	1393186	GUARD, EXIT, LEFT
5	* 1	1393E-LAB2	TERMINAL WIRING LABELS,1393E	45	1	1393199	GUARD, EXIT
6	*AR	1393E-PD1	DIAGRAM,PNEUMATIC	46	2	1393201	GUARD, SIDE TABLE
7	*AR	1393E-WD1	DIAGRAM,WIRING	47	1	1393240	ARM STOP WELDMENT
8	*AR	1393E-WD2	DIAGRAM,WIRING	48	1	1393310	TABLE STOP ASSY
9	*AR	1393E-WD3	DIAGRAM,WIRING	49	1	1393312	LOCK PIN VALVE ASSY
10	*AR	1393E-WD4	DIAGRAM,WIRING	50	2	1393360	TABLE PIVOT ASST
11	*AR	1393E-WD5	DIAGRAM,WIRING	51	1	1393770	REAR GUARD ASSY
12	*AR	1393E-WD6	DIAGRAM,WIRING	52	*AR	1394282	BRACKET,SHIPPING 11393
13	*AR	1393E-WD7	DIAGRAM,WIRING	53	2	AACM3112DXP	CYLINDER,AIR,2" BORE
14	*AR	1393E-WD8	DIAGRAM,WIRING	54	2	AAFD620	REAR PIVOT BRKT
15	*AR	1393E-WD9	DIAGRAM,WIRING	55	2	AAFD2313	CLEVIS, AIR CYL 7/16-20
16	*AR	1393E-WD10	DIAGRAM,WIRING	56	*	AATPWL1	WIRE LOOM,SLIT,.92"ID
17	1	1388232	1393E SUB-FRAME ASSEMBLY	57	12	BBTRA613	WASHER,THRUST,STL, .375B
18	1	1388303	BACK PANEL ELECTRICAL ASM	58	2	CCCL10F	CLAMP COLLAR- 5/8 ID
19	1	1388415	SWIVEL ARM ASSEMBLY	59	3	EE2AML4	OPERATOR, E-STOP,RED
20	2	1388520	LADDER, LONG, 1393E	60	1	EE194EE63PE	GROUND TERMINAL
21	1	1388549	SIDE DOOR ASSEMBLY, RH	61	1	EE194EE631753	63AMP DISCON
22	1	1388550	SIDE DOOR ASSEMBLY, LH	62	1	EE194LHE6N175	DISCONNECT HANDLE,RED/YEL
23	2	1388555	DOOR LATCH	63	1	EE07100SP072	CORD, FAN, 72" STRAIGHT
24	2	1388558	BOX, SAFETY SENSOR, DOOR	64	*	EED78W308	DUCT,WIRE,3/4 X 3/4
25	4	1388559	DOOR STOP/BUMPER ASM	65	*	EED78W332	DUCT,WIRE COVER
26	2	1388592	BRACKET, REAR GUARD MNT	66	*	EEDC15X15	DUCT,WIRE COVER
27	1	1388594	BOTTOM PANEL, ELEC, ASM	67	*	EEDE15X15	DUCT,WIRE
28	1	1388650	PNEUMATIC ASSY 1393E	68	6	EES2	CONTACT BLOCK, NC
29	1	1388664	CROSS CUT ASSY	69	*	FF822427	CABLE,SOOW,4X14AWG,600V
30	1	1388749	ENCODER ASSEMBLY,NEW SYTL	70	2	FFE6930A	SWITCH,INTEROCK,DOOR,SPDT
31	1	1389229	MOLEX MANIFOLD	71	3	MM800E15YE112	E-STOP LEGEND PLATE
32	1	1389245	WINDER ASSEMBLY	72	1	MM1910A25M	RULER,SILVER MYLAR 108"
33	1	1389258	PANEL TABLE ASSEMBLY	73	1	MM1976K78	FAN, COOLING, 230VAC
34	1	1389605	PULLEY, SLITTER MOTOR	74	* 6	MM9307K69	GROMMET,1" OD
35	1	1389860	SLITTER ASBLY,SPLIT SHAFT	75	* 1	MM19155K98	FAN,FINGER GUARD,5.9"
36	1	1389896	SLITTER SHARPENER ASBLY	76	12	MM98335A04	SPRING CLIP, .06 WIRE
37	1	1389902	PLATE, TOUCHSCREEN MOUNT	77	1	MMT9945	TAPE,REFLECTIVE,2" WIDE
38	2	1393096	LINKAGE, TOP	78	1	NNH3/8-16	NUT,HEX,3/8-16
39	2	1393098	LINKAGE, LOWER	79	1	SSHC25224F	3/8-16 X 3.5 HHCS, FULL T
40	2	1393100	MOUNTING WELDMENT	80	1	ZX5031	V-BELT,1/2X31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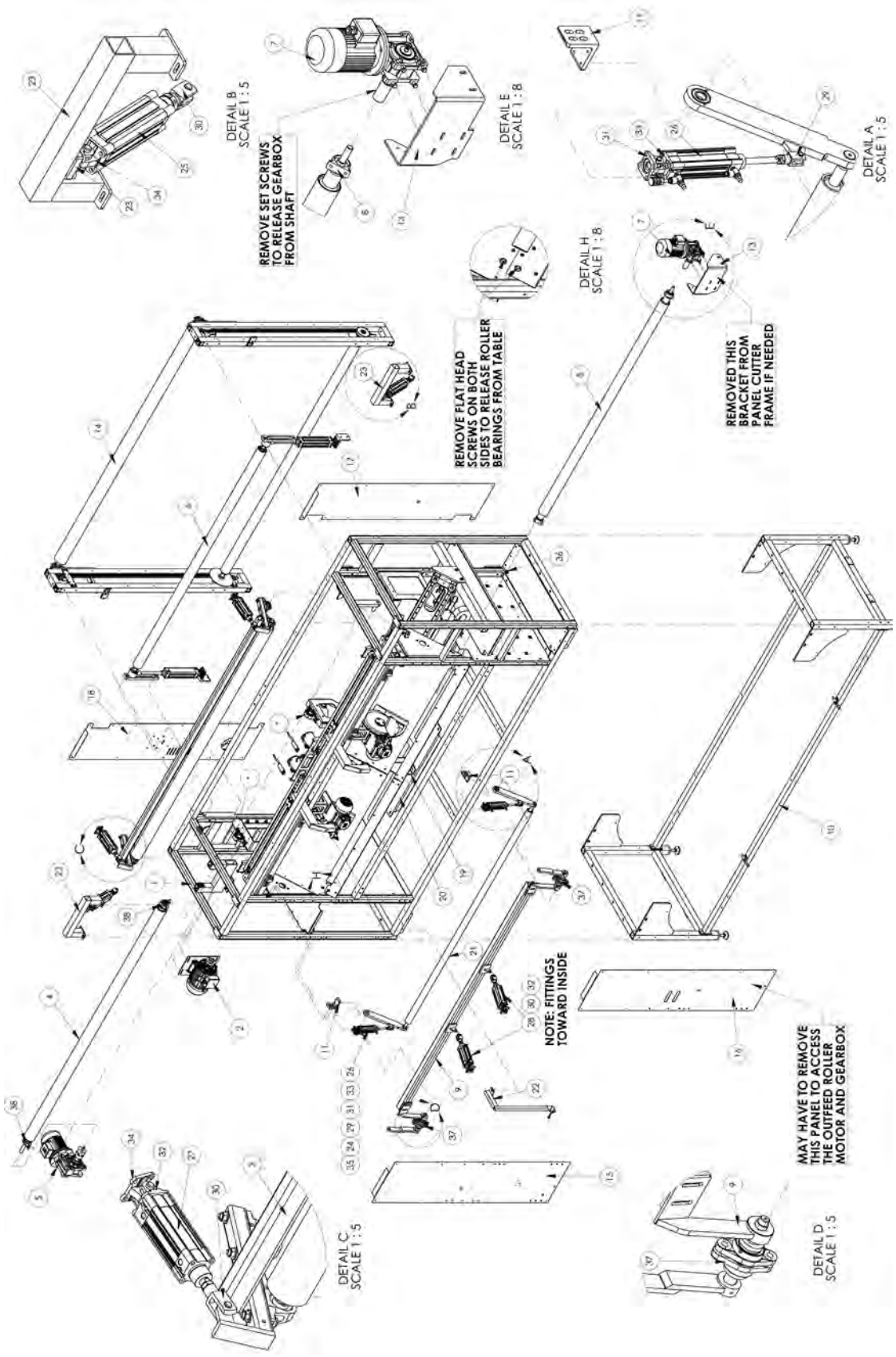
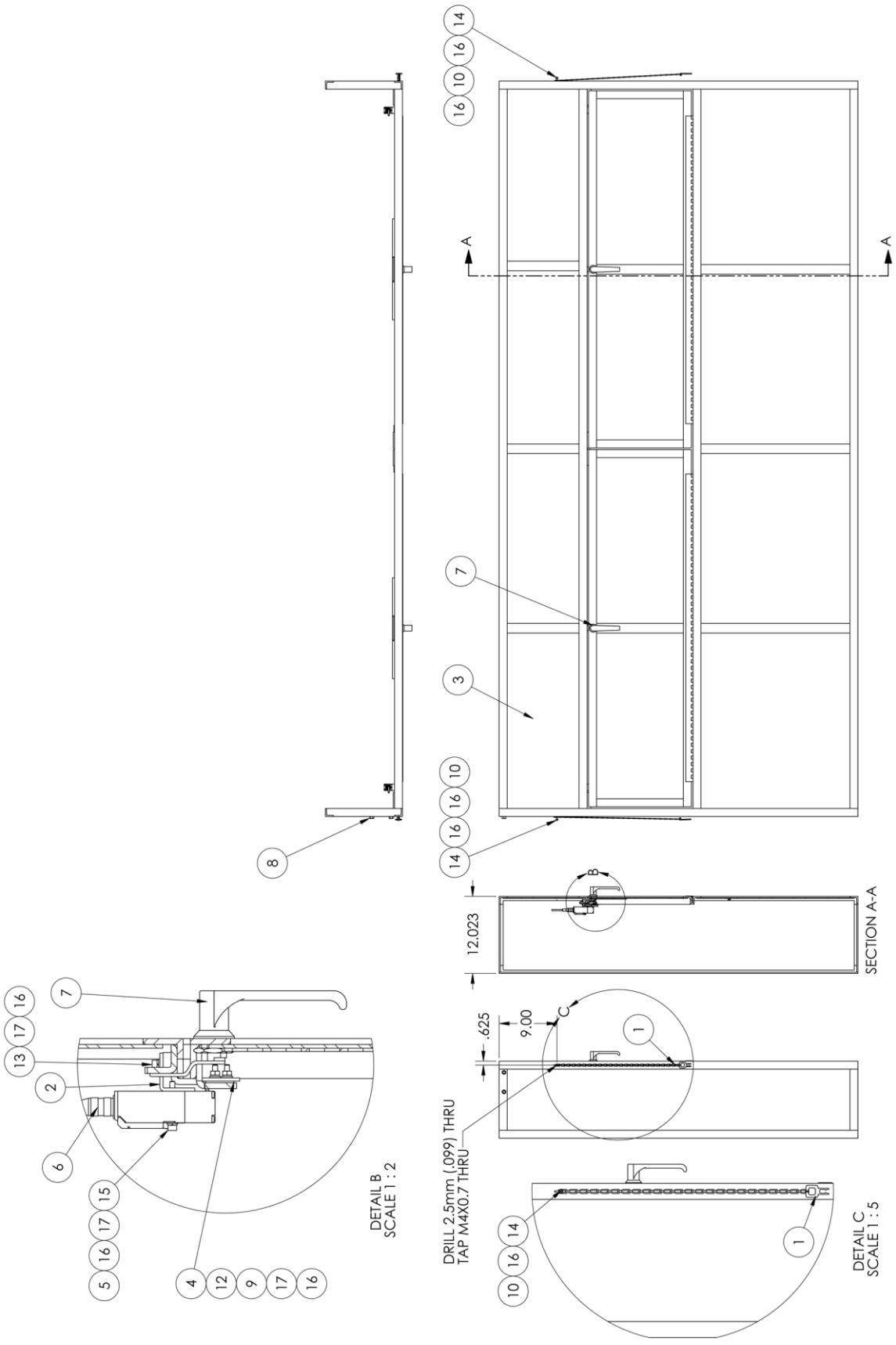

DETAIL B
SCALE 1 : 5
REMOVE SET SCREWS
TO RELEASE GEARBOX
FROM SHAFT
DETAIL E
SCALE 1 : 8
DETAIL A
SCALE 1 : 5
DETAIL H
SCALE 1 : 8
REMOVE FLAT HEAD
SCREWS ON BOTH
SIDES TO RELEASE ROLLER
BEARINGS FROM TABLE
REMOVED THIS
BRACKET FROM
PANEL CUTTER
FRAME IF NEEDED
NOTE: FITTINGS
TOWARD INSIDE
MAY HAVE TO REMOVE
THIS PANEL TO ACCESS
THE OUTFEED ROLLER
MOTOR AND GEARBOX
DETAIL C
SCALE 1 : 5
DETAIL D
SCALE 1 : 5

1388232 SUB-FRAME ASSEMBLY

AAC Drawing Number 1388232 Rev 4

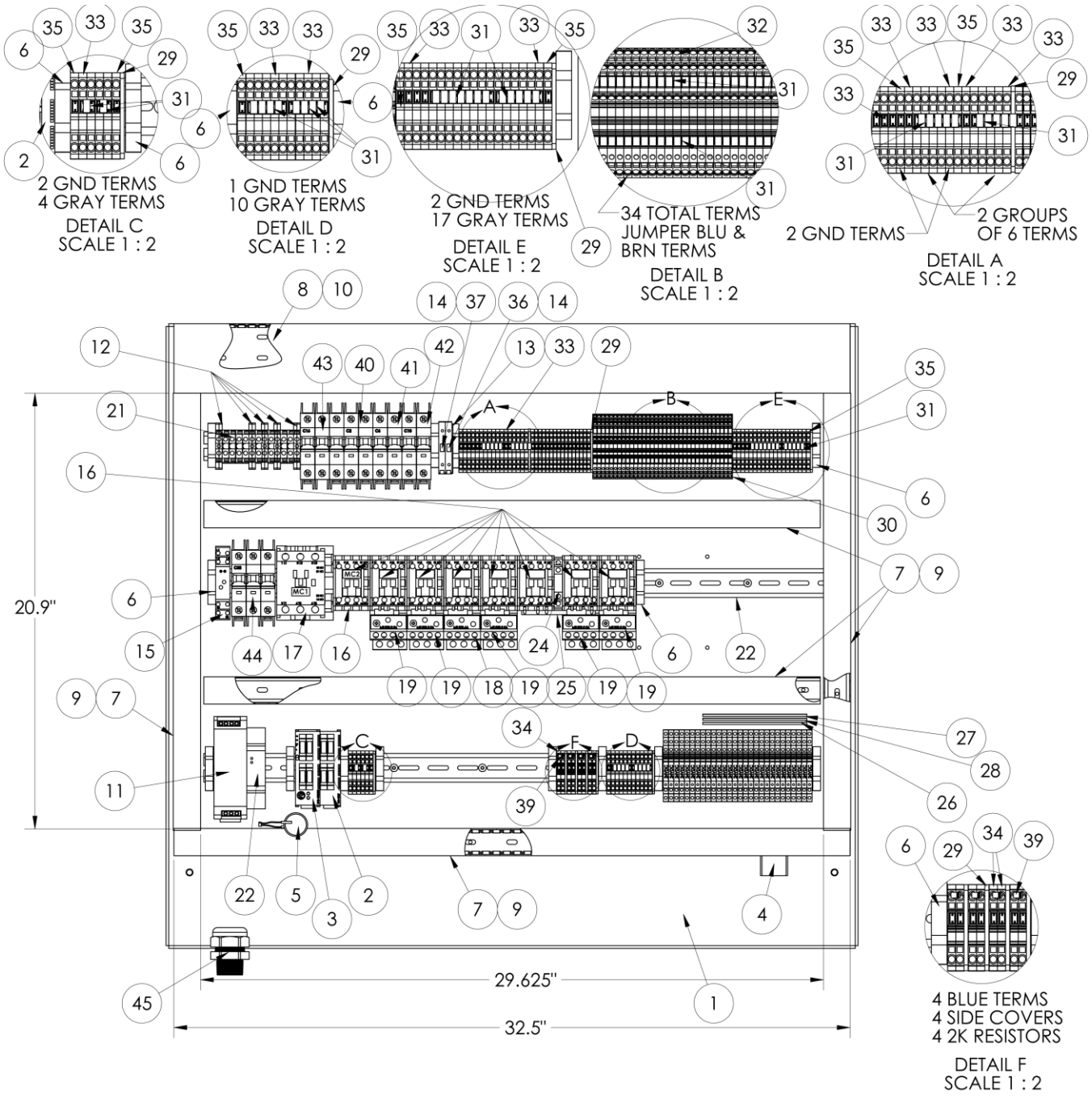
NO	QTY	PART #	DESCRIPTION
1	1	1388233	FRAME, ASSEMBLY
2	1	1388276	SLITTER, MOTOR DRIVE ASM
3	1	1388317	TOP ROLLER ASSEMBLY
4	1	1388326	INFEED DRIVE ROLL WLDMNT
5	1	1388331	INFEED ROLL DRIVE ASM
6	1	1388333	BORDER LIFT ROLL ASM
7	1	1388337	OUTFEED MOTOR DRIVE ASM
8	1	1388343	OUTFEED DRIVE ROLL ASM
9	1	1388347	XCUT CLAMP ASSY
10	1	1388351	PANEL CUTTER LEG ASSEMBLY
11	2	1388381	CYLINDER BKT, MOUNTING
12	2	1388568	WASHER PLATE, OUTFEED ROL
13	1	1388569	PLATE,VERT, OUTFEED DRV,L
14	1	1388572	DANCER ASSY 1393E
15	1	1388581	PANEL,BACK RIGHT
16	1	1388582	PANEL,BACK LEFT
17	1	1388583	PANEL,FRONT LEFT
18	1	1388584	PANEL, FRONT LEFT WELDMNT
19	1	1388642	BRACKET,CUT TABLE
20	1	1388662	PLATE, TABLE SUPPORT
21	1	1389060	EXIT ROLLER ASSEMBLY
22	1	1389078	MATERIAL SENSOR, X CUT
23	2	1393716	CYLINDER BRIDGE, LEFT
24	4	AA198RA408U	FLOW CONTROL,RC 1/8X1/4
25	2	AACDNC50150PPV	CYLINDER,AIR,50B,150S
26	2	AACDNCB3280PPVA	CYLINDER,AIR,ISO,32X80
27	2	AACDNCB5080PPVA	CYLINDER,AIR,ISO,50BX80
28	2	AACDNCB50100PPVA	CYLINDER,AIR,ISO,50BX100
29	2	AAFSGM10X1_25	CLEVIS,ROD,M10X1.25
30	6	AAFSGM16X1.5	CLEVIS ROD M16X1.5
31	2	AAFSNC32	FLANGE,SWIVEL,DNCB-32
32	6	AAFSNC50	FLANGE, SWIVEL, FOR DNCB50
33	2	AAFSNCS32	FLANGE,SWIVEL,SNCS-32
34	6	AAFSNCS50	CLEVIS SINGLE REAR W/PIN
35	2	AAN103X235	MUFFLER,1/4" PUSH IN
36	1	AAQBU-3-3	Bulkhead Union
37	4	BBGRFT205-25	BEARING, FLANGE,25MM
38	2	BBNAP205-25	BEARING, PILLOWBLOCK
39	2	CCCLMSP20F	CLAMP COLLAR- M20
40	8	WWFM8	WASHER, FLAT, M8 I.D.
41	8	WWLM8	M8 LOCK WASHER
42	8	SSHCM8X20	SCREW,HEX CAP


DETAIL B
SCALE 1 : 2
DRILL 2.5mm (.099) THRU
TAP M4X0.7 THRU
12.023
.625
9.00
SECTION A-A
DETAIL C
SCALE 1 : 5

1393160 FRONT GUARD

AAC Drawing Number 1393160 Rev 9

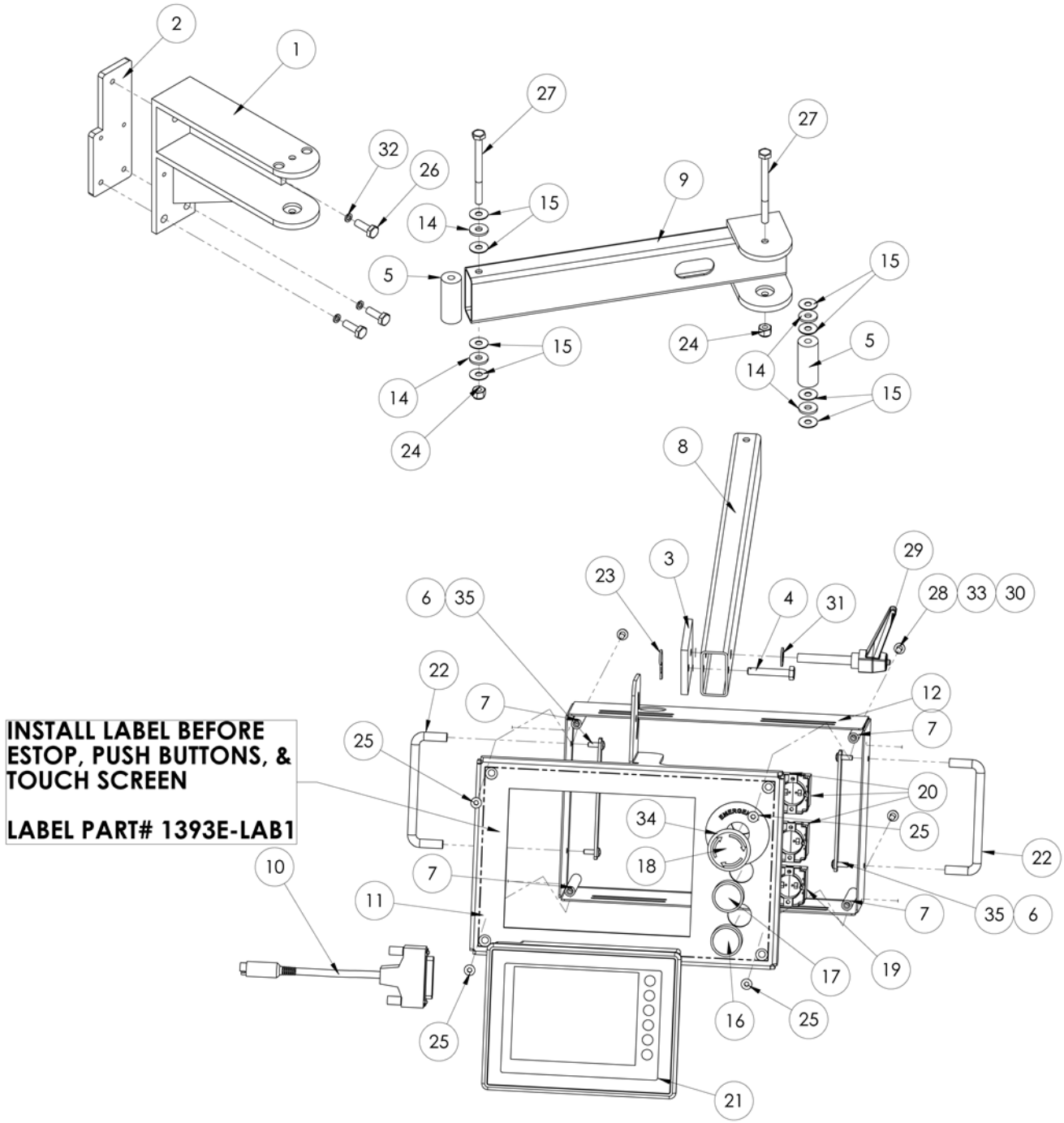
NO	QTY	PART #	DESCRIPTION
1	2	1388683	SAFETY SWITCH KEY ASM
2	2	1389632	LOCKOUT BKT, FRAME
3	1	1393899	FRONT, GUARD ASSY
4	2	EE140180	ACTUATOR, 90 DEGREE
5	2	EE1222002	SWITCH,SAFETY,DOOR 2 N.C.
6	2	FFRK44T-6	CABLE,EYE,19',NO END
7	2	MMELH149	LATCH HANDLE
8	2	NNH3/8-16	NUT,HEX,3/8-16
9	4	NNHM4X0.7	NUT,HEX,M4-0.7
10	2	NNJM4	NUT,JAM,M4,ZINC PLATED
11	24	SSFC90024	8-32 X 3/8 FL ALN CAP
12	4	SSPSM4X16	M4-0.70X16 PAN HS SLOTTED
13	4	SSSCM4X10	SCREW,SOC CAP,M4-0.7X8
14	2	SSSCM4X16	SCREW,SOCKET CAP
15	4	SSSCM4X35	SCREW,SOC CAP,M4-0.7X30
16	20	WWFM4.3	WASHER, FLAT, M4
17	12	WWL8	WASHER,LOCK,#8


2 GND TERMS
4 GRAY TERMS
DETAIL C
SCALE 1 : 2
1 GND TERMS
10 GRAY TERMS
DETAIL D
SCALE 1 : 2
2 GND TERMS
17 GRAY TERMS
DETAIL E
SCALE 1 : 2
34 TOTAL TERMS
JUMPER BLU &
BRN TERMS
DETAIL B
SCALE 1 : 2
2 GND TERMS
2 GROUPS
OF 6 TERMS
DETAIL A
SCALE 1 : 2
20.9"
29.625"
32.5"
4 BLUE TERMS
4 SIDE COVERS
4 2K RESISTORS
DETAIL F
SCALE 1 : 2

1388303 BACK PANEL ELECTRICAL ASSEMBLY

AAC Drawing Number 1388303 Rev 9

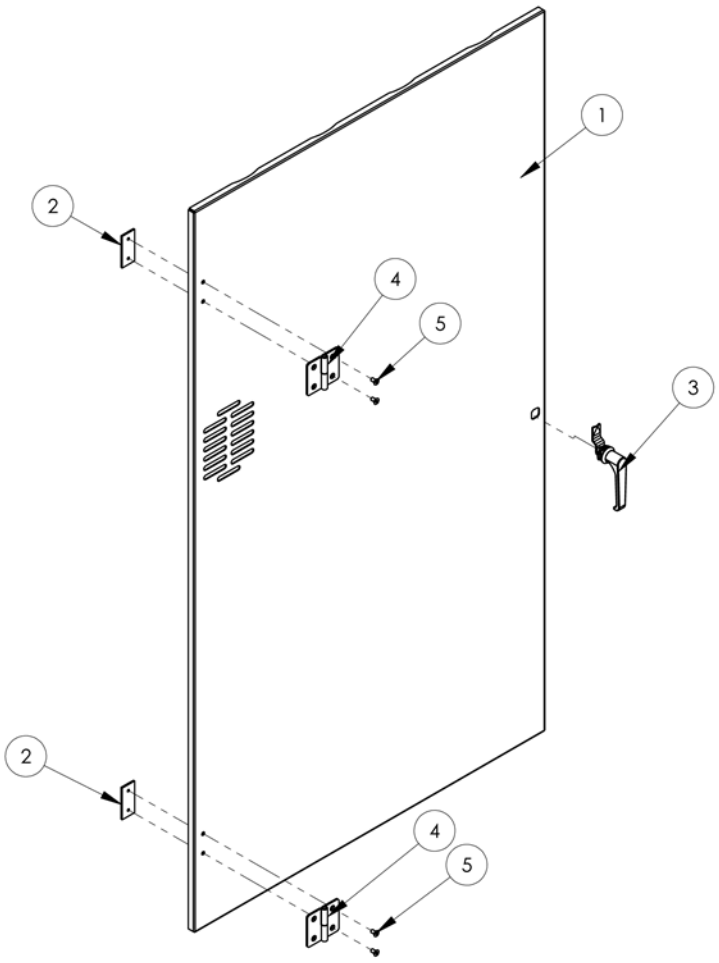
NO	QTY	PART #	DESCRIPTION
1	1	1388306	BACK PANEL WELDMENT
2	1	AAFP0-E32T-A	EXPANSION UNIT, PLC
3	1	AAFPG-C32TH	CONTROLLER, PLC, SIGMA
4	1	EE64151B	FERRITE CORE,SPLIT,CABLE
5	1	EEAFPG804	BATTERY,BACKUP,PLC
6	14	EECLIPFIX	ANCHOR,DIN RAIL
7	3.5	EEDC1LG	DUCT,WIRE COVER,1"
8	2.7	EEDC3X2	DUCT,WIRE COVER,3"
9	3.5	EEDF1X2	DUCT,WIRE,1X2
10	2.7	EEDF3X2	DUCT,WIRE,3X2
11	1	EEDR12024	POWER SUPPLY, 24VDC
12	5	EEEK635	TERMINAL BLOCK, EK2.6/35
13	1	EEEPF2	END PLATE, FUSE BLOCK
14	2	EEERF2	BLOCK, FUSE,TERMINAL
15	1	EEHRN56240	RELAY,3-PHASE MONITOR
16	8	EEMC12B11	CONTACTOR,IEC,230VAC
17	1	EEMC32A22	CONTACTOR,IEC,230VAC
18	1	EEMT32S6A	RELAY,OVERLOAD,4.0-6.0A
19	5	EEMT32S25A	RELAY,OVERLOAD,1.6-2.5A
20	28	EEPIR6W1P24	RELAY,INTERFACE,24VDC
21	8	EESAK6EN	TERMINAL BLOCK, SAK6/EN
22	1	EESR103AM01	SAFETY RELAY, DUAL CHAN.
22	88.8	EETS35X7.5A	DIN RAIL-AMERICAN
24	1	EEUR02	MECHANICAL INTERLOCK
25	1	EEUW22	WIRE KIT, REVERSING
26	* 2	EEZG20-1	JUMPER,RELAY,RED
27	* 2	EEZG20-2	JUMPER,RELAY,BLACK
28	* 2	EEZG20-3	JUMPER,RELAY,BLUE
29	9	FF280-308	TERMBLK ENDPLATE,WAGO,280
30	1	FF280-319	TERMBLK,WAGO,SENSOR,DIN
31	100	FF280-402	JUMPER,WAGO,TOP,SNGL
32	34	FF280-560	TERMBLK,WAGO,SENSOR,DIN
33	62	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY
34	8	FF280-904	TERMBLK,WAGO,TOP,SNGL
35	7	FF280-907	TERMBLK,WAGO,TOP,SNGL,GRN
36	1	FFGMA2	FUSE, 2AMP (5X20M) 125VAC
37	1	FFGMA4	FUSE, 4AMP (5X20M) 125VAC
38	700	FFLS11427	LABELS,AAC ROUND,BLK/WHT
39	4	FFR2K	RESISTOR, 2K, 1/4W
40	1	FFWMZT2C2	BREAKER,2P,2A,DIN,UL489
41	1	FFWMZT2C6	BREAKER,2P,6A,DIN,UL489
42	1	FFWMZT2C10	BREAKER,2P,10A,DIN,UL489
43	1	FFWMZT3C16	BREAKER,3P,16A,DIN,UL489
44	1	FFWMZT3C32	BREAKER,3P,32A,DIN,UL489
45	1	MM69915K72	STRAIN RELIEF, LIQ TIGHT
46	21	SSBCM5X8	SCREW,BUTTON CAP


INSTALL LABEL BEFORE ESTOP, PUSH BUTTONS, & TOUCH SCREEN
LABEL PART# 1393E-LAB1

1388415 SWIVEL ARM ASSEMBLY

AAC Drawing Number 1388415 Rev3

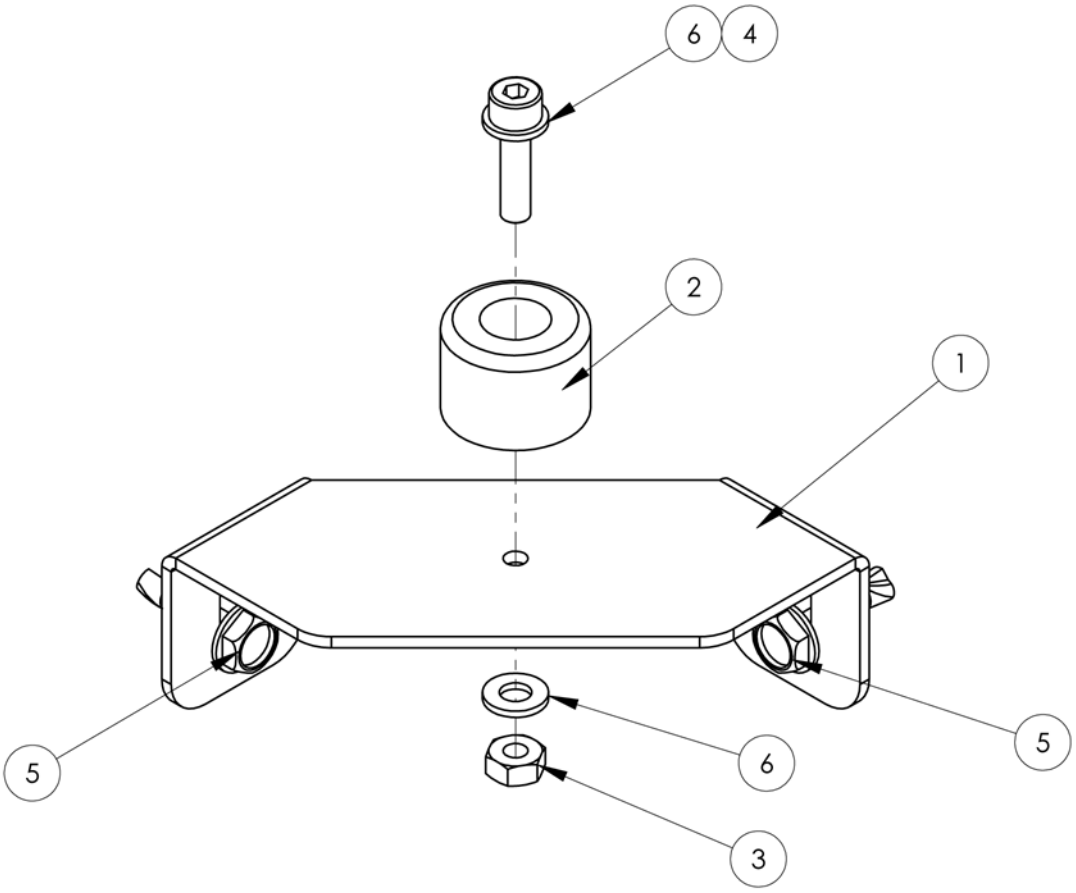
NO	QTY	PART #	DESCRIPTION
1	1	0411-114	WELDMENT,SWIVEL BASE
2	1	0411-3705	NUT PLATE,BASE MOUNT
3	1	0411-3708	NUT PLATE,BOX MOUNT
4	1	0411-3709	LOCK PIN
5	2	0411-3712	TUBE, SPACER, TALL
6	2	1379215	PLATE, WASHER, HANDLE
7	4	1388685	STANDOFF, .5" X 3",M5
8	1	1389681	TUBE,12 L,PIVOT ARM
9	1	1389701	WLDMT,PIVOT ARM
10	1	1389747	CABLE, TOUCHSCREEN, ASSY
11	1	1389870	MOUNT,TOUCHSCREEN
12	1	1389872	COVER,BACK,TOUCHSCREEN
*13	1	1393E-LAB1	PANEL BACK,LABEL
14	4	BBNTA411	BEARING,THRUST,.250B
15	8	BBTRA411	WASHER,THRUST,STEEL
16	1	EE2AF3	OPERATOR, FLUSH,GREEN
17	1	EE2AF4	OPERATOR, FLUSH,RED
18	1	EE2AML4	OPERATOR, E-STOP,RED
19	2	EES1	CONTACT BLOCK, NO
20	3	EES2	CONTACT BLOCK, NC
21	1	EEV606EM20	TOUCH SCREEN FOR 1393
22	2	MM1568A45	HANDLE,DOOR,PULL
23	1	MM98335A04	SPRING CLIP, .06 WIRE
24	2	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
25	4	SSFCM5X10	SCREW,FLAT ALLEN CAP
26	3	SSHC01048	1/4-20 X 3/4 HEX CAP
27	2	SSHC01192	HEX HEAD BOLTS, 1/4-20 X
28	4	SSPP98032	10-32 X 1/2 PAN PHIL
29	1	TTH32429	HANDLE,THRD,5/16-18X2.0
30	4	WWFM5	WASHER, FLAT, M5 I.D.
31	1	WWFS5/16	WASHER,FLAT,SAE,5/16
32	3	WWL10	WASHER,LOCK,#10
33	4	WWLM5	M5 LOCK WASHER
34	1	MM800E15YE112	E-STOP LEGEND PLATE
35	4	SSPP90032	SCREW,8-32 PAN HD PHIL



1388549 SIDE DOOR ASSEMBLY, RH

AAC Drawing Number 1388549 Rev 0

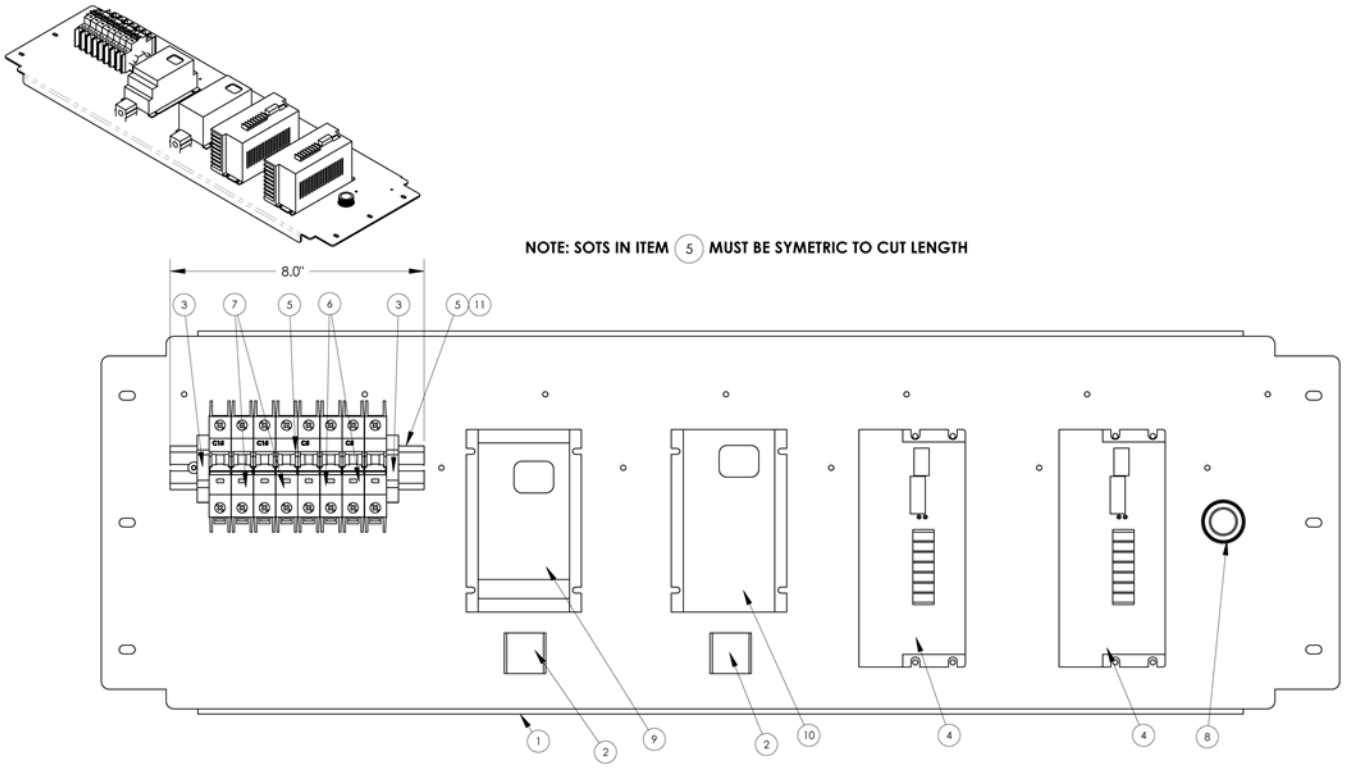
NO	QTY	PART #	DESCRIPTION
1	1	1388548	DOOR, RIGHT SIDE
2	2	1388551	PLATE, HINGE, NUT, M6
3	1	MMELH149	LATCH HANDLE
4	2	SHHPSLC845	HINGE,LH,DETACHABLE
5	4	SSFCM6X12	SCREW,FLAT ALLEN CAP



1388559 DOOR STOP/BUMPER ASSEMBLY

AAC Drawing Number 1388559 Rev0

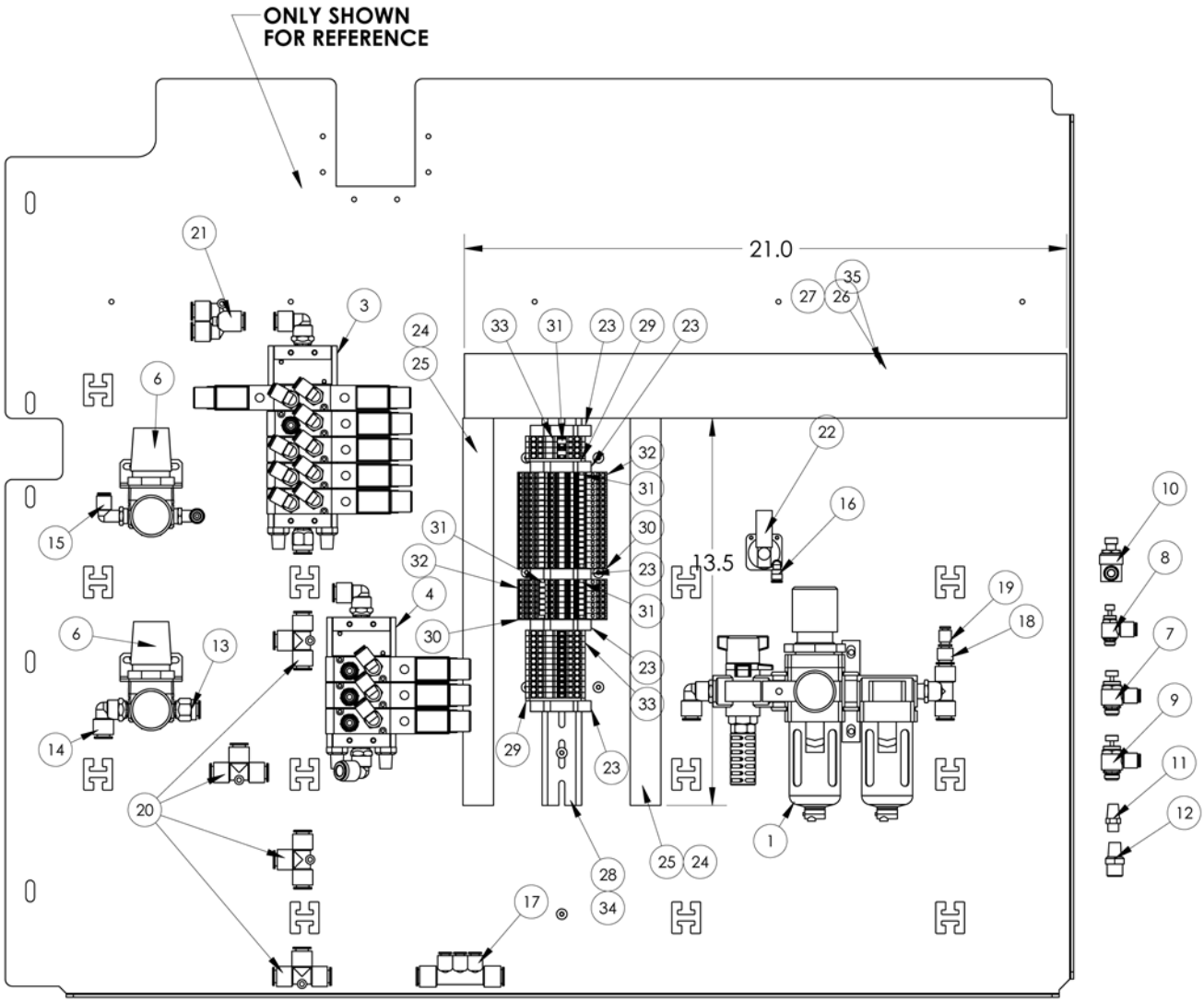
NO	QTY	PART #	DESCRIPTION
1	1	1388557	PLATE, DOOR STOP
2	1	MM9540K22	BUMPER, 3/4 DIA
3	1	NNHM4X0.7	NUT,HEX,M4-0.7
4	1	SSSCM4X16	SCREW,SOCKET CAP
5	2	SSZS93048	SCREW, SHT.METAL 10 ZIP
6	2	WWFM4.3	WASHER, FLAT, M4



1388594 BOTTON PANEL, ELEC, ASSEMBLY

AAC Drawing Number 1388594 Rev 4

NO	QTY	PART #	DESCRIPTION
1	1	1388595	BOTTOM PANEL, ELEC
2	2	EE64151B	FERRITE CORE,SPLIT,CABLE
3	2	EECLIPFIX	ANCHOR,DIN RAIL
4	2	EESD22208	MOTOR, STEPPER DRV, HYB
5	8"	EETS35X7.5A	DIN RAIL-AMERICAN
6	2	FFWMZT2C5	BREAKER,2P,5A,DIN,UL489
7	2	FFWMZT2C15	BREAKER,2P,15A,DIN,UL489
8	1	MM69915K72	STRAIN RELIEF, LIQ TIGHT
9	1	MMSL208S	DRIVE, VAR, FREQ. .75HP, 1PH
10	1	MMSM210S	DRIVE,1HP, INVERTER
11	2	SSBCM5X8	SCREW,BUTTON CAP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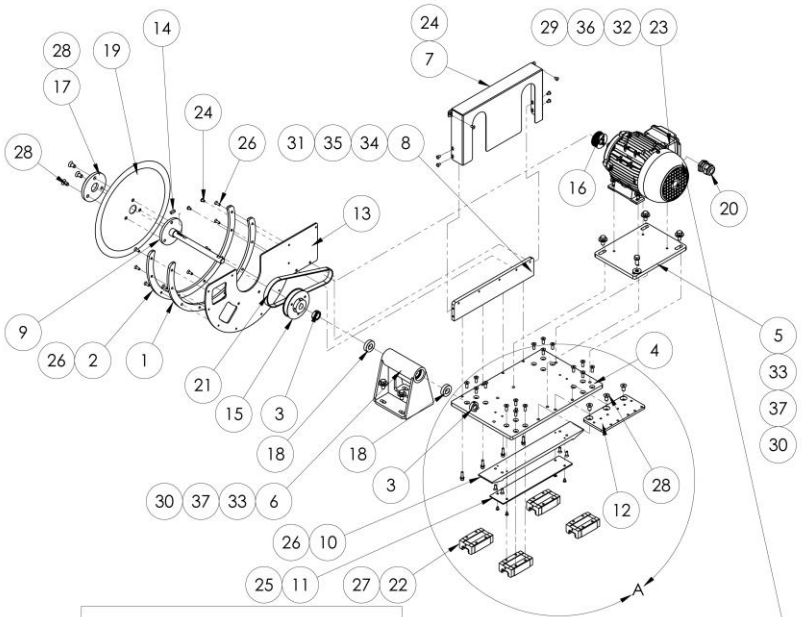
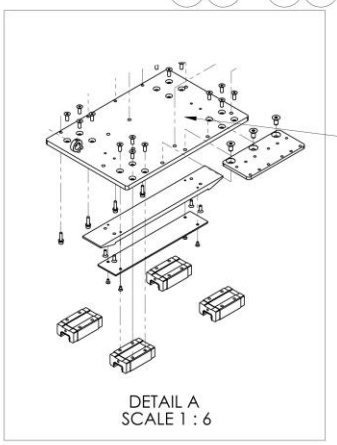
1388650 PNEUMATIC ASSEMBLY

AAC Drawing Number 1388650 Rev 2

NO	QTY	PART #	DESCRIPTION
1	1	1388335	FRL ASSEMBLY, 1393E
2	1	1388570	BACK PANEL, PNUEMATIC
3	1	1388653	SOLENOID,6 VALVE ASM
4	1	1388654	SOLENOID,4 VALVE ASM
5	9	1391160	CABLE ASSY,VALVE,DIN,3M
6	2	AA198-508	REGULATOR, 0-160 W/GAUGE
7	* 16	AA198RA404U	FLOW CONTROL,1/4PTX1/4
8	* 4	AA198RA408U	FLOW CONTROL,RC 1/8X1/4
9	* 2	AA198RR404U	FLOW CONTROL,1/4PTX1/4
10	* 2	AA3000F-07	FLOW CONTROL,INLINE,1/4"
11	* 2	AAFP18	MUFFLER,1/8 NPT, BRONZ
12	* 2	AAFP28	MUFFLER,1/4 NPT
13	1	AAQMC-3-4U	MALE CONNECTOR,3/8OD TUBE 1/4
14	1	AAQME-3-4U	MALE ELBOW,3/8OD TUBE 1/4
15	2	AAQME-4-4U	ELBOW, MALE,1/4X1/4NPT
16	1	AAQME-5-10	AIR ELBOW, 10-32 X 5/32
17	1	AAQMF-144	6-STATION AIR MANIFOLD
18	1	AAQPR-3-4	QUICK REDUCER 3/8-1/4
19	1	AAQPR-5-4	QUICK PLUG-IN REDUCER
20	4	AAQUT-3-3	QUICK UNION T3/8X3/8
21	1	AAQUY-3-3	QUICK UNION Y,3/8X3/8
22	1	AAVF51FM1B	AIR/ELEC PRESSURE SW
23	5	EECLIPFIX	ANCHOR,DIN RAIL
24	1.42 FT	EED78W308	DUCT,WIRE,.75 X .75
25	1.42 FT	EED78W332	DUCT,WIRE COVER,.75"
26	1.75 FT	EEDC2X2	COVER,WIRE DUCT
27	1.75 FT	EEDF2X2	DUCT,WIRE,2X2, MOD
28	13.50"	EETS35X7.5A	DIN RAIL-AMERICAN
29	2	FF280-308	TERMBLK ENDPLATE,WAGO,280
30	2	FF280-319	TERMBLK,WAGO,SENSOR,DIN
31	30	FF280-402	JUMPER,WAGO,TOP,SNGL
32	24	FF280-560	TERMBLK,WAGO,SENSOR,DIN
33	16	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY
34	12	SSBCM5X8	SCREW,BUTTON CAP
35	* 47"	ZZZSH-310	TAPE , DOUBLE SIDED

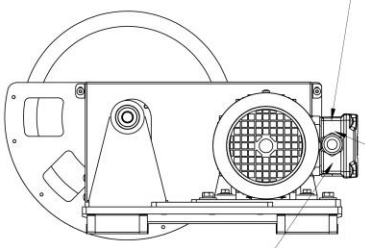




ASSEMBLY NOTES:
ASSEMBLE THESE PARTS ON THE LINEAR RAIL ON ASSEMBLY 1388665. TIGHTEN BEARINGS TO PLATE AFTER INSTALLING ON MACHINE.

ASSEMBLY NOTE:

1) PLEASE REMOVE AND ROTATE MOTOR FEET RIGHT 90°



REASSEMBLE MOUNTING FEET AS SHOWN PLEASE REMOVE FEET AND INSTALL IN ORIENTATION SHOWN WITH ELECRICAL BOX FACING AWAY FROM BLADE.

FEET CAN BE RELOCATED BY REMOVING TWO HEX CAP BOLTS FOR EACH FOOT.

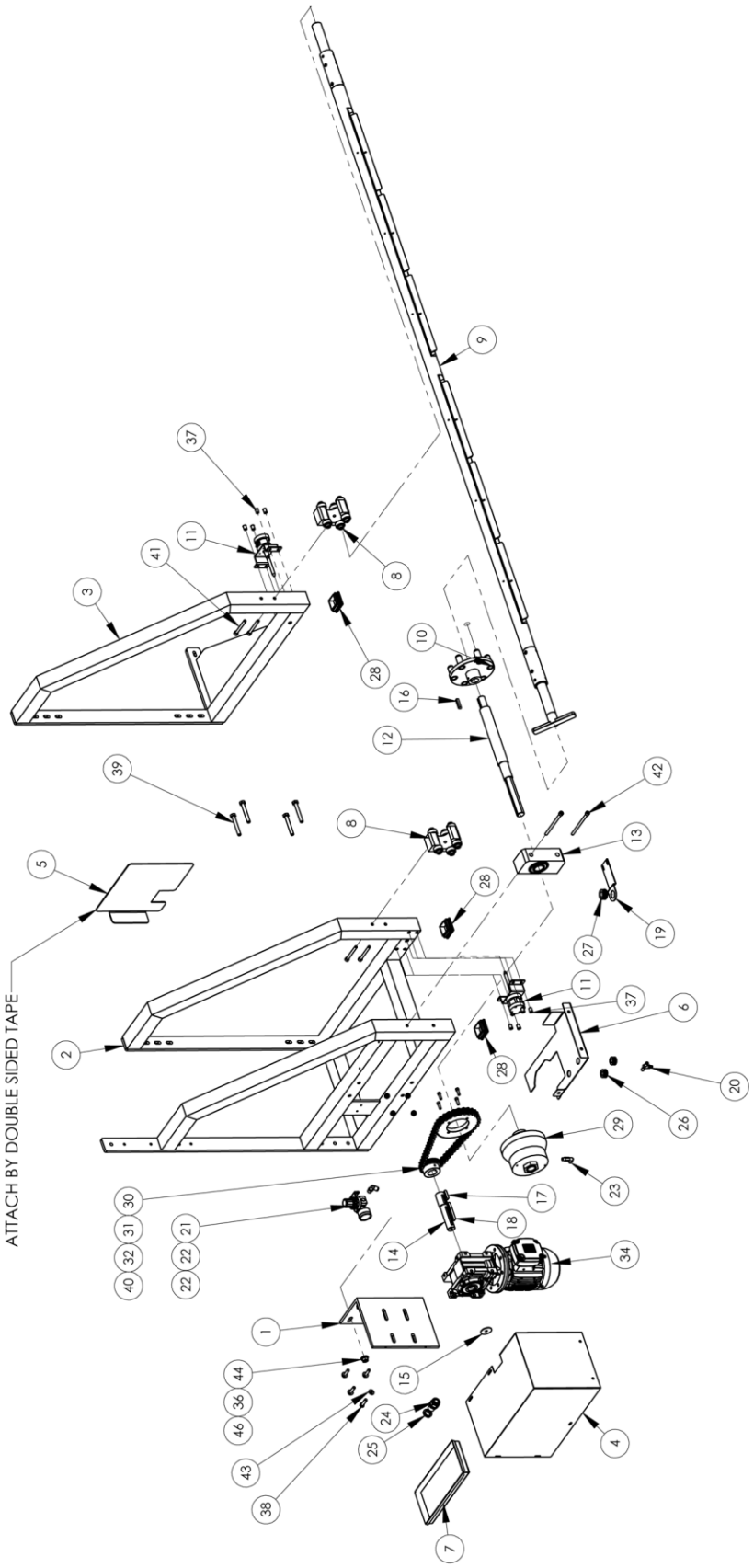
MOTOR IS SHOWN IN CORRECT ORIENTATION

Technical Manual & Part List

1388664 CROSS CUT ASSEMBLY

AAC Drawing Number 1388664 Rev 4

NO	QTY	PART #	DESCRIPTION
1	1	1388030	GUARD, BLADE, LOWER
2	1	1388031	GUARD, BLADE, LOWER
3	2	1388474	COLLAR, SET RETAINER
4	1	1388475	MOUNTING PLATE, CROSS CUT
5	1	1388476	MOTOR PLATE,X CUT
6	1	1388479	BEARING BLOCK, CROSS CUT
7	1	1388482	COVER, BELT, CROSS CUT
8	1	1388483	PLATE, BLADE GUARD XCUT
9	1	1388486	BLADE MOUNT, XCUT,WLDMNT
10	1	1388488	PLATE, PROX FLAG, XCUT
11	1	1388491	PLATE, PROX FLAG
12	1	1388492	PLATE, XCUT BELT DRIVE
13	1	1388737	GUARD, BLADE, CROSS CUT
14	1	1388761	KEY,5MMX5MMX.55IN
15	1	1389203	FLANGED PULLEY
16	1	1389895	PULLEY ASSY
17	1	1393390	HUB CAP, BLADE RETAINER
18	2	BB6002-ZZ	BEARING,BALL,.590B
19	1	CJ2090200	BLADE, 280MM SLITTER
20	1	EEPG16	CORD GRIP,CABLE ENTRY
21	1	GG220XL050UK	BELT,GEAR,KEVLAR CORE,URE
22	4	MMAGH25CAN	LINEAR BEARING
23	1	MMJW7124	MOTOR,IEC,1/2 HP,0.37 KW
24	8	SSBCM5X8	SCREW,BUTTON CAP
25	4	SSFCM4X8	SCREW,FLAT CAP,M4X8
26	12	SSFCM5X14	M5-0.8X14, FLAT ALLEN
27	16	SSFCM6X16	M6 X 20 FLAT ALLEN
28	6	SSFCM8X16	M8 X 16 FLAT CAP SCR
29	4	SSHCM6X16	SCREW, HEX M6X16
30	8	SSHCM8X20	SCREW,HEX CAP
31	4	SSSCM5X20	M5-0.8X20,SCREW,SOCKET CA
32	4	WWF1/4	WASHER, FLAT, 1/4", COM
33	8	WWF5/16	WASHER,FLAT,5/16
34	4	WWFM5	WASHER, FLAT, M5 I.D.
35	4	WWLM5	M5 LOCK WASHER
36	4	WWLM6	WASHER,LOCK,M6
37	8	WWLM8	M8 LOCK WASHER


ATTACH BY DOUBLE SIDED TAPE
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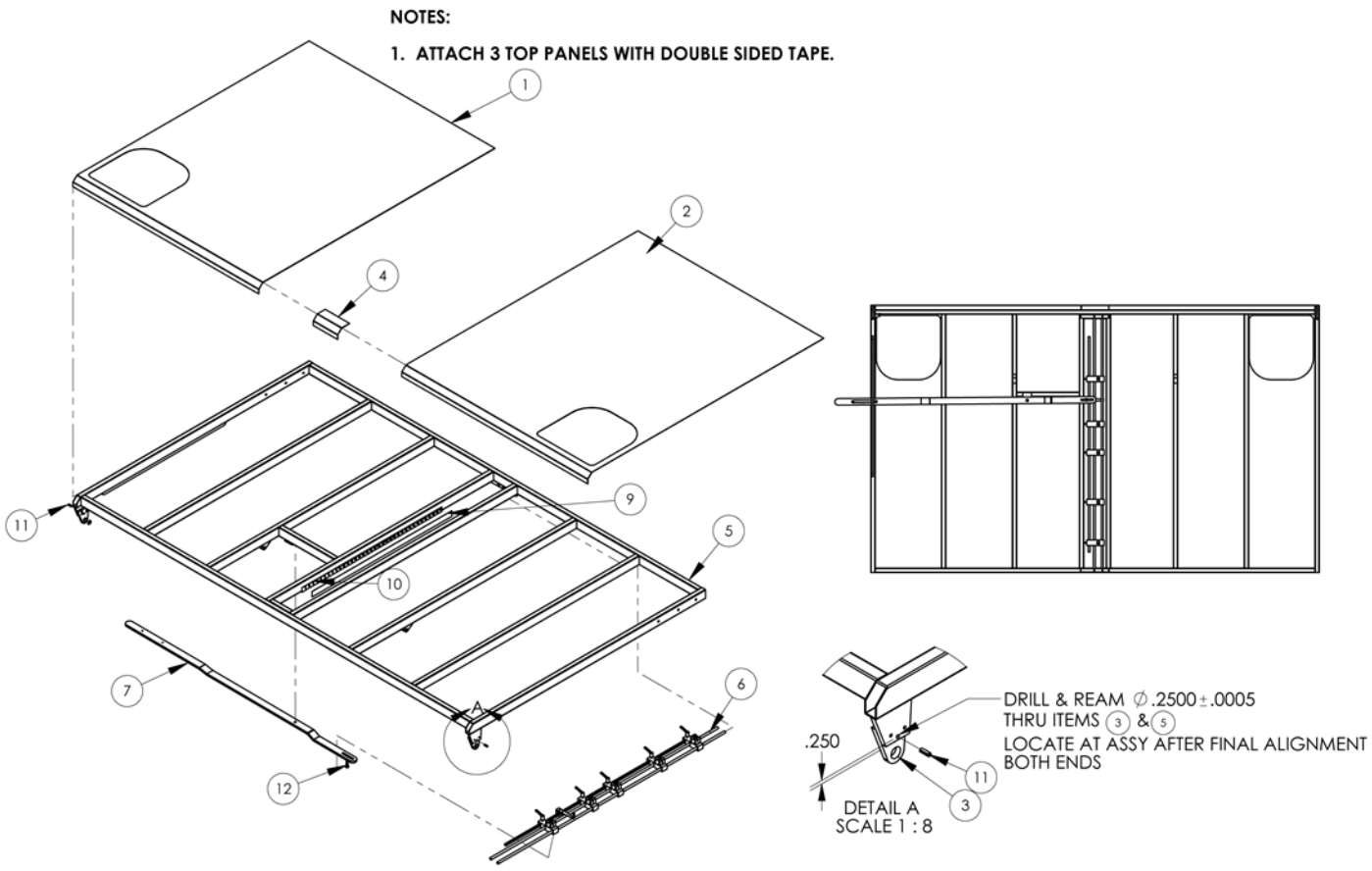
Technical Manual & Part List

1389245 WINDER ASSEMBLY

AAC Drawing Number 1389245 Rev10

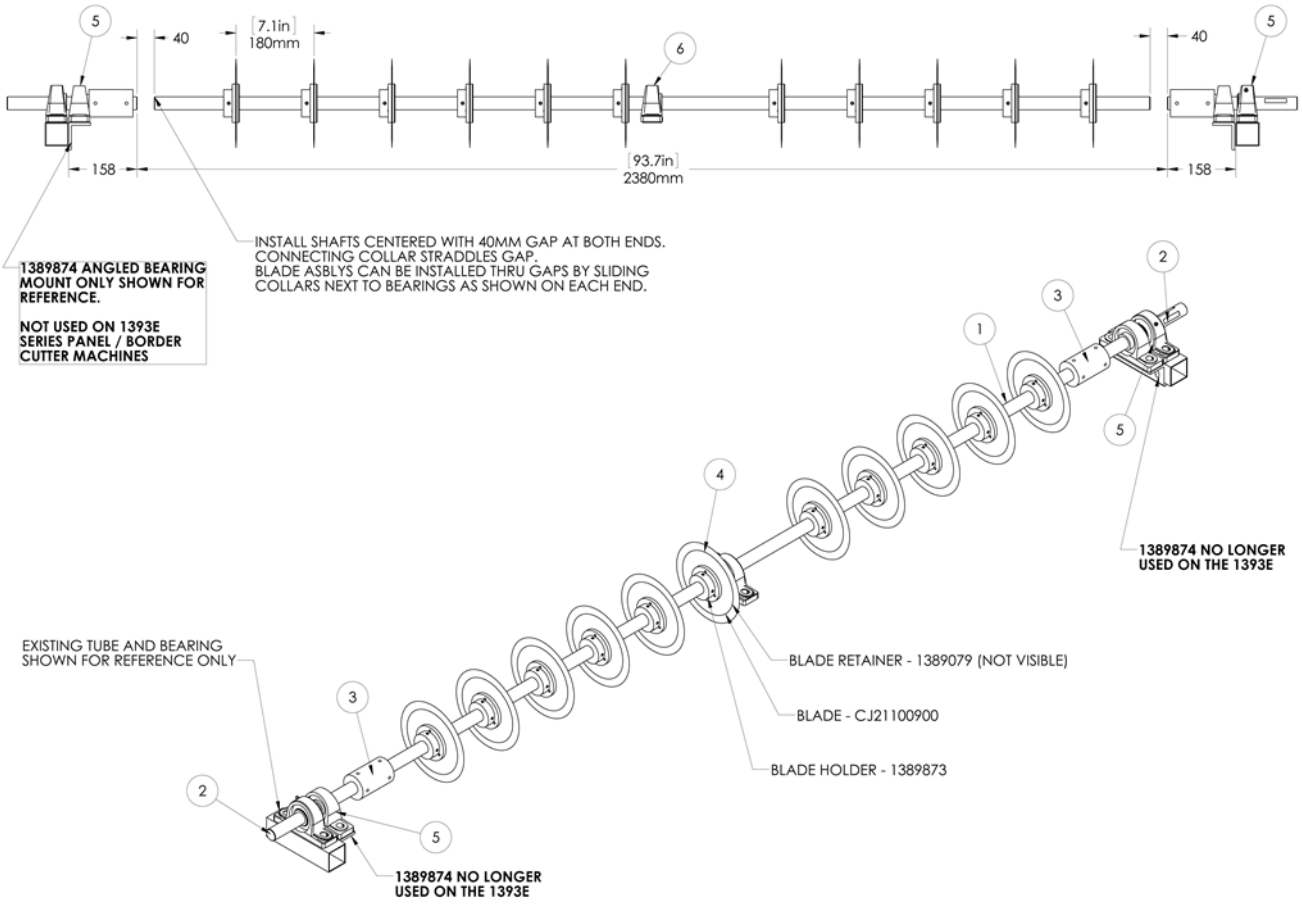
NO	QTY	PART #	DESCRIPTION
1	1	1961-331	MOUNT, MOTOR
2	1	1389241	DRIVE SUPPORT WELDMENT
3	1	1389250	ROD SUPPORT WELDMENT
4	1	1389261	COVER, MOTOR WINDER
5	1	1389263	BELT GUARD, INNER
6	1	1389472	CLOSURE PLATE,GUARD,LOWE
7	1	1389491	TRAY ASSEMBLY
8	2	1393058	CRADLE ASSY
9	1	1393139	TAKE UP DRIVE ROD
10	1	1393260	DRIVE DOG
11	2	1393301	TABLE LOCKING ASSY
12	1	1393333	CLUTCH SHAFT
13	1	1393334	BLOCK,BEARING,30MM
14	1	1393357	SHAFT, OUTPUT
15	1	1393364	RETAINER WASHER
16	1	1393366	KEY, DRIVE DOG
17	1	1393368	KEY, SMALL PULLEY
18	1	1393369	KEY, GEARMOTOR
19	1	1393491	BRKT,ANTI-ROTATION
20	1	AA2001F-03	FLOW CONTROL,INLINE,5/32
21	1	AAMSR20008	REG,0-140 W/GAUGE& BRKT
22	2	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT
23	1	AAQMEL-5-8	QUICK MALE ELBOW,LONG
24	1	FF3200	STRAIN RELIEF,1/2NPT
25	1	FF8463	NUT,LOCK,1/2NPT,NYLON,BLK
26	2	MM9307K63	GROMMET,1/2ID,13/16 HOLE
27	1	MM9307K69	GROMMET,5/8,1.125,.125GV
28	3	MM9565K8	DONT USE SEE MM9565K56
29	1	MM805275	CLUTCH,AIR,1.0 B,370 IN-L
30	*32"	MMD35	CHAIN,STL,DBL #35-2X32IN
31	1	MMD35B22M1	SPROCKET,22T,DBL,NO35
32	1	MMD35B48M1	SPROCKET,48T,DBL,NO35, MO
33	1	MMD35CL	MASTER LINK,DBL,#35 CHAIN
34	1	MMRV0501-30	MOTOR,GEARBOX,0.37KW,3PH
35	4	NNHM8X1.25	M8 X 1.25 HEX NUT
36	4	NNHM10X1.5	NUT,HEX,M10X1.5
37	8	RNM6-420	NUT,RIVET,M6-1.0
38	4	SSHCM8X30	SCREW,HEX CAP M8X30
39	4	SSHCM10X75	SCREW,HEX CAP,M10-1.5X70
40	4	SSSC01048	1/4-20 X 3/4" SOC CAP SC
41	4	SSSCM8X70	SCREW,SOC CAP,M8X25
42	2	SSSCM8X120	SOCKET HEAD SCREW M8x120
43	4	WWF1/4	WASHER, FLAT, 1/4", COM
44	4	WWFM10	WASHER, FLAT, M10 I.D.
45	4	WWLM8	M8 LOCK WASHER
46	4	WWLM10	M10 LOCK WASHER



1389258 PANEL TABLE ASSEMBLY

AAC Drawing Number 13589258 Rev 3

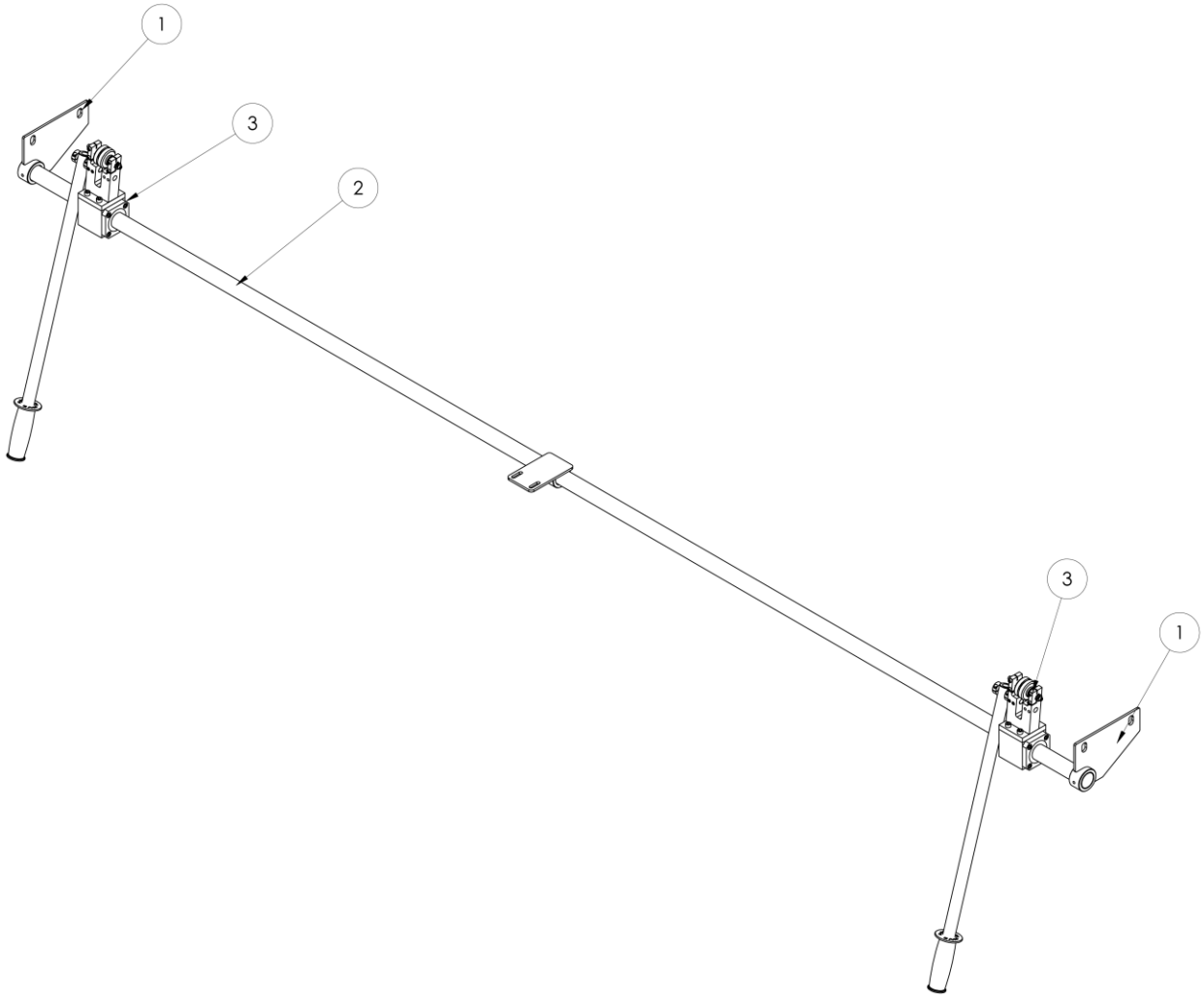
NO	QTY	PART #	DESCRIPTION
1	1	1389256	TOP PANEL, RIGHT
2	1	1389259	TOP PANEL, LEFT
3	2	1389706	PIVOT, TABLE
4	1	1393091	TOP PANEL, CENTER
5	1	1393095	EXIT TABLE WELDMENT
6	1	1393125	EYE ADJUSTMENT ASSY
7	1	1393300	LEVER, EYE ADJUSTMENT
8	* 4	BBTRA613	WASHER,THRUST,STL, .375B
9	1	MM1910A23M	RULER,SILVER MYLAR 36"
10	1	MM1910A43M	RULER,SILVER MYLAR 36"
11	2	MM98296A924	PIN,ROLL,1/4"X3/4"
12	2	SSAS024032	SHULDER BOLT 3/8 X .50L



1389860 SLITTER ASSEMBLY, SPLIT SHAFT

AAC Drawing Number 1389860 Rev3

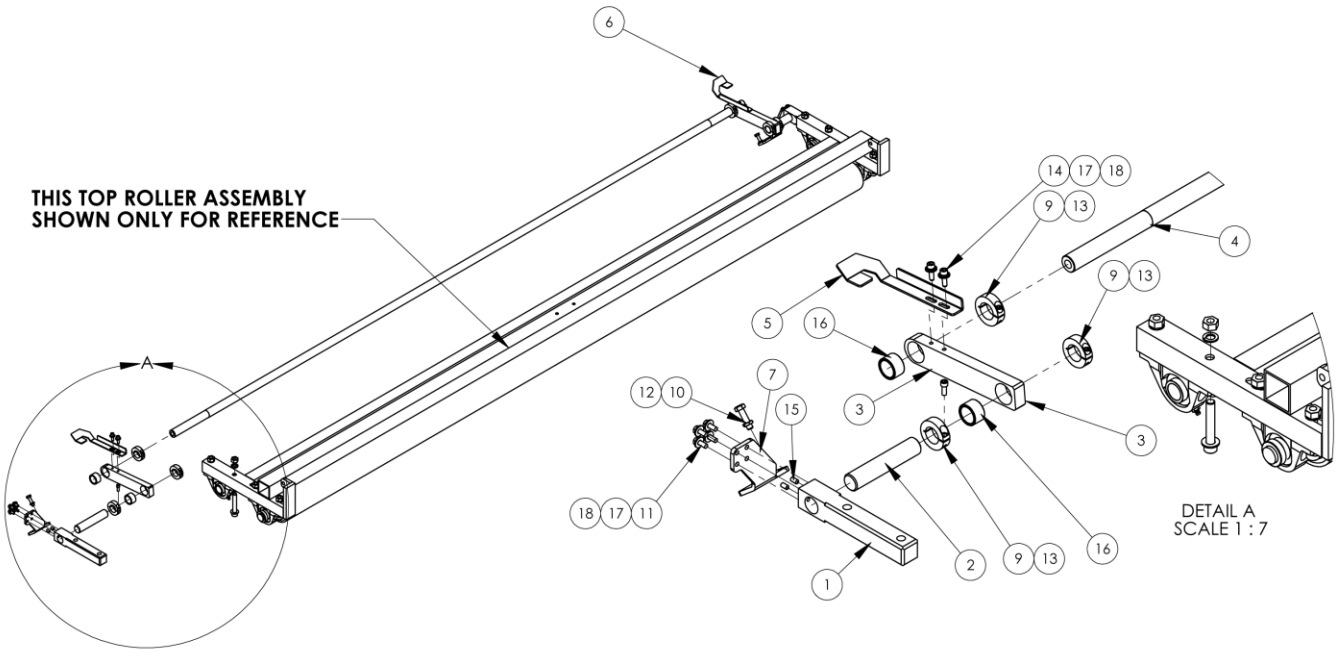
NO	QTY	PART #	DESCRIPTION
1	1	1389857	DRIVE SHAFT,30MM X 2300MM
2	2	1389858	DRIVE SHAFT, 30MM X 300MM
3	2	1389859	COUPLING,30MM X 4 IN
4	11	1393149	BSW SLITTER ASSEMBLY
5	5	BBUCP206	BEARING, PILLOWBLOCK



1389896 SLITTER SHARPENER ASSEMBLY

AAC Drawing Number 1389896 Rev 1

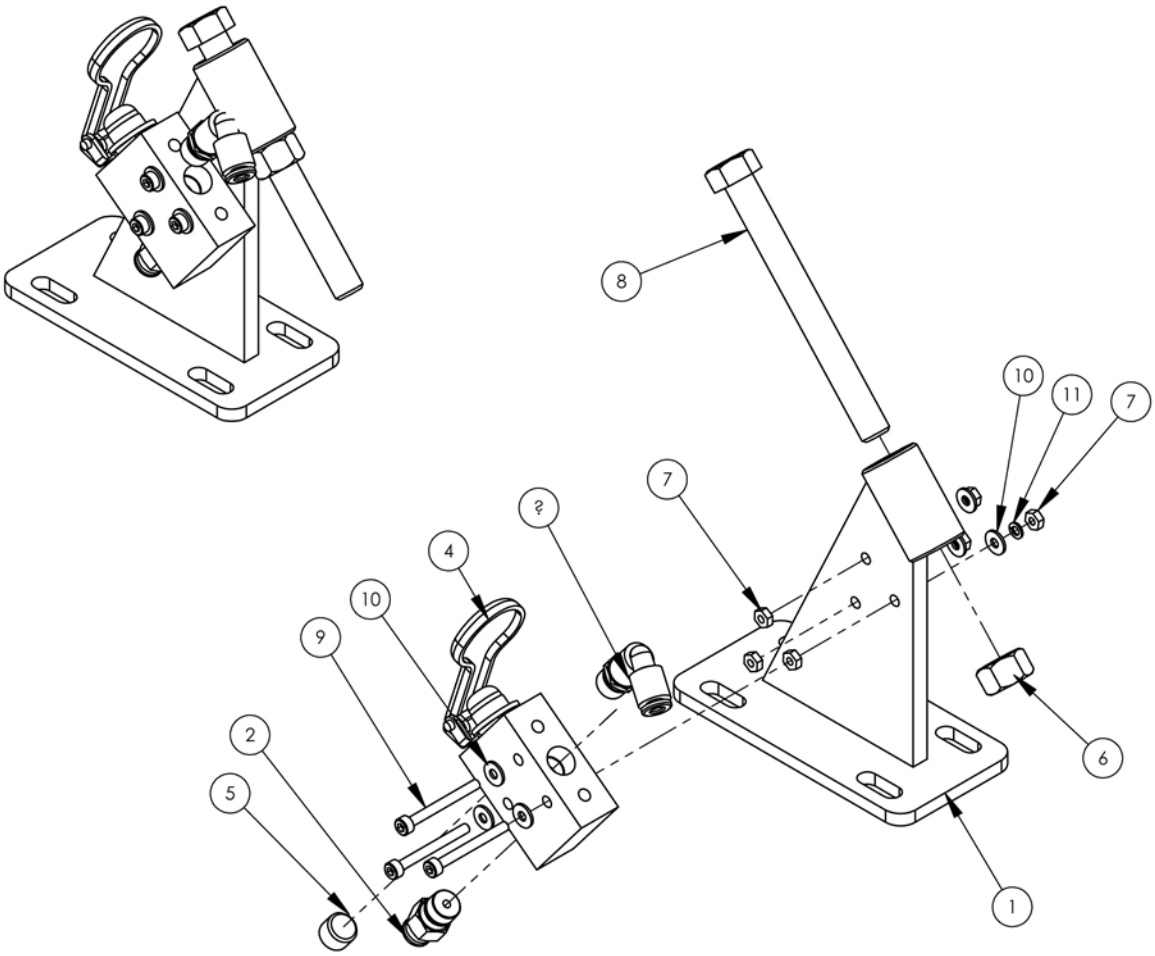
NO	QTY	PART #	DESCRIPTION
1	2	1389875	MOUNT, END, 30MM SHAFT
2	1	1389877	ROD,30MMX2720,60 CASE
3	2	1389884	SHARPENER ASBLY, SLITTERS



1393-KIT06 WEIGHTED SLITTER BAR ASSEMBLY

AAC Drawing Number 9002643 Rev 1

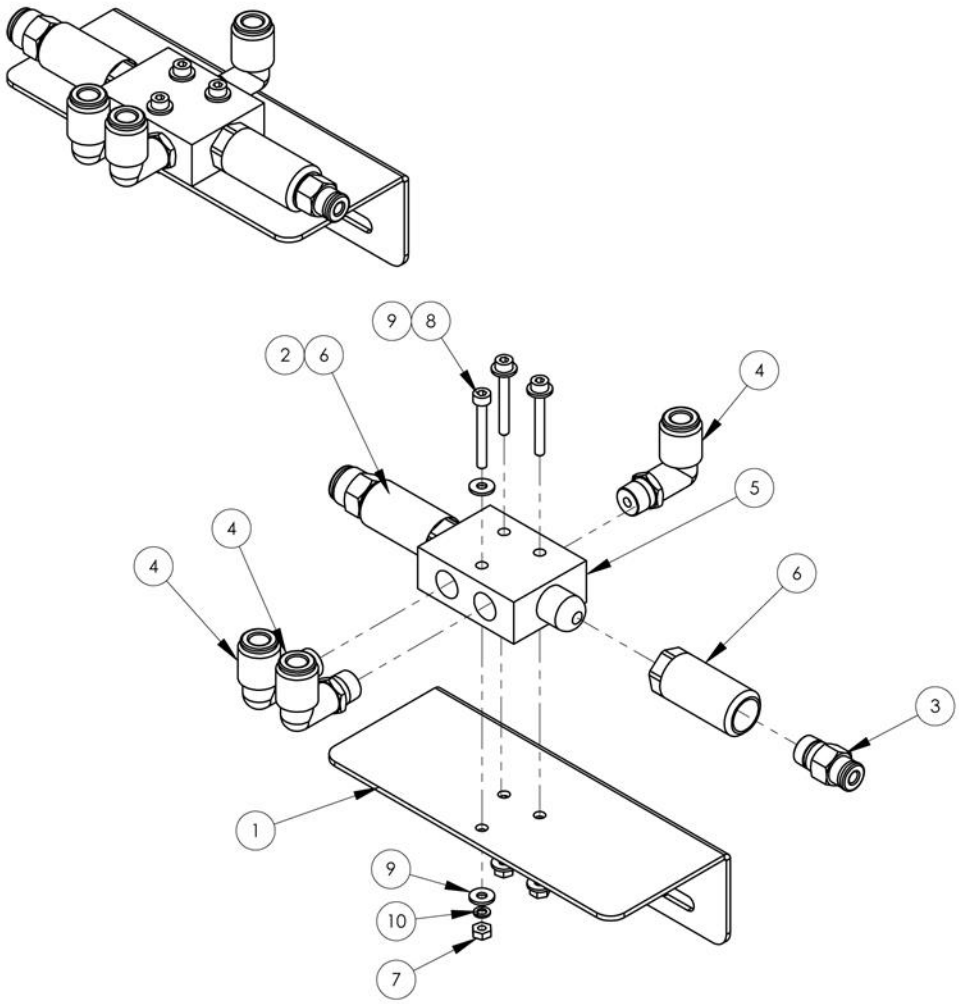
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	2	1388141	MOUNT, PIVOT SHAFT	10	2	NNJM8	NUT,JAM,M8,ZINC PLATED
2	2	1388142	SHAFT, STUB, 1" X 5"	11	8	SSHCM6X16	SCREW , HEX M6X16
3	2	1388143	ARM, SLITTER WEIGHTED BAR	12	2	SSHCM8X30	SCREW ,HEX CAP M8X30
4	1	1388144	BAR, WEIGHTED	13	6	SSSC05032	1/4-28 X 1/2, SOC CAP
5	1	1388145	PLATE, SUPPORT, BAR	14	4	SSSCM6X20	M6 X 20, SOC CAP
6	1	1388146	PLATE, SUPPORT, BAR	15	4	SSSSM6X12	M6 SET SCREW , 12MM L
7	1	1388677	PLATE, WEIGHTED BAR STOP	16	4	UUAA102-6	BEARING,BRZ, 1.003ID 1.254OD .75L
8	1	1388678	PLATE, WEIGHTED BAR STOP	17	12	WWFS1/4	WASHER,FLAT,SAE,1/4
9	6	CCCL16F	COLLAR,1" CLAMP TYPE	18	12	WWL1/4	WASHER,LOCK, 1/4



1393310 TABLE STOP ASSEMBLY

AAC Drawing Number 1393310 Rev 1

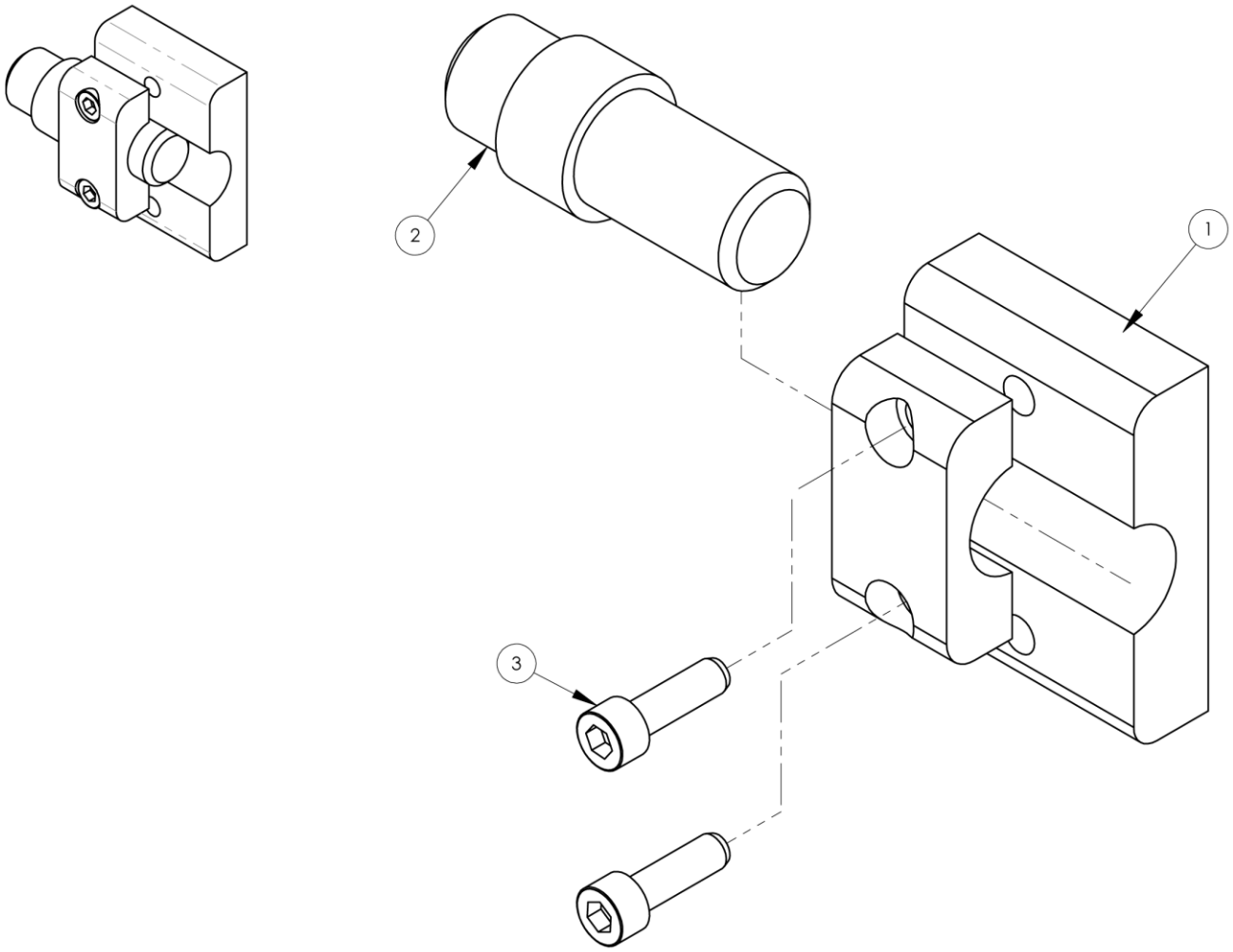
NO	QTY	PART #	DESCRIPTION
1	1	1393240	ARM STOP WELDMENT
2	1	AAQMC-5-8	QU. MALE CONN 5/32X1/8
3	1	AAQME-5-8	QUICK MALE ELBOW
4	1	AAV41-P34T	VALVE,SPOOL,4-WAY
5	1	MM4554K11	PLUG, 1/8" PIPE
6	1	NNH3/8-16	3/8-16 HEX NUT
7	6	NNHM3X0.5	NUT,HEX,M3-0.5
8	1	SSHC25224F	3/8-16 X 3-1/2 HEX HEAD FULL THD
9	3	SSSCM3X30	M3-0.5 X 30 SOC CAP
10	6	WWF4	WASHER, FLAT #4
11	3	WWL4	#4 LW



1393312 LOCK PIN VALVE ASSEMBLY

AAC Drawing Number 1393312 Rev 1

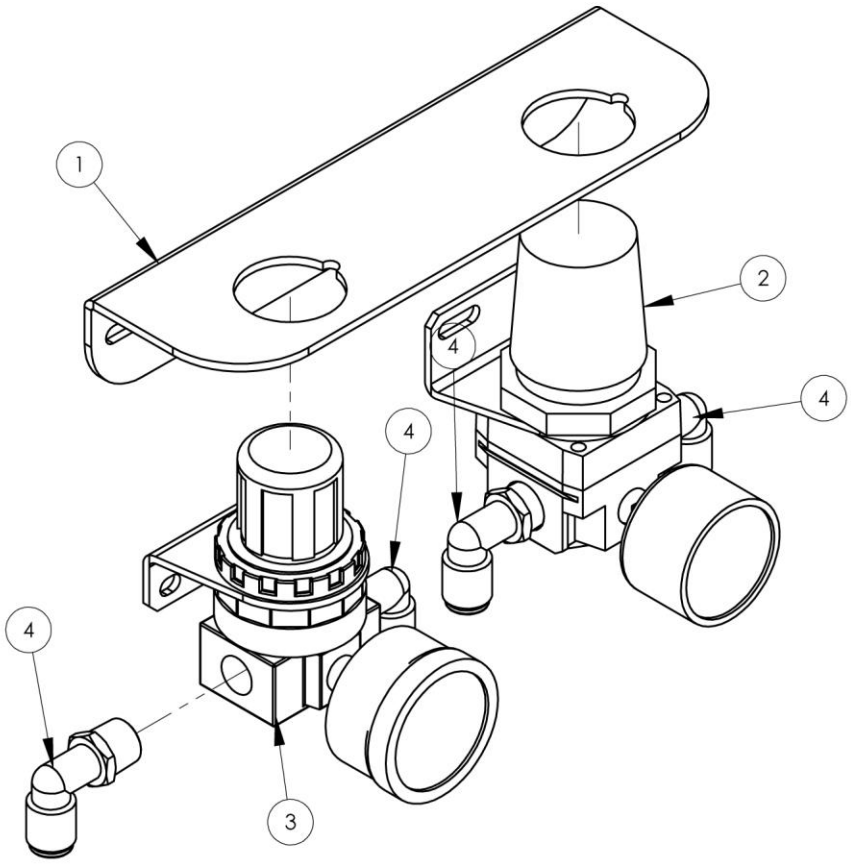
NO	QTY	PART #	DESCRIPTION
1	1	1393311	MOUNTING BRACKET
2	1	AAQMC-4-8	QUICK MALE CONNECT
3	1	AAQMC-5-8	QU. MALE CONN 5/32X1/8
4	3	AAQME-4-8	QUICK MALL ELBOW , 1/4 T
5	1	AAV41-PP	HUMPHREY VALVE,4 WAY
6	2	AAV341A	HUMPHREY VALVE
7	3	NNHM3X0.5	NUT,HEX,M3-0.5
8	3	SSSCM3X25	SCREW ,SOCKET CAP,M3 X 30MM
9	6	WWF4	WASHER, FLAT, #4
10	3	WWL4	WASHER,LOCK,#4



1393360 TABLE PIVOT ASSEMBLY

AAC Drawing Number 1393360 Rev 0

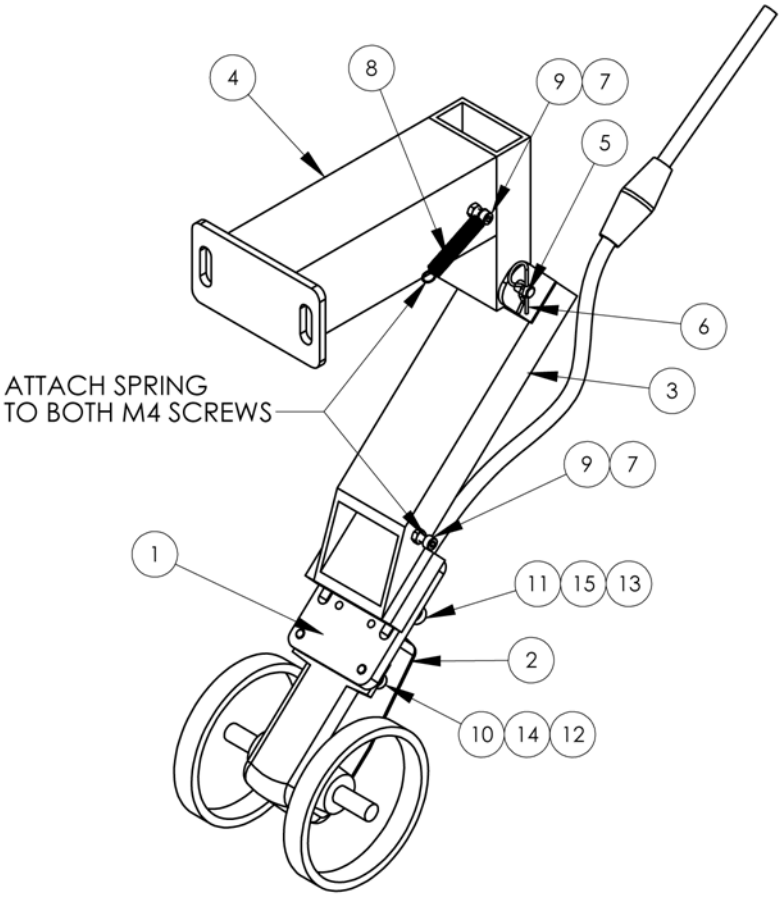
NO	QTY	PART #	DESCRIPTION
1	1	1393358	PIVOT BLOCK, TABLE
2	1	1393359	PIVOT PIN, TABLE
3	2	SSSCM6X20	M6 X 20, SOC CAP



1393394 KNIFE SHARPENER, REG. ASSEMBLY

AAC Drawing Number 1393394 Rev 5

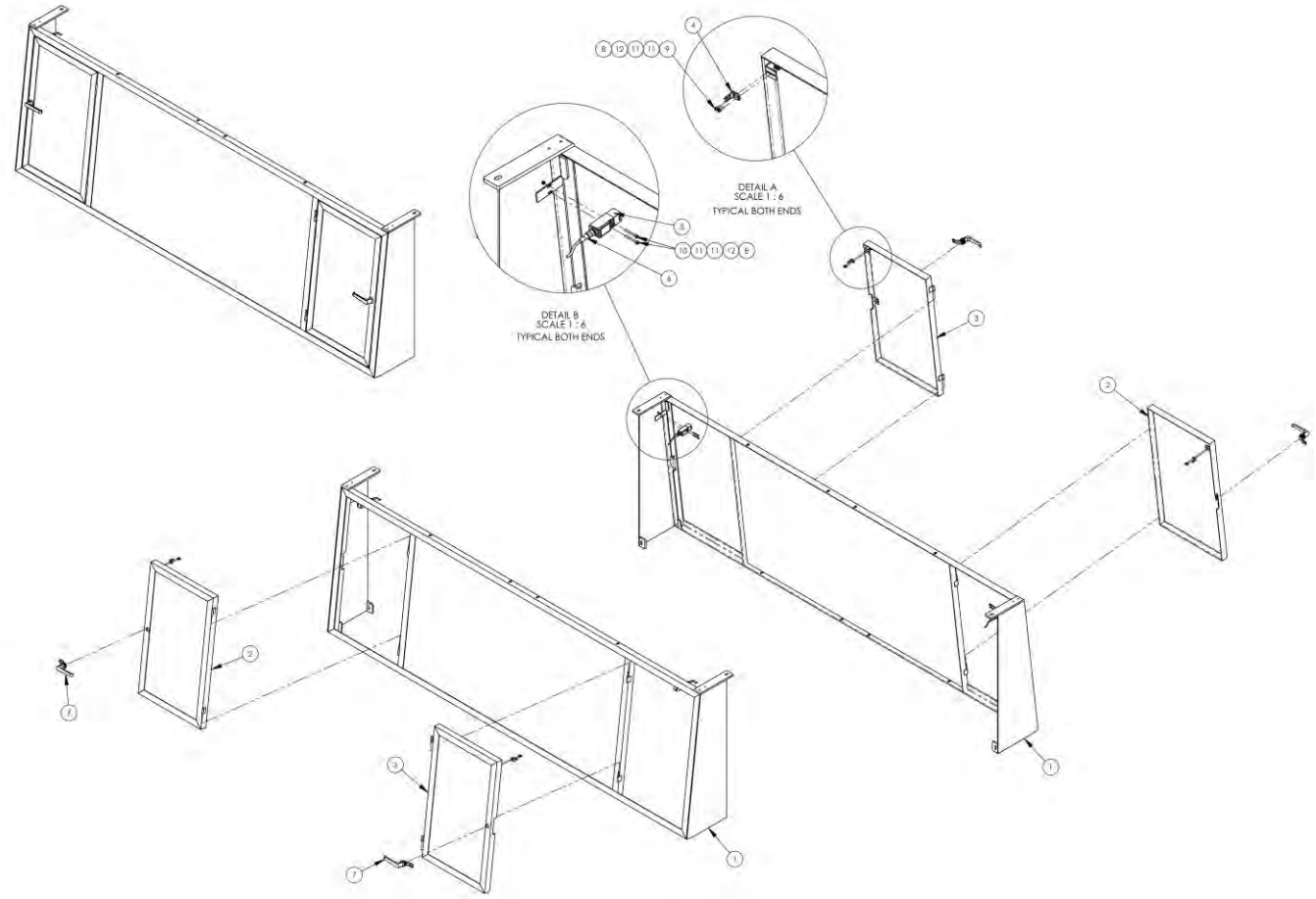
NO	QTY	PART #	DESCRIPTION
1	1	1393392	BRACKET, VALVE MOUNTING
2	1	AA198-508	REGULATOR, 0-160 W/GAUGE
3	1	AAMSR20008	REG,0-140 W/GAUGE& BRKT
4	4	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT



1393676 ENCODER ASSEMBLY

AAC Drawing Number 1393676 Rev 4

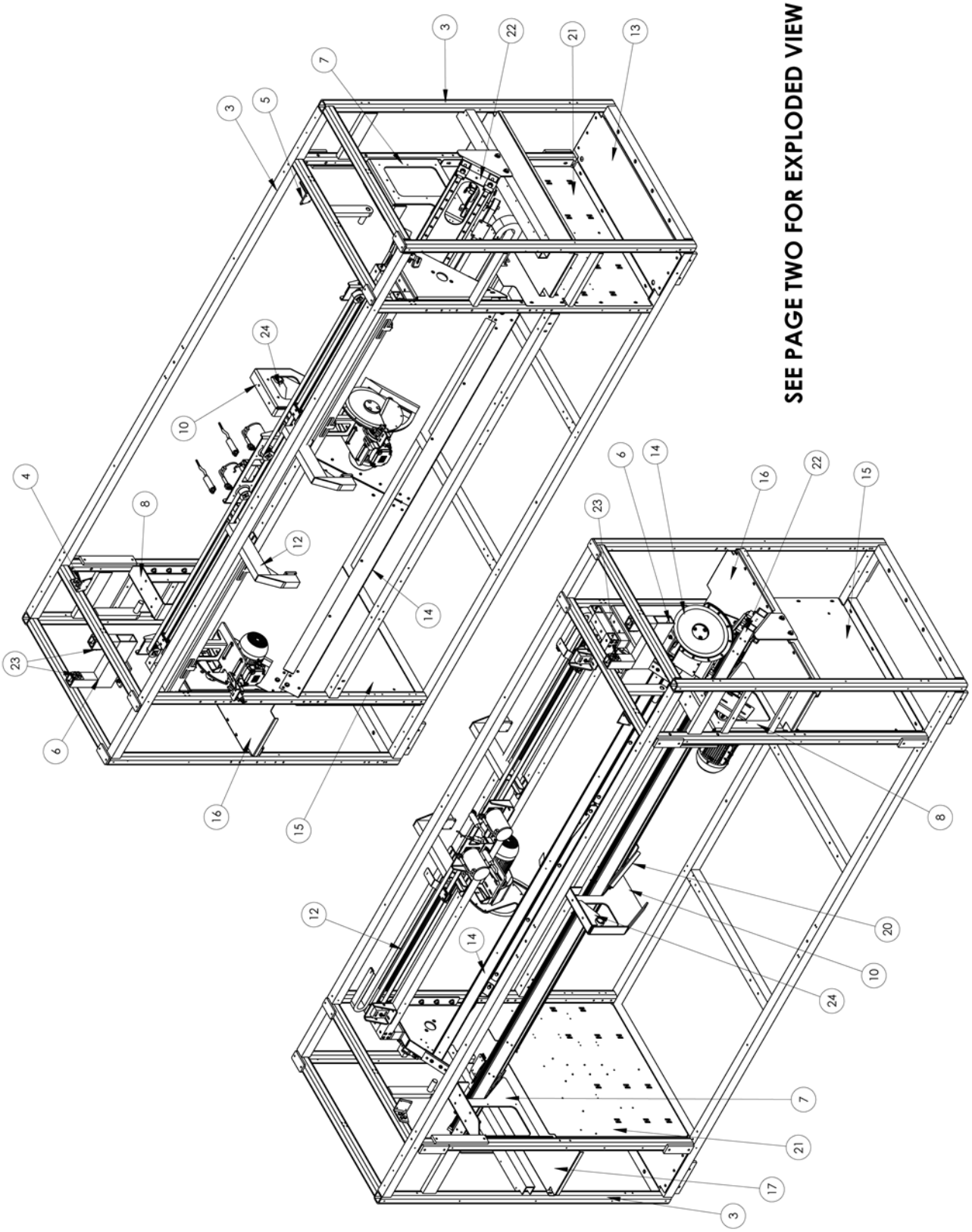
NO	QTY	PART #	DESCRIPTION
1	1	1388420	PLATE, ENCODER MOUNT
2	1	1389794	CABLE, ENCODER, ASSEMBLY
3	1	1393668	COUNTER ARM, MOVING
4	1	1393670	BRACKET, STAND-OFF WELD
5	1	1393675	PIVOT PIN ASSEMBLY
6	1	MM98335A04	SPRING CLIP, .06 WIRE
7	2	NNHM4X0.7	NUT,HEX,M4-0.7
8	1	RRLE030CD7	SPRING,EXT,.030X.31X2.0
9	2	SSSCM4X16	SCREW ,SOCKET CAP
10	2	SSSCM5X16	M5-0.8 X 16,SOC CAP SCR
11	2	SSSCM6X16	M6 X 16, SOC CAP
12	2	WWFM5	WASHER, FLAT, M5 I.D.
13	2	WWFM6	WASHER, FLAT, M6, SAE
14	2	WWLM5	M5 LOCK WASHER
15	2	WWLM6	WASHER,LOCK,M6

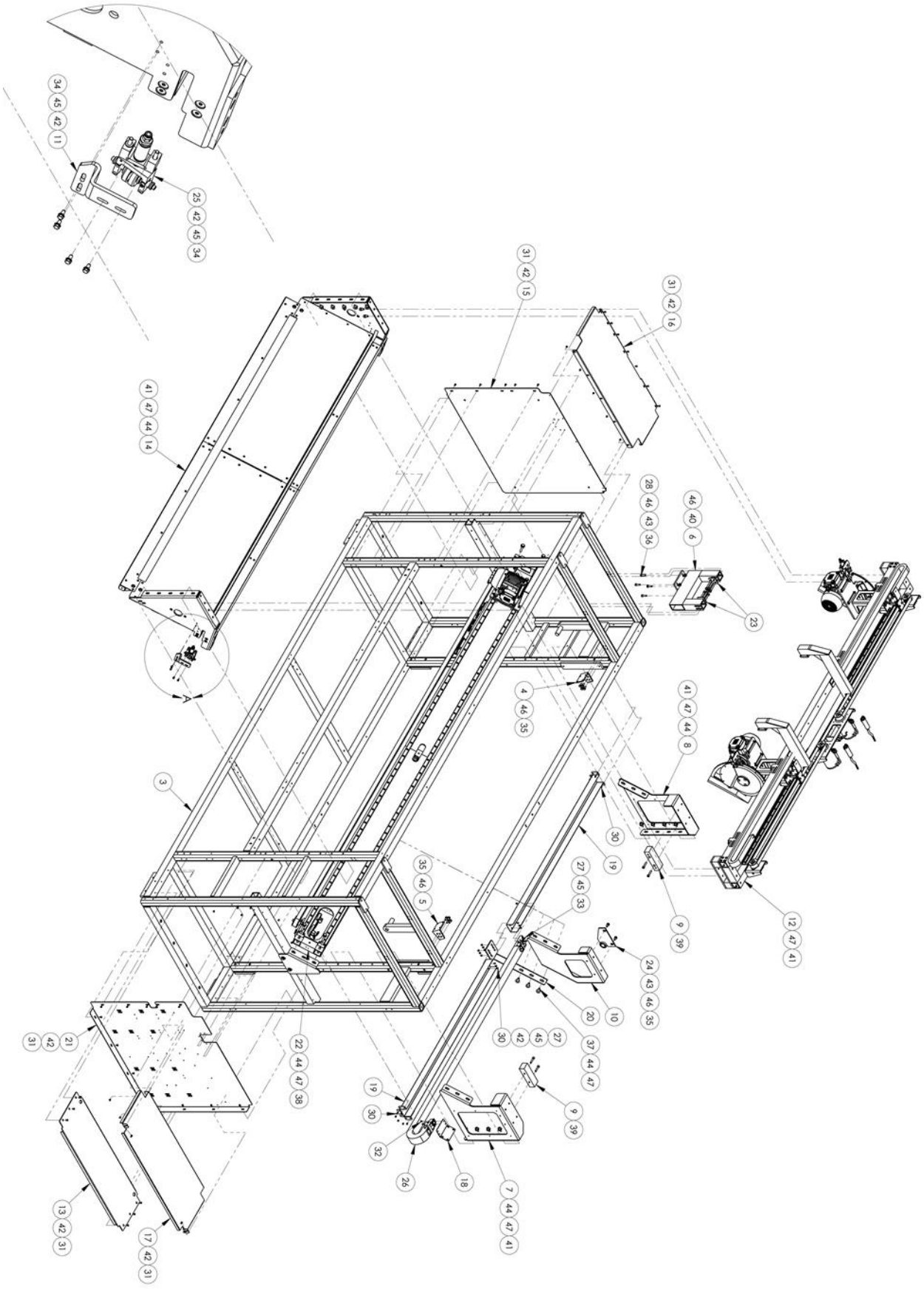


1393770 REAR GUARD ASSEMBLY

AAC Drawing Number 1393770 Rev 2

NO	QTY	PART #	DESCRIPTION
1	1	1393762	UPPER REAR GUARD WELD
2	1	1393763	DOOR,GUARD,LH
3	1	1393764	DOOR,GUARD,RH
4	2	EE140180	ACTUATOR, 90 DEGREE
5	2	EE1222002	SWITCH,SAFETY,DOOR 2 N.C.
6	2	FFRK44T-6	CABLE,EYE,19',NO END
7	2	MMELH149	LATCH HANDLE
8	8	NNH6-32	NUT,HEX,6-32
9	4	SSSC80032	6-32 X 1/2 SOC CAP SC
10	4	SSSC80096	6-32 X 1-1/2 SOC CAP SC
11	16	WWFS6	WASHER, FLAT, #6
12	8	WWL6	WASHER,LOCK,#6


SEE PAGE TWO FOR EXPLODED VIEW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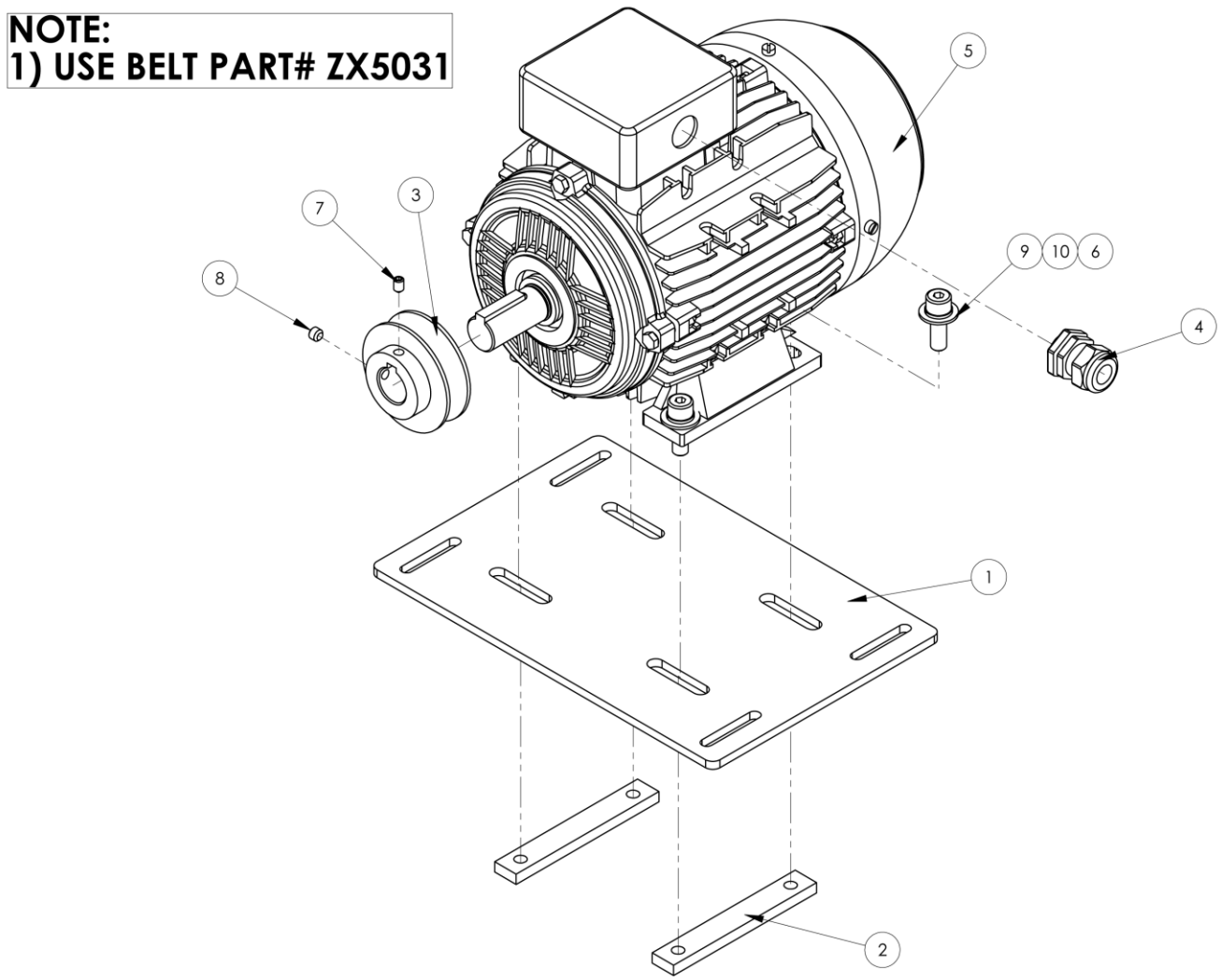
1388233 FRAME ASSEMBLY

AAC Drawing Number 1388233 Rev 4

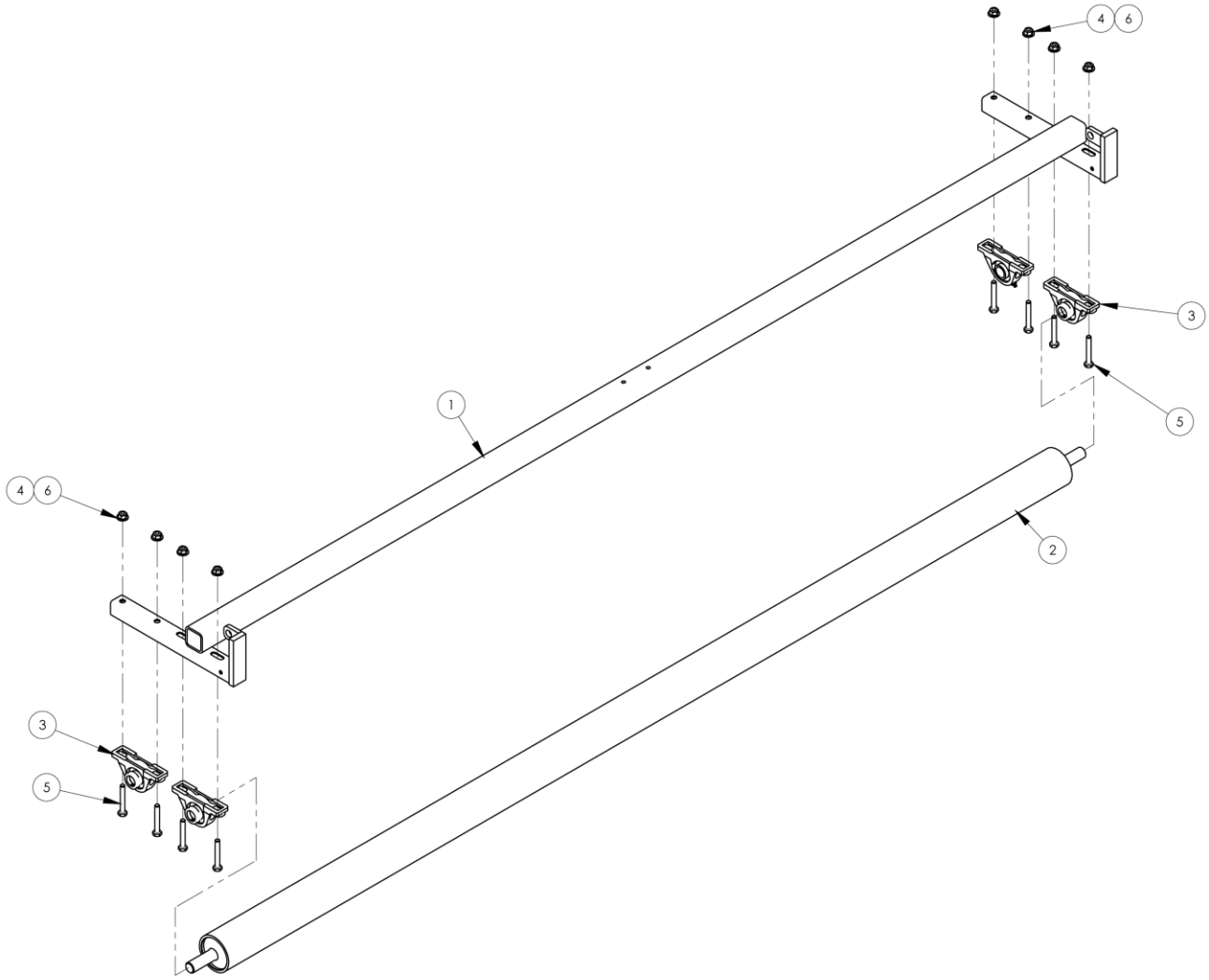
NO	QTY	PART #	DESCRIPTION
1	1	1386774	BRACKET,SLITTER MOUNT,LH
2	1	1386776	BRACKET,SLITTER MOUNT,RH
3	1	1388235	FRAME, ASSEMBLY WELDMNT
4	1	1388253	CYLINDER MOUNT,LH
5	1	1388254	CYLINDER MOUNT,RH
6	1	1388257	MOTOR MOUNT WELDMENT
7	1	1388260	BRACKET,SLITTER MOUNT,RH
8	1	1388261	BRACKET,SLITTER MOUNT,LH
9	2	1388265	BLOCK, SHARPENER SPACER
10	1	1388266	BRACKET,SLITTER MOUNT,CTR
11	1	1388334	BRACKET, SHARPENER, LH
12	1	1388385	SIDE TRIM RAIL ASSEMBLY
13	1	1388511	BOTTOM PANEL, PNEUMATIC
14	1	1388530	CUT TABLE ASSEMBLY
15	1	1388552	BACK PANEL, ELECTRICAL
16	1	1388553	PANEL, CNTRL TOP
17	1	1388554	PANEL, PNEUMATIC TOP
18	1	1388563	PLATE, CABLE TRACK MOUNT
19	2	1388564	CHANNEL,CABLE TRACK,XCUT
20	1	1388565	BRACKET, CENTER,CABLE TRK
21	1	1388570	BACK PANEL, PNUEMATIC
22	1	1388665	XCUT ASSEMBLY,1393E
23	2	1388669	PLATE, NUT, 1393E
24	1	1389875	MOUNT, END, 30MM SHAFT
25	1	1393029	SLITTER SHARPENER ASSY
26	1	MM45021-45	DUCT,WIRE PLASTITRAK
27	8	NNHM5X0.8	NUT,HEX,M5-0.8
28	4	NNHM8X1.25	M8 X 1.25 HEX NUT
29	4	NNHM10X1.5	NUT,HEX,M10X1.5
30	39	SSBCM5X8	SCREW,BUTTON CAP
31	41	SSBCM5X12	SCREW,BUTTON CAP
32	2	SSFCM5X10	SCREW,FLAT ALLEN CAP
33	2	SSFCM5X14	M5-0.8X14, FLAT ALLEN
34	4	SSHCM5X12	SCREW, HEX CAP
35	10	SSHCM8X20	SCREW,HEX CAP
36	4	SSHCM8X30	SCREW,HEX CAP M8X30
37	7	SSHCM10X35	SCREW,HEX CAP M10X35
38	4	SSHCM10X70	SCREW,HEX CAP,M10-1.5X70
39	4	SSSCM8X40	SCREW,SOC CAP,M8X40
40	8	SSSCM8X70	SCREW,SOC CAP,M8X25
41	24	SSSCM10X20	CAP SCREW 10MM X 20MM
42	61	WWFM5	WASHER, FLAT, M5 I.D.
43	6	WWFM8	WASHER, FLAT, M8 I.D.
44	35	WWFM10	WASHER, FLAT, M10 I.D.
45	12	WWLM5	M5 LOCK WASHER
46	22	WWLM8	M8 LOCK WASHER
47	35	WWLM10	M10 LOCK WASHER



1388276 SLITTER, MOTOR DRIVE ASSEMBLY

AAC Drawing Number 1388276 Rev 1

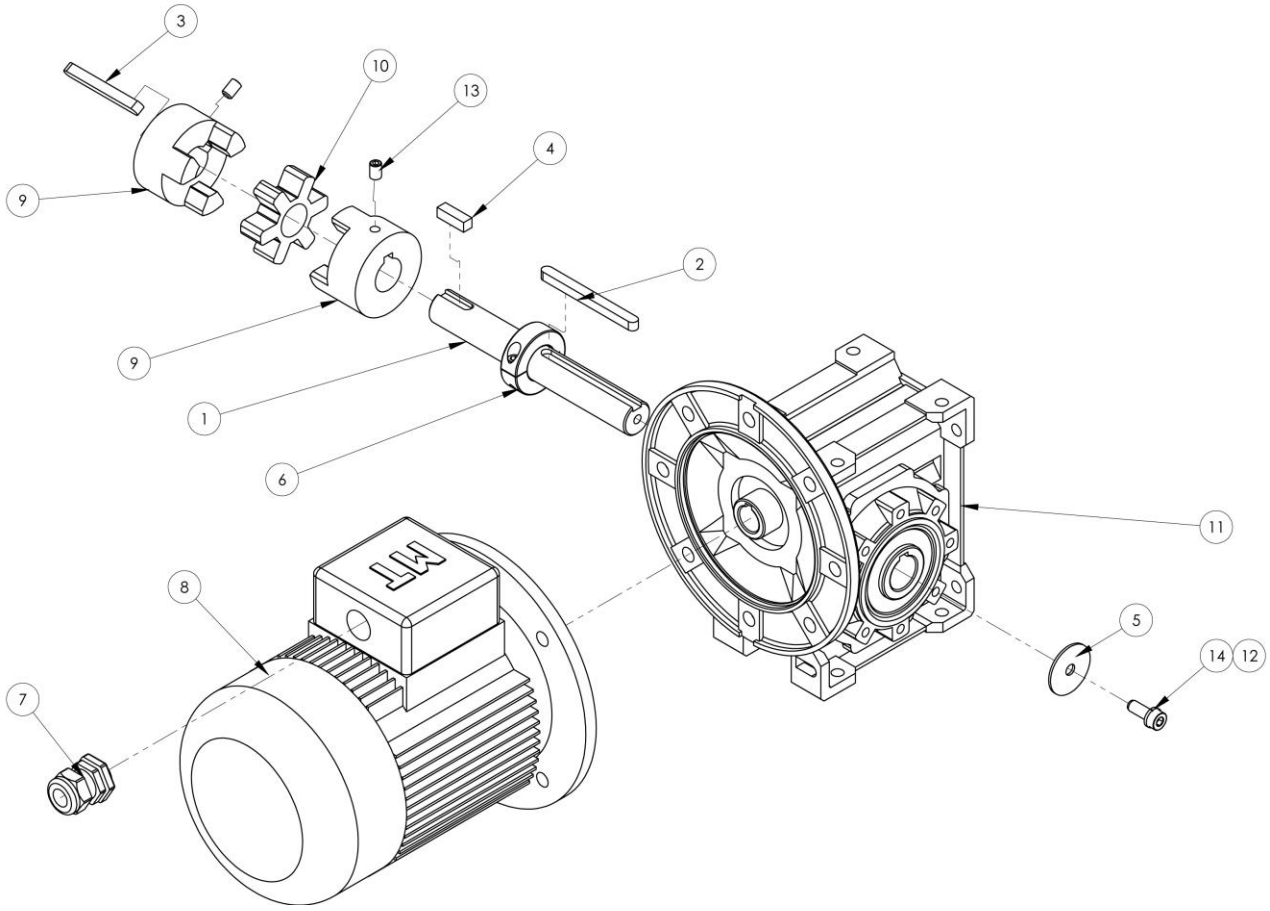
NO	QTY	PART #	DESCRIPTION
1	1	1388263	PLATE, MOTOR MOUNT
2	2	1388264	NUT PLATE,MOTOR MOUNT
3	1	1389606	PULLEY, SLITTER MOTOR
4	1	EEPG16	CORD GRIP,CABLE ENTRY
5	1	MM90S11B3	MOTOR,1.1KW,IEC,B3,1.5HP
6	4	SSSCM10X30	10M X 30MM, SOC CAP
7	1	SSSS01024	SCREW, SET, 1/4-20 X 3/8
8	1	SSSS10016	5/16-18X1/4 SET SC
9	4	WWFM10	WASHER, FLAT, M10 I.D.
10	4	WWLM10	M10 LOCK WASHER



1388317 TOP ROLLER ASSEMBLY

AAC Drawing Number 1388317

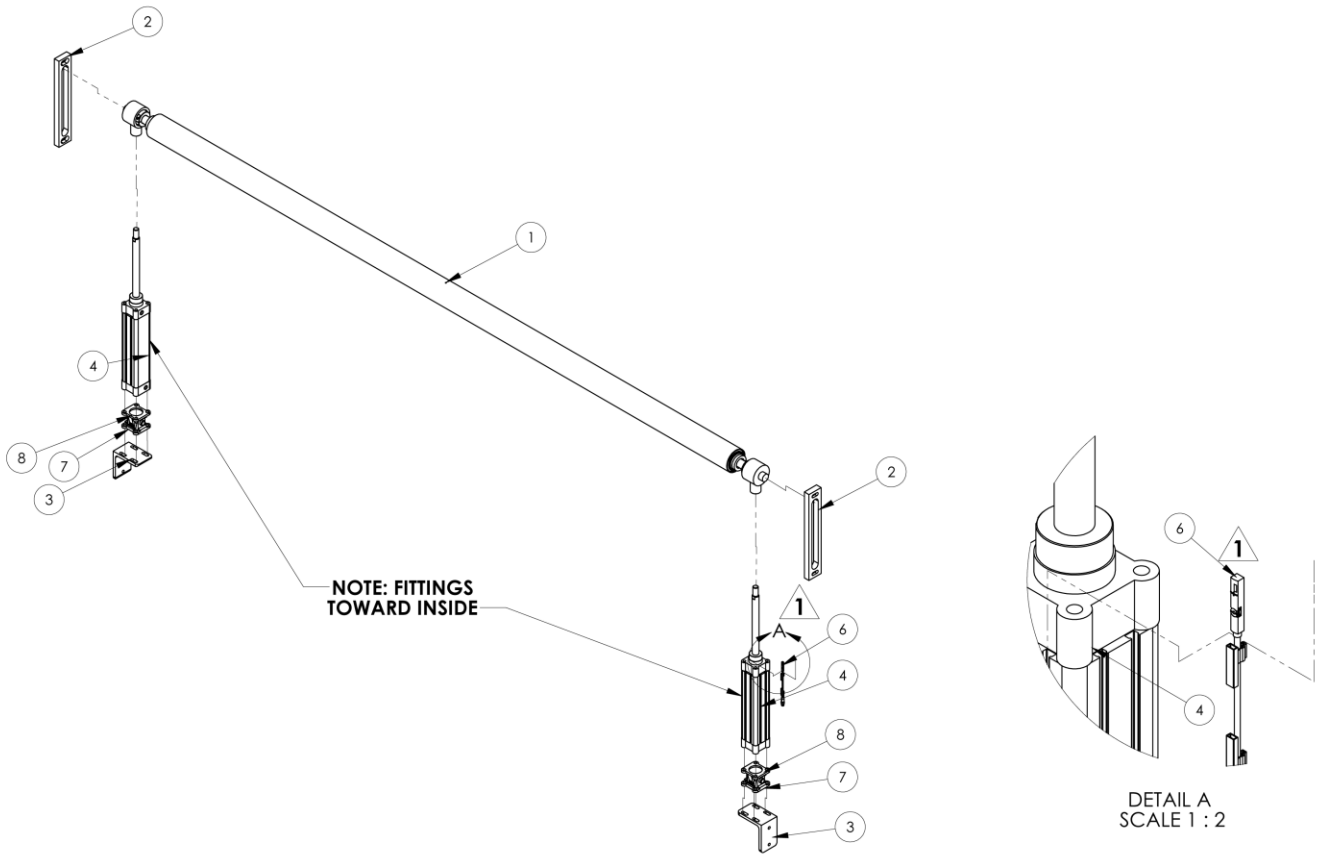
NO	QTY	PART #	DESCRIPTION
1	1	1388318	TOP ROLLER WELDMENT
2	1	1388324	INFEED PINCH ROLL WLDMNT
3	4	BBNAP205-25	BEARING, PILLOW BLOCK
4	8	NNEM10-1.5	NUT,ELASTIC LOCK,M10
5	8	SSHCM10X70	SCREW,HEX CAP,M10-1.5X70
6	8	WWFM10	WASHER, FLAT, M10 I.D.



1388331 INFEED ROLL DRIVE ASSEMBLY

AAC Drawing Number 1388331 Rev 3

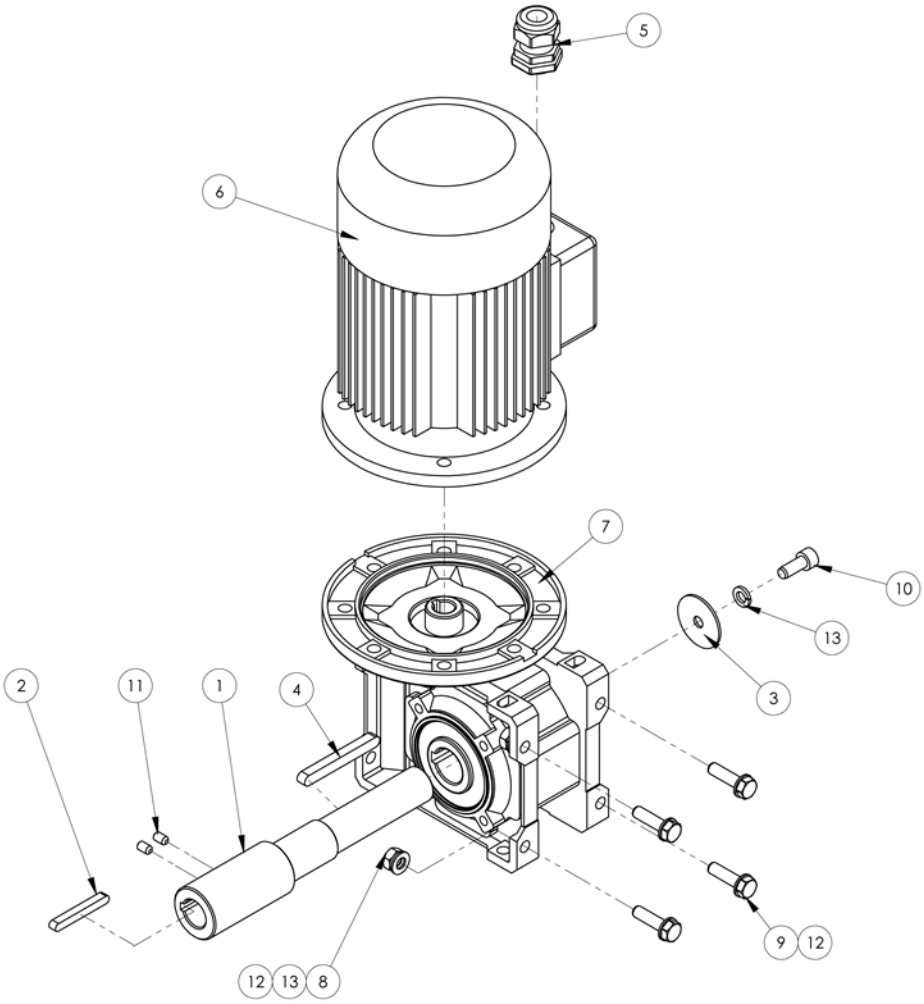
NO	QTY	PART #	DESCRIPTION
1	1	1386657	SHAFT MOTOR INSERT
2	1	1388330	KEY, INFEED DRIVE
3	1	1388332	KEY, INFEED PULL ROLLER
4	1	1392018	KEY, 8 MM X 25 MM
5	1	1393364	RETAINER WASHER
6	1	CCCLM25F	COLLAR, CLAMP METRIC 25MM
7	1	EEPG16	CORD GRIP,CABLE ENTRY
8	1	MM80B4B5	MOTOR,.75KW,IEC,B5,D80
9	2	MML099-25MM	COUPLING, FLEX, 25MM B
10	1	MML099/100H	SPIDER, LOVEJOY ML099
11	1	MMRV6340D80	GEARBOX,WORM,RV63,40:1
12	1	SSSCM8X20	M8X20 SOC CAP
13	2	SSSSM8X12	M8X12 SOC SET SCRW
14	1	WWLM8	M8 LOCK WASHER



1388333 BORDER LIFT ROLL ASSEMBLY

AAC Drawing Number 1388333 Rev 2

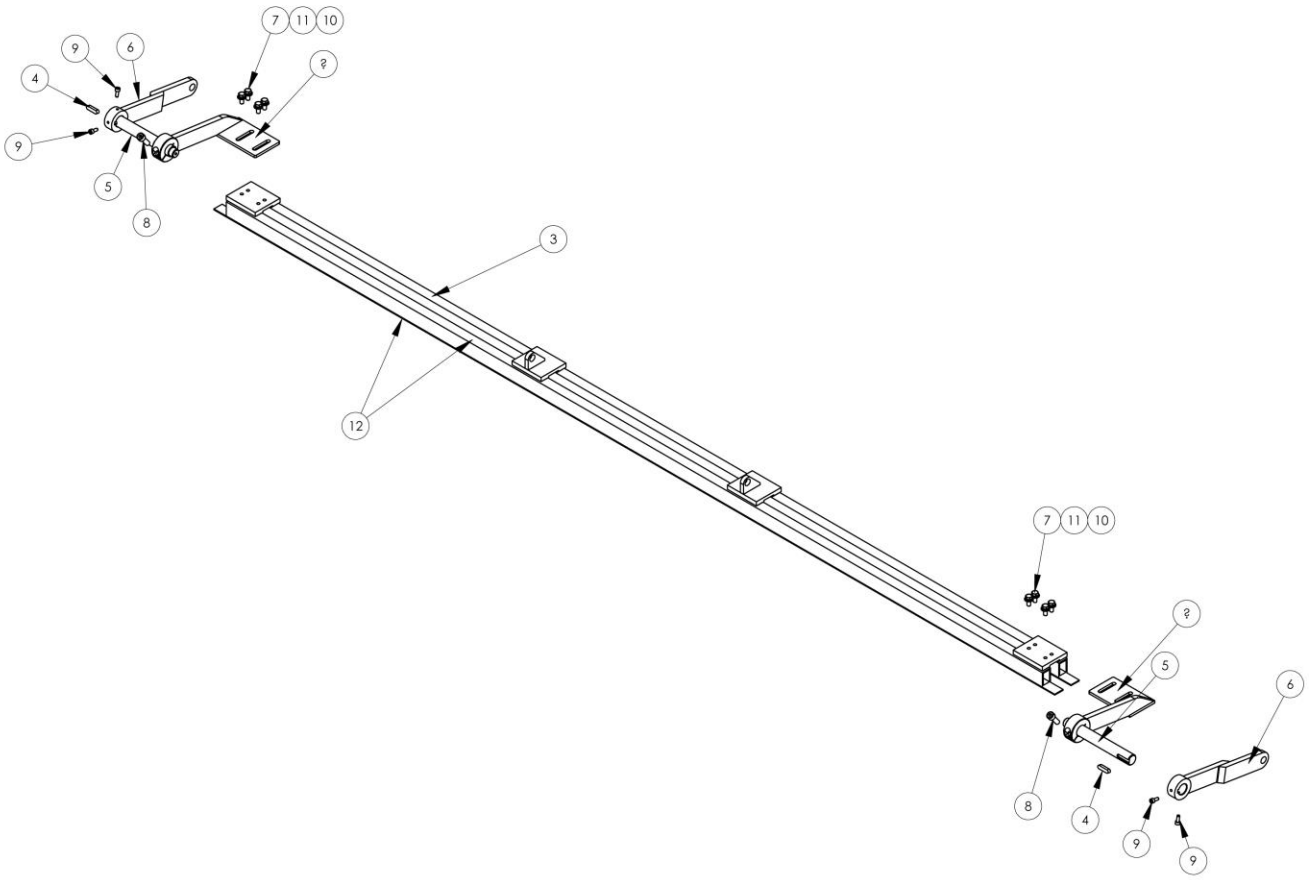
NO	QTY	PART #	DESCRIPTION
1	1	1388273	SLITTER ROLLER LIFT ASM
2	2	1389087	GUIDE
3	2	1389122	CYLINDER MOUNT
4	2	AACDNC50200PPV	CYLINDER,AIR,ISO,50B,200S
5	AR	AAEC4X	CABLE,AAEHSKQ
6	AR	AAESME8SLED24	SENSOR,NPN,M8 PICO, 1FT
7	2	AAFSNC50	FLANGE, SWIVEL, FOR
8	2	AAFSNCS50	CLEVIS SINGLE REAR W/PIN



1388337 OUTFEED MOTOR DRIVE ASSEMBLY

AAC Drawing Number 1388337 Rev 1

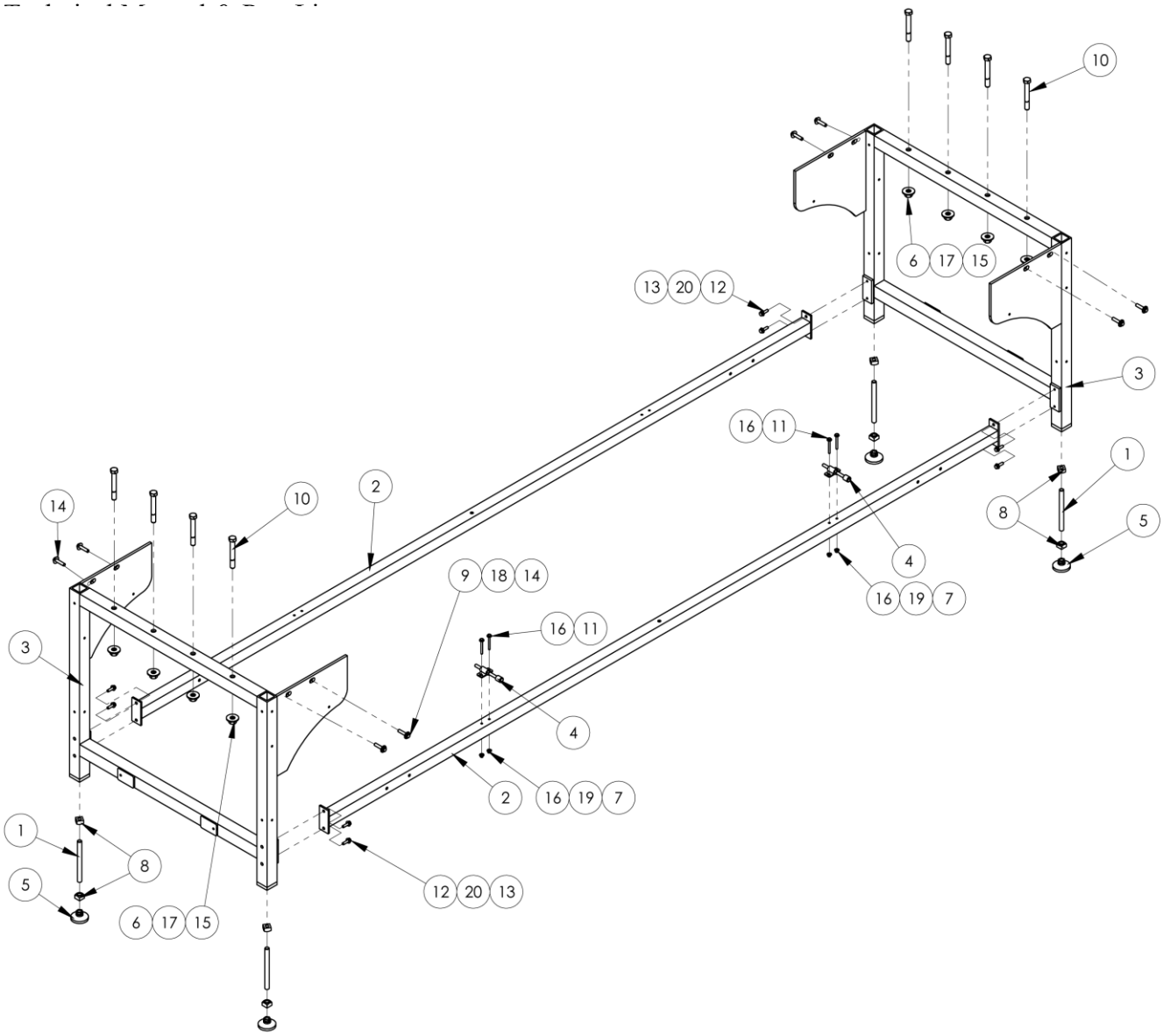
NO	QTY	PART #	DESCRIPTION
1	1	1388336	STUB,DRIVE SHAFT GEARBOX
2	1	1388338	KEY, 6X6X50
3	1	1393364	RETAINER WASHER
4	1	1393369	KEY, GEARMOTOR
5	1	EEPG16	CORD GRIP,CABLE ENTRY
6	1	MM71B4B5	MOTOR,.37KW,IEC,B5
7	1	MMRV5030D71	GEARBOX,WORM,RV50,30:1
8	4	NNHM8X1.25	M8 X 1.25 HEX NUT
9	4	SSHCM8X30	SCREW,HEX CAP M8X30
10	1	SSSCM8X20	M8X20 SOC CAP
11	2	SSSSM6X10	M6 SET SCREW, 10MM L
12	8	WWFM8	WASHER, FLAT, M8 I.D.
13	5	WWLM8	M8 LOCK WASHER



1388347 XCUT CLAMP ASSEMBLY

AAC Drawing Number 1388347 Rev 0

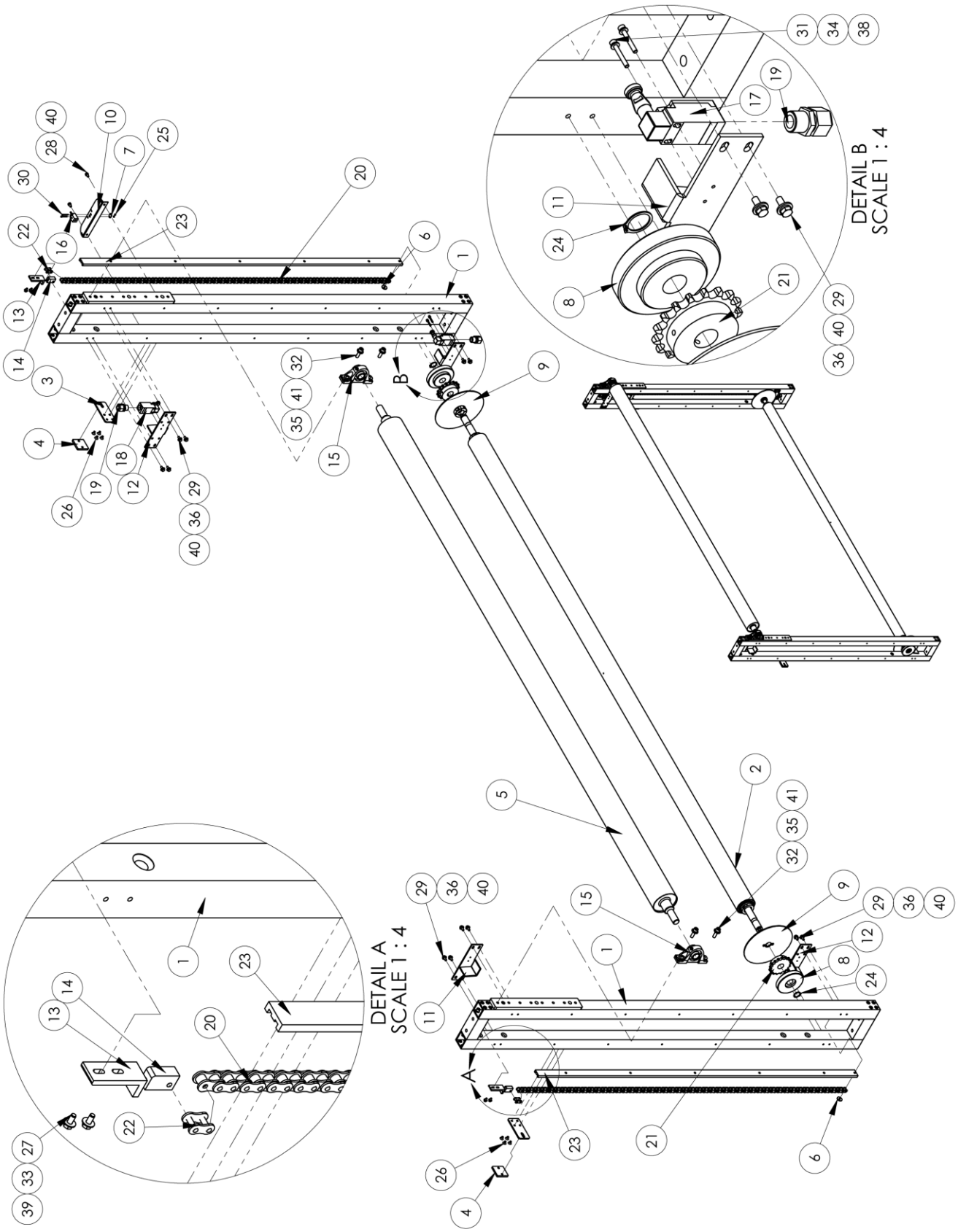
NO	QTY	PART #	DESCRIPTION
1	1	1388176	CLAMP ARM, LEFT, WELDMNT
2	1	1388344	CLAMP ARM, RIGHT, WELDMNT
3	1	1388348	CROSS CUT CLAMP WELDMNT
4	2	1388350	KEY,M8X7X32
5	2	1389062	PIVOT SHAFT
6	2	1393710	LEVER ARM WELDMENT
7	8	SSHCM8X20	SCREW ,HEX CAP
8	2	SSSCM10X30	10M X 30MM, SOC CAP
9	4	SSSCM6X15	M6X15 SOC CAP SCREW
10	8	WWF1/4	WASHER, FLAT, 1/4", COM
11	8	WWLM8	M8 LOCK WASHER
12	*20 FT	MM5109K25	FOAM SILICONE 3/32 X 1"

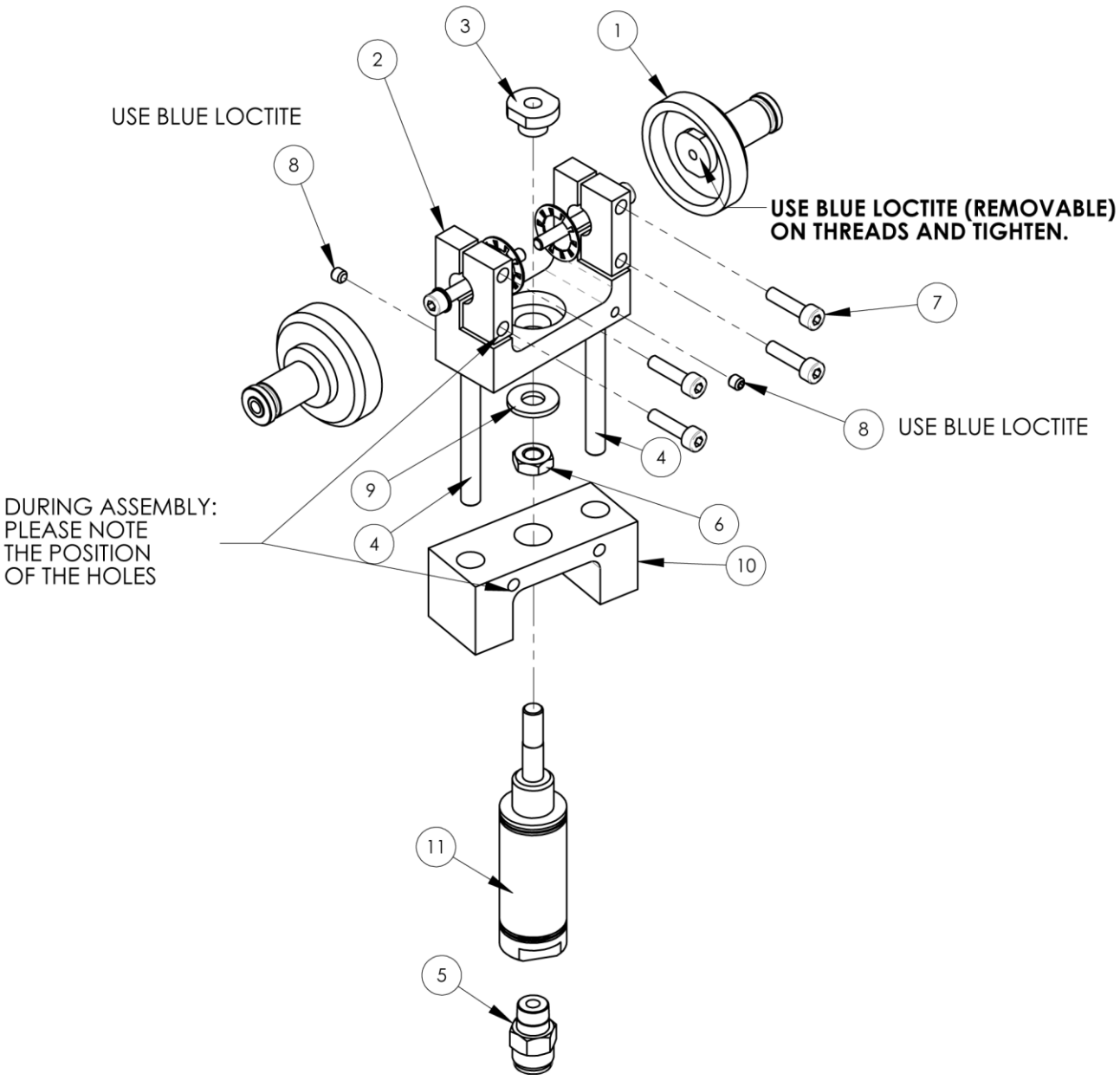


1388351 PANEL CUTTER LEG ASSEMBLY

AAC Drawing Number 1388351 Rev 0

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	4	1315661	ROD, THREADED, 5/8-11X7LG	11	4	SSHCM6X60	SCREW,HEX CAP
2	2	1388354	LEG STRUT WELDMENT	12	8	SSHCM8X30	SCREW,HEX CAP M8X30
3	2	1393225	EXTENSION,LEGS	13	8	WWF1/4	WASHER, FLAT, 1/4", COM
4	2	1393256	STOP ASSEMBLY	14	8	WWF3/8	WASHER,FLAT,3/8 OR 10MM
5	4	MML-2	LEVELING PAD, 5/8-11	15	8	WWF5/8	WASHER,FLAT,5/8
6	8	NNHM16X2.0	NUT,HEX,16MM-2.0	16	8	WWFS1/4	WASHER,FLAT,SAE,1/4
7	4	NNHM6X1.0	M6 X 1.0 HEX NUT	17	8	WWL5/8	WASHER,LOCK 5/8
8	8	NNSH5/8-11	NUT, SQUARE, 5/8-11	18	8	WWLM10	M10 LOCK WASHER
9	8	SSHCM10X45	SCREW,HEX CAP M10X45	19	4	WWLM6	WASHER,LOCK,M6
10	8	SSHCM16X120	SCREW,HEX CAP	20	8	WWLM8	M8 LOCK WASHER


DETAIL A
SCALE 1 : 4
DETAIL B
SCALE 1 : 4


USE BLUE LOCTITE
USE BLUE LOCTITE (REMOVABLE)
ON THREADS AND TIGHTEN.
USE BLUE LOCTITE
DURING ASSEMBLY:
PLEASE NOTE
THE POSITION
OF THE HOLES
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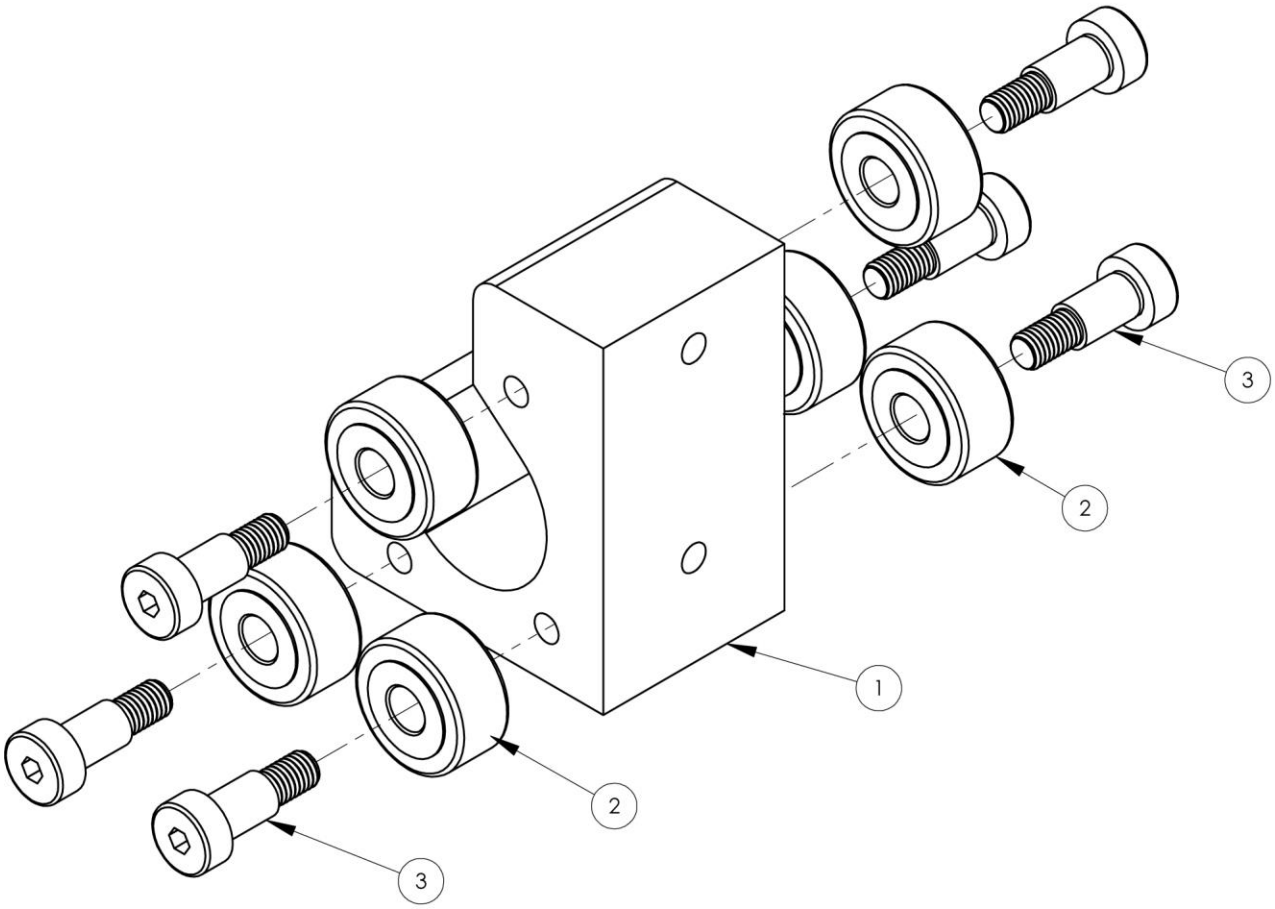
1393029 SLITTER SHARPENER ASSEMBLY

AAC Drawing Number 1393029 Rev 4

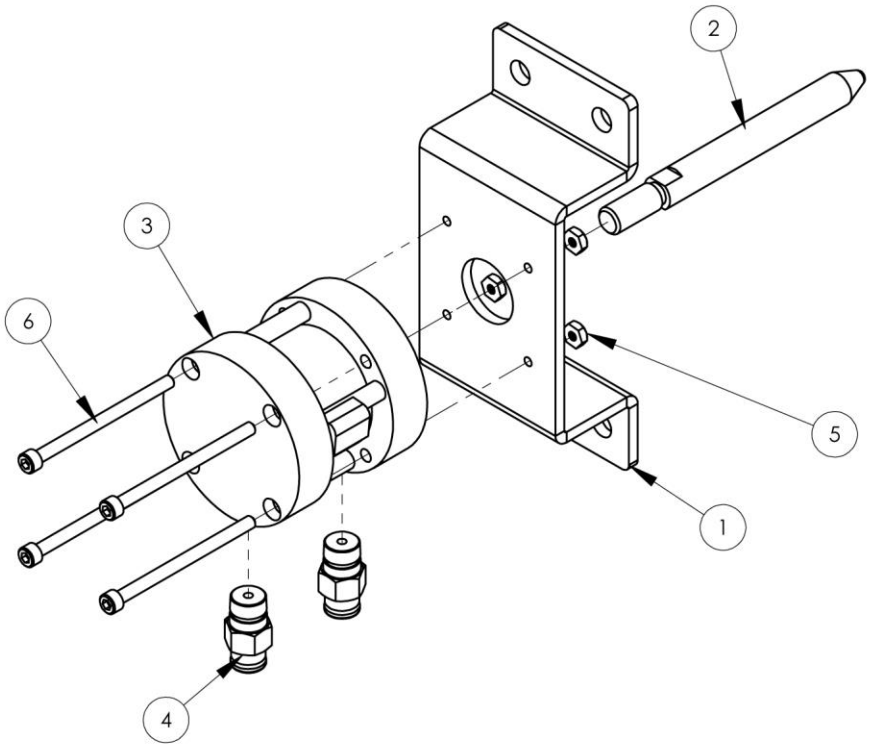
NO	QTY	PART #	DESCRIPTION
1	2	1393003	SHARPENER STONE MNT
2	1	1393028	BRKT,STONE MTG
3	1	1393030	NUT,FLOATING,M6
4	2	1393031	ROD,GUIDE,6MM DIA
5	1	AAQMC-4-8	QUICK MALE CONNECT
6	1	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
7	4	SSSCM4X16	SCREW,SOCKET CAP
8	2	SSSSM4X4	M4 SET SCREW, 4MM L
9	1	WWFS1/4	WASHER,FLAT,SAE,1/4
10	1	1393032	BRKT,CYL MTG
11	1	AAC7S-.5	CYLINDER,AIR,SA



1393058 CRADLE ASSEMBLY

AAC Drawing Number 1393058 Rev 1

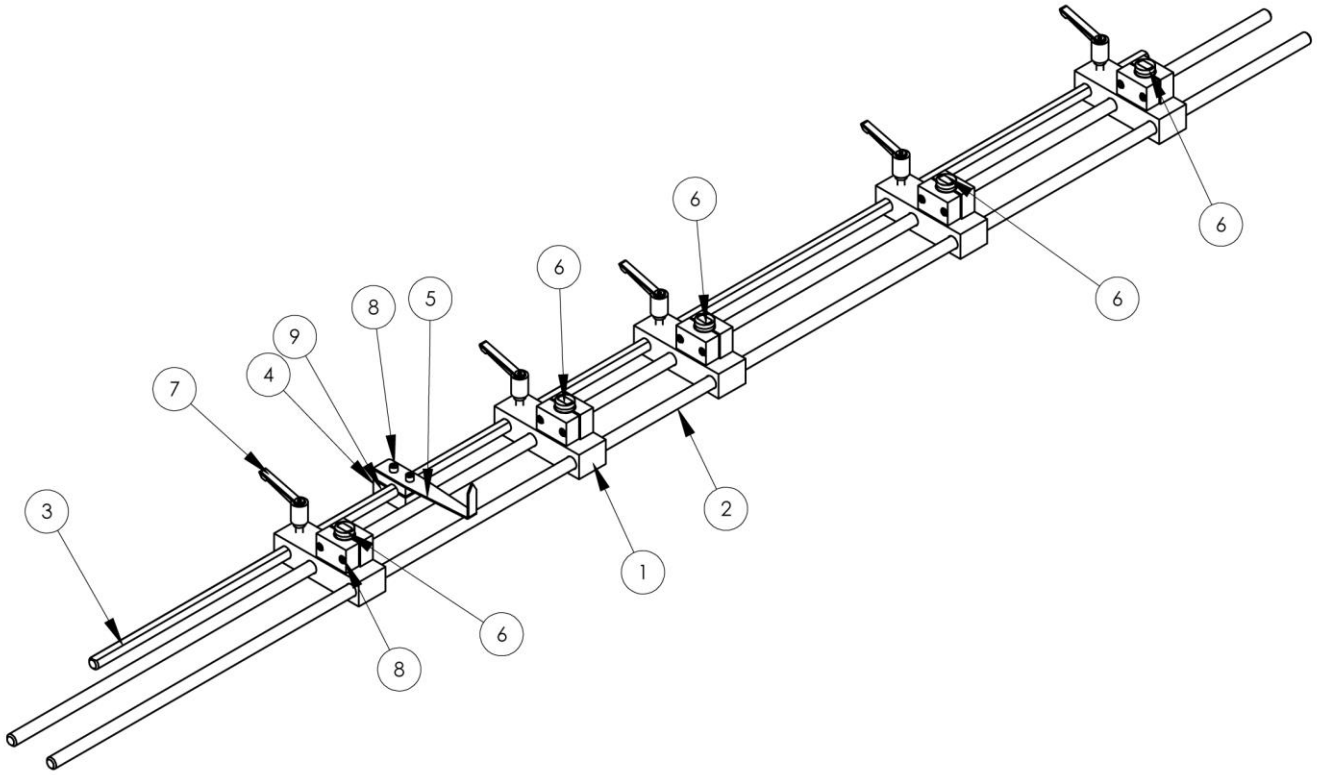
NO	QTY	PART #	DESCRIPTION
1	1	1393057	SUPPORT,REWIND SHAFT
2	6	BBMCYR10SX	CAM FOLLOWER,10 ID,30 OD
3	6	SSASM10M16M	SHOULDER BOLT 10mm



1393301 TABLE LOCKING ASSEMBLY

AAC Drawing Number 1393301 Rev 1

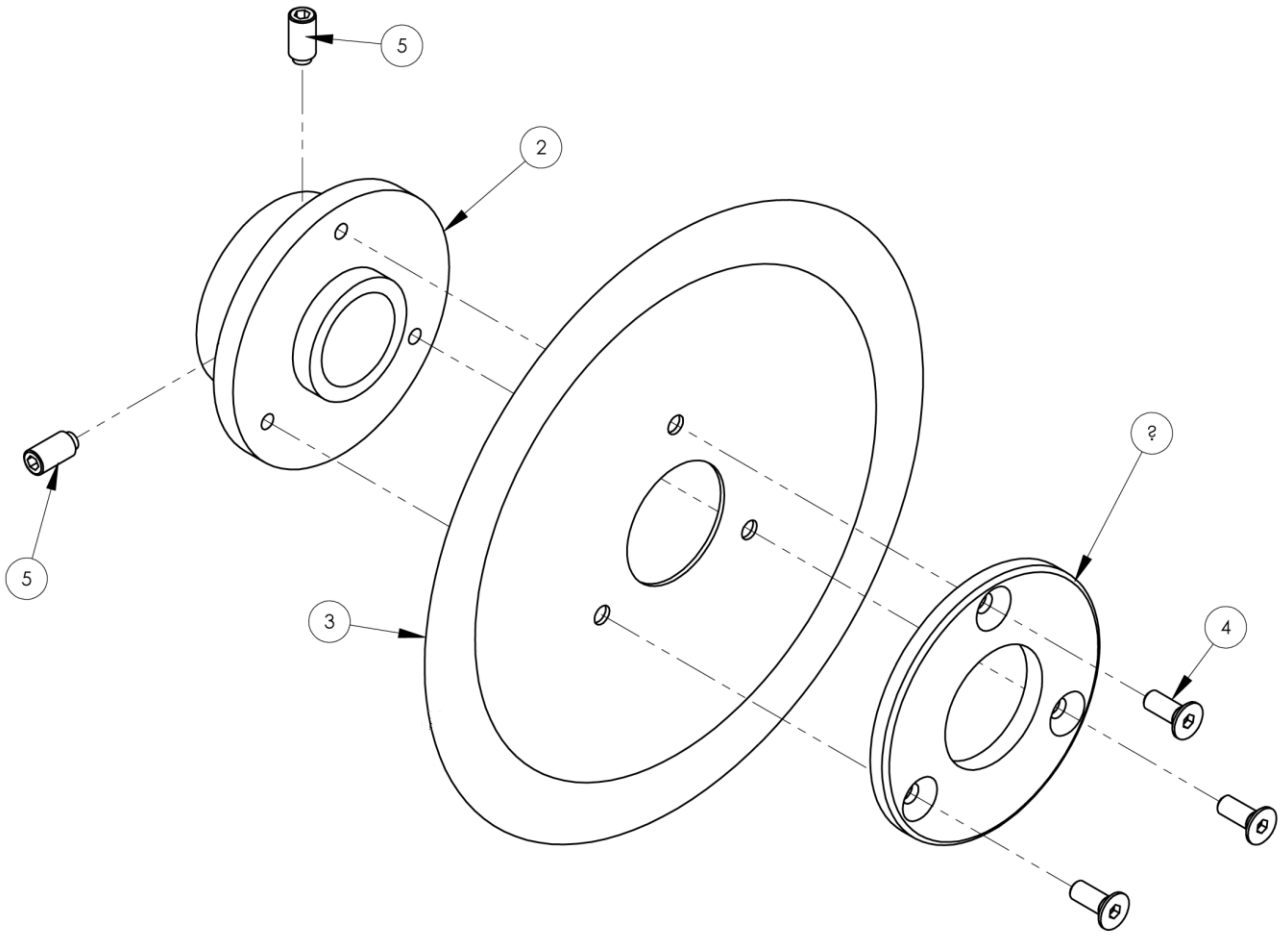
NO	QTY	PART #	DESCRIPTION
1	1	1393299	PANCAKE BRACKET
2	1	1393302	PIN, TABLE LOCKING
3	1	AACF0091	AIR CYLINDER, PANCAKE
4	2	AAQMC-5-8	QU. MALE CONN 5/32X1/8
5	4	NNH6-32	NUT,HEX,6-32
6	4	SSSC80128	6-32 X 2 SOC CAP SC



1393125 EYE ADJUSTMENT ASSEMBLY

AAC Drawing Number 1393125 Rev 1

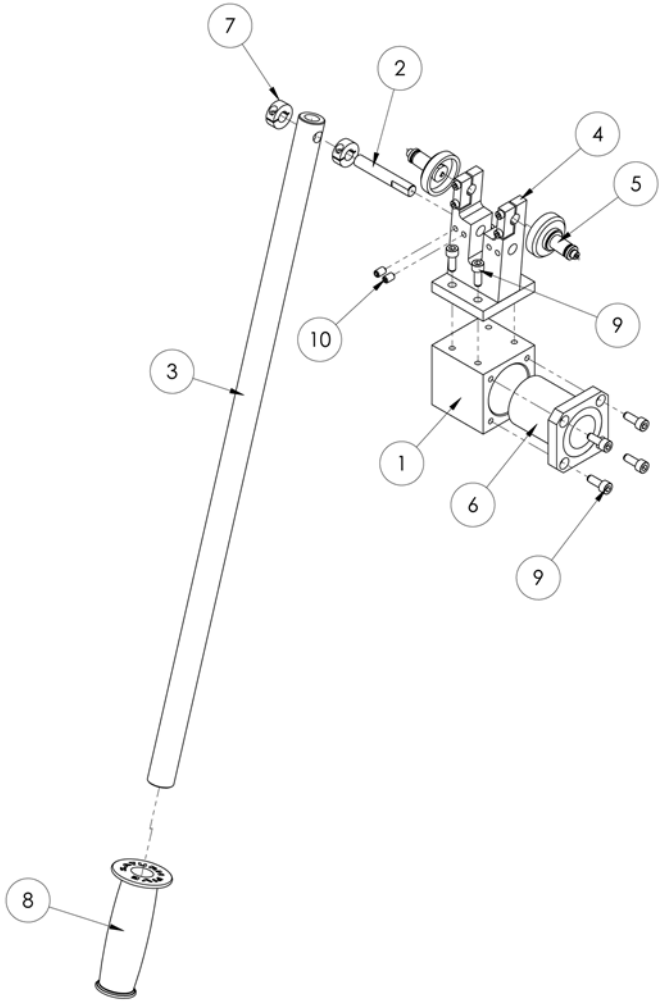
NO	QTY	PART #	DESCRIPTION
1	5	1393122	MOUNTING BLOCK, EYE, MOVI
2	2	1393123	GLIDE ROD, EXIT EYE
3	1	1393124	POSITION ROD, EXIT EYE
4	1	1393130	PIVOT BLOCK
5	1	1393297	POINTER, EYE ADJUST
6	AR	EESS20N4A	SENSOR,PHOTOELECTRIC 18MM
7	5	MM6324K170	M6 X 16mm
8	16	SSSCM4X20	SCREW,SOC CAP,M4-0.7X20
9	1	WWFS1/4	WASHER,FLAT,SAE,1/4



1393149 BSW SLITTER ASSEMBLY

AAC Drawing Number 1393149 Rev 2

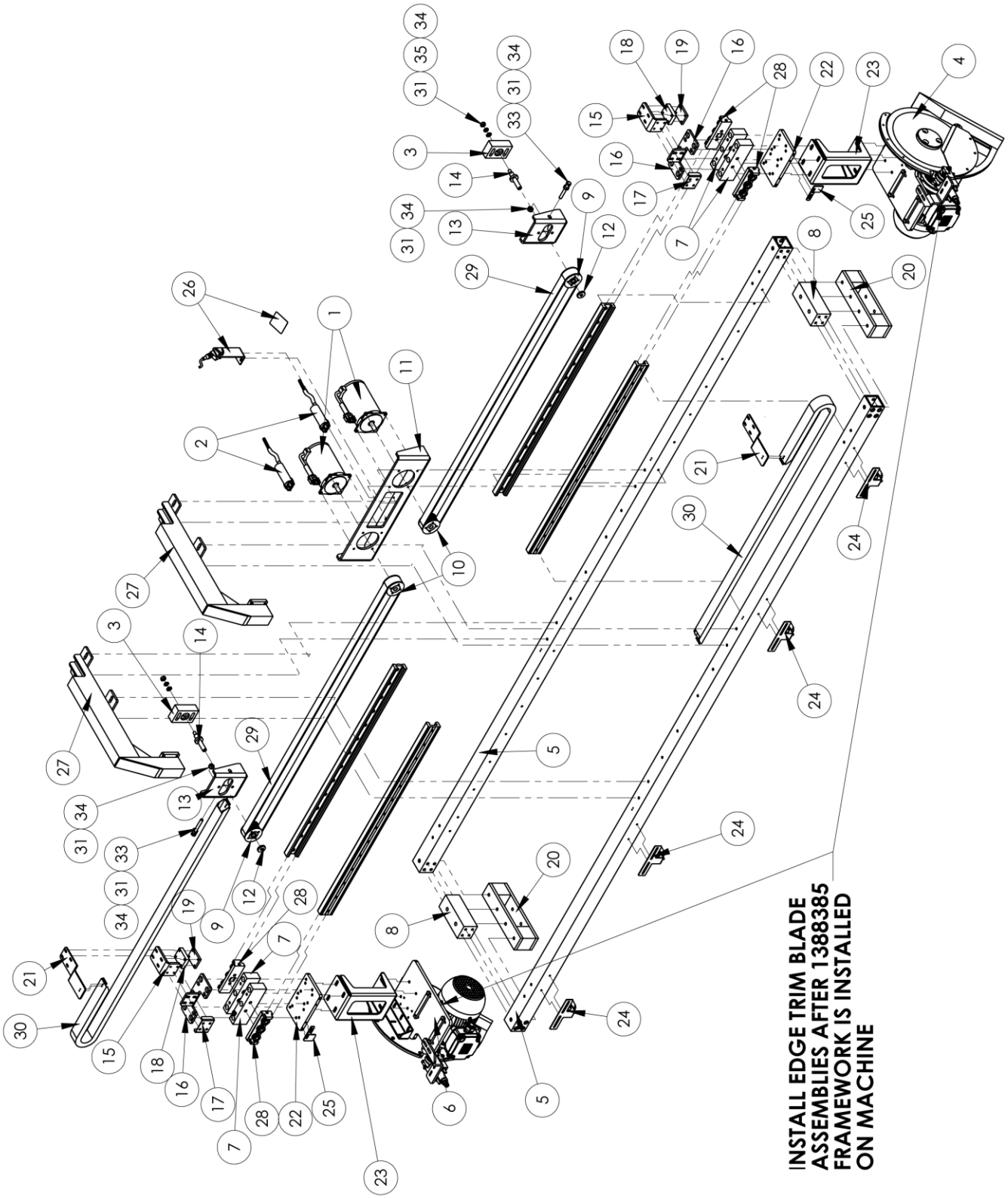
NO	QTY	PART	DESCRIPTION
1	1	1389079	BLADE RETAINER
2	1	1389873	BLADE HOLDER
3	1	CJ21100900_TEST	BLADE,40MM ID,205MM OD
4	3	SSFCM6X16	M6-1.0 X 16 FLAT ALLEN
5	2	SSSSM8X16BT	M8X16 SOC SET, BRASS TIP



1389884 SHARPENER ASSEMBLY, SLITTERS

AAC Drawing Number 1389884 Rev 2

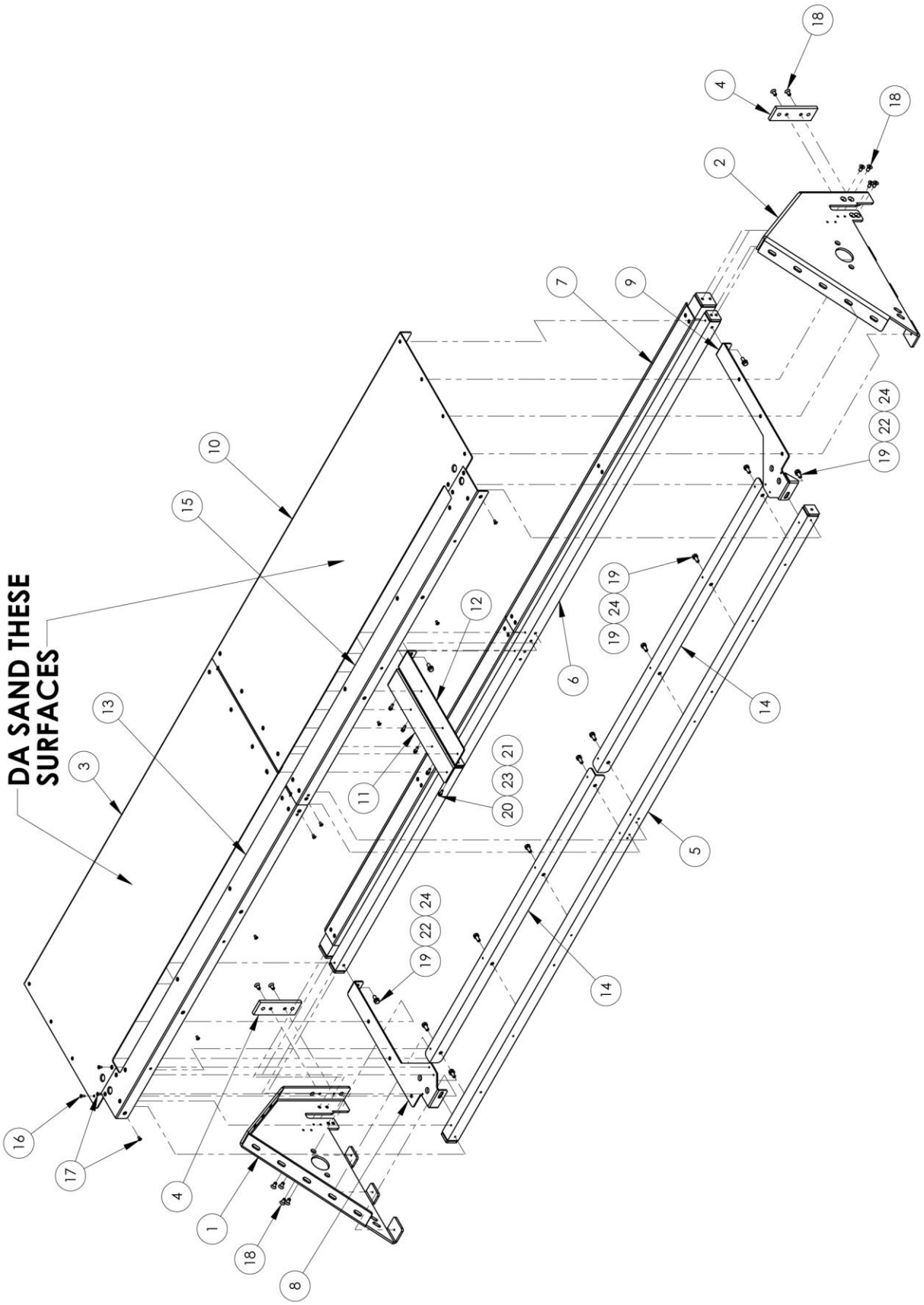
NO	QTY	PART #	DESCRIPTION
1	1	1389883	BLOCK,SLIDE,SHARPENER
2	1	1389889	ROD,10MM X 63MM
3	1	1389890	TUBE,HANDLE,7/8X24
4	1	1389892	SHARPENER STONE HOLDER
5	2	1393003	SHARPENER STONE MNT
6	1	BBSMK30GUU	BEARING,LIN,FLG,30MM
7	2	CCCLM10F	COLLAR,10MM CLAMP
8	1	PPP97045K57	GRIP,RIBBED VINYL
9	8	SSSCM6X16	M6 X 16, SOC CAP
10	2	SSSSM6X10	M6 SET SCREW, 10MM L


INSTALL EDGE TRIM BLADE
ASSEMBLIES AFTER 1388385
FRAMEWORK IS INSTALLED
ON MACHINE

1388385 SIDE TRIM RAIL ASSEMBLY

AAC Drawing Number 1388385 Rev 4

NO	QTY	PART #	DESCRIPTION
1	2	1386655	MOTOR,STEPPER,W/HD CON
2	2	1386656	CABLE, ASSEMBLY, STEPPER
3	2	1388077	BLOCK, PULLEY SUPPORT
4	1	1388288	EDGE CUT ASSEMBLY LEFT
5	2	1388384	SIDE TRIM RAIL TUBE
6	1	1388386	EDGE CUT ASSEMBLY RIGHT
7	4	1388387	EDGE TRIM RAIL MOUNT
8	2	1388388	EDGE TRIM FRAME BLOCK
9	2	1388391	GEAR PULLEY,EDGE TRIM,ASM
10	2	1388393	DRIVE PULLEY, 1393E
11	1	1388394	PLATE, MOTOR SUPPORT
12	2	1388395	WASHER, PULLEY RETAINER
13	2	1388396	PLATE, PULLEY SUPPORT
14	2	1388397	SHAFT STUD,GEAR PULLEY
15	2	1388398	PLATE, EDGE TRIM POSITION
16	2	1388399	PLATE, POS MNT,EDGE TRIM
17	2	1388400	PLATE, WASHER, RETAINER
18	2	1388401	CLAMP, BELT 3/8"P
19	2	1388402	NUT PLATE, BELT CLAMP
20	2	1388405	EDGE TRIM STANDOFF WLDMT
21	2	1388417	PLATE,MICROTRAK BRACKET
22	2	1388587	PLATE, EDGE TRIM MOUNT
23	2	1388588	STANDOFF, EDGE TRIM,BRKT
24	4	1388589	EDGE TRIM SENSOR ASSY
25	2	1388591	FLAG, SENSOR,EDGE TRIM
26	1	1388671	UNFEED SENSOR ASSEMBLY
27	2	1389100	BOOSTER CYLINDER MOUNT
28	4	BBRRS45	SLIDER, REDI-RAIL, 45MM
29	2	GG903L100ST	BELT,GEAR,3/8P,1W
30	2	MM180302848	DUCT,WIRE MICROTRAK
31	6	NNHM8X1.25	M8 X 1.25 HEX NUT
32	4	RR450814Y17	REDI-RAIL, 45MM X 814MM L
33	2	SSHCM8X60	SCREW,HEX CAP M8X60
34	7	WWFM8	WASHER, FLAT, M8 I.D.
35	2	WWLM8	M8 LOCK WASHER


DA SAND THESE SURFACES
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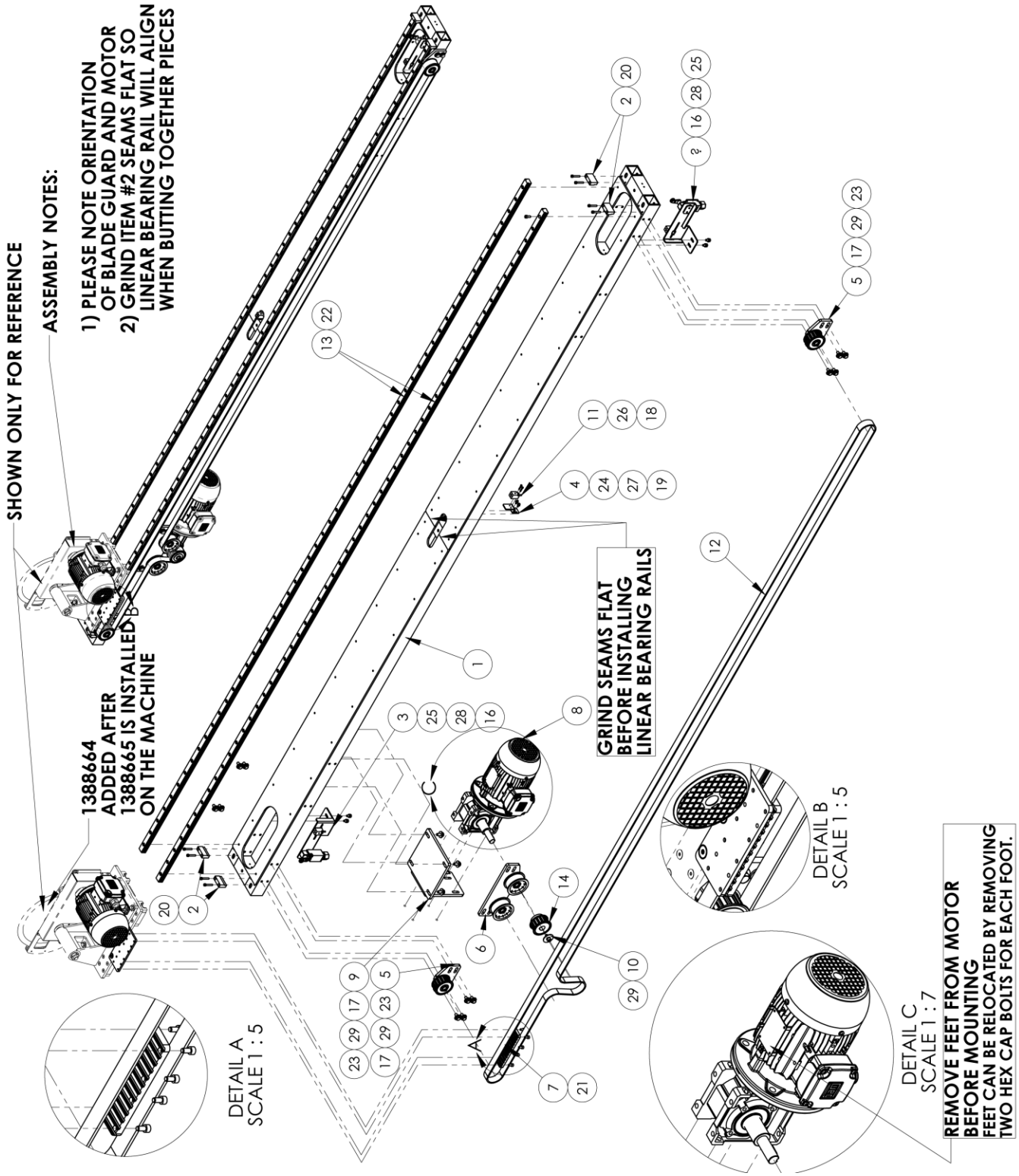
1388530 CUT TABLE ASSEMBLY

AAC Drawing Number 1388530 Rev 0

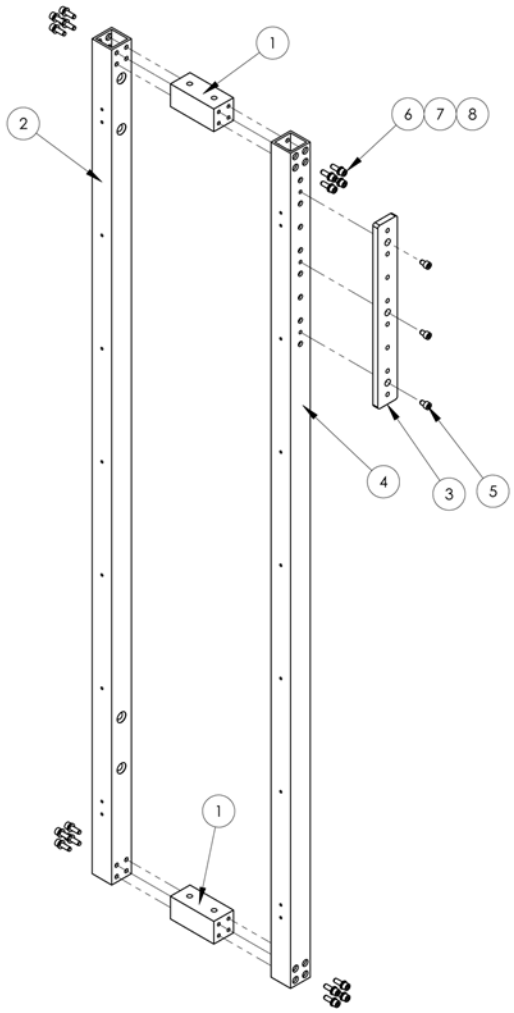
NO	QTY	PART #	DESCRIPTION
1	1	1388267	BRACKET,CUT TABLE, RH
2	1	1388285	BRACKET,CUT TABLE, LH
3	1	1388312	CUT TABLE TOP, RH
4	2	1388356	PLATE, BEARING SPACER
5	1	1388371	CUT TABLE,CROSS BAR WLDMT
6	1	1388373	CUT TABLE,CROSSBEAM,WLDMT
7	1	1388383	CROSS CUT, CLOTH PLATE ASSEMBLY
8	1	1388524	PLATE, TABLE MOUNT,RH
9	1	1388525	PLATE, TABLE MOUNT,LH
10	1	1388526	CUT TABLE TOP, LH
11	1	1388527	BRACE,CUT TABLE,RH
12	1	1388529	BRACE,CUT TABLE,LH
13	1	1388531	CUT TABLE TOP, RH,BOTTOM
14	2	1388532	SUPPORT ANGLE,CLOTH PLATE
15	1	1388533	CUT TABLE TOP, LH,BOTTOM
16	8	SSBCM5X12S	SCREW,BUTTON CAP,S/S
17	34	SSFCM5X10	SCREW,FLAT ALLEN CAP
18	12	SSFCM8X16	M8 X 16 FLAT CAP SCR
19	16	SSHCM8X20	SCREW,HEX CAP
20	5	SSSCM5X16	M5-0.8 X 16,SOC CAP SCR
21	5	WWFM5	WASHER, FLAT, M5 I.D.
22	8	WWFM8	WASHER, FLAT, M8 I.D.
23	5	WWLM5	M5 LOCK WASHER
24	16	WWLM8	M8 LOCK WASHER


SHOWN ONLY FOR REFERENCE
ASSEMBLY NOTES:
1) PLEASE NOTE ORIENTATION OF BLADE GUARD AND MOTOR
2) GRIND ITEM #2 SEAMS FLAT SO LINEAR BEARING RAIL WILL ALIGN WHEN BUTTING TOGETHER PIECES
1388664 ADDED AFTER 1388665 IS INSTALLED ON THE MACHINE
GRIND SEAMS FLAT BEFORE INSTALLING LINEAR BEARING RAILS
DETAIL A SCALE 1 : 5
DETAIL B SCALE 1 : 5
DETAIL C SCALE 1 : 7
REMOVE FEET FROM MOTOR BEFORE MOUNTING
FEET CAN BE RELOCATED BY REMOVING TWO HEX CAP BOLTS FOR EACH FOOT.

1388665 XCUT ASSEMBLY, 1393E

AAC Drawing Number 1388665 Rev 1

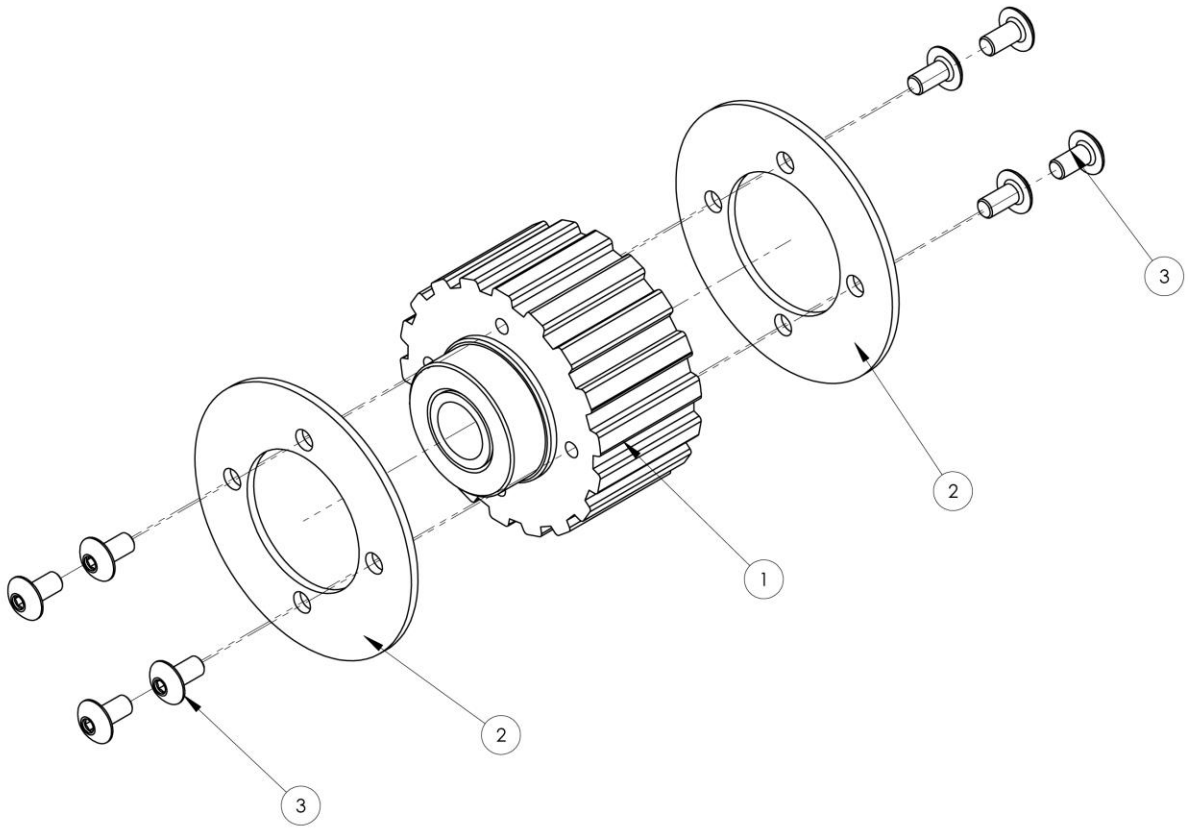
NO	QTY	PART #	DESCRIPTION
1	1	1388465	XCUT SUPPORT WELDMENT
2	4	1388487	BLOCK, RAIL STOP,XCUT
3	2	1388490	XCUT SENSOR ASSEMBLY
4	1	1388493	BRACKET, SENSOR,XCUT
5	2	1388541	XCUT DRV IDER PULLEY ASM
6	1	1388542	XCUT DRV BELT IDLER ASM
7	1	1388545	CLAMP,GEAR BELT
8	1	1388666	CROSS CUT MTR DRIVE ASSY
9	1	1388668	XCUT DRIVE MOUNT WLDMNT
10	1	1393364	RETAINER WASHER
11	1	EENI5Q18AN6X	SENSOR, PROX. NPN,10-30DC
12	1	H100L72M1	BELT,GEAR,1/2"P,1"WIDE
13	2	MMAGR253360N	RAIL,LINEAR, AG 3360MM
14	1	PP16H100M2	PULLEY,1/2P,16T, 1"WIDE
15	1	SSFCM8X16	M8 X 16 FLAT CAP SCR
16	4	SSHCM6X12S	SCREW, HEX M6X12 SS
17	16	SSHCM8X20	SCREW,HEX CAP
18	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
19	2	SSSCM4X10	SCREW,SOC CAP,M4-0.7X8
20	8	SSSCM5X30	M5-0.8X30,SCREW,SOC CAP
21	8	SSSCM6X12	M6X12 SOC CAP SCREW
22	112	SSSCM6X15	M6X15 SOC CAP SCREW
23	16	WWF5/16	WASHER,FLAT,5/16
24	2	WWF8	WASHER, FLAT, #8
25	4	WWFM6	WASHER, FLAT, M6, SAE
26	2	WWL4	WASHER,LOCK,#4
27	2	WWL8	WASHER,LOCK,#8
28	4	WWLM6	WASHER,LOCK,M6
29	17	WWLM8	M8 LOCK WASHER



1388571 DANCER FRAME ASSEMBLY

AAC Drawing Number 1388571 Rev 0

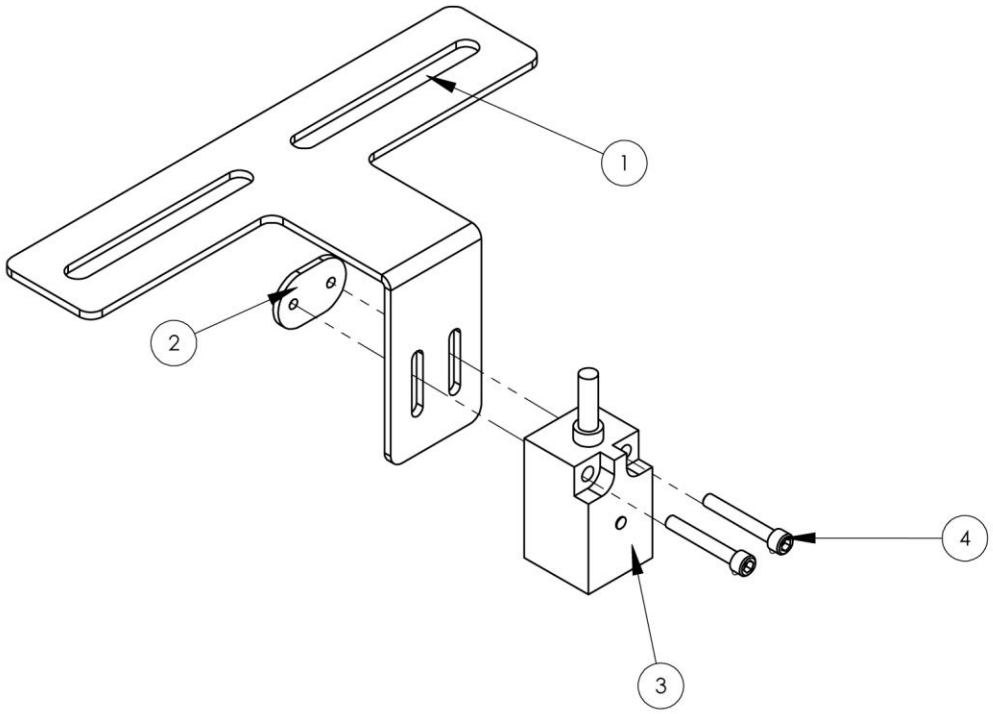
NO	QTY	PART #	DESCRIPTION
1	2	1388573	DANCER FRAME BLOCK
2	1	1388574	TUBE,11GAX2X2X77.0L
3	1	1388575	BAR, BEARING MOUNT
4	1	1388576	TUBE,CRS, 2X2X77L
5	3	SSSCM8X12	SCREW,SOC CAP,M8X12
6	16	SSSCM8X25	SCREW,SOC CAP,M8X25
7	16	WWFM8	WASHER, FLAT, M8 I.D.
8	16	WWLM8	M8 LOCK WASHER



1388391 GEAR PULLEY, EDGE TRIM, ASSEMBLY

AAC Drawing Number 1388391 Rev 0

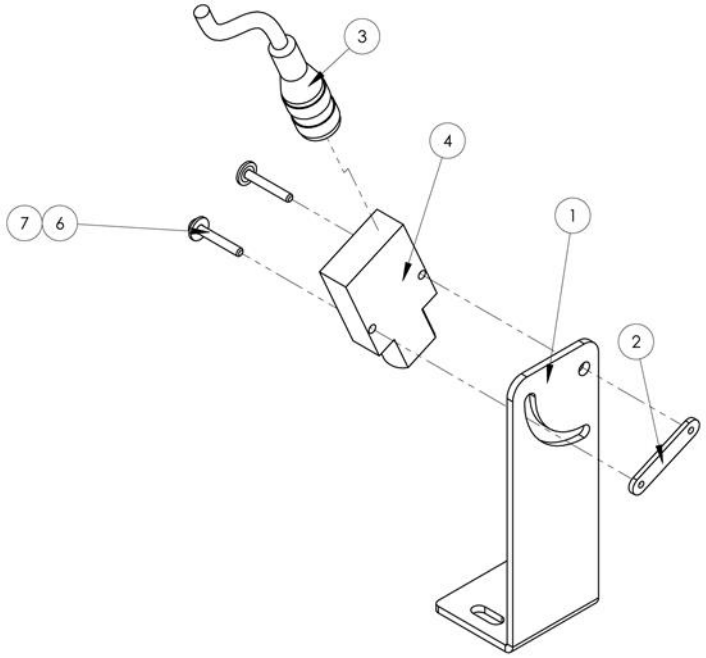
NO	QTY	PART #	DESCRIPTION
1	1	1388389	PULLEY,GEAR,3/8P,18T,12MM
2	2	1388390	PLATE, PULLEY BELT RETAIN
3	8	SSBCM4x8	4mm X 8mm BUTTON HEAD

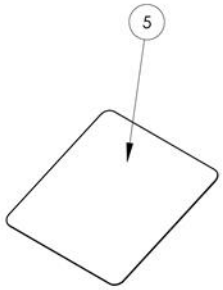


1388589 EDGE TRIM SENSOR ASSEMBLY

AAC Drawing Number 1388589 Rev 0

NO	QTY	PART #	DESCRIPTION
1	1	1388590	BRACKET, SENSOR,EDGE TRIM
2	1	1393373	PLATE, NUT, 4-40
3	1	EENI5Q18AN6X-M1	PROX SWITCH, MOD W/PLUG
4	2	SSSC70048	4-40 X 3/4 SOCKET CAP

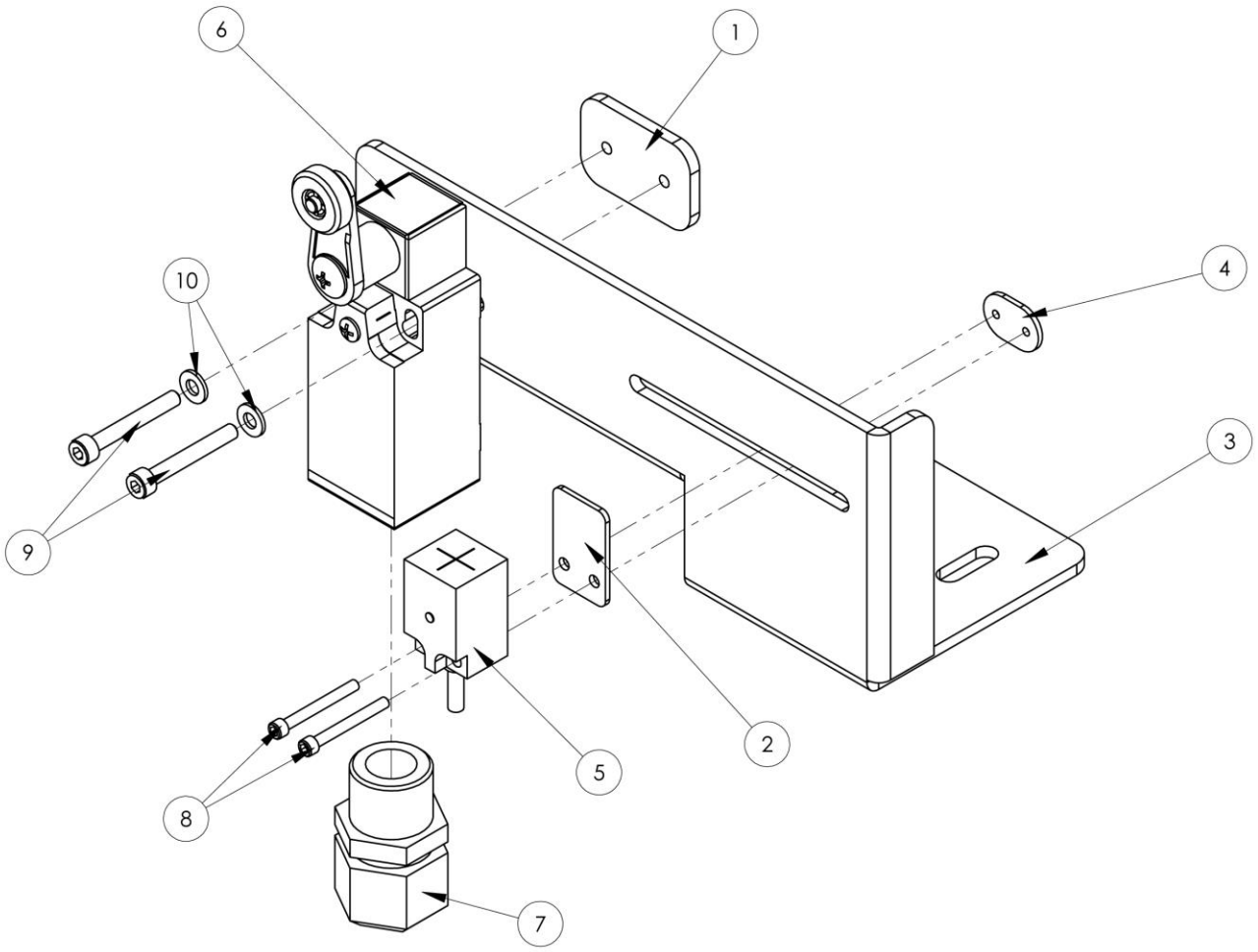




1388671 UNFEED SENSOR ASSEMBLY

AAC Drawing Number 1388671 Rev 0

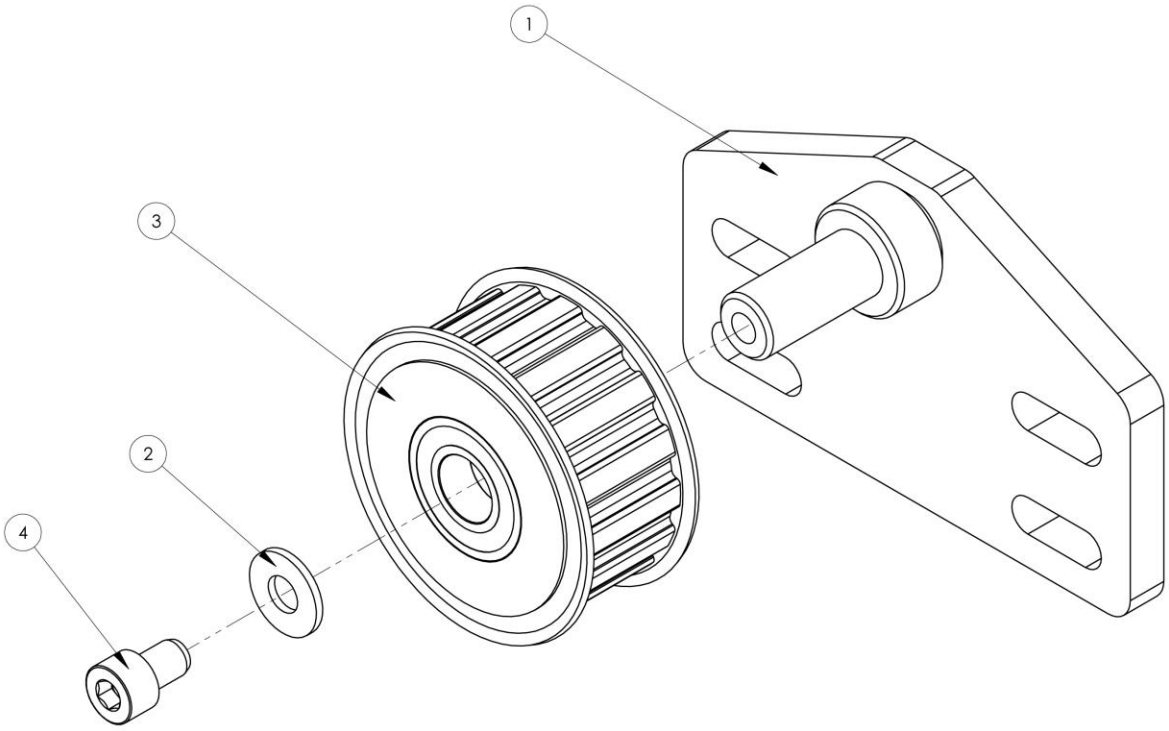
NO	QTY	PART #	DESCRIPTION
1	1	1278-6689E	BRACKET, EYE MOUNT
2	1	1975-412A	PLATE,NUT,4-40,.95CTC
3	1	FFRK44T-8	CABLE,EYE,25',NO END
4	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
5	1	MMT9945	TAPE,REFLECTIVE,2" WIDE
6	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
7	2	WWF4	WASHER, FLAT, #4



1388490 XCUT SENSOR ASSEMBLY

AAC Drawing Number 1388490 Rev 1

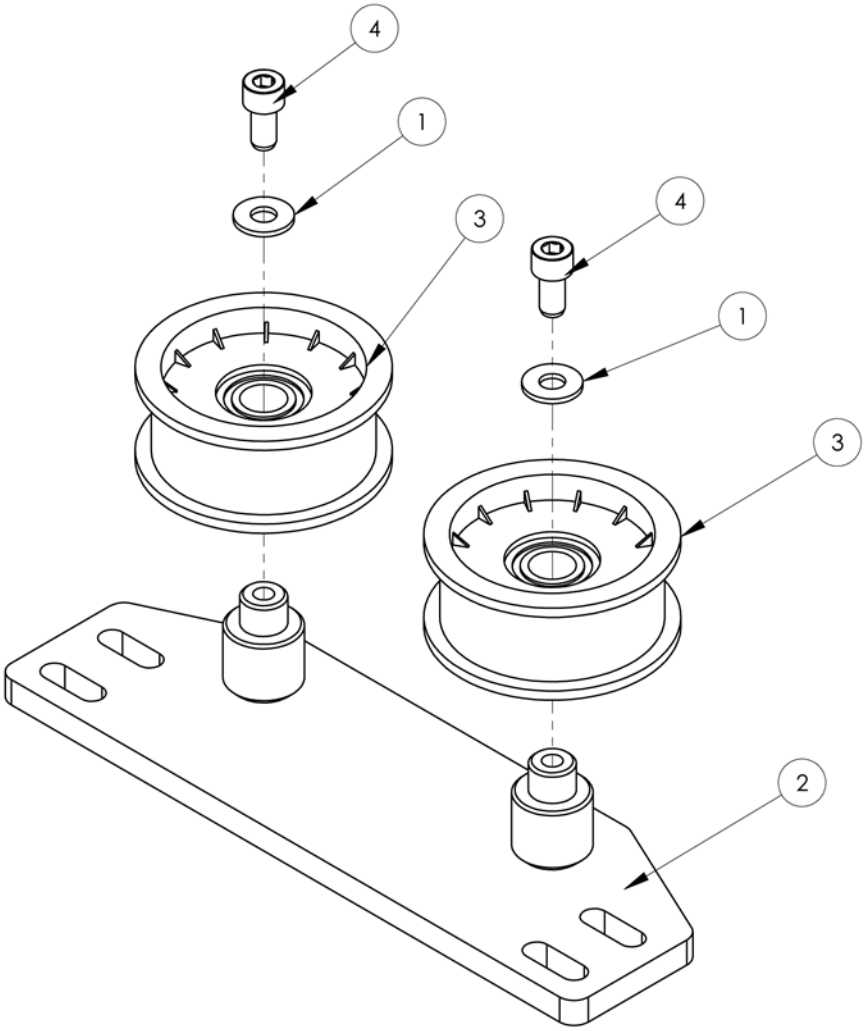
NO	QTY	PART #	DESCRIPTION
1	1	1388092	PLATE,NUT, FOR FFEVN2000A
2	1	1388102	PLATE, WASHER, SENSOR MNT
3	1	1388489	MOUNT, LIMIT SWITCH
4	1	1393373	PLATE, NUT, 4-40
5	1	EENI5Q18AN6X	SENSOR, PROX. NPN,10-30DC
6	1	FFGLLA01A1B	SWITCH, LIMIT, ROLLER
7	1	FFM4518	STRAIN RELIEF,LIQ TIGHT
8	2	SSSC70064	4-40 X 1 SOCKET CAP
9	2	SSSCM4X30	SCREW,SOC CAP,M4-0.7X30
10	2	WWFM4.3	WASHER, FLAT, M4



1388541 XCUT DRIVER IDLER PULLEY ASSEMBLY

AAC Drawing Number 1388541 Rev 0

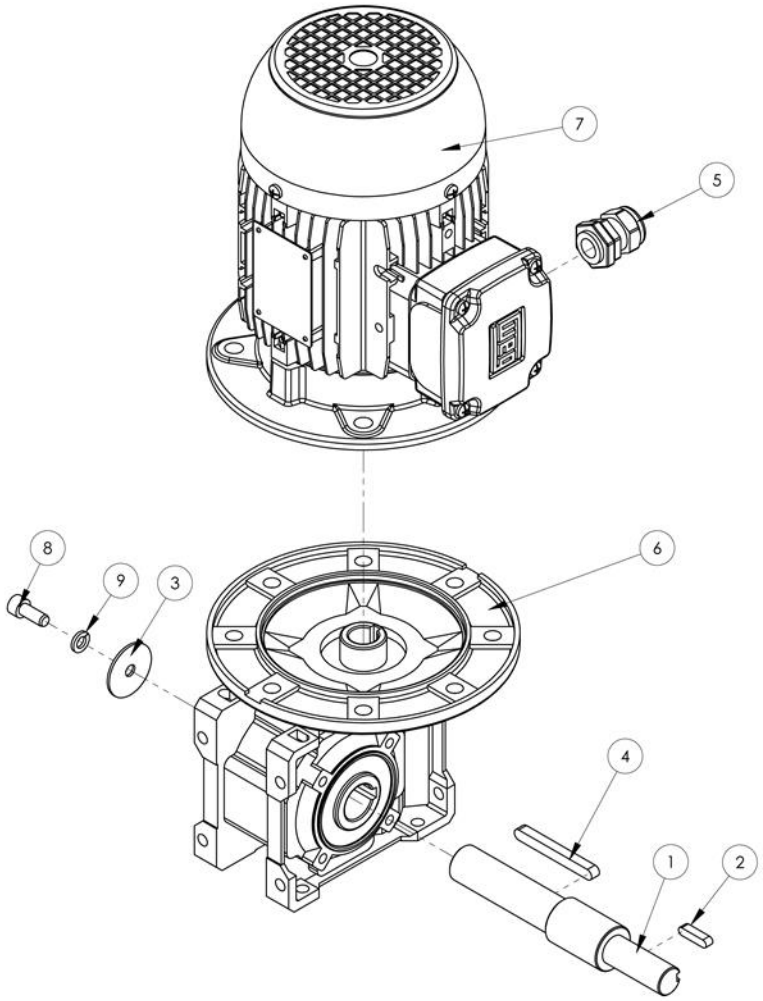
NO	QTY	PART #	DESCRIPTION
1	1	1388540	BELT TENSION, IDLER,WLDMT
2	1	1388543	RETAINER WASHER
3	1	PP16H100M1	PULLEY, IDLER 16T,1/2P,H
4	1	SSSCM8X12	SCREW,SOC CAP,M8X12



1388542 XCUT DRIVE BELT IDLER ASSEMBLY

AAC Drawing Number 1388542 Rev 0

NO	QTY	PART #	DESCRIPTION
1	2	1388543	RETAINER WASHER
2	1	1388546	BELT DRV IDLER WELDMENT
3	2	PPTPBSN7028	PULLEY, IDLER, 28MM WIDE
4	2	SSSCM8X16	SCREW,SOC CAP,M8X16

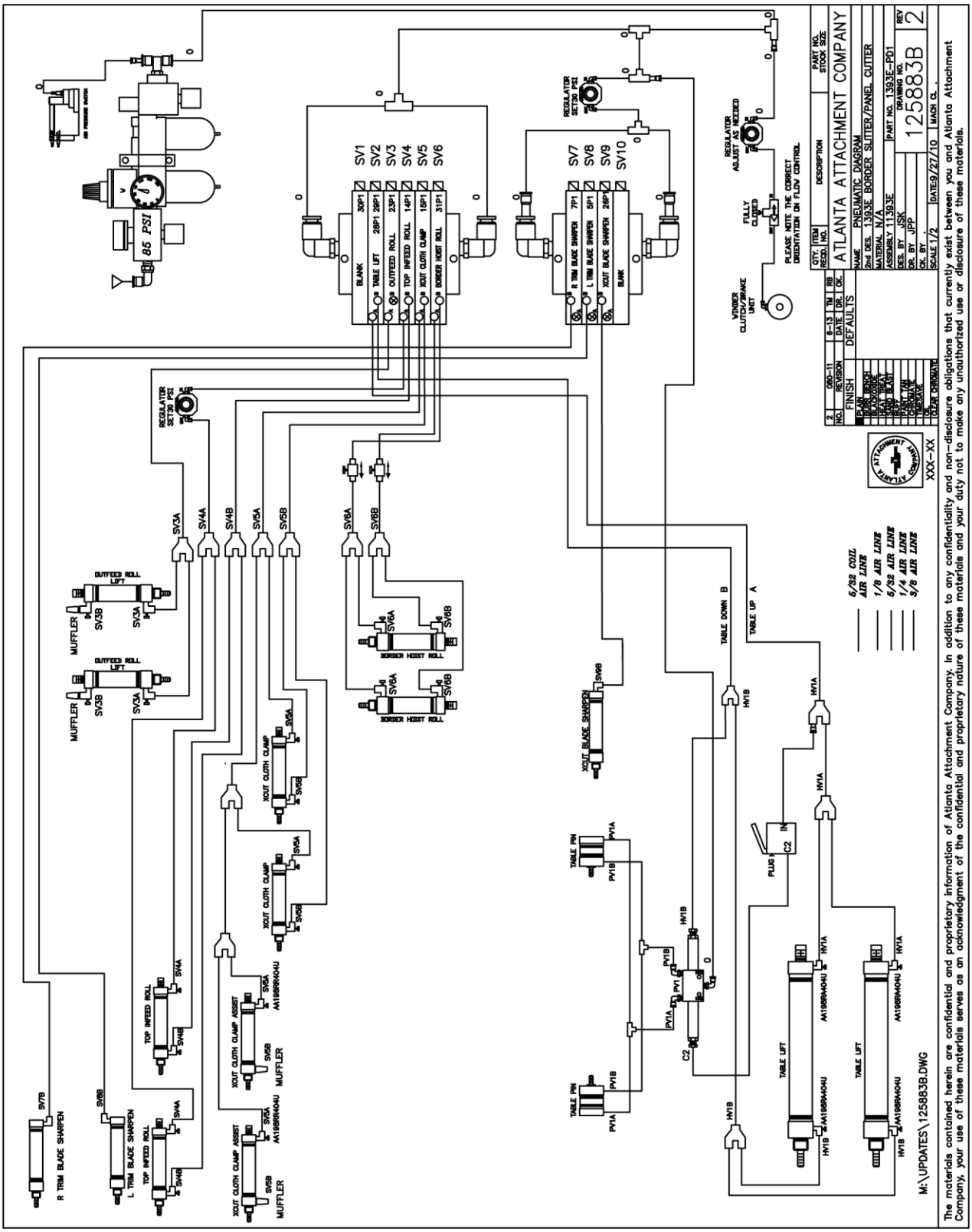


1388666 CROSS CUT MOTOR DRIVE ASSEMBLY

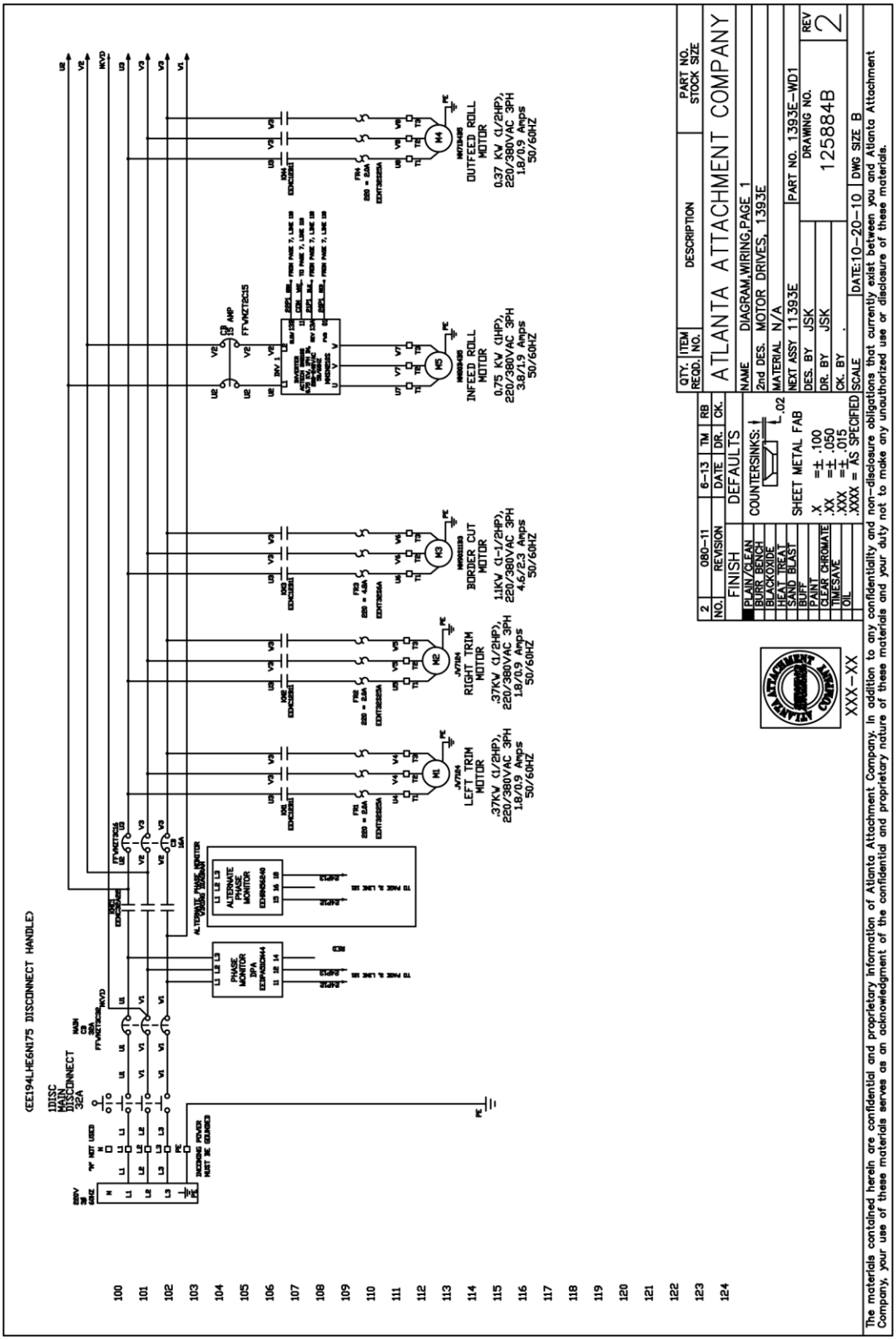
AAC Drawing Number 1388666 Rev 1

NO	QTY	PART #	DESCRIPTION
1	1	1388297	ADAPTER SHAFT, XCUT DRIVE
2	1	1388299	KEY, GEAR PULLEY
3	1	1393364	RETAINER WASHER
4	1	1393369	KEY, GEARMOTOR
5	1	EEPG16	CORD GRIP,CABLE ENTRY
6	1	MMRV5015D80	GEARBOX,WORM,RV50,15:1
7	1	MMYS801455	MOTOR,.55KW,IEC,B5,D80
8	1	SSSCM8X20	M8X20 SOC CAP
9	1	WWLM8	M8 LOCK WASHER

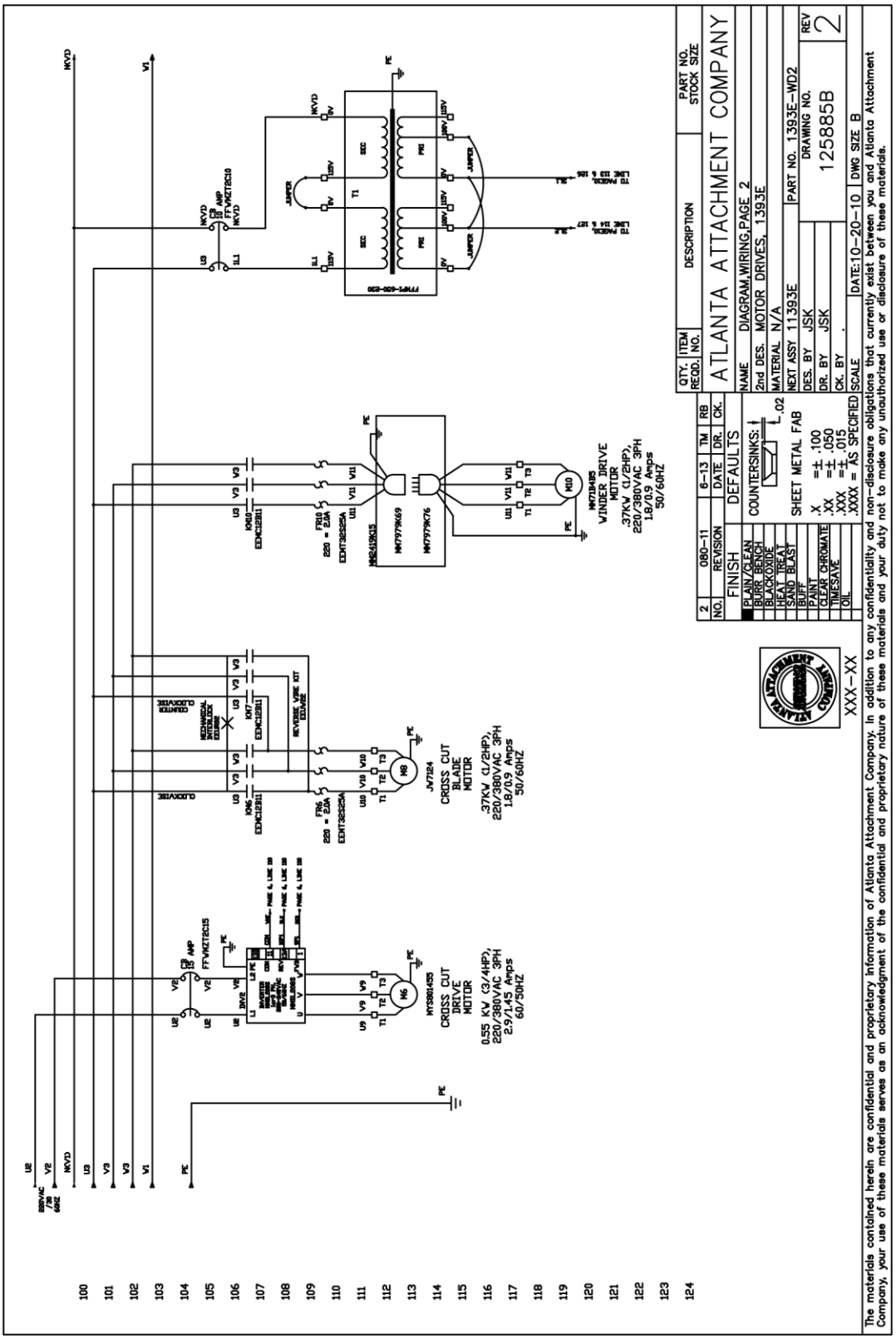
1393E-PD1 PNEUMATIC DIAGRAM



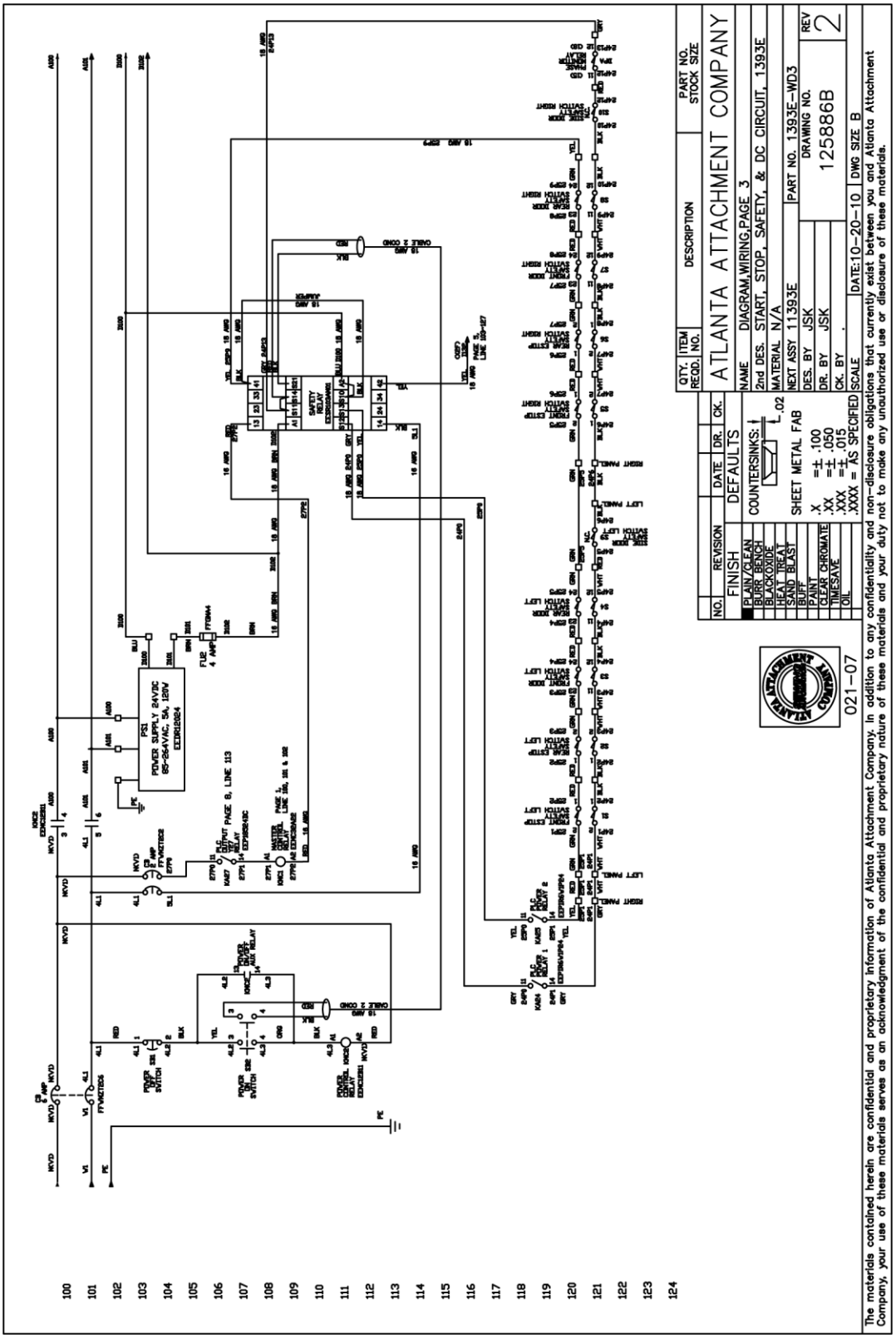
1393E-WD1 WIRING DIAGRAM, PAGE 1



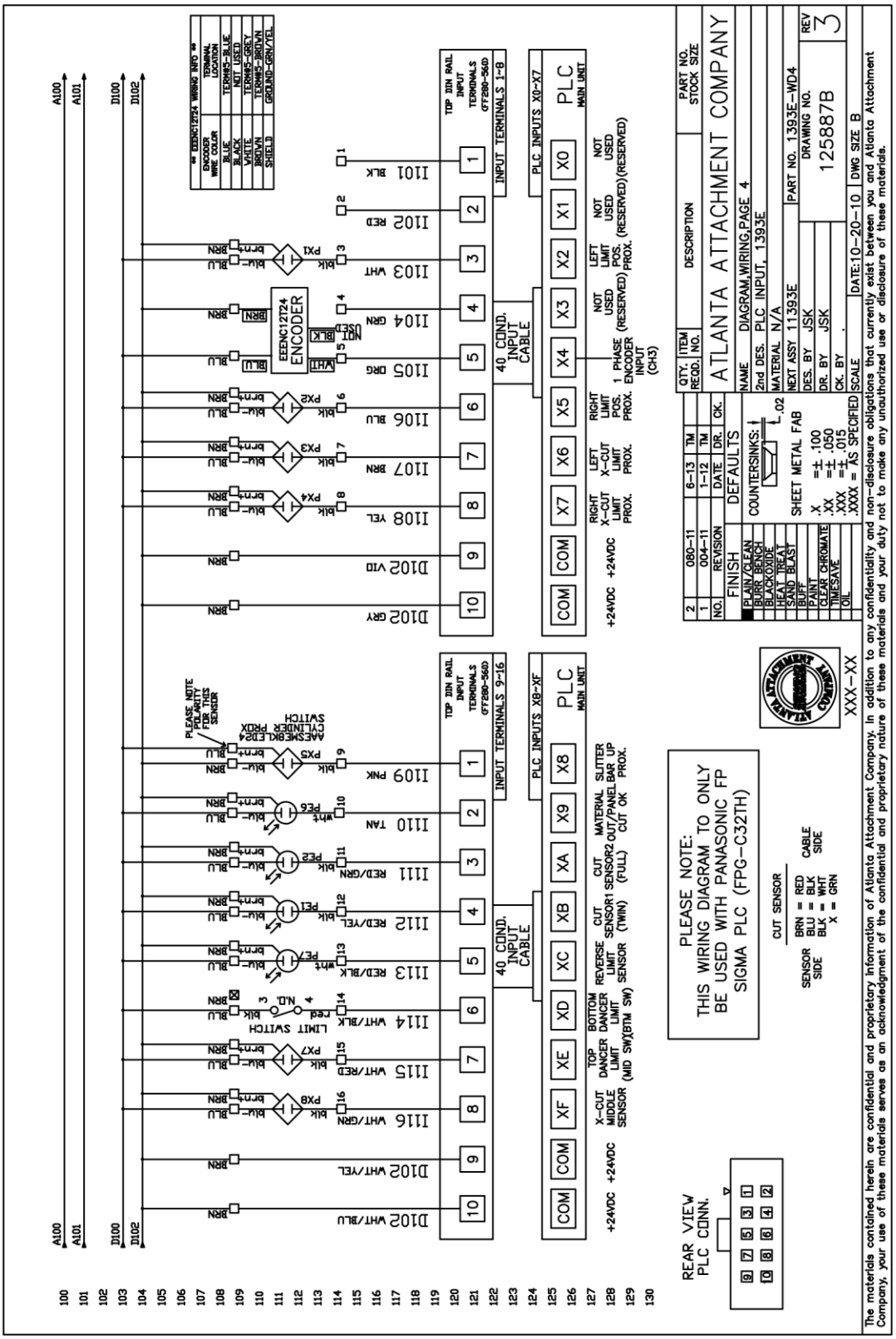
1393E-WD2, WIRING DIAGRAM, PAGE 2



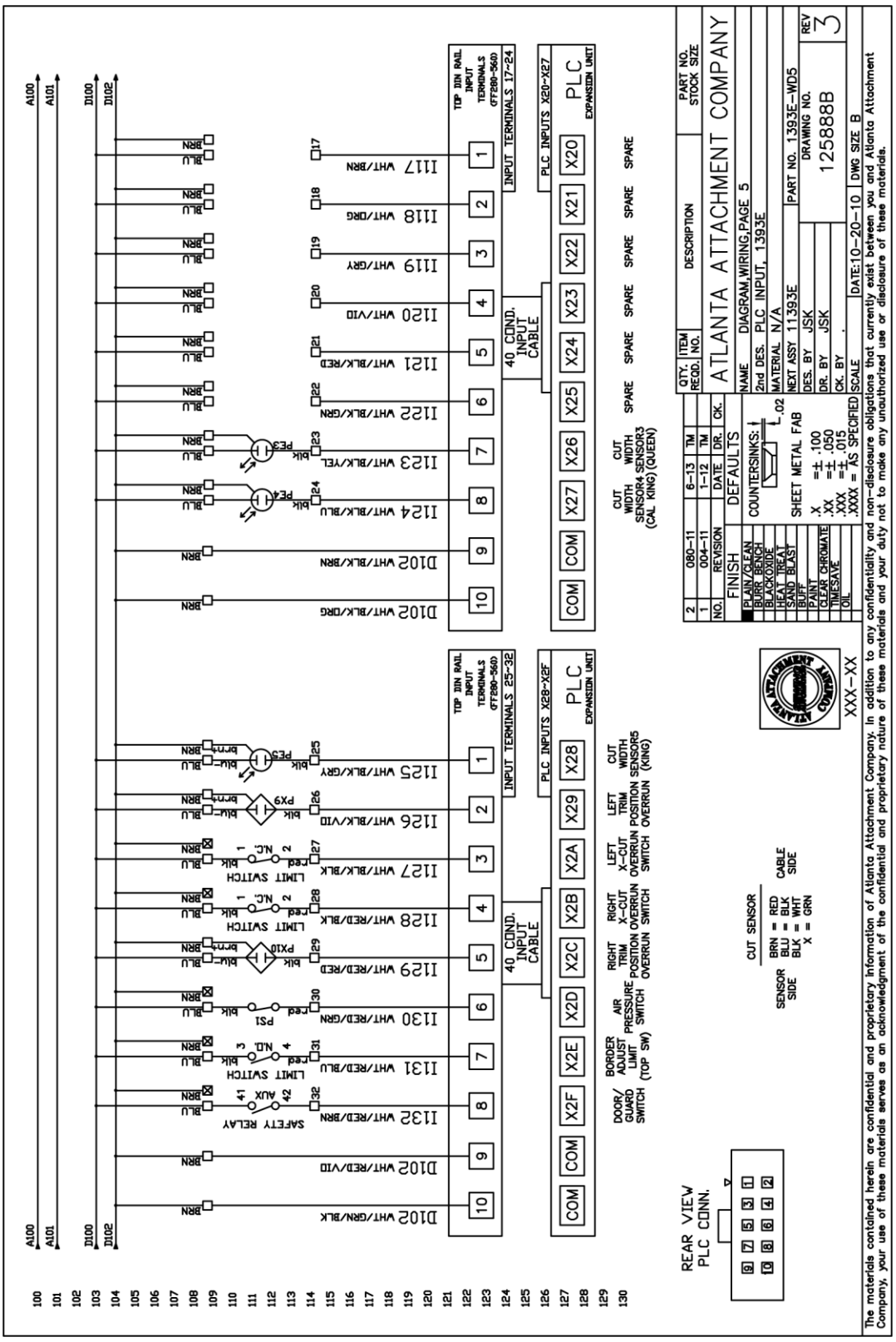
1393E-WD3, WIRING DIAGRAM, PAGE 3



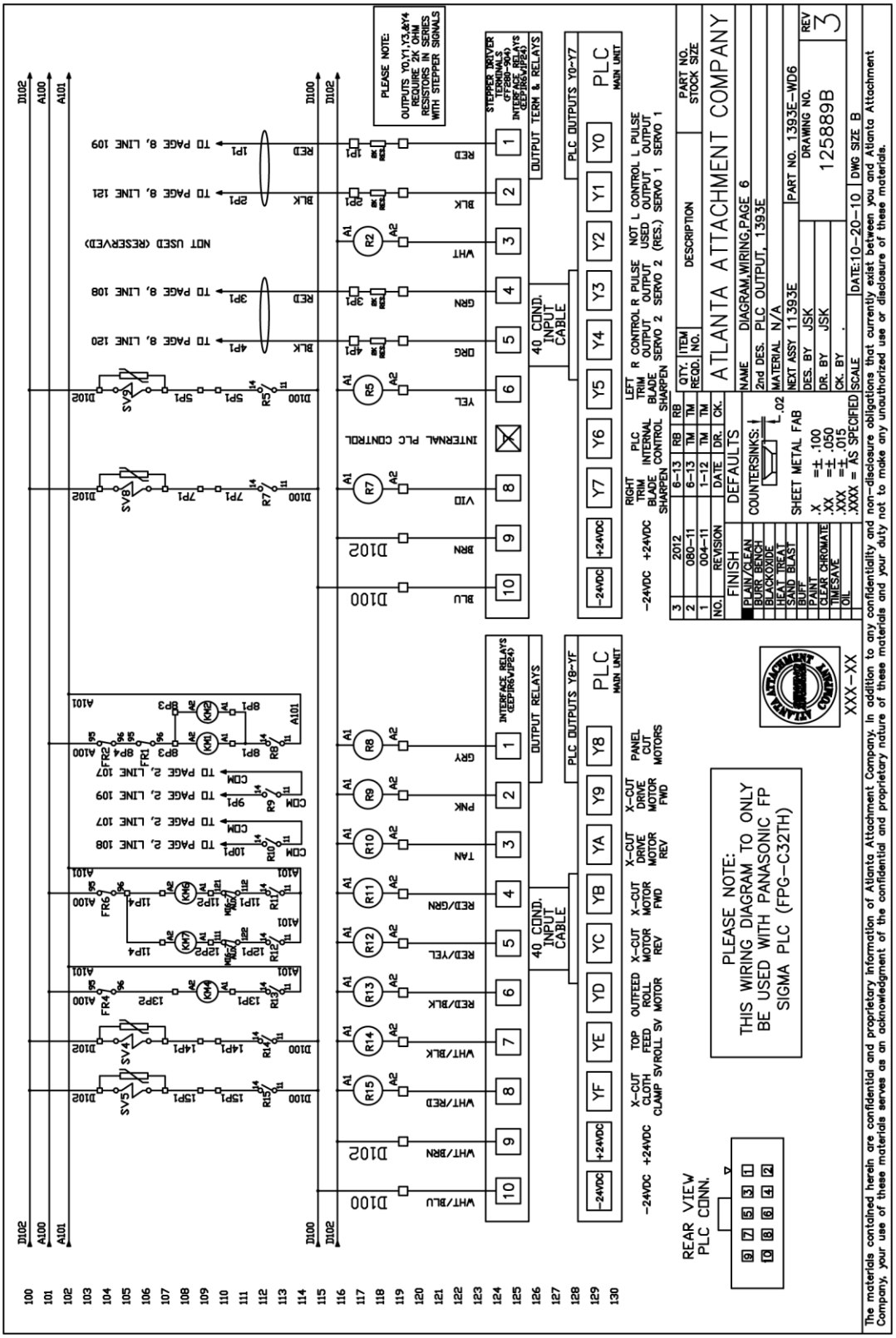
1393E-WD4, WIRING DIAGRAM, PAGE 4



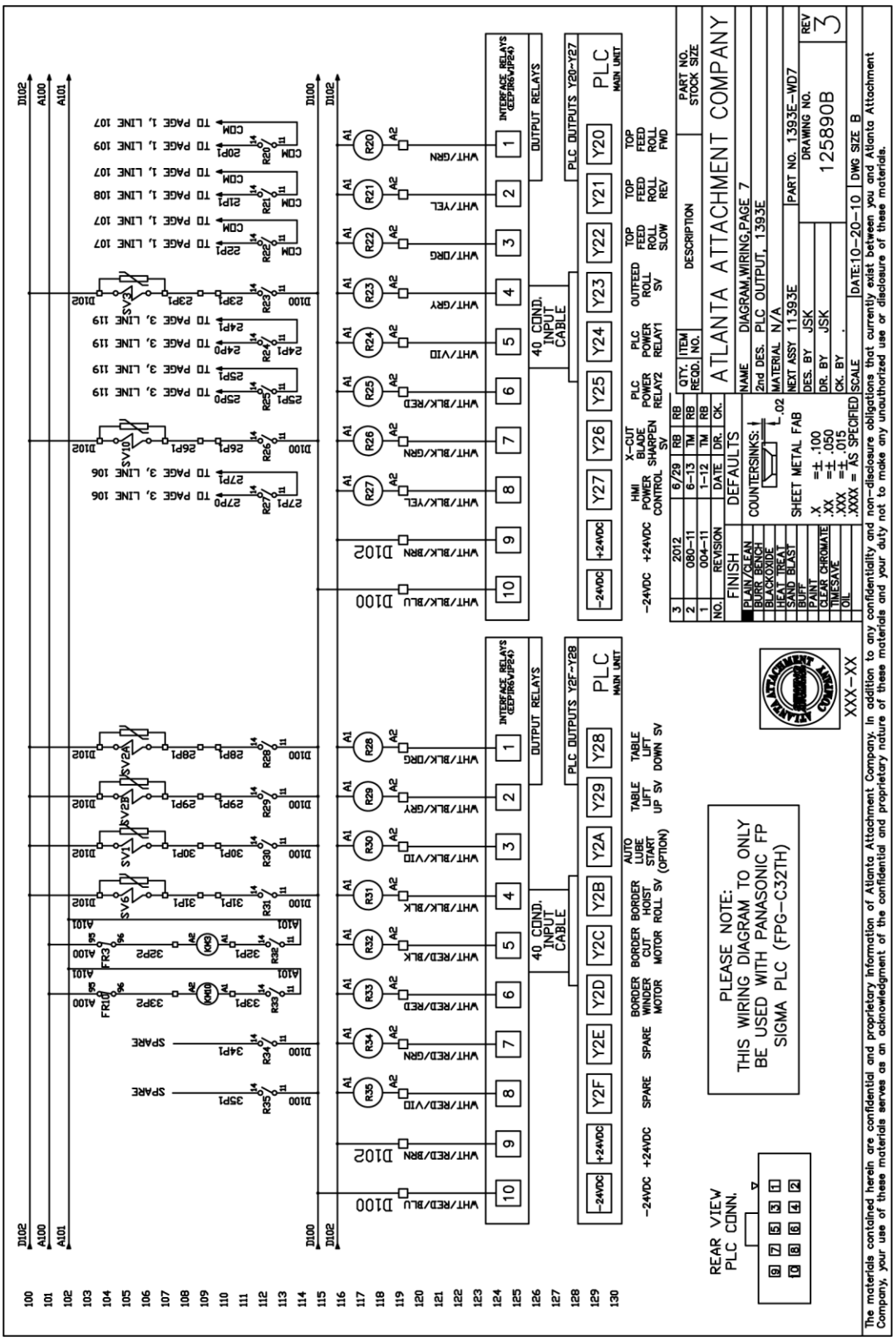
1393E-WD5, WIRING DIAGRAM, PAGE 5



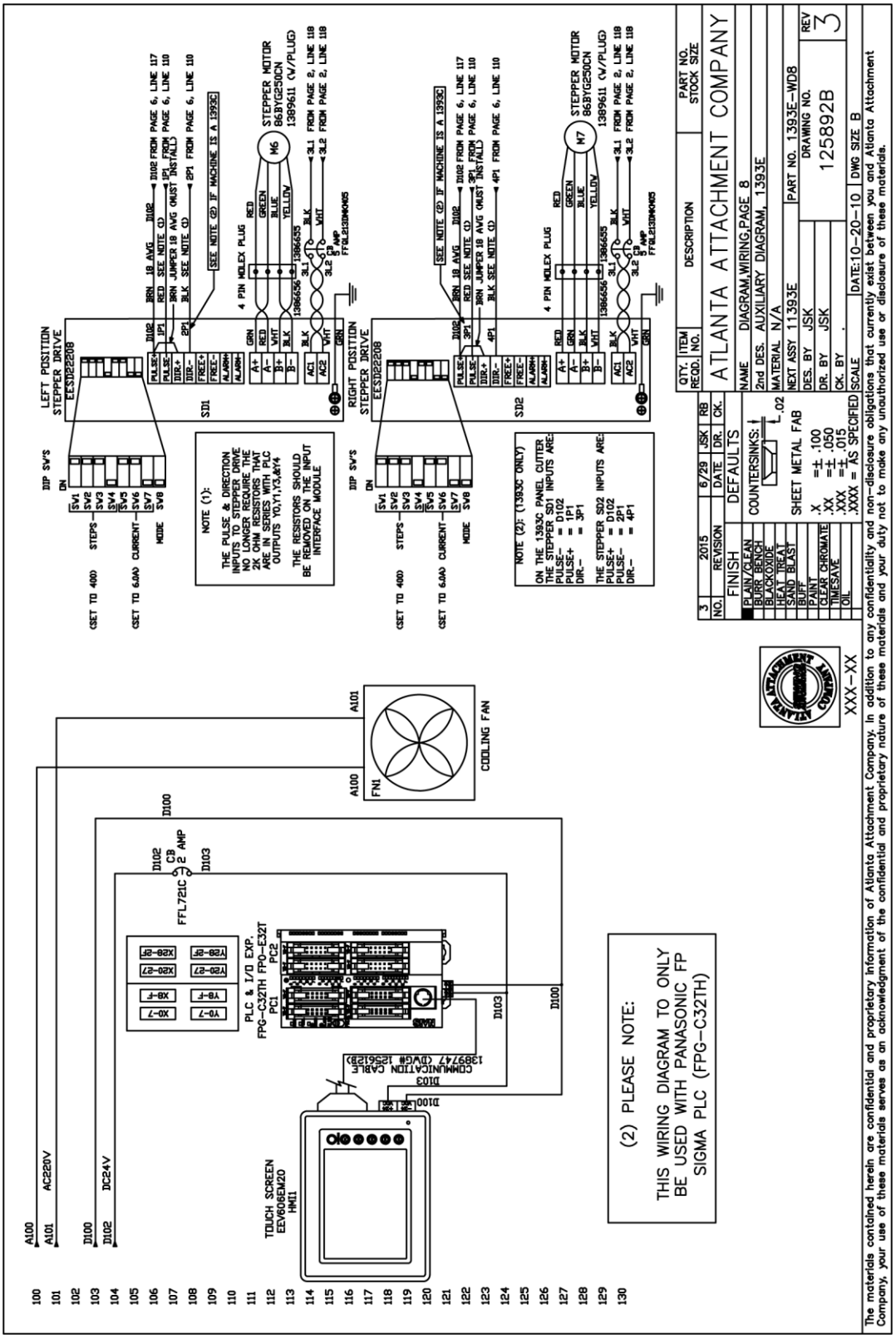
1393E-WD6, WIRING DIAGRAM, PAGE 6



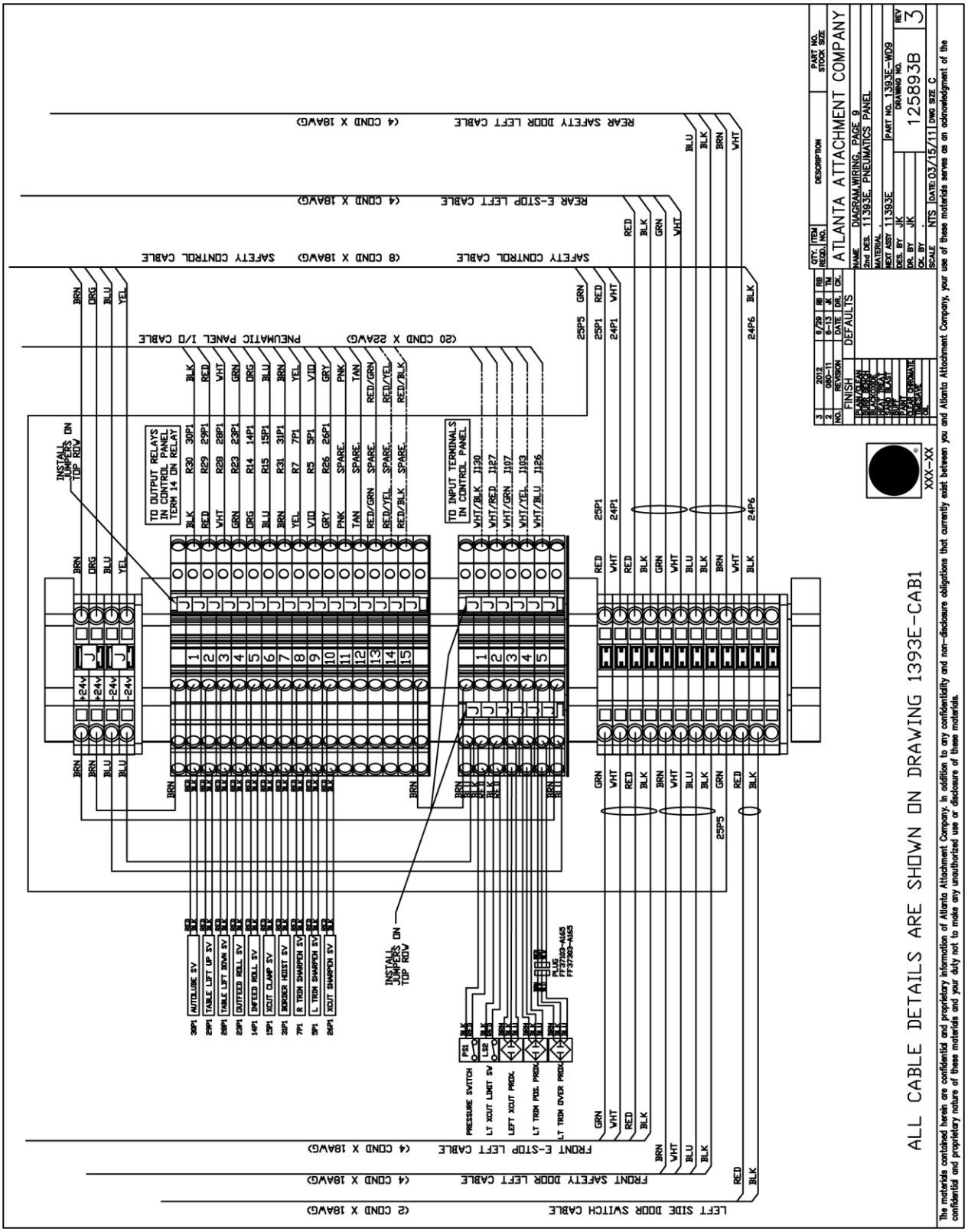
1393E-WD7, WIRING DIAGRAM, PAGE 7



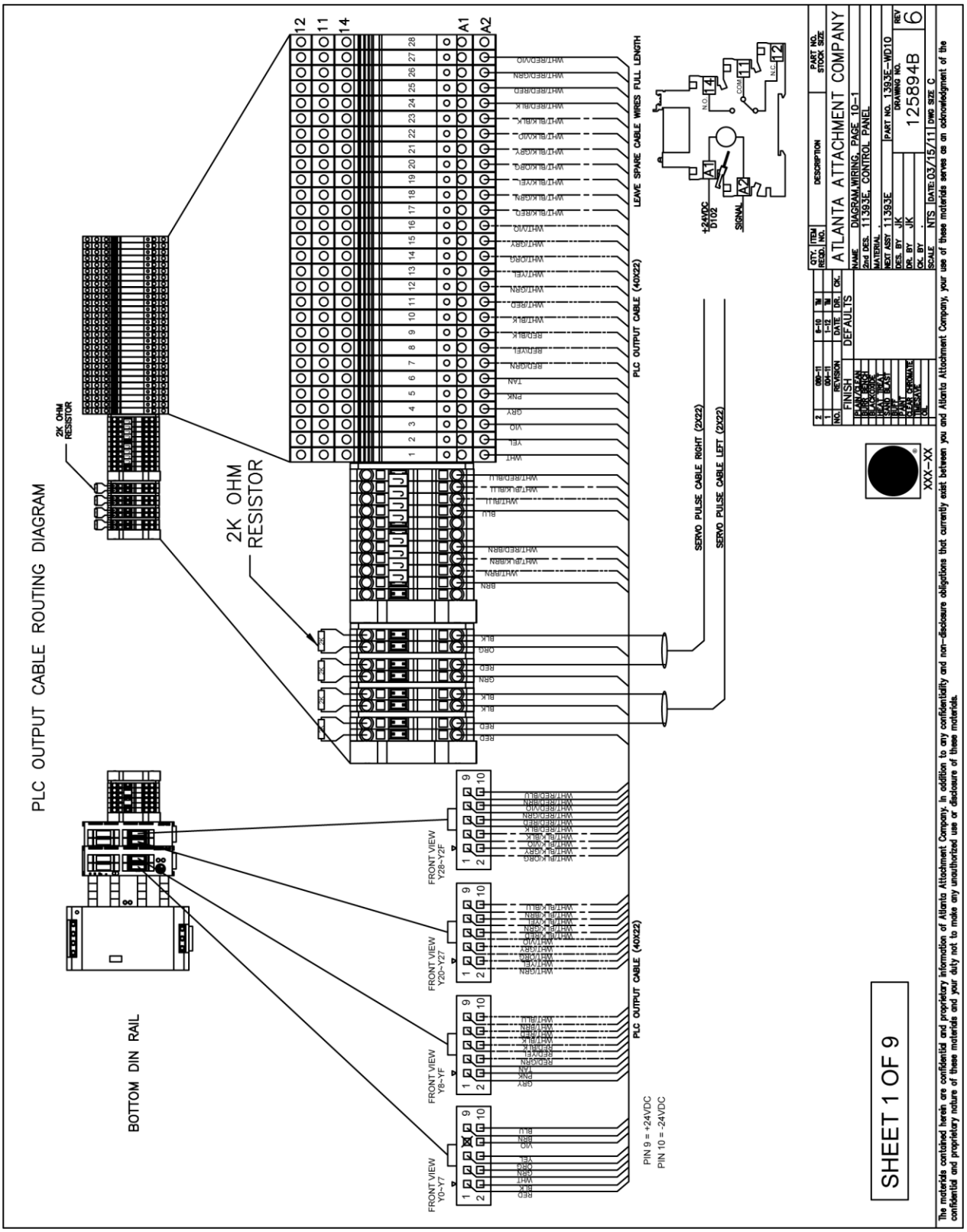
1393E-WD8, WIRING DIAGRAM, PAGE 8



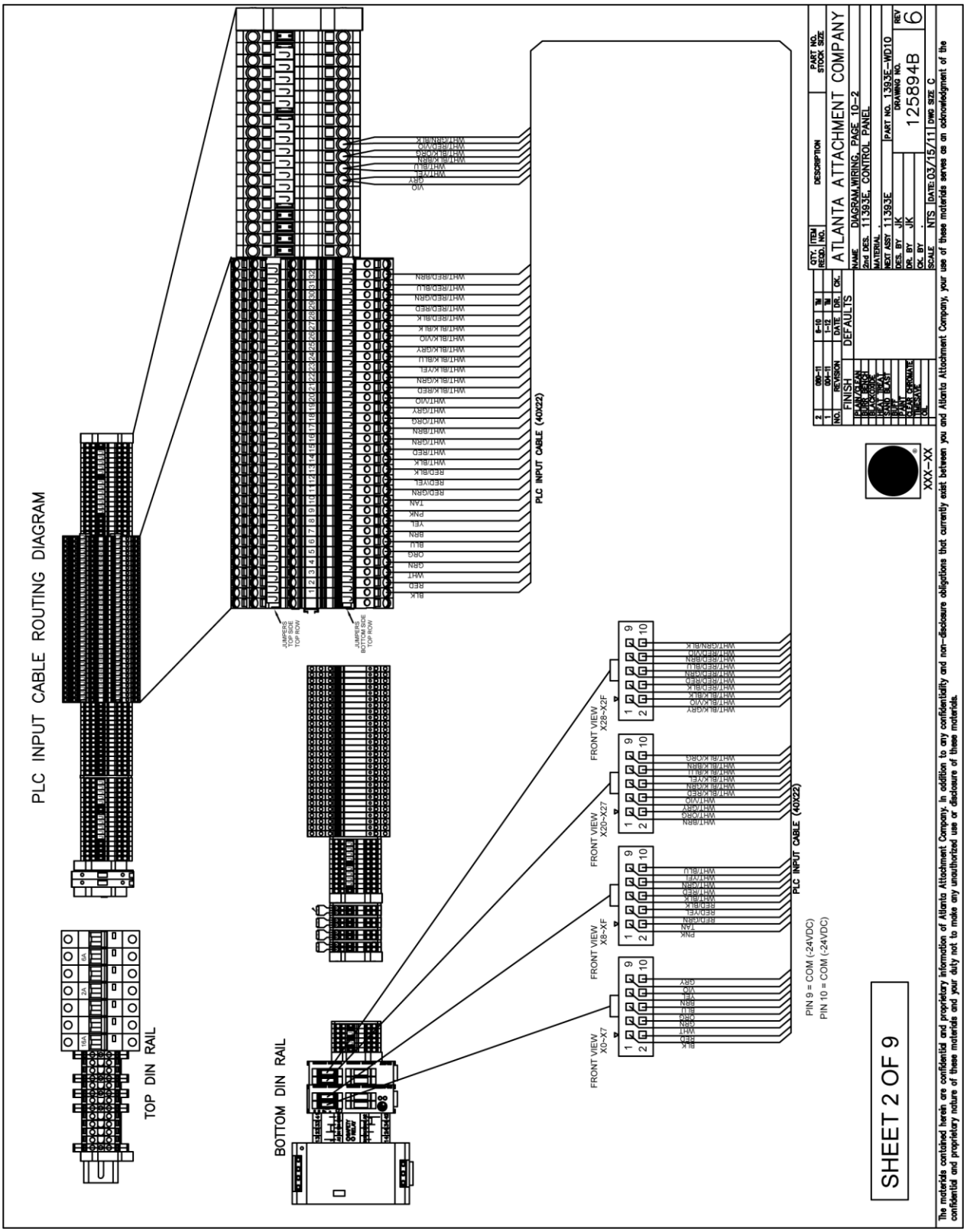
1393E-WD9, WIRING DIAGRAM, PAGE 9



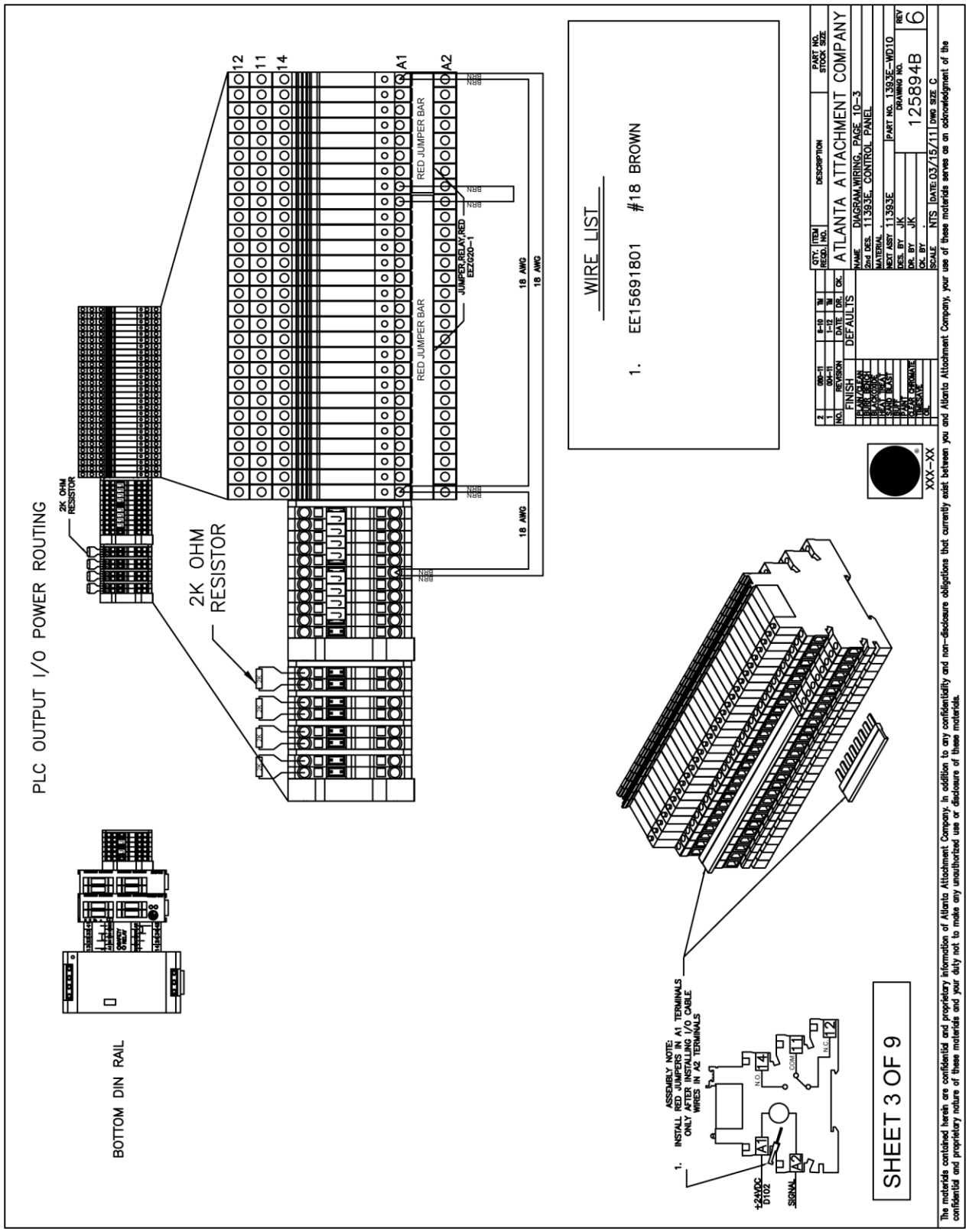
1393E-WD10, WIRING DIAGRAM, PAGE 10-1



1393E-WD10, WIRING DIAGRAM, PAGE 10-2



1393E-WD10, WIRING DIAGRAM, PAGE 10-3



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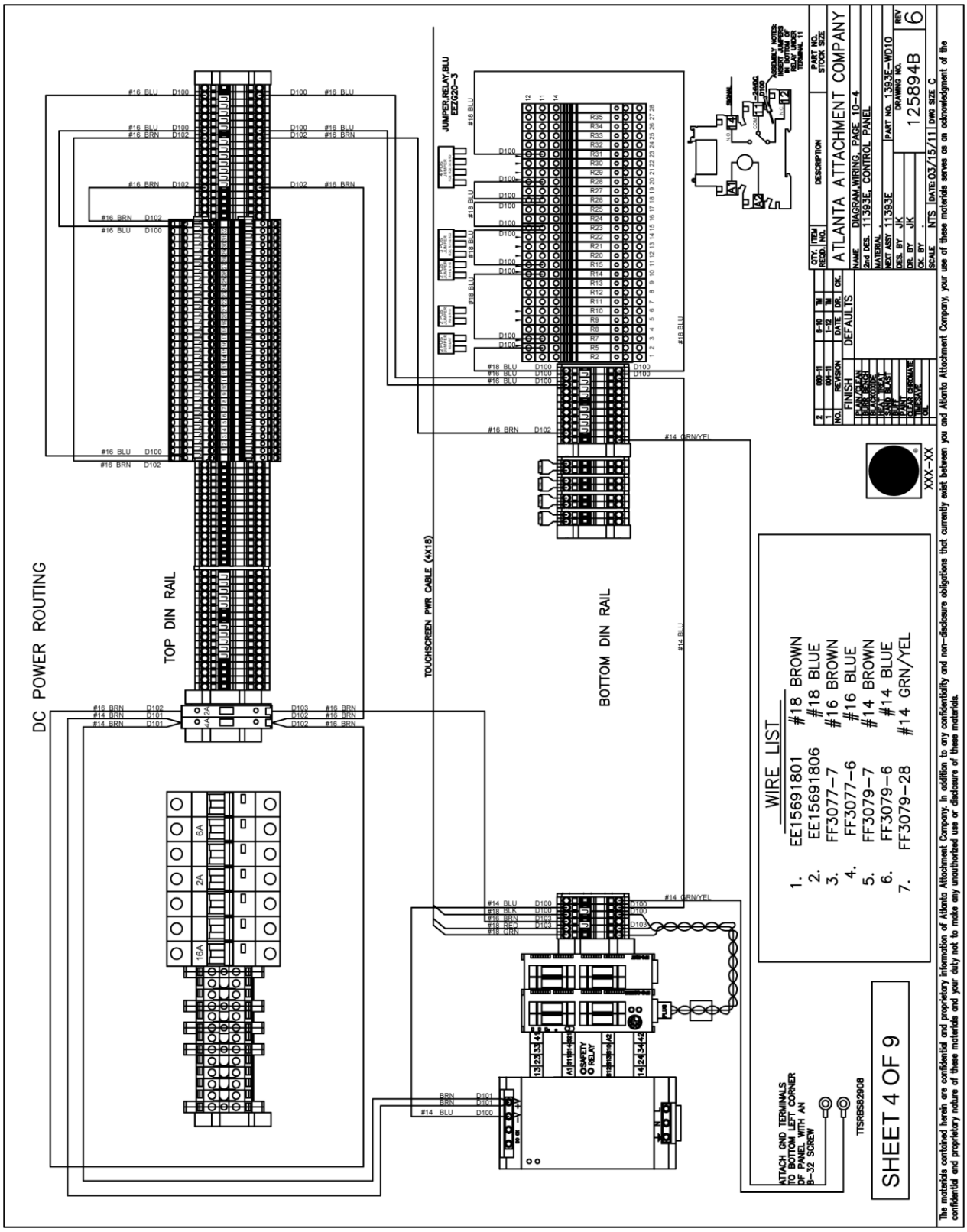
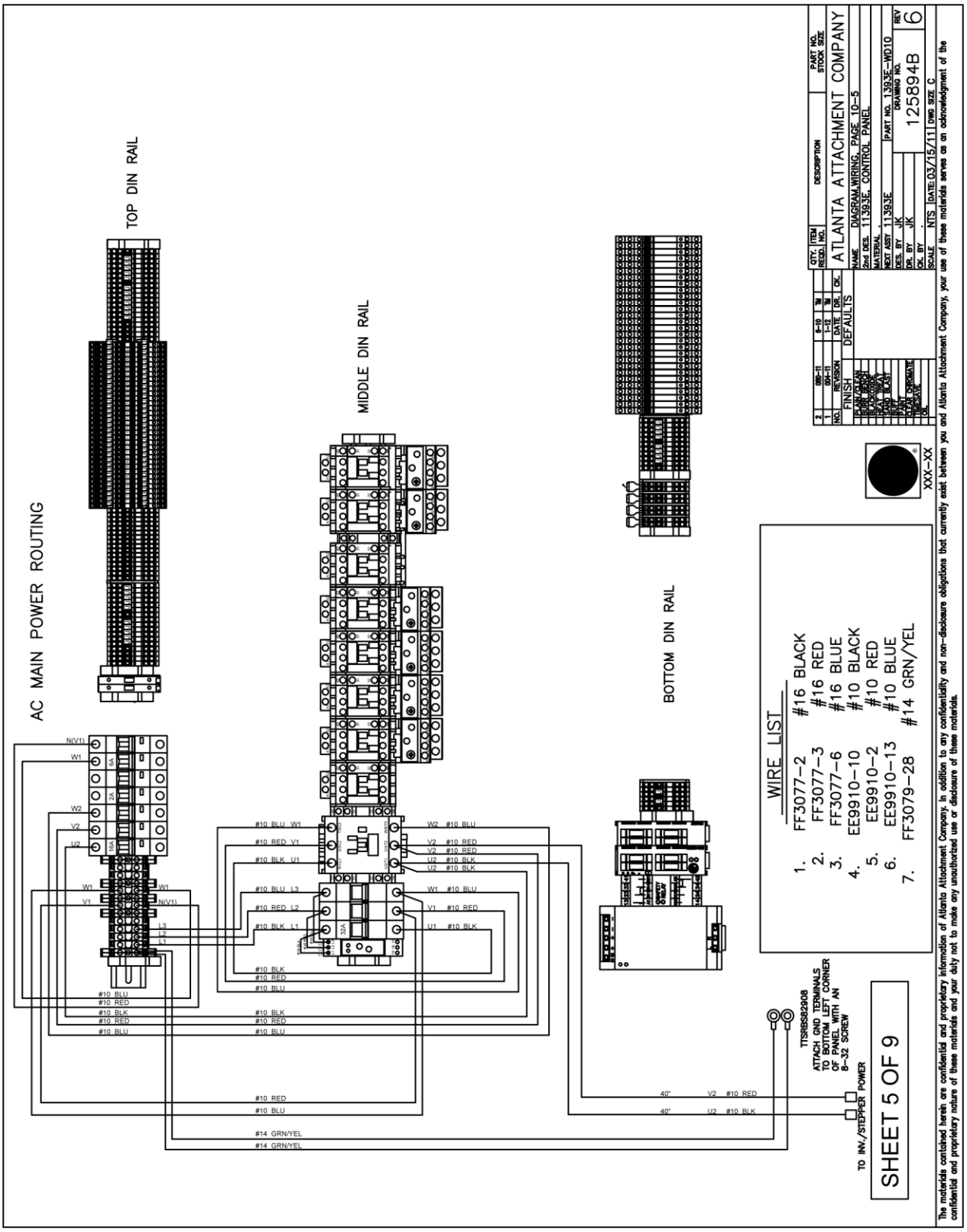
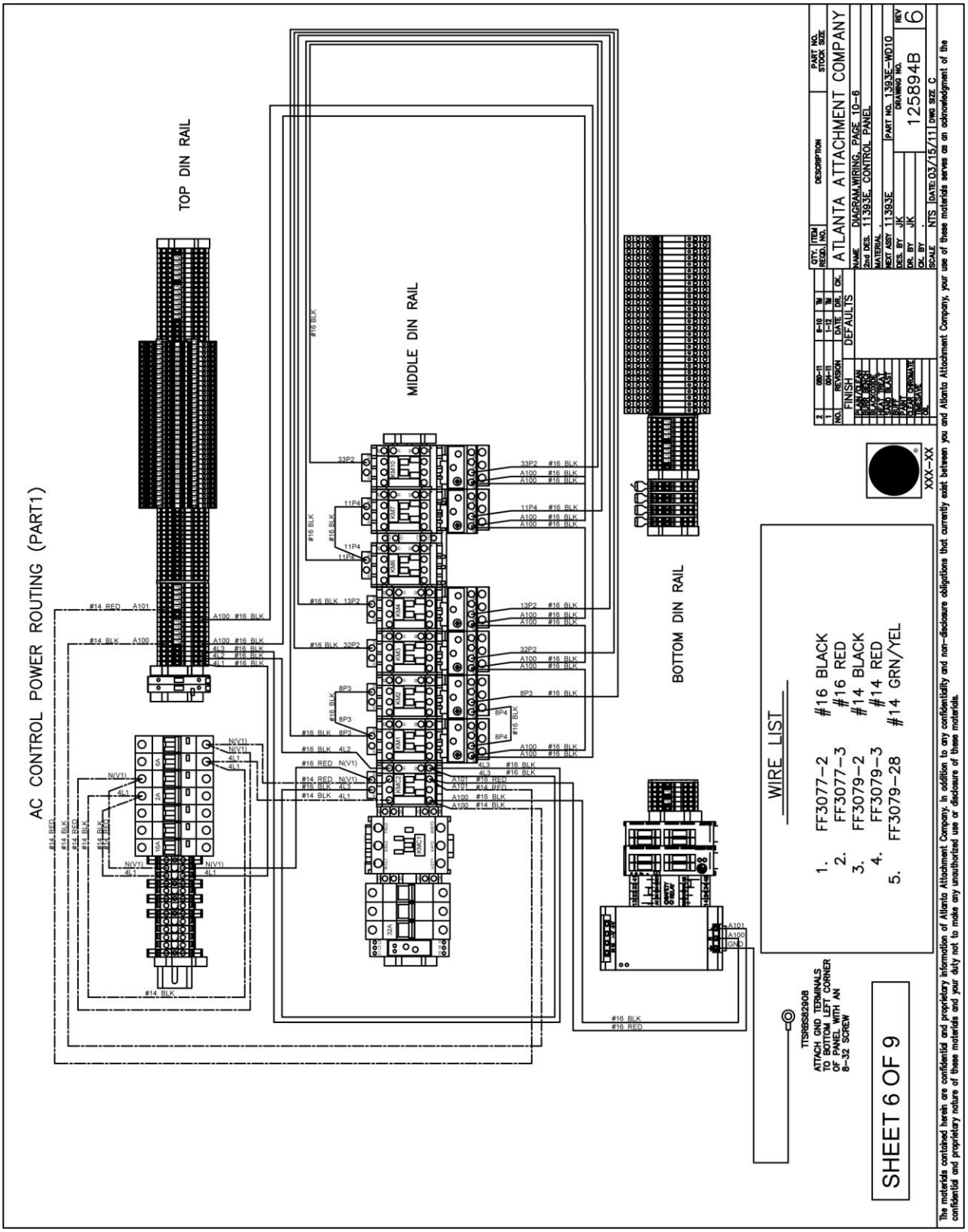
1393E-WD10, WIRING DIAGRAM, PAGE 10-4



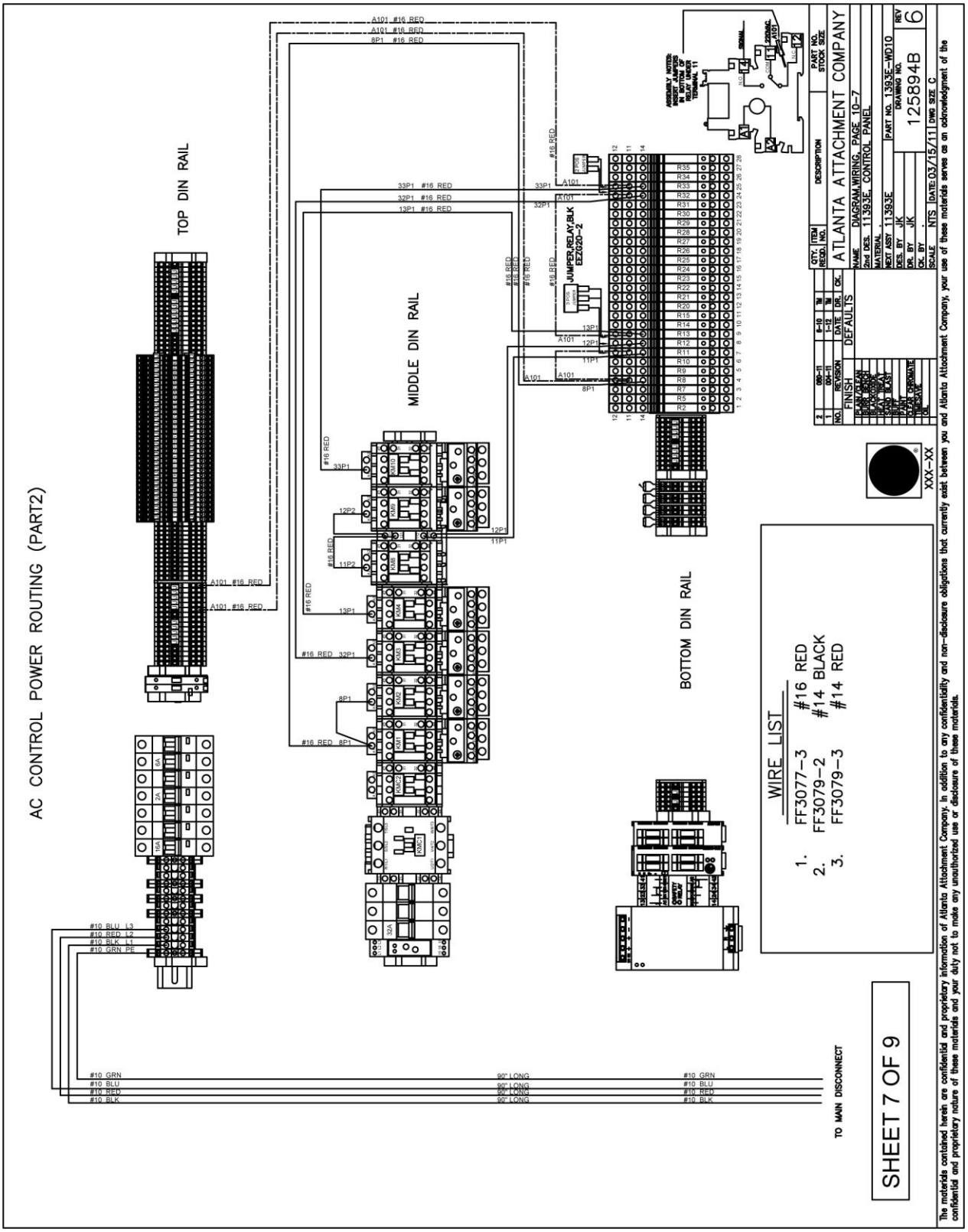
1393E-WD10, WIRING DIAGRAM, PAGE 10-5



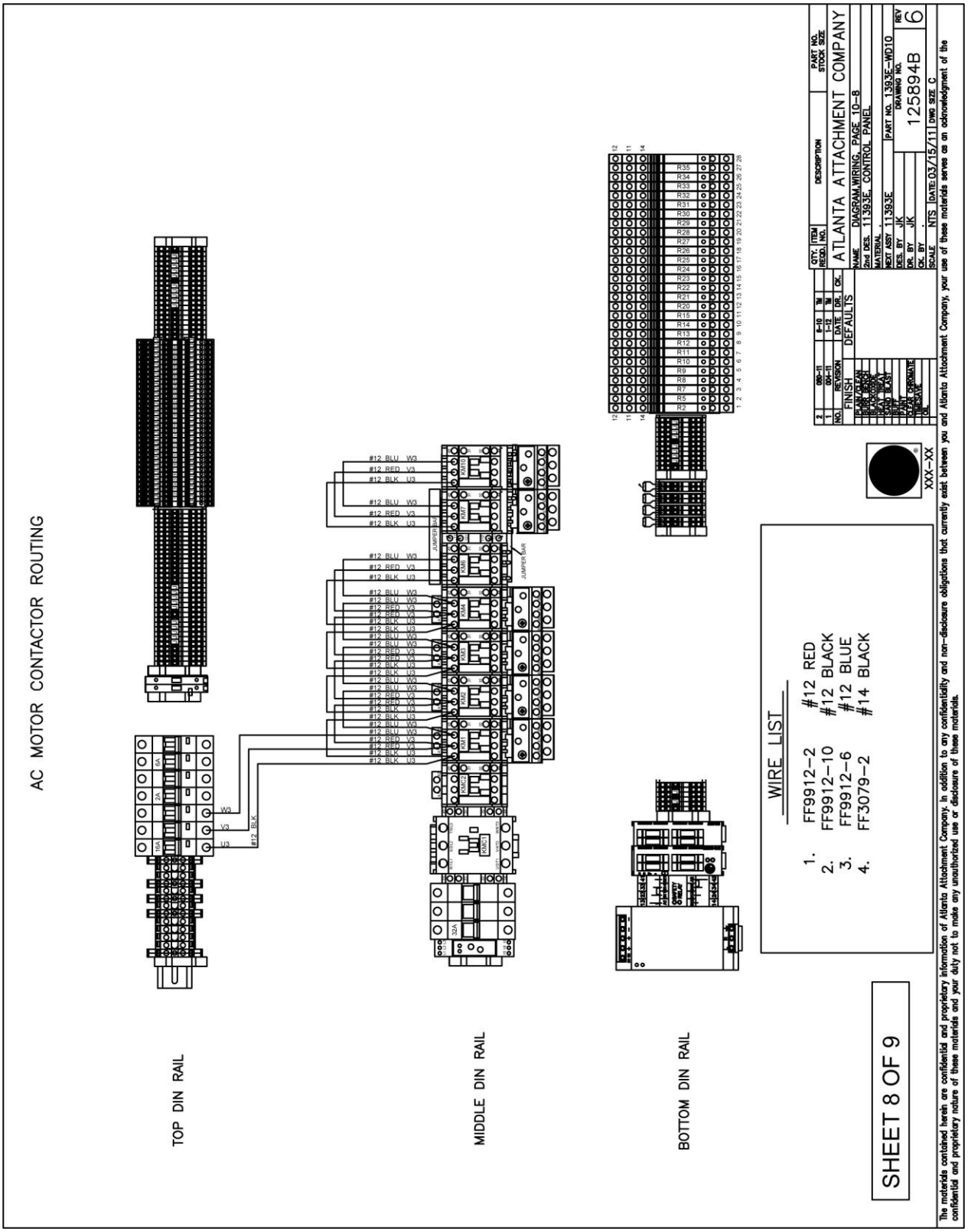
1393E-WD10, WIRING DIAGRAM, PAGE 10-6



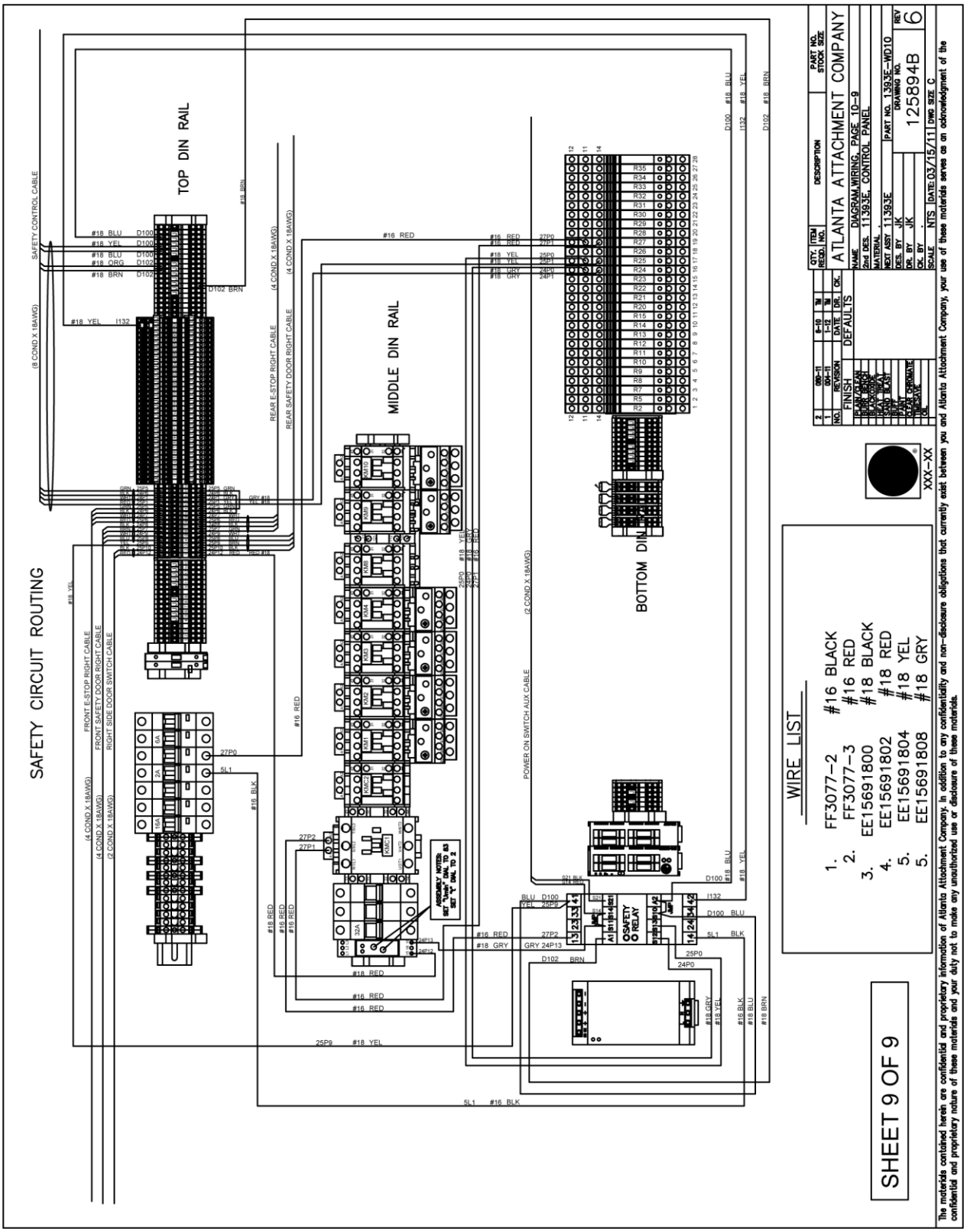
1393E-WD10, WIRING DIAGRAM, PAGE 10-7



1393E-WD10, WIRING DIAGRAM, PAGE 10-8



1393E-WD10, WIRING DIAGRAM, PAGE 10-9



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 período 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 debe ser confirmado por escrito.
- AAC se reserva el derecho de exigir el retorno de cada pieza defectuosa con un formulario de reclamo de garantía.
- AAC va, según su criterio, a reparar o reemplazar las máquinas o piezas defectuosas devueltas a AAC.
- AAC se reserva el derecho para tomar la decisión final sobre toda cuestión de garantía.
- Las garantías de AAC tiene una validez de ochocientas (800) horas o cien (100) días, cual llega primero.
- AAC garantiza la operación satisfactoria de sus máquinas en base de las normas aceptadas de la industria siempre y cuando se instale use y mantenga de forma apropiada.
- La garantía de AAC no puede ser cambiada o modificada y no está sujeto a cualquier otra garantía implicada por otro agente o distribuida 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 hayan sido manufacturados por AAC, son garantizados por un período de ochocientas (800) horas.
- Componentes mecánicos que fallen por defectos de materiales o de fabricación que hayan sido manufacturados por AAC, son garantizados por un período de ochocientas (800) horas.
- Componentes comprados (Motores, Cabezales) son protegidos debajo de la garantía del fabricante.
- AAC asistirá con el manejo de todo reclamo de garantía bajo la garantía del fabricante.

Lo Que No Está Garantizado

- Falla de repuestos a raíz de uso incorrecto, falta de mantenimiento, lubricación o modificación.
- Daños ocurridos a raíz de mal transporte, accidentes, incendios o cualquier daño como resultado de servicio por personas no autorizados o instalaciones incorrectas de conexiones eléctricas o neumáticas.
- Desgaste normal de piezas como correas, anillos de goma, cuchillas, agujas, etc.
- Ajustes de la máquina en relación a las aplicaciones de costura y/o la operación en general de la máquina.
- Gastos de Reparaciones fuera de las instalaciones de AAC
- Pérdida de tiempo, ingresos potenciales, y/o ganancias.

Daños personales y/o daños a la propiedad como resultado de la operación de este equipo

Technical Manual & Part List

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