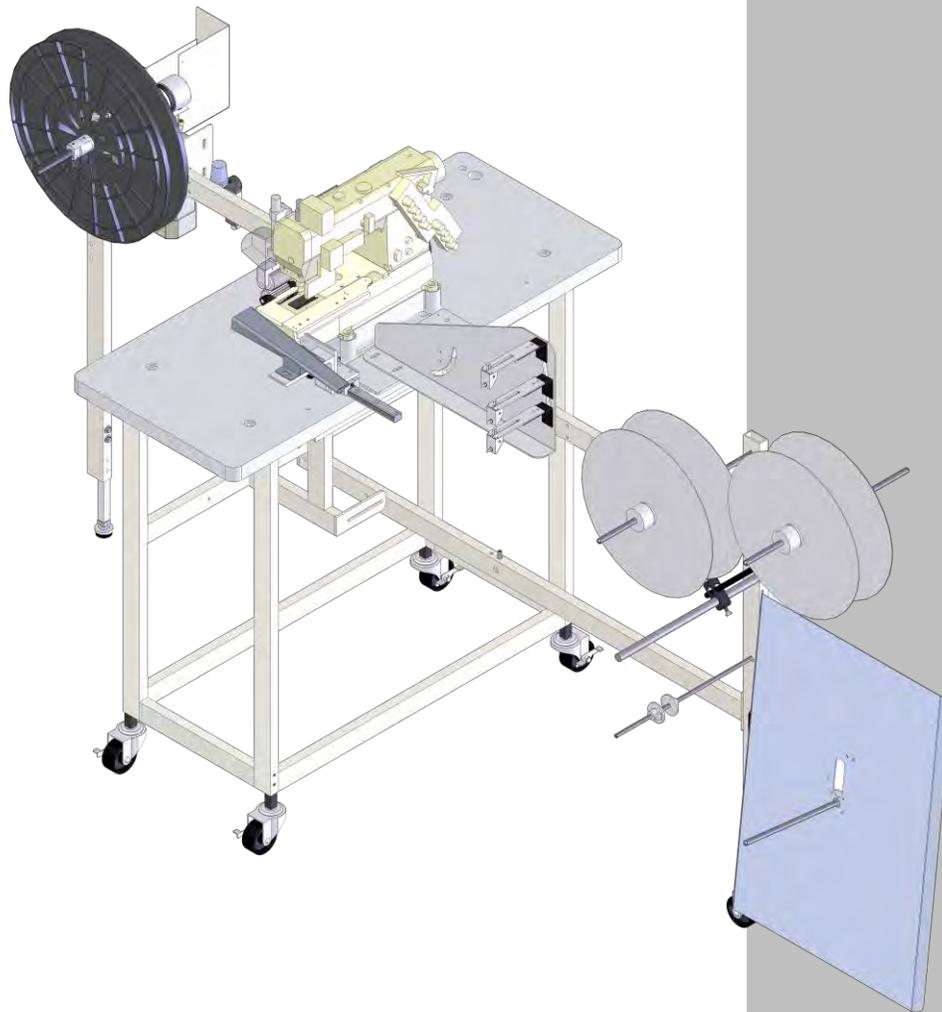




Model **1959Y28B**

Revision 11.3 Updated Oct 3, 2012

Technical Manual & Parts Lists



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ATLANTA ATTACHMENT COMPANY, INC.

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

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

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Important Safety Instruction



This part of the Instruction Material is provided for the safe use of your equipment. It contains important information to help work safely with the unit and describes the dangers inherent in machinery. Some of these dangers are obvious, while others are less evident.

Mandatory Information

All persons operating and/or working on the 1959Y28B Automatic Handle Workstation should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include;

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

Intended Use

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

Exclusion of Misuse



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

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

Liability

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

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

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

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

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

Choice and Qualification of Personnel

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

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

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines



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

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

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

Damage

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

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

Faults or Errors

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

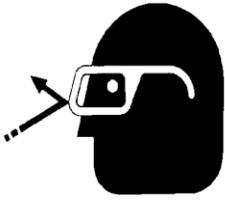
Signs on the Machine

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

Clothing, Jewelry, Protective Equipment

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

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

The following fire extinguishers may be used:

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

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

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

Electrical Power Supply



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

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

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

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

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

- Kinetic energy - Note that some motors or spindles, for example, may continue to run or coast run on after being switched off.

- Potential energy - Individual assemblies may need to be secured if necessary for repair work.

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

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

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

Workplace Environment

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

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

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

Protect against unauthorized access.

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

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

Local Regulations

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

Maintenance

General Safety Instructions

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

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

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

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

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

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

Repair

Replacement Parts

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

Repair, Electrical

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

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

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

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

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

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

Ventilation/Hazardous Gases

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

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

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

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

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

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

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

1959-K2 Miter Knife

Installation

Please read this entire manual before operating this machine.

Refer to installation drawings and wiring diagrams.

Place the Miter unit behind the sewing unit and bolt together with the U shaped bracket provided. Align the slack arm and feeding rollers up with the centerline of sewing. Lock the casters in place.

Wire the power cord (220VAC, single phase) to the same on/off switch as the sewing machine so that it turns on and off with the sewing machine switch.

Connect the RUN cable to a N.O. set of dry isolated contacts (relay or air-elect switch) that will remain closed while the sewing unit is running.

Connect the STOP cable (N.O. relay contacts) to the sewing units thread break circuit or stop circuit so the Miter unit can stop the sewing when it has completed its preset piece count.

Connect air supply line to the Miter units FRL. Set to 80 PSI.

Place collection boxes behind machine to hold cut handles and trimmings.

Control Functions:

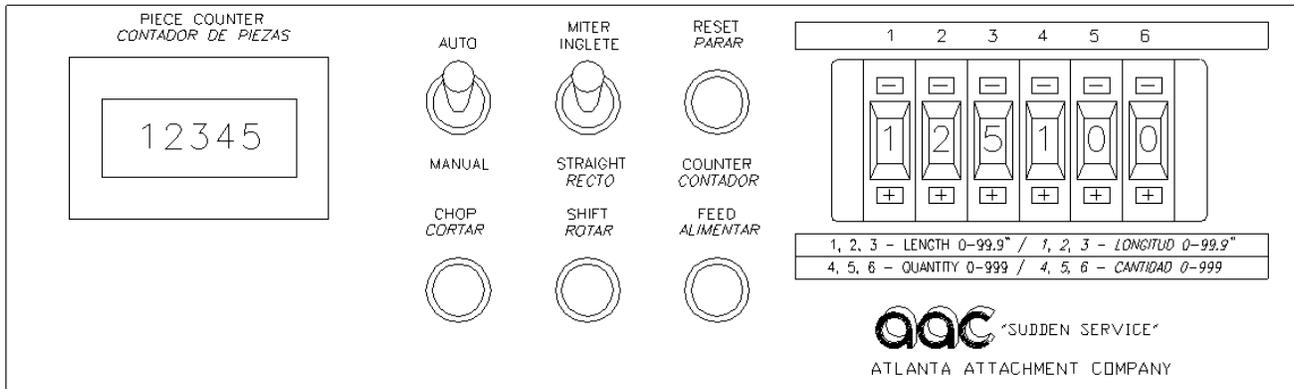
Stepper Motor Control Box:



The stepper motor control box powers the motor on the material feeder. On the rear of the box there is a power on/off switch, a fuse holder, a JOG socket, a MOTOR socket, and a SYNC socket. The feed motor plugs into the MOTOR socket. A cable from the computer box plugs into the JOG socket, and the SYNC socket has no connection. Leave the on/off switch ON all the time except when servicing the inside of the box. The box will turn on and off with the main on/off switch. On the front of the box there is a JOG button, a SPEED control knob, a POWER on indicator lamp, and three thumbwheel switches. Pressing the JOG button will run the feed motor. The SPEED knob is a 10 turn potentiometer preset to 85% of full speed. This is the maximum recommended speed for the feed motor. Adjust (if necessary) the speed of the sewing machine feeding this machine so that this machine can feed and cut handles

faster than they are being sewn. The thumbwheel switches have no function on this machine. Inside the box are DIP switches to set motor current and direction. The motor current is set for 2 amps and the direction is set to CW. Do not change these settings.

Computer Control Box:



The rear of the computer box has an on/off switch, a fuse holder, and the sockets for all input and output cables. Leave the on/off switch ON all the time except when servicing inside the box. Refer to the wiring diagram for proper connection of all the cables. On the front of the box are thumbwheel switches, toggle switches, push buttons, and a piece counter which control all the functions of the machine.

The AUTO/MANUAL switch selects the operation mode of the machine. In MANUAL the only functions available are manual CHOP which activates the knife, manual SHIFT which toggles the knife (in MITER mode) left and right, and FEED which turns on the feed motor the same as the JOG button on the Stepper Control Box. Use MANUAL mode to disable the Miter unit while servicing the sewing unit. The SHIFT button has no function in STRAIGHT mode.

The MITER/STRAIGHT switch selects the cutting mode for the knife. In MITER mode the knife will cut a 120 degree point on the handle material by cutting, shifting, and cutting a second time after each feed cycle. In STRAIGHT mode the knife must be locked in its detent and will cut only once after each feed cycle. Switching from MITER to STRAIGHT mode will remove air pressure from the shift cylinder so it can be moved to its locked position. When switching from STRAIGHT to MITER mode it is necessary to release the lock detent by pulling up on the lever and rotating the lever to the locked up position, then press RESET to restore air pressure to the shift cylinder and move the knife to its HOME position.

The RESET button is use to reset the knife to its HOME position and reset the PIECE counter. It must be pressed after power on to enable the AUTOMATIC functions and after changing any switch or thumbwheel settings.

The PIECE counter displays the number of pieces cut since the last RESET.

The THUMBWHEELS set the handle length and the quantity of handles cut in each batch. The first three thumbwheels set the handle length in tenths of an inch. Example: a setting of 125 equals a handle approximately 12.5" long. The length is not exact and must be adjusted as necessary to achieve the correct length. The last three thumbwheels set the desired number of pieces to be cut in a batch. At the end of this count the machine will send a stop signal to the sewing machine and no more pieces will be cut until the RESET button is pressed to reset the PIECE counter and restart the automatic cycle.

Operation:

Be sure sewing unit is not sewing.

Set thumbwheels to desired Length and Quantity counts.

Turn on all on/off switches on the Miter unit (main, stepper box, and computer box).

Switch unit to AUTO, select MITER or STRAIGHT mode, press RESET.

Feed handle strap through the slack arm ring and up to the feeder. Press FEED and allow the feeder to feed material past the knife. Press CUT and the machine will trim the first end of the handle. Remove scrap material.

Run the sewing machine and allow one handle to be cut. Stop sewing. Check the length of the handle and adjust the thumbwheels as needed. Restart the sewing. The slack arm will stop the Miter unit whenever there is not enough material to make a handle. The sewing speed must be adjusted so that the Miter unit stops and waits for the sewing to catch-up before feeding the next handle. THE SEWING UNIT MUST NOT RUN FASTER THAN THE MITER UNIT.

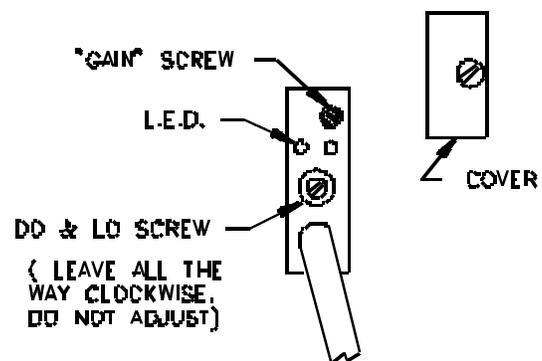
When the Miter unit has completed cutting its preset number of pieces it sends a STOP signal to the sewing unit. To start the next batch, press RESET and restart the sewing unit.

If the Miter unit is running without material present, switch it to MANUAL mode to stop it.

Electric Eye Sensor Adjustment

To adjust the sensor, first remove the clear plastic cover from the end of the sensor. There are two adjusting screws under the cover. One is labeled "GAIN" and is used to set the sensitivity of the sensor. The other screw is labeled "DO & LO" and should always be fully clockwise.

With the end of the sensor pointing at the center of the reflective tape, turn the "GAIN" screw counter-clockwise until the red LED indicator is off. Then turn the "GAIN" screw clockwise until the LED indicator comes on. Then turn the "GAIN" screw one full turn clockwise. The LED indicator should be blinking slowly. Cover the eye so that the sensor cannot see the reflective tape and the LED should go off.



Reflective Tape Maintenance

Use a soft cloth for cleaning.

Do not use chemicals or abrasives to clean it.

Avoid any contact with oils and liquids.

Do not touch the tape with bare fingers.

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

1959K3-Parameters

PARAMETER	RANGE (default)	VALUE	DESCRIPTION
290	0-24 (5)	0	Mode of operation. MUST SET THIS PARAMETER FIRST!
100	0-254 (2)	002	Number of soft start stitches
110	0-200	185	POSITION SPEED
111	200-9900 rpm	130(1300)	Maximum speed when "129" is 0, 1, or 2.
115	70-1500	050	Soft start speed
116	70-1500	185	Trimming speed
134	0-1 (0)	1	Soft start enable
161	0-1 (1)	0=CW	Motor rotation
180	0-360 (175)	045	Degrees reverse run goes to get to needle up
181	0-999 (10)	10	Delay till reverse run starts after trim
182	0-1 (0)	1	Enable reverse run after trim to get to "true" needle up
202	0-500 (50)	250	Start sew delay after footlift turns off
204	1-100% (40)	100	F/L solenoid holding power, 100% = maximum
207	1-55 (20)	40	LOW SPEED BREAKING
208	1-55 (30)	40	HIGH SPEED BREAKING
254	1-100% (100)	100	Upper limit for 204
270	0-5 (0)	1	External handwheel sensor configuration.
271	0-255	142	Needle down position for under trimmer (red dot @ wht dot)
272	020-255 (100)	75	Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111. (For Yamato and Pegasus, setting should be 100; for Rimoldi, setting should be 124)
436		0	Use code "5913". This disables an input that was causing box to reset itself.

Front panel LED's:

- LED 1: Off
- LED 2: Off
- LED 3: Off
- LED 4: Off
- LED 5: Off
- LED 6: Off
- LED 7: Off, Stop at needle down.
- LED 8: On, Stop at needle up.

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "311"
3. Press "E" once and "2.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E".
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.

8. Run sewing head to save parameters before powering down

To Perform Master Reset of Parameters:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "591"
3. Press "E" twice and "093" is displayed.
4. Press "+" once, "094" is displayed.
5. Press "P" to exit programming mode with all default values.

Recommended Spare Parts List

AAC Part # SP1959 Spare Parts Kit

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	66601	Looper	5	1	ZX3825	V Belt
2	2	66621	Retainer	6	1	ZX3836	V Belt
3	1	099A	Single Level Parts List	7	1	ZX3837	V Belt
4	2	FF313500	Fuse, 1/2A				

Contact AAC's sales department to order replacement parts.

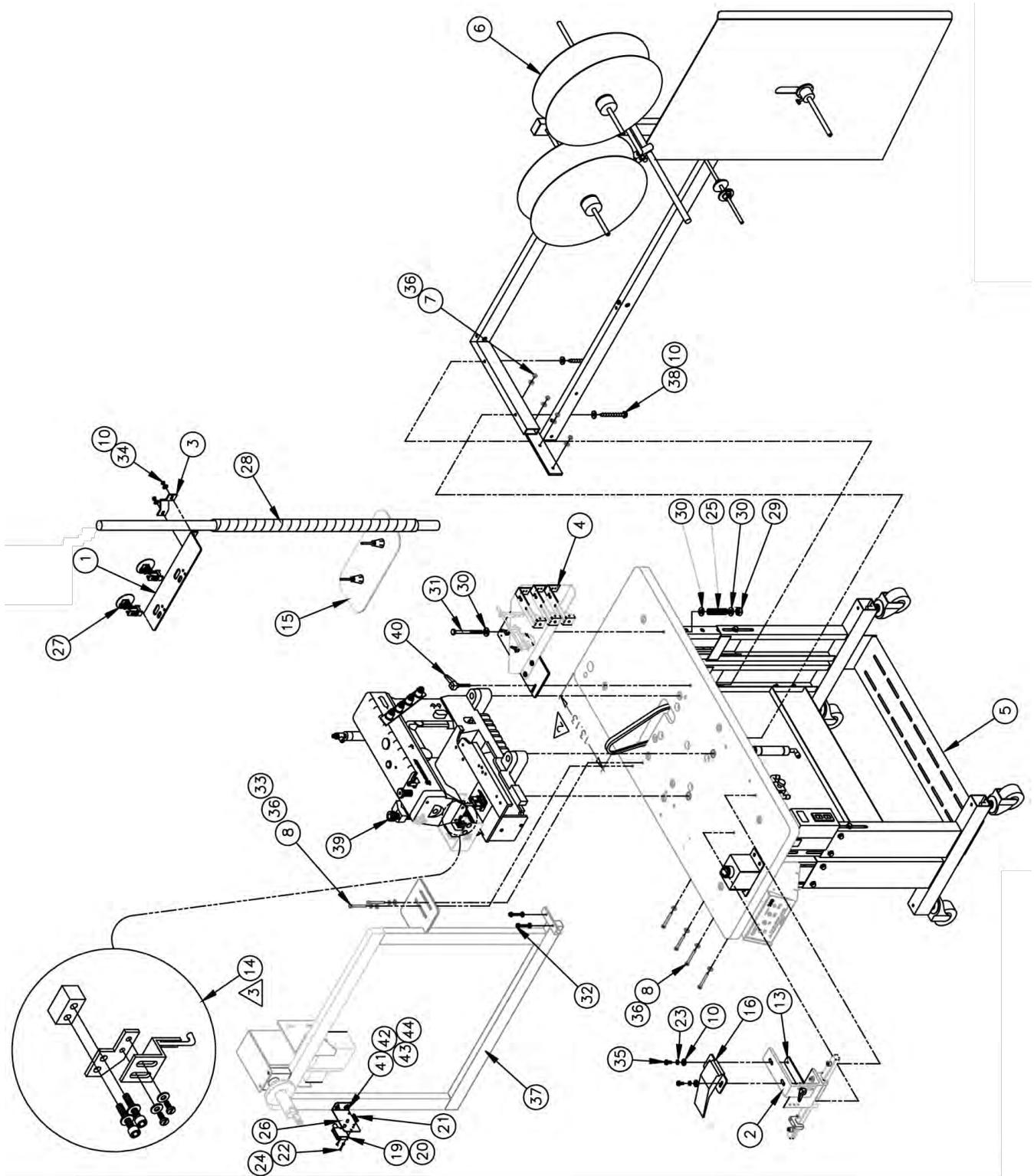
Phone: 770-963-7369
Fax: 770-963-7641
Email: sales@atlatt.com
Website: www.atlatt.com

Assembly Drawings & Parts Lists

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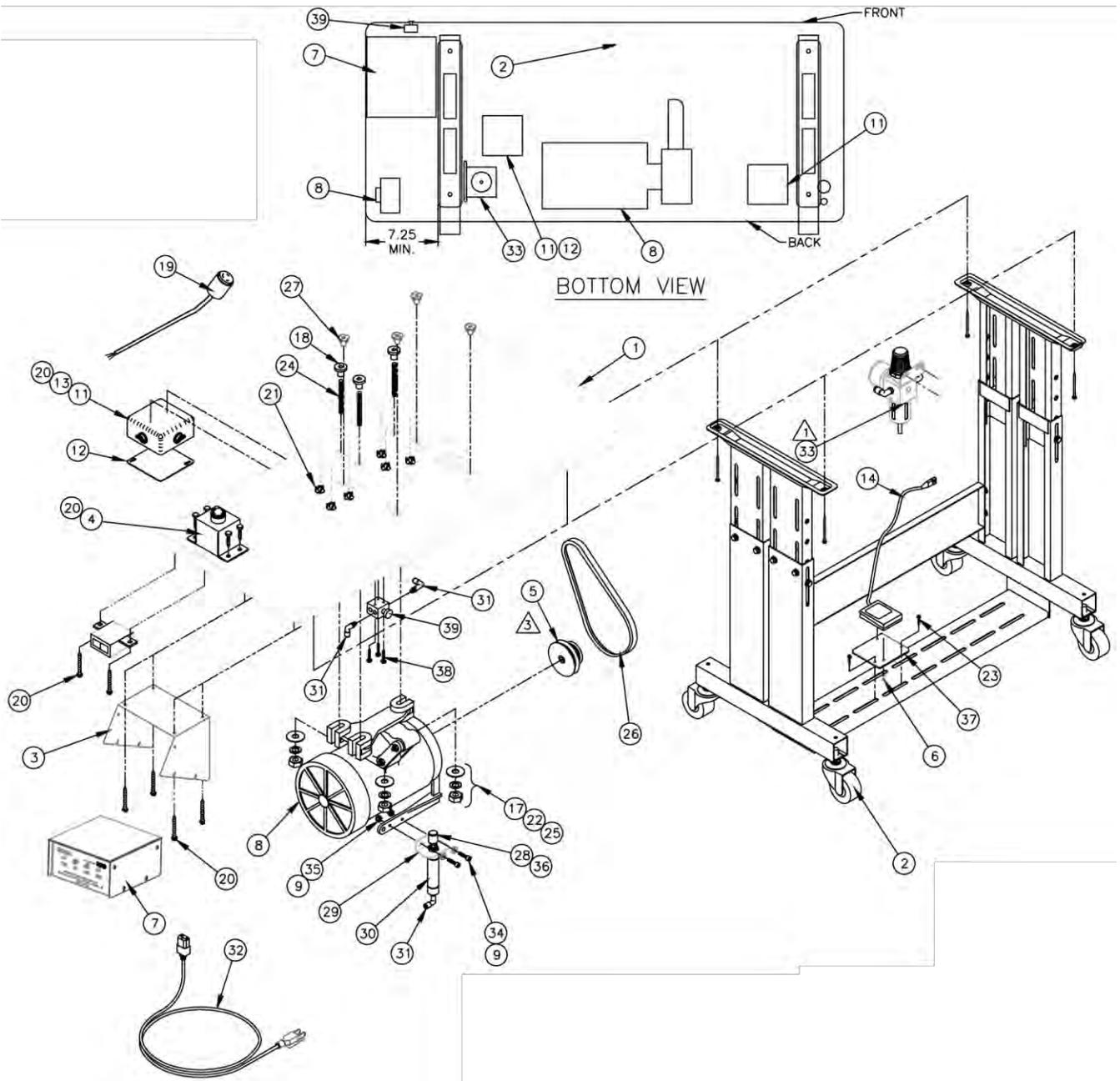
One-Stop Shopping
For Expendable Replacement Parts for AAC & Other Bedding Equipment Suppliers
Toll Free: **1-866-885-5100**
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11959Y28B Auto Handle Sewing Unit

AAC Drawing Number 192738C Rev 9

NO.	QTY	PART #	DESCRIPTION	
1	1	0411-069B	THREAD BRK. BRKT.	
2	1	1334-1100B	FOLDER MOUNT ASSY.	Page 27
3	1	0411-070	SONSOR BRKT CLAMP	
4	1	1959-050	MATERIAL CONTROL ASSY.	
5	1	1959-700	TABLE & STAND ASSY.	Page 19
6	1	1959039	ROLL HOLDER ASSY.	Page 24
7	4	NNK1/4-20	KEP NUT	
8	6	SSHC01128	HEX CAP SCREW	
9	1	AA2000F-03	FLOW CONTROL	
10	8	WWFS10	FLAT WASHER, SAE	
11	AR	1959-PD	PNEUMATIC DIAGRAM	Page 30
12	AR	1959-WD	WIRING DIAGRAM	Page 31
13	1	1959-015	NUT PLATE	
14	REF	1959-111	AIR WIPER ASSY.	Page 25
15	1	1959-112	2 POS THREAD PLATE ASSY.	
16	AR	1959-018	FOLDER W/ MOUNT PLATE	
17	1	4003-MA3/FE	CABLE 8FT	
18	AR	4003-MA4/FE	ADAPTOR, 4 M TO 1 F	
19	1	FFRK44T-4	12" PLUG CABLE	
20	1	FFQM42VN6A	ELECTRIC EYE	
21	1	1975-412A	NUT PLATE	
22	2	WWF4	FLAT WASHER	
23	2	WWL10	LOCK WASHER	
24	2	SSPS70048	PAN SLOTTED SCREW	
25	1	273-4F	SPRING	
26	1	1959-009	PROX EYE BRKT	
27	2	4003-IS3WT2	THREAD BREAK SENSOR	
28	1'	AATPWL1	WIRE LOOM	
29	1	NNE3/8-16	ELASTIC LOCK NUT	
30	3	WWF3/8	FLAT WASHER	
31	1	SSHC25224	HEX CAP SCREW	
32	2	SSZH#10064	HEX SHEET METAL SCREW	
33	2	WWL1/4	LOCK WASHER	
34	2	SSPS98024	PAN SLOTTED SCREW	
35	2	SSPS98032	PAN SLOTTED SCREW	
36	10	WWF1/4	FLAT WASHER	
37	1	1961-320N	REWIND ASSEMBLY	
38	2	SSZH#10192	HEX SHEET METAL SCREW	
39	1	1334-1000A	SEWING HEAD ASSY.	Page 26
40	1	TTH34323	THREADED HANDLE	
41	2	SSHC01096	HEX CAP SCREW	
42	4	WWFS1/4	WASHER	
43	2	WWL1/4	LOCK WASHER	
44	2	NNH1/4-20	HEX NUT	



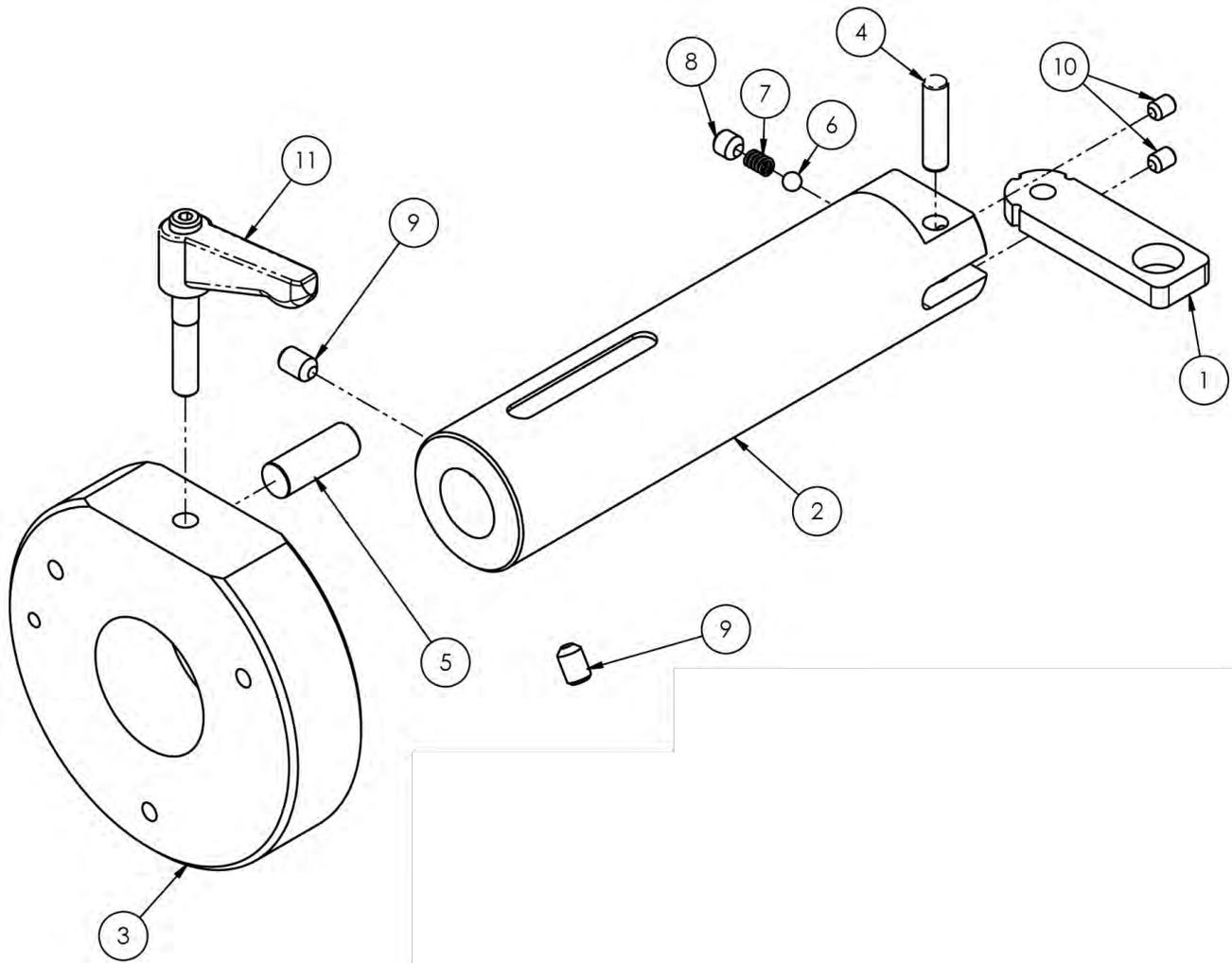
1959-700 Table and Frame Assembly

AAC Drawing Number 192738C Rev 9

NO.	QTY	PART #	DESCRIPTION
1	1	1959-004	TABLE TOP
2	1	K-4D	STAND
3	1	1959-120	MNT BRKT
4	1	213-005Y	STOP BUTTON
5	1	PPM615	PULLEY
6	2	SSFC80016	FLAT ALLEN SCREW
7	1	4000D-500	CONTROL BOX
8	1	4058-2	MOTOR
9	4	WWFS1/4	FLAT WASHER SAE
10	4	SSZH#10192	SHEET METAL SCREW
11	2	K-233	ELEC. BOX
12	2	K-234	COVER
13	5	K-235	ROMEX CONN.
14	1	EE24F163	FOOT SWITCH
15	AR	1959-WD	WIRING DIAGRAM
16	AR	1959-PD	PNEUMATIC DIAGRAM
17	3	NNH5/16-18	HEX NUT
18	3	NNM103	RECESSED NUT
19	1	FFHBL4579C	3 POLE RECEPTACLE 3W
20	12	SSZH#10064	SHEET METAL SCREW
21	6	TTIW1/4-20	THREADED INSERT
22	3	WWF5/16	FLAT WASHER
23	2	SSZH#10032	HEX SHEET METAL SCREW
24	3	010-054	THD ROD 5/16-18X3.25L
25	3	WWL5/16	LOCK WASHER
26	1	ZX3834	BELT
27	4	TTIW3/8-16	RECESSED NUT
28	1	11200	BUMPER
29	1	97-2602	CLUTCH CYL. BRKT
30	1	AAC7DP-2	AIR CYLINDER
31	3	AAQME-5-8	QUICK MALE ELBOW
32	1	EE37F3311	POWER CORD
33	1	AA198-5/32	AIR REGULATOR
34	2	SSSC01048	SOCKET CAP SCREW
35	2	NNK1/4-20	KEP NUT
36	1	NNJ1/4-20	JAM NUT
37	1	1961-159	FOOT PEDAL PLATE
38	3	SSZH#6096	HEX SHEET METAL SCREW
39	1	AAVMB43	3WAY AIR SWITCH

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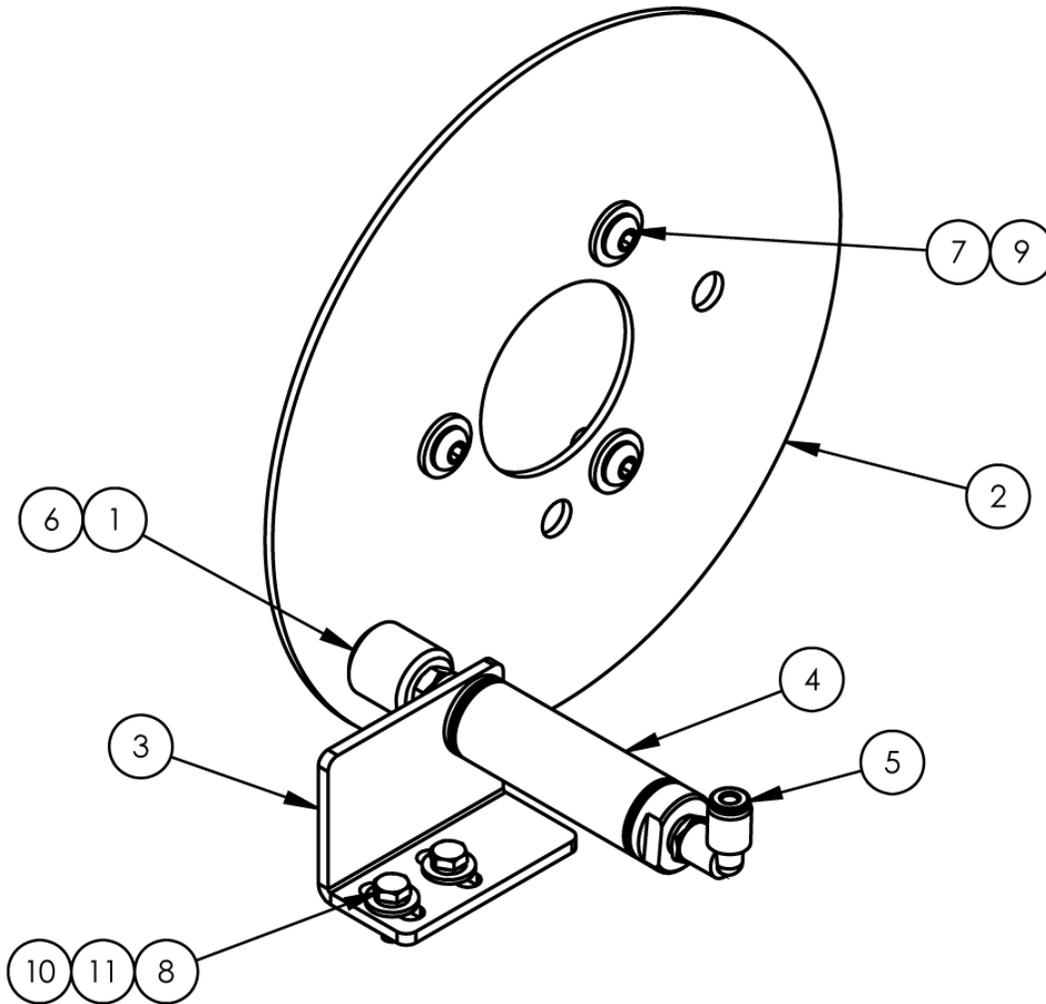
Page 30



1961141 Spindle Assembly, 1.5 bore

AAC Drawing Number 1961141 Rev 1

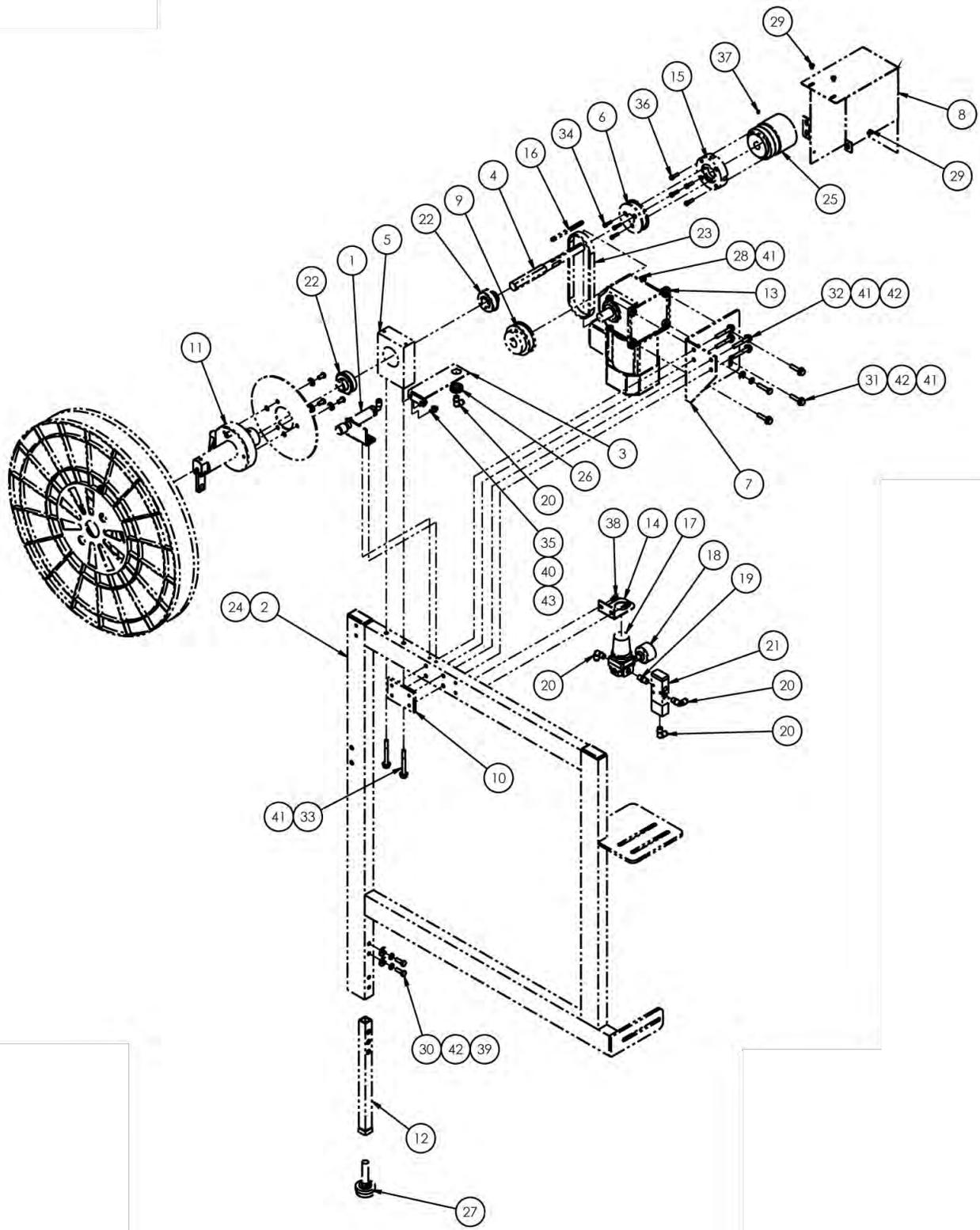
NO.	QTY	PART #	DESCRIPTION
1	1	1959-003	LOCK, HANDLE
2	1	1961142	SHAFT, .751 BORE SPINDLE
3	1	1961143	HUB, .751 BORE SPINDLE
4	1	IID016X064	DOWEL PIN, 1/4 X 1
5	1	iid024x064	DOWEL PIN, 3/8 X 1
6	1	JJ012	3/16 DIA. BALL
7	1	RRLC026B1	SPRING, COMP .026X.18X.25
8	1	SSSS01016	1/4-20 X 1/4 KNURL PT
9	2	SSSS01024	SCREW, SET, 1/4-20 X 3/8
10	2	SSSS98016	SCREW, SKT SET, FLAT POINT
11	1	TTH32416	HANDLE, THRD, 1/4-20X1-1/8



1312043 Rewinder Brake Assembly

AAC Drawing Number 1312043 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	11200T	BUMPER,1/4-28
2	1	1312041	DISC,BRAKE
3	1	1312042	BRKT,BRAKE CYL.
4	1	AAC7S-1	CYLINDER,AIR,SA
5	1	AAQME-5-8	QUICK MALE ELBOW
6	1	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
7	3	SSBC01032	1/4-20 X 1/2 BUT CAP SC
8	2	SSHC98032	10-32X1/2 HEX HD
9	3	WWFS1/4	WASHER,FLAT,SAE,1/4
10	2	WWFS10	WASHER, FLAT, #10, SAE
11	2	WWL10	WASHER,LOCK,#10

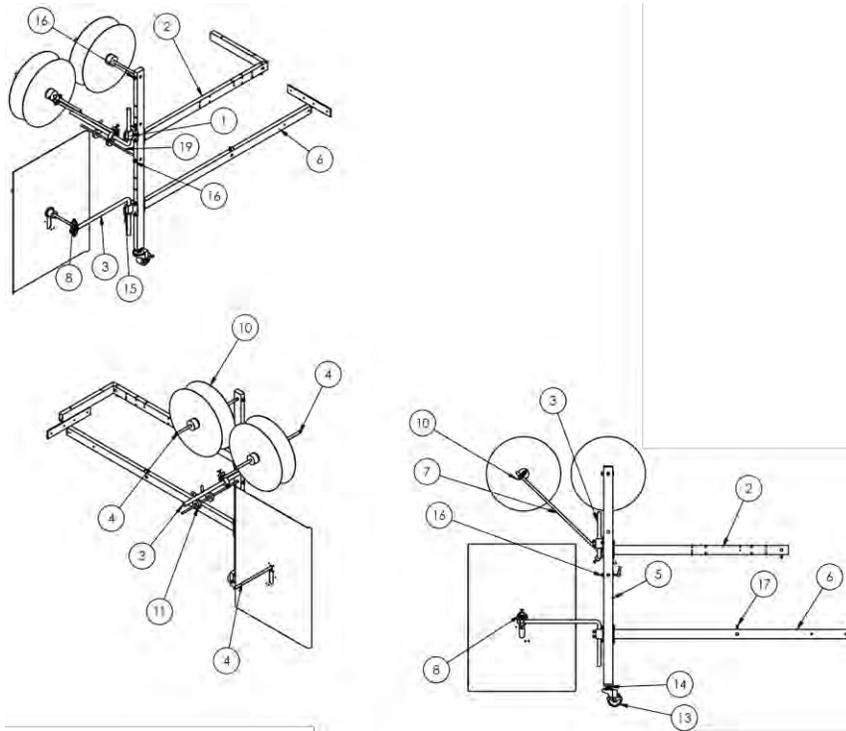


1961-320M Rewinder Assembly

AAC Drawing Number 9002860 Rev 5

NO.	QTY	PART #	DESCRIPTION
1	1	1312043	REWINDER BRAKE ASSY
2	1	1961-335B	FRAME,REWIND ASSY
3	1	1961-354A	SUPPORT, AIR CLUTCH
4	1	1961-358	SHAFT,FLATTED,1/2,X8
5	1	1961-365	YOKE, BEARING
6	1	1961-366	PULLEY, CLUTCH, 20T, 3/8
7	1	1961-367	MOUNT, MOTOR
8	1	1961-368	COVER,BELT
9	1	1961-369	PULLEY, CLUTCH, 20T, 3/8
10	1	1961-370	PLATE, NUT, 1/4-20 X 4, 1 X 2 CTC
11	1	1961141	SPINDLE ASSY, 1.5" BORE
12	1	1961149	LEG, 3/4 SQ X 22
13	1	23218D	MOTOR, GEAR RT. ANGLE
14	1	4130-001	REGULATOR BRACKET
15	1	97-3320	PLATE, ADAPTOR, AIR CLUTCH
16	1	97-3398	KEY, 3/16 X 3/16 X 3.56L
17	1	AA198-502	REGULATOR,AIR,0-30 PSI
18	1	AA198-5032	0-60PSI AIR GAGE 1/8NPT
19	1	AAF122A-A	1/8" NPT HEX CLOSE
20	4	AAQME-5-8	QUICK MALE ELBOW
21	1	AAV125B	PILOT VALVE
22	2	BBS8703-88	BEARING,BALL,.75IDX1.75OD
23	1	GG187L050	BELT, 3/8P, 50T, 1/2W
24	2	MM132-1496	PLUG 1 X 2
25	1	MM800100	CLUTCH,AIR,5/8 BORE,NEXEN
26	1	MM9600K21	GROMMET,RUBBER,9/16 ID
27	1	MMFB4444	FOOT, RUBBER
28	4	NNK1/4-20	NUT,HEX,KEP,1/4-20,W/LOCK
29	5	SSBC98016	10-32 X 1/4 BUTTON CAP SC
30	2	SSHC01048	1/4-20 X 3/4 HEX CAP
31	4	SSHC01080	1/4-20 X 1-1/4 HHCS
32	4	SSHC01112	HEX HEAD BOLT 1/4-20X1.75
33	2	SSHC01160	1/4-20 X 2-1/2 HHCS
34	3	SSSC90040	8-32 X 5/8 SOC CAP SC
35	2	SSSC98032	10-32X1/2, SOC CAP
36	4	SSSC98040	10-32 X 5/8 SOC CAP
37	1	SSSS90008	8-32X1/8 SET SCREW
38	2	SSZS93032	SCREW, SHT.METAL 10 ZIP
39	2	WWF1/4	WASHER, FLAT, 1/4", COM
40	2	WWF10	WASHER, FLAT, #10, COM
41	14	WWFS1/4	WASHER,FLAT,SAE,1/4
42	12	WWL1/4	WASHER,LOCK,1/4
43	2	WWL10	WASHER,LOCK,#10

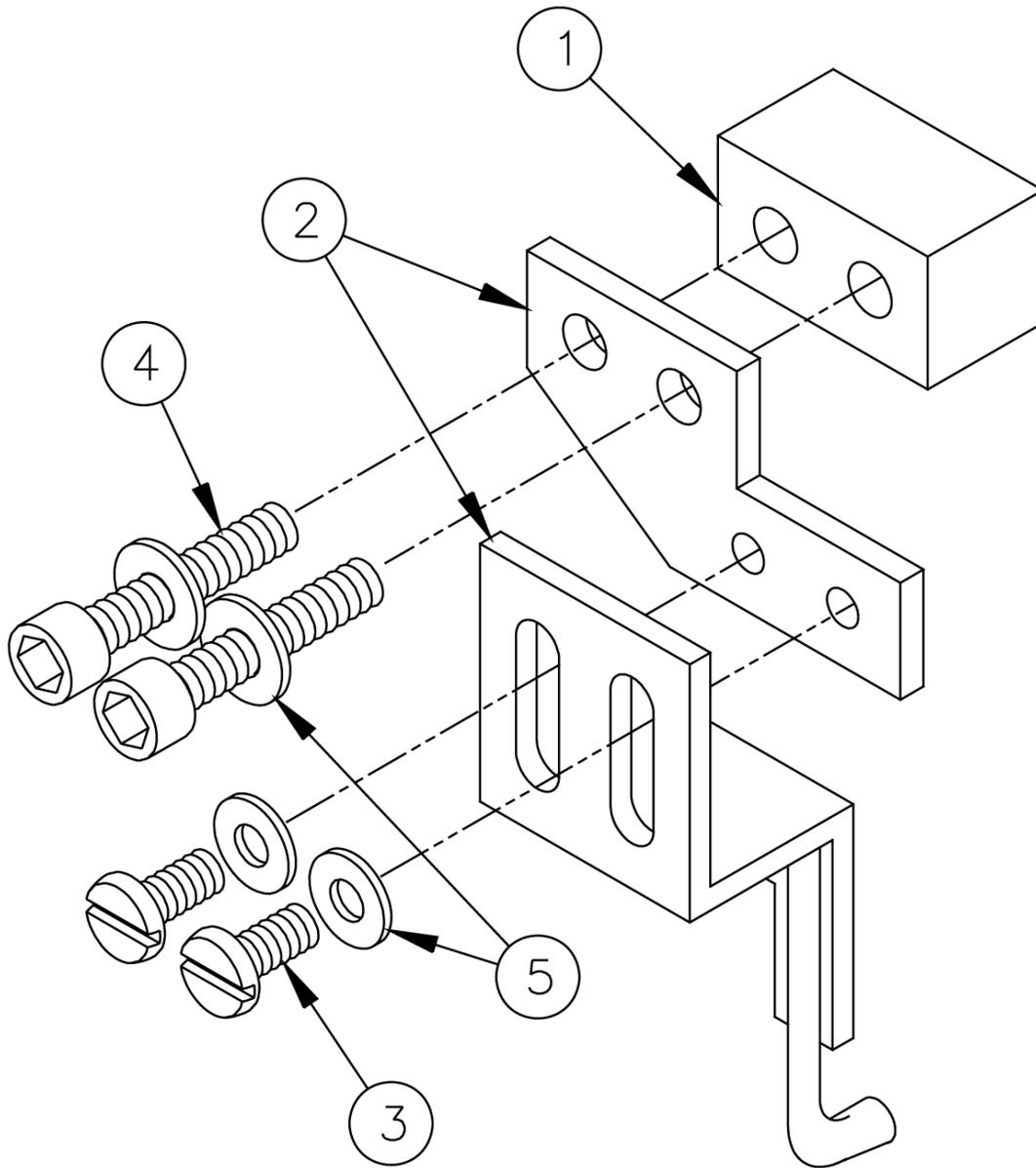
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1959039 Roll Holder Assembly

AAC Drawing Number 1959039 Rev 2

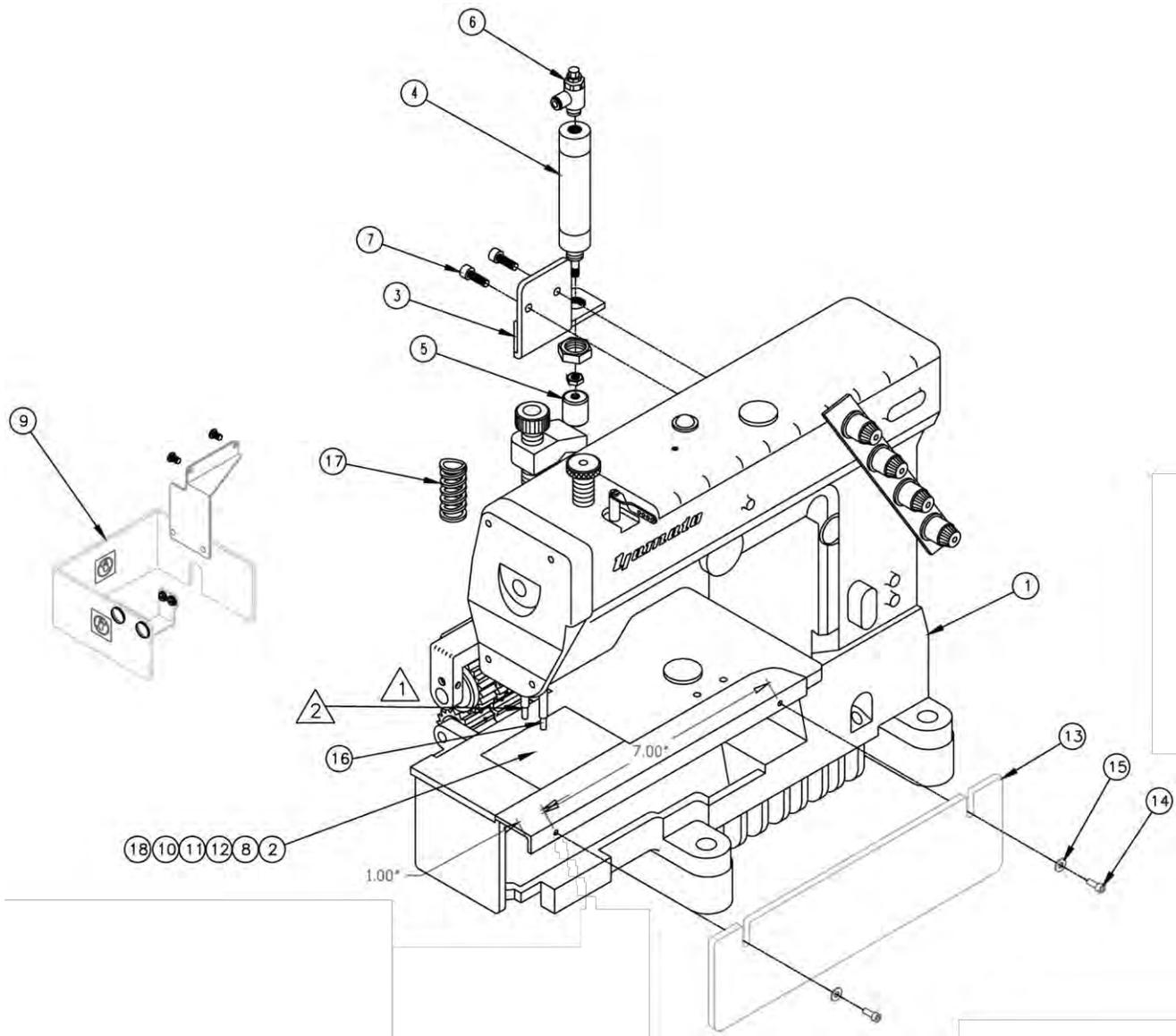
NO.	QTY	PART #	DESCRIPTION
1	2	1278-6206	BLOCK BASE ASSEMBLY
2	1	1312021	UPPER MATERIAL FRAME ASSY
3	2	1959-035	ROD, BENT, 90 DEG
4	3	1959-101	ROD, STRAIGHT, 1/2 X 20L
5	1	1959-105	TUBE, ROLL HLDR, 1X2X50.3L
6	1	1959-106B	TUBE, HORIZ. W/FLANGE
7	1	1961-311D	ROD, STRA, CRS, 1/2X27.0L
8	2	28201	BLOCK, CROSS, (LARGE)
9	1	785-A95-36	DISC. ASSY, 36" STATIONAR
10	4	786B16-2.2	DISC & CONE BEARING ASSY
11	2	A-4-024	EDGE GUIDE, 2"X3/4B
12	1	A-U	ROD CROSS BLOCK
13	1	MM503022LB	CASTER, 3" LOCKING
14	1	NNH1/2-13	NUT, HEX, 1/2-13
15	4	SSHC10048	5/16-18 X 3/4 HHCS
16	2	SSHC10064	5/16-18 X 1 HHCS
17	2	SSSC01080	1/4-20X1-1/4, SOC CAP
18	4	SSSC01176	1/4-20 X 2-3/4 SOC CAP
19	1	W1004	ROD, STRAIGHT, 3/8 X 18.0L
20	4	WWFS1/4	WASHER, FLAT, SAE, 1/4
21	4	WWL1/4	WASHER, LOCK, 1/4



1959-111 Air Wiper Assembly

AAC Drawing Number 190145A Rev 0

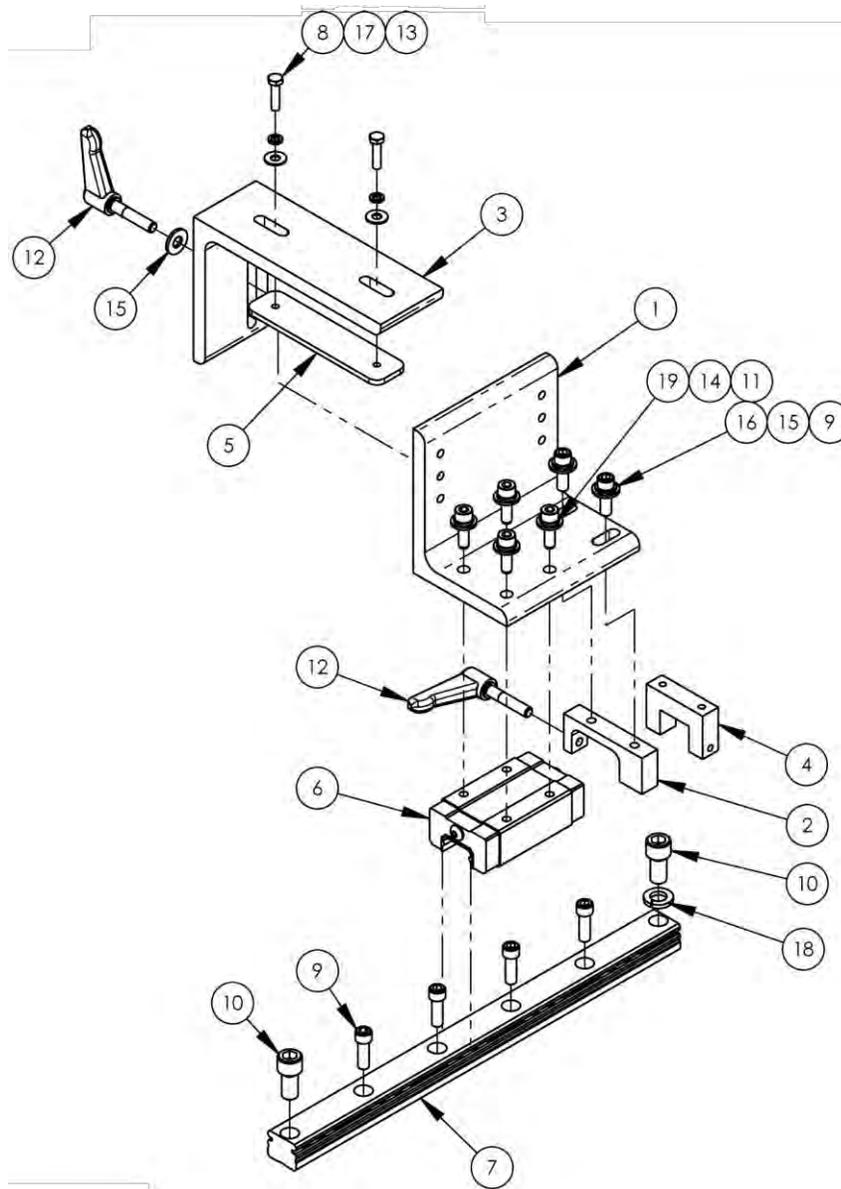
NO.	QTY	PART #	DESCRIPTION
1	1	1959-025	NDL COOLER SPACER
2	1	3151010	AIR W/ SUPPORT WIPER
3	2	SSM110009	PAN SLOTTED SCREW
4	2	SSSCM4X20	SOCKET CAP SCREW
5	4	WW000538	WASHER, M4



1334-1000A Sewing Head

AAC Drawing Number 192557C Rev 3

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	SYAM-1804A	SEWING HEAD YAM.	11	1	54420X9016	PRESSER FOOT
2	1	1862N94016	NEEDLE HOLDER	12	1	54224A9016	THROAT PLATE
3	1	112013	BRACKET	13	1	1334041	THRD GUIDES GUARD
4	1	AAC6S-1-H	AIR CYLINDER	14	2	SSSC98032	SOCKET CAP SCREW
5	1	11200A	BUMPER	15	2	WWFS10	FLAT WASHER
6	1	AA198RR508	FLOW CONTROL	16	1	3300012M	NEEDLE BAR MOD
7	2	SSSCM6X16	SOCKET CAP SCREW	17	1	RRLC105J10	PULLER SPRING
8	1	54242B9016	SPREADER	18	1	1862N95016	LOOPER HOLDER
9	1	1959-412	GUARD	19	10	SN11318GB	NEEDLE UY113, SIZE 18
10	1	54205A9016	FEED DOG				

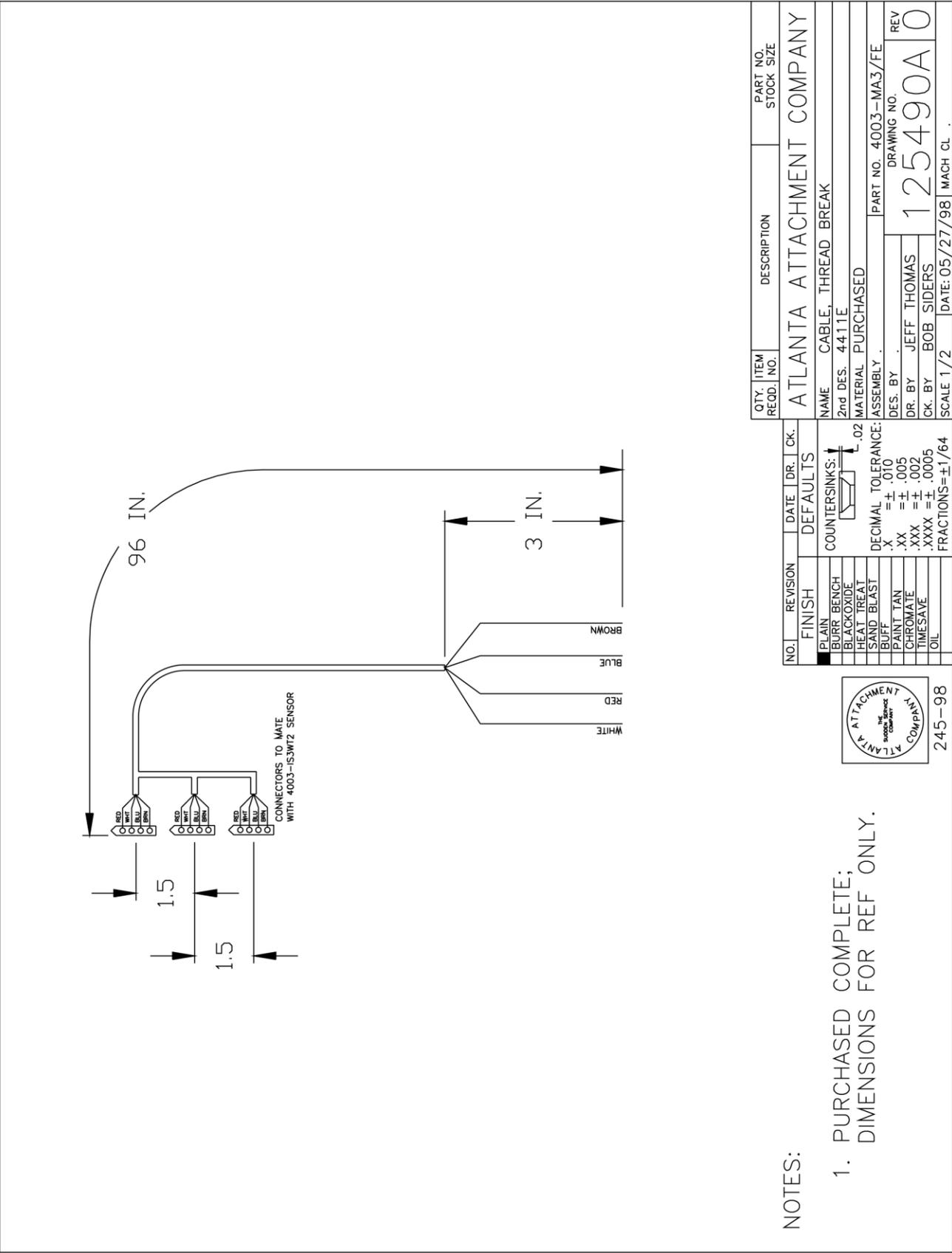


1334-1100B Folder Mount Assembly

AAC Drawing Number 9002988 Rev 3

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1334-1005	MOUNT, ANGLE, UPPER	11	4	SSSCM6X20	SCREW, SOCKET CAP
2	1	1334-1006	MOUNT, LOCKING HANDLE	12	2	TTH32416	HANDLE, THRD, 1/4-20X1-1/8
3	1	1334-1022	MOUNT, ANGLE, UPPER	13	2	WWF10	WASHER, FLAT, #10, COM
4	1	1335-310	STOP BLOCK, FRONT	14	4	WWFM6.1	WASHER, FLAT, M6, SAE
5	1	1959-015	NUTPLATE, 10-32, 3.25 OC	15	3	WWFS1/4	WASHER, FLAT, SAE, 1/4
6	1	MMAGH25CAN	LINEAR BEARING	16	2	WWL1/4	WASHER, LOCK, 1/4
7	1	MMAGR25360M	RAIL MODIFICATION, 360MM	17	2	WWL10	WASHER, LOCK, #10
8	2	SSHC98048	SCREW, HEX CAP #10-32X.75	18	1	WWL3/8	WASHER, LOCK, 3/8
9	6	SSSC01048	1/4-20 X 3/4" SOC CAP SC	19	4	WWLM6	M6 LOCK WASHER
10	2	SSSC25048	3/8-16X3/4 SOC CAP				

4003-MA3/FE Thread Break Cable



NOTES:

- 1. PURCHASED COMPLETE; DIMENSIONS FOR REF ONLY.



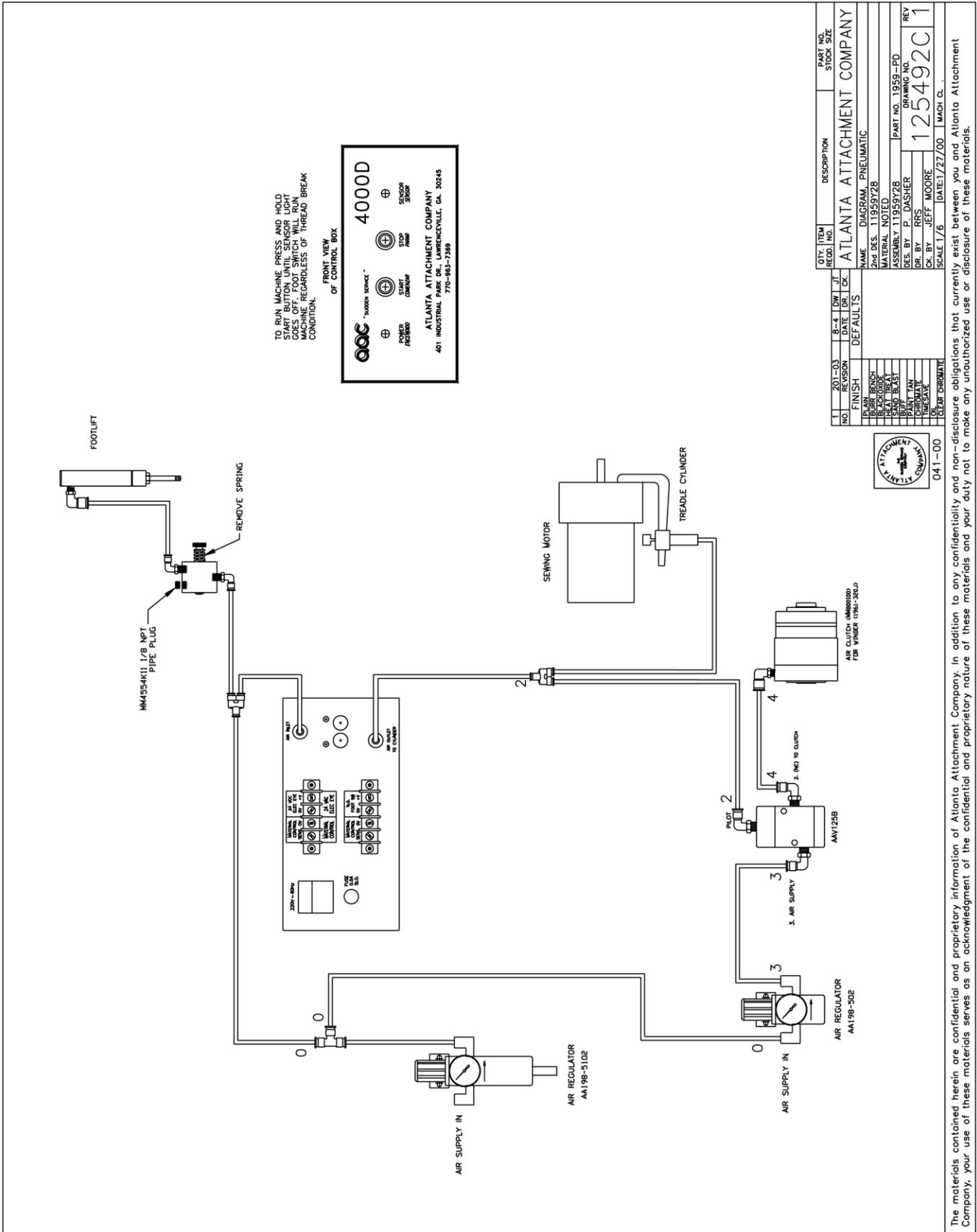
245-98

NO.	REVISION	DATE	DR.	CHK.
	FINISH			
	PLAIN			
	BURR BENCH			
	BLACK OXIDE			
	HEAT TREAT			
	SAND BLAST			
	BUFF			
	PAINT TAN			
	CHROMATE			
	TIMESAVE			
	OIL			

QTY.	ITEM	DESCRIPTION	PART NO.
REQD.	NO.		STOCK SIZE
		ATLANTA ATTACHMENT COMPANY	
		NAME CABLE, THREAD BREAK	
		2nd DES. 4411E	
		MATERIAL PURCHASED	
		ASSEMBLY .	
		DES. BY .	
		DR. BY JEFF THOMAS	DRAWING NO.
		CK. BY BOB SIDERS	125490A
		SCALE 1/2	DATE: 05/27/98
			MACH CL.

DECIMAL TOLERANCE:	PART NO.	DRAWING NO.	REV
.X = ± .010	4003-MA3/FE	125490A	0
.XX = ± .005			
.XXX = ± .002			
.XXXX = ± .0005			
FRACTIONS = ± 1/64			

1959-PD Pneumatic Diagram



Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

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

Términos y Condiciones:

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

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

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



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www.atlatt.com

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