

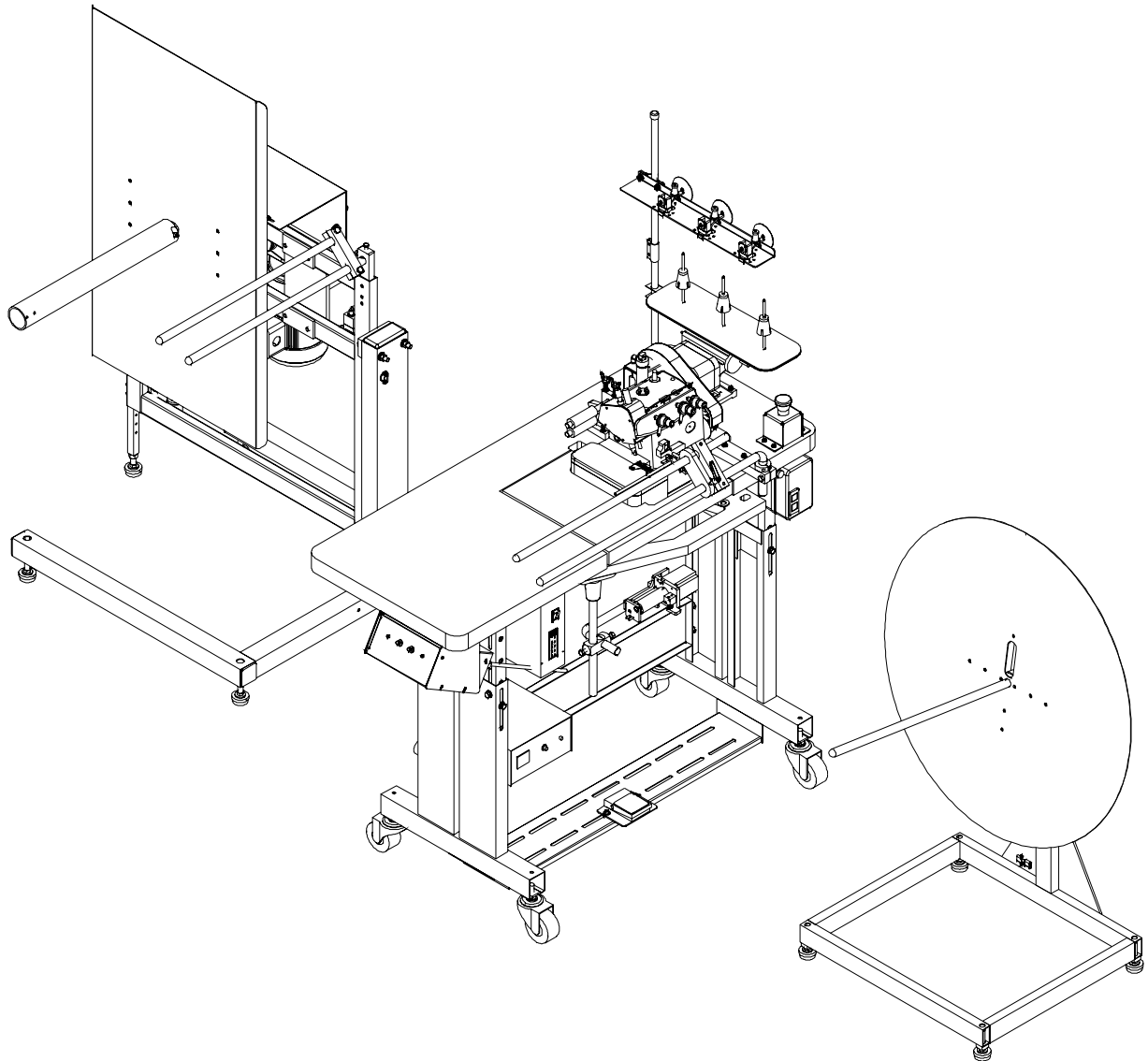
model: **1961SB**

Automatic Single Border Workstation



Technical Manual & Parts List

"Sudden Service"®



Atlanta Attachment Company

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The sale of this product does not sell or otherwise transfer any license or other rights under any U.S. Patent or other corresponding foreign patent.

This equipment is protected by one or more of the following patents:

US patents: 4,038,933; 4,280,421; 4,432,294; 4,466,367; 4,644,883; 4,886,005; 5,134,947; 5,159,889; 5,203,270; 5,307,750; 5,373,798; 5,437,238; 5,522,332; 5,524,563; 5,562,060; 5,634,418; 5,647,293; 5,657,711; 5,743,202; 5,865,135; 5,899,159; 5,915,319; 5,918,560; 5,924,376; 5,979,345; 6,035,794

Foreign patents - 2,084,055; 2,076,379; 2,177,389; 2,210,569; 4-504,742; 8-511,916; 9-520,472; 0,537,323; 92,905,522.6; 95,935,082.8; 96,936,922.2; 5,159,889; 5,203,270.

Other U.S. and Foreign Patents Pending.



I M P O R T A N T

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.

Atlanta Attachment Company
362 Industrial Park Drive
Lawrenceville, Georgia 30045
Phone: (770) 963-7369
Fax: (770) 963-7641
Email: sales@atlatt.com

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

Mandatory Information

All persons working on the machine should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only work on the machine occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.



Scope Of The Instruction Material

The Instruction Material comprises:

- Safety information,
- Operator Instructions,
- Electrical and Pneumatic diagrams, and may also include;
- A list of recommended spare parts,
- Serial Bus Control system Operator instructions,
- Instruction Manual(s) for components made by other manufacturers and
- 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.

Important Safety Instruction

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

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

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

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

Choice And Qualification Of Personnel

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

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

Training

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



Responsibilities

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

A Word To The Operator

The greatest danger inherent in our machines:

- is that of fingers, hands or loose clothing being drawn into a machine by live, coasting or rotating tools or assemblies or
- of being cut by sharp tools or burned by hot elements.

Always be conscious of these dangers!

Safety Equipment On The Machines

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

The correct functioning of safety equipment on machines and systems should be checked

- every day and before every new shift starts,
- after maintenance and repair work,
- when starting up for the first time and when restarting (e.g. after prolonged shutdowns).

If safety equipment has to be dismantled for setting-up, maintenance or repair work, such safety equipment shall be replaced and checked immediately upon completing the maintenance or repair work.

All protective mechanisms shall be fitted and fully operational whenever the machine is at a standstill or if it has been shut down for a longer period of time.

Damage

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

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

Faults Or Errors

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

Signs On The Machine

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

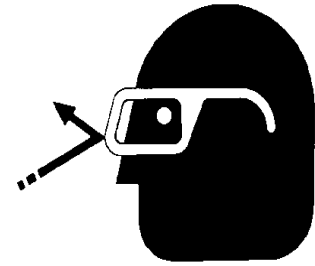


Clothing, Jewelry, Protective Equipment

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

Protective Eyewear

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

**Tools**

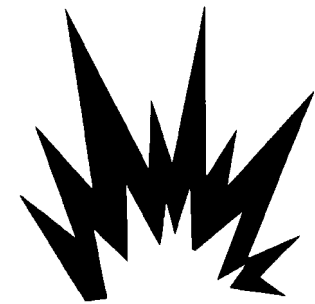
Always count the number of tools in your possession before starting work on the machine. This will allow you to check that no tools have been left behind inside the machine. Never leave a tool in the machine while working.

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

**Workplace**

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting And Fighting Fires

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



The following fire extinguishers may be used:

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

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

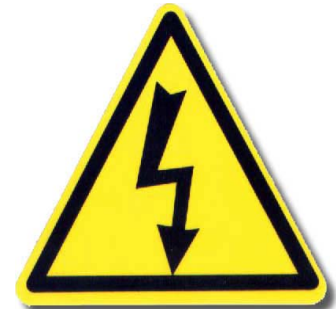
A qualified person should be consulted to repair the damage after a fire.

Electrical Power Supply

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

In practice, this may mean that the technician, electrician and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required.

The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.



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

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

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.

- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected and the machine checked to



ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

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

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

Delivery Of The Machine/Packaging

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

Transport Damage

The packaging and machine must immediately be examined for signs of damage in transit. Such damage must be reported to the shipper/transporter within the applicable time limits. Contact us and/or your transport insurer without delay. Never operate a damaged machine.

Interim Storage

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

Transporting The Machine

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



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

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

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

Workplace Environment

Our machines are designed for use in enclosed rooms:

- Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.
- Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.
- Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.
- Protect against unauthorized access.
- Ensure that the machine and accessories are set up in a stable position.
- Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Machine Installation

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

Local Regulations

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

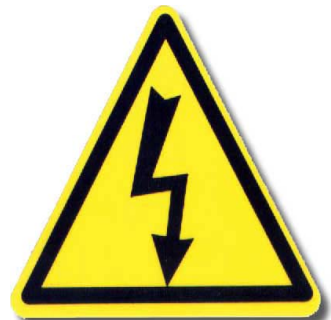


Connection, Reconnection

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

Electrical Connection

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



Pneumatic Connection

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

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup. Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.

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

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard.

Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control. When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

Repair

Replacement Parts

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

Repair, Electrical

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

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

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



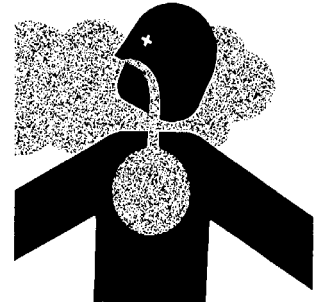
Signal generators (limit switches) and other electrical parts on the safety mechanisms must not be removed or bypassed. Only use original fuses or circuit overloads with the specified current rating. The machine must be switched off immediately if a fault develops in the electrical power supply.

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

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

Ventilation/Hazardous Gases

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



Hydraulic And Pneumatic Systems

Work on hydraulic or pneumatic equipment shall only be carried out by persons with training, knowledge and experience of hydraulic systems.

Pressure lines shall be depressurized before starting any repair work.

General Liability

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

Starting Machine Movements

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

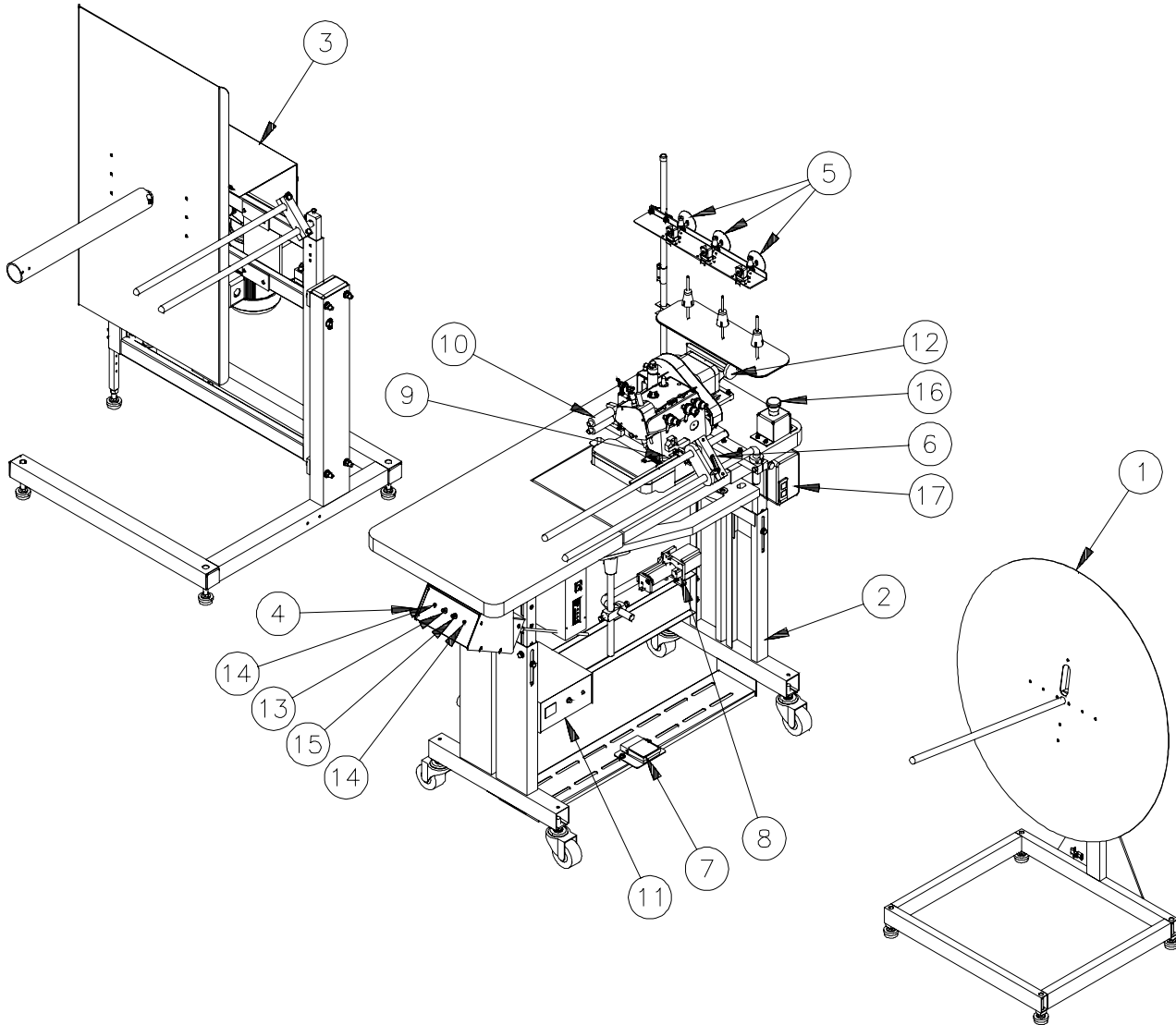
A Word To The End User

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

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



Component Identification



- | | |
|---------------------------|-------------------------------|
| 1. Roll Holder Assembly | 10. Puller |
| 2. Main Console Assembly | 11. AP-28-600B Control Box |
| 3. Rewinder Assembly | 12. Puller Hand Wheel |
| 4. 4000D Motor Controller | 13. Start Button |
| 5. Thread Break Detectors | 14. Power/Sensor Light |
| 6. Edge Guide | 15. Stop Button |
| 7. Foot Pedal | 16. Emergency Stop Button |
| 8. Metering Device | 17. K-CB600 Start/Stop Switch |
| 9. Elastic Guide | |



This machine has a Roll Holder (1) with a material out eye for the border material, a Main Console (2), and an electro-pneumatic Rewinder (3). The sewing console consists of a stand, a sewing head, a Puller (10), a sewing motor, a 4000D Motor Controller (4), an electronic Metering Device (8), and a thread stand with Thread Break Detectors (5). The Rewinder has a continuously running AC motor with a pneumatic clutch. Winding is accomplished by applying air pressure to the clutch. Increasing or decreasing the air pressure will increase or decrease the tightness of the roll. The Rewinder will wind in either direction.

Operating Instructions

Refer to "Material Loading Diagram" on page 12.

Load the border material aligning the Roll Holder (1) with the Edge Guide (6) on the Main Console (2). Adjust guides as necessary to obtain the trim desired. Run the machine by pressing the Foot Pedal (7) until there is enough material to place into the Rewinder (3). Align the Rewinder to the machine and tape the material to the PVC roll holder. Flip the switch on the Rewinder assembly to change direction of winding as necessary. When the roll is full, the Roll Holder can be removed and taken to the next operation. There are four roll holders provided for this convenience. More can be purchased by contacting your sales representative at 770-963-7369 or sales@atlatt.com.

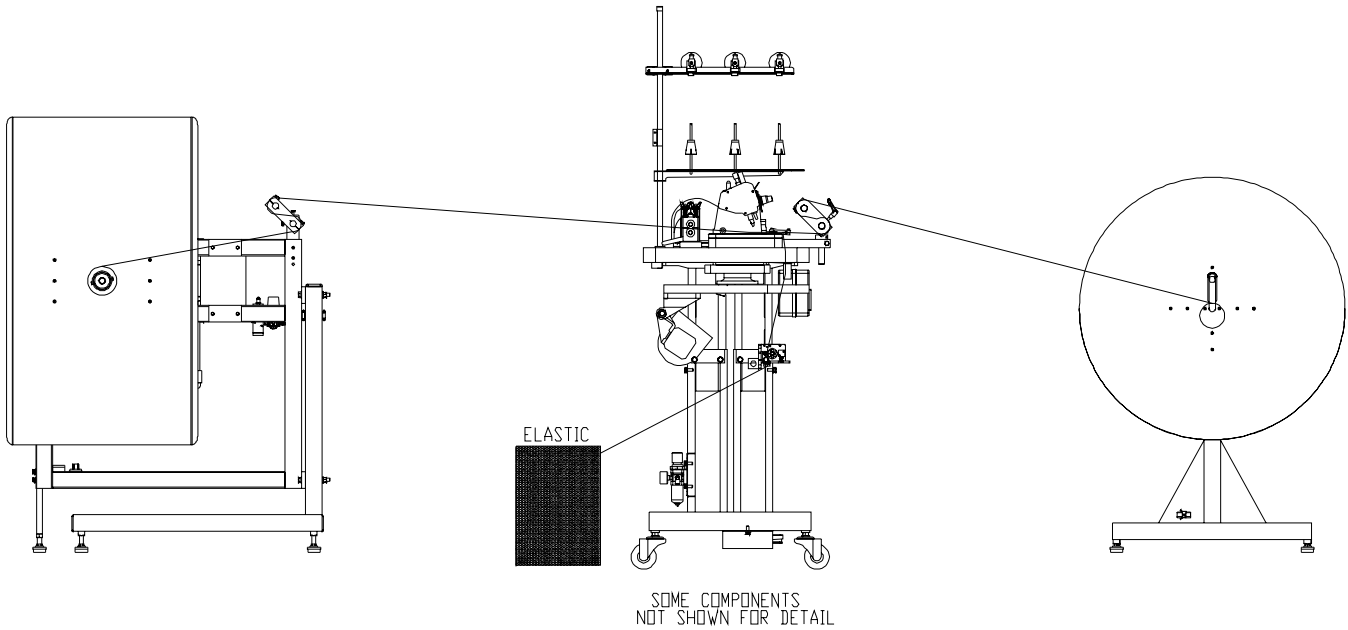
Load the elastic through the Metering Device (8), through the Elastic Guide (9), under the foot, and into the Puller (10). The AP-28-600B Control Box (11) can be adjusted as necessary to obtain the proper elastic tension.

Note: A very loose tension may result in a wrap. If this happens, turn off the power and pull the elastic from the bottom to remove the wrap.

Run the machine in manual mode until the elastic is past the Puller (10). Watch for wraps with the loose end of elastic. The Puller should be set to the correct speed at the factory but some minor adjustment of the puller speed may be necessary to synchronize the speeds, stitch length, and stretch required. Rotate the Puller Hand Wheel (12) clockwise to increase speed. Too much speed will result in a longer stitch length than can be trimmed properly. Five SPI (Stitches Per Inch) is the maximum stitch length. Press the Start Button (13) on the 4000D when ready to run in automatic mode.

The machine can be operated manually with the Foot Pedal (7) or in automatic mode with the 4000D Motor Controller (4). The Foot Pedal will override the sensors. With power on, the Power light (14) and Sensor light (14) should be illuminated on the 4000D Motor Controller. To run in automatic mode, hold the Start Button (13) down until the Sensor light (14) goes out. The machine will continue to run until a thread breaks or the roll runs out. If the Sensor light does not go out, the machine will not continue to run. Refer to the "1961SB-WD Wiring Diagram" on page 23 and "1347MA-PD Pneumatic Diagram" on page 22 as necessary to correct this problem. When the machine is stopped with the Stop Button (15) on the 4000D or the Emergency Stop Button (16), the machine stops with power on and the machine is in a "paused" mode. Turn the power off with the K-CB600 Start/Stop Switch (17).

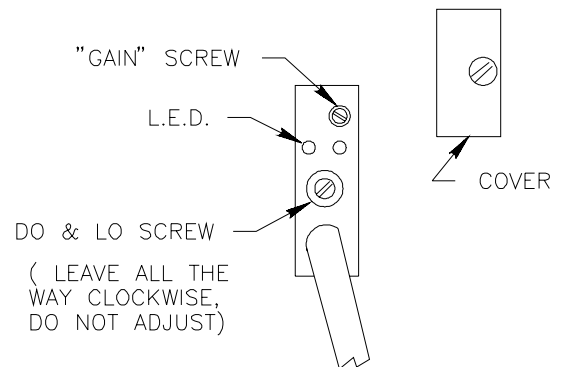
Material Loading Diagram



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.

Parameter Settings

Before programming, perform a Master Reset of Parameters. See below.

Parameter	Range	Value	Description
290		0	Mode of Operation. MUST BE SET FIRST!
111	200-9900 rpm	500/ 600	Maximum Speed when "129" is 0, 1 or 2.
119	1-3	1	Linear Acceleration
161	0-1	0=CW	Motor Rotation
270	0-5	1	External handwheel sensor configuration.
272	020-255	100	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)

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 until "COD" is displayed.
2. Press ">>" once and enter the number 311.
3. Press "E" once and "2.0.0" is displayed.
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 until "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.





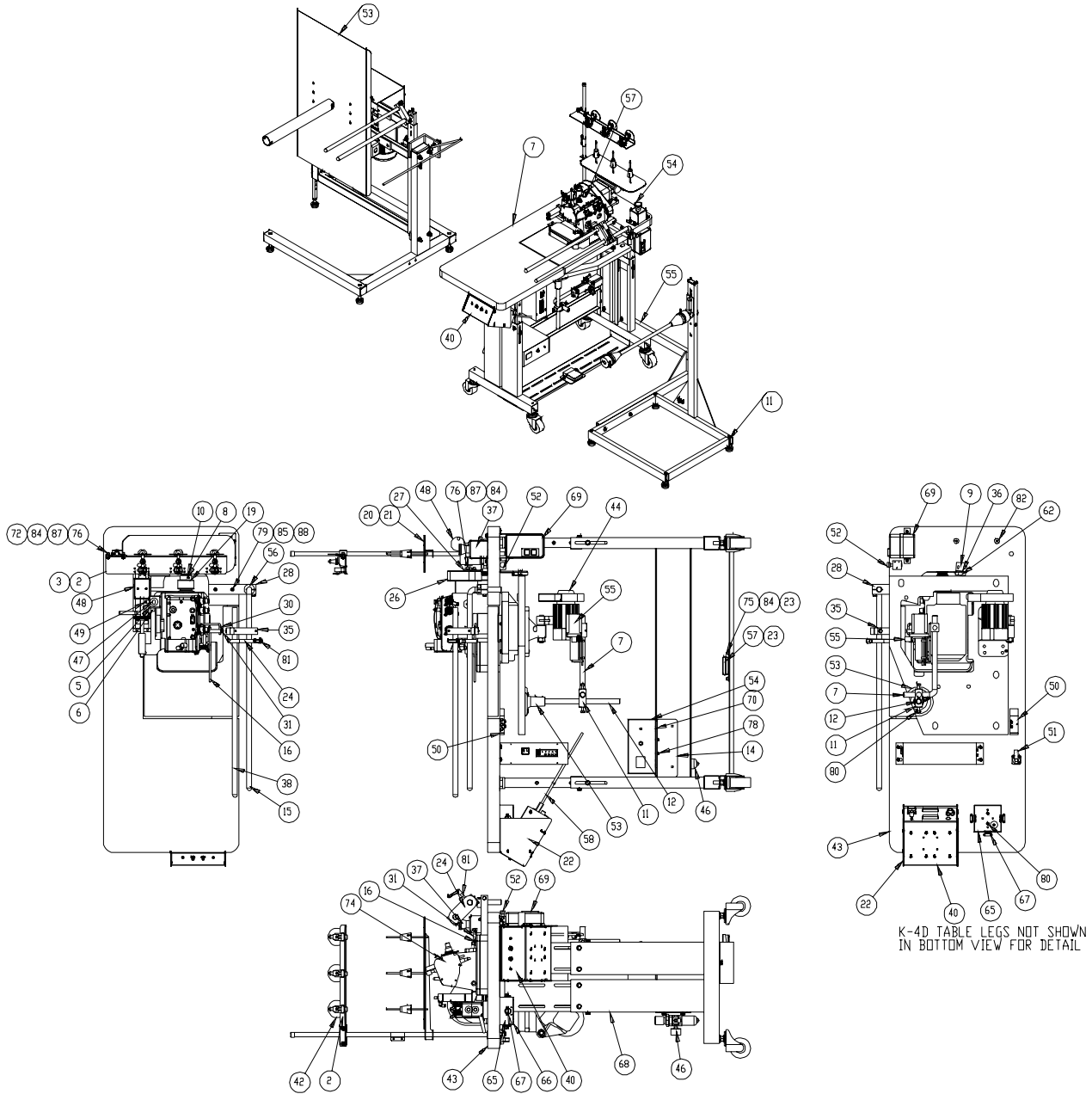
Assembly Drawings & Parts Lists

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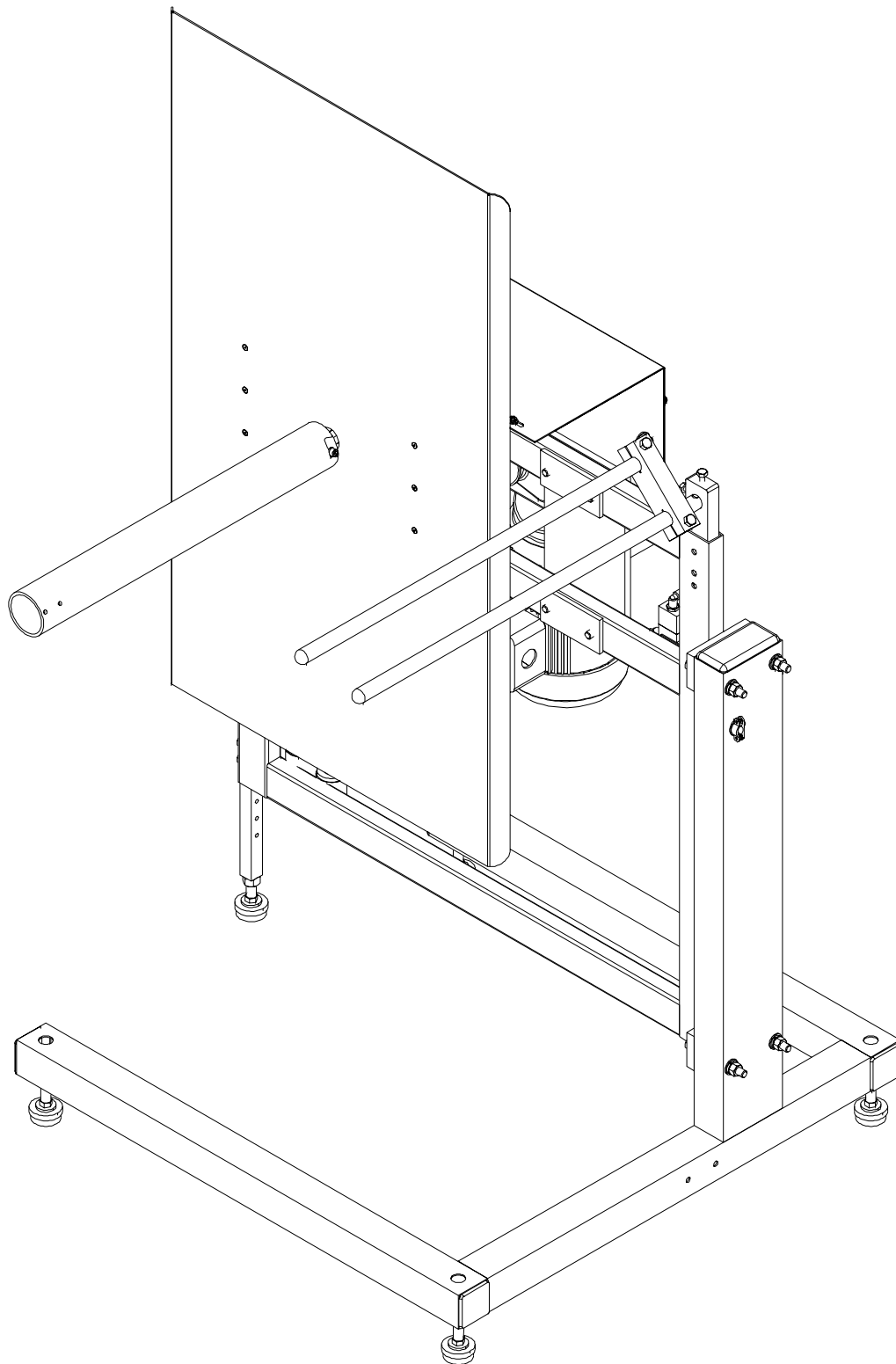


11961SBQ56E Main Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	0211-702C	CABLE,POS.SENSOR,3	1		47	AAC6DP-2	CYLINDER,DA, 1-1/16 X 2	1	
2	0411-069C	BRKT,THREAD BRK DET	1		48	AAP11	ZEROMAX PULLER	1	
3	0411-070	CLAMP, SENSOR BRACKET	1		49	AAQME-5-8	QUICK MALE ELBOW	1	
4	11200A	BUMPER 5/16-24	1		50	AAV125B	PILOT VALVE	1	
5	112J27-01	BRKT,MOUNT,FTLIFT CYL	1		51	AAVF51FM1B	AIR/ELEC PRESSURE SW	1	
6	112J27-02	EXTENSION,FOOTLIFT ARM1	1		52	AAVMB43	SWITCH,AIR,3 WAY,W/EXH	1	
7	1278-6207B	ROD, BENT, 90 DEG	1		53	AP-1721	STAND BASE,COMPLETE	1	
8	1278-6364	DISC, TAPE MOUNTING	1		54	AP-28-600B	CONT BOX,STACKABLE	1	
9	1278-6689B	BRACKET, EYE MOUNT	1		55	AP-28100H	METERING HEAD	1	
10	23174	PULLEY, TOP CONVEYOR	1		56	CCCL12F	CLAMP COLLAR- 3/4	1	
11	28201	BLOCK,CROSS,(LARGE)	1		57	EE24F163	FOOTSWITCH, TREADLITE	1	
12	28203	ROD, STRAIGHT, 3/4X11	1		58	EE37F3311	CEE POWER CORD, 6	1	
13	1330033	SLACK TAKE UP	1		59	FF03091081	THREE PIN FEMALE MOLEX1	1	
14	1335936	BRKT,MNT,STEP BOX	1		60	FF59F1803	3 PIN MALE CONN	1	
15	1347436	ROD, BENT, 90 DEG	1		61	FFRK44T-4	CABLE,EYE,12',NO END	1	
16	1347438	ROD,SST,1/4X8	1		62	FFSM312LVQ	BANNER MINI-BEAM	1	
17	1347MA-PD	PNEUMATIC DIAGRAM	AR	22	63	FFT18FF100Q	EYE,FIXED FIELD, 4IN	1	
18	1533-200	CABLE,SWITCH INPUT	1		64	GG170XL037	BELT,GEAR,1/5P,3/8W	1	
19	1535-321	ADAPTER,HANDWHEEL	1		65	K-233	BOX,ELECTRICAL,SQUARE	1	
20	1959-022	PAD, THREAD, 3 POS	1		66	K-234	COVER,4IN SQUARE	1	
21	1959-024	PAD, FOAM, 3 POS	1		67	K-235	CONNECTOR,ROMEX,1/2	3	
22	1959-120	BRKT,MOUNTING,4000D	1		68	K-4D	HD T LEG ADJ STAND	1	
23	1961-159	PLATE, MOUNT, FT PEDAL	1		69	K-CB600	MOTOR STARTER,ELEC	1	
24	1961-211	PLATE, EDGE GUIDE	1		70	MMSLD-ECH	1/2" DIA RUBBER BUMPER	4	
25	1961-255	BRACKET, SENSOR MTG	1		71	MMTBV3A490	WASTE SYSTEM	1	
26	1961033	BELT GUARD	1		72	NNH1/4-20	1/4-20 HEX NUT	4	
27	1961037	L BRKT	1		73	PP48XL037	PULLEY,GEAR,1/5P,48T,3/8B	1	
28	1961038	CLAMP,3/4ROD,3"CTC	1		74	SJUKI-6904S	SEWING HEAD,OVERLOCK	1	
29	1961039	REWINDER W/ MNT ASSY	1	19	75	SSSC01032	1/4-20 X 1/2 SOC CAP	2	
30	1961043	ROD,.25X3.13X1.63,90DEG	1		76	SSSC01048	1/4-20 X 3/4 SOC CAP	4	
31	1961045	CLAMP,1/4DX1.5CTC	1		77	SSSC80032	#6-32 X 1/2 SOC CAP	2	
32	1961050	ROLLHOLDER OFFSET	1		78	SSSC98032	#10-32 X 1/2 SOC CAP	4	
33	1961051	ROLL HOLDER ASSY	1		79	SSSC98176	#10-32 X 2-3/4 SOC CAP	6	
34	1961SB-WD	WIRING DIAGRAM	AR	23	80	SSZH#10064	SCREW,SHT.METAL HEX	10	24
35	1962-3201	CLAMP,3/4ROD,3"CTC	1		81	TTH32415	HANDLE,THREADED,1/4-20	1	
36	1975-412A	PLATE,NUT,4-40@.96 CTC	1		82	TTIW10-32	THREADED INSERT, WOOD	6	
37	213-005	STOP BUTTON BOX ASSY	1	21	83	WWFS1/2	WASHER, FLAT, 1/2	1	
38	33008202A	ROD, ROLL, SST, 3/4 X 28	1		84	WWFS1/4	WASHER FLAT, 1/4	10	
39	350-12017	NUT PL, 1/4-20, 1.00 CTC	1		85	WWFS10	WASHER, FLAT #10	10	
40	4000D-500	CONTROL BOX	1		86	WWFS6	WASHER, FLAT, #6	2	
41	4000D-INS1	INSTRUCTIONS,WIRING	AR		87	WWL1/4	1/4 LW	6	
42	4003-IS3WT2	SENSOR,THREAD BREAK	3		88	WWL10	#10 LW	10	
43	4048-3716A	TABLE TOP, MODIFIED	1		89	WWL6	WASHER,LOCK,6	2	
44	4059-DC1500	MOTOR W/ CONTROLLER	1		90	ZX3831	V BELT,3/8X31	1	
45	661-C	GUIDE,UPPER	1						
46	AA198-5102	REGULATOR W/GAUGE	1						

Drawing Number 9000569 Rev. 2

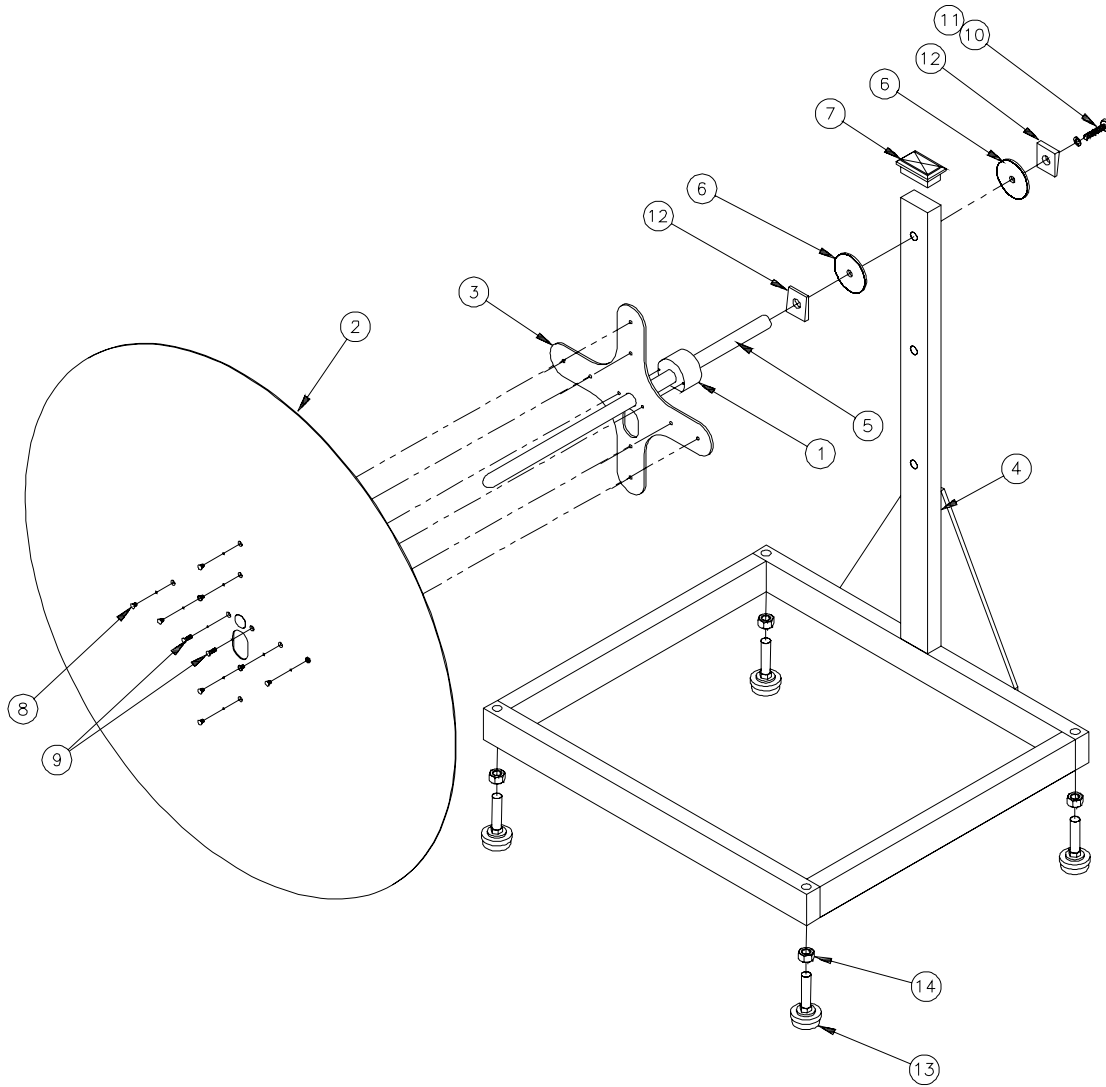




1961039 Rewinder Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1330201	REWINDER MOUNTING	1		35	MM802860	CLUTCH,AIR,3/4 BORE	1	
2	1334326	MOUNT, FLANGE	2		36	MM9600K21	GROMMET,RUBBER	1	
3	1334376	PLATE, REWIND,24 X 40	1		37	MMBH2LM22R	MOTOR,GEAR,R/A,220V	1	
4	1961-319	PLATE,NUT,3/8-16	2		38	MMFB4444	FOOT, RUBBER	5	
5	1961-321	PLATE, ADAPTOR	1		39	NNH1/2-13	1/2-13 HEX NUT	1	
6	1961-331	MOUNT, MOTOR	1		40	NNH3/8-16	3/8-16 HEX NUT	8	
7	1961-332	COVER, MOTOR	1		41	NNK1/4-20	KEP NUT, 1/4-20	4	
8	1961-335	FRAME	1		42	PP22LB075-1-1/8	PULLEY 3/8P, 22T	1	
9	1961-354B	SUPPORT, AIR CLUTCH	1		43	SSFC80024	#6-32 X 3/8 FLAT ALLEN	6	
10	1961-360	SHAFT, AIR CLUTCH	1		44	SSHC01048	1/4-20 X 3/4 HEX HEAD	4	
11	1961-365B	BLOCK, BEARING MOUNT	1		45	SSHC01064	1/4-20 X 1 HEX HEAD	2	
12	1961-366A	PULLEY 3/8P, 22T, 1-1/8BO	1		46	SSHC01096	1/4-20 X 1-1/2 HEX HEAD	4	
13	1961040	SLEEVE, REWIND, 20	1		47	SSHC01160	1/4-20 X 2-1/2 HEX HEAD	4	
14	1961041	SUPPORT,TAKEUP SPINDLE	1		48	SSHC10096	5/16-18 X 1-1/2 HEX HEAD	2	
15	1961042	HUB, TAKEUP SPINDLE	1		49	SSHC25096	3/8-16 X 1-1/2 HEX HEAD	4	
16	1962-3201	CLAMP. 3/4 ROD	1		50	SSHC25128	3/8-16 X 2 HEX HEAD	4	
17	1962-3202A	SUPPORT, PULLER	1		51	SSHC25224	3/8-16 X 3-1/2 HEX HEAD	4	
18	26127	LEG,STUD MOUNT	1		52	SSPP90024	#8-32 X 3/8 PAN HD PHIL	2	
19	4130-001	REGULATOR BRACKET	1		53	SSPP98032	#10-32 X 1/2 PAN HD PHIL	4	
20	AA198-502	REGULATOR,AIR,0-30 PSI	1		54	SSSC01048	1/4-20 X 3/4 SOC CAP	2	
21	AA198-5032	0-60PSI AIR GAGE 1/8NPT	1		55	SSSC01096	1/4-20 X 1-1/2 SOC CAP	4	
22	AAF122A-A	1/8" NPT HEX CLOSE	1		56	SSSC90064	#8-32 X 1 SOC CAP	3	
23	AAQMC-4-8	QUICK MALE CONN	1		57	SSSC98032	#10-32 X 1/2 SOC CAP	2	
24	AAQME-5-4	ELBOW, MALE 5/32	2		58	SSSS01016	1/4-20 X 1/4 KNURL PT	2	
25	AAQMEL-5-8	QUICK MALE ELBOW	1		59	WWF8	WASHER, FLAT #8	2	
26	AAV125B	PILOT VALVE	1		60	WWFS1/4	WASHER FLAT, 1/4	14	
27	BBS8703-88	BEARING,BALL	2		61	WWFS10	WASHER, FLAT #10	6	
28	FF23F356	DPDT SWITCH,ON-OFF-ON	1		62	WWFS3/8	WASHER, FLAT, 3/8	20	
29	FFHBL4570C	PLUG, 2P/3W, GROUNDING	1		63	WWL1/4	1/4 LW	8	
30	FFHBL4579C	RECEPTACLE,3 POLE,3W	1		64	WWL10	#10 LW	6	
31	K-235	CONNECTOR,ROMEX,1/2	2		65	WWL3/8	3/8 LW	12	
32	MM132-1496	PLUG 1 X 2	1		66	WWL8	#8 LW	2	
33	MM132-2X2A	END CAP, SQUARE	4		67	1961-252A	ROD,ROLL SS,3/4 X 24	2	
34	MM132-2X4	END CAP,RECT,BLACK	1			Rev. 0			

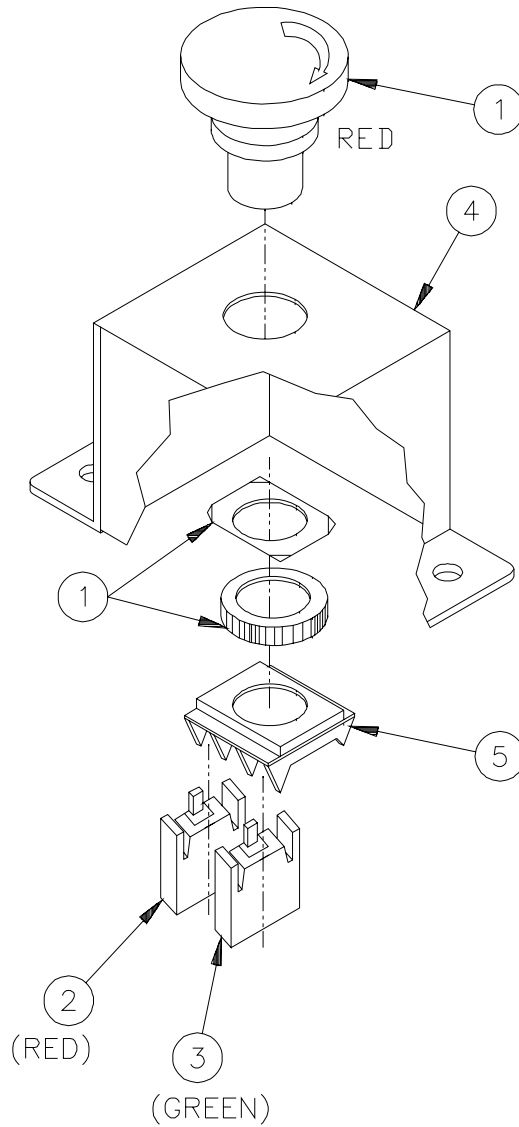




778-11 Roll Holder Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1961-253	Unwind Hub	1		9	SSFC80032	Screw, Flat Allen	2	
2	1961-254	32" Disc	1		10	SSHC25160	Screw, Hex Cap	1	
3	1961-258	Disc Support	1		11	WWL3/8	Lock Washer	1	
4	778-9A	Frame Weldment	1		12	WWSQ080B	Washer	2	
5	33008202A	Rod, 3/4 x 21	1		13	MMFB4444	Rubber Foot	4	
6	33008226	Disc, 10ga, SS	2		14	NNH1/2-13	Hex Nut	4	
7	MM132-1496	End Cap	1		Drawing Number 192119B Rev. 0				
8	SSFC80016	Screw, Flat Allen	8						



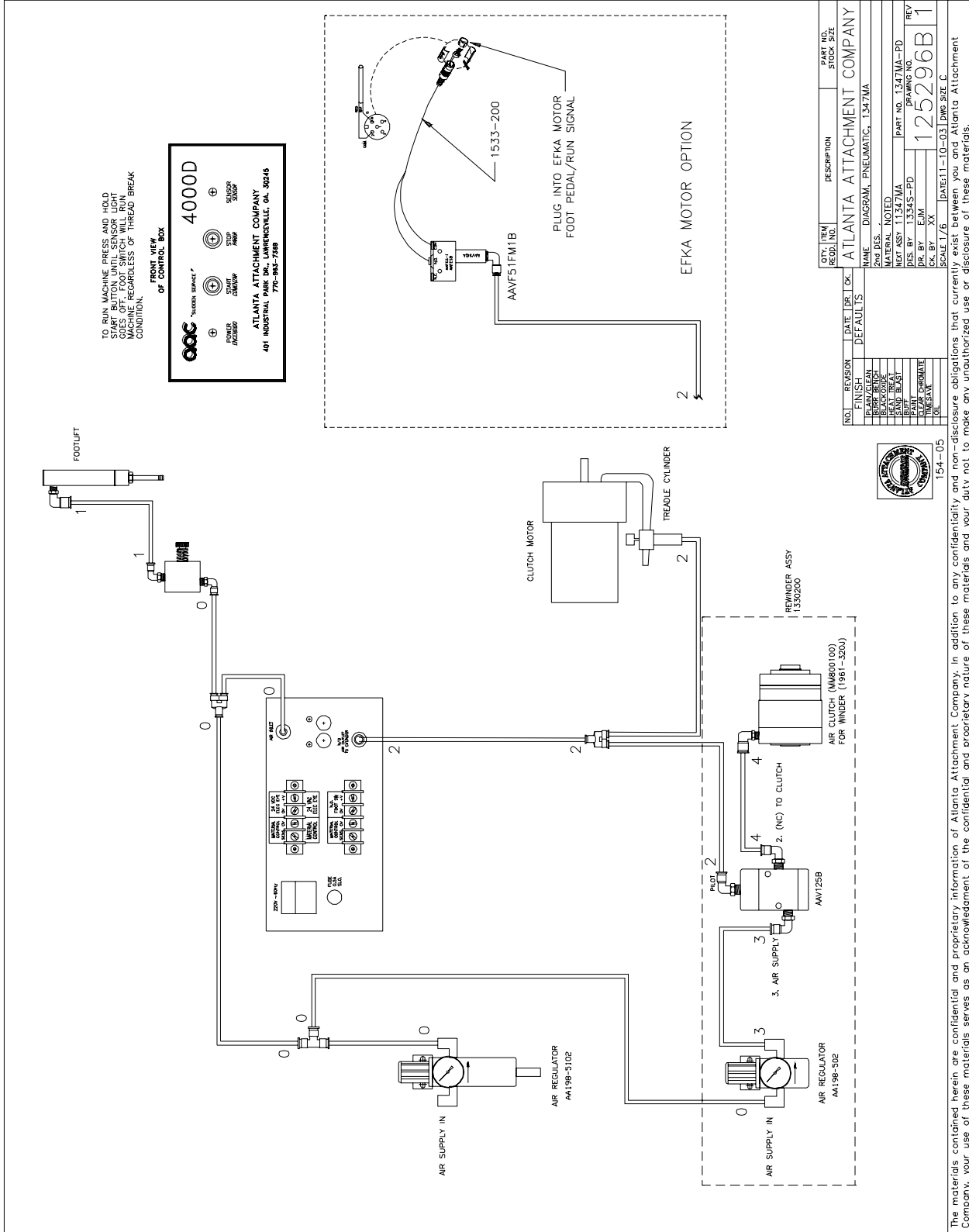


213-005 Stop Button Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	EEPMTS44	Push Button	1		4	350-12154	Stop Button Brkt	1	
2	EE3X01	Switch, N.C., SPST	1		5	EEA3L	Mounting Latch	1	
3	EE3X10	Switch, N.O., SPST	1				Drawing Number 290645A Rev. 3		

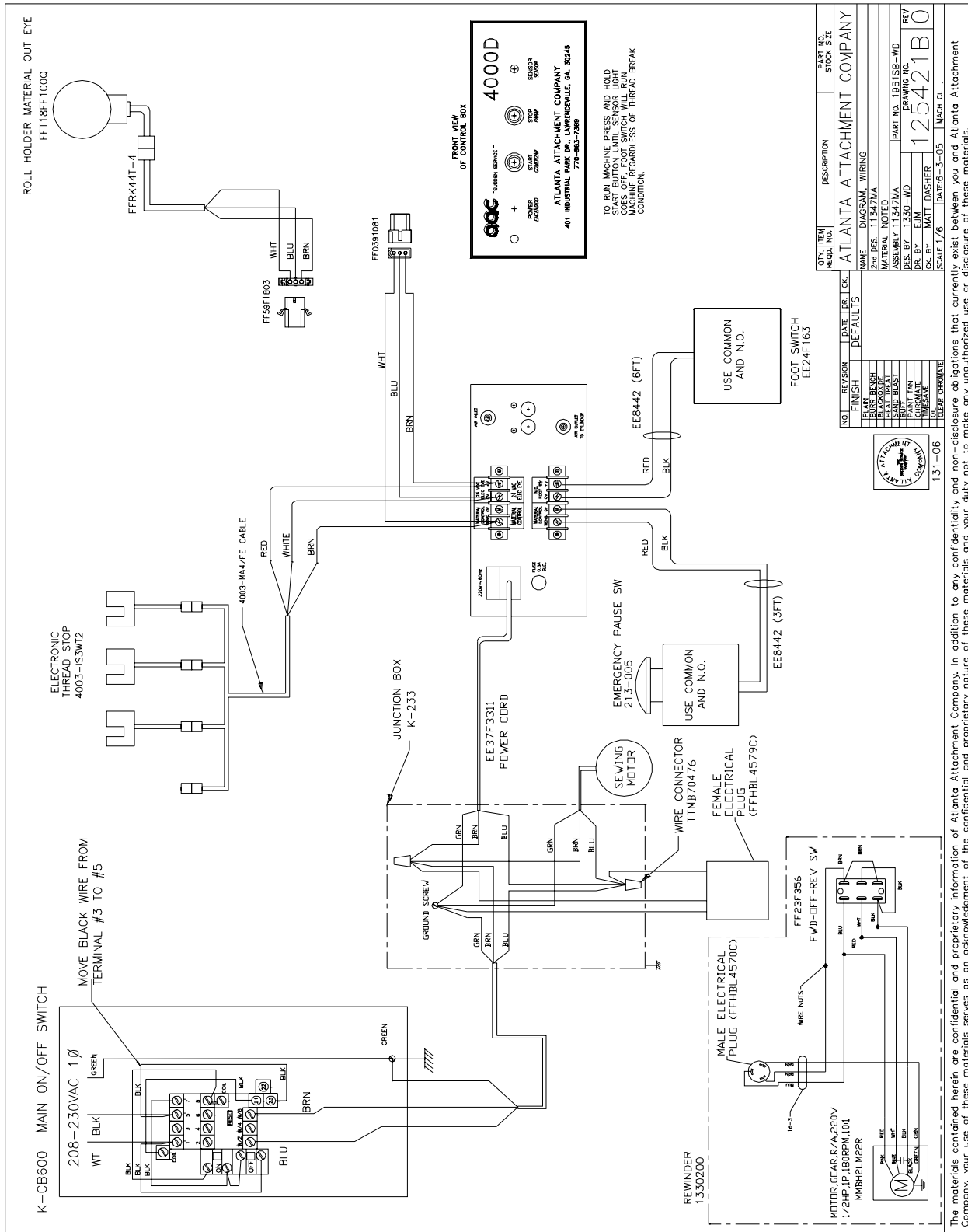


1347MA-PD Pneumatic Diagram



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	REG. NO.		1347MA-PD
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1961SB-WD Wiring Diagram



4000D
 ATLANTA ATTACHMENT COMPANY
 401 INDUSTRIAL PARKWAY
 WILMINGTON, GA 30245
 TEL: 770-962-1289

TO RUN MACHINE PRESS AND HOLD PAUSE SWITCH UNTIL MOTOR GOES OFF. FOOT SWITCH WILL RUN MACHINE REGARDLESS OF THREAD BREAK CONDITION.

QTY.	ITEM	DESCRIPTION	PART NO.	STOCK SIZE
	REGD. NO.			
	NAME	DIAGRAM, WIRING		
	2nd REV.	11/34/7MA		
	MATERIAL NOTED			
	ASSEMBLY	11/34/7MA	PART NO. 1961SB-WD	DRAWING NO.
	DES. BY	EJM	1330-MD	REV
	CHK. BY	EJM		
	SCALE	1/8" = 1"	DATE	12/28/65
			WASHER	125421B
				0



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Atlanta Attachment Company (AAC)

Statement of Warranty

Manufactured Products

Atlanta Attachment Company warrants manufactured products to be free from defects in material and workmanship for a period of eight hundred (800) hours of operation or one hundred (100) days which ever 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 which ever 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 manufacturer's (OEM) warranty.
- AAC will assist in the procurement and handling of the manufacturer's (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.

Atlanta Attachment Company (AAC)

Declaración de Garantía

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libre de defectos de material y de mano de obra durante un periodo de ochocientos (800) horas de operación o cien (100) días cual llega primero. Atlanta Attachment Company garantiza que todos los componentes del bus serie son libre 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 la máquina o pieza defectuosa devuelto para AAC.
- AAC reserva el derecho para tomar la decisión final sobre toda cuestión de garantía.
- Las garantías de AAC tienen un validez de ochocientos (800) horas o cien (100) días cual llega primero.
- AAC garantiza operación satisfactoria de sus máquinas en base de las normas aceptadas de la industria contingente en la instalación y mantenimiento adecuada.
- La garantía de AAC no puede ser cambiada o modificada y no está sujeto a cualquier otra garantía implicado por otro agente o distribuidor menos que sea autorizado por AAC antes de cualquier reclamo.

Lo Que Está Garantizado

- Componentes eléctricos que no están incluidos dentro del sistema Bus Serie que han sido manufacturados por AAC son garantizados por un periodo de ochocientos (800) horas.
- Mechanical parts or components that fail due to defects in material or workmanship, which are manufactured by AAC.
- 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 al raíz de mal transporte, accidentes, incendio o cualquier daño al resultado de servicio por personas no autorizadas o instalaciones incorrectas de conexiones eléctricas o neumáticas.
- Desgaste normal de repuestos como correas, anillos de goma, cuchillos, 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 en el campo.
- Pérdida de tiempo, ingresos potenciales, y/o ganancias.
- Daños personales y/o daños al propiedad al resultado de la operación de este equipo.

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