

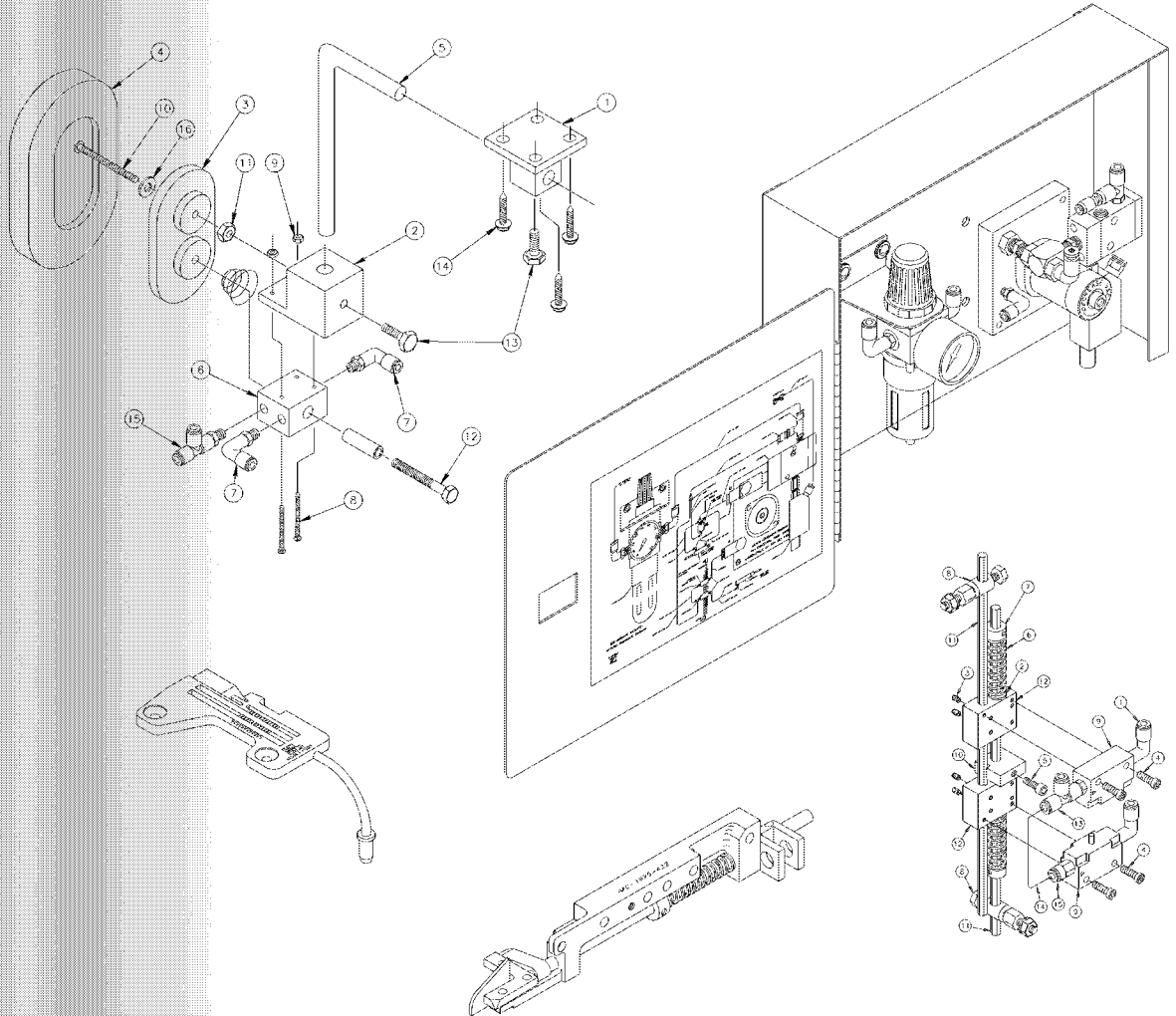
Innovative Technology For The Sewn Products Industry World Wide

ATLANTA ATTACHMENT COMPANY

# AP26SE

## Automatic Backlatch System

# TECHNICAL MANUAL



401 Industrial Park Dr.  
Lawrenceville, GA 30045  
[www.atlatt.com](http://www.atlatt.com)

**MANUAL NO. ZZAP26SE  
SETUP INSTRUCTIONS, LIST OF  
PARTS AND PNEUMATIC DIAGRAMS  
FOR**

**AAP26SE**

**Semi Automatic Backlatch**

**Last Updated 6-20-2002**

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**ATLANTA ATTACHMENT CO., INC.**

**LAWRENCEVILLE, GEORGIA**

**(770) 963-7369 FAX (770) 963-7641**

**PRINTED IN U.S.A.**

**MANUAL NO. ZZAP26SE  
INSTRUCCIONES DE INSTALACIÓN  
LISTA DE PARTES, Y DIAGRAMA  
NEUMÁTICO PARA LA**

**AAP26SE**

**Remate Semiautomático**

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**IMPRESO EN LOS EE.UU.**

**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.

**Este equipo es fabricado bajo una o más de las  
patentes siguientes:**

En EE.UU.: 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;  
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92,905,522.6; 95,935,082.8; 96,936,922.2.

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## **!CAUTION!**

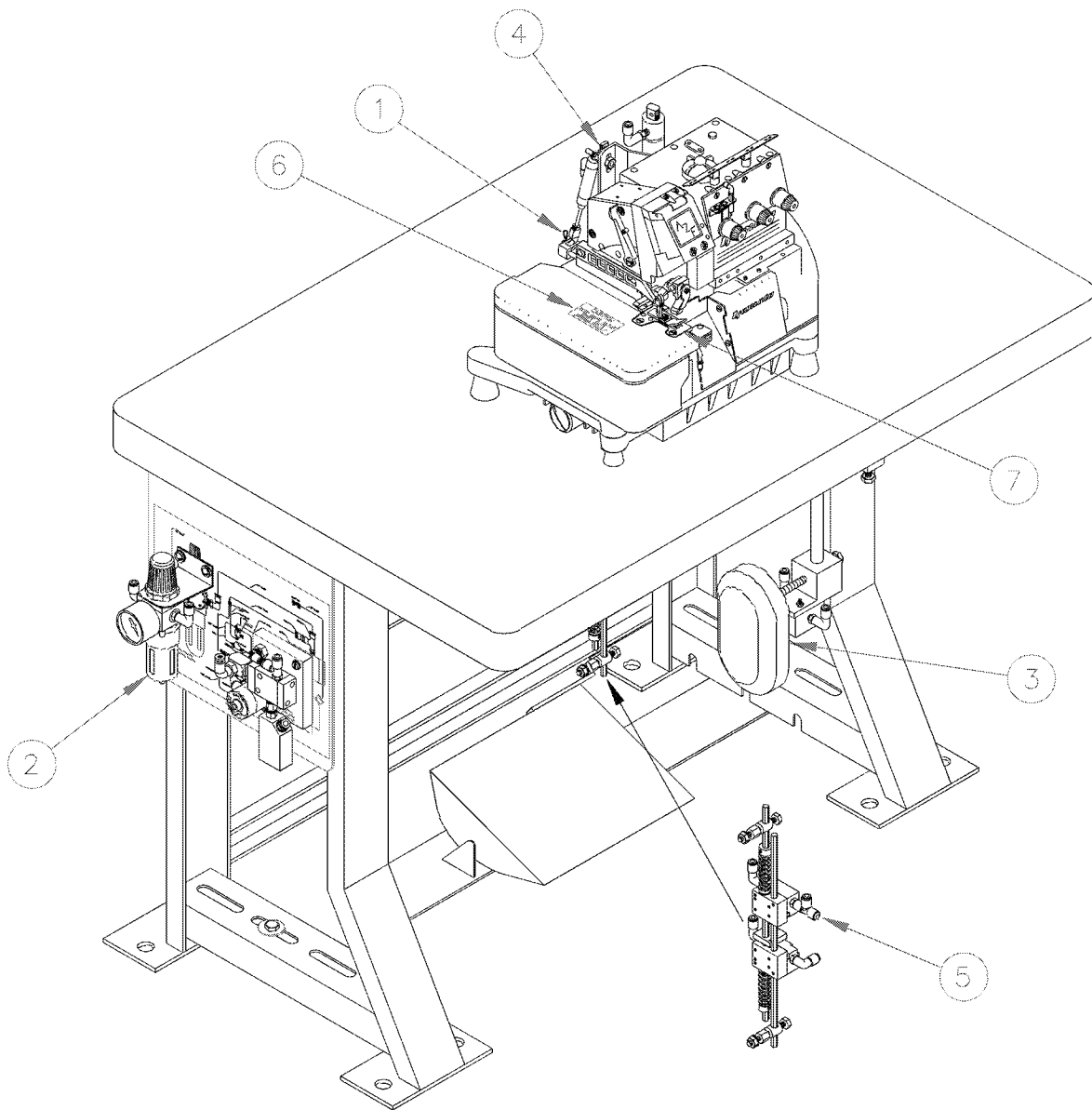
**There is a chain cutting knife located behind the presser foot. This knife is operated remotely by a electric Eye or a Push Button. DO NOT put fingers or hands in or around this knife.**

**All sewing adjustments to the sewing machine head should be made with the power “OFF”.**

## **¡PRECAUCIÓN!**

**Hay una cuchilla para cortar la cadeneta situada detrás del pie prensatelas. Esta cuchilla es accionada por un Ojo Fotoeléctrico o un botón de hundir. No ponga los dedos o las manos en o alrededor de esta cuchilla.**

**Todos los ajustes a la cabeza de la máquina de coser deben hacerse con la electricidad “APAGADA”.**



## AAP26SE Major Components

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	1975-400*	1	2-6	7	Throat Plate & Parts	1	2-8
2	1975E-400A	1	1-6	8	SSZH#10064	4	Δ1
3	1975-400K	1	1-8	9	AATP4-1	10ft	Δ1
4	1975-400*	1	2-7	10	AATP5/32	20ft	Δ1
5	AA192-56	1	1-9	Δ1 = Not Shown			
6	AT-LABEL-1	1					

\* = Last character denotes machine head type. See Section II for complete number.

\*\* = Cut can be accomplished on heel back. Delete Knee Switch and use appropriate Treadle Switch.

## **1975E-400A Control Panel**

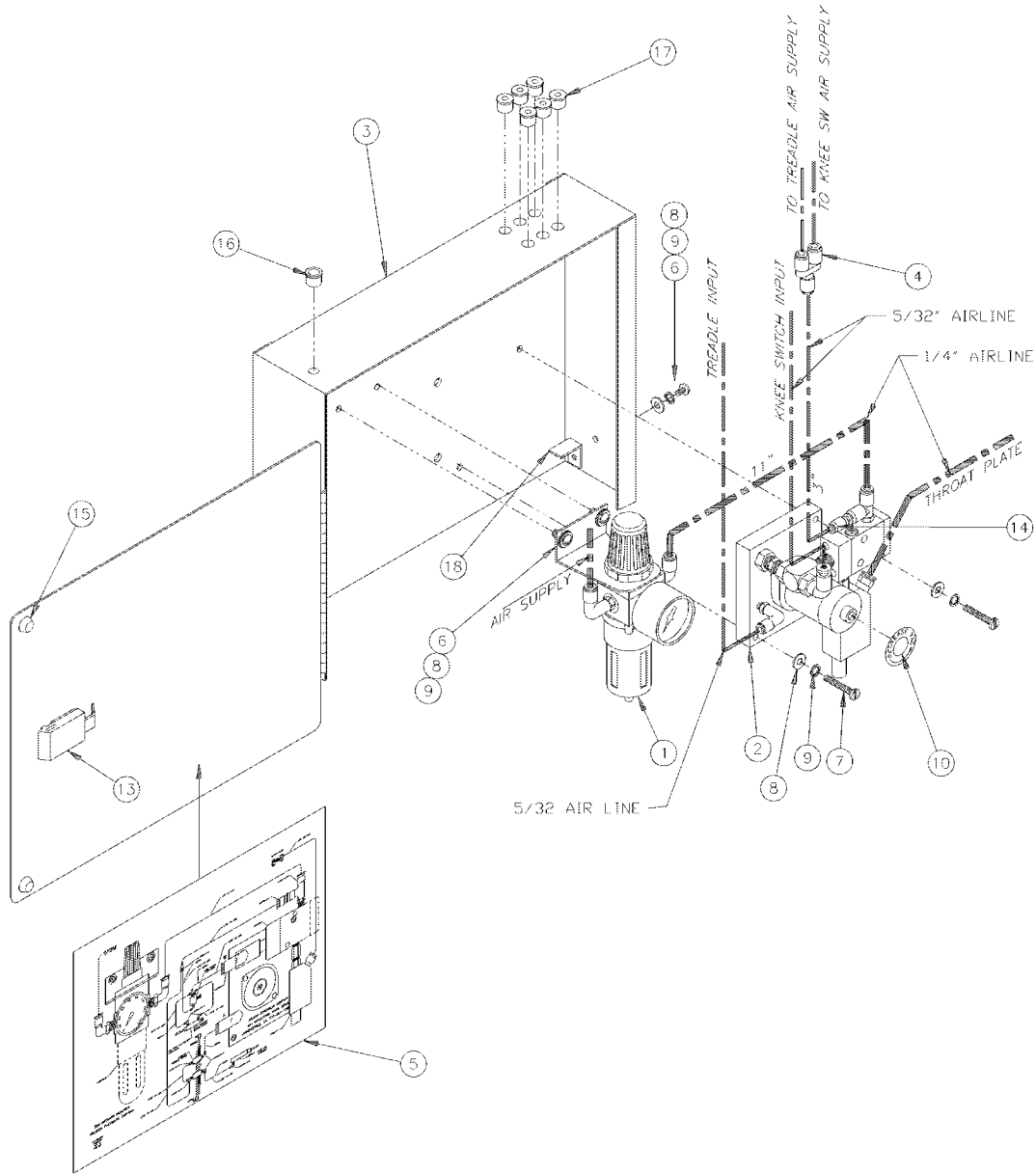
There must be an independent air supply to the Control Panel (no tees or splices) from a main line. This line should be able to maintain 4 CFM of air at 80 PSI. If the Backlatch is not operating correctly:

- (A) Turn off the air supply.
- (B) Disconnect air line from the throat plate at the vacuum valve.
- (C) Clean any thread or trash from inside the vacuum generator.
- (D) Check all fittings and air lines for tightness and air leaks.
- (E) Check Throat Plate for holes in the tube or burrs on the chaining finger.

## **Panel De Control 1975E-400A**

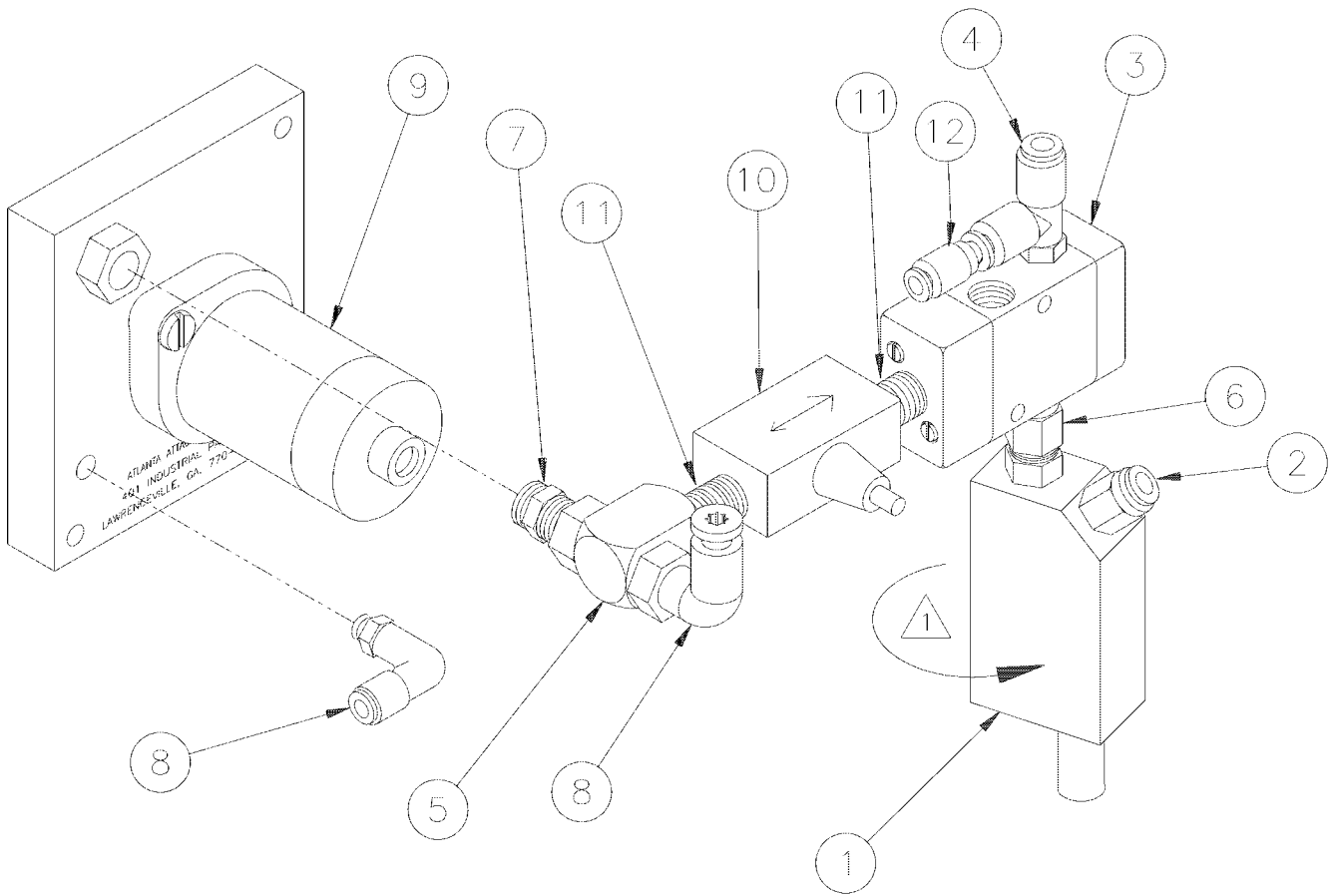
Tiene que haber un surtidor independiente de presión de aire desde una línea principal al panel de Control (no "T" o empalmes). Esta línea debe poder mantener 4 Pies Cúbicos por Minuto (CFM) de presión de aire a 80 PSI. Si el Remate Automático no está operando correctamente:

- (A) Apague la presión de aire.
- (B) Desconecte la manguera de presión de aire de la plancha de la aguja a la válvula de succión.
- (C) Limpie cualquier hilo o basura de dentro del generador de vacío.
- (D) Verifique que todos los accesorios y las mangueras estén bien apretados y chequee por escapes de aire.
- (E) Chequee por orificios en el tubo de la Plancha de la Aguja y por esquirlas en el dedo de encadenado.



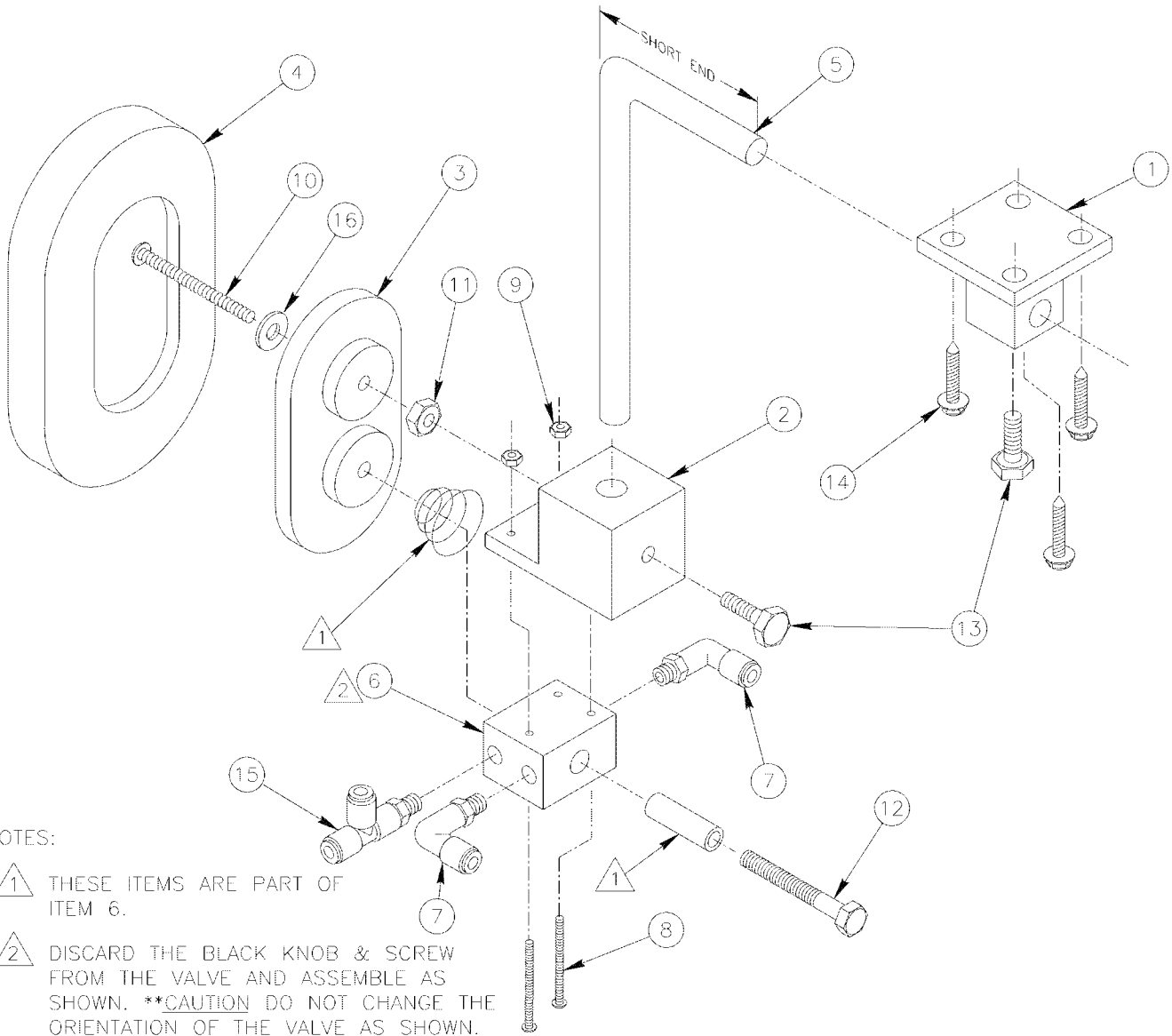
## 1975E-400A Control Panel

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AA198-5102	Reg. w/ gauge & nut	1	11	1975C-407	Reg. Label	AR Δ1
2	1976-408D	Backlatch Acrylic SubA.	1	12	LABEL-PAT	Patent Label	AR Δ1
3	1975D-401	Control Box	1	13	MM40450010	Latch	1
4	AAQUY-5-5	Quick Union Y	1	14	AAQPR-5-4	Quick Reducer	1
5	AAP26SEPD2	Pneumatic Diagram	AR	15	MMSLD-ECH	Rubber Bumper	2
6	SSPS90024	Scr, Pn SI 8-32x3/8	3	16	EESB-375-4	Heyco Bushing 1/4"	1
7	SSPS90064	Scr, Pn SI.8-32x1	2	17	EESB-375-3	Heyco Bushing 3/16"	6
8	WWF8	Flat Washer	5	18	1275C-411	Support	1
9	WWSI8	Internal Star Washer	5	AAC Drawing Number = 191786C Rev. 8			
10	1975C-405A	Label, Decrease Vaccum.	AR				



### 1976-408D Backlatch Acrylic Sub Assembly

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AAV#33-4	1		8	AAQME-5-8	AR	
2	AAQMC-4-8	AR		9	AAVR333	AR	
3	AAV125B	AR		10	AAF207P-2	AR	
4	AQMT-4-8	AR		11	273-4-504	AR	
5	AAVSI25	AR		12	AAQPR-5-4	AR	
6	AAQPR-5-4	AR		AAC Drawing Number = 190403A Rev. 4			
7	AAF122A-A	AR					



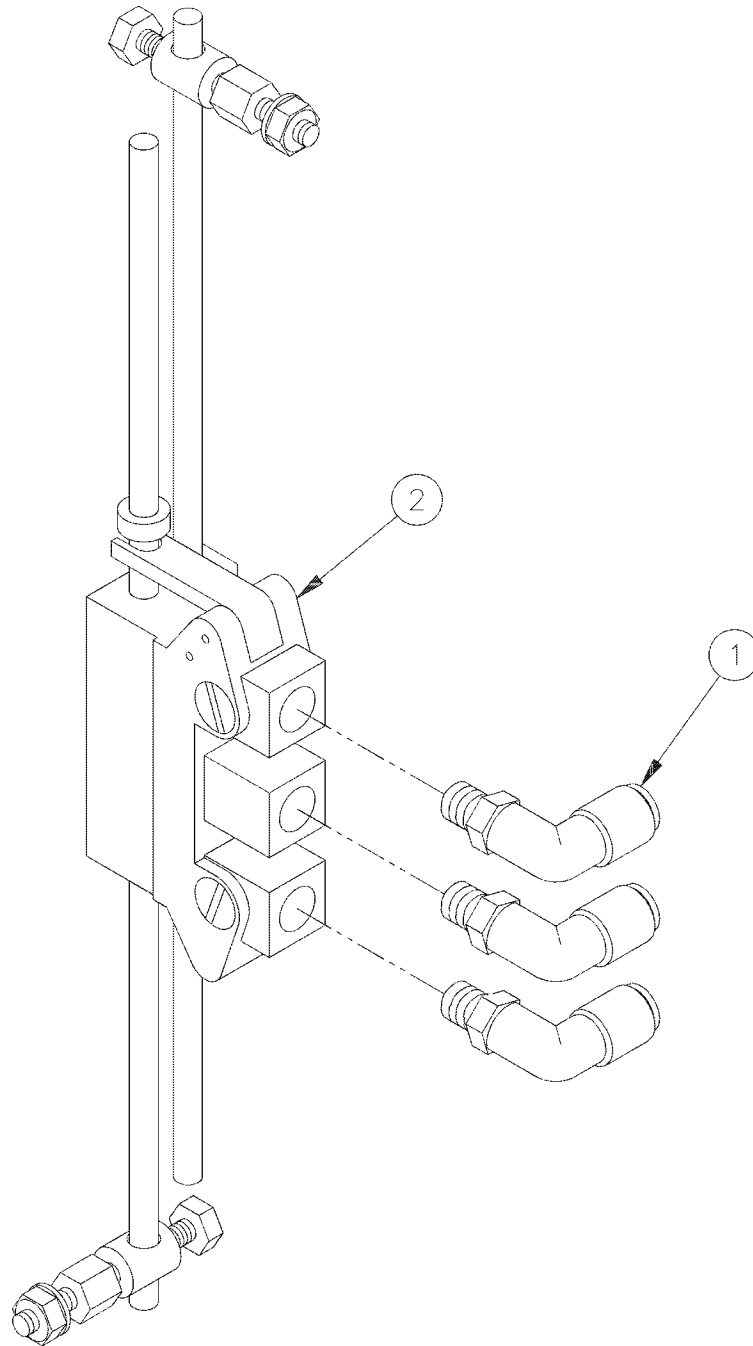
NOTES:

- 1. THESE ITEMS ARE PART OF ITEM 6.
- 2. DISCARD THE BLACK KNOB & SCREW FROM THE VALVE AND ASSEMBLE AS SHOWN. **\*\*CAUTION DO NOT CHANGE THE ORIENTATION OF THE VALVE AS SHOWN.**
- 3. ITEMS 1-13 TOGETHER MAKE UP A AA192-6-1 KNEE SWITCH.

## 1975-400K Knee Switch

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AA192-6A1	Machine Mount	1	10	SSRS98160	Scr,Rd,Slot, 10-32x2 1/2	1
2	AA192-6A2	Switch Mount	1	11	NNH10-32	Nut, Hex, 10-32	1
3	AA192-6A3	Activator	1	12	SSHC01128	Scr,Hex Cap, 1/4-20 x 2	1
4	AA192-6A5	Rubber Pad	1	13	SSHC10048	Scr,Hex Cap, 5/16-18 x 3/4	2
5	273-4-407	Bent Rod	1	14	SSZH#10064	Scr,Pan Sht Met, #10 x 1	4
6	AAVMB43	Valve	1	15	AAQMT-5-8	Male Run Tee	1
7	AAQME-5-8	Quick Male Elbow	2	16	WWF10	Washer, Flat, #10	1
8	SSRS80096	Scr,Rd,Slot, 6-32x1 1/2	2	AAC Drawing Number = 190106B Rev. 2			
9	NNH6-32	Nut, Hex, 6-32	2				

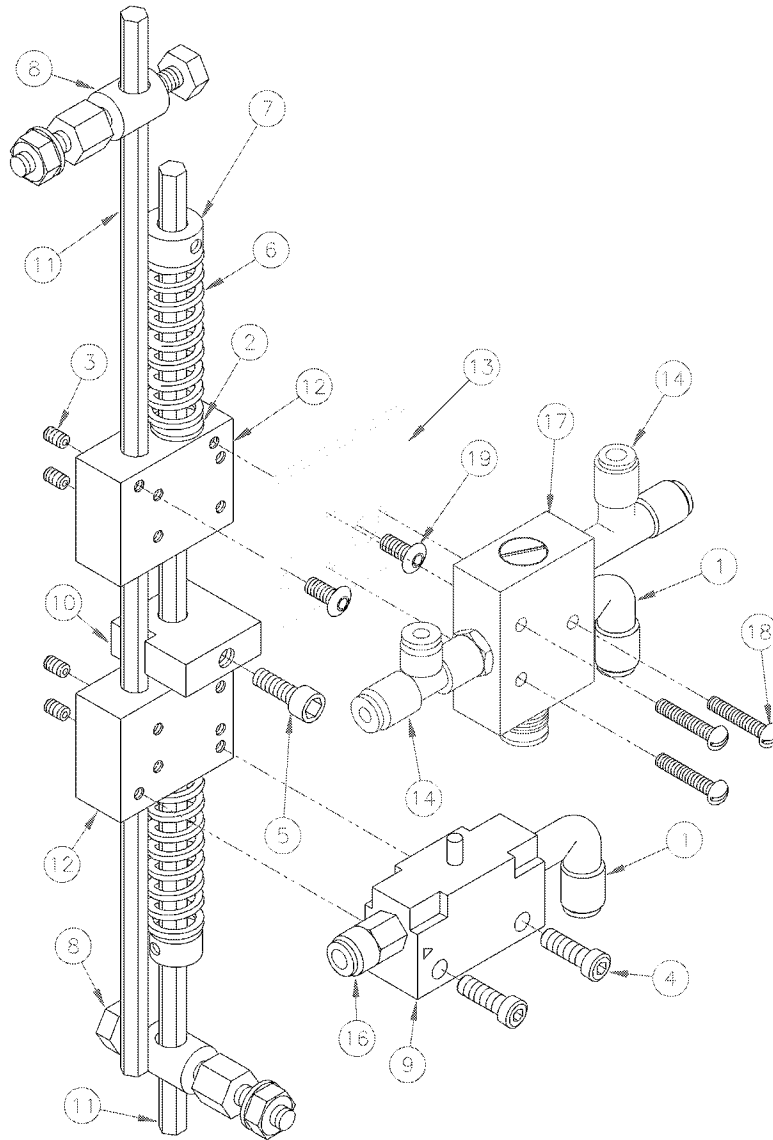




### AA192-56 Double Action Treadle Switch

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AAQME-5-8	Quick Male Elbow	3	2	AA25768	Treadle	1

AAC Drawing Number = 190123B Rev. 7



NOTES:

△ NOT SHOWN.

## 1975-400T1 Treadle Switch, Double Action

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	AAQME-5-8	Quick Male Elbow	2	11	AA192-552	Treadle Rod	1
2	WWF5/16S	Washer SAE No. 5/16	2	12	AA192-554	Mount Block	2
3	SSSS90012	Scr,So St 8-32x3/16	4	13	AA192-555	Bracket Valve	1
4	SSSC90064	Scr,So Cp 8-32x1	2	14	AAQMT-5-8	Quick Male Tee	2
5	SSSC01064	Scr,So Cp 1/4-20x1	1	15	AATP5/32	Airline, 5/32	.37'
6	RRLC026E12	Spring	2	16	AAQMC-5-8	Quick Male Conn	1
7	CCSC9/32	9/32 ID Set Collar	2	17	AAV41-P	Air Valve	1
8	AA192-7DC1	Rod End	2	18	SSPS80048	Scr. Pn Hd Sl 332x3/4	3
9	AAVNVM130	Air Valve	2	19	SSFC90024	Scr. Fl Al Cp 3-32x3/8	2
10	AA192-591	Activator Bracket	1	AAC Drawing Number = 192007B Rev. 1			

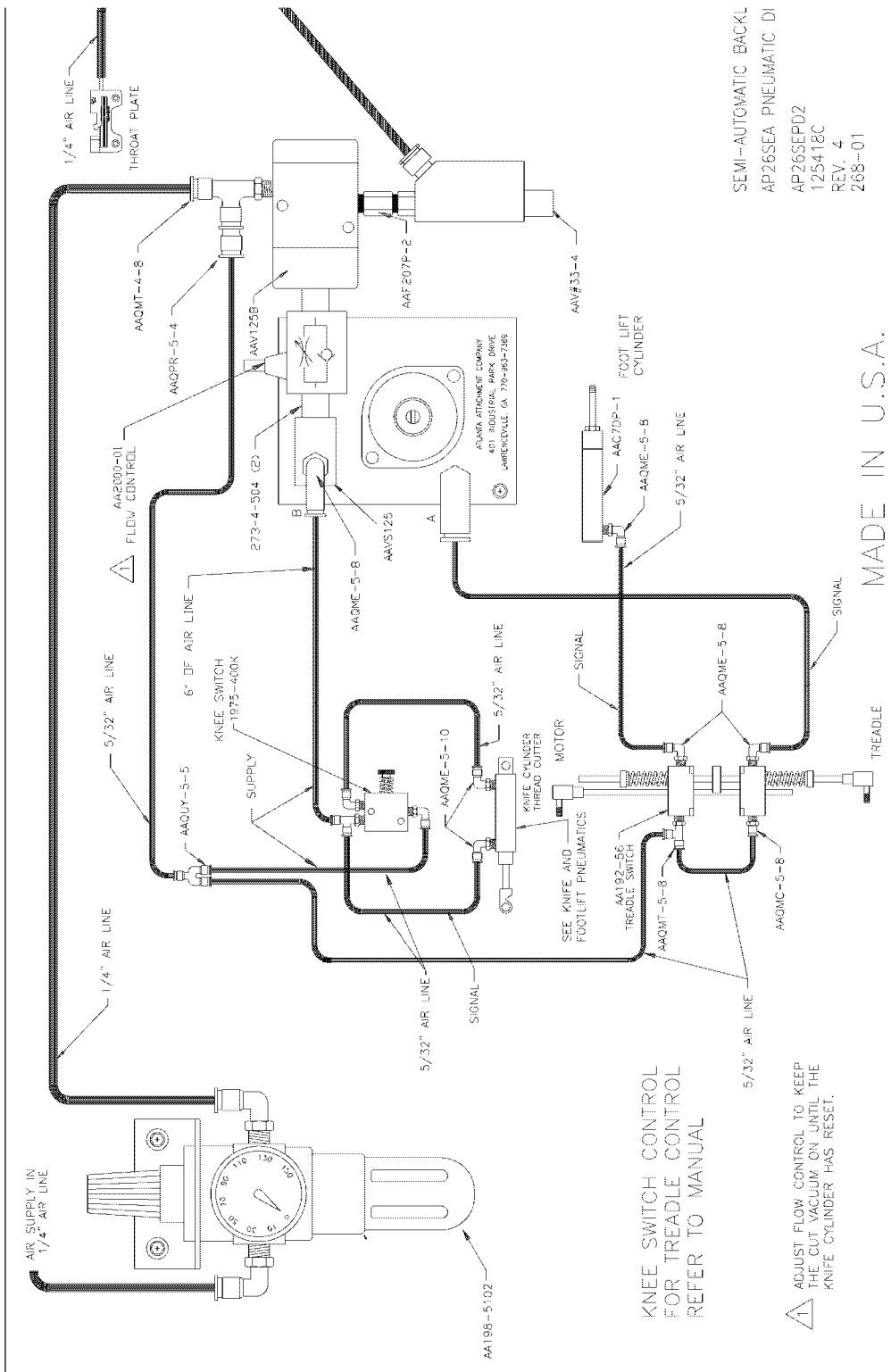
## AAP26SE Sew Off

1. Heel the treadle to lift the foot.
2. Insert the garment under the presser foot as close to the needle as possible.
3. Release and depress the sew treadle.
  - A. Vacuum comes on.
  - B. Stitching begins.
  - C. Vacuum shuts off. The time interval of the vacuum "on" is only long enough to capture the stitch chain and sew past the vacuum tube at the rear of the throat plate. To change this time interval, rotate screw on timing valve as indicated.
4. As sewing is complete, release the treadle and gently pull the chain to the rear and actuate the chain cutting knife by depressing the knee switch, or heel back to cut if the heel back to cut option was selected. The stitch chain must be completely pulled off the stitch tongue.
5. The knee switch or optional heel switch will operate the chain cutting knife and open the vacuum to the chaining tongue for a predetermined amount of time.
6. Ideally the chain will be drawn into the tube by the vacuum from the cut signal.
7. Another garment can now be sewn. Placement of the garment to the edge trimming knife and needle position are of little concern.

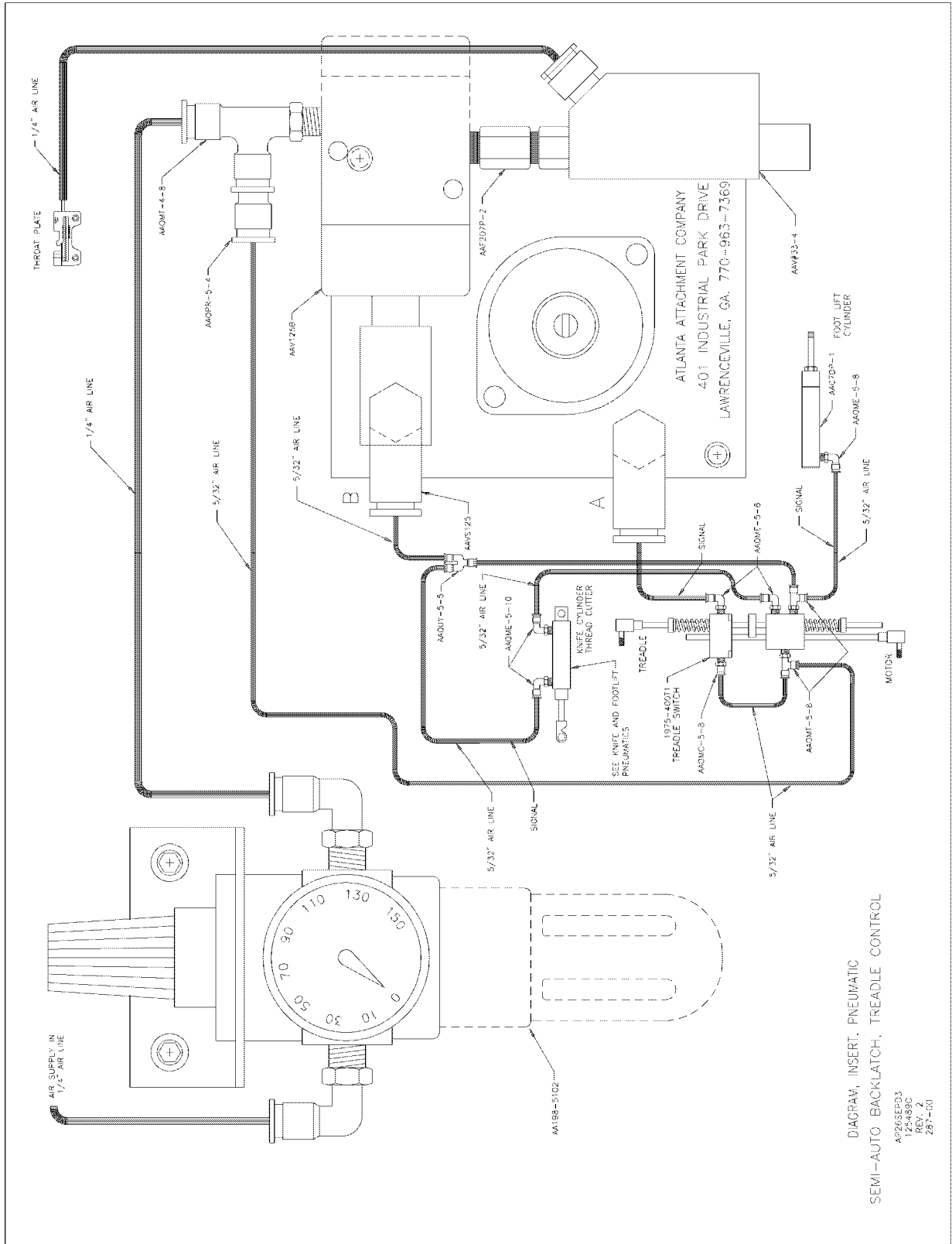
## Para Coser Con La AAP26SE

1. Taconee el pedal para levantar el prensatelas.
2. Inserte la prenda debajo del prensatelas tan cerca de la aguja como sea posible.
3. Suelte y hunda el pedal para coser.
  - A. La succión se enciende.
  - B. La costura comienza.
  - C. La succión se apaga. El tiempo que la succión se enciende es sólo suficiente para capturar la cadeneta y coser más allá del tubo de succión en la parte posterior de la plancha de la aguja. Para cambiar este intervalo de tiempo, rote el tornillo en la válvula de tiempo como es indicado.
4. Al terminar la costura, suelte el pedal y suavemente tire de la cadeneta hacia atrás y active el cortacadeneta con el interruptor de rodilla, o taconee para cortar si se escogió la opción de cortar con el tacón. La cadeneta tiene que ser completamente halada de la lengua de la puntada.
5. El interruptor de rodilla o el interruptor opcional del talón operará el cortacadeneta y encenderá la succión a la lengua de encadenado por un tiempo predeterminado.
6. La cadena debe introducirse dentro del tubo de succión a la señal de corte.
7. Otra prenda puede ser cosida ahora. La colocación de la prenda hasta la recortadora de borde y la posición de la aguja no son importantes.

# AP26SEPD2 Pneumatic Diagram



# AP26SEPD3 Pneumatic Diagram



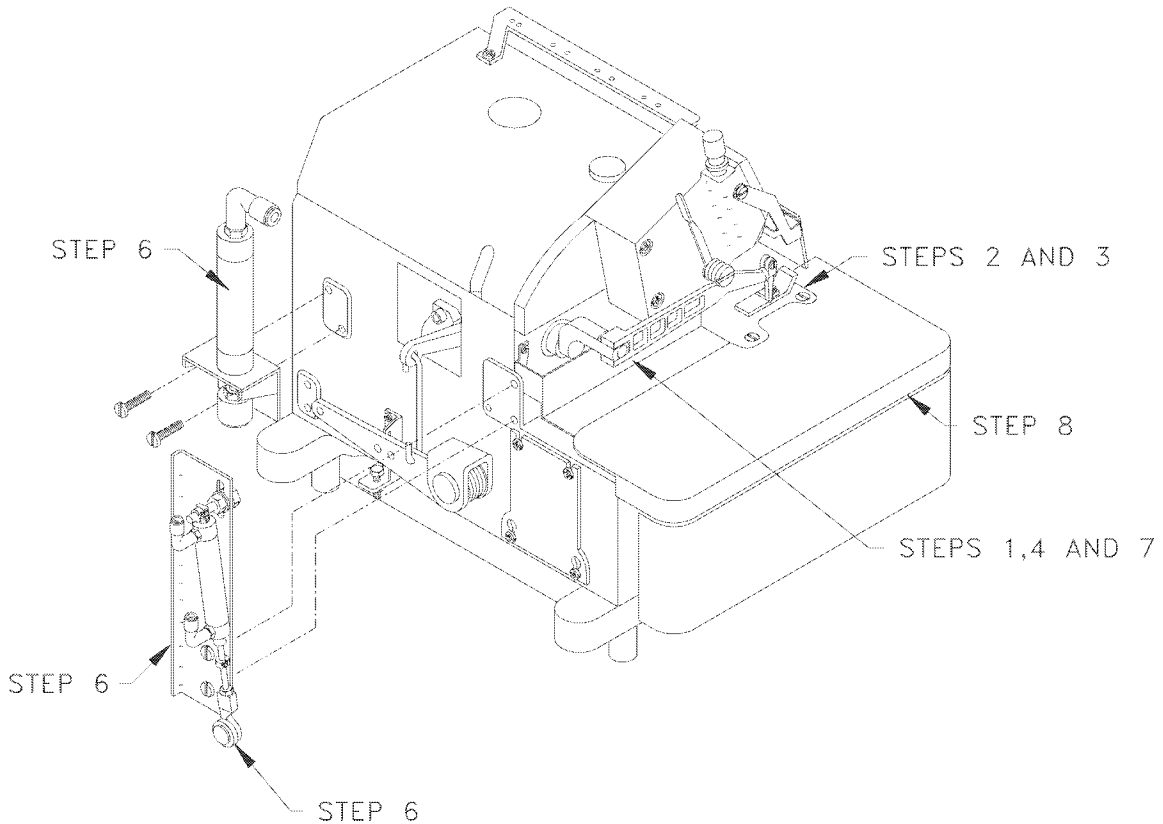
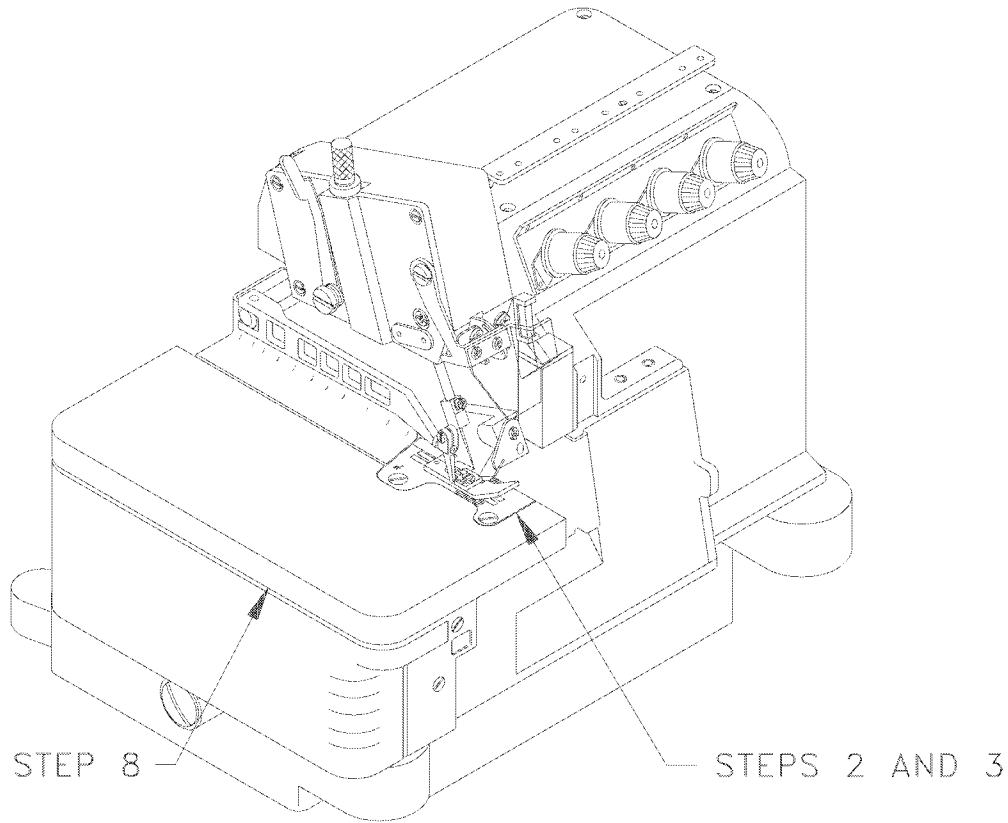
# Notes

**SECTION II**  
**AAP26SEG24, AAP26SEG27**  
**& AAP26SEG29**  
**INSTALLATION INSTRUCTIONS**  
**FOR**

**PEGASUS**  
**G24 FOR MODEL EX5204-02**  
**G27 FOR MODEL EX5214-02**  
**G29 FOR MODEL S52**

**INSTRUCCIONES DE INSTALACIÓN**  
**PARA**

**PEGASUS**  
**G24 PARA MODELO EX5204-02**  
**G27 PARA MODELO EX5214-02**  
**G29 PARA MODELO S52**





**AAP26SE G24/27****Installation Instructions**

1. Remove the material guard . Use the screws to mount the Cutter spacer block.
2. Remove the throat plate.
3. Remove the feed dogs. Install the feed dogs provided with the kit. (Or modify per dwgs. on pages 9 and 10 and reinstall)
4. Install the Cutter assembly (1975-400M) on the spacer block.
5. Install the patented throat plate provided (M3G24-001) or (M3G27-001). Check to make sure the needle is properly aligned in the slot. Check the feed dog alignment and set the feed dog height. Note: Check for interference between the Cutter body and the rear feed dog.
6. Mount the footlift cylinder assembly to the sewing head with the screws provided. Mount the Cutter drive cylinder assembly to the sewing head with the screws provided. Adjust the height of the moveable blade by moving the Cutter driver cylinder with the rod extended. The Cutter blade should be as high as possible without any interference. Use the clamp collar on the rod to limit the travel of the blade. The blades should be able to cut their entire length, but the moveable blade should not contact the Cutter body.
7. Install the material guide on the Cutter body.
8. Place the Cutter warning label on the cloth plate.

**AAP26SE G24/27****Instrucciones de Instalación**

- Quite la guarda del material. Use los tornillos para montar el bloque espaciador de la Cortadora.
- Quite la plancha de la aguja.
- Quite los dientes de arrastre. Instale los dientes de arrastre provistos. (O modifique de acuerdo a los dibujos en las pags. 9 y 10 y vuelva a montarlos)
- Instale el ensamblado de la Cortadora (1975-400M) en el bloque.
- Instale la plancha de la aguja patentada provista (M3G24-001) o (M3G27-001) Verifique que la aguja está debidamente alineada en la ranura. Chequee el alineamiento y fije la altura de los dientes. Nota: Chequee por interferencia entre el cuerpo de la Cortadora y los dientes de arrastre de atrás.
- Monte el cilindro del alzaprensateelas al cabezal con los tornillos provistos. Monte el ensamblado del cilindro de transmisión de la Cortadora al cabezal con los tornillos provistos. Ajuste la altura de la hoja movable moviendo el cilindro del transportador de la Cortadora con la varilla extendida. La hoja de la Cortadora debe estar tan alto como sea posible sin ningún obstáculo. Use el collar de sujeción en la varilla para limitar el viaje de la hoja. Las hojas deben poder cortar en toda su extensión, pero la hoja movable debe no entrar en contacto con el cuerpo de la Cortadora.
- Instale la guía de material en el cuerpo de la Cortadora.
- Coloque el rótulo de advertencia en la plancha de la tela.

9. Mount the knee switch to the underside of table with the screws provided. The operator's right knee, while at rest, should be aligned with the edge of the trimming Cutter on the machine. Locate the knee switch accordingly. [Optional Pedal. Mount pedal to treadle mount brace on stand.]
10. Move existing treadle rod assembly from the treadle and install the treadle switch provided. The "T" air fitting should be positioned at the top. Adjust the treadle rod to accommodate the operator. The tension on the motor clutch should be adjusted so that the vacuum to the throat plate is turned on just before the machine begins to sew. Adjust the clutch if necessary at this time.
11. Mount the Control Panel Assembly to the table top using the screws provided.
12. Attach the air lines according to the pneumatic diagram.
13. The unit is now installed on the machine and is ready to be sewn off. See sew off instructions located in section 1 in this manual.

Monte el interruptor de rodilla a la parte de abajo de la mesa con los tornillos provistos. La rodilla derecha del operario, mientras en reposo, debe alinear con la cuchilla de la recortadora en la máquina. Localice el interruptor de la rodilla en conformidad. [Pedal Opcional. Monte el pedal a la montura en el soporte.]

Quite la varilla del pedal existente e instale el interruptor del pedal provisto. La "T" del sistema neumático debe estar arriba. Ajuste la varilla del pedal para dar comodidad al operario. La tensión en el embrague del motor debe ajustarse para que la succión a la plancha de la aguja se encienda justo antes que la máquina empiece a coser. Ajuste el embrague ahora si es necesario.

Monte el panel de Control a la mesa usando los tornillos provistos

Conecte las mangueras según el diagrama neumático.

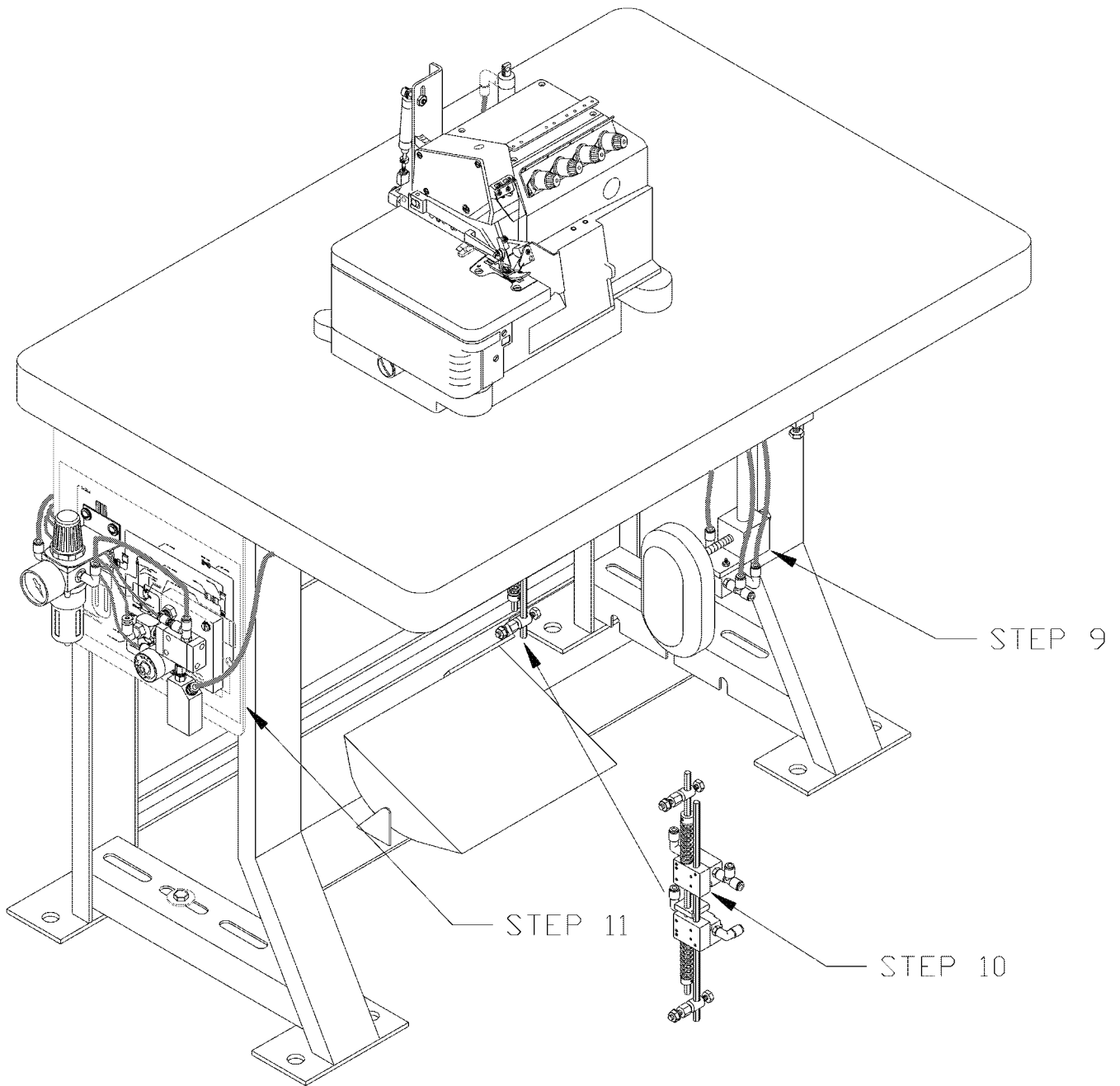
La unidad está ahora instalada en la máquina y lista para coser. Las instrucciones para coser las encontrará en la sección 1 del manual.

## **IMPORTANT NOTES**

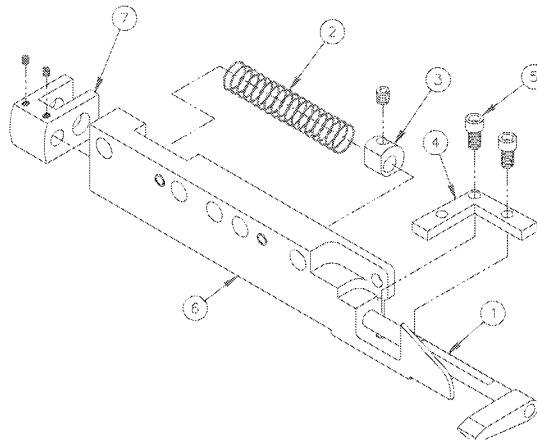
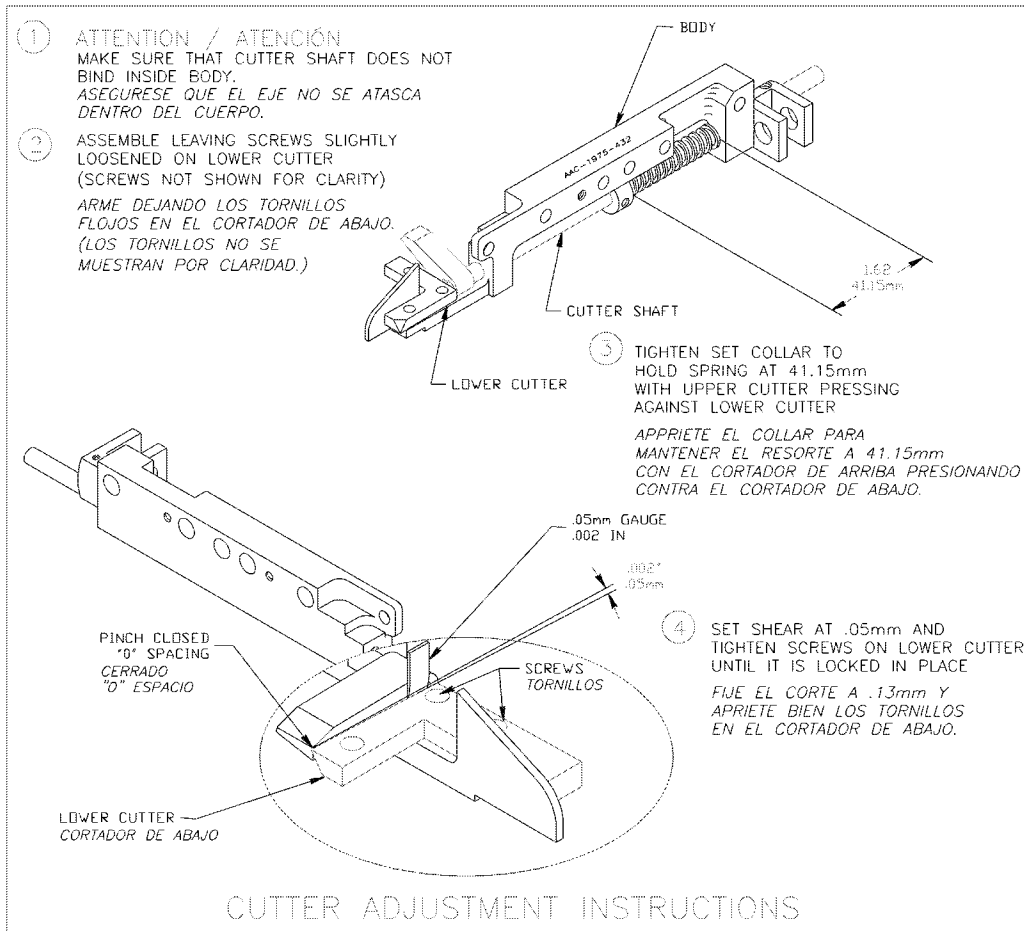
The needle height setting will be 1/16" less than the book setting because of the thicker throat plate. Make sure the lower looper does not contact the throat plate. If it does, install the throat plate spacer provided.

## **NOTAS IMPORTANTES**

La altura de la aguja será 1/16" menos que la del libro debido a que la plancha de la aguja es más gruesa. Asegurese que el engazador (looper) de abajo no hace contacto con la plancha de la aguja. Si lo hace, instale el espaciador de la plancha de la aguja, (provisto.)

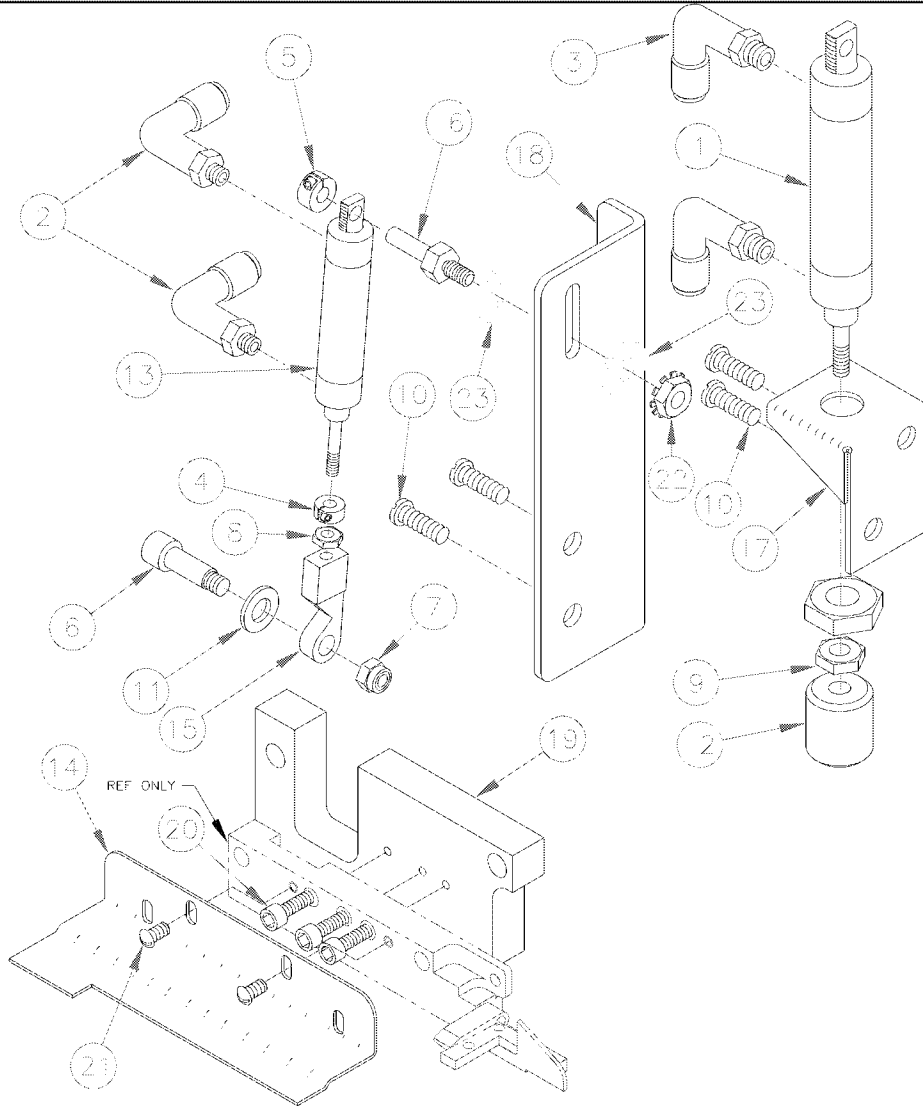


# AAP26SE



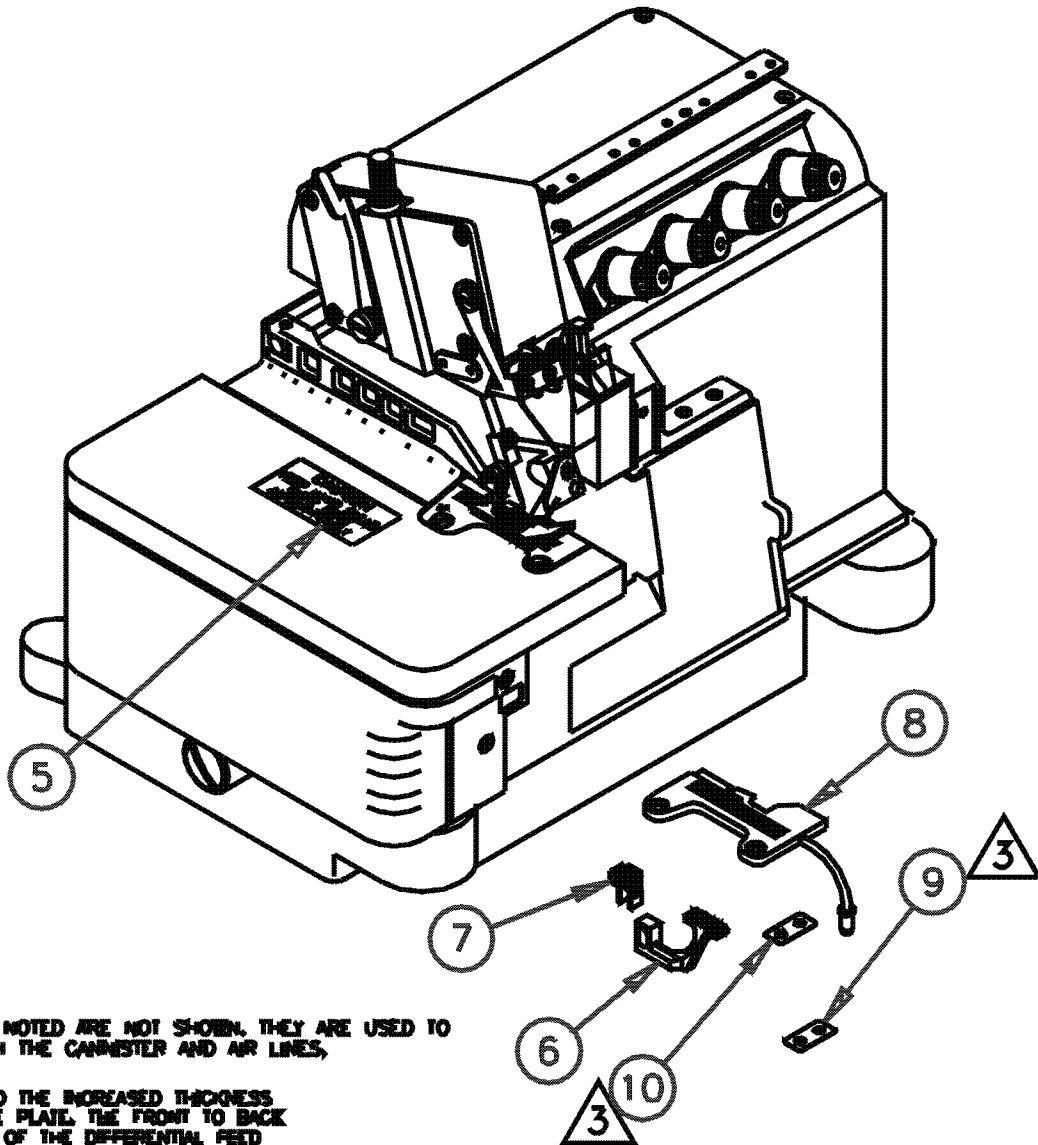
### 1975-400MG Cutter Assembly

Part No.	Description	Qty.	Pg.	Part No.	Description	Qty.	Pg.
1	1976-100	Upper Cutter Assy	1	6	1975-432	Cutter Body	1
2	RRLC024C14	Spring	1	7	1975-407	Clevis	1
3	1976-002	Retainer	1	NOTE: 1976-024 Lower Cutter has 2 sharpened sides. i.e. it may be rotated 1 time.			
4	1976-024	Lower Cutter	1	AAC Drawing Number = 190330C Rev.8			
5	SSSC70016	Scr.Soc Cap 4-40x.25	2				



## 1975-400G6 Cutter & Footlift Pneumatics For Pegasus Sewing Head

Part No.	Description	Qty	Pg.	Part No	Description	Qty	Pg.
1	AAC7DP-1	1		13	1975-213A	1	
2	AAQME-5-10 Quick Male Elbow	2		14	1975-244	1	
3	AAQME- 5-8 Quick Male Elbow	2		15	1975-408	1	
4	CCCL3F	1		16	1976-048	1	
5	CCSC33/16	1		17	1976-057B	1	
6	SSM4633	1		18	1976-058	1	
7	NNE10-32	1		19	1976-059	1	
8	NNH10-32	1		20	SSSC85024	3	
9	NNJ1/4-28	1		21	SSTS85016	0	
10	SSCM6X10	4		22	NNK10-32	1	
11	WWFF1/4A	1		23	WWFS10	2	
12	11200	1		AAC Drawing No. 190478A Rev. 7			



**NOTES:**

▲ ITEMS NOTED ARE NOT SHOWN. THEY ARE USED TO ATTACH THE CANISTER AND AIR LINES.

2, DUE TO THE INCREASED THICKNESS OF THE PLATE, THE FRONT TO BACK ANGLE OF THE DIFFERENTIAL FEED MAY NEED ADJUSTMENT

▲ INSTALL UNDER PLATE THROAT MOUNT

## 1975-400\*\* Throat Plate & Parts

Part No.	Description	Qty	Pg.	Part No.	Description	Qty.	Pg.
1	EE6X750 Cable Tie, 4 1/2"	8		6	M2G24-001 Feed Dog, Modified	1	
2	NNE1/4-20 Nut, Elastic Lock, 1/4- 20	2		7	M2G24-002 Main Feed Dog	1	
3	SSHC01056 Scr, Hex Cap 1/4-20 x 7/8	2		8	M3G24-001 For EX5204-02	0	
4	WWF1/4 Washer, Flat 1/4	4		9	26419 Spacer Support, Front	1	
5	AT-LABEL-1 Label "Caution"	1		10	26420 Spacer Support, Reart	1	

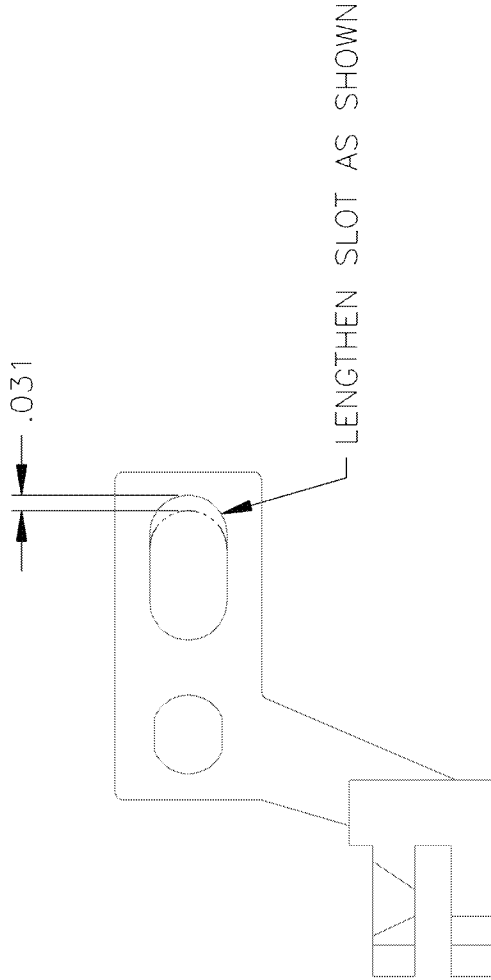
AAC Drawing Number = 190479A Rev. 6

Technical drawing of a gear-like part. The drawing shows a side view of the part with a lengthened slot. A dimension line indicates a length of .031 for the slot. A note points to the right side of the teeth, stating "REMOVE RIGHT SIDE OF FEED TEETH AS SHOWN." Another note points to the slot, stating "LENGTHEN SLOT AS SHOWN." The drawing includes a circular feature with a plus sign inside, likely representing a hole or a specific finish.

QTY.	ITEM	DESCRIPTION	PART NO.
RECD.	NO.		STOCK SIZE
1		ATLANTA ATTACHMENT COMPANY	
NAME		FEED DOG, MODIFIED	
2nd DES.		FOR 0411-SG24	
MATERIAL		277305-16F	
ASSEMBLY		0411-SG24	PART NO. M2G24-001
DES. BY		JAM	DRAWING NO.
DR. BY		ALAN HUTCHINS	252053A
CHK BY		JEFF THOMAS	1
SCALE		NTS	MACH CL
DATE		5-6-92	EX5204-02
PF		AF	



139-92



QTY. ITEM RECD. NO.	DESCRIPTION	PART NO. STOCK SIZE
ATLANTA ATTACHMENT COMPANY		
NAME	FEED DOG MAIN	
2nd DES	EX5204 PFAFF	
MATERIAL	277303-16F	
ASSEMBLY		PART NO. M2G24-002
DES. BY	JDL	DRAWING NO.
DR. BY	JEFF THOMAS	252095A
CK. BY	ALAN HUTCHINS	REV
SCALE	3/1	DATE: 7-7-97
		MACH. CL. EX5204 PFAFF

NO.	REVISION	DATE	DR.	CK.
FINISH				
	PLAIN			
	BURR BENCH			
	BLACKOXIDE			
	HEAT TREAT			
	SAND BLAST			
	BUFF			
	PAINT TAN			
	CHROMATE			
	THINSEAL			
	OIL			

COUNTERSINKS:  .02	
DECIMAL TOLERANCE	
.X	= ± .010
.XX	= ± .005
.XXX	= ± .002
.XXXX	= ± .0005
FRACTIONS	= ± 1/64



211-97



## Notes

## Notes

## Notes



**Innovative Technology  
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World Wide**

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