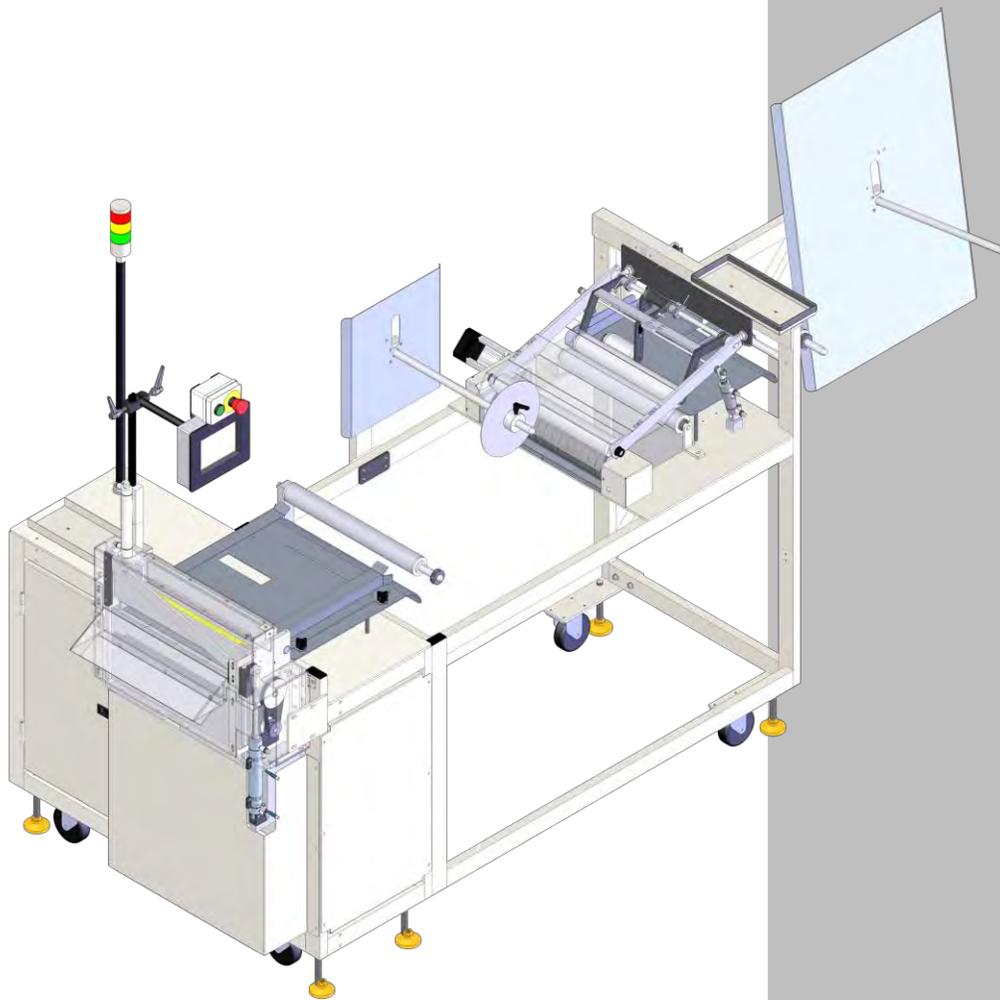




Model **3200PB1**

Revision 1.5 Updated Nov13, 2015

Technical Manual & Parts Lists



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IMPORTANT

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

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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 3200PB1 Mattress Border 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.

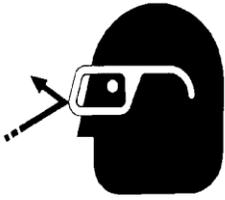
Signs on the Machine

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.

General Machine Data

Electrical / Pneumatic Setup

Electrical: 220 VAC, 15amp, 50/60 Hz Single Phase

Pneumatic: 80 PSI, 5 SCFM avg.
Set the low pressure switch to 60 PSI

Machine Setup

Position the machine in a desired location on a sound and reasonably level floor.

Make sure that there is sufficient lighting over the machine.

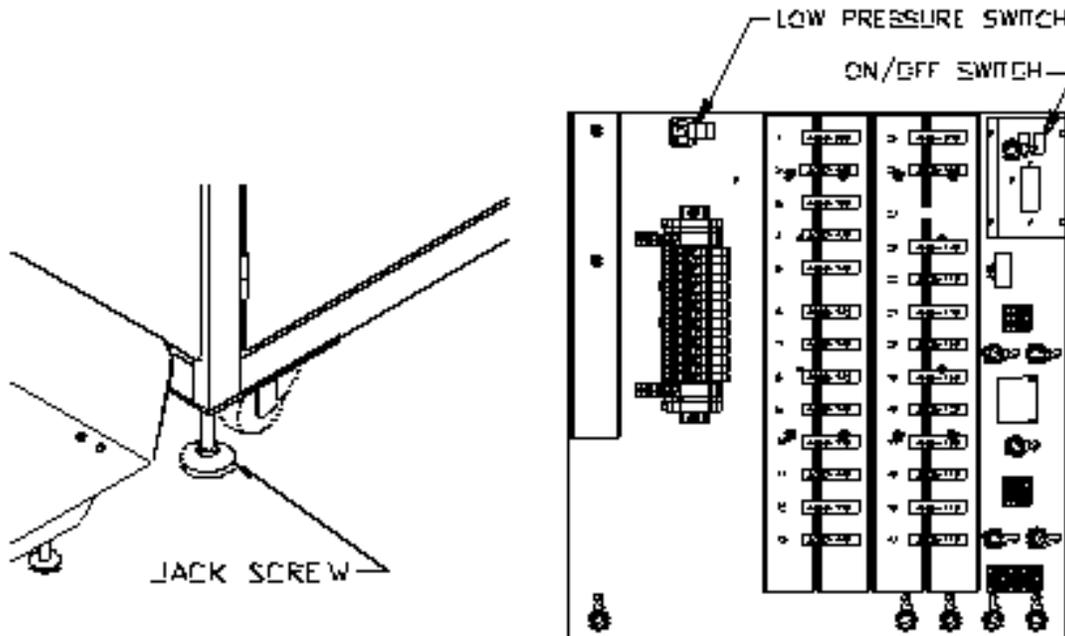
Remove all packing material.

Adjust the jack screws so that the casters are about 1/8" off the floor.

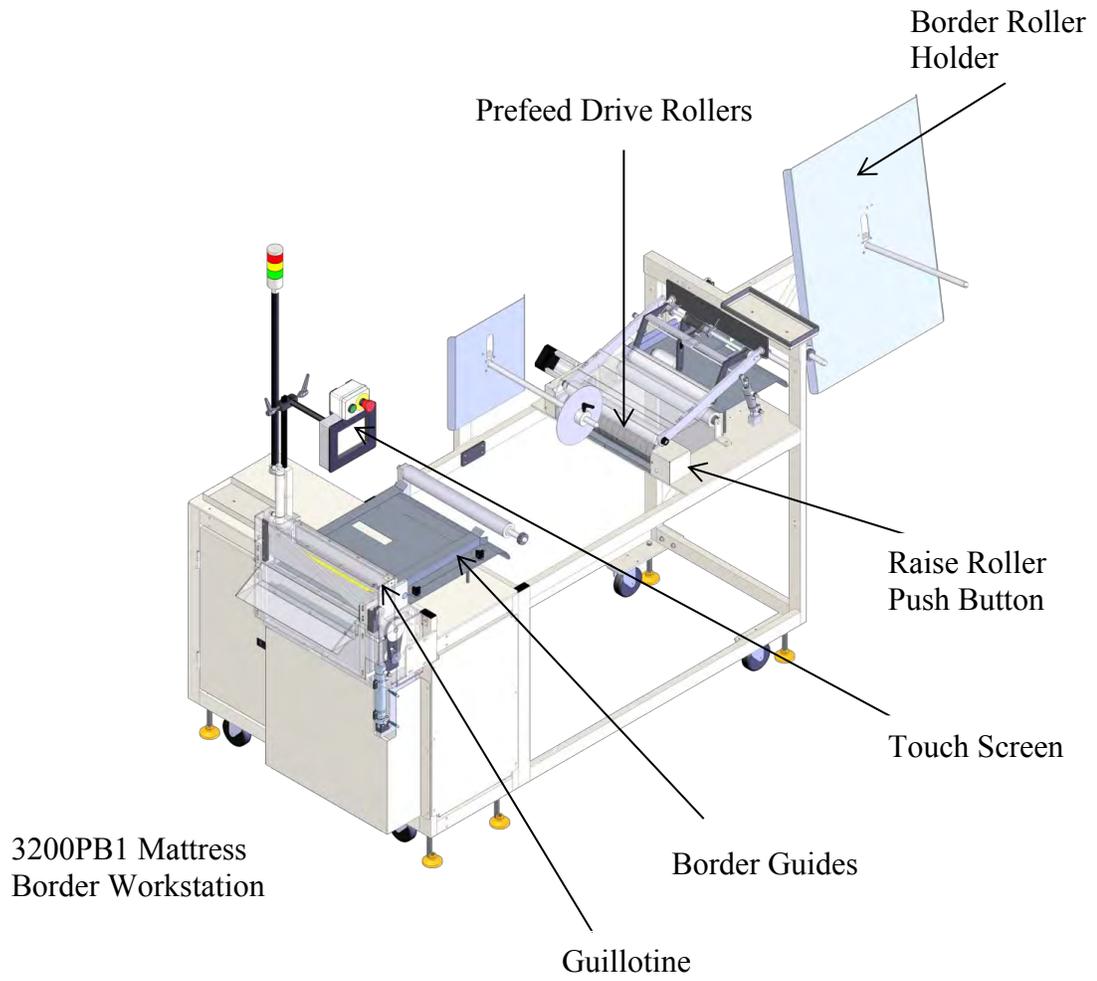
Connect electrical power and compressed air as specified above and in accordance to local codes.

Open the main control box door in front of the machine. Turn on the ON/OFF circuit breaker located in the top right corner by pressing the green button. The green light inside the button should illuminate.

Turn the main air lock-out valve (red knob before the main pressure regulator) to the ON position.



Component Identification



Touch Screen Operation

The graphic images presented on the touch screen show “3-dimensional” buttons, which may be pressed to access other screens, change counters and timers, or actuate hardware. Areas lacking the “3 dimensional” border contain information only. Counters are identified with the “+” and “-” buttons in the corners. These counters may be adjusted by pressing the “+” and “-” boxes. Pressing Reset from any screen clears all machine functions and returns to the main Ready page. Normal operation of the machine is controlled from the main Ready menu. From here you can start the Auto Cycle. The main Ready menu allows anyone to access the necessary functions and adjustments needed for normal operation of the machine.



Light Tower Function

The purpose of the 3200PB1 light tower is to indicate the current status of the machine at some distance away from the machine. This makes it easy to see machine status at a glance. Definitions for the different light states currently available on the 3200 are included below.

Light Status	Definition
Green Steady	Normal, machine producing borders
Green Flashing	Machine producing borders but will stop soon for bobbin change.
Yellow Steady	Normal, machine powered but idling between borders.
Yellow Flashing	Machine stopped in middle of order and needs operator activity before continuing.
Red	Not currently utilized. Available for future use.

Calibrating Default Border Lengths

When installing the Model 3200PB1 border machine, it is necessary to first obtain new default border lengths for all mattress sizes. To obtain these lengths determine which border-making table will be used to check the borders coming off of the 3200PB1 machine. Using this table, a measurement of every border size needs to be made by wrapping a measuring tape around the arm and measuring to the cut mark for each border size.

After all of the default border lengths have been recorded, they must be stored in the controller of the 3200PB1 machine. To store the default border lengths in the 3200PB1 controller press Edit New Order and then Customize Style. Change the default border lengths to match the values measured on the border table. NOTE: length of borders is displayed in tenths of inches. For example: king size value of 3040 is equivalent to 304.0 inches

Machine Operation

Turn on the power and select the desired language (if other than English) and wait until the touch screen displays the Ready – New Order screen.

Initial Border Loading Procedure

Press the Open Rollers button, the Prefeed Roller and the Main Roller lift up.

Open the Material Guides wider than the expected border width to be loaded.

Load a roll of border material on the Border Roll Holder. If the leading edge of the border is not of good quality, or it is not square, cut off the bad part and square off the leading edge. This will make the border loading process much easier.

Feed the border between the 2" roller and the 3/4" rod, across the prefeed table, and between the prefeed drive rollers. Then feed over the upper rollers, through the guillotine and stop with the end of the border protruding slightly beyond the knife blades. Adjust the guides to fit the border size using the adhesive rulers provided. Hold the border in place and press the Close Rollers button. Be sure not to cover the Border Prefeed Slack Eye.

Note: If you get a message “Border Slack Warning” on the screen, walk over to prefeed part of the machine and press the Raise Roller push button mounted on the cover of the prefeed roller, pull the slack out, and press the button again to lower the prefeed roller. If the message “Border Slack Warning” comes up again with no slack present, most likely the slack eye is not adjusted properly to see the reflective tape on the side panel of the machine, or the eye is not working properly and needs to be checked.

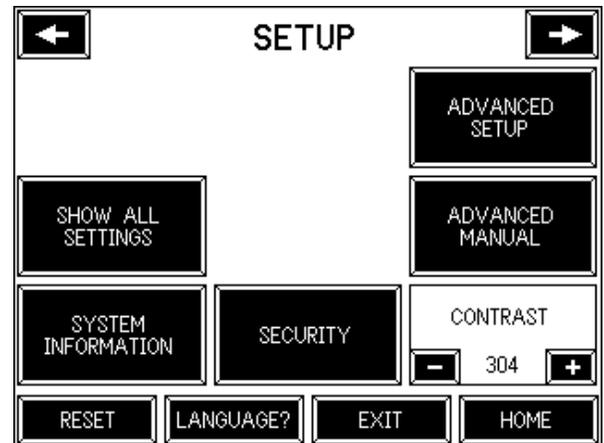
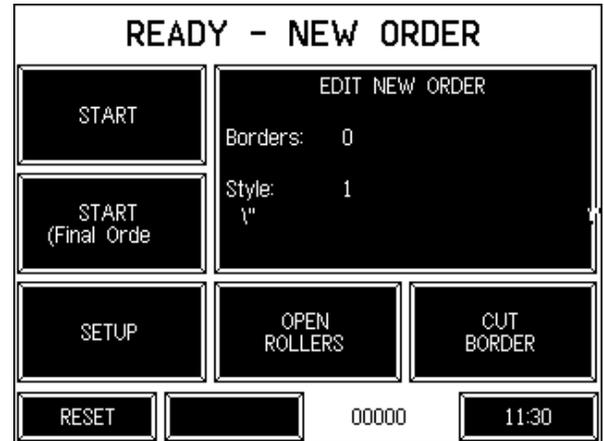
Setting Up the Machine to Make Borders

To setup the machine to make the desired borders go to the main **Ready – New Order** screen and press the large **Edit New Order** button.

The new screen **Edit Order** displays all available options: the style, quantity of borders, and the type of fill material in the border (foam or fiber) can be set here. Select the desired combination and press **Exit** button to get back to the main **Ready – New Order** screen. You are now ready to make borders.

There are two **Start** buttons on the **Ready - New Order** screen. The top **Start** button is used to start the auto cycle when the next order will use the same tick style. When the machine is started with this button, the last border of the current order will be completed without stopping for a tick change. When you are ready

to start the last order on the current tick style, start the machine with the lower **Start (Final Order)** button. When the last border of the order is about half way complete the machine will stop and display the message **Pause to Splice**. The prefeed rollers will back up slightly to create some slack material. **WARNING: DO NOT OPEN THE ROLLERS DURING THIS PROCEDURE.** Cut off the border material between the roll and the prefeed table. Load the new roll of border material onto the spindle. Pull the slack material back and attach the new roll of border material to it. Press **Continue** to restart the machine. The unfinished border will be completed and the machine will stop to allow you to enter the new order for the new tick. Adjust the guides to fit the new tick width. When the machine is started, the splice will be cut out automatically as the first border is made.

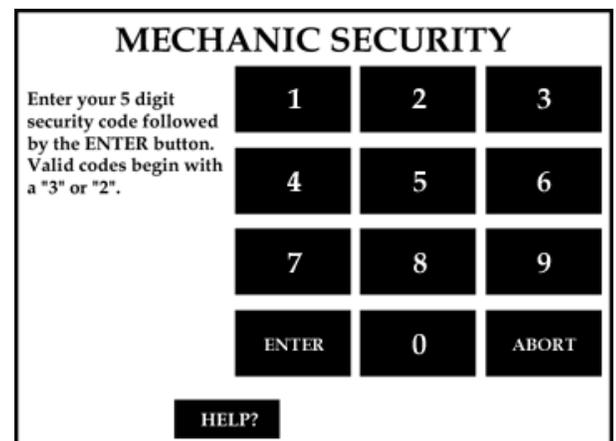


Setup Screen

Show All Settings: When this button is pressed, all of the values for the different settings are displayed in a table format.

System Information: Pressing this button allows users to view the machine version and serial number, the software revision and controller serial number, and the total piece count.

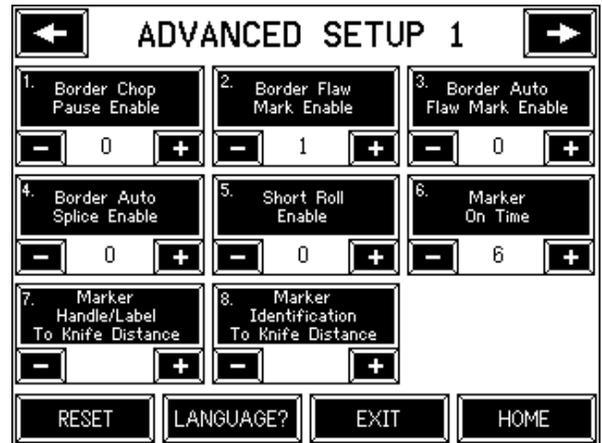
Security: Pressing this button allows the user to raise their security clearance with a 5 digit security code.



Advanced Setup: Pressing this button gives access to 2 screens of adjustments that can be made. When a button on one of the screens is pressed, it will give an explanation of what the adjustment is and allow the adjustment to be made.

Advanced Manual: Pressing this button gives access to 3 screens of adjustments that will allow the user to manually activate individual functions of the unit.

Contrast: Pressing the “+” and “-” will raise and lower the contrast of the screen for better visibility.



Border Splicing Method

When the machine runs out of border material, it stops and automatically back feeds about 10 inches to make the border splicing easier. The screen displays an “Out of Border Material” message. Load the next border roll on the pin, and staple its leading edge to the trailing edge of the border currently in the machine.

Also, to make the operation of the 3200PB1 machine more efficient, the border splicing on the Sewing Station must be performed correctly.

Machine Adjustments

The following adjustments will have already been made before the unit is shipped from the factory.

Adjust the spring screw on the guillotine to make sure the blade cuts the material.

Adjust the roller down cylinder so that the rollers touch with little or no pressure.

Adjust the cylinders on the prefeed rollers the same.

Adjust the counter balance springs on the prefeed seam detector rollers to counter balance 70% of the weight.

Step motor speed

Prefeed		Feed	
Slow	135 RPM	Slow	28 RPM
Fast	163 RPM	Fast	151 RPM

Motor Parameter Settings (3300A-PrePAR)

Before Programming, Perform a Master Reset of Parameters (See Below)

PARAMETER	RANGE	VALUE	DESCRIPTION
290		0	Mode of operation. MUST SET THIS PARAMETER FIRST!
026		0	
111	0-999	0900	Maximum speed when "129" is 0, 1, or 2.
119	1-3	1	Linear acceleration
153	0-50	0	Braking power at standstill
161	0-1	1-CCW	Motor rotation
207	1-55	1	Braking
220	1-55	1	Acceleration
240	0-56	55	Enable reverse run of motor with input 1
270	0-5	5	No handwheel sensor
272	020-255	1000	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.
436		0	
401		1	

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: Off

Programming Instructions:

1. Power on holding down the "P" button till "CODE" is displayed.
2. Press ">>" once and enter the number "5913"
3. Press "E" once and "4.0.0." 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 "CODE" is displayed.
2. Press ">>" once and enter the number "5913"
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.

Speed	RPM	Treadle/Low
Fast	163	C
Slow	135	A, C

Motor Parameter Settings (3300A FeedPAR)

Before Programming, Perform a Master Reset of Parameters (See Below)

PARAMETER	RANGE	VALUE	DESCRIPTION
290		0	Mode of operation. MUST SET THIS PARAMETER FIRST!
110	70-390	70	Positioning speed = 700 rpm
111	0-999	120	Maximum speed = 1200 rpm.
119	1-3	1	Linear acceleration
153	0-50	35	Braking power at standstill
161	0-1	1-CCW	Motor rotation
207	1-55	35	Braking
220	1-55	1	Acceleration
240	0-56	55	Enable reverse run of motor with input 1
270	0-5	5	No handwheel sensor
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.
436		0	Use code "5913". This disables an input that was causing box to reset itself.
401	0-1	1	Immediate save all parameters before turning off power

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: Off

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.

Speed	RPM	Treadle/Low
Fast	151	C
Slow	28	B&C

Machine Maintenance

Regularly scheduled maintenance of the 3200PB1 unit reduces possible problems and downtime. Proper care will also ensure a longer life and better performance of the machine.

Perform the following procedures to properly maintain the machine.

1. Clean the machine daily at the end of every shift.
 - A. Wipe all photo eye lenses with a clean, nonabrasive, dry cloth.
 - B. Use blow-off hose to get rid of excess lint, thread and other clippings.
2. Check air filters weekly; replace filter elements once every six months.
3. Lubricate the bearing block on the guillotine knife once every three months using standard sewing head oil. The oiling hole is located on the top face of the bearing block, and it is indicated by a red paint mark.
4. Apply Accrolube™ grease to the recessed cavity on the back side of the top blade side plate of the guillotine knife. This will improve performance and extend the life of the blade.

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.

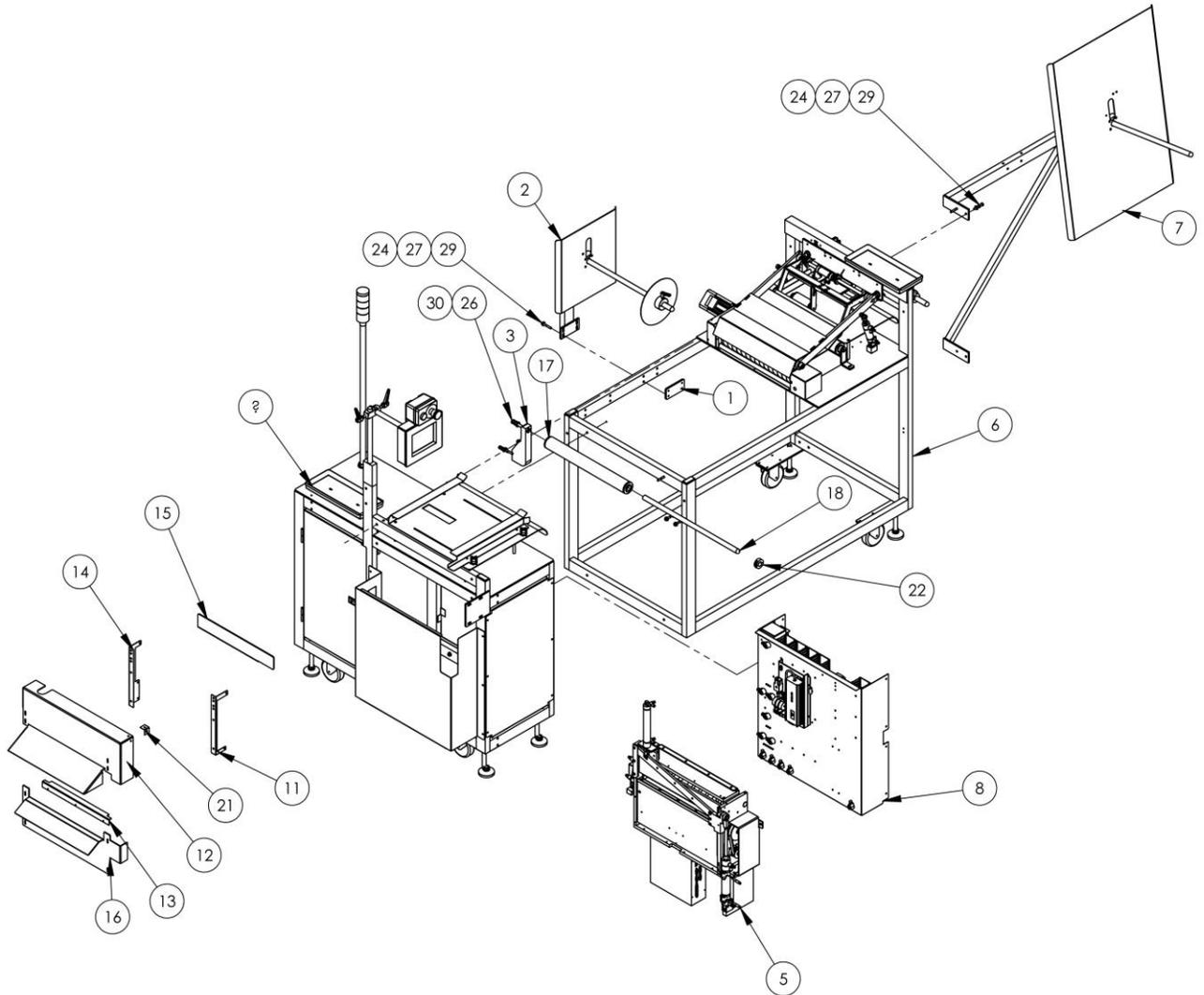
If tape is dirty or opaque, the eye may not function correctly.

Assembly Drawings & Parts Lists

The materials contained herein are confidential and proprietary information of Atlanta Attachment Company. In addition to any confidentiality and non-disclosure obligations that currently exist between you and Atlanta Attachment Company, your use of these materials serves as an acknowledgment of the confidential and proprietary nature of these materials and your duty not to make any unauthorized use or disclosure of these materials.



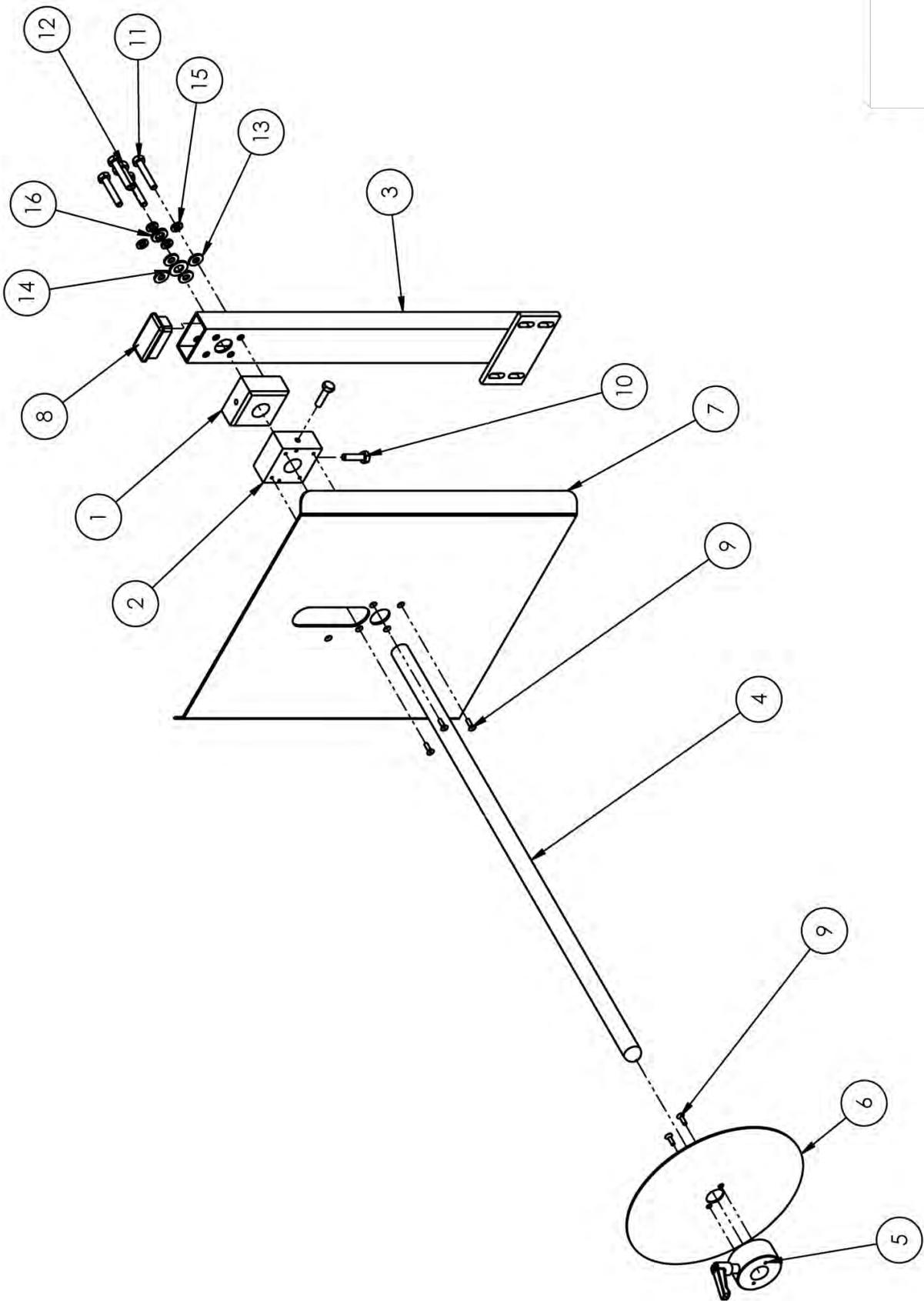
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33200PB1 Border Workstation, Measure & Cut

AAC Drawing Number 9000562 Rev2

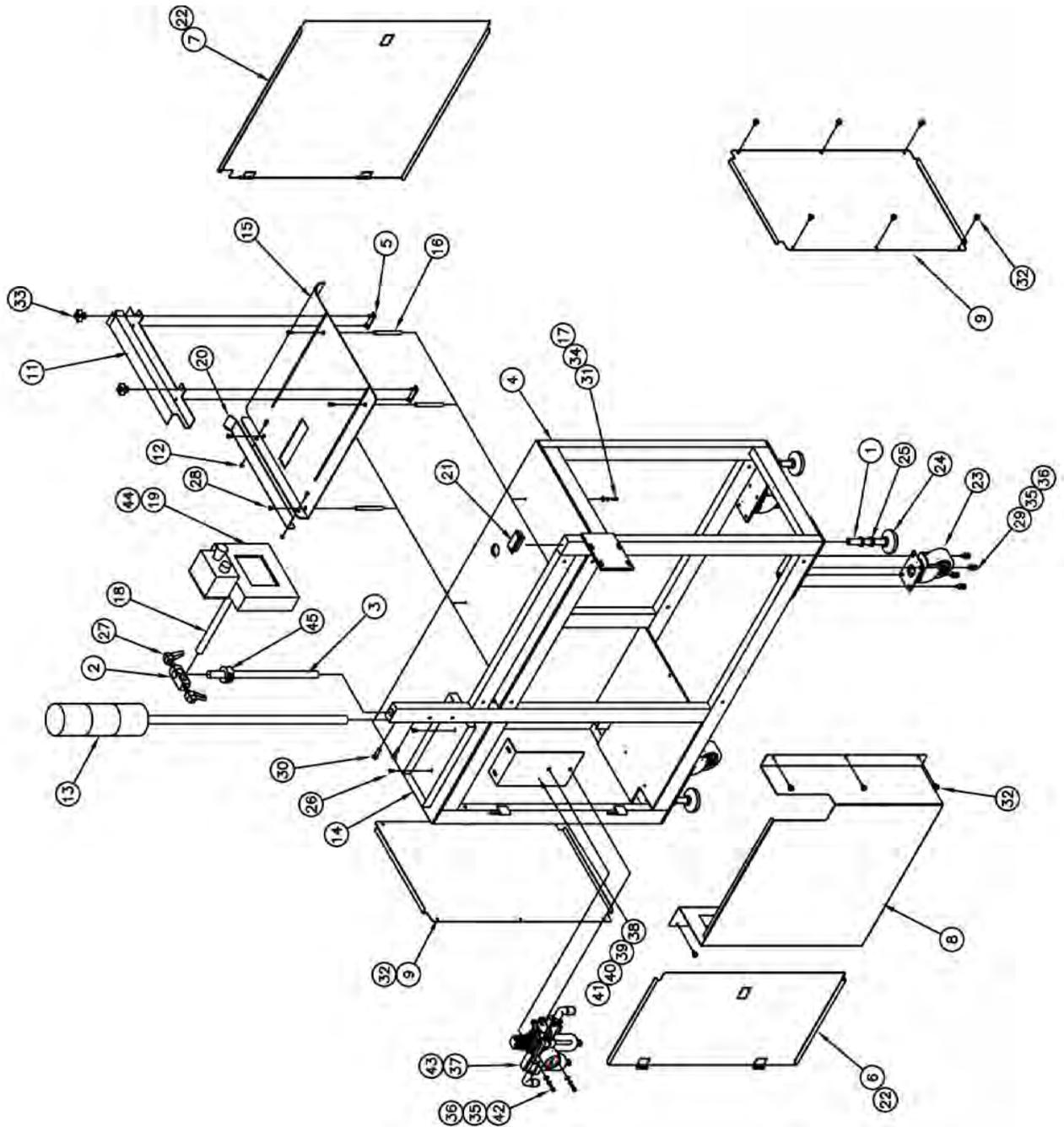
NO	QT	PART #	DESCRIPTION
1	1	1961-182	PLATE,NUT,1/4-20,4 PL
2	1	3200085	SMALL ROLL HOLDER ASSY
3	1	3200093	MOUNT,IDLER ROLL
4	1	32003000PA1	MAIN FRAME ASSEMBLY
5	1	32004000PB1	GUILLOTINE ASSEMBLY
6	1	32005000PA	PREFEED ROLLER ASSY.
7	1	32007700P	ROLL HOLDER ASSY
8	1	32009000PB1	CONTROL PANEL
9	*AR	3200PB1-PD	PNEUMATIC DIAGRAM
10	*AR	3200PB1-WD1	DIAGRAM, WIRING
11	1	33004033A	BRKT,GUARD,RIGHT SIDE
12	1	33004034B	GUARD, TOP HALF, 3300RA
13	1	33004035	GUARD, BOTTOM
14	1	33004037	BRKT,GUARD,LEFT SIDE
15	1	33004048B	SHIELD, TOP, GUILLOTINE
16	1	33004055A	COVER, BOTTOM GUILLOTINE
17	1	33005689C	ROLLER, 17.25L, 2 OD, .75 ID
18	1	33008202	ROD, ROLL, SST, 3/4X21 W/RAD
19	*AR	3300A-FEEDPAR	PARAMETER SETTINGS
20	*AR	3300A-PREFPAR	PARAMETER SETTINGS
21	1	98-6819A	BRKT,CORNER 2 x 10-32
22	1	CCCL12F	COLLAR, CLAMP, 3/4 BORE
23	8	NNH1/4-20	NUT, HEX, 1/4-20
24	10	SSHCO1112	HEX HEAD BOLT 1/4-20X1.75
25	4	SSHCO1160	1/4-20 X 2-1/2 HHCS
26	1	SSHCO25128	3/8-16 X 2 HEX CAP
27	22	WWFS1/4	WASHER, FLAT, SAE, 1/4
28	1	WWFS3/8	WASHER, FLAT, SAE, 3/8
29	14	WWL1/4	WASHER, LOCK, 1/4
30	1	WWL3/8	WASHER, LOCK, 3/8



3200085 Small Roll sewing Rod Assembly

AAC Drawing Number 3200085 Rev0

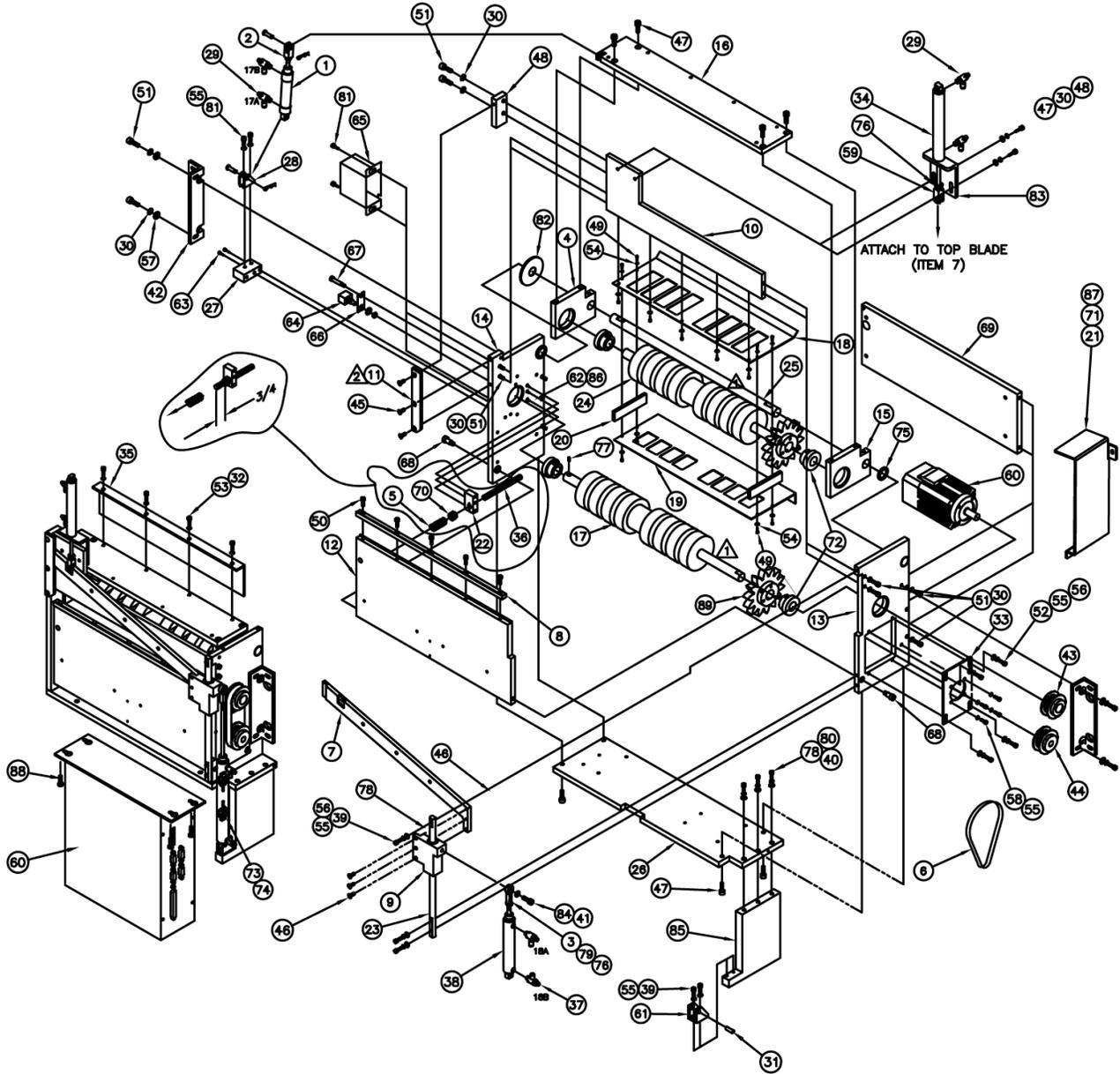
NO.	QTY	PART #	DESCRIPTION
1	1	1961-251A	HUB, UNWIND SHAFT
2	1	1961-253A	HUB, UNWIND STAND
3	1	3200092	WELDMENT,MID ROD MOUNT
4	1	32005004	ROD,SS,3/4 X 24.0L
5	1	360-116	HUB, LOCKING
6	1	784-08-050	DISC,BB,SP,8" DIA
7	1	784B-1414	PLATE, ALU, 14' X 14"
8	1	MM132-1496	PLUG 1 X 2
9	6	SSFC80032	#6-32 X 1/2 FLAT ALLEN
10	2	SSHCO1064	1/4-20 X 1 HEX HEAD
11	4	SSHCO1096	1/4-20 X 1-1/2 HEX HEAD
12	1	SSHCO25064	3/8-16 X 1 HEX HEAD
13	4	WWFS1/4	WASHER FLAT, 1/4
14	1	WWFS3/8	WASHER, FLAT, 3/8
15	4	WWL1/4	1/4 LW
16	1	WWL3/8	3/8 LW



32003000PA1 Main Frame Assembly

AAC Drawing Number 192131A Rev3

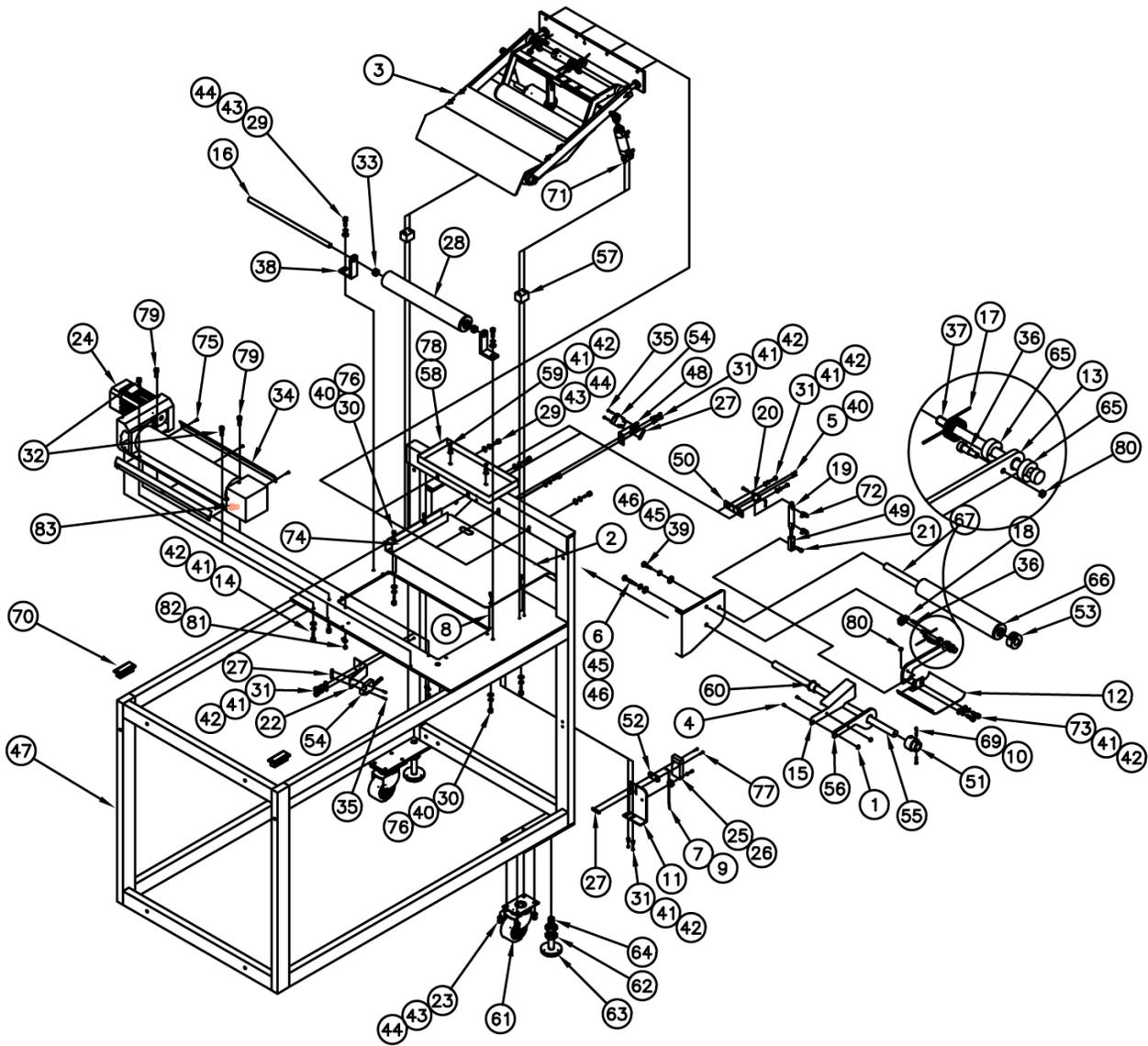
NO	QTY	PART #	DESCRIPTION
1	4	1411-1063	THREADED ROD
2	1	28201	CROSS BLOCK
3	1	28203	STRAIGHT ROD
4	1	32003500P	FRAME ASSY
5	2	32004035A	NUT PLATE
6	1	32005011	FRONT DOOR
7	1	35005012	REAR DOOR
8	1	3200180	PANEL
9	2	32005015	PANEL
10	1	32005027	PANEL
11	1	32005526	PANEL
12	1	NNK8-32	KEP NUT
13	1	33001130	LIGHT TOWER
14	1	33005534	TOOL TRAY
15	1	33005605A	CLOTH PLATE
16	4	33005623	STANDOFF
17	4	WWL8	LOCK WASHER
18	1	40-112A	SCREEN MOUNT
19	1	4080-004	TOUCH SCREEN
20	1	3200090	GUIDE
21	1	MM132-1496	END CAP, RECT, BLACK
22	2	M40450010	SLIDE LOCK
23	4	MM431-4	CASTER
24	4	MML-2	LEVELING PAD
25	8	NNSH5/8-11	SQUARE NUT
26	2	SSBC98024	SCREW, BUTTON CAP 10-32 X 3/8
27	2	TTH32426	THREADED HANDLE
28	6	SSFC90024	SCREW, FLAT ALLEN 8-32 X 3/8
29	16	SSHCO1040	SCREW, HEX CAP 1/4-20 X5/8
30	2	SSHCO1064	SCREW, HEX CAP 1/4-20 X 1
31	4	SSSC90032	SCREW, SOCKET CAP 8-32 X 1/2
32	18	SSZS93032	SCREW, SHEET METAL 10-16 X 1/2, SELF DRILL
33	2	TTCL1APPK1	KNOB
34	4	WWF8	FLAT WASHER
35	18	WWFS1/4	FLAT WASHER
36	18	WWL1/4	LOCK WASHER
37	1	AA198-5110	REGULATOR
38	1	32003033	MOUNT BRKT
39	2	SSSC98024	SCREW, SOCKET CAP 10-32 X 3/8
40	2	WWL10	LOCK WASHER
41	2	WWFS10	FLAT WASHER
42	2	SSSC01048	SCREW, SOCKET CAP 1/4-20 X 3/4
43	2	AAQME-3-4	MALE ELBOW
44	1	1278-6010	START/STOP SWITCH
45	1	CCCL12F	COLLAR, CLAMP, 3/4, BORE



32004000PB1 Guillotine Assembly

AAC Drawing Number 192138A Rev2

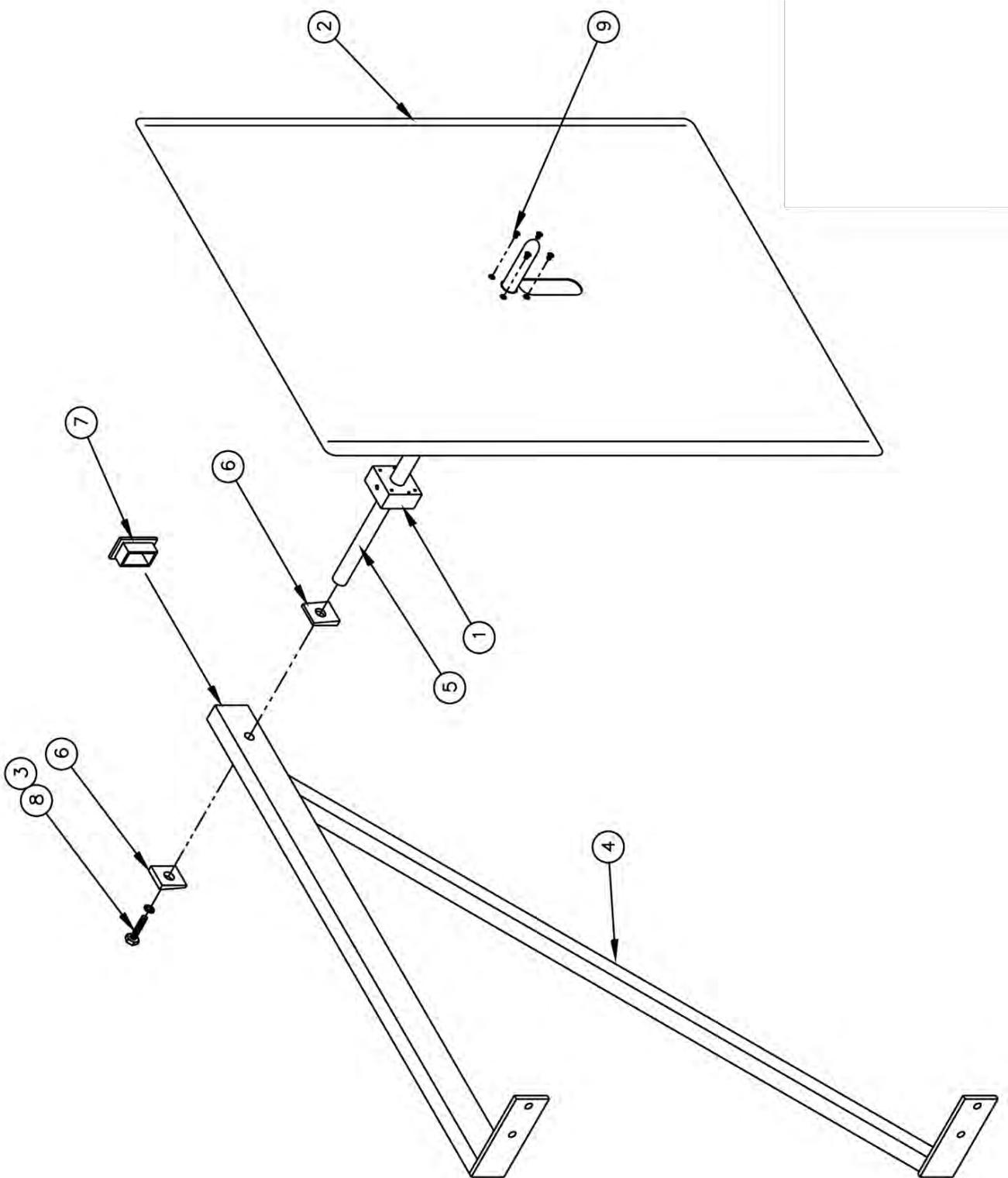
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	AAC7DP-1	AIR CYLINDER	46	3	SSFC98040	SCREW, FLAT ALLEN CAP 10-32 X5/8
2	1	AAFCT-7	CLEVIS, AIR CYL.	47	10	SSSC01048	SCREW, SOCKET CAP 1/4-20 X 3/4
3	1	BBAW-7	BEARING, ROD END	48	1	3200129	BLOCK, PLATE RUB MNTG
4	1	33004014	ARM, TOP RIGHT	49	13	SSBC70016	SCREW BOTTON CAP 4-40 X 1/4
5	1	PRLC092H6	SPRING	50	5	SSSC98040	SCREW, SOCKET CAP 10-32 X 5/8
6	1	GG150L050	BELT, GEAR	51	14	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1
7	1	3200133	BLADE, TOP	52	4	SSSC95048	SCREW, SOCKET CAP 10-24 X 3/4
8	1	3200356	BLADE, BOTTOM	53	4	SSSC98032	SCREW, SOCKET CAP 10-32 X 1/2
9	1	3200082	BLOCK, GUIDE, TOP BLADE	54	13	WWS14	INTERNAL TOOTH WASHER
10	1	3200350	BAR, TIE	55	15	WWL10	LOCK WASHER
11	1	3200130	PLATE, RUB	56	7	WWFS10	SAE FLAT WASHER
12	1	3200349	PLATE, HINGE1	57	6	WWFS1/4	SAE FLAT WASHER
13	1	3200121	PLATE, FRONT SIDE	58	4	SSSCM5X147	SCREW, SOCKET CAP M5-0.8 X 14
14	1	33004008	PLATE, REAR SIDE	59	1	AAFCT-11	CLEVIS, AIR CYLINDER
15	1	33004009	ARM, TOP LEFT	60	1	4059-DC1500A	MOTOR & CONTROLLER
16	1	33004010	PLATE, BACK	61	1	3200083	PIVOT BRKT
17	1	33004020	ROLLER, DRIVE, BOTTOM	62	1	SSSC98080	SCREW, SOCKET CAP 10-32 X 1 1/4
18	1	3200351	GUARD, TOP ROLLER	63	2	SSSC95096	SCREW, SOCKET CAP 10-24 X 1 1/2
19	1	3200352	GUARD, BOTTOM ROLLER	64	1	EENC256	ENCODER
20	2	33004015	GUIDE, MATERIAL, INTERNAL	65	1	33004061	ENCODER COVER
21	1	3200178	COVER	66	1	33004080	BRKT, ENCODER SUPPORT
22	1	33004017	BLOCK, SPRING	67	1	SSASO16064	SCREW ALLEN SHOULDER 1/4 X 1, 10-24
23	1	3200124	SHAFT, TOP BLADE	68	2	SSASO24040	SCREW ALLEN SHOULDER 3/8 X 5/8, 5/16-18
24	1	33004011	ROLLER, IDLER, TOP	69	1	33004062	PLATE, MAIN MTG.
25	1	33004021	SHAFT, HINGE	70	2	NNJ3/8-24	NUT, JAM, 3/8-24
26	1	3200127	PLATE, BASE, GUILLOTINE	71	2	WWF8	WASHER #8
27	1	32004063	MOUNT, CYLINDER, REAR	72	4	BBS8703-88	BALL BEARING
28	1	AAFBP-11C	PIVOT BRKT	73	2	AAEHSKQ	SWITCH, HALL EFFECT
29	4	AA198RA508	FLOW CONTROL	74	2	AAF35875-11	BAND FOR AAHSKQ
30	16	WWL1/4	LOCK WASHER	75	1	33004063	SPACER
31	1	IID016X064	DOWEL PIN	76	1	273-4-503A	LEATHER WASHER
32	4	WWSI10	INTERNAL TOOTH WASHER	77	1	SSSS98012B	SCREW, SOCKET SET, BRASS TIP 10-32 X 3/16
33	1	3304027A	PLATE, MTG, STEP, MTR	78	3	SSSC10080	SCREW, SOCKET CAP 5/16-18 X 1 1/4
34	1	AA095DP	AIR CYLINDER	79	1	NNJ7/16-20	NUT, JAM 7/16-20
35	1	33004050	GUARD, TOP, GUILLOTINE	80	3	WWFS5/16	5/16 FLAT WASHER
36	1	3304031	SCREW, BLADE PRESSURE ADJ.	81	2	SSSC95032	SCREW, SOCKET CAP 10-24 X 1/2
37	2	AA198RA408	FLOW CONTROL	82	1	BBTRA1220	WASHER, THRUST, STEEL
38	1	AACM125DP	AIR CYLINDER	83	1	3200102	CYLINDER MNT
39	5	SSSC95064	SCREW, SOCKET CAP 10-24 X 1	84	1	SSSC40080	SCREW, SOCKET CAP 7/16-20 X 1 1/4
40	3	WWL5/16	5/16 LOCK WASHER	85	1	3200128	MOUNT, PIVOT BRKT
41	1	WWL7/16	7/16 LOCK WASHER	86	2	SSSC98064	SCREW, SOCKET CAP 10-32 X 1
42	2	33004058A	BRACKET	87	2	SSPS90024	SCREW, PAN HD SLOTTED 8-32 X 3/8
43	1	PP24LB050M3	GEAR PULLEY	88	4	SSPS98032	SCREW, PAN HD SLOTTED 10-32 X 1/2
44	1	PP10LF050M3	GEAR PULLEY	89	2	3200343	CYCLOID GEAR, 14TH
45	3	SSFC95032	SCREW, FLAT ALLEN CAP 10-24 X 1/2				



32005000PA Prefeed Roller Assembly

AAC Drawing Number 192086A Rev6

NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	2	NNK6-32	NUT, KEP, 6-32, W/L/W	41	14	WWL10	LOCK WASHER
2	1	33005605	PLATE, CLOTH	42	14	WWFS10	SAE FLAT WASHER
3	1	33005600	PREFEED ROLLER ASSY.	43	14	WWL1/4	LOCK WASHER
4	2	SSBC80032	SCREW, BUTTON CAP 6-32 X 1/2	44	14	WWFS1/4	SAE LOCK WASHER
5	2	SSSC90024	SCREW SOCKET CAP 8-32 X 3/8	45	2	WWL3/8	WASHER, LOCK
6	1	SSHC25192	SCREW HEX CAP 3/8-16 X 3.0	46	2	WWF3/8	WASHER, FLAT
7	1	1278-7154A	CLAMP TUBE	47	1	32005500P	FRAME ASSY
8	4	33005623	STAND OFF	48	1	33005664	BRKT, EYE
9	1	40-609B	UNCURLING TUBE	49	1	33005686	CLEVIS, SKI LIFT
10	2	NNE 10-32	ELASTIC NUT	50	1	33005687	MTG. PLATE
11	1	33005639	BRKT, MARK EYE	51	1	33005656	SLEEVE, CLOTH GUARD
12	1	33005661	SKID PLATE ASSY.	52	1	WW25DW	WASHER PLATE
13	1	33005662	ARM, SKID PLATE	53	1	CCCL12F	CLAMP COLLAR
14	2	SSSC98048	SCREW, SOCKET CAP 10-32 X 3/4	54	2	FFSM312LVQ	ELECTRIC EYE
15	1	33005699	GUIDE, RH	56	1	33005657A	EDGE GUIDE ARM
16	1	33005690	ROD, 1/2 X 17.5L	57	2	33005670	SPACER
17	1	RRLT085N4R	SPRING, TORSION	58	1	33005534	TOOL TRAY
18	1	33005667	CLAMP, SPRING	59	2	SSBC98024	SCREW, BUTTON CAP 10-32 X 3/8
19	1	AAC8DP-1	AIR CYLINDER	60	1	33005679	BUSHING, EDGE GUIDE
20	1	AAFBP-8C	BRKT, PIVOT	61	2	MM431-4	CASTER
21	1	SSAS016040	SCREW, ALLEN SHOULDER 1/4 X 5/8, 10-24	62	4	NNSH5/8-11	5/8-11 NUT
22	1	98202010	EYE BRKT	63	2	MML-2	LEVELING PAD
23	8	SSHC01048	SCREW, HEX CAP 1/4-20 X 3/4	64	2	0411-1063	ROD. HEM FOOT
24	1	33005650A	BOTTOM PULLER ROLLER ASSY.	65	2	CCCL6F	COLLAR, CLAMP 3/8
25	1	V8	LENS	66	1	33005689C	ROLLER
26	1	FFSE3WLC	SMART EYE	67	2	33008202	ROD, 3/4 X 21
27	3	1975-412A	NUT PLATE	69	2	SMSSBNK-2	PLUNGER, BALL
28	1	33005689	ROLLER	70	2	MM132-1496	RECT. END CAP
29	6	SSSC01048	SCREW, SOCKET CAP 1/4-20 X 3/4	71	4	SSSC98096	SCREW, SOCKET CAP 10-32 X 1-1/2
30	6	SSSC90032	SCREW, SOCKET CAP 8-32 X 1/2	72	2	AA198RA510	FLOW CONTROL
31	8	SSSC98032	SCREW, SOCKET CAP 10-32 X 1/2	73	2	SSSC95032	SCREW, SOCKET CAP 10-24 X 1/2
32	2	SSSC98024	SCREW, SOCKET CAP 10-32 X 3/8	74	1	33005683	BORDER GUIDE
33	2	CCCL8F	CLAMP COLLAR	75	6	SSBC90024	SCREW, BOTTON CAP 8-32 X 3/8
34	2	33005673	BRKT GUARD	76	8	WWF8	FLAT WASHER
35	6	SSPS70048	SCREW, PAN HD SLOTTED 4-40 X 3/4	77	2	SSPS70064	SCREW, PAN HEAD 4-40 X 1
36	2	SSAS016032	SCREW, ALLE SHOULDER 1/4 X 1/2, 10-24	79	2	SSSC98040	SCREW, SOCKET CAP 10-32 X5/8
37	1	SSAS024256	SCREW, ALLEN SHOULDER 3/8X4, 5/16-19	80	2	NNH10-24	HEX NUT
38	2	33005688	BRACKET	81	2	AAF3/16	PLASTIC CLAMP
39	1	SSHC25064	SCREW, HEX HEAD 3/8-16 X 1	82	2	NNK10-32	KEP NUT
40	8	WWL8	LOCK WASHER	83	1	EE49111AS	SWITCH

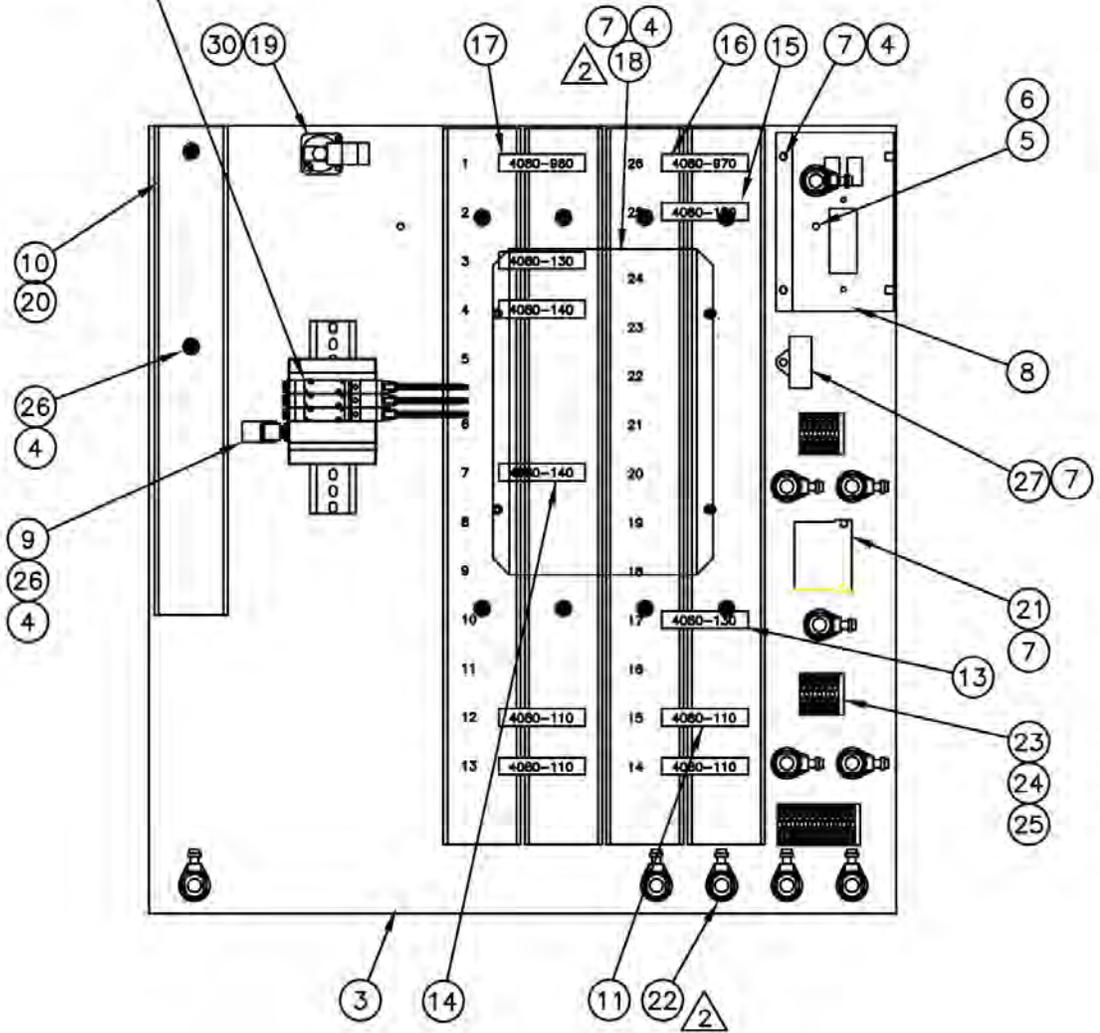


32007700P Roll Holder Assembly

AAC Drawing Number 192088A Rev1

NO.	QTY	PART #	DESCRIPTION
1	1	1961-253A	Unwind Hub
2	1	784B-2436	Alu Plate
3	1	WWL 3/8	Lock Washer
4	1	32007704	Roll Hold Frame
5	1	33008202	Rod, 3/4x21
6	2	WWSQ080B	Washer SQ. Struct
7	1	MM132-1496	End Cap
8	1	SSHC25160	Hex Cap Screw 3/8-16 x 2-1/2
9	4	SSFC80032	Allen Cap Screw Flat 6-32 x 1/2

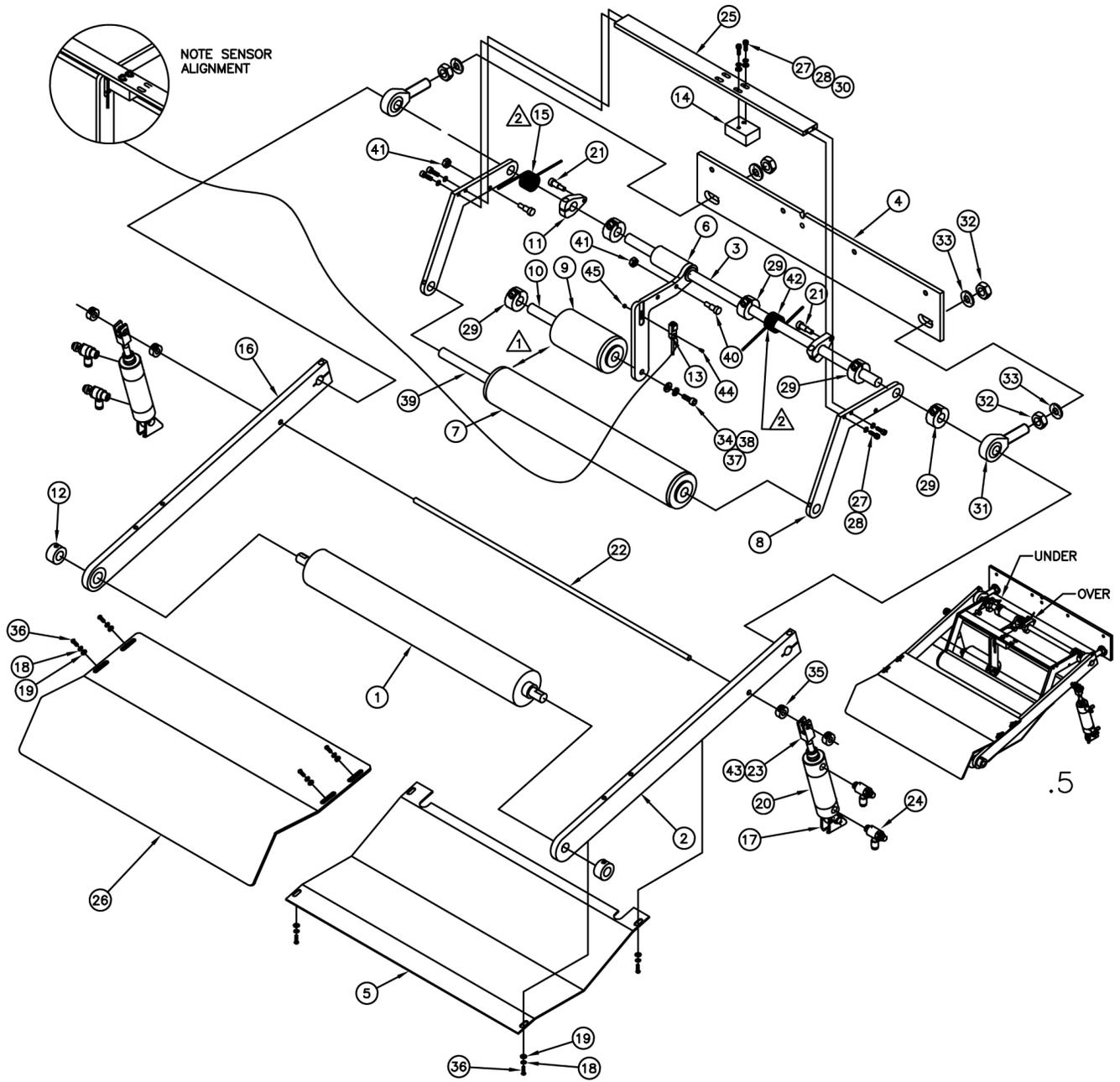
ADD VALVE FROM
MARKER KIT HERE
IF NECESSARY



32009000PB1 Control System

AAC Drawing Number 192132A Rev5

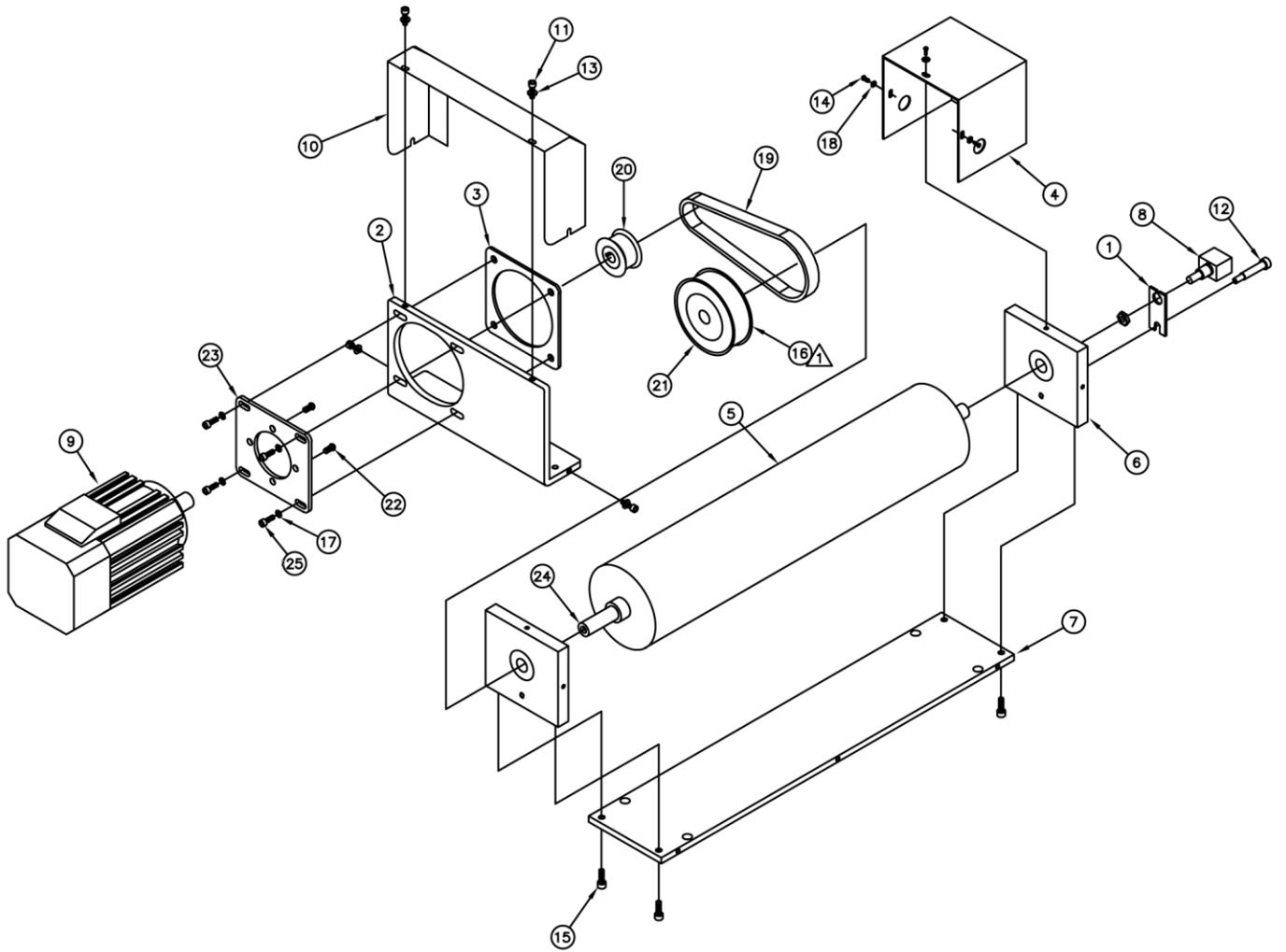
NO	QTY	PART #	DESCRIPTION
1	1	32009100PB1	CABLE PACKAGE
2	2	TTAA5267	TERMINAL
3	1	32009001A	PANEL, CONTROL
4	20	WWF8	FLAT WASHER, #8
5	1	NNK8-32	KEP NUT
6	1	TT5811	TERMINAL RING
7	11	SSSC90024	SCREW, SOCKET CAP 8-32 X3/8
8	1	40-320	AC POWER DISCONN. ASSY.
9	1	AAE3200-3	SOLENOID VALVE ASSY.
10	10'	EEDF2X2	DUCT, WIRE
11	4	4080-110	MODULE, QUAD INPUT
12	AR	SEE NOTE 3	WIRING DIAGRAM
13	2	4080-130	MODULO, DUAL OPTO-ISO
14	2	4080-140	MODULE, QUAD OUTPUT
15	1	4080-150	MODULE, PROGRAM
16	1	4080-970	MODULE, MEMORY
17	1	4080-980	MODULE, SBUS-CONT
18	1	4080-990R	BOX, POWER SUPPLY
19	1	AAVF51M1B	AIR/ELEC SWITCH
20	10'	EEDC2X2	DUCT, WIRING COVER
21	1	EECA491024	CONTACTOR, MINI
22	11	FF1724	STRAIN RELIEF
23	8	FF264-341	TERMBLK, WAGO, GRAY
24	4	FF264-347	TERMBLK, WAGO, GRN
25	32	FF2264-371	TERMBLK, WAGO, END
26	12	SSPS90024	SCREW, PAN HD SLOTTED 8-32 X 3/8
27	1	FFRAV781BW	MODULE, TVS
28	AR	12788-509A	JUMPER, RESISTOR
29	AR	3200PB1-PD	PNEUMATIC DIAGRAM
30	2	SSSC70024	SCREW, SOCKET CAP 4-40 X 3/8
31	AR	3200PLAB	LABEL



33005600 Prefeed Roller Assembly

AAC Drawing Number 192155C Rev7

NO	QTY	PART #	DESCRIPTION
1	1	33005652	PULLER, ROLLER
2	1	33005610	PULLER, LEFT ARM
3	1	33005611	ROD
4	1	33005617	BAR, PIVOT MTG
5	1	33005622	BRACE, PREFEED
6	1	33005675	ROLLER ARM ASSY
7	1	33005632	ROLLER
8	2	33005653	ARM, SEAM DETECT
9	1	33005671	ROLLER
10	1	33005672	ROD, ROLLER
11	2	33005678	CLAMP SPRING
12	2	33005676	SET COLLAR
13	1	1278-5075D	PROX SWITCH
14	1	33005669	TARGET BLOCK
15	1	RRLT085R4L	SPRING, TORSION LEFT
16	1	33005628	PULLER, RIGHT ARM
17	2	AAFBP-11C	BRKT, PIVOT
18	8	WWL10	LOCK WASHER
19	8	WWFS10	SAE FLAT WASHER
20	2	AAC6DP-1	AIR CYLINDER
21	3	SSASO16024	SCREW ALLEN SHOULDER 1/4 X 3/8, 10-24
22	1	33005677	ROD
23	2	AAFCT-11	CLEVIS
24	4	AA198RA508	FLOW CONTROL
25	1	33005654	BRACE, TARGET ADJ.
26	1	33005633	COVER
27	6	SSSC90040	SCREW, SOCKET CAP 8-32 X 5/8
28	6	WWL8	LOCK WASHER
29	5	CCCL8F	CLAMP COLLAR
30	2	WWF8	FLAT WASHER
31	2	1325-11	BEARING, ROD END
32	4	NNJ1/2-20	JAM NUT
33	4	WWF1/2	FLAT WASHER
34	1	SSSC01048	SCREW, SOCKET CAP 1/4-20 X 3/4
35	4	CCCL4F	COLLAR, CLAMP
36	8	SSHC95032	SCREW, HEX CAP 10-24 X 1/2
37	1	WWFS1/4	SAE FLAT WASHER
38	1	WWL14	LOCK WASHER
39	1	33005655	ROD
40	1	SSASO16040	SCREW, ALLEN SHOULDER 1/4 X 5/8, 10-24
41	2	NNH10-24	NUT, HEX 10-24
42	1	PRLT085N4R	SPRING, TORSION RIGHT
43	1	NNJ5/16-24	NUT, JAM, 5/16-24
44	1	SSPS50032	SCREW, PAN HD SLOTTED 2-56X1/2
45	1	NNH2-56	NUT, HEX,2-56

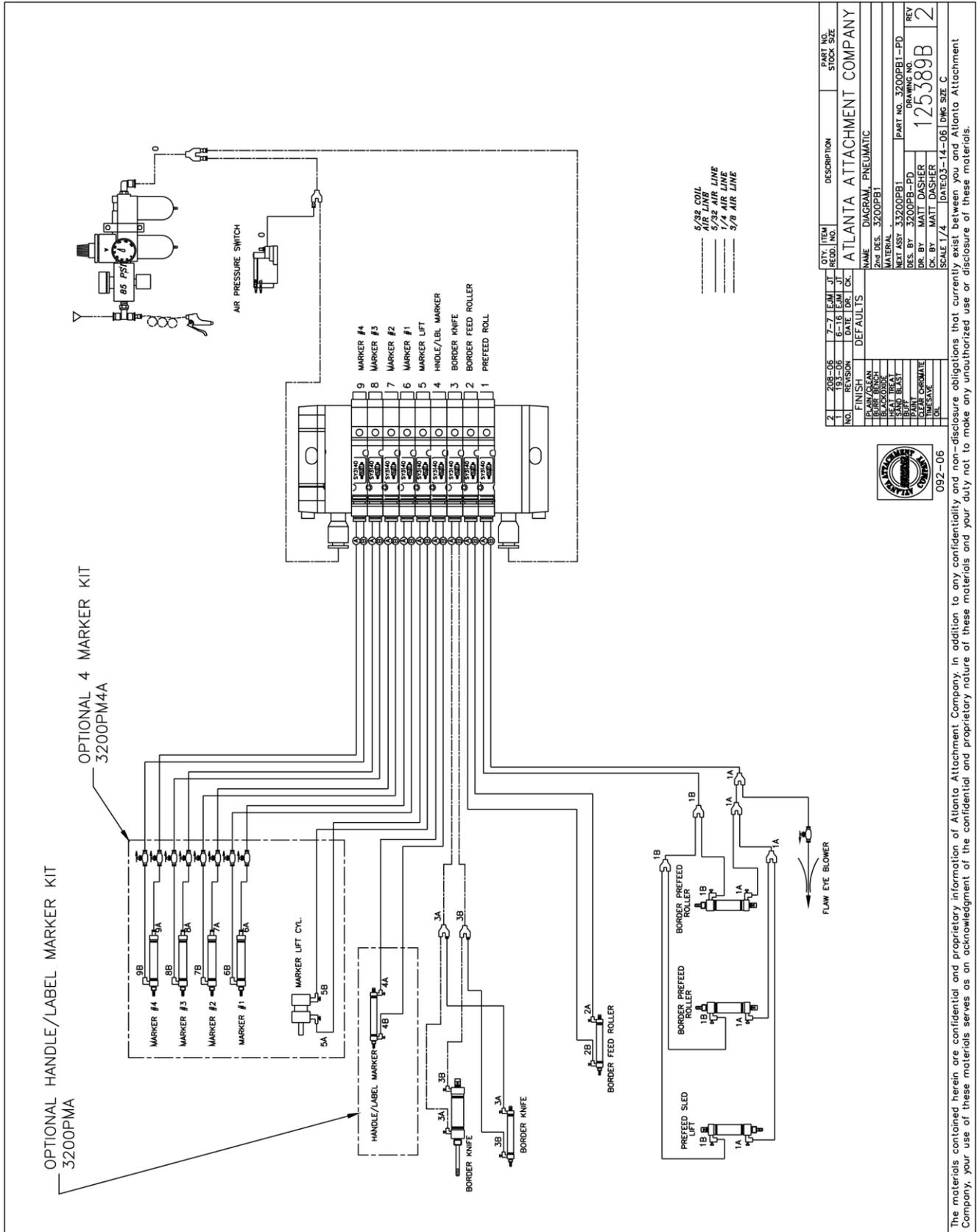


33005650A Bottom Puller Roller Assembly

AAC Drawing Number 192913B Rev3

NO	QTY	PART #	DESCRIPTION
1	1	33004080	BRKT, ENCODER SUPPORT
2	1	33005674	BRKT, MOTOR MOUNTING
3	1	0411-016	NUT PLATE
4	1	33005681	GUARD, ENCODER
5	1	33005603C	PULLER ROLLER
6	2	33005608	BLOCK BEARING
7	1	33005609	PATE, BEARING MTG
8	1	EENC256	ENCODER
9	1	4059-DC1500A	STEPPER MOTOR
10	1	33005692	BELT GUARD
11	4	SSSC70024	SCREW, SOCKET CAP 4-40 X 3/8
12	1	SSASO16064	SCREW, ALLEN SHOULDER 1/4 X 1, 10-24
13	4	WWF4	WASHER, FLAT
14	3	SSBC80024	SCREW BUTTON CAP 6-32 X 3/8
15	4	SSSC98032	SCREW, SOCKET CAP 10-32 X 1/2
16	2	SSSC01064	SCREW, SOCKET CAP 1/4-20 X 1
17	4	WWFS10	WASHER FLAT
18	3	WWFS6	SAE FLAT WASHER
19	1	GG142L050	BELT
20	1	PP10LF050M3	PULLEY, 10T
21	1	PP24LB050M1	PULLEY, 24T
22	4	SSSCM5X14	SCREW, SOCKET CAP M5-08 X 14
23	1	4059-3200	PLATE, CONVERSION
24	1	330056003C2	SHAFT, ROLLER
25	4	SSSC98040	SCREW, SOCKET CAP 10-32 X 5/8

3200PB1-PD Pneumatic Diagram



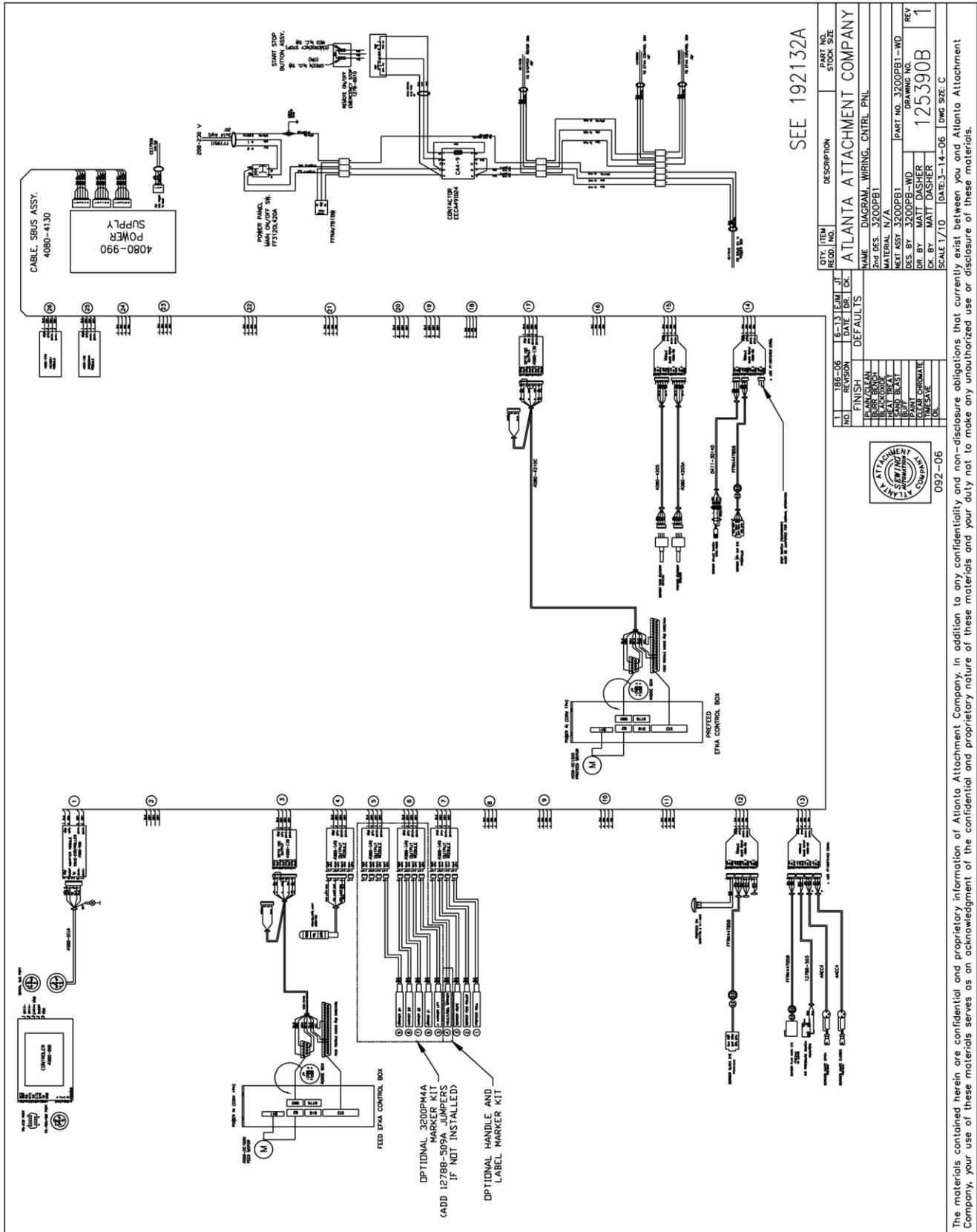
QTY.	ITEM	DESCRIPTION	UNIT	STOCK
7-7	TEAM JT			
6-16	EJM JT			
1	DATE DR. CK			
2	208-06	7-7 TEAM JT		
1	193-06	6-16 EJM JT		
1	REVISION	DATE DR. CK		
FINISH				
DEFAULTS				
NAME DIAGRAM, PNEUMATIC				
2nd DES. 3200PB1				
MATERIAL				
NEXT ASSY 3200PB1				
PART NO. 3200PB1-PD				
DRAWING NO.				
DES. BY MATT DASHER				
DR. BY MATT DASHER				
CK. BY MATT DASHER				
SCALE 1/4				
DATE 03-14-06				
DWG SIZE C				
REV 2				
125389B				



092-06

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3200PB1-WD Wiring Diagram



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Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

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

Términos y Condiciones:

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

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

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



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