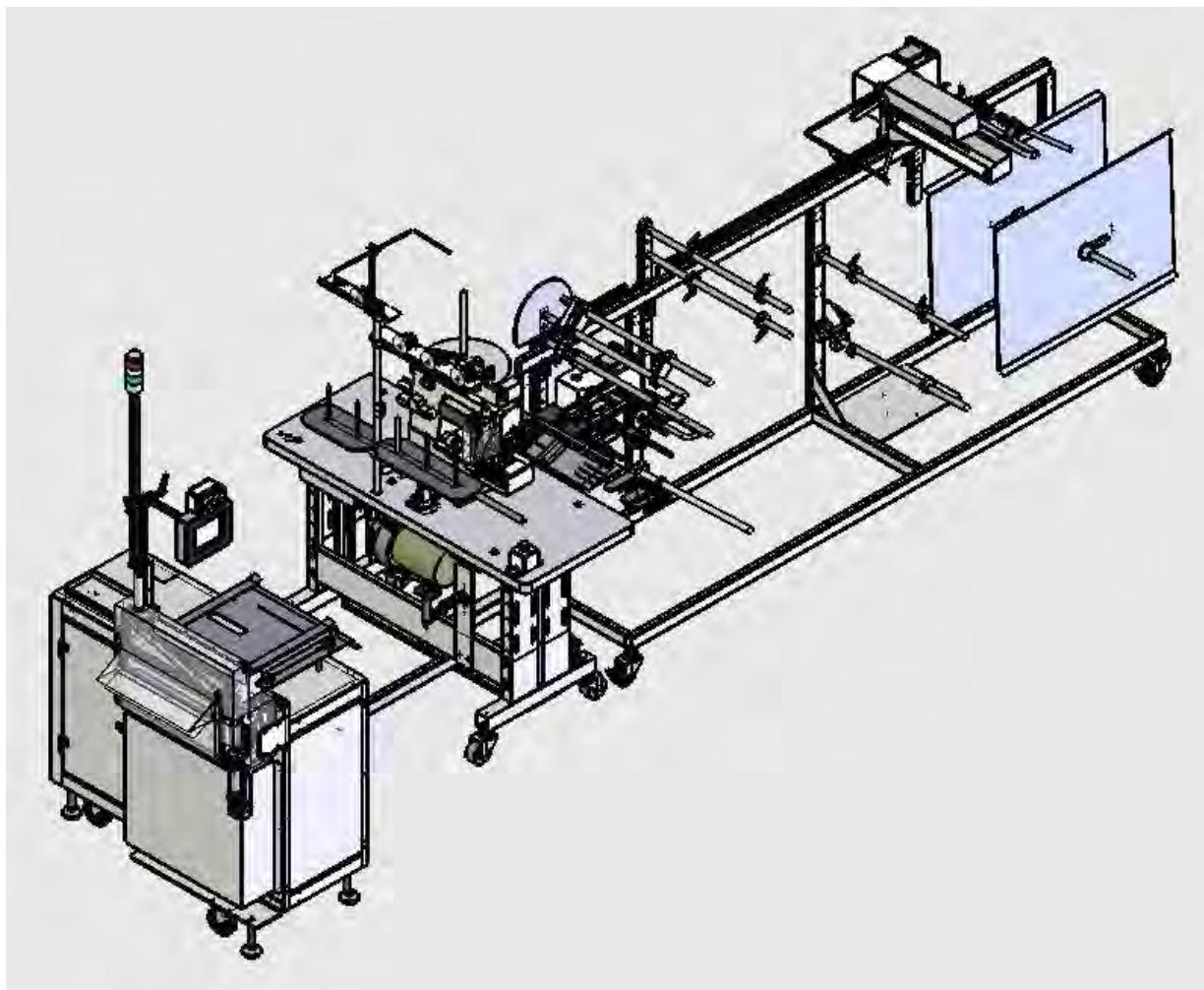




Model **332P30Z1**
ZIPPER SEW STATION

Revision 1 Updated Nov. 17, 2015

Technical Manual & Parts Lists



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ATLANTA ATTACHMENT COMPANY, INC.

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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 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.

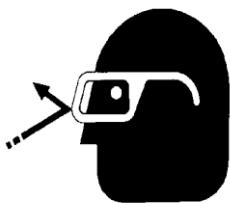
Signs on the Machine

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 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

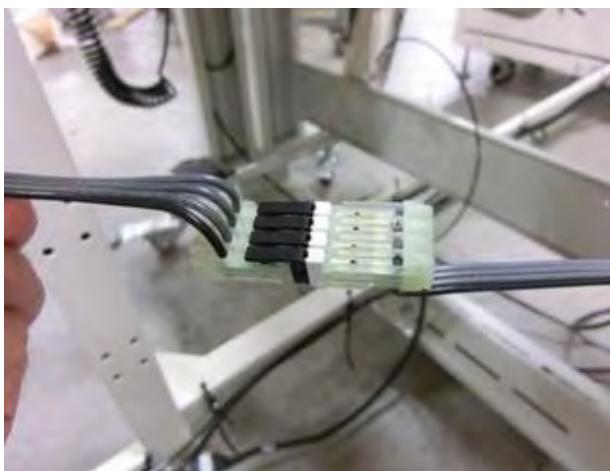
Electrical: 220 VAC, 15amp, 50/60 Hz Single Phase
Pneumatic: 80 PSI, 5 SCFM avg.
Sewing speed: 3500 RPM
Stitch Length: 6 SPI

Machine Setup

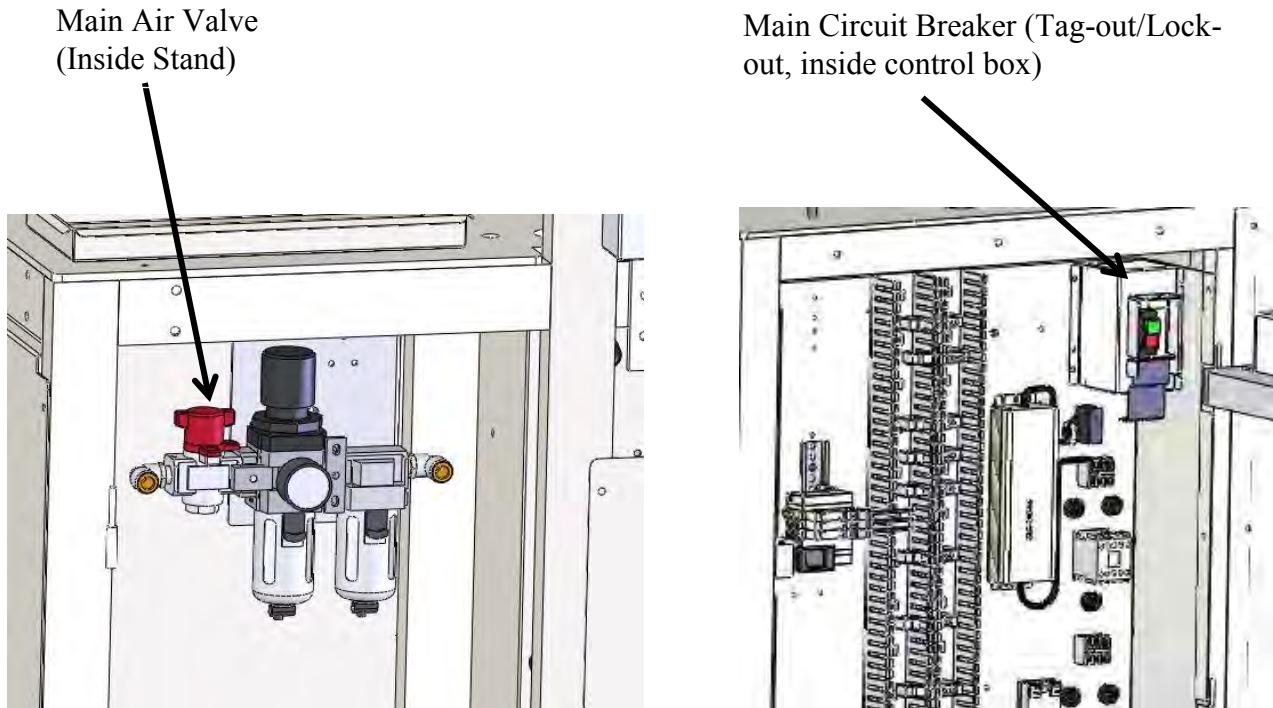
Position the machine components in a desired location on a sound and reasonably level floor. Make sure that there is sufficient lighting over the machine. Remove all packing material. Re-attach the joining bars at the base of the assemblies. See Component Identification Drawing.



Adjust the jack screws so that the casters are about 1/8" off the floor. Lock the remaining swivel casters. Connect electrical power and compressed air as specified above and in accordance to local codes. Re-connect the two Serial Buss cables between the three assemblies. Be sure the black wires are lined up with each other. Re-connect all air lines and power cords for the border and zipper feeder motors



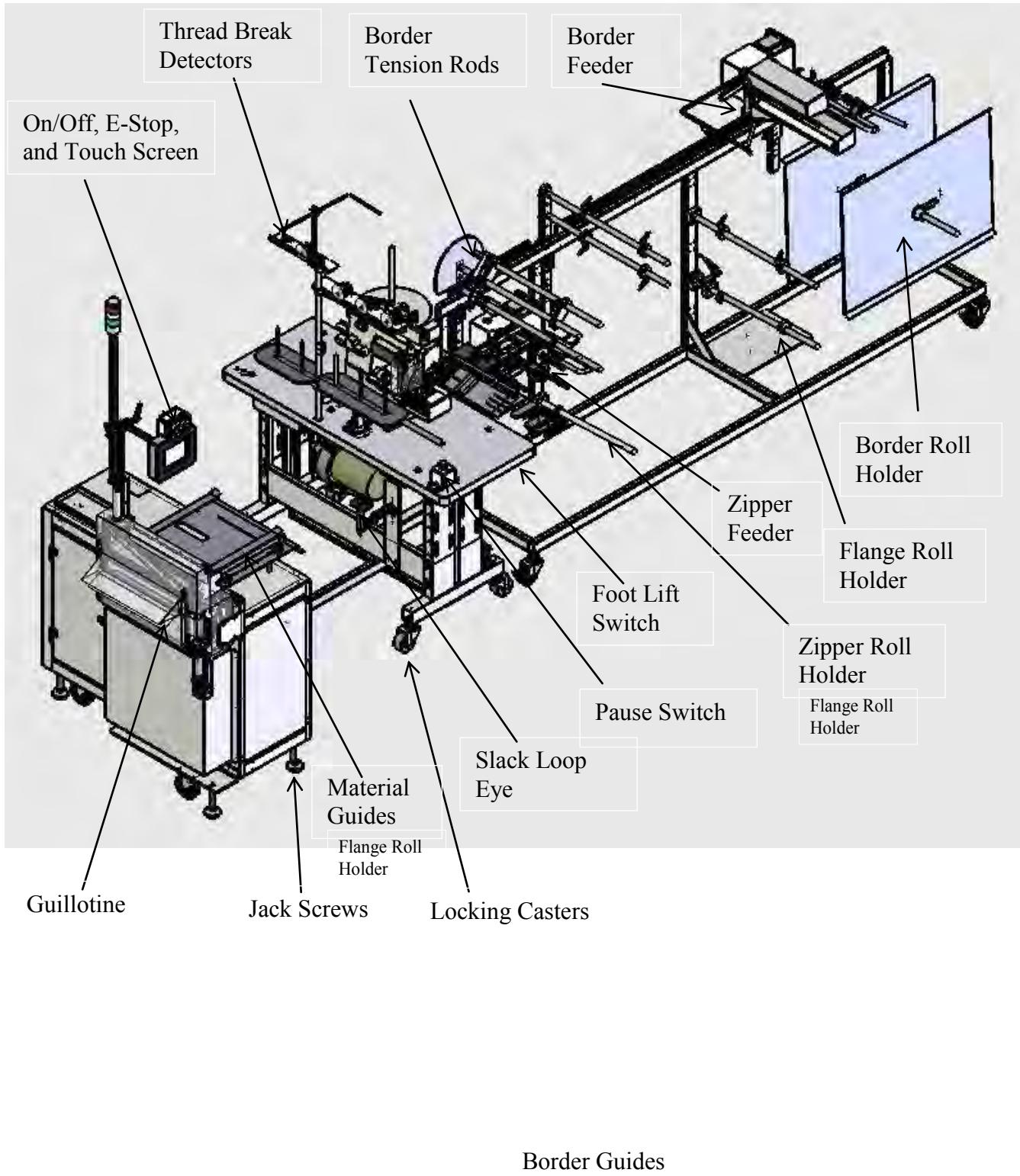
Open the main control box door in front of the machine. Turn on the ON/OFF circuit breaker located in the top right corner by pressing the green button. The green light inside the button should illuminate. Turn the main air lock-out valve (red knob before the main pressure regulator) to the ON position.



Turn on machine by pressing the green button located above the touch screen (the e-stop must be unlatched – twist to unlatch) and verify the screen comes up in the Ready – New Order screen. Check the electric eye mounted on the lower back of the sewing stand. It must “see” the piece of reflective tape located on the main stand control box door. This is the slack loop control eye. Adjust the aim of the eye as necessary so the red LED on it is blinking. Check the rest of the electric eyes on the machine for proper operation.

Turn off power by pressing the E-stop button located above the touch screen. Add thread to thread stand and pull it through to the sewing head. You can move the folder out of the way by loosening the rail locking handle located under the folder mounting plate and sliding the folder to the right. You can lift the presser foot by activating the pneumatic button valve located under the table to the left of the folder mount.

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 light tower is to indicate the current status of the machine viewable 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 are listed below.

Steady Green - Running normal production.

Flashing Green - Making last piece of an order.

Steady Yellow - Machine on, not making borders.

Flashing Yellow - Machine stopped with a fault condition. Needs attention.

Red - No function

Loading Material

Caution: To prevent the slack feeders from running while loading material, turn off power to the machine during initial material loading.

Remove the large outer disc and place the border on the spindle so it feeds with the good side up. Replace the disc to apply slight tension on the roll so it will not unwind on to the floor by itself.



Feed the border over the first rod, under the second, over the third and thru the feed wheel.



Border Curl/Out
Eyes

Adjust the left edge guide to fit the border.

There is a “Border Jam” detecting switch located at the base of the rod to stop the machine if the border roll becomes tangled or threads catch on the rod causing the roll to lift up.



Lift the roller open lever to position the border between the feed rollers.



Position the border under the slack eye and over the top center guide rods.



Border Slack Eye

Adjust the left guides to fit the border as you thread the border through the various guide hardware. All the right guides should remain as preset to align with the folder.

Feed the border over and under the border tension rods. Border sewing tension can be adjusted by rotating the rod assembly to apply drag to the border. A calibrated disc is provided so you can record the tension position for a specific border type.



Loosen this handle
to rotate guide
assembly.

Loosen the folder locking handle and slide the folder away from the sewing head while loading the folder.



Folder Locking Handle

Thread the border through the folder, adjusting the left guide as necessary.



Special right guides are provided to accommodate any decorative seams or tape lines that may be in the border. Position them as needed.



Allow the border to stick out about 4" in front of the folder.

Load the flange material onto the flange support rod by sliding over the outer guide disc. Do not remove the disc. Adjust as needed to fit the flange roll width. If the disc must be moved, check the flange Low Eye function before proceeding. This disc has a reflective tape feature used along with the Flange Low Eye to alert the machine operator when the material is getting close to the end of the roll. There is a "Jam" detecting switch located at the base of the rod to stop the machine when the roll runs out and the core is lifted because it is taped to the flange.



Thread the flange over the upper guide rod, adjusting the guide disc as needed.

Flange Low Eye, Jam switch, and Reflective Tape Disc.



Thread the flange over the lower middle support rod. Adjust left guide disc.



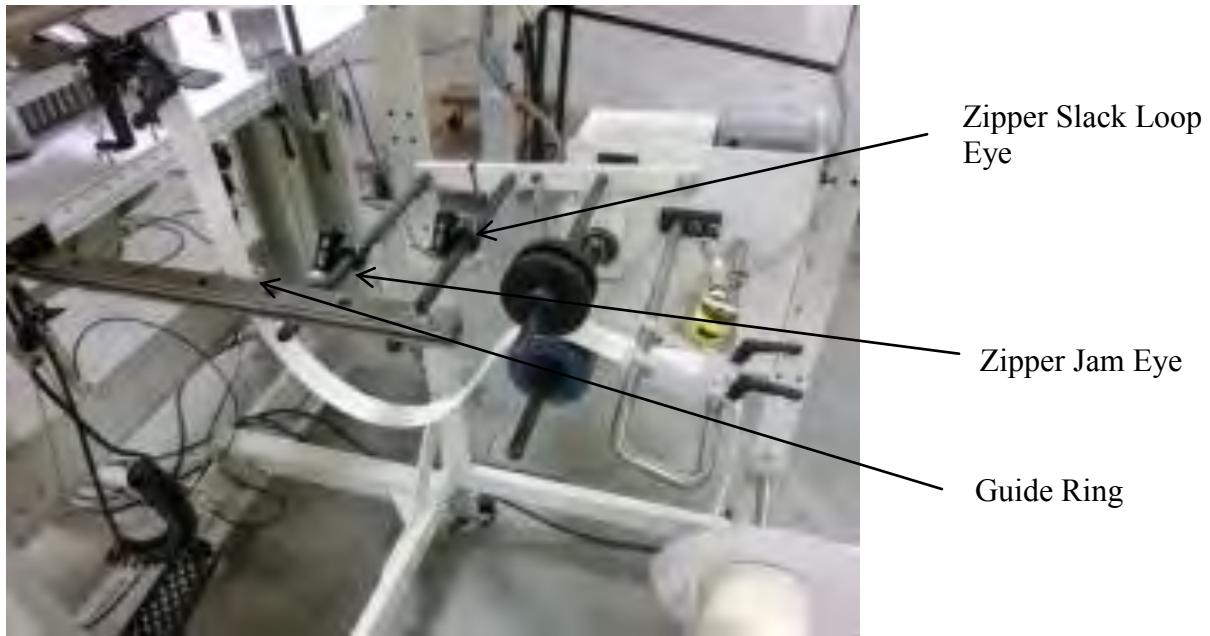
Insert flange into folder slot, adjust left guide as necessary. Allow flange to stick out 4" from front of the folder.



Load the zipper roll on the zipper holder rod so it feeds out with the zipper teeth up. Center the roll left to right to align it with the zipper feeder guides.



Thread the zipper over the first guide rod, under the second, and through the feed rollers (you can open the feed rollers by lifting on the rod the two electric eyes are mounted on). Thread the zipper through the guide ring and up into the zipper box.



Hold the zipper box open by pressing on the end of the top lever. Insert the zipper through the zipper box and into the zipper guide tube that runs under the folder. Let 4" of zipper stick out past the folder,

Load the tape roll onto the tape roll holder. The roll holder can be tilted as needed to apply tension to the tape. The further it is tilted up to the vertical position, the more tension will be on the tape. Thread the tape through the ring guide, through the guide slot in front of the tape out eye, and into the binder. Cutting a long point on the tape will help when inserting it into the binder. Push the tape through the binder and past the folder by about 4"

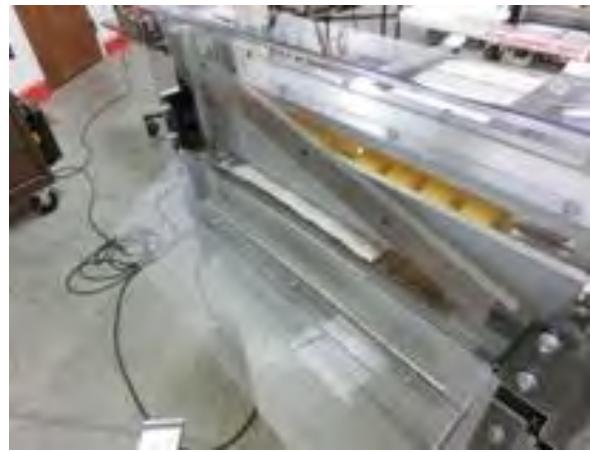
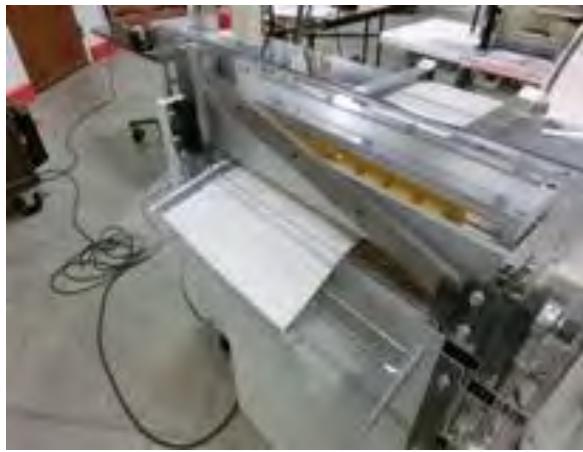


Raise the presser foot (using the button under the table) and raise the puller (using the puller lift lever). Slide the folder forward toward the foot so that all the materials go under the presser foot and the puller roller. Lower the foot and puller.

Turn on power. Using the manual sew pedal below the sewing head, sew about six feet of border, checking the seam alignment and adjusting as necessary. Feed this border into the guides on the main console. Adjust the left guide as necessary.



Press the “Open Roller” button on the touch screen to open the guillotine rollers. Insert the border through the rollers so about 4” of material sticks out beyond the cutter blades. Lower the rollers. Press the Cut Border button to trim the border even with the cutter blades.



Caution: Never place your hand inside the guillotine guards. Knife blades are extremely sharp.

Machine Operation

This machine attaches zipper tape, flange, and binding tape, from rolls, to a mattress border . Borders are measured and cut to length.

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.

Making Borders:

Press the "Edit New order" button and "Border Style" button to select the desired style. Use the "Style Select Menu" button to review and select available styles or use the Style Select Keypad to enter a style number directly. Use the "Borders" setting to enter the number of borders to make. "Exit" back to the main screen. The "Ready" screen shows # Borders desired, # Borders made (If more than 1), Style #, and Style Name.

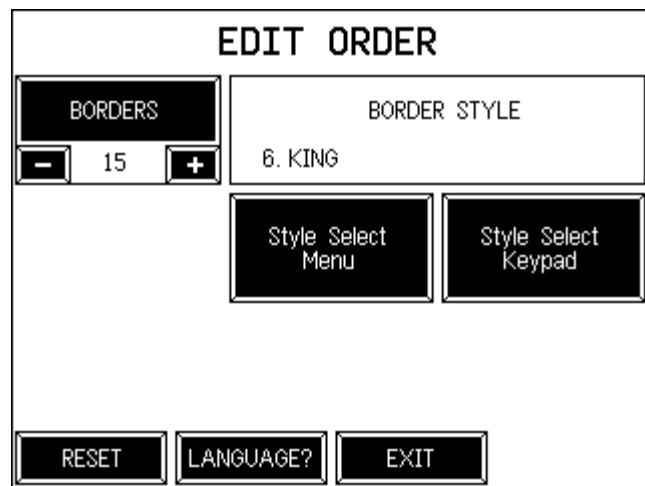
Run the sewing head with the manual foot pedal until there is enough border loop to cover the loop eye. Press the "Start" button. If the border has not been trimmed or the rollers have been opened, the machine will automatically trim the first border. The machine will begin feeding and measuring the border. As soon as the slack loop has uncovered the loop eye, the sewing head will start sewing and feeding new border. You can stop the process any time by pressing the PAUSE screen button.

******* Keep hands, fingers, etc., away from the knife blades. Never stick anything in the knife except border material. *****

Pause the machine after cutting the first border. Check its length on a stretch table and make any adjustments to the machine settings as required to correct the border length. You can temporarily change the length or the compensation. Usually, small adjustments are made by modifying the compensation or selecting a different compensation to use on this border. Once the border length is verified, you may wish to save these settings for future borders. See instructions below for saving settings.

If multiple borders are selected the machine will continue to make borders until the order is complete.

If the feeding process is interrupted with a "Pause" button press, it can be resumed with the "Continue" button. If the machine stops due to a "Fault", read the message on the screen, resolve the fault condition, and press "continue". You can also press "reset" and return to the ready screen where you can edit the existing order.



Editing Styles

Creating a Style

From the "Ready" screen press "Setup".

Press "Security" and enter user code "22222", Enter, Exit, if necessary.

Press SHOW ALL STYLES, then EDIT STYLES or

Press ADVANCED STYLES, the ACTIVE STYLES PAGE 1 menu appears.

Press STYLE EDIT MENU button.

In the EDIT STYLES MENU press the dark area in the MyLabel column next to an unused style number. Use the top arrows to scroll to other screens with more styles.

Enter a name for the style using the keyboard.

Exit back to the style screen.

Select the dark area under the LENGTH column next to the new style.

Enter the desired length from the keypad. Press ENTER and EXIT.

Select the dark area under the COMP. SELECT column next to the new style.

Enter the desired compensation factor from the keypad. Press ENTER and EXIT.

All data is automatically saved as it is entered.

Exit back to the READY screen

To run the new style, go to the EDIT ORDER screen and select the new style # from the menu.

Modifying a Style

Modify a Style is the same as creating a new Style, you just select an existing style to edit instead of a new style.

If this is a temporary change to an existing style:

Go to the Active Styles Page 1 and press the arrow button at the top of the page. This opens the Active Styles Page 2. Here you can temporarily change the compensation and length. Exit back to the READY page. Notice that the STYLE # has changed to "0" indicating that you are running a non-standard style. To return back to the original Style settings, return to the EDIT ORDER screen and reload the original style.

On the STYLE EDIT MENU there is a button named DEFAULT ACTIVE STYLE. Pressing it will erase the name of the active style, clear the compensation setting, and set the length to 300". Use to delete an obsolete style. There is also a SAVE ACTIVE STYLE button that allows you to save (copy) an active style as a new number for further editing.

Piece Counter:

The third button from the left on the bottom row of the READY screen is a resettable piece counter. Press on the button to access the screen for resetting it. This counter counts knife activations during automatic cycle. This can be used for daily production monitoring. There is also a timer that shows the efficiency of the machine based on "run" time divided by "on" time. It resets with the piece counter. In the System Information screen there is also a life-time piece counter that does not reset.

SETUP screen buttons, mechanic mode.

Show All Settings: When this button is pressed, all of the values for the different settings are displayed in a table format. By pressing EDIT SETS you can change individual settings.

Show all Styles: Pressing this button gives access to a Style lists. You can press EDIT STYLES to go to the EDIT STYLES MENU.

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.

Manual Setup Cycle: Pressing this button gives access to manual buttons for activating the Guillotine cutter.

Security: Pressing this button gives access to the screens for changing the security level for screen access. Some screens have functions only available at Mechanic and Technician levels.

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

Advanced Styles: Pressing this button gives access to the screens for creating, modifying, and copying styles.

Advanced Manual: Pressing this button gives access to screens that will allow the user to manually activate individual outputs and check operation of input devices.

Machine Adjustments

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

- Guillotine blade spring pressure. Adjusting screw accessed through hole in back of guillotine. Excessive pressure will shorten the life of the blades.
- Feed roller hold down cylinder. Set so that the rollers just touch with little or no pressure.
- Sew head puller roller pressure. Just enough to get uniform stitch lengths.
- Sew head puller feed stroke. Set for 6 SPI along with maximum feed dog stroke.
- Sew head foot pressure. Excessive pressure can cause stretching of materials and cause the border to become curved.
- Border tension. Set as light as possible to prevent stretching.
- Zipper tension. Set as needed to sew flat along seam without ripples at outer edge.
- Tape tension. Excessive tape tension will cause the border to curve.
- Flange tension. Set as needed to make flange lay flat along seam.
- Material loop control eyes set for optimum loop control

- Zipper jam eye set to activate if zipper loop pulls up flat.
- Air pressure monitor set to 60 PSI minimum. Machine will not run if loss of pressure.

Main Feed Motor Parameter Settings

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

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	Pedal Function, analog off
110	70-390	70	Pos Speed
111	0-999	1200	Maximum speed when "129" is 0, 1, or 2.
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	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	Disable auto machine ID function
401		1	Change from 0 to 1 to save parameters

Front panel LED's:

Programming Instructions:

- | | |
|----------------------------------|---|
| LED 1: Off | 1. Power on holding down the "P" button till "CODE" is displayed. |
| LED 2: Off | 2. Press ">>" once and enter the number "5913" |
| LED 3: Off | 3. Press "E" once and "4.0.0." is displayed this is a parameter |
| LED 4: Off | 4. Proceed to the parameter to be changed and press "E" |
| LED 5: Off | 5. The value now shows in the screen, adjust to desired value. |
| LED 6: Off | 6. Press "E" to enter value and continue with parameter setting. |
| LED 7: Off, Stop at needle down. | 7. Repeat for other parameters, press "P" once when complete. |
| LED 8: Off | 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	56	C
Slow	30	A, C

Machine Maintenance

Regularly scheduled maintenance of the 32P30Z1 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. 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.
3. 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 Adjustment (Yellow SM312LVQ)

These sensors use reflective tape. Check the target tape condition before adjusting sensor. Replace tape if needed. 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 (Brass) is labeled "GAIN" and is used to

set the sensitivity of the sensor. The other screw (White plastic) 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.

Electric Eye Adjustment (Black QM42)

These sensors do not use reflective tape. They sense objects directly and are affected by the object's color. To adjust the sensor, turn the brass screw labeled “GAIN” until the desired sensitivity is obtained.

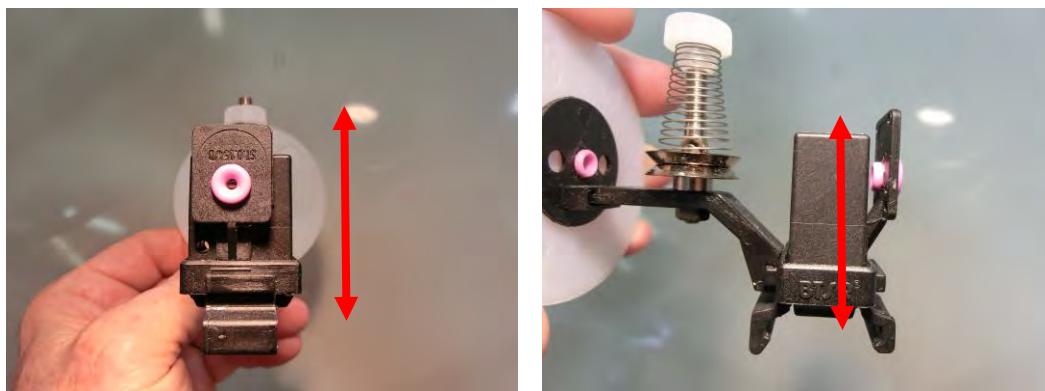
Reflective Tape Maintenance

Use a soft cloth for cleaning.
Do not use chemicals or abrasives.
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.

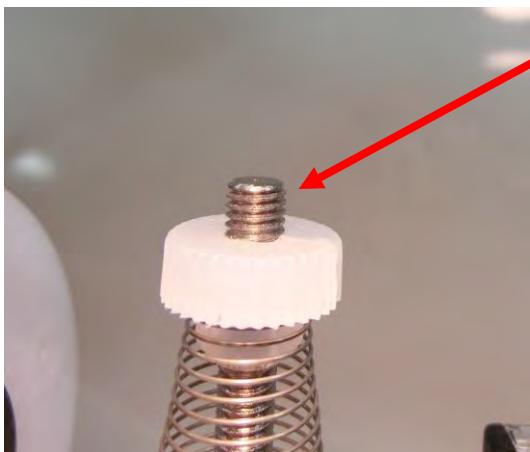
Thread Break Detector Maintenance

Check thread break sensors for proper adjustment and assembly condition.

Sensor must be mounted straight in its holder. This is critical!!



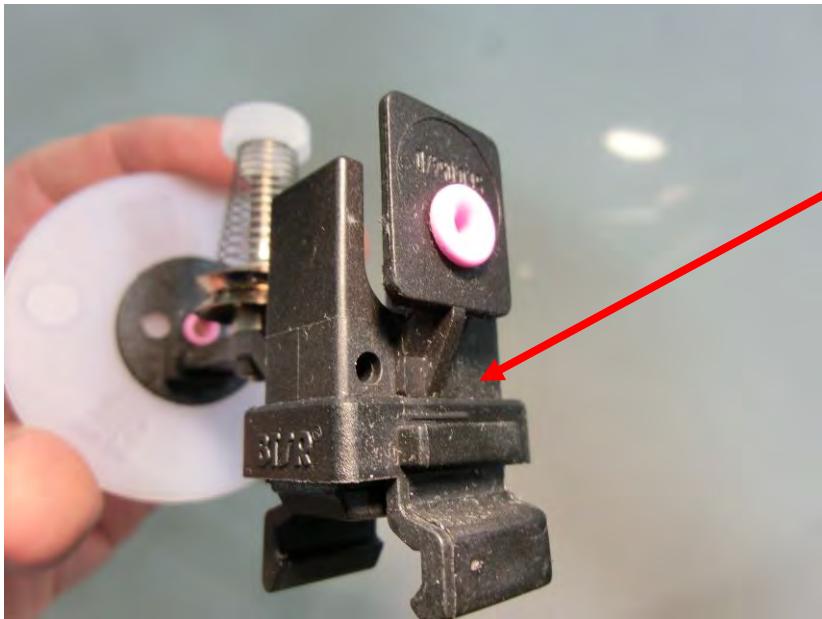
Tension knob has about 1/8-1/4" thread above.



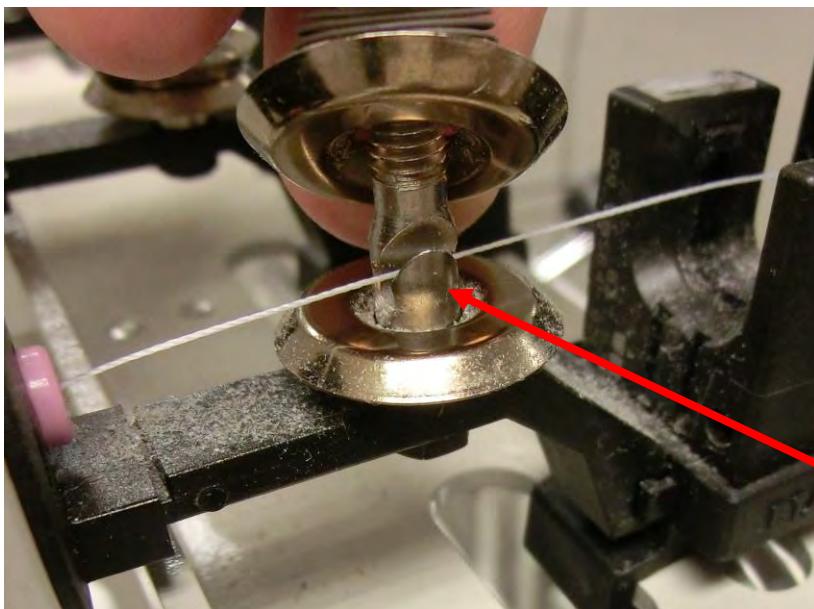
Tension arm seated all the way to the right in its slot.



Exit eyelet seated all the way down in its mounting slot.



Thread must pass through groove in tension post.



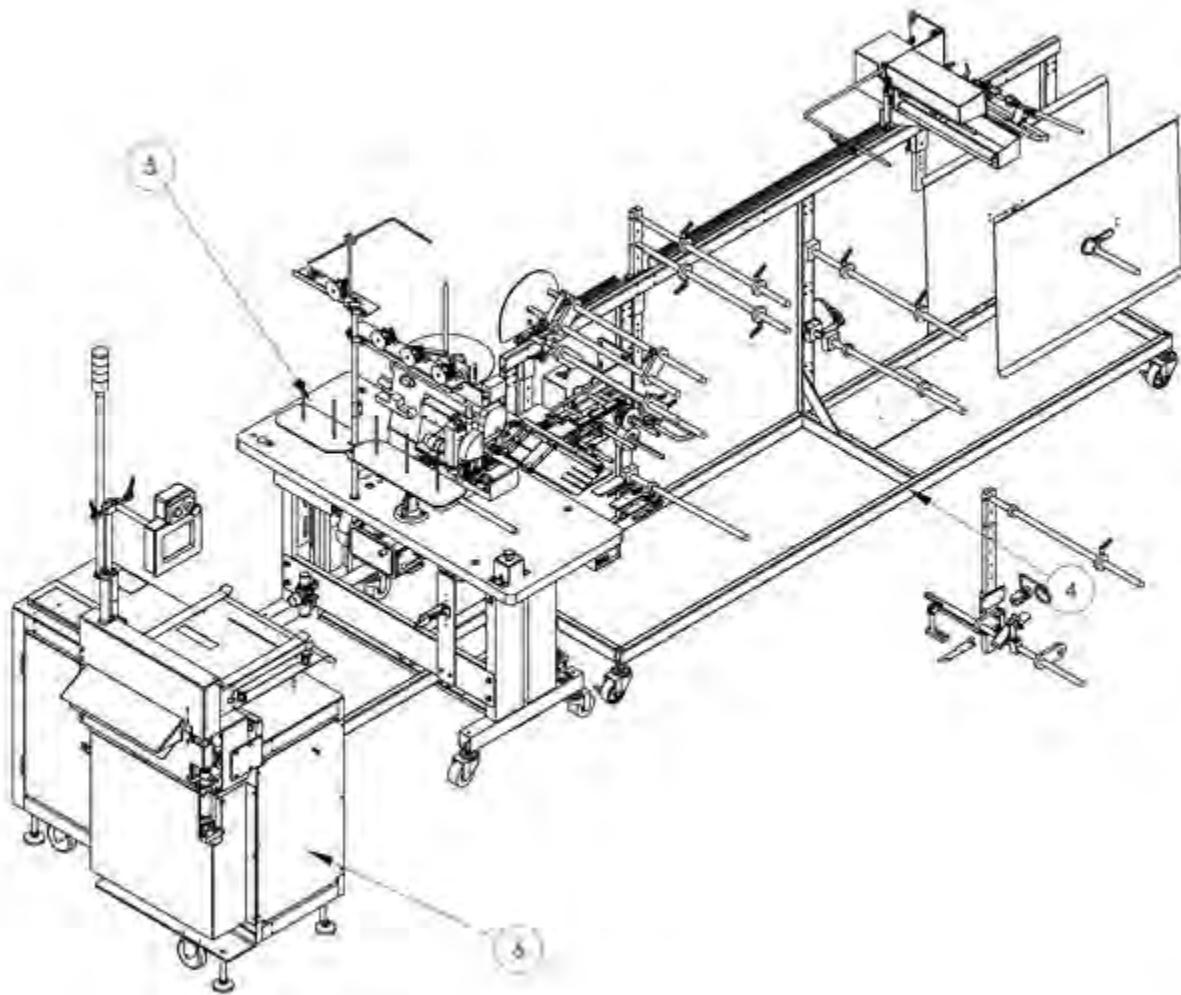
Blow off sensors and clean lint out daily!

Assembly Drawings & Parts Lists

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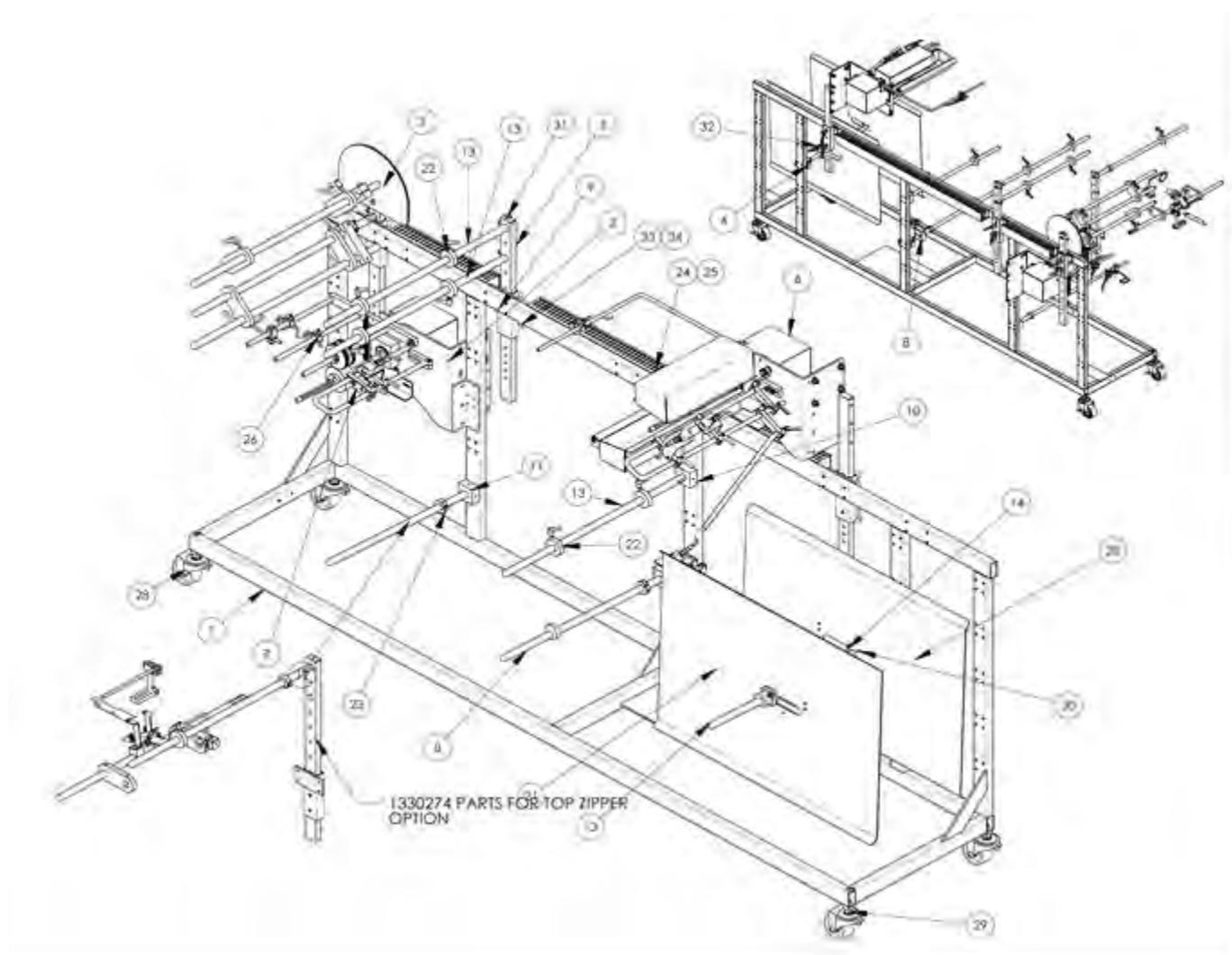
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32P30Z1 ZIPPER SEW STATION

AAC Drawing Number 900512 Rev 0

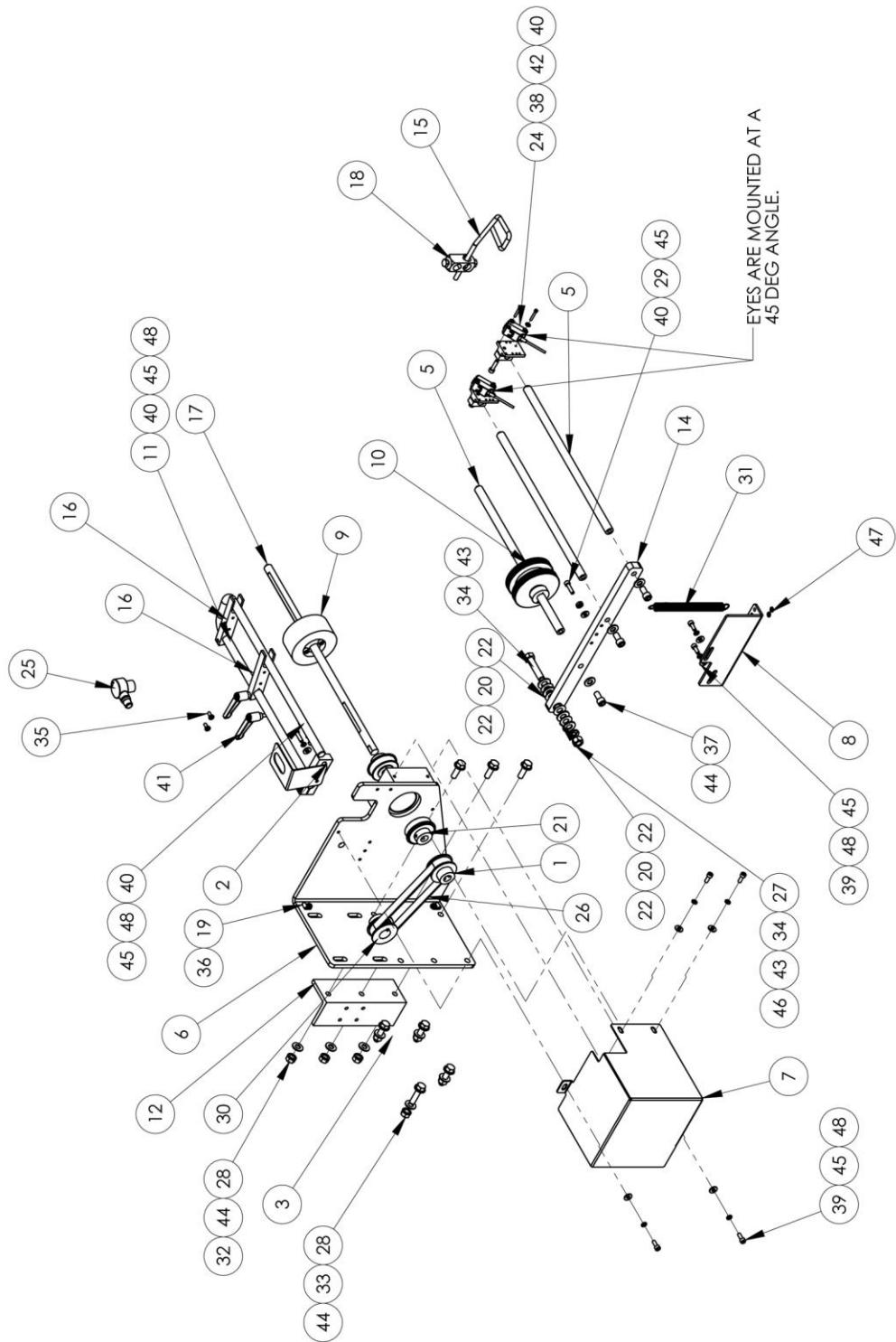
NO	QTY	PART #	DESCRIPTION
1	1	1330-PD	DIAGRAM, PNEUMATIC
2	1	1330212	BRACE FRAME ASSY.
3	2	1330215	BRACE, FRAME
4	1	1330269	ROLL HOLDER
5	1	1330270	TABLE, STAND, MOTOR
6	1	3200370	BORDER WKSTN, MEAS & CUT
7	1	332P30Z1-PD	DIAGRAM, PNEUMATIC
8	1	332P30Z1-WD	DIAGRAM, WIRING



1330269 ROLL HOLDER

AAC Drawing 1330269 Rev 1

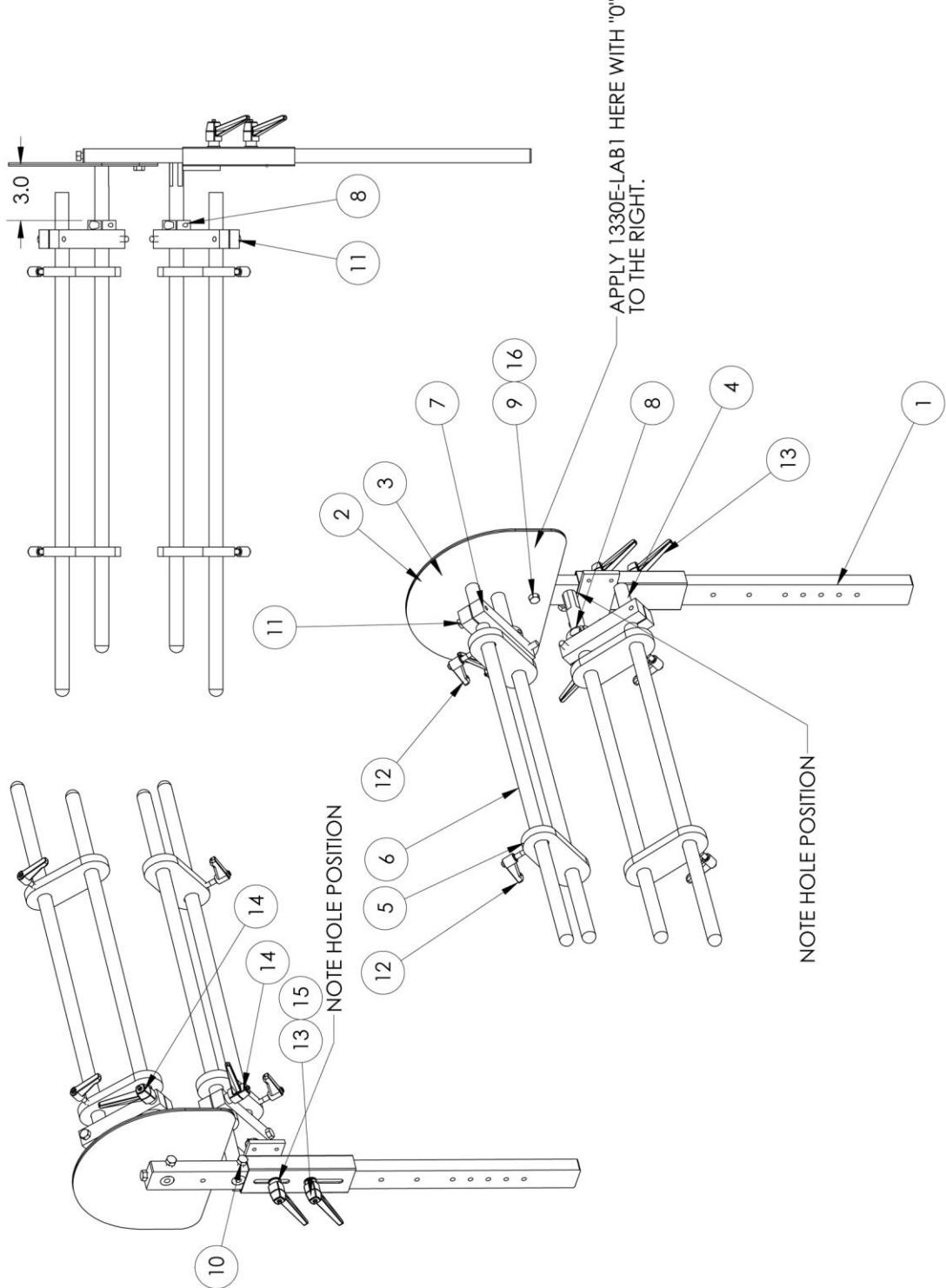
NO	QTY	PART #	DESCRIPTION
1	1	1330012	FRAME WELDMENT, 4 ROLL
2	1	1330113	UNWINDER,ZIPPER W/PULLS
3	1	1330138	SUPPORT, TENSIONER,DUAL
4	1	1330155	ROD MOUNT, 3/4B, W/SWITCH
5	1	1330160	TENSION RACK, DUAL
6	1	1330176	MOTOR ASSY,UNWINDER
7	1	1330181	ZIPPER PULL DETECTOR
8	1	1330272	FLANGE HOLDER W/SW
9	1	1347093	SUPPORT, TENSIONER
10	1	1961-251A	HUB, UNWIND SHAFT
11	1	1961-251C	HUB, UNWIND SHAFT
12	1	1961-252	ROD,ROLL,SST,3/4X21 W/RAD
13	4	1961-252D	ROD, ROLL, 27" L
14	1	1961-253A	HUB, UNWIND STAND
15	1	332P30Z1-WD	DIAGRAM, WIRING
16	1	332P30Z1-PD	DIAGRAM, PNEUMATIC
17	3	4080-110	MODULE,QUAD INPUT
18	1	4080-940	MODULE,TERMINATOR
19	1	4080-4187	CABLE,SBUS,1330269
20	1	784B-2436	PLATE, ALU, 23.75 X 31.75
21	1	785-A97-36	DISC ASBLY , 36" X 3/4 HUB
22	6	A-4-048	EDGE GUIDE, 2"X3/4B
23	1	CCCL12F	CLAMP COLLAR- 3/4
24	*56	EEDF2X2	DUCT,WIRE,2X2, MOD
25	*56	EEDC2X2	COVER,WIRE DUCT
26	4	FFRK44TBS4	CABLE,AE PLUG,4'LONG
27	3	FFRK44TBS6	CABLE,AE PLUG,6'LONG
28	4	MM503022LB	CASTER, 3" LOCKING
29	4	NNH1/2-13	NUT,HEX,1/2-13
30	4	SSBC80024	6-32 X 3/8 BUTTON HEAD
31	4	SSHG10048	5/16-18 X 3/4 HHCS
32	2	TTH32416	HANDLE,THR'D,1/4-20X1-1/8
33	2	TTH32425	HANDLE,THR'D,5/16-18X3/4
34	1	WWFS5/16	WASHER,FLAT,SAE,5/16



1330113 UNWINDER ZIPPER W/PULLS

AAC Drawing Number 1330113 Rev 4

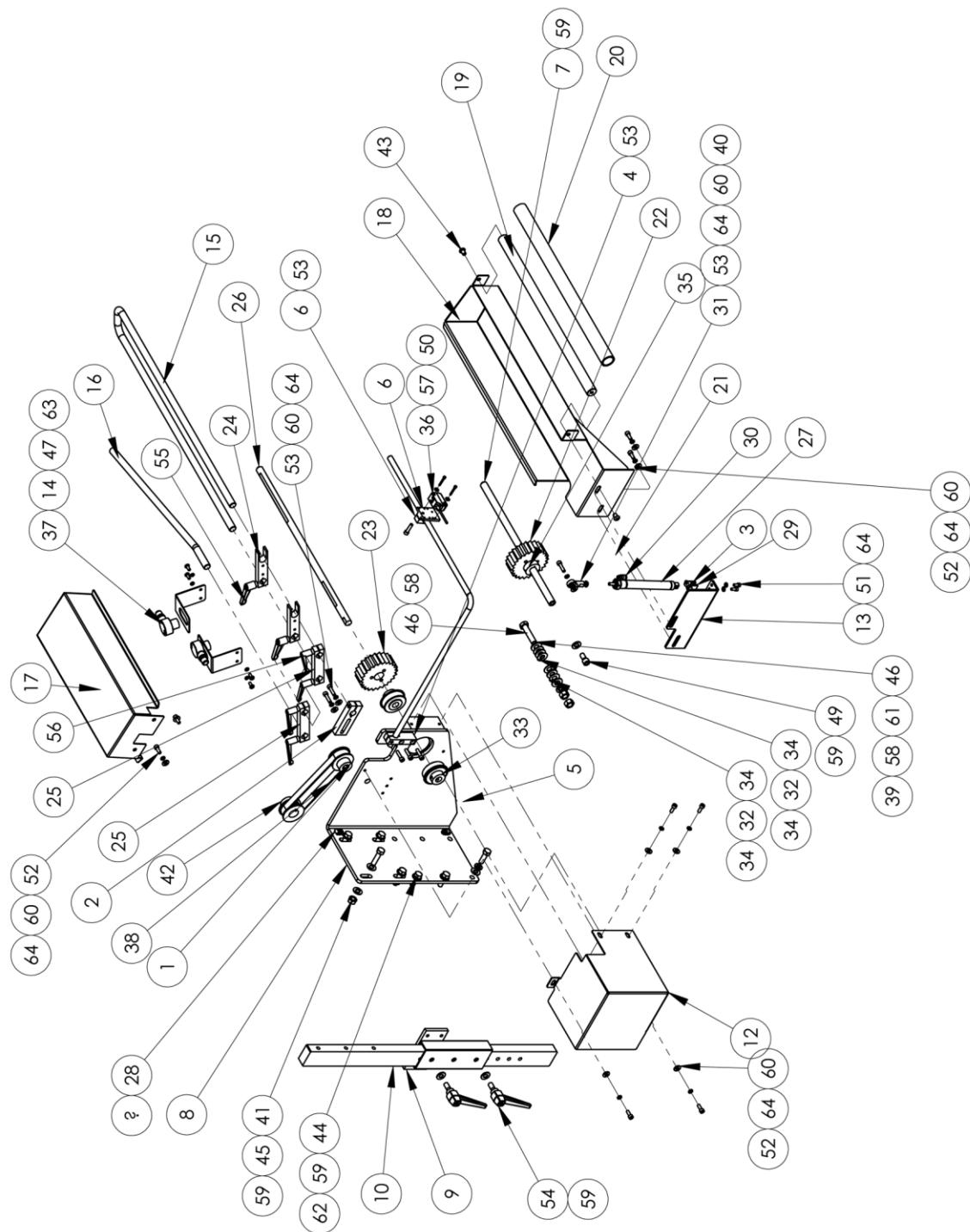
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	211-057	PULLEY, 3/8P, 12T,1/2B	25	1	FFT18FF100Q	EYE,FIXED FIELD, 4IN
2	1	1325-346	HOLDER,ROD,1/2 D,SLOT MNT	26	1	GG157L050	BELT,GEAR,3/8P,1/2W
3	1	23218DM	MOTOR ASSY,GEAR	27	1	NNH3/8-16	3/8-16 HEX NUT
4	2	265156A	HOLDER, EYE, 1/2 BORE	28	7	NNK5/16-18	NUT,KEP,5/16-18
5	3	1330017	SHAFT, IDLER ROLLER	29	1	NNK10-32	KEP NUT, 10-32
6	1	1330018	MOTOR MOUNT WELDMENT	30	1	PP12LF050-3/4	PULLEY,GEAR,3/8P,.50B,12T
7	1	1330026	BELT, COVER	31	1	RRLE045E12	Lee Spring LE-031 D8
8	1	1330055	BRACKET, CYLINDER	32	3	SSHC10064	5/16-18 X 1 HHCS
9	1	1330127	ROLLER,ZIPPER,DRIVE	33	4	SSHC10080	5/16-18 X 1-1/4 HEX HEAD
10	1	1330128	ROLLER,ZIPPER,IDLER	34	1	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
11	1	1330129	ROD,1/2 DIA, 180 DEG	35	2	SSPP90024	8-32X3/8 PAN PHLPS
12	1	1330131	MOUNT, ANGLE,FEEDER	36	2	SSPS90024	#8-32 X 3/8 PAN HD SLOT
13	1	1330132	BRACKET, SEN, RT ANGLE	37	3	SSSC10040	5/16-18 X 5/8 SOC CAP
14	1	1330157	ARM, TENSION	38	4	SSSC70048	#4-40 X 3/4 SOC CAP
15	1	1330175	ROD,GUIDE,ZIPPER FEED	39	6	SSSC98032	#10-32 X 1/2 SOC CAP
16	2	1335499	ARM, 1/2" ROD CLAMP	40	5	SSSC98048	#10-32 X 3/4 SOC CAP
17	1	1335738	SHAFT, DRIVE ROLLER	41	2	TTH34311	HANDLE,THREADED,10-24X3/4
18	1	A-U	ROD CROSS BLOCK	42	4	WWF4	WASHER, FLAT #4
19	2	AAF1/8	1/8" PLASTIC CLAMP	43	2	WWFS3/8	WASHER, FLAT, 3/8
20	2	BBNTA613	BEARING,THRUST,.375BORE	44	17	WWFS5/16	WASHER, FLAT, 5/16
21	2	BBS8701-88	BEARING,BALL,.50IDX1.75OD	45	9	WWFS10	WASHER, FLAT #10
22	4	BBTRA613	WASHER,THRUST,STL, .375B	46	1	WWL3/8	3/8 LW
23	2	CCCL8F	CLAMP COLLAR- 1/2	47	4	WWL8	WASHER,LOCK,#8
24	2	FFQS18VN6AFF	SENSOR,PROXIMITY	48	8	WWL10	#10 LW



1330160 DUAL TENSION RACK

AAC Drawing Number 1330160 Rev 0

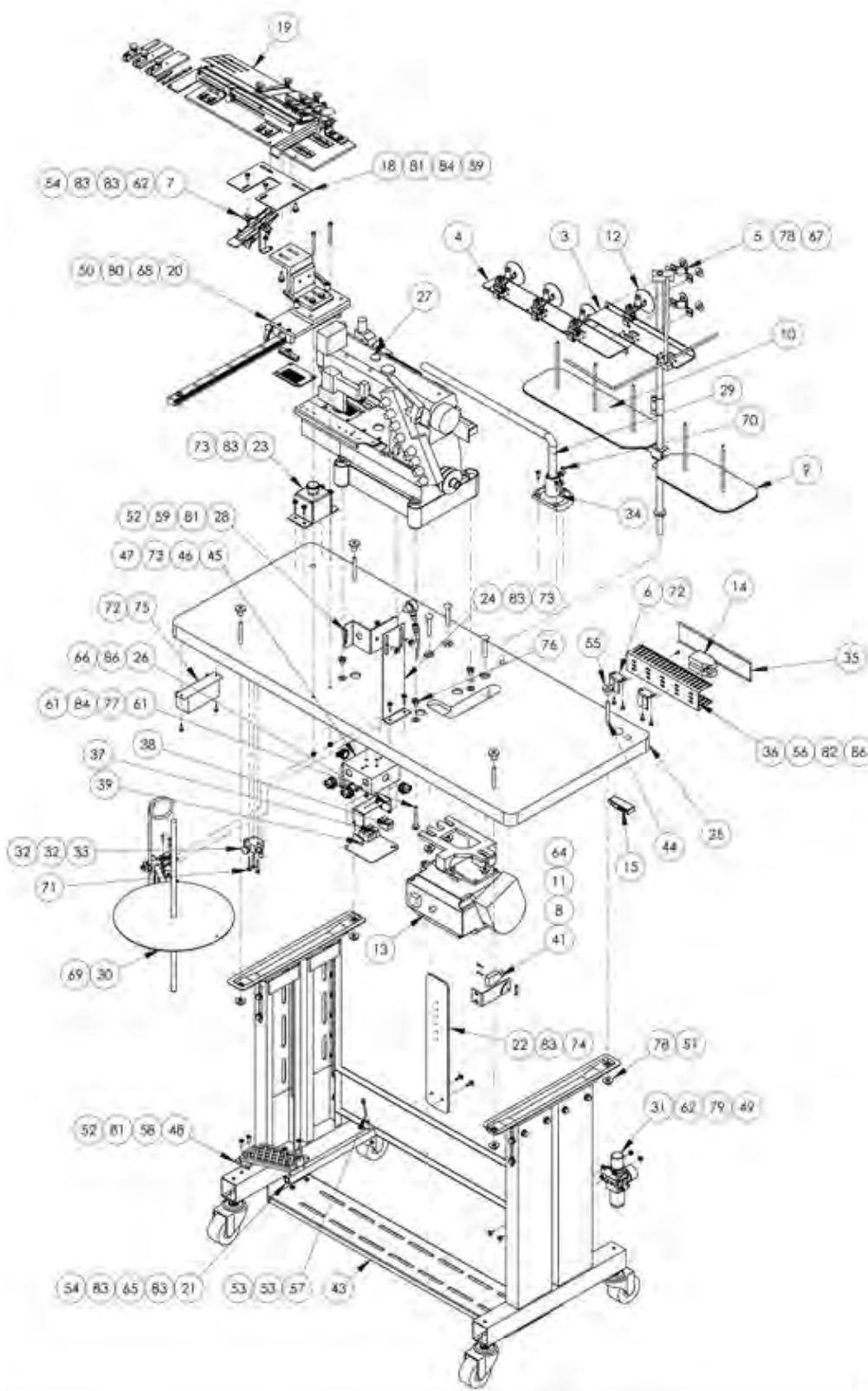
NO	QTY	PART #	DESCRIPTION
1	1	1330138	SUPPORT, TENSIONER,DUAL
2	1	1330159	DISC, SCALE MOUNT
3	1	1330E-LAB1	LABEL,CALIBRATION SCALE
4	1	1347093	SUPPORT, TENSIONER
5	4	1961-211	PLATE, EDGE GUIDE
6	4	1961-252D	ROD, ROLL, 27" L
7	2	1962-3201	CLAMP, 3/4 ROD, 3" CTC
8	2	CCCL12F	CLAMP COLLAR- 3/4
9	1	SSHC10032	5/16-18 X 1/2 HHCS
10	4	SSHC10048	5/16-18 X 3/4 HHCS
11	2	SSHC10096	5/16-18 X 1-1/2 HHCS
12	4	TTH32416	HANDLE,THR'D,1/4-20X1-1/8
13	2	TTH32425	HANDLE,THR'D,5/16-18X3/4
14	2	TTH32429	HANDLE,THR'D,5/16-18X2.0
15	2	WWFS5/16	WASHER,FLAT,SAE,5/16
16	1	WWL5/16	WASHER,LOCK, 5/16



1330176 MOTOR ASSY. UNWINDER

AAC Drawing Number 1330176 Rev 1

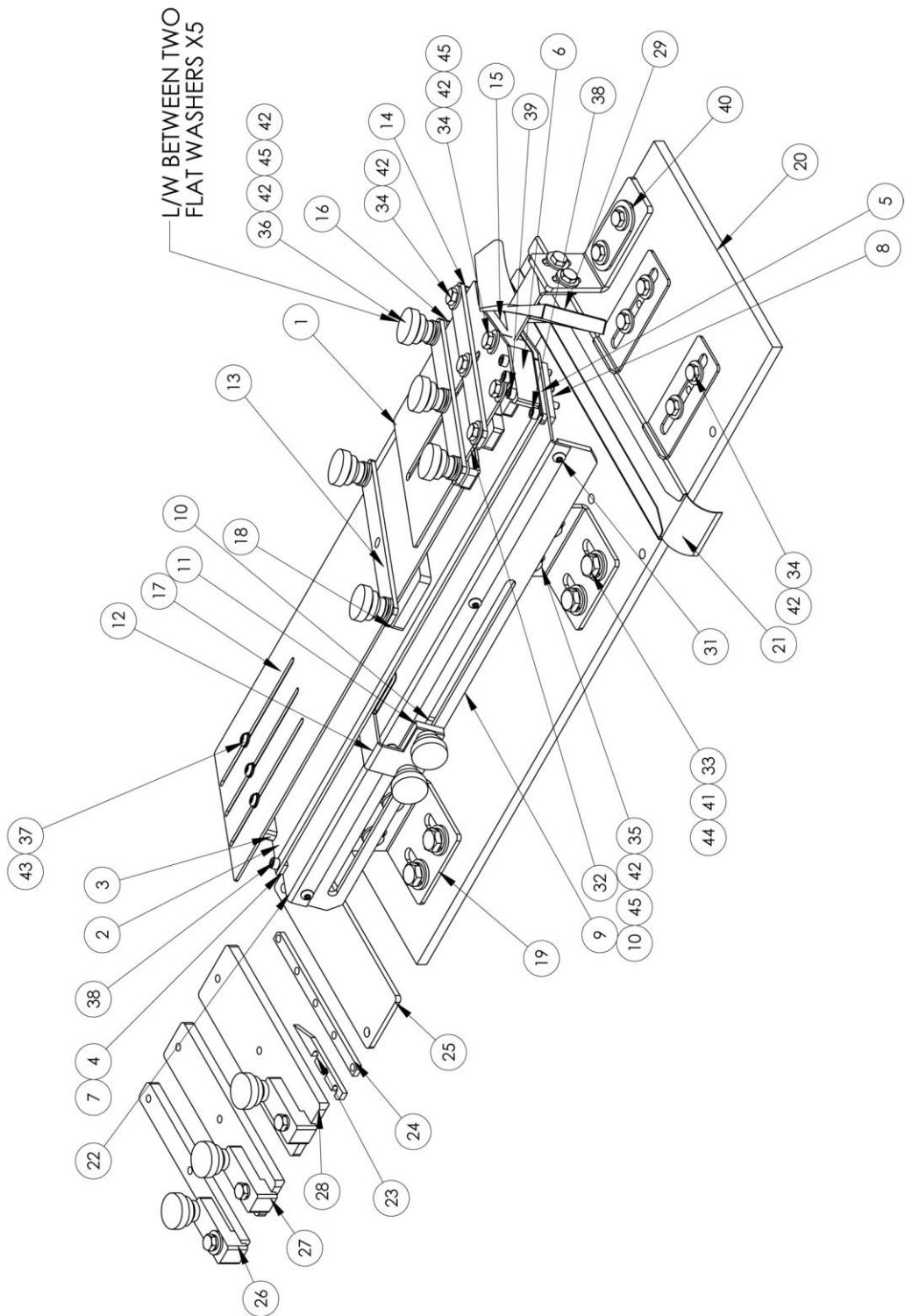
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	211-057	PULLEY, 3/8P, 12T,1/2B	33	2	BBS8701-88	BEARING,BALL,.50IDX1.75OD
2	1	1325-346	HOLDER,ROD,1/2 D,SLOT MNT	34	4	BBTRA613	WASHER,THRUST,STL,.375B
3	1	1335M-2046	PLATE,NUT,8-32@.43 CTC	35	2	CCCL8F	CLAMP COLLAR- 1/2
4	1	23080A	BLOCK,CLAMP,EYE	36	1	FFQS18VN6AF	SENSOR,PROXIMITY
5	1	23218DM	MOTOR ASSY,GEAR	37	2	FFT18FF100Q	EYE,FIXED FIELD, 4IN
6	1	265156A	HOLDER, EYE, 1/2 BORE	38	1	GG157L050	BELT, GEAR,3/8P,1/2W
7	1	1330017	SHAFT, IDLER ROLLER	39	2	NNH3/8-16	NUT,HEX,3/8-16
8	1	1330018	MOTOR MOUNT WELDMENT	40	1	NNJ10-32	NUT,JAM,THIN #10-32
9	1	1330019	SUPPORT, UNWINDER	41	4	NNK5/16-18	NUT,KEP,5/16-18
10	1	1330022	SUPPORT, UNWINDER	42	1	PP12LF050-3/4	PULLEY, GEAR,3/8P,.50B,12T
11	1	1330025	ROD,BENT,CRS,1/2 OD	43	2	SSBC01024	1/4-20 X 3/8 BUT CAP SC
12	1	1330026	BELT, COVER	44	3	SSHC10064	5/16-18 X 1 HHCS
13	1	1330055	BRACKET, CYLINDER	45	4	SSHC10080	5/16-18 X 1-1/4 HHCS
14	2	1330132	BRACKET, SEN, RT ANGLE	46	1	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
15	1	1330158	ROD,1/2 DIA, 180 DEG	47	4	SSPP90024	8-32X3/8 PAN PHLPS
16	1	1330174	ROD,GUIDE,BORDER ROLL	48	2	SSPS98024	10-32X3/8 PAN HD SLOT
17	1	1330234	COVER,UNWINDER,UPPER	49	1	SSSC10040	5/16-18 X 5/8 SOC CAP
18	1	1330236	COVER,UNWINDER,LOWER	50	2	SSSC70048	4-40 X 3/4 SOCKET CAP
19	1	1330237	ROD,SST,TAPPED 10-32,3/4D	51	2	SSSC90024	#8-32 X 3/8 SOC CAP SC
20	1	1330238	ROLLER,PVC,3/4" SCH 40	52	8	SSSC98032	10-32X1/2, SOC CAP
21	1	1335189	LINK, IDLER ROLLER	53	7	SSSC98048	10-32 X 3/4 SOC CAP
22	1	1335497	ROLLER, FLUTTED, IDLER,	54	2	TTH32425	HANDLE,THRDED,5/16-18X3/4
23	1	1335498	DRIVE ROLLER, FLUTED,	55	2	TTH34311	HANDLE,THREADED,10-24X3/4
24	2	1335499	ARM, 1/2" ROD CLAMP	56	4	TTH48070	HANDLE,THREADED 10-32X.63
25	2	1335501	ARM, 1/2" ROD CLAMP	57	2	WWF4	WASHER, FLAT, #4
26	1	1335738	SHAFT, DRIVE ROLLER	58	2	WWFS3/8	WASHER,FLAT,SAE,3/8
27	1	AAC8DP-3	CYLINDER,AIR,DA	59	14	WWFS5/16	WASHER,FLAT,SAE,5/16
28	2	AAF1/8	1/8" PLASTIC CLAMP	60	11	WWFS10	WASHER, FLAT, #10, SAE
29	1	AAFBP-8C	BRKT,PIVOT,5/32 BORE	61	1	WWL3/8	WASHER,LOCK, 3/8
30	1	AAQME-5-10	AIR ELBOW, 10-32 X 5/32	62	3	WWL5/16	WASHER,LOCK, 5/16
31	1	BBAW-3Z	BRG,ROD END,F, 10-32	63	4	WWL8	WASHER,LOCK,#8
32	2	BBNTA613	BEARING,THRUST,375BORE	64	13	WWL10	WASHER,LOCK,#10



1330270 TABLE, STAND, MOTOR

AAC Drawing Number 1330270 Rev 2

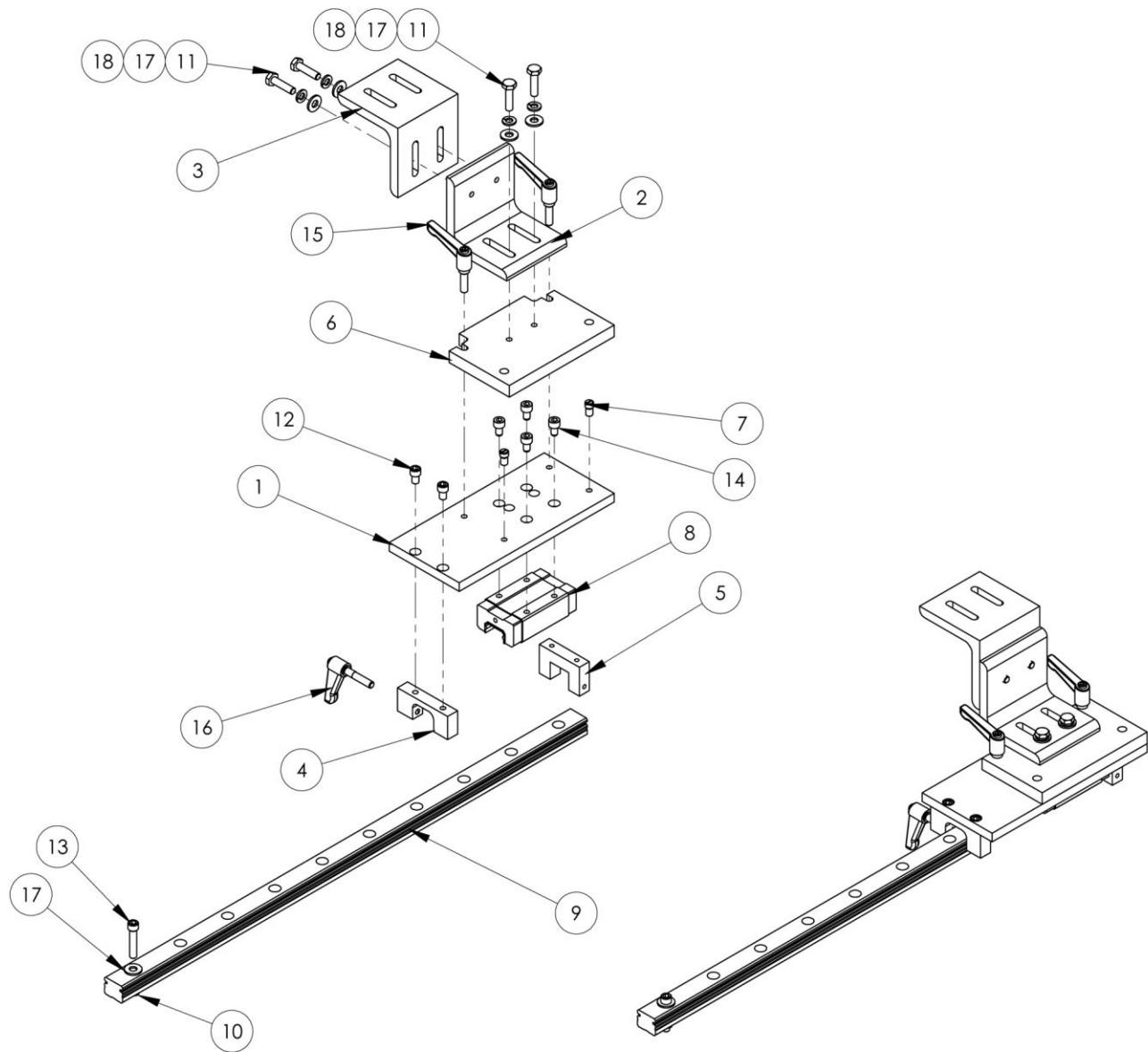
NO	QTY	PART #	DESCRIPTION	NO	QTY	PART #	DESCRIPTION
1	1	332P30Z1-PD	DIAGRAM, PNEUMATIC	45	1	K-233	BOX,ELECTRICAL,SQUARE
2	1	332P30Z1-WD	DIAGRAM, WIRING	46	1	K-234	COVER,4IN SQUARE
3	1	0411-069B	BRKT, THREAD BREAK DETECT	47	4	K-235	CONNECTOR,ROMEX,1/2"
4	1	0411-069C	BRKT,THREAD BRK DETECTION	48	1	K-29402	CAST IRON FOOT PEDAL
5	2	0411-070	CLAMP, SENSOR BRACKET	49	2	NNE10-32	NUT,ELASTIC LOCK
6	2	0411-2433	BRKT,TRACK MOUNT	50	2	NNM6-1.0	NUT,LOCK M6-1.0
7	1	502-Z088A	ZIPPER BOX, 1-3/8	51	7	NNH3/8-16	3/8-16 HEX NUT
8	1	1278-6689E	BRACKET, EYE MOUNT	52	4	NNK1/4-20	NUT,HEX,KEP,1/4-20,W/LOCK
9	1	1959-112	2 POS THREAD PLATE ASSY	53	2	NNK8-32	NUT,KEP,8-32
10	1	1959-161	3 POS THREAD PLATE ASSY.	54	4	NNK10-32	KEP NUT, 10-32
11	1	1975-412A	PLATE,NUT,4-40,.95CTC	55	4	NNM103	NUT,RECESSED,5/16-18
12	4	4003-IS4F	SENSOR,THREAD BREAK	56	2	SSBC80032	6-32 X 1/2 BUT HEAD
13	1	4058-3	MOTOR, 3/4HP, 220V, 600W	57	1	SSBE90064	EYEBOLT,8-32X1
14	2	4080-110	MODULE,QUAD INPUT	58	2	SSFS01048	1/4-20 X 3/4 FHS
15	1	4080-200	MODULE,AIR PRESSURE	59	4	SSHCO1048	1/4-20 X 3/4 HEX CAP
16	1	4080-4186	CABLE,SBUS,#2,1330270	60	2	SSHCO1056	1/4-20 X 7/8 HEX CAP
17	1	4080-4230	CABLE,INPUT,3P IDC	61	4	SSHCO1160	1/4-20 X 2-1/2 HHCS
18	1	1330015	PLATE, 1-3/8" Z-BOX MOUNT	62	4	SSHCO98032	10-32X1/2 HEX HD
19	1	1330110	FOLDER, 4-12" ADJ	63	2	SSPP98024	10-32 X 3/8 PAN HD PHILIP
20	1	1330119	ASSY, FOLDER MOUNT	64	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
21	1	1330147	TREADLE EXTENSION TUBE	65	2	SSPS98080	10-32X1-1/4 PAN HD SLOT
22	1	1330148	SLACK EYE TARGET	66	4	SSSC80016	6-32 X 1/4 SOC CAP SC
23	1	1330164	PAUSE BUTTON BOX ASSY	67	4	SSSC98032	#10-32 X 1/2 SOC CAP
24	1	1330165	BRACKET, MATERIAL OUT	68	2	SSSCM6X60	M6X60 SOC CAP SCREW
25	1	1330222	TABLE, TOP	69	2	SSWF10064	SCR,WOOD,#10X1",PH
26	1	1330225	BRKT, WAGO BLOCK	70	3	SSWF12064	SCR,WOOD,1/4X1,FH
27	1	1330229	SEW HEAD ASSY W/ROLLERS	71	3	SSZH#6096	SCREW,SHT.METAL HEX 6
28	1	1347036	SENSOR BRACKET	72	6	SSZH#10048	SCREW,SHT.METAL HEX 10
29	1	1347117	ROD, BENT, 90 DEG	73	8	SSZH#10064	SCREW,SHT.METAL HEX 10
30	1	1347630	BINDING REEL ASBLY	74	2	SSZS93048	SCREW, SHT.METAL 10 ZIP
31	1	AA198-5102	REGULATOR W/GAUGE & NUT	75	1	T75	ON/OFF 1PH SWITCH BOX,
32	2	AAQME-5-8	QUICK MALE ELBOW	76	4	TIW1_4-20	1/4-20 TEE NUT FOR WOOD
33	1	AAVMB33	SWITCH,AIR,3 WAY,W/EXH	77	4	WWF1/4	WASHER, FLAT, 1/4", COM
34	1	AP-1721	STAND BASE,COMPLETE	78	10	WWF3/8	WASHER,FLAT,3/8 OR 10MM
35	1	EEDC2X2	COVER,WIRE DUCT	79	4	WWF10	WASHER, FLAT, #10, COM
36	1	EEDF2X2	DUCT,WIRE,2X2, MOD	80	2	WWFM6	WASHER, FLAT, M6, SAE
37	4	FF264-341	TERM BLK,WAGO, TOP,DUAL,GR	81	8	WWFS1/4	WASHER,FLAT,SAE,1/4
38	2	FF264-347	TERM BLK,WAGO, TOP,DUAL,GR	82	2	WWFS6	WASHER, FLAT, #6
39	1	FF264-371	TERM BLK,WAGO, TOP,END	83	18	WWFS10	WASHER, FLAT, #10, SAE
40	2	FFRK44TBS4	CABLE,AE PLUG,4'LONG	84	8	WWL1/4	WASHER,LOCK,1/4
41	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	85	9	WWL3/8	3/8 LW
42	1	FFT18FF100Q	EYE, FIXED FIELD, 4IN	86	6	WWL6	WASHER,LOCK,#6
43	1	K-4D	HD T LEG ADJ STAND	87	2	WWL10	WASHER,LOCK,#10
44	4	K-102-21	ROD,TH,5/16-18,2-1/2L				



1330110 FOLDER 4-12" ADJ WITH FLANGE

AAC Drawing Number 1330110 Rev 1

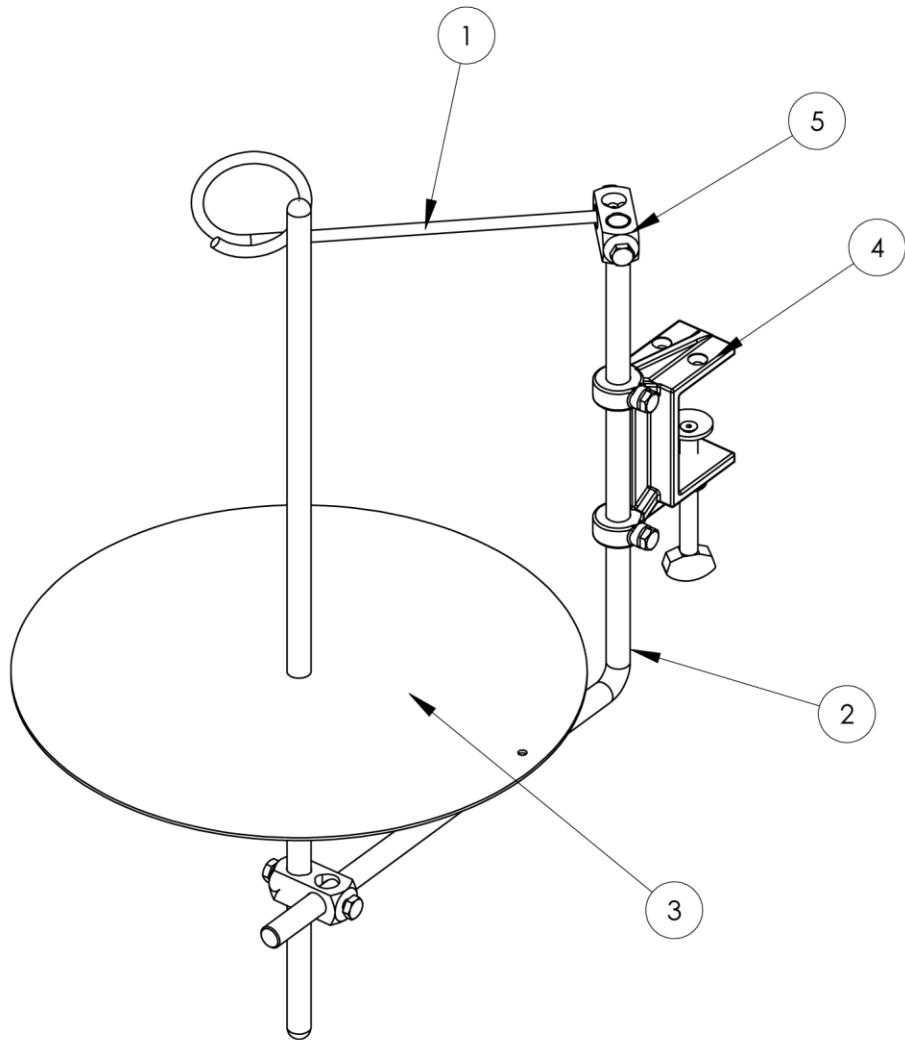
NO	QTY	PART #	DESCRIPTION
1	1	1330087	FOLDER TOP
2	1	1330088	FOLDER MID PLATE
3	1	1330090	SPACER, 1/4 X 5 HOLE
4	1	1330091	SPACER, .10 X 6 HOLE
5	1	1330092	SPACER, 4 HOLE X .10
6	1	1330093	SPACER, 3 HOLE X .50
7	1	1330094	NUT PLATE, 6 HOLE
8	1	1330095	NUT PLATE, 4 HOLE
9	1	1330096	SLOTTED GUIDE PLATE
10	3	1330097	NUT PLATE, 2X10-32X.5
11	1	1330098	WASHER PLATE, 2X.196X1
12	1	1330102	EDGE GUIDE, FLANGE
13	3	1330103	WASHER PLATE, 2 X 4.2
14	1	1330105	SPACER, 1/4 X 3/4
15	1	1330106	SPACER PLATE, 1/4, RT
16	1	1330107	NUT PLATE, FOLDER TONGUE
17	1	1330108	FOLDER PLATE LEFT
18	1	1330109	NUT PLATE, 1/4X4.2X10-32
19	2	1330112	MOUNT ANGLE
20	1	1330114	BASE PLATE
21	1	1330117	ZIPPER GUIDE ASBLY
22	1	1330118	FOLDER BOTTOM ABLY
23	1	1330133	SPACER, 1/8 X 3 HOLE
24	1	1330134	SPACER, 1/8 X 3 HOLE
25	1	1330140	SPACER, 1/8 X 4.2 X 1-1/2
26	1	1330161	SPACER, FOLDER, 1/4X1/2
27	1	1330162	SPACER, FOLDER, 1/4X1
28	1	1330163	SPACER, FOLDER, 1/4X1.5
29	1	252-A016084	RAW FINISH BINDER
30	3	NNK6-32	KEP NUT, 6-32
31	4	SSBC80012	BHCS #6-32X..25L
32	4	SSFC80016	SCR, FLAT HD,CAP, 6-32 X 1/4
33	4	SSHC01048	1/4-20 X 3/4 HEX CAP
34	11	SSHC98024	10-32 X 3/8 HEX CAP
35	4	SSHC98032	10-32X1/2 HEX HD
36	7	SSMKK3	KNOB, 3/4" KNURLED
37	3	SSPS80064	#6-32 X 1 PAN HD SLOTTED
38	2	SSSC80024	6-32 X 3/8 SOC CAP SC
39	3	SSSC80064	6-32 X 1 SOC CAP SC
40	1	WW25DW	PLATE, WASHER
41	4	WWFS1/4	WASHER, FLAT, SAE, 1/4
42	25	WWFS10	WASHER, FLAT, #10, SAE
43	3	WWFS6	WASHER, FLAT, #6
44	4	WWL1/4	WASHER, LOCK, 1/4
45	11	WWL10	WASHER, LOCK, #10



1330119 FOLDER MOUNT ASSY.

AAC Drawing Number 1330119 Rev 1

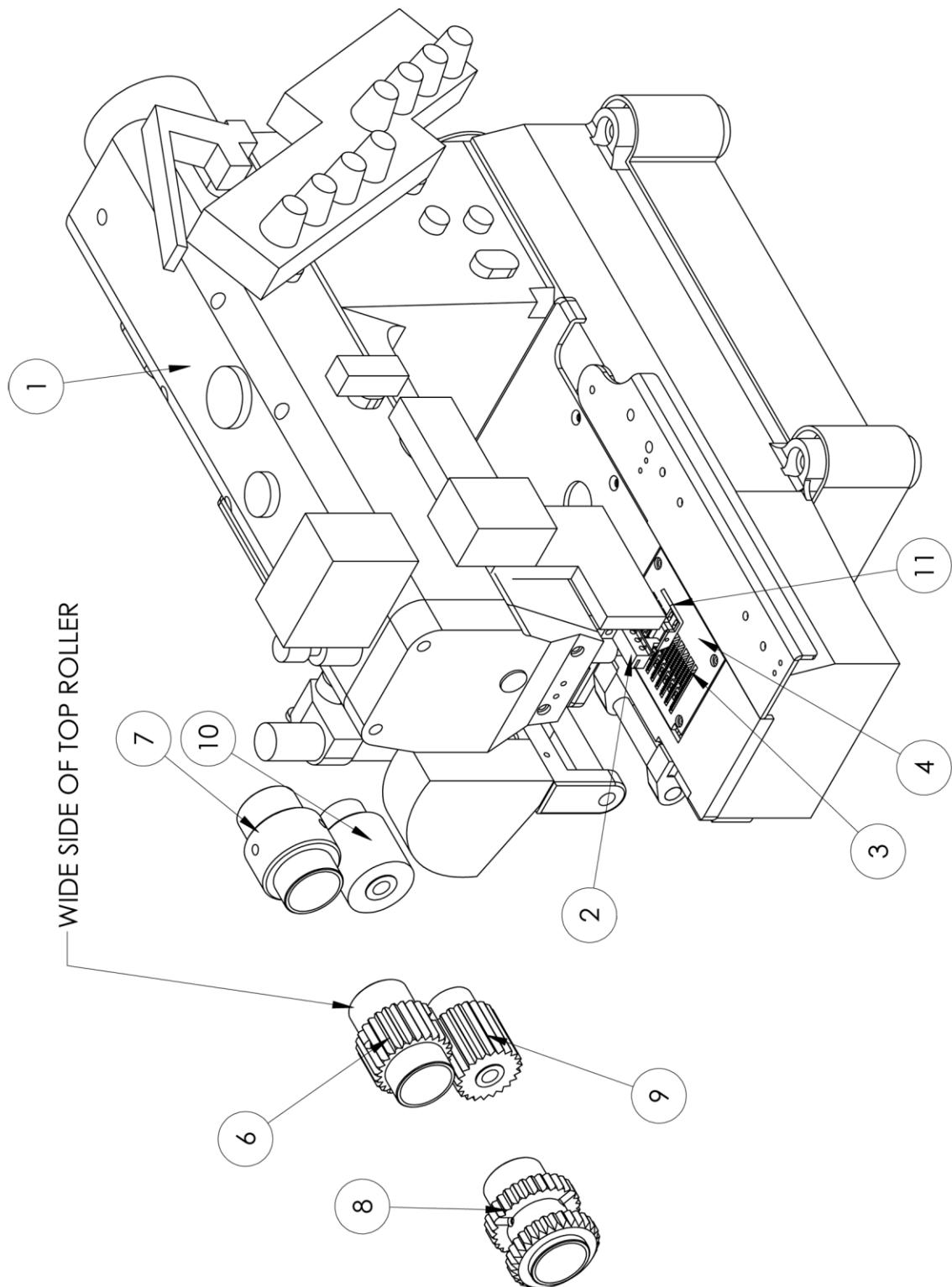
NO	QTY	PART #	DESCRIPTION
1	1	1330104	ADAPTOR, FOLDER
2	1	1330124	MOUNT, FOLDER
3	1	1330125	MOUNT, FOLDER,UPPER
4	1	1334-1006	MOUNT,LOCKING HANDLE
5	1	1335-310	STOP BLOCK,FRONT
6	1	1347062	BASE, FOLDER MOUNT
7	2	1347088	STUD, .312 OD, 1/4-20
8	1	MMAGH25C	LINEAR BEARING
9	1	MMAGR2559	RAIL,LINEAR AG SERIES
10	1	NNK1/4-20	NUT,KEP,1/4-20
11	4	SSHC01064	1/4-20 X 1 HHCS
12	2	SSSC01024	1/4-20 X 3/8 SOC CAP SC
13	1	SSSC01080	1/4-20 X 1-1/4 SOC CAP
14	4	SSSCM6X10	M6X10 SOC CAP SCREW
15	2	TTH32415	HANDLE,THDED,1/4-20X7/8
16	1	TTH32416	HANDLE,THRD,1/4-20X1-1/8
17	5	WWFS1/4	WASHER,FLAT,SAE,1/4
18	4	WWL1/4	WASHER,LOCK,1/4



1347630 BINDING REEL ASSY.

AAC Drawing Number 1347630 Rev 0

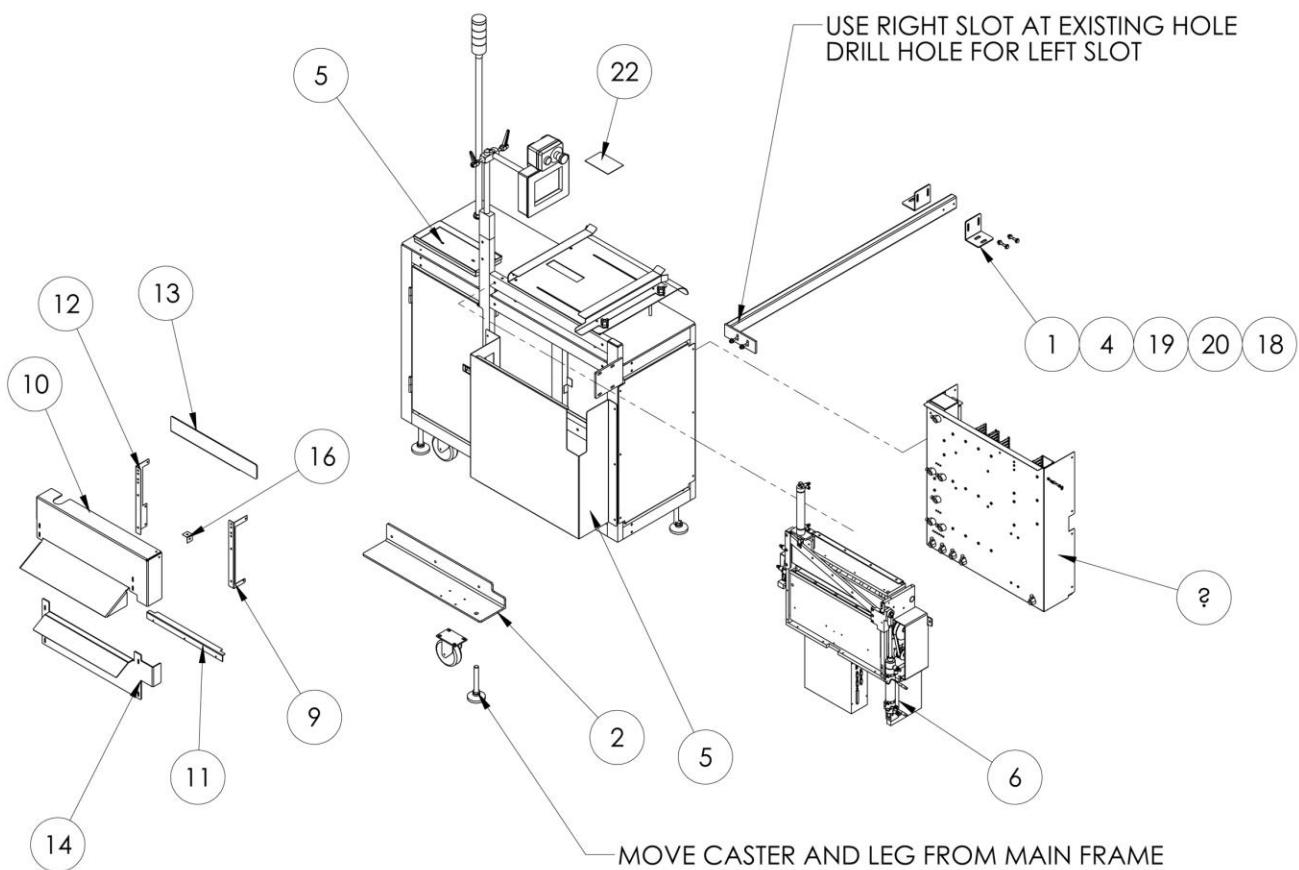
NO	QTY	PART #	DESCRIPTION
1	1	1347116	RING,TAPE GUIDE
2	1	780-102C	ROD, BENT,12 X 12 X 90DEG
3	1	781-3-S1401	PIPING STAND,12" DISC
4	1	A-7-1/2	TABLE CLAMP ASSEMBLY
5	2	A-U	ROD CROSS BLOCK



1330229 SEW HEAD ASSY. W/ROLLERS

AAC Drawing Number 1330229 Rev 1

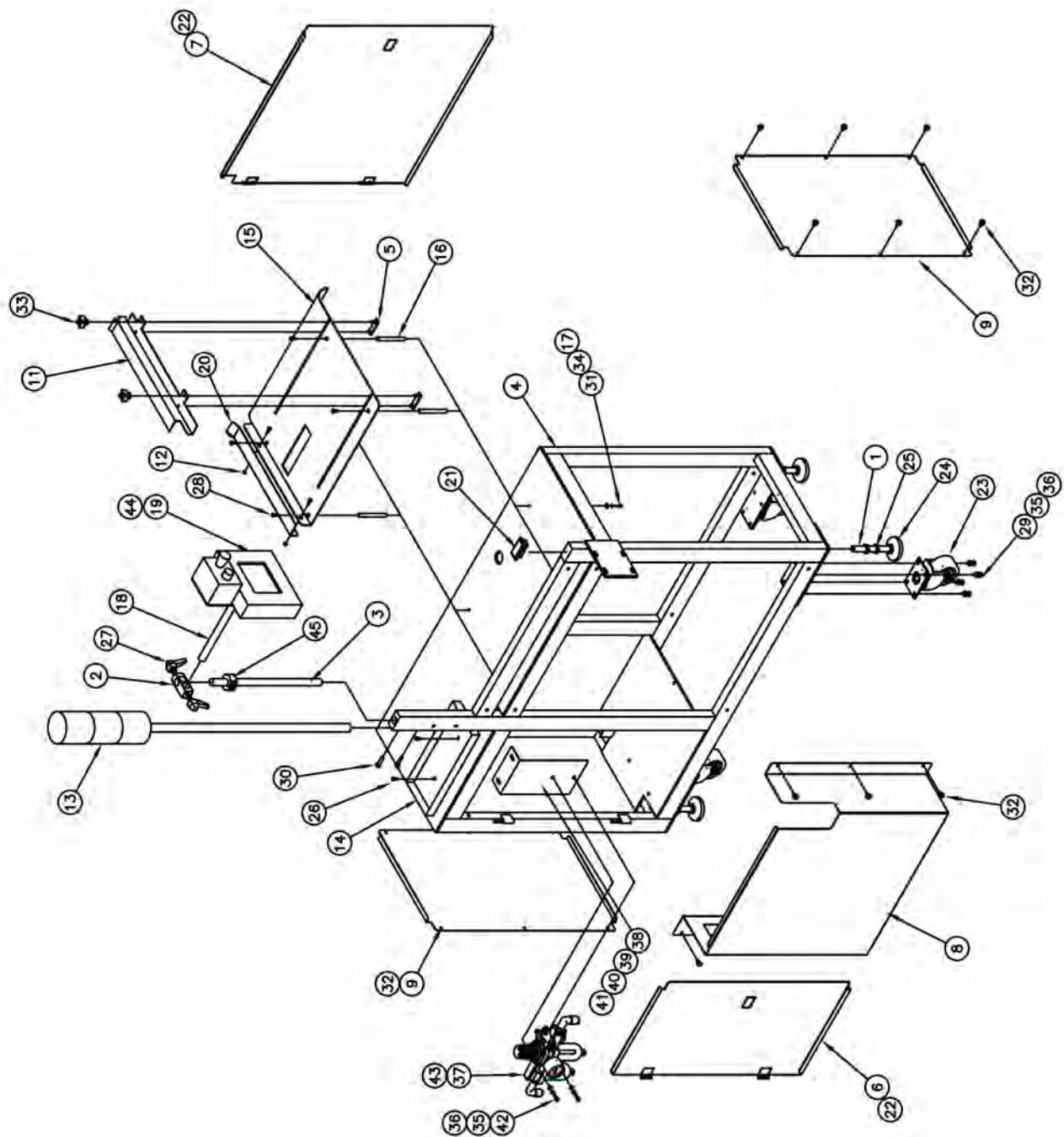
NO	QTY	PART #	DESCRIPTION
1	1	1334-1000B	SEWING HEAD DETAIL
2	1	1862N94016	NEEDLE CHUCK,9N,1/4 GA
3	1	54205A9016	FEED DOG, 9N, 1/4 GA.
4	1	54224A9016	PLATE,THROAT,9N,1/4 GA
5	1	54242B9016	SPREADER,9NDL 1/4 GA
6	1	0065468M3	ROLLER, FLTD,UPPER 26TH
7	AR	0066567M2	ROLLER,RUBBER,UPPER FEED
8	1	1330259	ROLLER, FLUTED, 30 TOOTH
9	1	3300079M2	ROLLER, FLTD,LWR, 1.89 OD
10	AR	3300083M	ROLLER,RUBBER,LOWER IDLER
11	1	M1V67-026	FOOT,2N,ZIPPER,L&R



3200370 BORDER WKSTN, MEAS & CUT

AAC Drawing Number 3200370 Rev 1

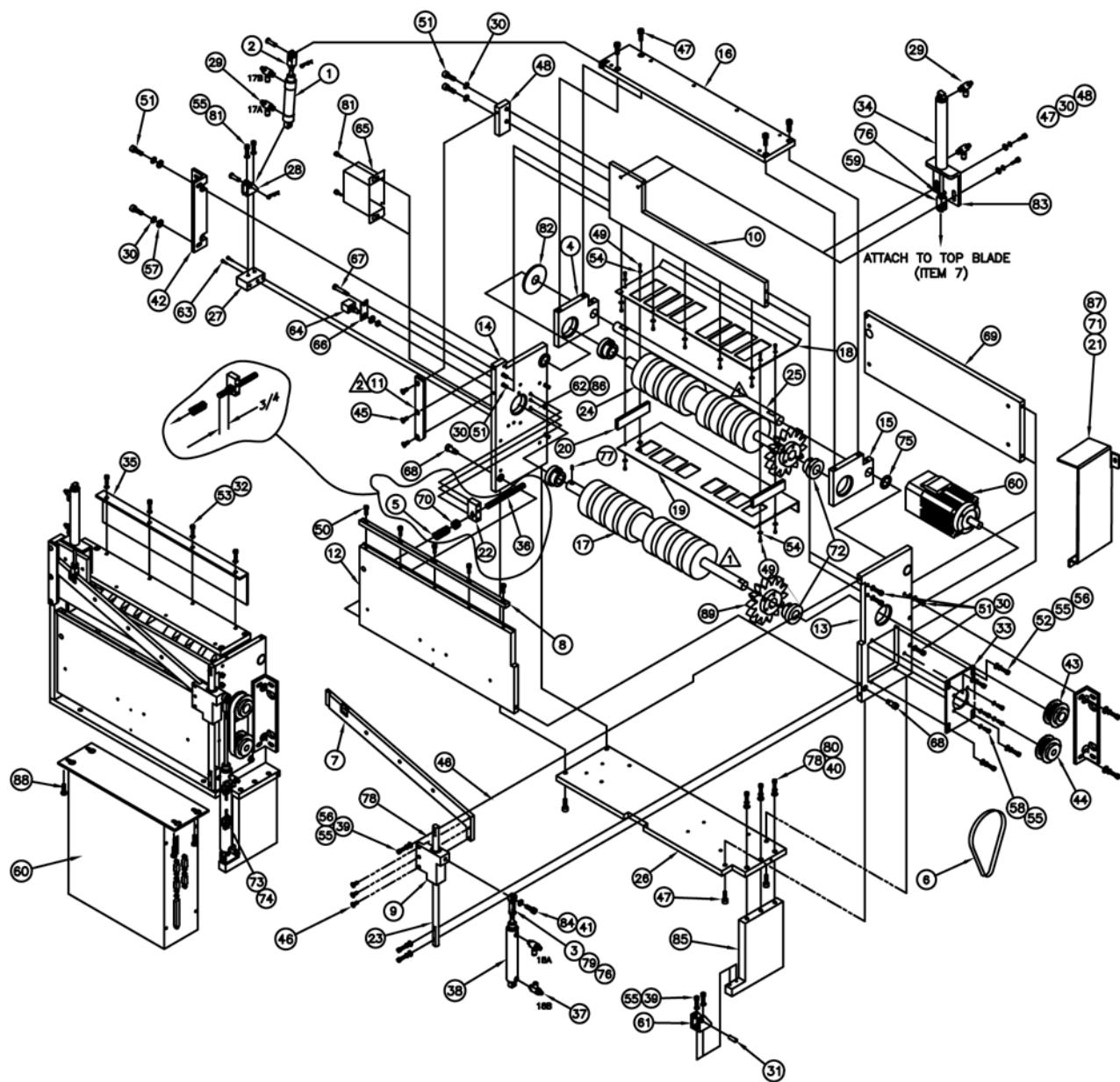
NO	QTY	PART #	DESCRIPTION
1	2	1330215	BRACE, FRAME
2	1	3200212	PLATE, CASTER EXTENSION
3	1	3200364	CONTROL PANEL
4	1	3261002	FRAME, JOINING, 36"
5	1	32003000PA1	MAIN FRAME ASSEMBLY
6	1	32004000PB1	GUILLOTINE ASSEMBLY
7	AR	332P30Z1-PD	DIAGRAM, PNEUMATIC
8	AR	332P30Z1-WD	DIAGRAM, WIRING
9	1	33004033A	BRKT, GUARD, RIGHT SIDE
10	1	33004034B	GUARD, TOP HALF, 3300RA
11	1	33004035	GUARD, BOTTOM
12	1	33004037	BRKT, GUARD, LEFT SIDE
13	1	33004048B	SHIELD, TOP, GUILLOTINE
14	1	33004055A	COVER, BOTTOM GUILLOTINE
15	AR	3300A-FEEDPAR	PARAMETER SETTINGS
16	1	98-6819a	BRKT, CORNER 2 x 10-32
17	2	NNH1/4-20	NUT, HEX, 1/4-20
18	2	NNK1/4-20	NUT, KEP, 1/4-20
19	4	SSHC01112	HEX HEAD BOLT 1/4-20X1.75
20	8	WWFS1/4	WASHER, FLAT, SAE, 1/4
21	2	WWL1/4	WASHER, LOCK, 1/4
22	AR	SPEC. LABEL	MACHINE ELEC. SPECS



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 1/4-20X5/8
30	2	SSHCO1064	SCREW, HEX CAP 1/4-20X 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



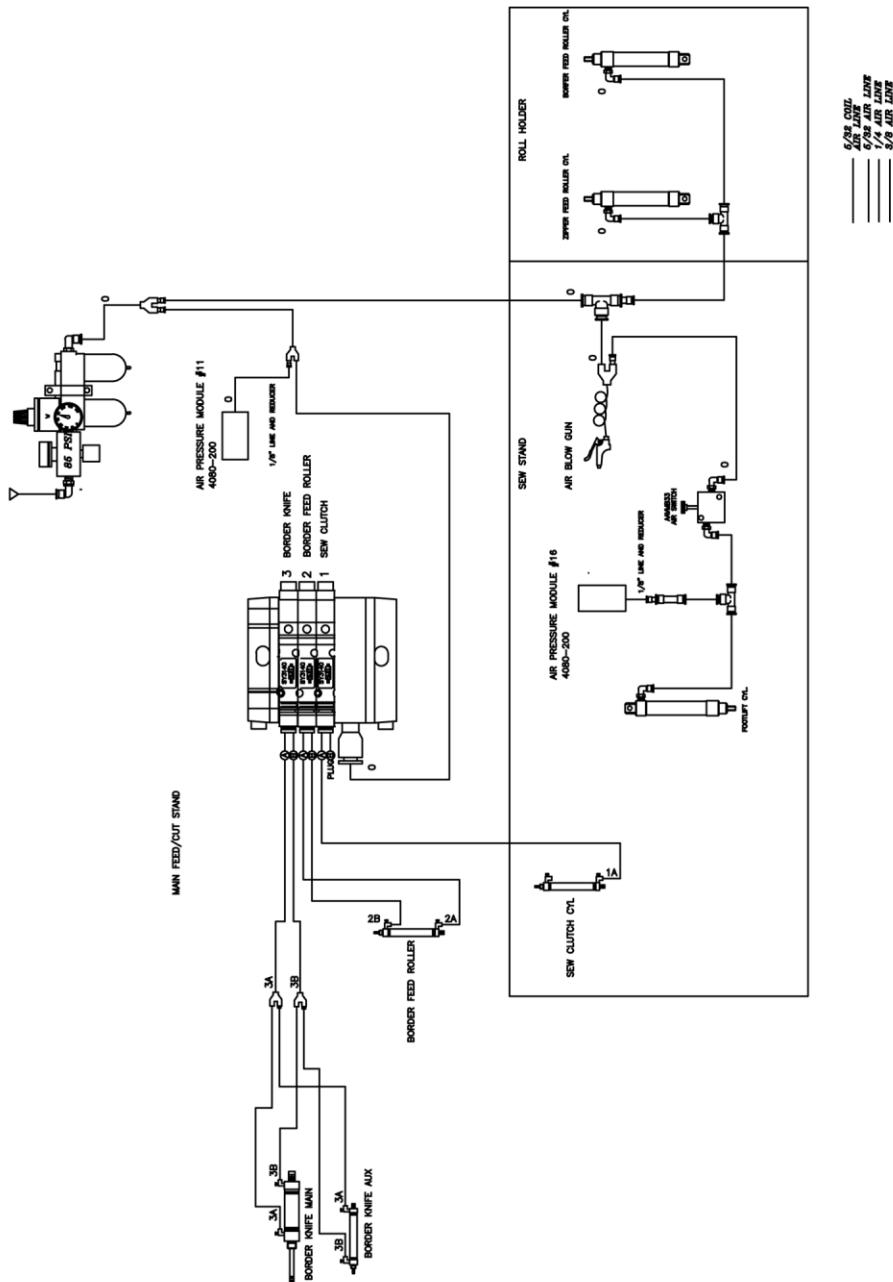
32004000PB1 Guillotine Assembly

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 X 5/8
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	AAFD35875-11	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	WWS110	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				

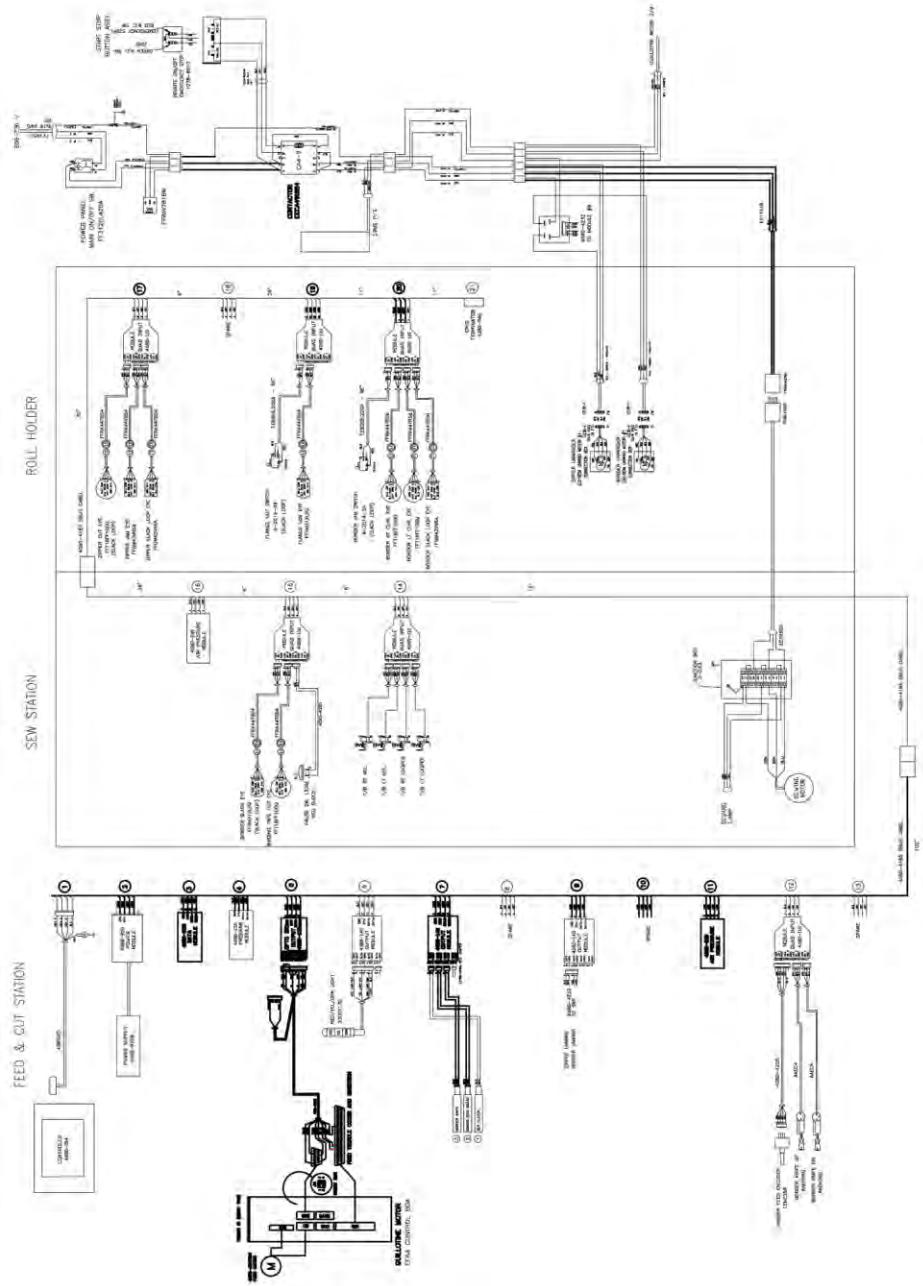
332P30Z1-PD PNEUMATIC DIAGRAM

AAC Drawing Number 125976A



332P30Z1-WD WIRING DIAGRAM

AAC Drawing Number 125975A





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