

Innovative Technology For The Sewn Products Industry World Wide

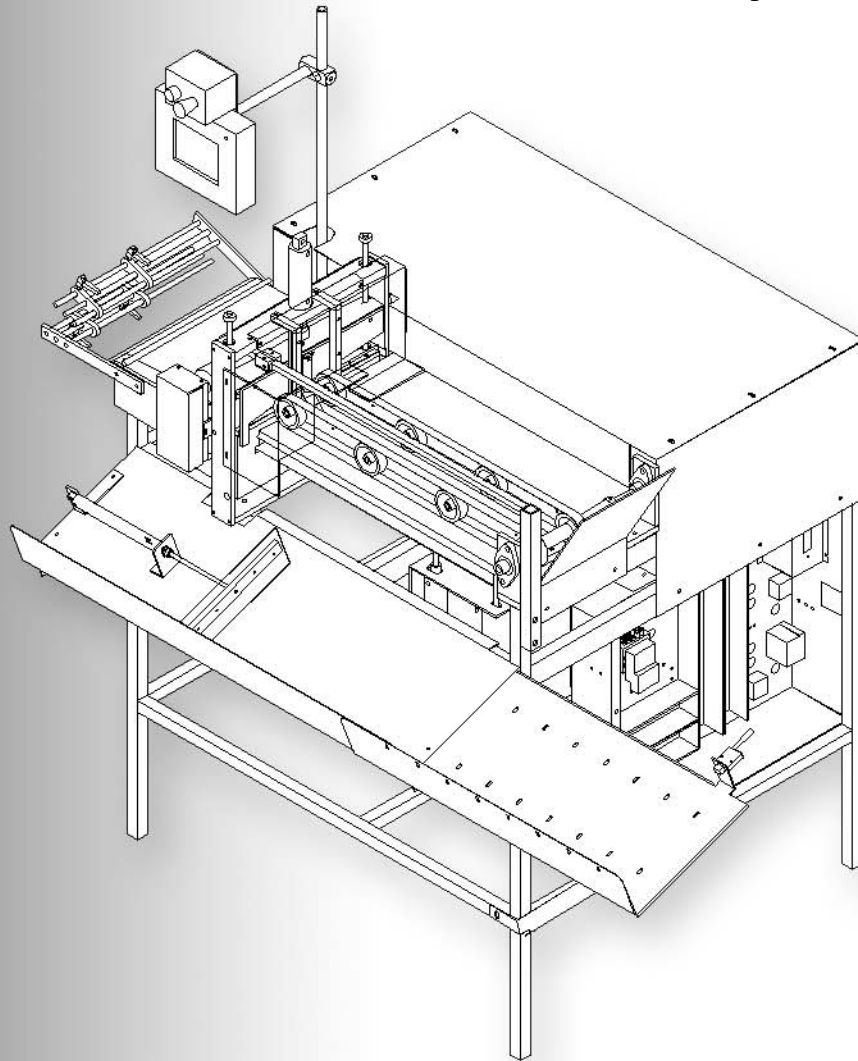
996A

Collar & Cuff Cutter w/ Stacker

Assembly Drawings & Parts Lists

Revision 3

Updated: January 19, 2004



ATLANTA ATTACHMENT COMPANY

Atlanta Attachment Company
401 Industrial Park Dr.
Lawrenceville, GA 30045
Phone: 770-963-7369
www.atlatt.com

Atlanta Attachment Company, Inc.

Confidential And Proprietary Information

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.

All materials contained herein are additionally protected by United States Copyright law and may not be used, disclosed, reproduced, distributed, published or sold without the express written consent of Atlanta Attachment Company, which consent may be withheld in Atlanta Attachment Company's sole discretion. You may not alter or remove any copyright, trademark or other notice from copies of these materials.

Patents & Patents Pending

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

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

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

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

Other U.S. and Foreign Patents Pending.



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.

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

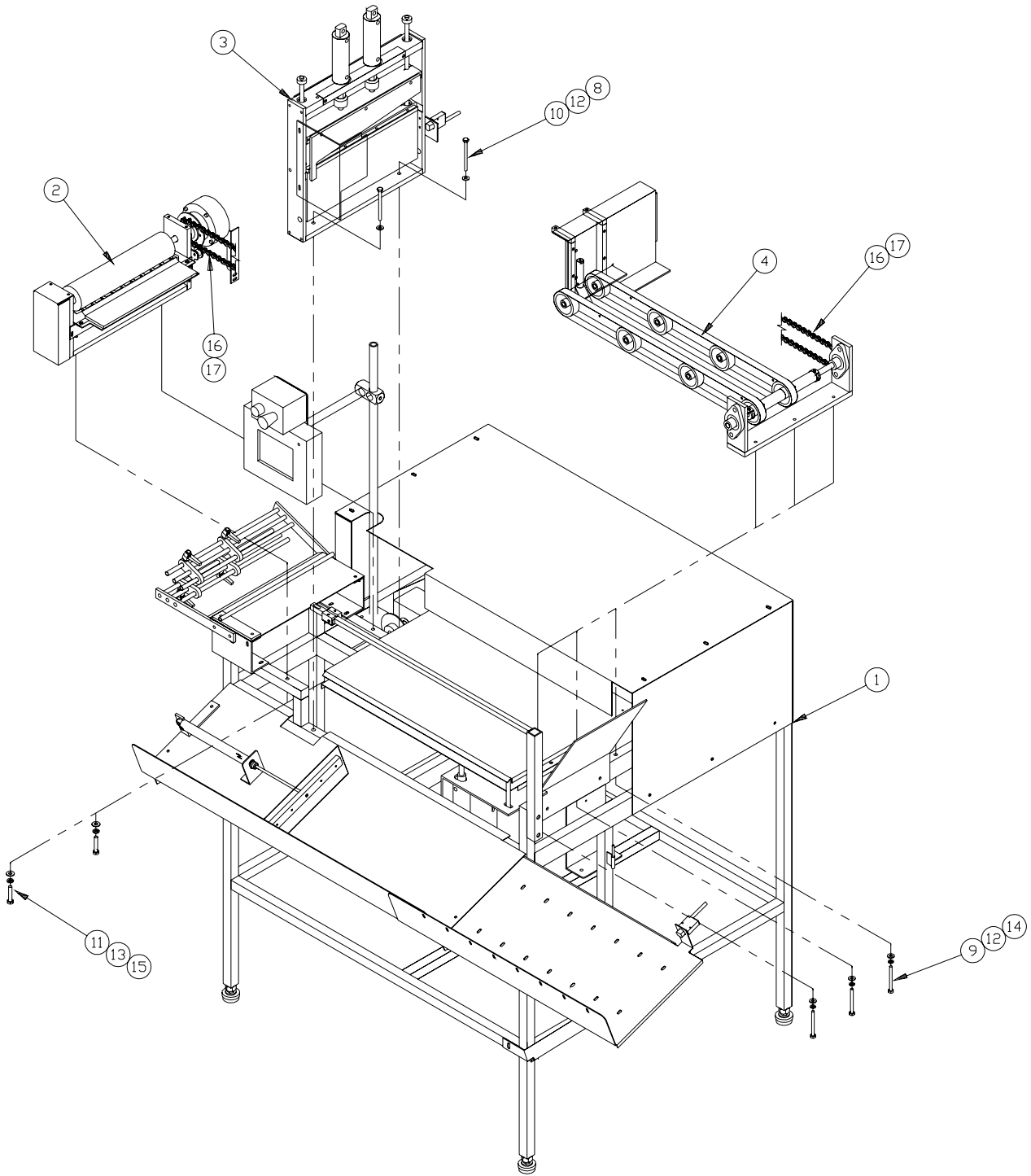
Table Of Contents

996A Collar & Cuff Cutter w/ Stacker 3
96-1000 Table & Stand Assembly 5
96-2000 Feed Roller Assembly 7
96-3000A Cutter Assembly 9
96-4000 Conveyor Assembly 11
96-5200 Stacker Table Assembly 13
96-5300 Pusher Assembly 15
96-5400 Trap Door Assembly 17
96-5500 Drop Shelf Assembly 19
96-5600 Infeed Table Assembly 21
96-9000 Electronics Assembly 23
97-1700 Touch Screen Assembly 25
996-PD Pneumatic Diagram 26
996-WD Wiring Diagram 27

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.

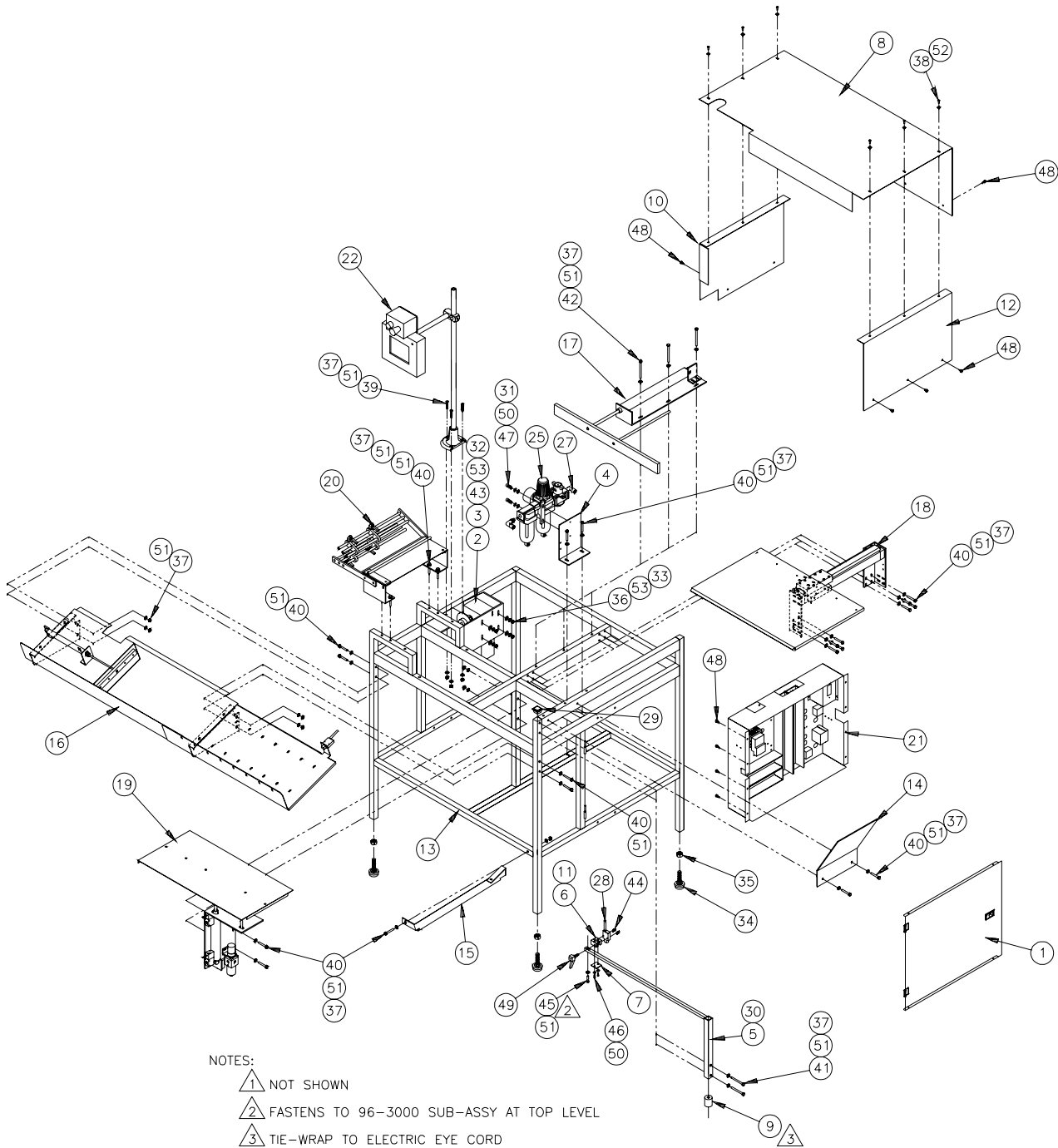




996A Collar & Cuff Cutter w/ Stacker

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	96-1000	Table & Stand	1	5	10	SSHC01192	Screw, Hex Cap	2	
2	96-2000	Feed Roller Assy	1	7	11	SSHC10096	Screw, Hex Cap	2	
3	96-3000A	Cutter Assy	1	9	12	WWFS1/4	Flat Washer	5	
4	96-4000	Conveyor Assy	1	11	13	WWFS5/16	Flat Washer	2	
5	996-LAB	Label	1		14	WWL1/4	Lock Washer	3	
6	996-PD	Pneumatic Diagram	1	26	15	WWL5/16	Lock Washer	2	
7	996-WD	Wiring Diagram	1	27	16	MM25	Rivet Chain, #25	96"	
8	NNK1/4-20	Kep Nut	2		17	MM25L	Connecting Link	2	
9	SSHC01160	Screw, Hex Cap	3		AAC Drawing Number 192801C Rev. 0				

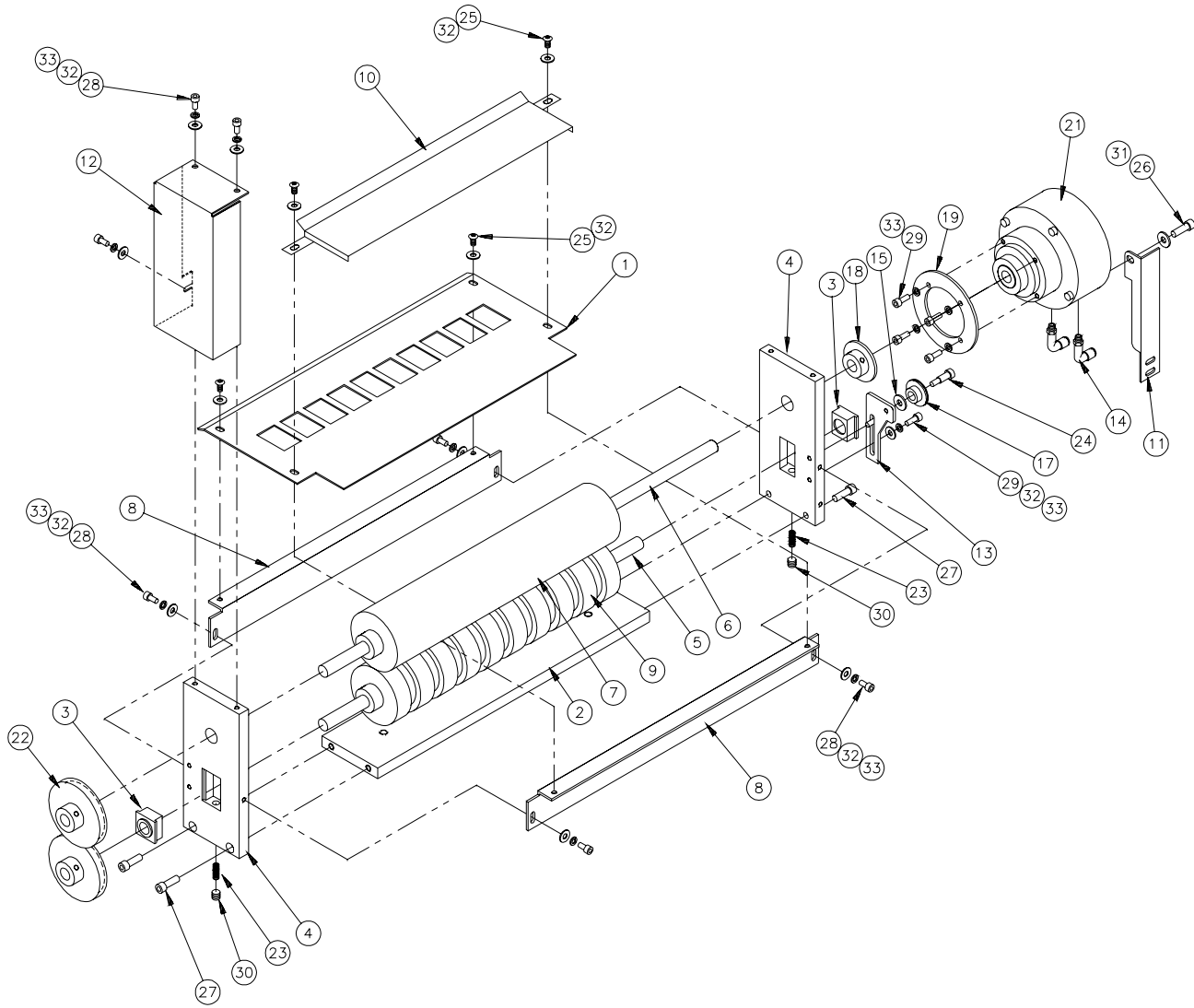




96-1000 Table & Stand Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	010-122	Door	1		28	FFSM312LVQ	Electric Eye	1	
2	1961-181	Key	1		29	MM132-1202	End Cap	1	
3	23218D	Gear Motor	1		30	MM1910A43	Adhesive Ruler	1	
4	4130-004	Regulator Brkt	1		31	WWL8	Lock Washer	2	
5	96-1006	Sensor Frame	1		32	MM25B403/4M	Drive Sprocket	1	
6	96-1007	Eye Mnt Clamp	1		33	WWL5/16	Lock Washer	4	
7	96-1008	Eye Cable Clamp	1		34	MMFB4444	Rubber Foot	4	
8	96-1011	Cover	1		35	NNH1/2-13	Hex Nut	4	
9	96-1012	Weight	1		36	NNH5/16-18	Hex Nut	4	
10	96-1013	Left Cover	1		37	NNK1/4-20	Keq Nut	31	
11	96-1014	Scale Brkt	1		38	SSBC98032	Screw, Button Cap	6	
12	96-1015	Right Cover	1		39	SSFC01064	Screw, Flat Allen	3	
13	96-1100	Stand Weldment	1		40	SSHC01112	Screw, Hex Cap	23	
14	96-1124	Conveyor Support Brkt	1		41	SSHC01160	Screw, Hex Cap	2	
15	96-1125	Support Brkt	1		42	SSHC01192	Screw, Hex Cap	3	
16	96-5200	Stacker Table	1	13	43	SSHC10064	Screw, Hex Cap	4	
17	96-5300	Pusher	1	15	44	SSPS70048	Screw, Pan Head	2	
18	96-5400	Trap Door Assy	1	17	45	SSSC01064	Screw, Socket Cap	1	
19	96-5500	Drop Shelf Assy	1	19	46	SSSC90024	Screw, Socket Cap	2	
20	96-5600	Infeed Table Assy	1	21	47	SSSC90048	Screw, Socket Cap	2	
21	96-9000	Electronics Assy	1	23	48	SSZS93032	Screw, Sheet Metal	18	
22	97-1700	Touch Screen Assy	1	25	49	TTH32415	Threaded Handle	1	
23	996-PD	Pneumatic Diagram	1	26	50	WWF8	Flat Washer	4	
24	996-WD	Wiring Diagram	1	27	51	WWFS1/4	Flat Washer	61	
25	AA198-5110	Regulator Assy	1		52	WWFS10	Flat Washer	6	
26	AA2000F-03	Flow Control	1		53	WWFS5/16	Flat Washer	8	
27	AAQME-4-4	Quick Male Elbow	2		AAC Drawing Number 192523C Rev. 0				

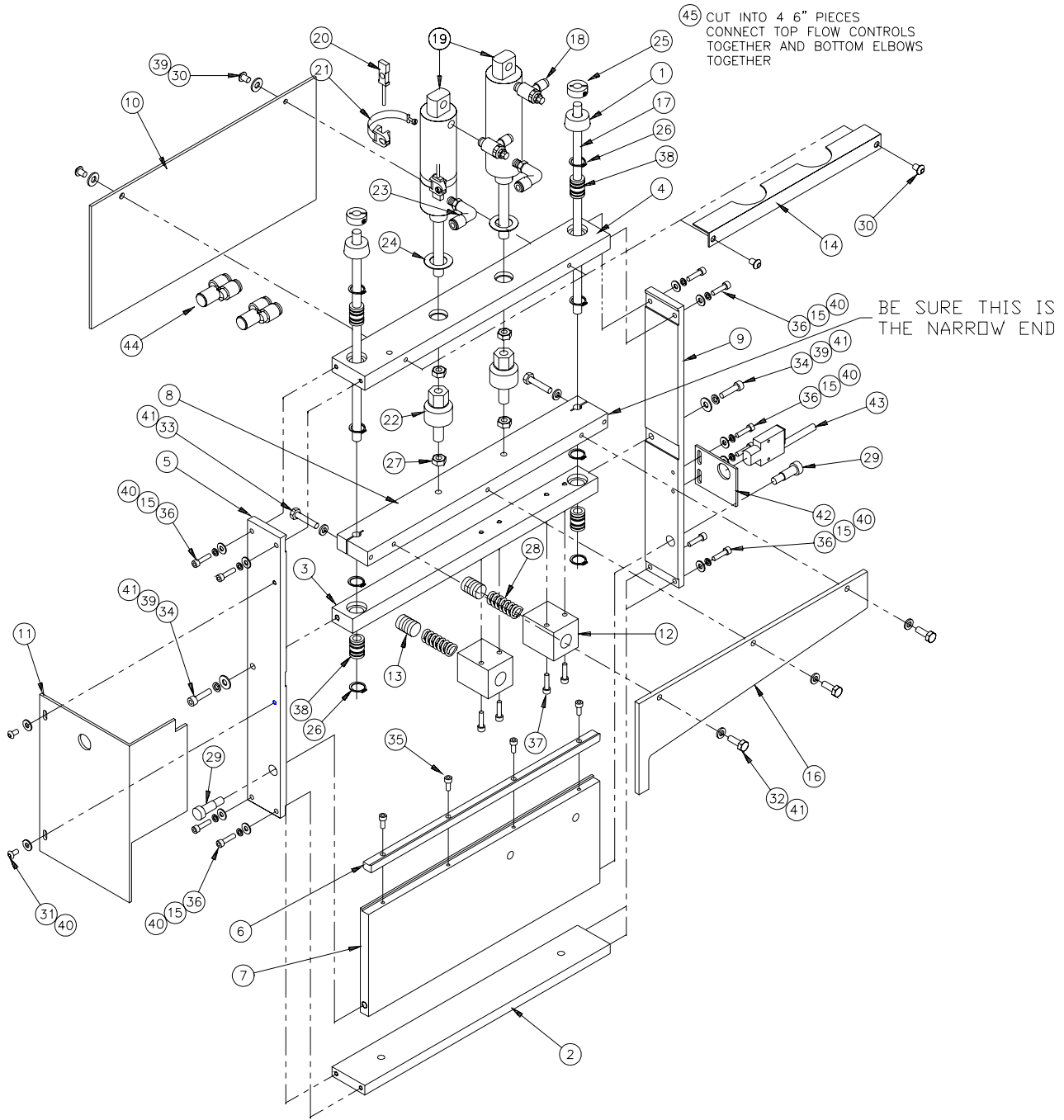




96-2000 Feed Roller Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	96-2001	Roller Guard	1		18	MM25B181/2M	Idler Sprocket	1	
2	96-2002	Bottom Plate	1		19	MM25B402.13M	Clutch Sprocket	1	
3	96-2003	Floating Block	2		20	MM25L	Chain Link	1	
4	96-2004	Side Plate	2		21	MM826051	Clutch-Brake	1	
5	96-2007	Bottom Roller Shaft	1		22	MMGQHH201/2M	Gear, 8 dp	2	
6	96-2008	Clutch Shaft	1		23	RRLC040C15	Spring	2	
7	96-2009	Drive Roller	1		24	SSAS016032	Screw, Allen Shoulder	1	
8	96-2010	Guard Mount	2		25	SSBC98024	Screw, Button Cap	4	
9	96-2011	Driven Roller	1		26	SSSC01032	Screw, Socket Cap	1	
10	96-2012	Stripper Plate	1		27	SSSC01048	Screw, Socket Cap	4	
11	96-2013	Anti-Rotation Brkt	1		28	SSSC98024	Screw, Socket Cap	7	
12	96-2014	Gear Cover	1		29	SSSC98032	Screw, Socket Cap	6	
13	96-2015	Idler Sprocket Brkt	1		30	SSSS20024	Screw, Socket Set	2	
14	AAQME-4-4	Quick Male Elbow	2		31	WWFS1/4	Flat Washer	1	
15	BBTT601	Thrust Washer	1		32	WWFS10	Flat Washer	13	
16	MM25	Chain	25.375"		33	WWL10	Lock Washer	13	
17	MM25B123/8M	Idler Sprocket	1		AAC Drawing Number 192524C Rev. 0				



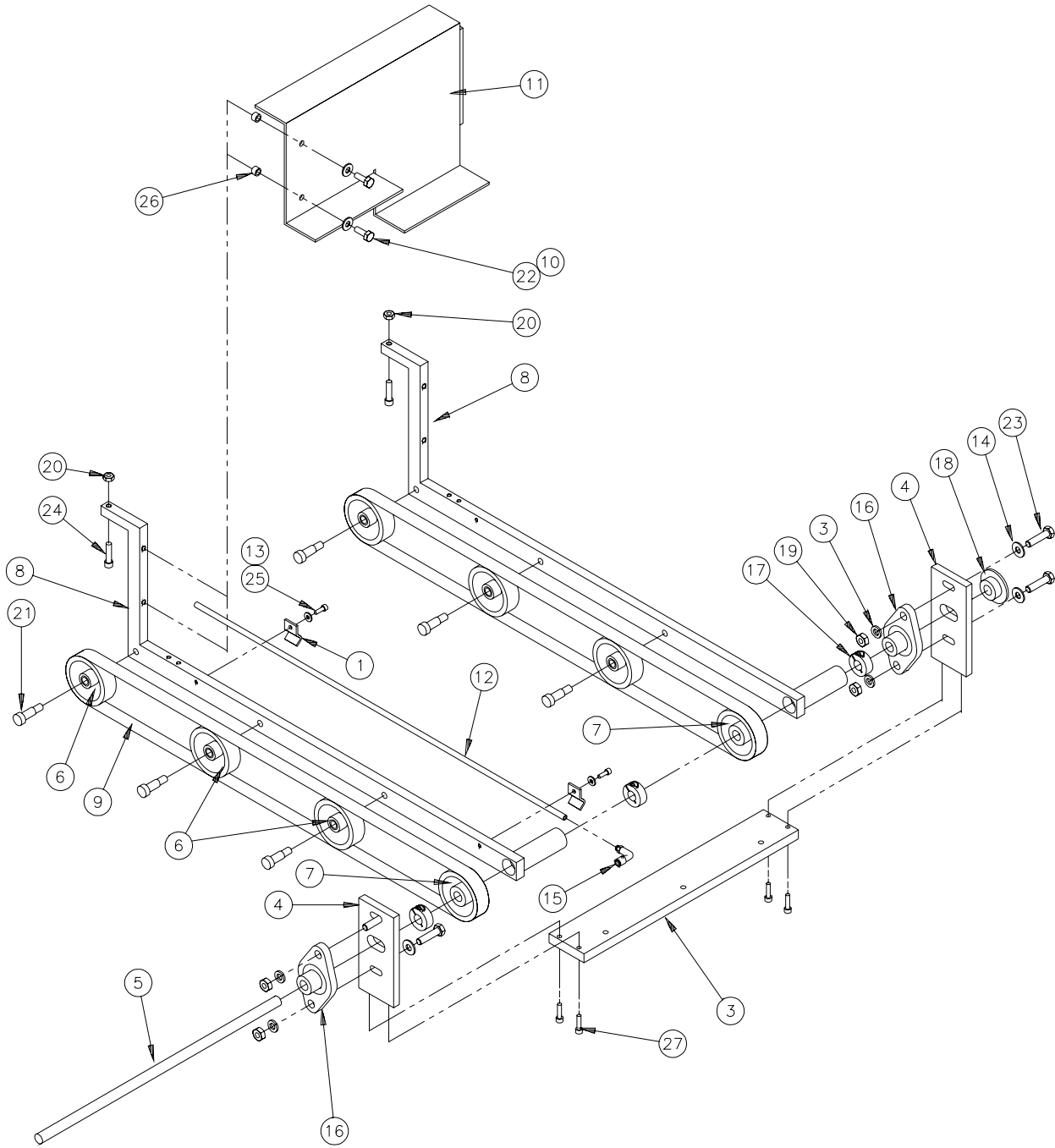


96-3000A Cutter Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1981-804	Bumper	2		24	BBTRA1220	Thrust Washer	2	
2	96-3101	Bottom Plate	1		25	CCCL6F	Clamp Collar	2	
3	96-3102A	Middle Plate	1		26	MM8410A126	Retaining Ring	8	
4	96-3103A	Top Plate	1		27	NNJ7/16-20	Jam Nut	4	
5	96-3104	RH Side Plate	1		28	RRLC092H6	Spring	2	
6	96-3107	Bottom Blade	1		29	SSAS024048	Screw, Allen Shoulder	2	
7	96-3108A	Hinge Plate	1		30	SSBC01024	Screw, Button Cap	4	
8	96-3111A	Mounting Block	1		31	SSBC98024	Screw, Button Cap	2	
9	96-3115	LH Side Plate	1		32	SSHC01048	Screw, Hex Cap	3	
10	96-3117	Front Guard	1		33	SSHC01080	Screw, Hex Cap	2	
11	96-3118	Rear Guard, Left	1		34	SSSC01048	Screw, Socket Cap	2	
12	96-3121	Spring Block	2		35	SSSC98032	Screw, Socket Cap	4	
13	96-3122	Screw	2		36	SSSC98048	Screw, Socket Cap	10	
14	96-3123A	Conveyor Brkt	1		37	SSSC98096	Screw, Socket Cap	4	
15	WWL10	Lock Washer	10		38	UUFL06	Bearing	4	
16	98-3109	Upper Blade	1		39	WWFS1/4	Flat Washer	4	
17	98-3114	Shaft	2		40	WWFS10	Flat Washer	10	
18	AA198RA408	Flow Control	2		41	WWL1/4	Lock Washer	7	
19	AAC172DPM	Air Cylinder	2		42	96-1002	Eye Brkt	1	
20	AAEHSKQ	Switch	1		43	FFSM312LVQ	Electric Eye	1	
21	AAFD35875-12	Band For AAEHSKQ	1		44	AAQYU-4-4	Quick Union "Y"	2	
22	AAFNJ07	Alignment Coupling	2		45	AATP4-1	Airline	2'	
23	AAQME-4-8	Quick Male Elbow	2						

AAC Drawing Number 192800C Rev. 0

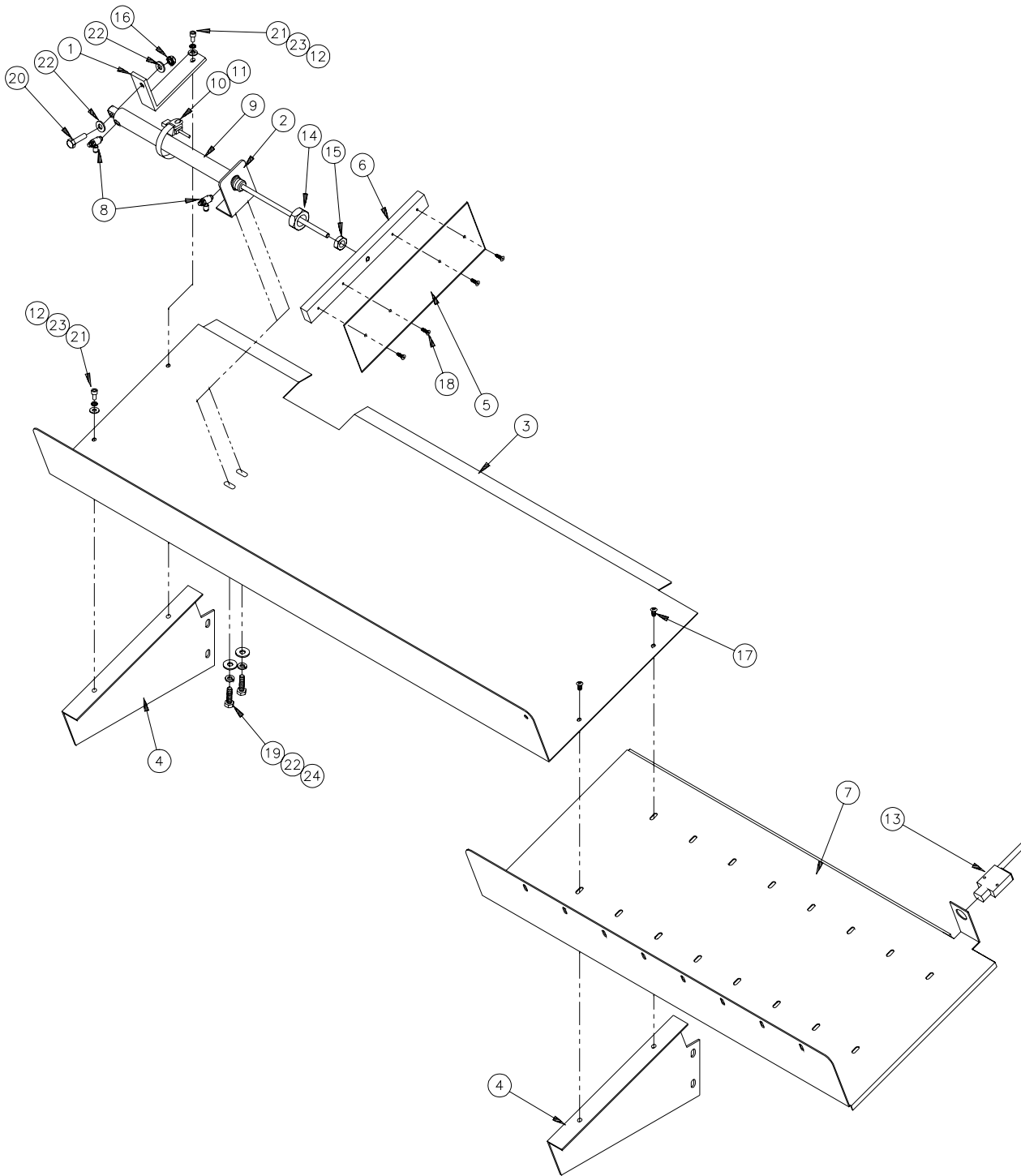




96-4000 Conveyor Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	0411-2126	Tube Clamp	2		15	AAQME-5-10	Quick Male Elbow	2	
2	WWL5/16	Lock Washer	4		16	BBMF2S-208	Bearing	2	
3	96-4001	Base Plate	1		17	CCCL8F	Clamp Collar	3	
4	96-4002	Mount Plate	2		18	MM25B181/2M	Idler Sprocket	1	
5	96-4003	Flat Shaft	1		19	NNH5/16-18	Hex Nut	4	
6	96-4004	Idler Roller	6		20	NNJ1/4-20	Jam Nut	2	
7	96-4009	Idler Roller	2		21	SSAS024048	Screw, Allen Shoulder	6	
8	96-4010	Conveyor Frame	2		22	SSHC01048	Screw, Hex Cap	2	
9	96-4011	Belt	2		23	SSHC10080	Screw, Hex Cap	4	
10	WWFS1/4	Flat Washer	2		24	SSSC01064	Screw, Socket Cap	2	
11	96-4014	Right Rear Guard	1		25	SSSC90032	Screw, Socket Cap	2	
12	96-4015	Air Tube	1		26	UUA304-35	Bronze Bearing	2	
13	WWF8	Flat Washer	2		27	SSSC98048	Screw, Socket Cap	4	
14	WWF5/16	Flat Washer	4		AAC Drawing Number 192526C Rev. 2				

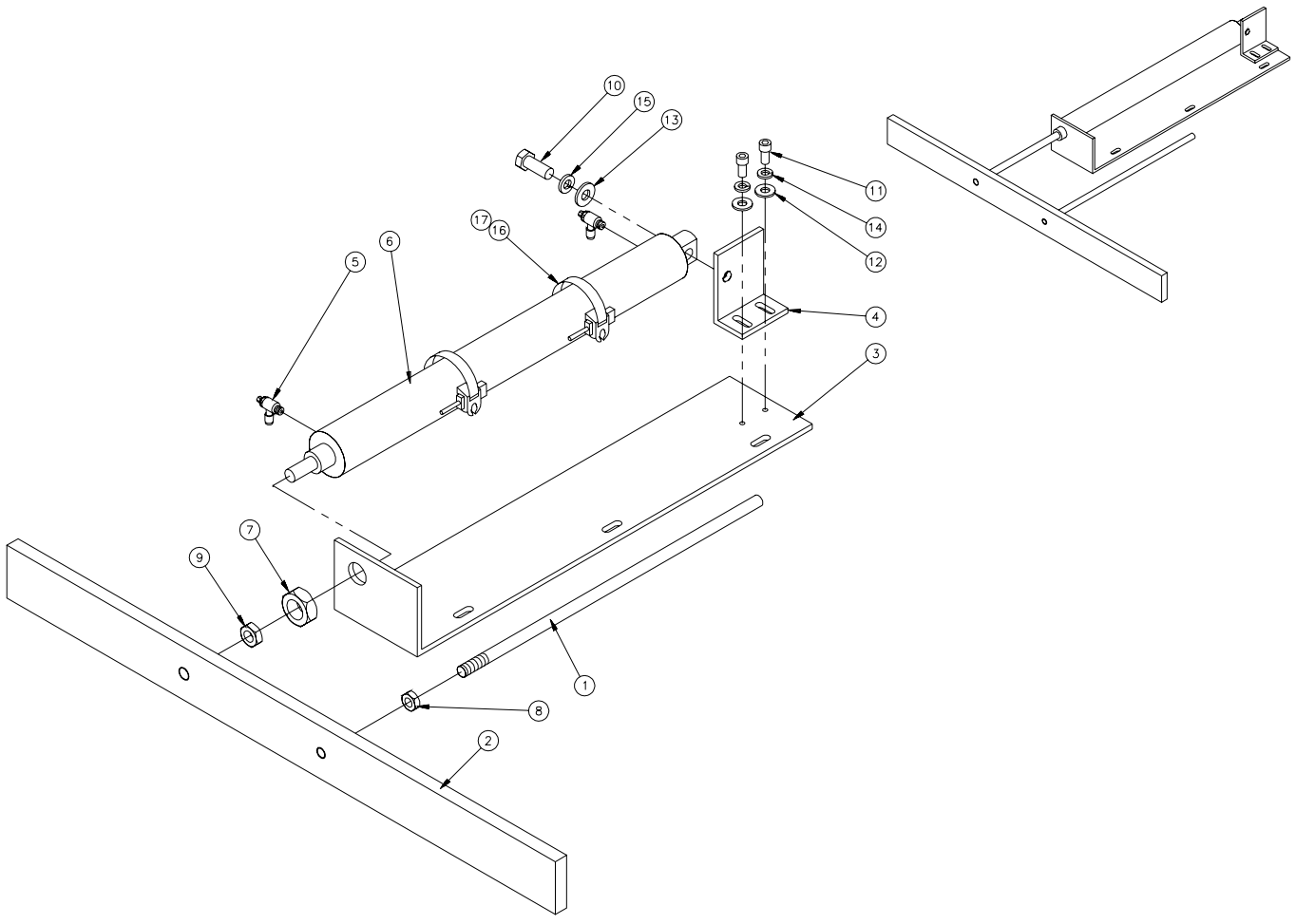




96-5200 Stacker Table Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	96-5201	Cylinder Brkt	1		14	NNJ3/4-16	Jam Nut	1	
2	96-5202	Cylinder Mount	1		15	NNJ7/16-20	Jam Nut	1	
3	96-5203	Stacker Plate	1		16	NNK1/4-20	Keq Nut	1	
4	96-5204	Support Brkt	2		17	SSBC98024	Screw, Button Cap	2	
5	96-5205	Pushing Plate	1		18	SSFC90024	Screw, Flat Allen	4	
6	96-5206	Plate Mount	1		19	SSHC01032	Screw, Hex Cap	2	
7	96-5208	Stacker Plate Ex.	1		20	SSSC01064	Screw, Socket Cap	1	
8	AA198RA508	Flow Control	2		21	SSSC98024	Screw, Socket Cap	2	
9	AACM046DXP	Air Cylinder	1		22	WWFS1/4	Flat Washer	4	
10	AAEHSKQ	Switch	1		23	WWFS10	Flat Washer	2	
11	AAFD35456-6	Band For AAEHSKQ	1		24	WWL1/4	Lock Washer	2	
12	WWL10	Lock Washer	2		AAC Drawing Number 192527C Rev. 0				
13	FFSM312LVQ	Electric Eye	1						

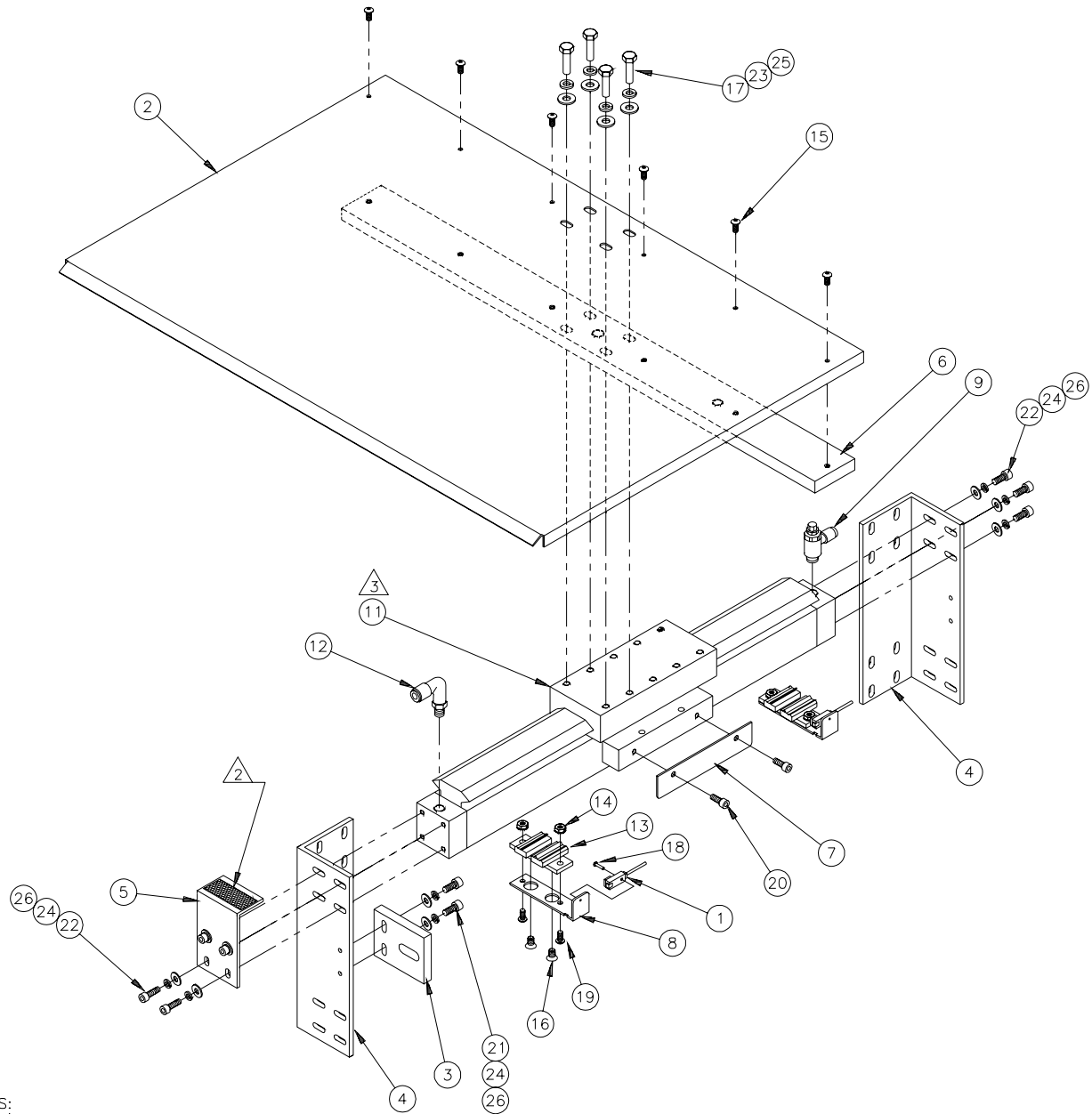




96-5300 Pusher Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	96-5301	Guide Rod	1		10	SSHC35064	Screw, Hex Cap	1	
2	96-5302	Pushing Plate	1		11	SSSC01032	Screw, Socket Cap	2	
3	96-5303	Cylinder Mount	1		12	WWFS1/4	Flat Washer	2	
4	96-5304	Cylinder Mount	1		13	WWFS3/8	Lock Washer	1	
5	AA198RA508	Flow Control	2		14	WWL1/4	Lock Washer	2	
6	AAC1712DPM	Air Cylinder	1		15	WWL3/8	Lock Washer	1	
7	NNJ3/4-16	Jam Nut	1		16	AAEHKQ	Switch	2	
8	NNJ3/8-16	Jam Nut	1		17	AAFD35875-12	Band For AAEHKSQ	2	
9	NNJ7/16-20	Jam Nut	1		AAC Drawing Number 192528C Rev. 1				





NOTES:

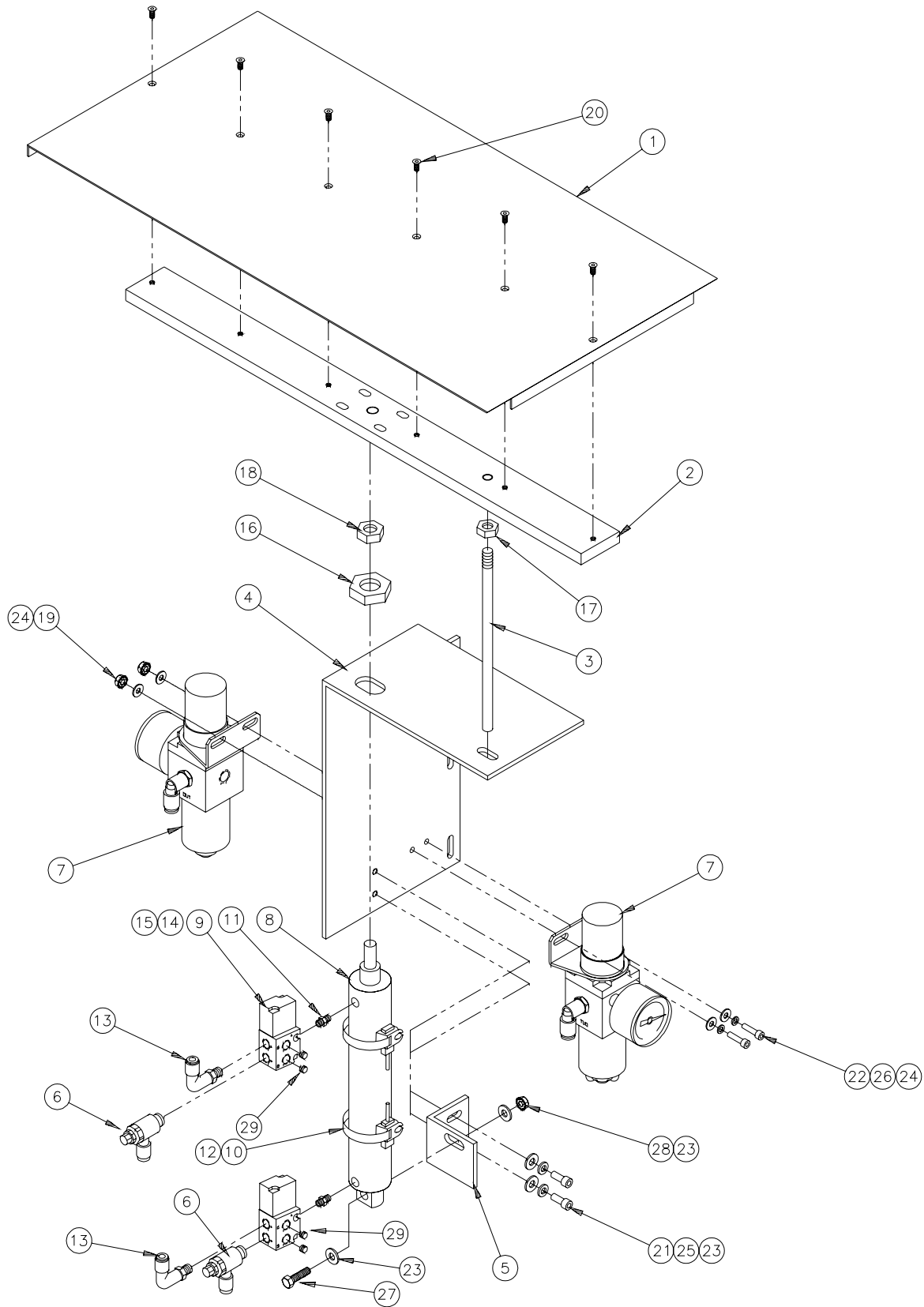
- ① NOT SHOWN
- ② ADD TEFLON TAPE
- ③ GRIND EXISTING BOLTS ON UNDERSIDE DOWN TO THE NUT TO AVOID COLLISION WITH ITEM 8



96-5400 Trap Door Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1278-7055B	Prox Switch	2		15	SSBC80032	Screw, Button Cap	6	
2	96-5401	Pushing Plate	1		16	SSFC98024	Screw, Flat Allen	4	
3	96-5402	Guide Brkt	1		17	SSHC01064	Screw, Hex Cap	4	
4	96-5403	Cylinder Brkt	2		18	SSPS50024	Screw, Pan Head	2	
5	96-5404	Pushing Plate Brkt	1		19	SSPS90024	Screw, Pan Head	4	
6	96-5502	Shelf Mount	1		20	SSSC98024	Screw, Socket Cap	2	
7	98202008	Vane, Trans. Sensor	1		21	SSSC98032	Screw, Socket Cap	2	
8	98202009	Sensor Brkt	2		22	SSSC98040	Screw, Socket Cap	8	
9	AA198RA408	Flow Control	1		23	WWFS1/4	Flat Washer	4	
10	AA3000F-07	Flow Control	1		24	WWFS10	Flat Washer	10	
11	AACR203011.5	Air Cylinder	1		25	WWL1/4	Lock Washer	4	
12	AAQME-4-8	Quick Male Elbow	1		26	WWL10	Lock Washer	10	
13	MMNR7	Cylinder Support Brkt	2		AAC Drawing Number 192529C Rev. 0				
14	NNK8-32	Kep Nut	4						

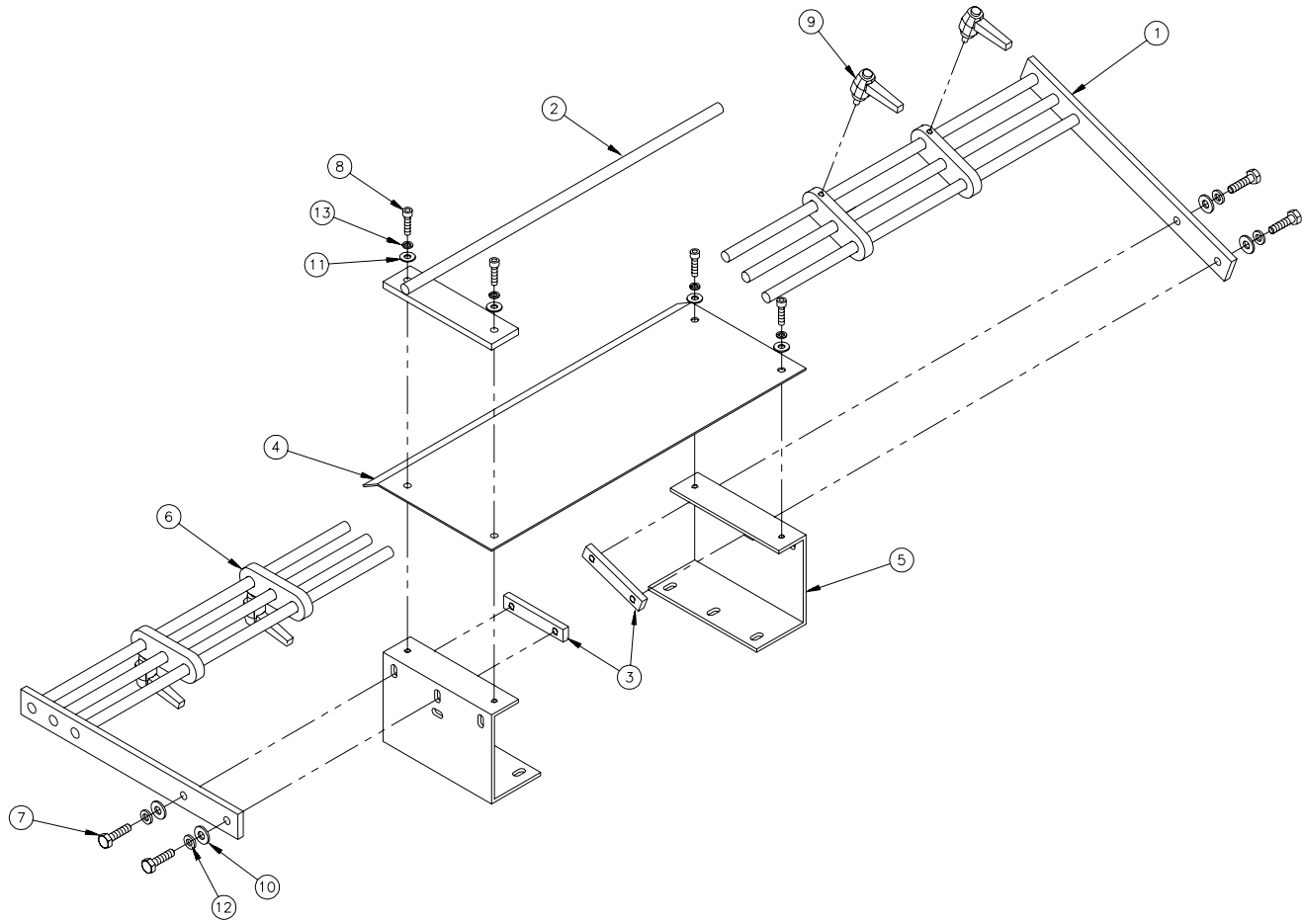




96-5500 Drop Shelf Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	96-5501	Shelf Plate	1		16	NNJ3/4-16	Jam Nut	1	
2	96-5502	Shelf Plate Mount	1		17	NNJ3/8-16	Jam Nut	1	
3	96-5503	Guide Rod	1		18	NNJ7/16-20	Jam Nut	1	
4	96-5504	Cylinder Brkt	1		19	NNK10-32	Kep Nut	2	
5	96-5505	Cylinder Brkt	1		20	SSFC80024	Screw, Flat Allen	6	
6	AA198RA508	Flow Control	2		21	SSSC01024	Screw, Socket Cap	2	
7	AA198-5102	Regulator	2		22	SSSC98048	Screw, Socket Cap	2	
8	AAC176DPM	Air Cylinder	1		23	WWFS1/4	Flat Washer	4	
9	AAE45A24D	Solenoid Valve	2		24	WWFS10	Flat Washer	4	
10	AAEHSKQ	Switch	2		25	WWL1/4	Lock Washer	2	
11	AAF122A-A	Nipple	2		26	WWL10	Lock Washer	2	
12	AAFD35875-12	Band For AAEHSKQ	2		27	SSHC01080	Screw, Hex Cap	1	
13	AAQME-4-8	Quick Male Elbow	2		28	NNK1/4-20	Kep Nut	1	
14	FF31F1022	Male Pin	4		29	MM4554K11	Pipe Plug	4	
15	FF59F1802	2 Pin Male Conn.	2		AAC Drawing Number 192530C Rev. 2				

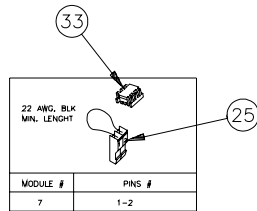
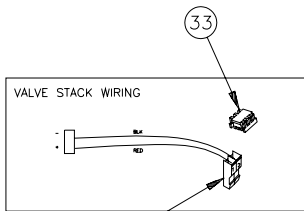
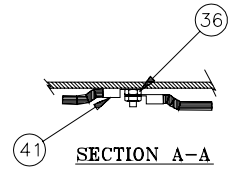
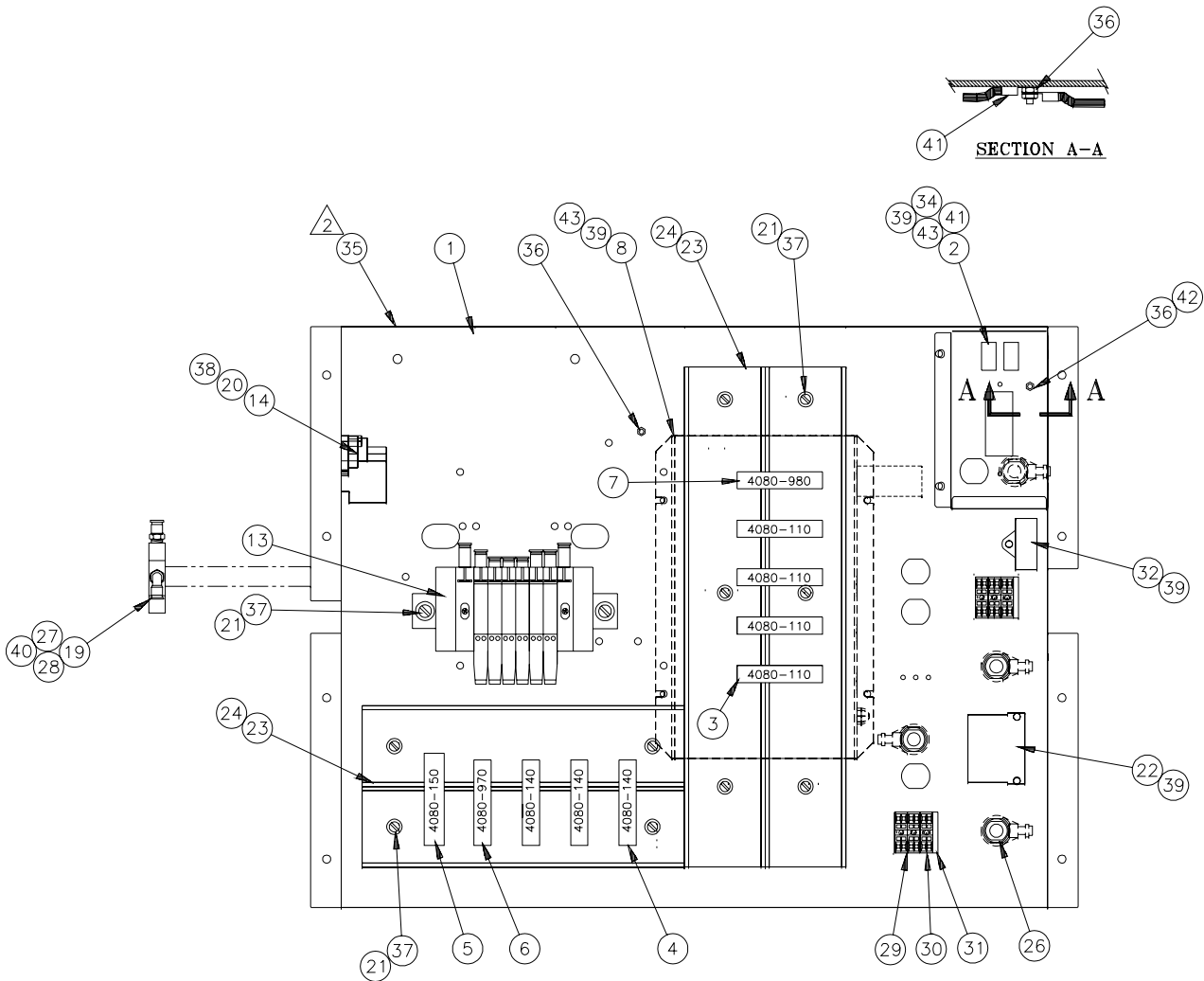




96-5600 Infeed Table Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	96-5601	Material Guide Assy	2		8	SSSC98048	Screw, Socket Cap	4	
2	96-5603	Material Guide Assy	1		9	TTH32410	Threaded Handle	4	
3	96-5606	Nut Plate	2		10	WWFS1/4	Flat Washer	4	
4	96-5608	Cloth Plate	1		11	WWFS10	Flat Washer	4	
5	96-5609	Material Guide Mount	2		12	WWL1/4	Lock Washer	4	
6	96-5610	Edge Guide	4		13	WWL10	Lock Washer	4	
7	SSHC01064	Screw, Hex Cap	4				AAC Drawing Number 192531C Rev. 2		





NOTES:

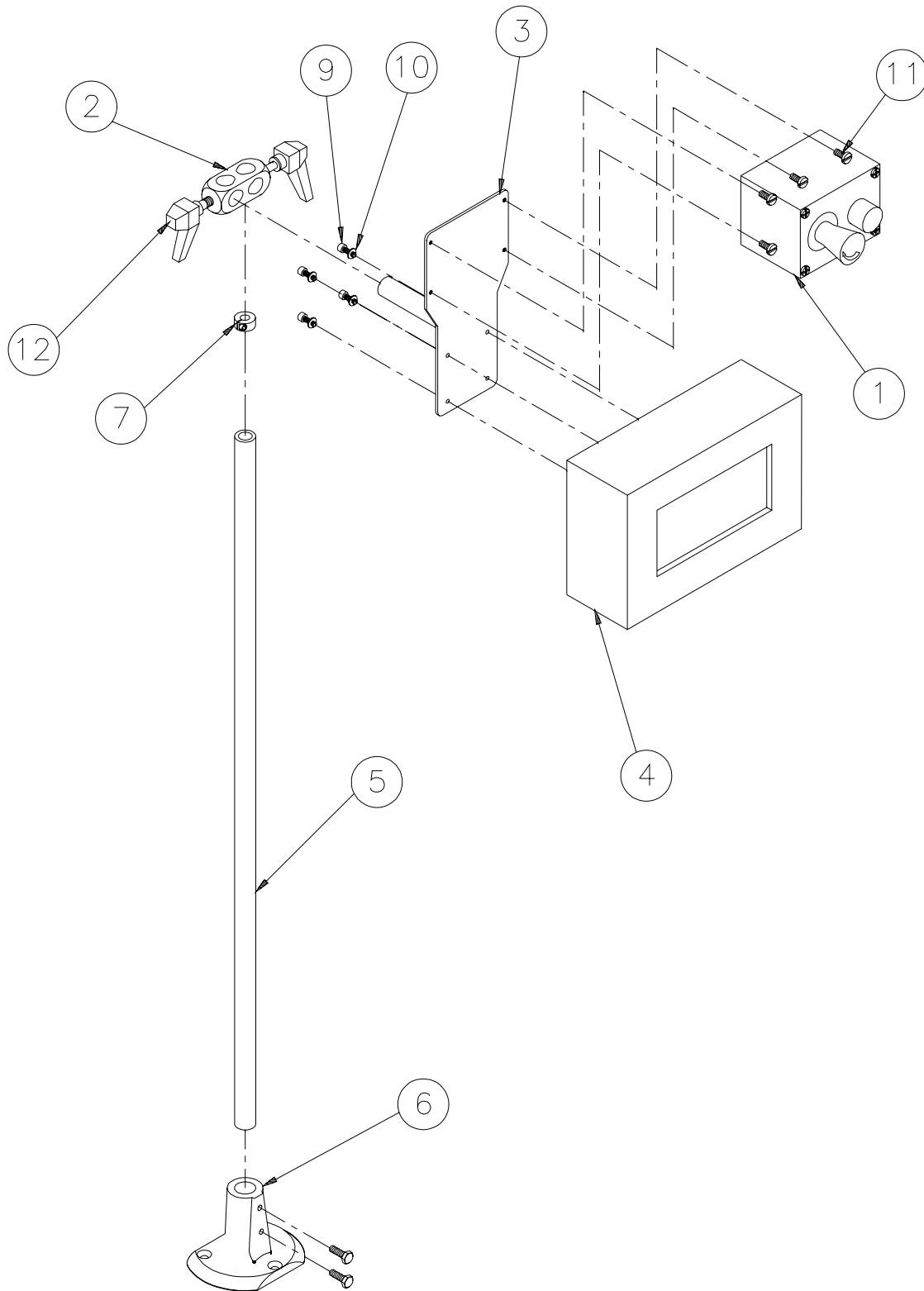
- ① NOT SHOWN. SEE WIRING DIAGRAM (996-WD) AND PNEUMATIC DIAGRAM (996-PD).
- ② USE DOOR TRIM TO LINE CUTOUTS ON TOP.



96-9000 Electronics Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	211-204	Electrical Panel	1		23	EEDC2X2	Wire Duct Cover	4.4'	
2	40-320	AC Power Disconnect	1		24	EEFD2X2	Wire Duct	4.4'	
3	4080-110	Quad Input Module	4		25	FF100F2202	2 Pin Connector	6	
4	4080-140	Quad Output Module	3		26	FF1724	Strain Relief	4	
5	4080-150	Program Module	1		27	AAQMC-5-8	Quick Male Connector	1	
6	4080-970	Memory Module	1		28	AAQME-5-8	Quick Male Elbow	2	
7	4080-980	Control Module	1		29	FF264-341	Dual Wago, Grey	6	
8	4080-990	Power Supply Box	1		30	FF264-347	Dual Wago, Green	2	
9	96-9001	Cable Package	1		31	FF264-371	Wago End, Grey	2	
10	96-LAB	Valve Label	1		32	FFRAV781BW	TVS Module	1	
11	996-PD	Pnuematic Diagram	1	26	33	FFSC10002	Strain Relief Cover	6	
12	996-WD	Wiring Diagram	1	27	34	FFY30306801	Terminal Adapter	2	
13	AAE996-6	Solenoid Assy	1		35	MM100-1/8	Door Trim	1'	
14	AAQME-5-10	Quick Male Elbow	1		36	NNK8-32	Kep Nut	2	
15	AAQPR-5-4	Reducer	5		37	SSPS98024	Screw, Pan Head	12	
16	AAQUT-4-4	Quick Union "T"	8		38	SSSC70024	Screw, Socket Cap	1	
17	AATP4-1	Airline	10'		39	SSSC90024	Screw, Socket Cap	11	
18	AATP5/32	Airline	10'		40	SSPS80048	Screw, Pan Head	2	
19	AAV125B	Pilot Valve	1		41	TTAA5261	Terminal	4	
20	AAVF51FM1B	Pressure Switch	1		42	TT5811	Terminal Ring	1	
21	WWFS10	Flat Washer	12		43	WWF8	Flat Washer	8	
22	EECA491024	Mini Contactor	1				AAC Drawing Number 192463C Rev. 3		





97-1700 Touch Screen Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1278-6010	Start/Stop Button	1		8	EE16-3C2406	Cable	10'	
2	28201	Cross Block	1		9	SSSC80032	Screw, Socket Cap	4	
3	40-112A	Touch Screen Mount	1		10	WWL6	Lock Washer	4	
4	4080-003	Serial Bus Controller	1		11	SSPS90040	Screw, Pan Head	4	
5	97-1711	Tube, 3/4 x 30 x 1/8	1		12	TTH32426	Threaded Handle	2	
6	AP-1721B	Stand Base	1		AAC Drawing Number 191886C Rev. 2				
7	CCCL12F	Clamp Collar	1						





Atlanta Attachment Company (AAC)

Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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