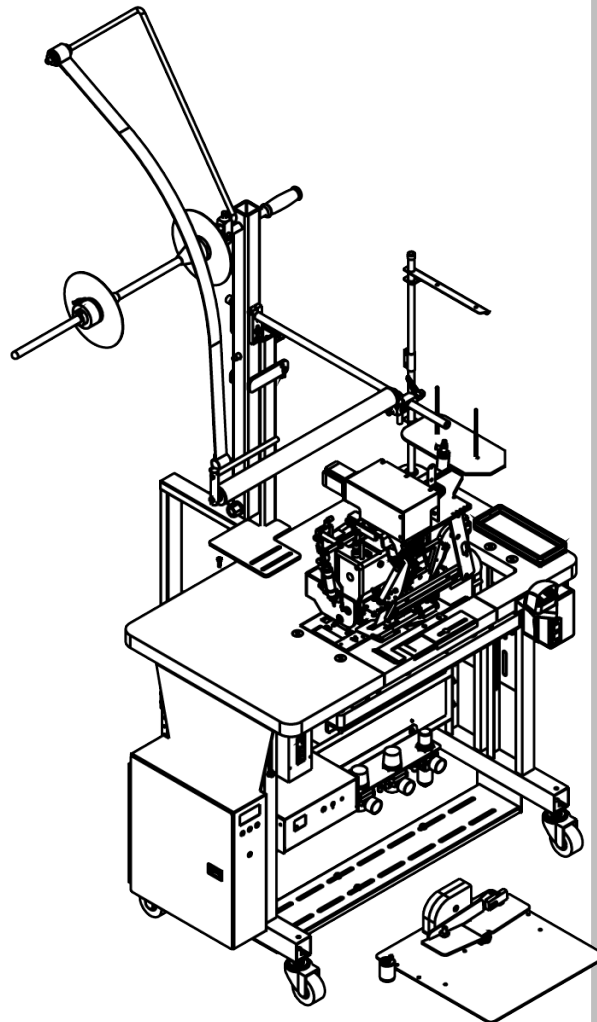




Model

# 1335ET

## Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

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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 1335E Manual Ruffler 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

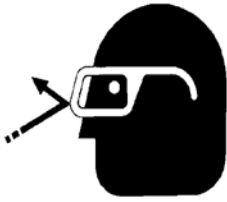
Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.

### 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 Specifications

Electrical:	220 VAC, 5amp, 50/60 Hz Single Phase
Pneumatic:	70-80 PSI, 2 SCFM avg.
Sewing Speed:	2500 RPM
Needle (Standard):	SN62X5722
Stitch Density:	6 SPI

## Installation & Setup

Provide a 220VAC, single phase, 5 Amp electrical drop and 1/4" air supply line (80 PSI).  
 Remove any shipping straps from machine.  
 Mount and adjust the Guide Roller Assembly.  
 Check the oil level in the oil pan.

## Control Box Operation

### Main Control Box:

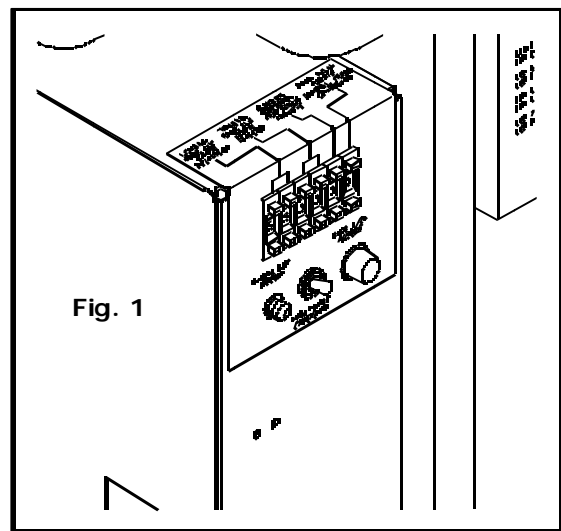
The front of the main control box has an Auto/Manual Switch, a Manual Ruffle Pushbutton, an Unwinder Reverse Switch, a Fuse Holder, and 6 Thumbwheels. On the back is the power entry socket and an on/off switch. Be sure the on/off switch is always on.

**Note: The on/off switch only switches one line and does not make the box safe to work on. Always disconnect the main power cord before servicing the control box.**

The Auto/Manual Switch turns on the automatic ruffling cycles for the corners. When this switch is in Manual, the ruffling is disabled and the machine will only sew, trim, and foot lift.

The Manual Ruffle pushbutton turns on one ruffle cycle and also functions as the Reset button for the automatic cycle. Pushing this button once will turn on the ruffle cycle. Pushing it a second time will reset the automatic program and cause the ruffle hardware to reset and go to its "Home" position. Use this button to reset the ruffler after adjusting the ruffle size.

The Fuse Holder fuses the entire machine. Replace the fuse with a 5A Slow Blow 250v as necessary.

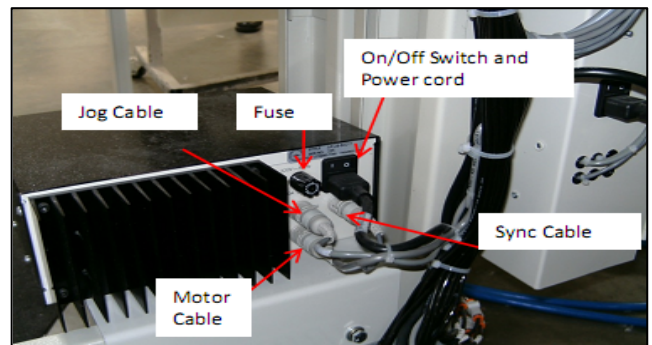
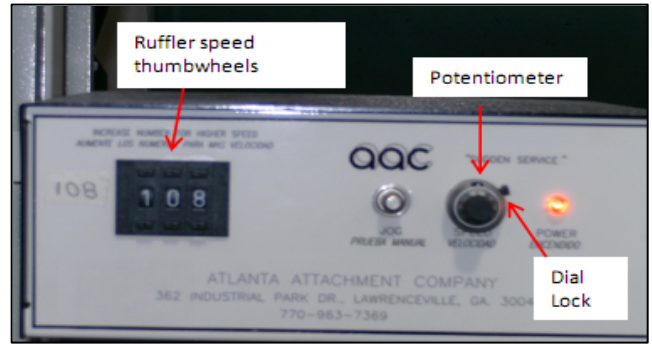


## Stepping Motor Control Box

The stepping motor box is located under the table.

The Ruffler box has three thumbwheels on the front which are set to synchronize the Ruffler to the sewing head. The number is proportional to the stitch length and is not affected by sewing speed. The 10-turn potentiometer is used to set the speed of the Ruffler during the feed in to pleat and feed out to make the next ruffle. It is set based on the thickness and type of material being sewn, if the ruffler blade stalls while feeding in or out you will need to lower the setting on this control. To adjust unlock the dial and turn counter clockwise to reduce the speed turn clockwise to increase.

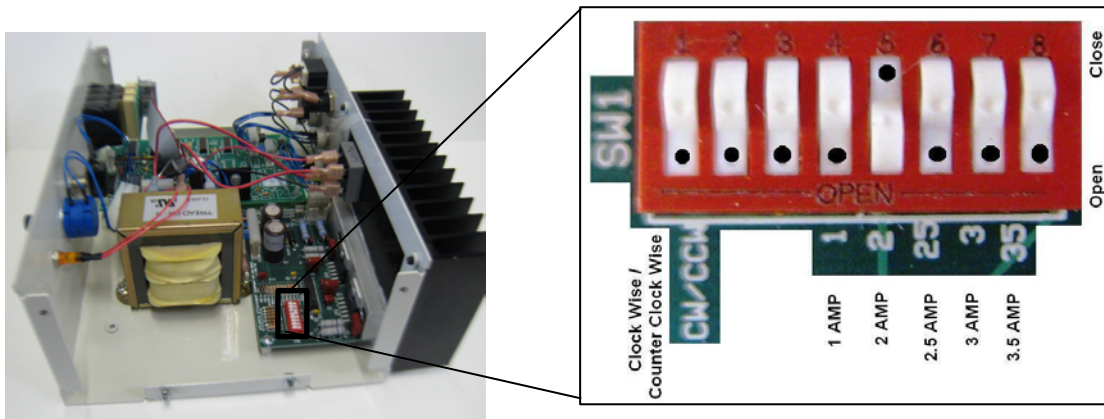
The back of the box has an on/off switch, fuse, and cables. Leave the on/off switch on all the time. When working on the box always disconnect the power cord before servicing.





## Mini Switch (SW1)

- **Switch # 1:** Control the rotations of the motor CW: Clock wise rotation. CCW: Counter close wise rotation For 1335 Ruffler 2 AMPS motors set to position Open (CW)
- **Switch 2:** No function
- **Switch 3:** No function
- **Switch 4:** For 1 amps motors. For 1335 Ruffler 2 AMPS motors set to position Open
- **Switch 5:** For 2 Amps Motors. For 1335 Ruffler 2 AMPS motors set to position Close
- **Switch 6:** For 2.5 Amps Motors. For 1335 Ruffler 2 AMPS motors set to position Open
- **Switch 7:** For 3 Amps Motors. For 1335 Ruffler 2 AMPS motors set to position Open
- **Switch 8:** For 3.5 Amps Motors. For 1335 Ruffler 2 AMPS motors set to position Open

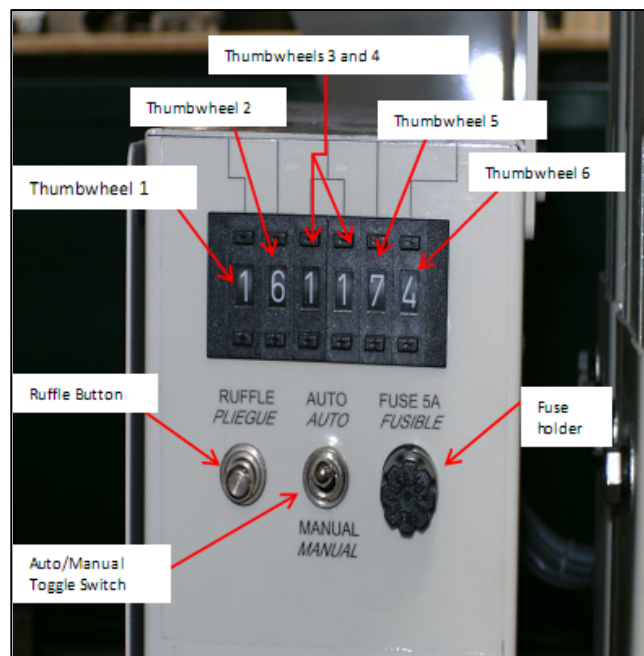


## Ruffler Control Box

**Thumbwheel 1** on the left sets the stitch count for the slow start feature after the last ruffle. This reduces the sewing speed for a few stitches to help the material to feed to the puller before the machine goes to high speed. The stitch count equals twice the number shown on the thumbwheel. This feature can be turned off by setting thumbwheel 1 to “0”.

**Thumbwheel 2** controls the sewing speed of the sewing head during ruffling. Each increment is approximately 100 rpm. The normal setting is “6”.

**Thumbwheels 3 and 4** together make up the Stop count for the corners. This is the stitch count (00-99 stitches) from when the front eye uncovers until the sewing stops in the corner to start the ruffling cycle. This should be adjusted to stop the panel so that when the corner turn is finished the right edge of the panel is flush against the edge guide, decrease the stitch count to stop the panel sooner. If, after turning the corner, the right edge of the panel is to the right of the edge guide, increase the stitch count to stop the panel closer to the foot.



**Thumbwheel 5** has two functions. When it is set to 1-6, it sets the number of ruffles to be sewn in the corner. The panel must be turned while ruffling to form a round corner. When this thumbwheel is set to 7, 8, or 9 the ruffler will sew in “square corner” mode. In this mode, with the thumbwheel set to 7 the ruffle will sew to the corner, and make one ruffle while still sewing straight. The ruffler will then stop, the presser foot and puller will raise. The operator must keep the treadle pressed as the panel is turned 90 deg without sewing. When the treadle is released and pressed again the ruffler will make one ruffle straight ahead and the start sewing at regular speed. This creates a “square” or “straight” corner instead of the rounded corner. The stopping stitches must be adjusted for this mode to form a correct corner. If the thumbwheel is to 8, two ruffles will be made on each side for a total of four ruffles per corner. If the thumbwheel is set to 9, three ruffles will be made on each side for a total of six ruffles per corner.

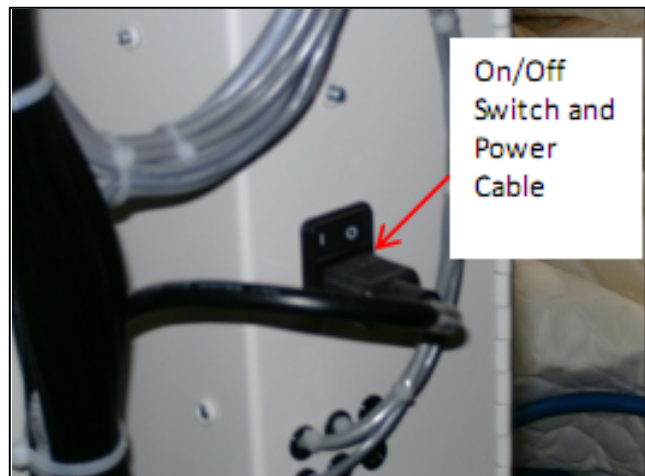
**Thumbwheel 6** sets the number of stitches sewn in each ruffles and is adjusted according to the ruffle size. There should be enough stitches to sew to the folded edge of each ruffle.

The **Auto/Manual Switch** turns on the automatic ruffling cycles for the corners. When this switch is set to Manual, the ruffling is disabled and the machine will only sew, trim, and foot lift.

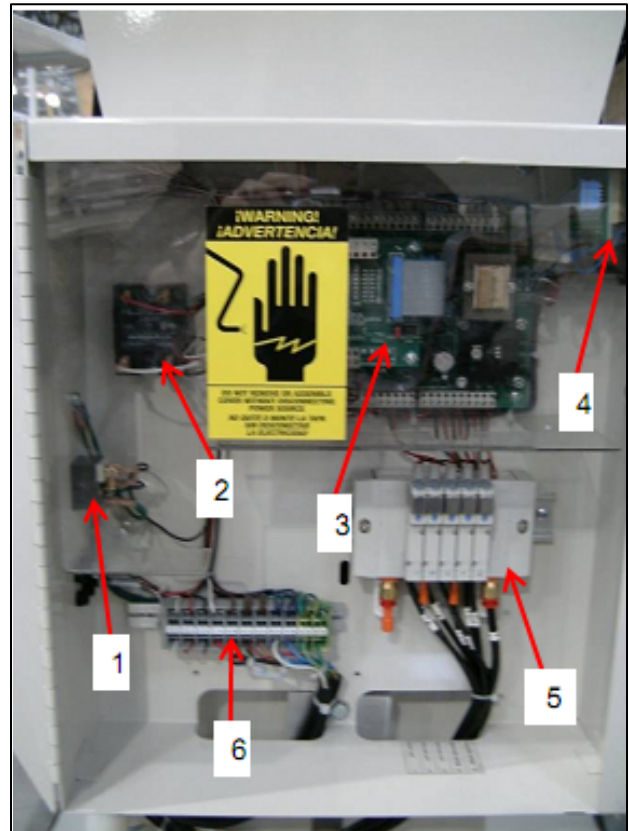
**The Manual Ruffle** push button turns on the ruffle cycle and also functions as the Reset button for the automatic cycle. Pushing this button once will turn on the ruffle cycle. Pushing it a second time will reset the automatic program and cause the ruffle hardware to reset and go to its “home” position. Use this button to reset the ruffler after adjusting the ruffle size.

**The Fuse Holder** fuses the entire machine. Replace the fuse with a 5A Slow Blow 250V as necessary.

The back of the control box has the power cord plug and on/off switch. Be sure the on/off switch is always on. Always disconnect the main power cord before servicing the control box.



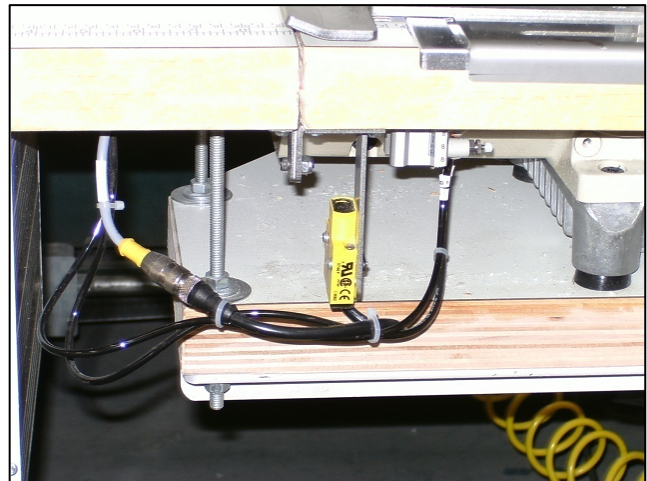
The door on the left side of the ruffler control box gives access to the electronic components. The on/off switch (1), the unwinder relay (2), the computer board (3), the thumbwheels (4), the valve assembly (5), the WAGO blocks (6). Do not service this part of the machine while power is still connected. Unplug the power cable from the back of the control box, follow all lock out/tag out procedures.



## Eyes

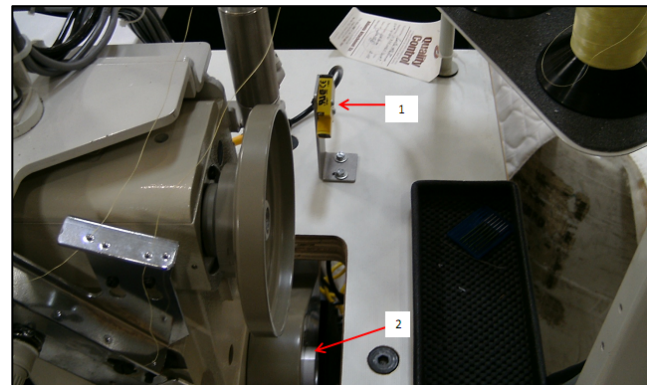
### 1.- Panel End Sew Eye

The panel end sew eye is located under the table top, part of the flip down access. The panel end eye, “looks” for the end of the panel. When the end of the panel goes by it sends a signal to the ruffler control box to start counting stitches for the stop count, thumbwheels 3 and 4.



### 2.- Hand wheel Eye

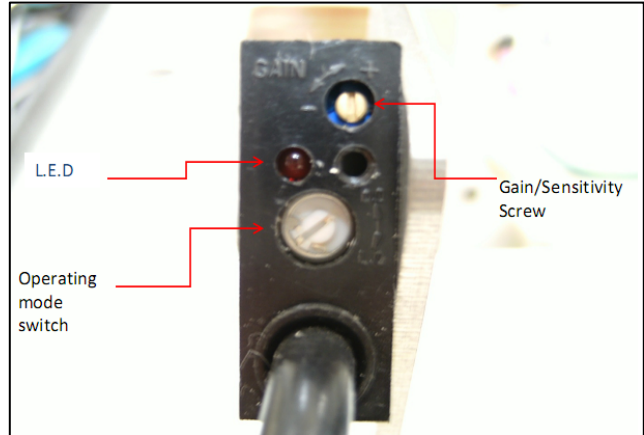
The Hand wheel eye (1) is mounted to the top of the table, behind and to the right of the sewing head. The Hand wheel eye (1) reads a piece of reflective tape located on the pulley disks (2). The Hand wheel eye is responsible for reporting to the Efka motor that the sewing head is sewing at the set RPM, stitch counting for all counters, and for needle position when stopping.



### 3.- Adjustments

#### Hand wheel and Panel Eye

To set the eye, first remove the cover (not shown), make sure that the operating mode switch is set to L.O. or all the way clockwise, with the eye “seeing” the reflective tape, turn the Gain/Sensitivity Screw to the “+” or clockwise until the L.E.D starts blinking, the L.E.D should blink about 2 times per second when set correctly.

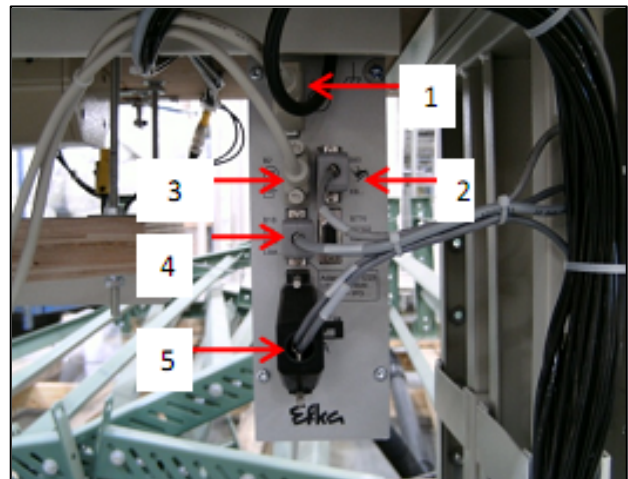


#### Efka Motor

##### Connections

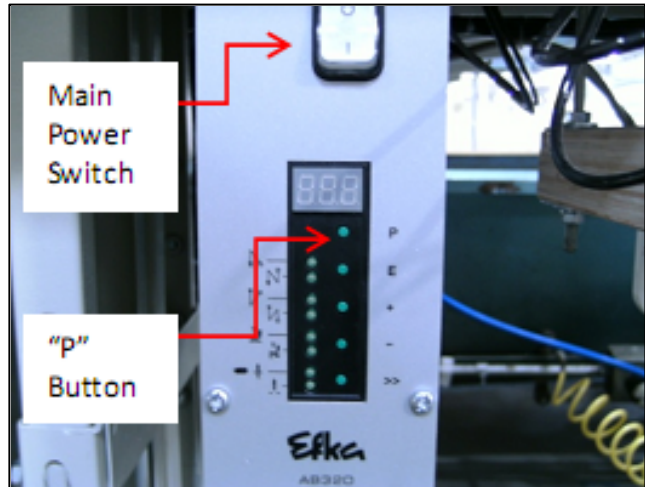
The back of the Efka Motor has all of the cables.

- 1.- Power Cable for the Efka Motor.(Goes to the Efka Motor)
- 2.-Foot Pedal Cable
- 3.- Commutation Transmitter (goes to the Efka Motor)
- 4.-Hand wheel Eye
- 5.-Socket for solenoid inputs and outputs, solenoid valves, displays, keys and switches

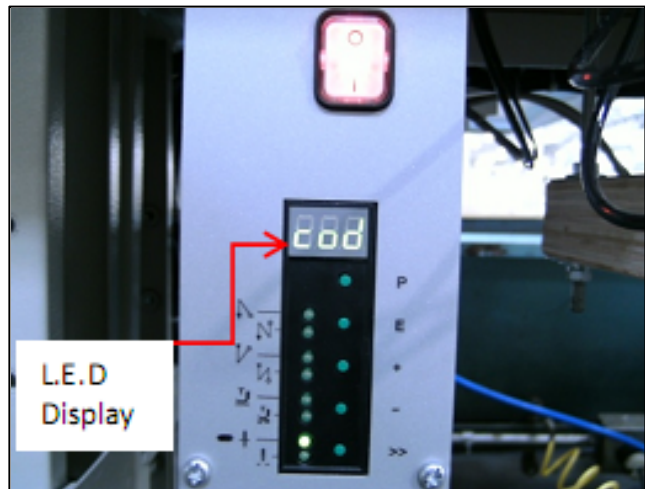


## Programming

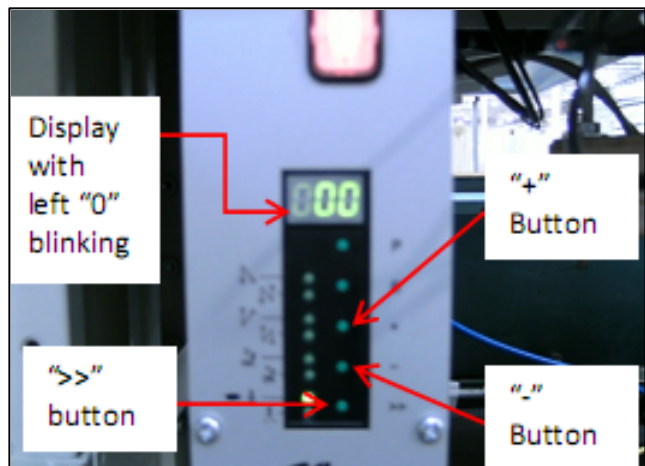
1) Press and hold the “P” button while turning on the Main Power Switch.



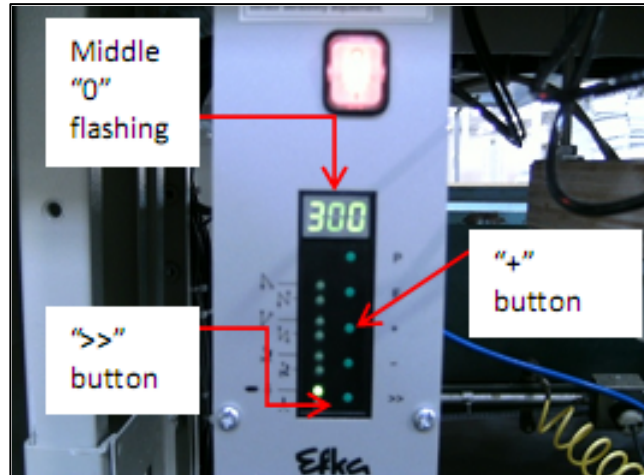
2) Once “cod” (short for code) appears in the display release the “P” button and press the “>>” button. The code to enter in is “311”



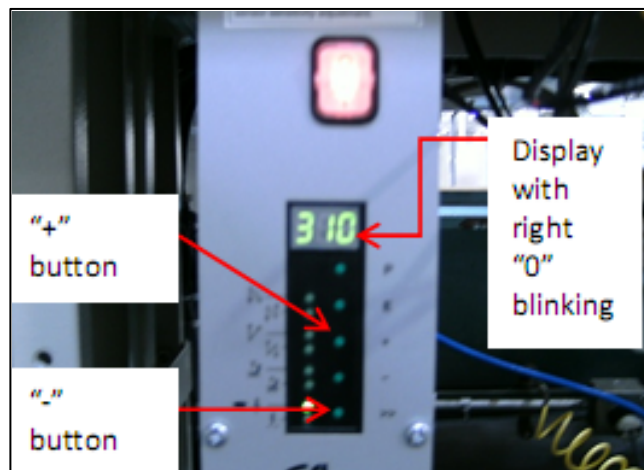
3) 000 will appear on the display with the left 0 blinking. Press the “+” three times to get a “3” in the display, if you go past “3” then either continue pressing the “+” button until it cycles back or press the “-” button to go back. Then press the “>>” button. Page 1



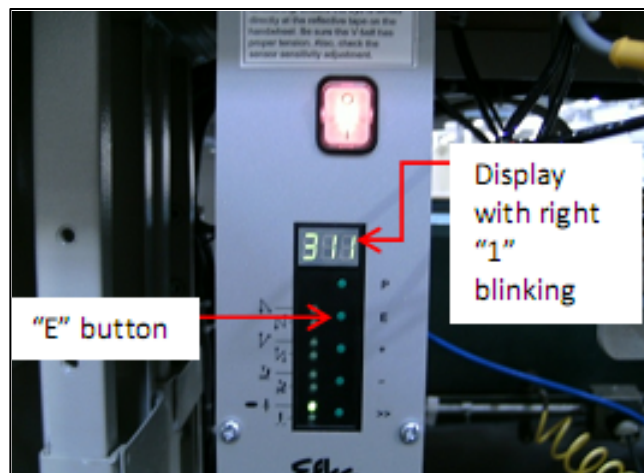
4) Display should look like picture to the left with the middle “0” blinking, if not press the “>>” button until the middle “0” is blinking. Press the “+” button once to get a “1” as the middle number. Then press the “>>” button.



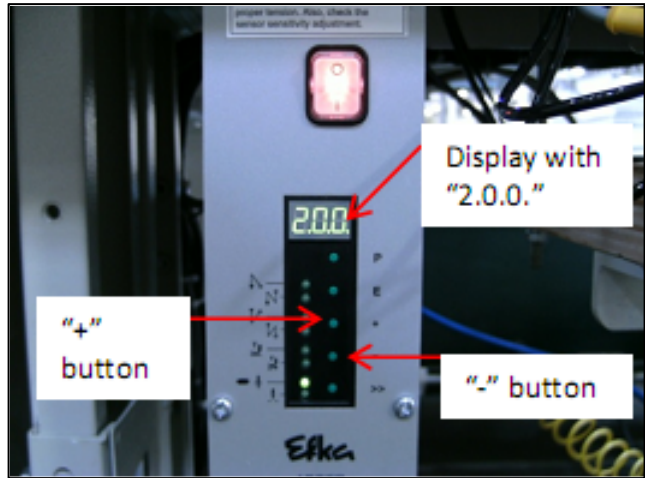
5) Display should look like picture to the left with the right “0” blinking, if not press the “>>” button until the right “0” is blinking. Press the “+” button once to get a “1” as the right number.



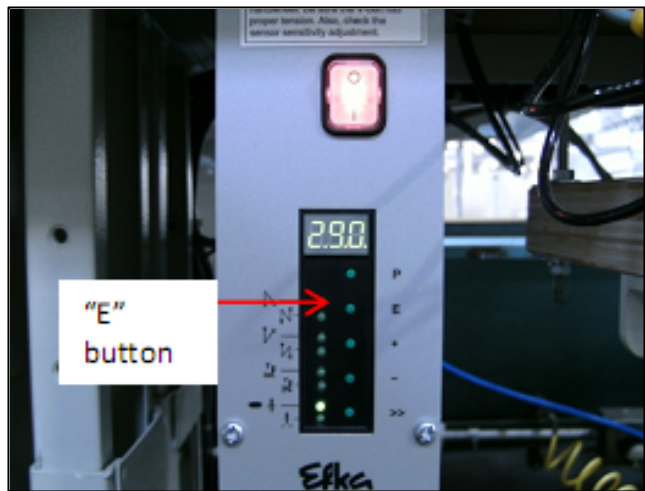
6) Display should look like picture to the left with the right “1” flashing. (It does not matter which number in the display is blinking as long as it reads “311”) Press the “E” button.



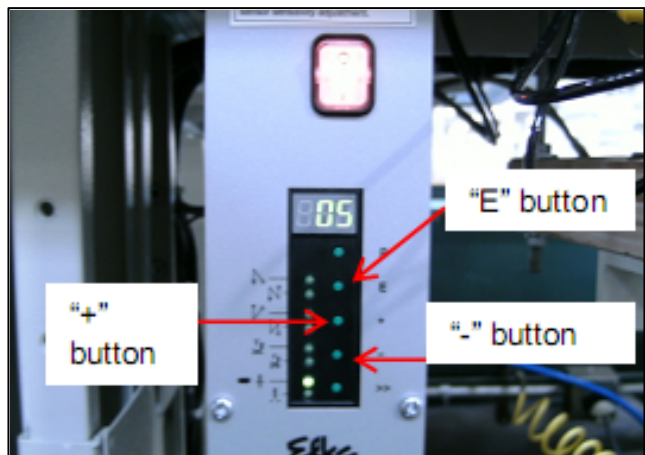
7) The display will change to “2.0.0.” this is a parameter number “200”. Any number with the “.” between the digits will be a parameter. To move o the correct parameter you will press either the “+” or “-” buttons. Press nd hold the “+” button, the parameter numbers will start scrolling faster the longer the button is held down, until “2.9.0.” is displayed. This is the first parameter to be programmed when starting new, only using as an example. (You may need to access a different parameter number, use the same method as above)



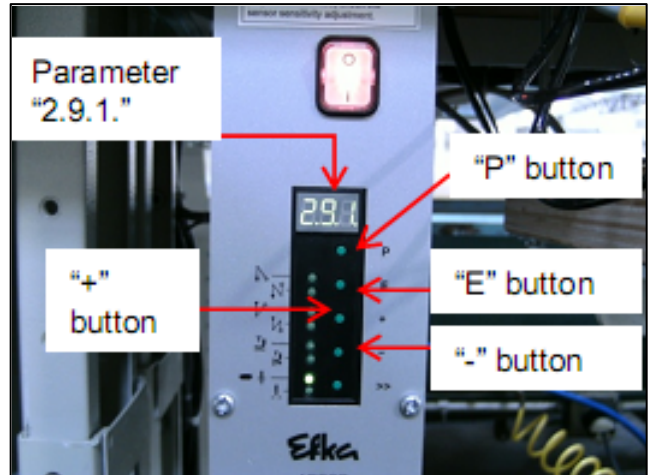
8 ) With “2.9.0.”(or parameter number you chose) in the display, which is parameter “290”, press the “E” button once.



9) The display will change from “2.9.0.” to “05” (your display may not be the same, depends on the type of sewing head being used, refer to your machines programming sheet in manual) this is the setting of parameter “2.9.0.” all displayed numbers without the “.”are values of parameters. To change this number use the “+” or “-” button. Then press the “E” button once.



10) The display will show “2.9.1.”, this is the next parameter after “290”. You will use the “+” or “-” buttons to advance to the next parameter on the list, then follow the process in step 9. Continue this until all parameters have been set according to the programming sheet. After the last parameter has been set, if the number displayed DOES NOT have the “.” between them, press the “E” button then press the “P” button. If it DOES have the “.” between them then only press the “P” button.



11) The display will now show the set maximum RPM. The display only shows three numbers the actual RPM in the example picture is 3200 RPM. You will need to sew at least one stitch to lock in the changes to the parameters and complete the process.

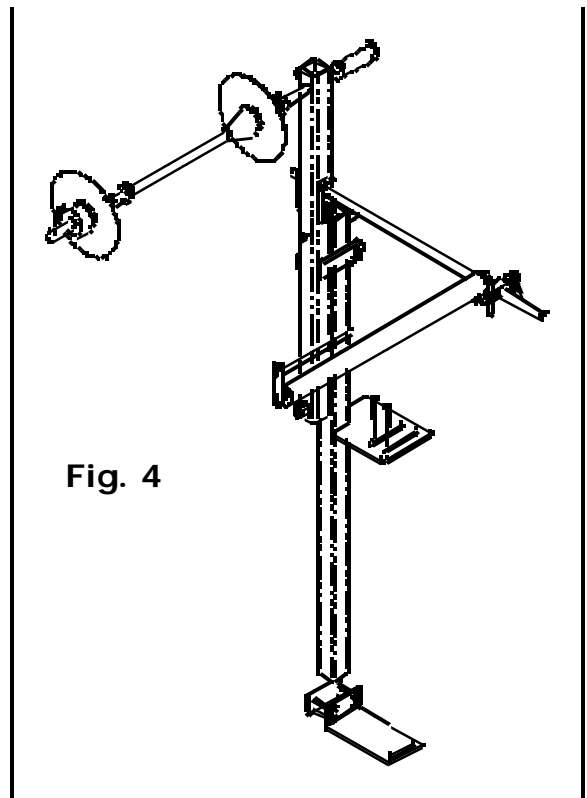




## Basic Machine Operation

### Loading the Roll Holder

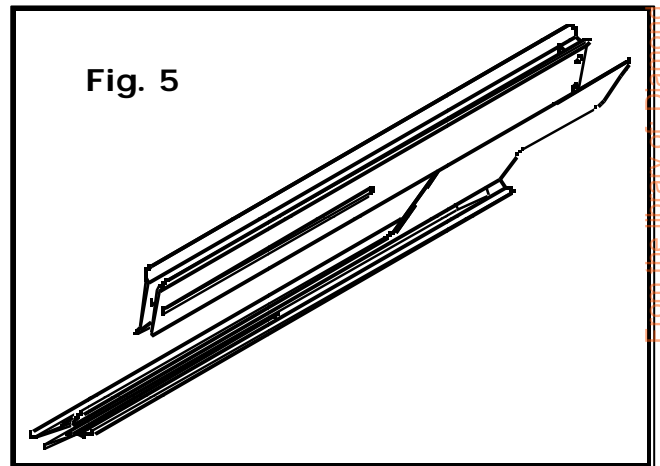
Remove the outer disc from the upper rod. Place a roll of material on the rod and replace the outer disc. Feed the material over the top roller and down to the folder with the good side toward the sewing head. (When making continental foundations, the good side will face the operator)



### Loading and Adjusting the Folder

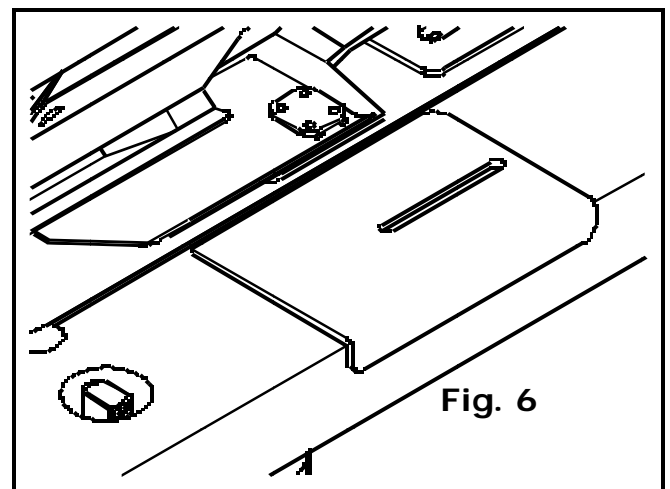
Feed the gusset through the top portion of the folder with the flange to the right and under the right flange guide. Adjust the left guide to make a snug fit to the gusset width. Adjust the folder left or right as necessary to set the desired stitch margin. Normally, with the folder positioned to its right most position in its slots, a 6" wide gusset will be centered on the needle.

The folder spacers should be sized as required to fit the thickness of the gusset. Extra spacers can be ordered to fit any thickness gusset from 1/8" to 9/16". Adjust the lower portion of the folder in the same manner.



### Adjusting the Edge Guide

The edge guide located on the front of the table should be set so its left edge aligns with the right edge of the gusset. This is the guide for the right edge of the panel.



From the library of: Diamond Needle Corp

## Loading the Panel

Heal back the treadle or step on the foot lift pedal to raise the presser foot. Swing in the stripper blade and the folder/ruffler assembly. Be sure the sensor at the back of the swing-out bracket is lit indicating that the bracket is all the way in to the detent. Activate the "Wipe" switch to raise the folder for easier loading. Pull the gusset through the folder, under the presser foot and under the puller. Activate the "Wipe" switch again to lower the folder. Load the panel under the gusset with the center of the short side even with the needle and the edge of the panel against the edge guide. Lower the presser foot. Be sure the Auto/ Manual switch is in its Auto position (up). Be sure the folder is "Down". The automatic cycle will not function while the folder is up.

## Sewing the Panel with Rounded Corners

Set thumbwheel #5 to any ruffle setting between 1 and 6 as desired.

Sew the panel to the corner being sure not to get your hands in the way of the electric eye mounted under the table which must "see" the edge of the panel as it nears the presser foot. The machine will stop automatically at the corner. Go to neutral treadle as you position your hands for turning. Place your right hand on the panel near the presser foot and your left hand about 1 foot to the left on the panel. Treadle forward and allow the machine to make the first ruffle sewing straight. Begin to rotate the panel as the rest of the ruffles are formed. Try to turn an equal amount with each ruffle so that when the ruffles are complete the panel has turned 90 degrees and the right edge of the panel is resting against the left edge of the edge guide. The ruffles can be made one at a time by going to neutral treadle between each ruffle. Complete all four corners.

## Sewing the Panel with Straight Corners

Set thumbwheel #5 to "7" for 1 ruffle per side, "8" for 2 ruffles per side, or "9" for 3 ruffles per side. Sew the panel to the corner being sure not to get your hands in the way of the electric eye mounted under the table, which must "see" the edge of the panel as it nears the presser foot. The machine will pause momentarily as the ruffler engages and then continue to sew straight as it makes the ruffles.

After the last ruffle is finished on the first side of the corner the machine will continue to sew slow stitches based on the setting of thumbwheel #1. The number of slow stitches sewn is equal to twice the setting of thumbwheel #1. Setting the thumbwheel to "0" will disable this slow sew function. After the slow stitches the machine will stop with the presser foot lifted. Turn the panel 90 degrees. Release and depress the treadle. The foot will drop and the machine will again make slow stitches based on the setting of thumbwheel #1, and then begin making the ruffles on the second side of the corner. When the ruffles are complete the machine will resume sewing at treadle speed. Adjust the stop count as necessary to achieve the desired corner finish.

## Adjusting the Corner Ruffles

The ruffles should be set so the outer edge of the gusset lays flat for taping. A typical ruffled gusset will have ruffles which butt against each other without overlapping or gaps between them. Adjust Thumbwheels #5 and #6 and the ruffle size knob to achieve the desired finish. Euro style gussets typically have 3 or 4 small ruffles with extra stitches between them.

## Finishing the Panel

After the last corner, sew the panel until the starting edge of the gusset is almost to the presser foot. Stop and activate the "Wipe" switch to raise the folder. Cut the gusset so

that there is enough overlap of gusset for finishing. Swing out the stripper blade. Fold the trailing edge of the gusset under itself, lay it on top of the starting edge and oversew the two together. Heal back and remove the panel. Reload the gusset under the foot and puller and lower the folder. Note: The automatic functions will not operate with the folder up!

## Efka Control Box Settings

The Efka control has been preprogrammed to operate the sewing head in conjunction with the ruffler. The maximum sewing speed has been preset to 4000 RPM. The maximum sewing speed can be temporarily reduced by holding in the "-" button on front of the control box while sewing. To restore maximum speed use the "+" button. Be sure the needle down LED is the only LED lit on front of the control box. The LED's can be changed only immediately after power on or a full healback. Refer to the appendix for complete Efka programming parameters.

## General Machine Adjustments

### Air Pressure

Set all air supply pressure regulators (Right to left):

Main Pressure:	70 PSI
Puller Pressure:	30 PSI
Ruffle Blade Pressure:	10 PSI
Foot Sew Pressure:	15 PSI

### Sewing Head

See the manufacturer's manuals for normal adjustments and parts. The presser foot spring pressure should be set very light so that the ruffling blade can feed under the foot while ruffling. The Efka motor should be set for stopping needle down at neutral treadle to help hold the ruffle in place while turning the corners. The auxiliary foot pressure cylinder should be set to provide added foot pressure while sewing straight.

### Ruffler Drive

Set the Ruffler blade position left to right. The slot in the Ruffler blade should align with the sewing needle. Loosen the 4 clamp screws and adjust ruffler blade left or right as needed.

Set the Ruffler blade IN position so that the front edge of the blade is even with the needle when the ruffler drive is positioned at the IN sensor. To position the drive at the sensor, press the manual ruffle button once and quickly tap the treadle or sew pedal. The Ruffler should position itself at the IN sensor. Adjust the sensor position in its slot, press the manual ruffle button to reset the ruffler and repeat the cycle to test the setting.

Set the Ruffler blade OUT position by turning the adjusting knob on the front cover of the ruffler drive. This controls how big each ruffle will be. After making an adjustment, always reset the ruffler by pressing the manual ruffle button twice.

The swing-out stripper blade protects the panel from the ruffler blade while ruffling so that the panel does not get pleated by the blade. It should be positioned as close to the presser foot as possible. The ruffling air pressure should be set as high as practical without it pressing the stripper blade down and pinching the panel while turning.

## Puller Drive

Set the puller down position as low as practical without actually touching the cloth plate. The roller should be centered on the needle. Set the Puller air pressure as needed to provide positive feeding without the puller stalling at high speed.

## General Machine Maintenance

### Daily

- Clean machine at the end of every shift
- Clean lint etc. from the Looper/bobbin area on the sewing head
- Remove any threads wrapped around moving parts of the handwheel, puller, and ruffler.
- Wipe all photo eye lenses with clean, nonabrasive, dry cloth
- Use blow-off hose to get rid of excess lint, thread and other clippings
- Follow manufactures recommendations and guidelines for daily maintenance and lubricating of the sewing head.

### Weekly

- Check all belts for tightness and condition. Adjust or replace as necessary.
- Check oil level in oil pan.
- Put one drop of machine oil on all moving Ruffler parts.

## 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

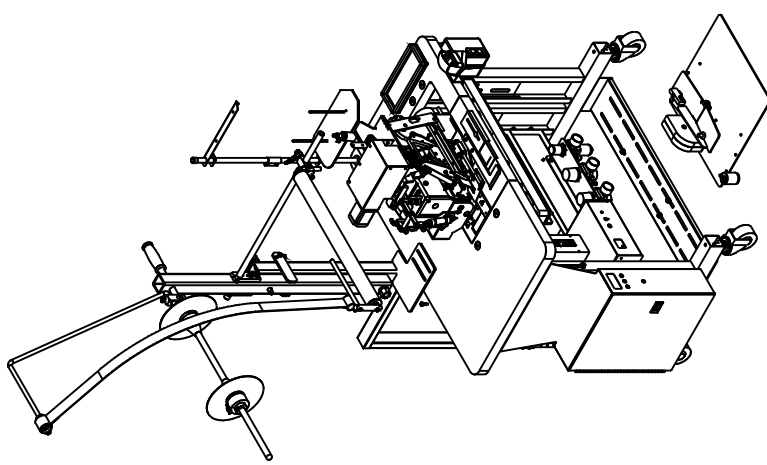
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From the library of: Diamond Needle Corp

ITEM NO.	Hardware Shown/Qty.	PART NUMBER	DESCRIPTION
1	1	1325145	BASE CONSOLE,TYPICAL
2	1	1335930	ROLLHOLDER ASSY,OVERHEAD
3	1	4059-FP301D	FOOT PEDAL ASSY,EFFKA
4	4	NNK1/4-20	KEP NUT, 1/4-20
5	4	SSHCO1048	1/4-20 X 3/4 HEX HEAD
6	8	VWVF51/4	WASHER FLAT, 1/4



S\1335\1133SET

**RESEARCH & DEVELOPMENT**

WORK ORDER:	
MACHINE TIME:	QTY. FOR TRIAL 1
DESIGN TIME:	QTY. PER ASSY. 1
NEEDED BY:	
CHECKED BY:	
RETURN TO:	P.DASHER

SHEET 1 OF 1

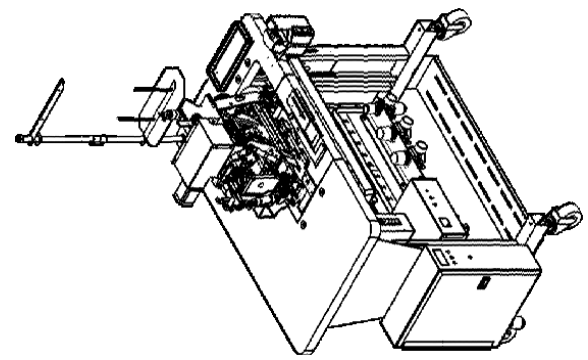
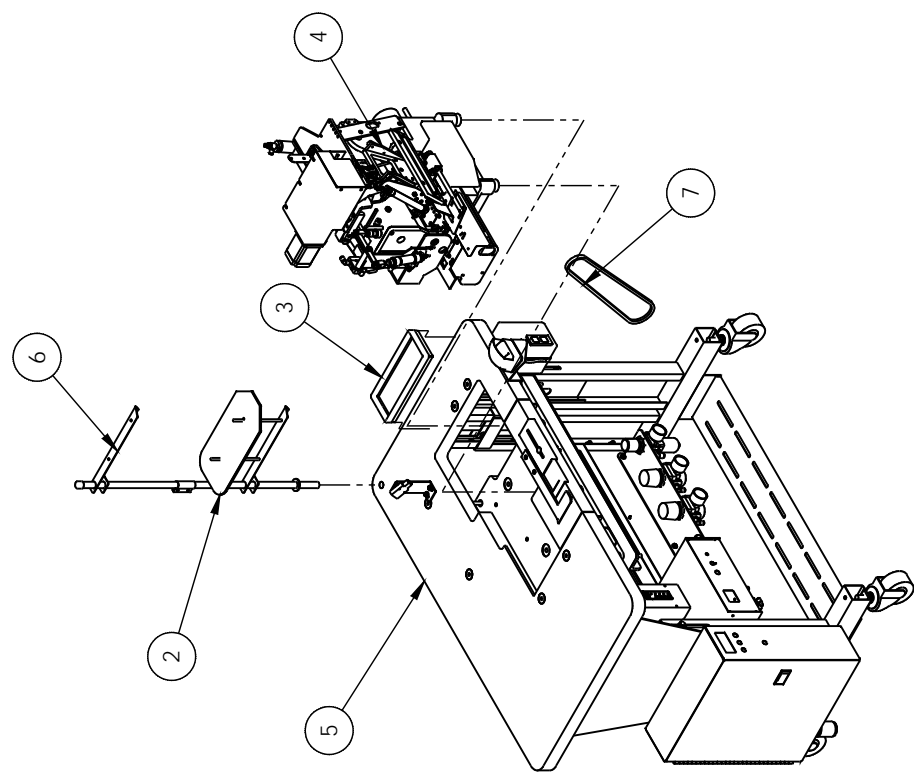
FINISH	DEFAULTS	ATLANTA ATTACHMENT COMPANY
PLAIN/OLEAN	COMMENTS	NAME RUFFLER WORKS IN ECONOMY
BLUR/REICH		2nd DRS DROP FEED W/PULLER
BLACK/ONDE		MATERIAL AS NOTED
SAID/BLAST		ASSEMBLY
BLUF		DES BY: FBD
PAINT		DR BY: PBD
W/ASSURE		SCALE 1:16
W/SAVE		DATE 12/4/2012
OTHER		DWG SIZE: B



2012

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ITEM NO.	QTY	PART NUMBER	DESCRIPTION
NS	AR	1335MF-PD	DIAGRAM, PNEUMATIC
2	1	1959-112	2 POS THREAD PLATE ASSY
3	1	26151	TOOL TRAY, 1X3.5X9
4	1	1325144	SEW HEAD SUBASSEMBLY
5	1	1325165	STAND / MOTOR ASSY
6	1	D-2	THREAD STAND, 2 THREAD
7	1	ZX3833	V-BELT, 3/8 X 33



S:\1325\1325145

RESEARCH & DEVELOPMENT	
WORK ORDER:	
MACHINE TIME:	QTY. FOR TRIAL 1
DESIGN TIME:	QTY. PER ASSY. 1
NEEDED BY:	
CHECKED BY:	
RETURN TO:	P DASHER

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2012

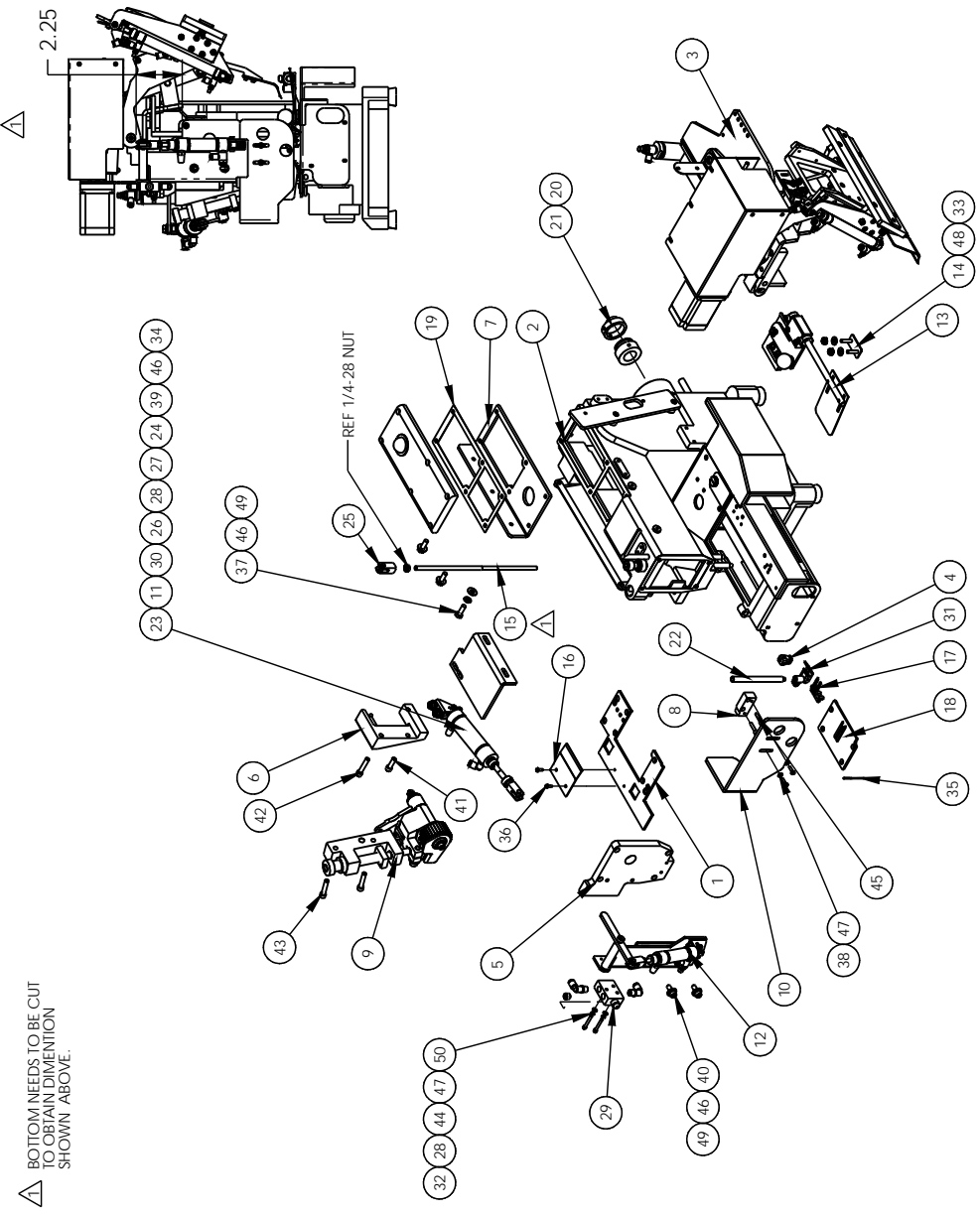
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FLUORURENCH	COMMENTS				
BLACK/CONDE					
SAND BLAST					
BLUF					
PAINT					
IMMERSURE					
IMMERSAVE					
OIL					
OTHER					

SHEET 1 OF 1

ATLANTA ATTACHMENT COMPANY	
NAME	BASE CONSOLE TYPICAL
2nd DES.	RUFHLER, GK321-12
MATERIAL	NOTED
ASSEMBLY	11335T
DES BY	FBD
DR BY	PBD
CHECKED BY	
PART NO.	1325145
DRAWING NO.	1325145
REV.	0



△ BOTTOM NEEDS TO BE CUT TO OBTAIN DIMENTION SHOWN ABOVE.



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1325146	SEW HEAD PLATE
2	1	1325147	SEWING HEAD, MODIFIED
3	1	1325148	RUFFLER ASSEMBLY, TYP
4	1	1325151	NEEDLE CHUCK, 1IN TYP
5	1	1325152	FACE PLATE, TYP
6	1	1325153	BRKT, PULLER MOUNT, TYP
7	1	1325154	RUFFLER MOUNTING BRKT, TYP
8	1	1325159	SPACER, GUARD, TYPICAL
9	1	1325160	PULLER SUB-ASSY
10	1	1325163	PULLER, GUARD, HD
11	1	1325166	BRACKET PULLER LIFT, HD
12	1	1325173	FOOT PRESSURE ASSY
13	1	1325175	STRIPPER BLADE ASSY
14	1	1325177	PLATE, 10-32 PEM STUD
15	1	1335209	FOOT LIFT PIN
16	1	1335418	PULLER WEAR PLATE
17	1	1888N12S01	FEED DOG 1N
18	1	1889N13000	THROAT PLATE, 1 NDL
19	1	197100005	HEAD GASKET
20	1	311-128	HUB, HANDWHEEL, TAPE MOUN
21	1	311-129	SLEEVE TAPE MOUNT ADJUST
22	1	3300015	PRESSER BER, 1804 YAMATO
23	1	AAC6DP-1.5	CYLINDER, AIR, DA, P/VOI
24	1	AAFBR-11TC	BRKI P/VOI, 1/4 BORE
25	1	AAFCI-7	CLEVIS, AIR CYL, 1/4-28
26	1	AAFCI-11	CLEVIS, CYL, 5/16-24, 1/4
27	1	AAFPI-18	MUFFLER, 1/8 NPT, BRONZ
28	3	AAQME-5-8	QUICK MALE ELBOW
29	1	AAV41-P	HUMPHREY VALVE, 4 WAY
30	1	CCGL5F	CLAMP COLLAR, 5/16" BORE
31	1	MTV67-016	FOOT 1N RUFFLER
32	1	MN4554K11	PLUG, 1/8" PIPE
33	2	NNK10-32	KEP NUT, 10-32
34	2	NNK1/4-20	NUT, HEX, KEP, 1/4-20 W/LOCK
35	10	SN62X5/21	NEEDLE, SIZE 130/21
36	2	SSBC-80024	6-32 X 3/16 BUT HEAD
37	3	SSHOC05048	1/4-28 X 3/4 HEX CAP
38	2	SSPP80032	#6-32X1/2 PAN PHILLIPS
39	2	SSSC01032	1/4-20 X 1/2 SOC CAP
40	2	SSSC01040S	1/4-20 X 5/8" SOC CAP SS
41	1	SSSC01048	1/4-20 X 3/4 SOC CAP SC
42	1	SSSC01080	1/4-20X1-1/4, SOC CAP
43	2	SSSC05080	1/4-28 X 3/4 W/NYLON PATCH
44	2	SSSC80064	6-32 X 1 SOC CAP SC
45	2	SSSCM4X20	SCREW, SOC CAP, M4-0.7X20
46	7	WVWF5T4	WASHER, FLAT, #6
47	4	WVWF56	WASHER, FLAT, #10, SAE
48	2	WVWF510	WASHER, FLAT, #10, SAE
49	5	WVWL1/4	WASHER, LOCK, 1/4
50	2	WVWL6	WASHER, LOCK, #6

S\1325\1325144

SHEET OF 1

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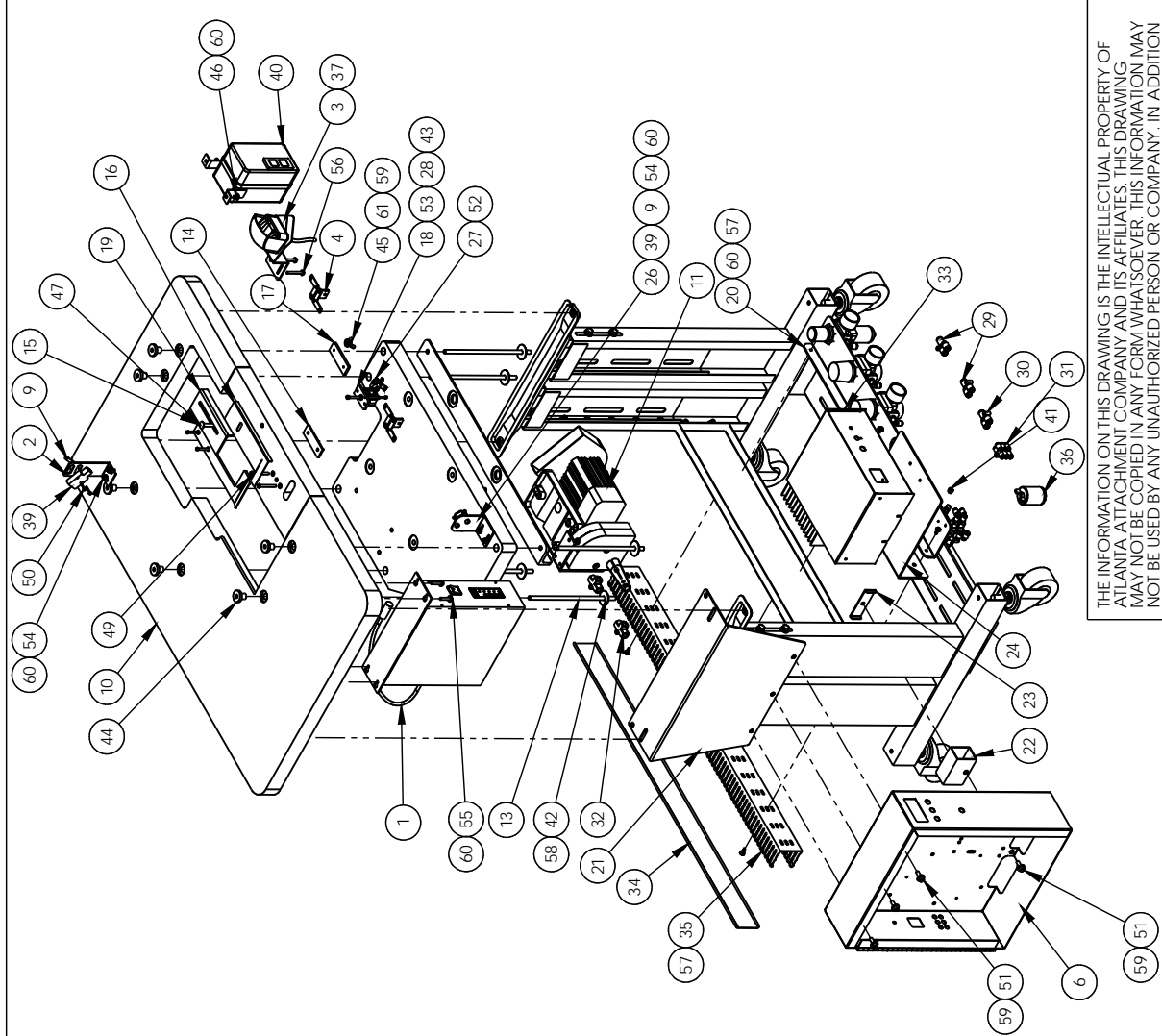
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2012

NAME		SEW HEAD SUBASSEMBLY	
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50	0000	0000	0000

From the library of: Diamond Needle Corp



ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	0211-702A	CABLE POS. SENSOR 6"
2	1	127B-6689B	BRACKET EYE MOUNT
3	1	127B-6718A	BRKT OPTO TOUCH SWITCH
4	4	1335M-114	HINGE BRACKET
NS	AR	1335M-LAB	LABELS
6	1	1335MF-500	CONTROL BOX ASSY
NS	AR	1335MF-PD	PNEUMATIC DIAGRAM
NS	AR	1335MF-WD	WIRING DIAGRAM
9	2	1975-412A	PLATE NUT 4-40 .95CTC
10	1	4048-GK321FR	TABLE TOP MAIN W/SUPPORT
11	1	4059-DC1500	MOTOR & CONTROLLER
12	1	4080-4508B	CABLE STEP MOTOR 4 AMP/7
13	6	1335244	ROD THRD 5/16-18 X 8.75
14	1	1335274	WASHER PLATE - PANEL TENS
15	1	1335275	TOP PLATE - PANEL TENSION
16	1	1335278	PANEL TENSION FINGER
17	1	1335280	NUT PLATE - PANEL TENSION
18	1	1335281	NUT PLATE - PANEL TENSION
19	1	1335284	EDGE GUIDE
20	1	1335716	PNEUMATIC SHELF
21	1	1335784	BRKT ANGLE CONTROL BOX
22	1	1335785	SPACER BLOCK
23	1	1335786	SPACER HOLDER
24	1	1335936	BRKT MAIN STEP BOX
25	1	1347688	LOWER TABLE SUPPORT ANG.
26	1	982050110	BRKT SENSOR 982A
27	2	AA198RA510	FLOW CONTROL 5/32X10-32
28	1	AACNCO2BT16-10D	COMPACT 1.6MM BORE .10MM
29	2	AAOUIY-4-4	Y UNION 1/4X1/4
30	1	AAOUIY-5-4	Y UNION 5/32X1/4
31	3	AAV5T25	QUICK UNION Y .5732
32	2	AAV5T25	SHUTTLE VALVE 1/8"PORT
33	1	AP-28-800Y1A	BOX STEPPER H.S. (X5)1/2A
34	28 FT	EEDC2X2	COVER WIRE DUCT
35	28 FT	EEDF2X2	DUCT WIRE 2X2 .MOD
36	1	FFHBL4579C	RECEPTACLE 3 POLE 3W
37	1	FFOIBVN6	SWITCH OPTO TOUCH
38	1	FFR4413P5	CABLE EURO-3P
39	2	FFSM312LV0	EYE ELECTRIC 10-30VDC
40	1	K-CB600	MOTOR STARTER ELEC
41	1	MM4554K11	PLUG 1/8" PIPE
42	6	NH5716-18	5/16-18 HEX NUT
43	1	NH4X0.7	M4 X 0.7 HEX NUT
44	6	NNM103	NUT RECESSED 5/16-18
45	1	NNM1/4-20	NUT WING 1/4-20
46	2	SSRC90024	#8-32 X 3/8 BUT HEAD
47	1	SSRK01160	1/4-20 X 2 1/2 BOLT CARG
48	2	SFS90128	#8-32 X 3/4 FLAT S/OI
49	2	SFS98112	#8-32 X 3/4 FLAT S/OI
50	2	SSP570048	4-40 X 3/4 PAN HD S/OI
51	4	SSSC01048	1/4-20 X 3/4 SOC CAP
52	2	SSSC043X30	MR 6.5 X 30 SOC CAP
53	1	SSSCN4X10	M4-0.7 X 40 SOC CAP
54	4	SS7H#10032	#10 X 1/2 HSNMS
55	4	SS7H#10064	#10 X 1 HSNMS
56	2	SS7H#10096	#10 X 1 1/2 HSNMS
57	6	SS7595032	SCREW SHI METAL 10 ZIP
58	6	WWFED20	WASHER FENDER 5/16
59	5	WWFST1/4	WASHER FLAT 1/4
60	12	WWFST1/2	WASHER FLAT #10
61	1	WWL1/4	1/4 LW
62	1	K-4D	HD TLEG ADJ STAND

NO.	CRNO	DATE	BY	CHK	RE
2	2013	8/19	RB	RB	
1	2013	6/3	PD	RB	

FINISH		DETAILS	
PLAIN/CLEAN	COURTESY	NAME	STAND / MOTOR ASSY
BURR/FINISH		2nd DRS.	TYPICAL GK321-12
BLACK/ONDE		MATERIAL	NOTED
SAND/BLAST		ASSEMBLY	1325165
BLUES		REV	
PAINT		DR BY	PBD
WARRANTY		CR BY	
UNSAVE		SCALE	1:10
WELD		DATE	1/14/2013
		DWG SIZE	B
		WEIGHT	

ATLANTA ATTACHMENT COMPANY	
PART NO.	1325165
DRAWING NO.	1325165
REV	2



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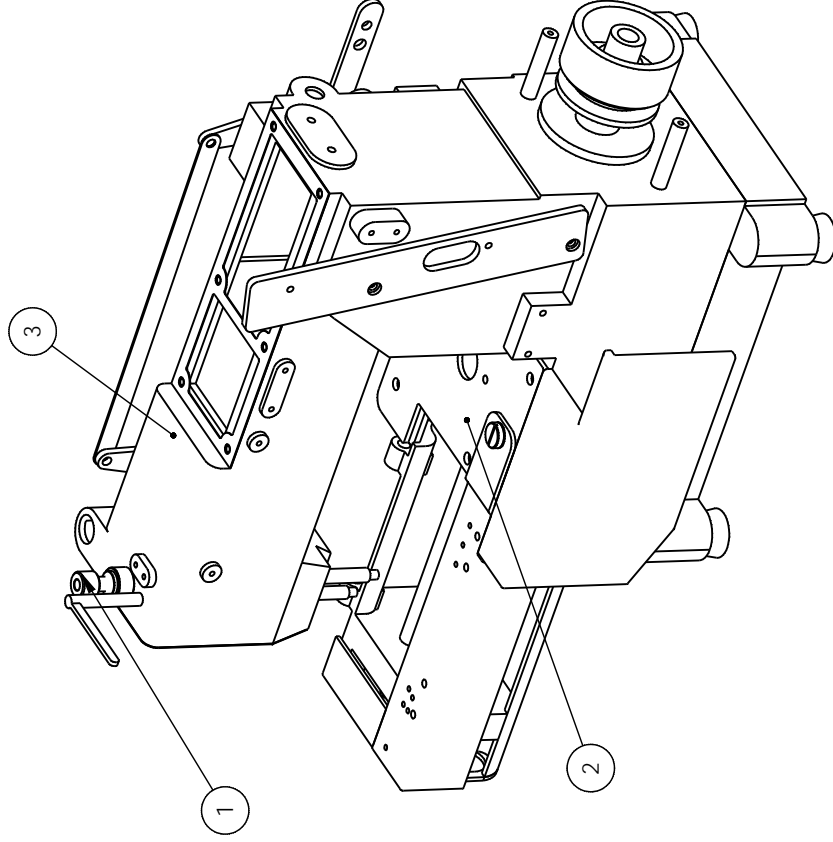
REMOVE :  
 FACE PLATE  
 FOOT, NEEDLE PLATE, NEEDLE CHUCK  
 FEED DOG  
 ALL LOOPERS AND SPREADER PINS  
 EXCEPT CENTER POSITION  
 UPPER PULLER YOKE &  
 PULLER ROLLERS

MOD CLOTH PLATE PER 1325176 DWG

MOD F/L PRESSER SCREW PER 1325164.

MOD TENSION OPENER FOR ONLY TWO THREADS

ITEM NO.	Hardware Shown/Qty.	PART NUMBER	DESCRIPTION
1	1	1325164	FOOT LIFT ADJ - MOD
2	1	1325176	CLOTH PLATE MODIFIED
3	1	STYP-GK321-12	SEWING HEAD WITH PULLER
4	1	321KIT01	OIL WICK KIT



S:\1325\1325147

RESEARCH & DEVELOPMENT	
WORK ORDER:	
MACHINE TIME:	QTY. FOR TRIAL 1
DESIGN TIME:	QTY. PER ASSY. 1
NEEDED BY:	
CHECKED BY:	
RETURN TO:	P DASHER

SHEET 1 OF 1

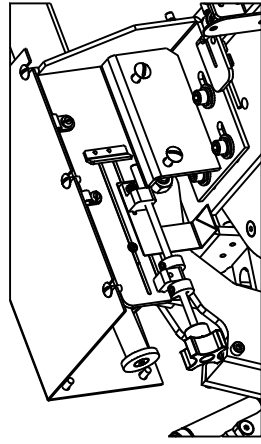
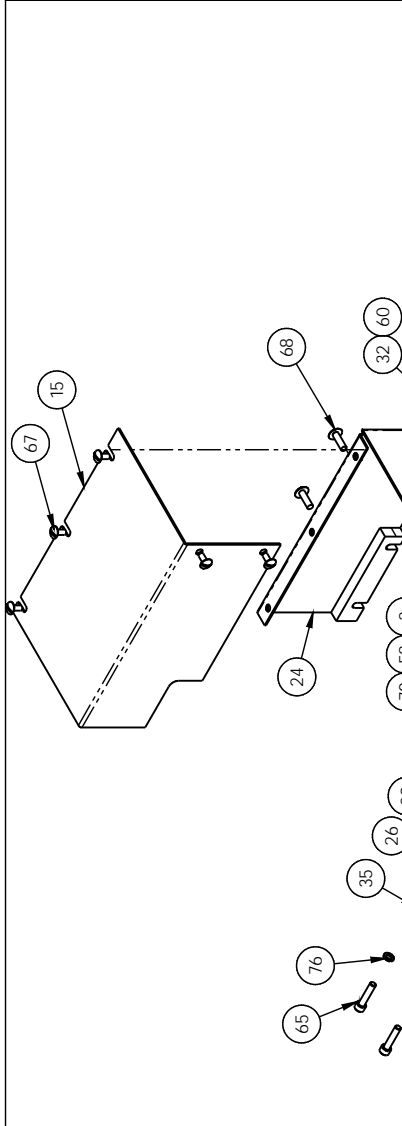
FINISH	DEFAULTS	NAME	ATLANTA ATTACHMENT COMPANY
PLAIN/CLEAN	COMMENTS	SEWING HEAD, MODIFIED	
BURR/FINISH		2nd DRS: TYP GK321-12	
BLACK/WHITE		MATERIAL: STYP-GK321-12	
SAND/BLAST		ASSEMBLY: 11335E1	
PAINT	Tight Tolerance	PART NO.: 1325147	
PLATE	X.X - +.030	DES BY: FBD	
WELDING	XX.X - +.030	DR BY: PBD	
THREADED	XXX.X - AS SPECIFIED	CR BY:	
OIL		SCALE: 1:3	
OTHER		DATE: 12/4/2012	
		DWG SIZE: B	WEIGHT: 52.98714



2012

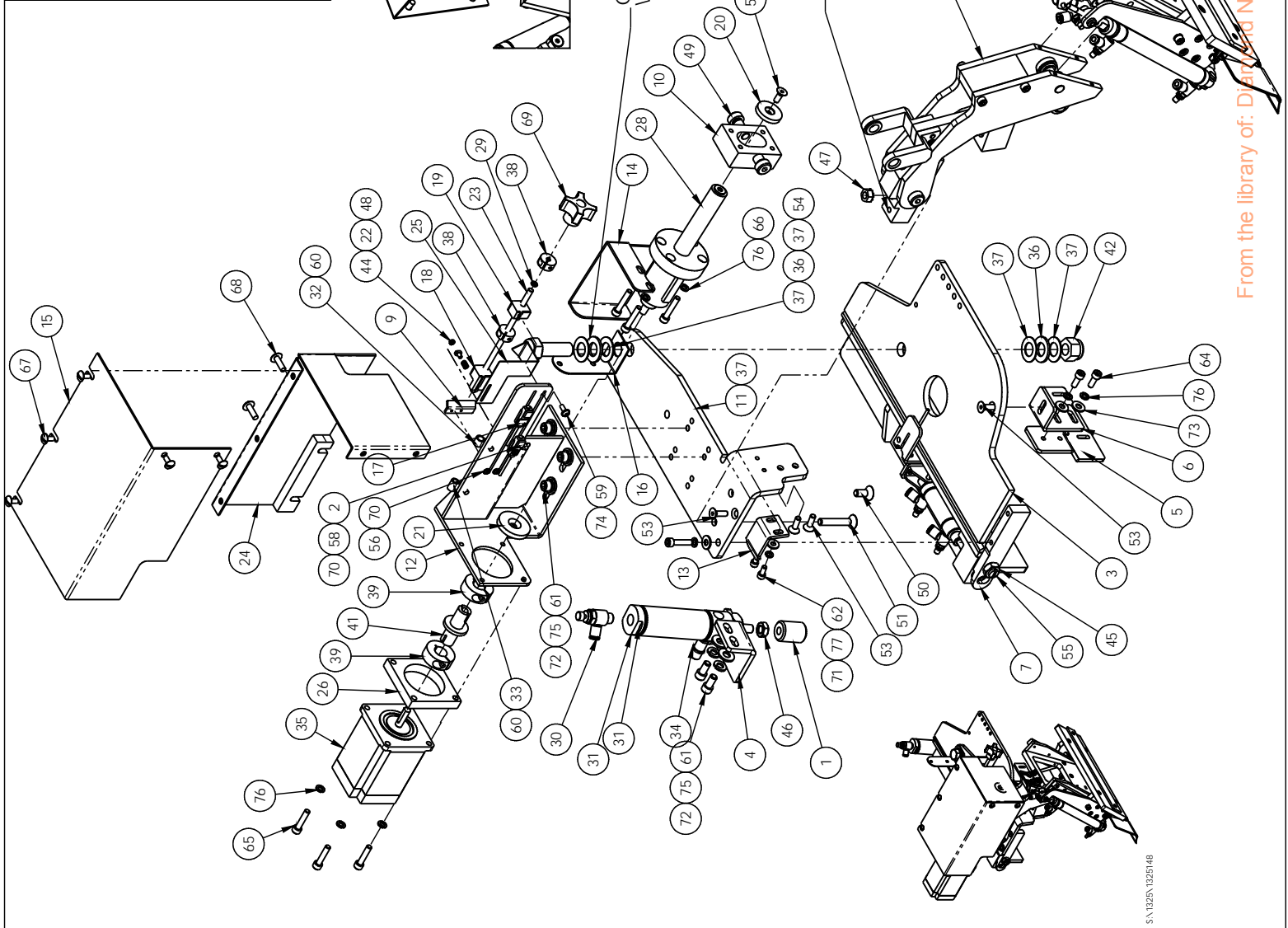
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ITEM NO.	QTY	PART NUMBER	DESCRIPTION
61	6	SSSC01032	1/4-20X1/2 SOCC CAP
62	2	SSSC90024	#8-32 X 3/8 SOCC CAP
63	4	SSSC90032	#8-32 X 1/2 SOCC CAP
64	2	SSSC98032	#10-32 X 1/2 SOCC CAP
65	5	SSSC98056	#10-32 X 7/8 SOCC CAP
66	4	SSSC98064	#10-32 X 1 SOCC CAP
67	5	SSIS90024	#6-32 X 3/8 TRUSS HD
68	2	SSIS98040	#10-32 X 5/8 TRUSS HD
69	1	TICLIAPPK1	PLASTIC KNOB, #10-32
70	4	WVWF2	WASHER, FLAT, #2
71	2	WVWF8	WASHER, FLAT, #8
72	6	WVWF1/4	WASHER, FLAT, 1/4
73	4	WVWF10	WASHER, FLAT, #10
74	1	WVWF56	WASHER, FLAT, #6
75	6	WVWL1/4	1/4 LW
76	12	WVWL10	#10 LW
77	2	WVWL8	#8 LW



GREASE THRUST BEARING  
WITH GREEN GREASE

HOLES NEED TO BE DRILLED OUT  
W 3/16 DRILL BIT THROUGH PIVOT  
PLATE 1335M-2008



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	11200A	BUMPER 5/16-24
2	2	1278-7055D	PROX SWITCH W/PLUG, 12"
3	1	1325149	RUFFLER MINI ASSY, TYP
4	1	1325156	FOOT LIFT BRKT
5	1	1325170	SUPPORT BRKT/RUFFLER
6	1	1335218	ADJ ANGLE/RUFFLER SUPP
7	1	1335324	LOCKING LEVER
8	1	1335332	RUFFLER CYL LIFT ASSY
9	1	1335M001	BRACKET, STOP, PRX SWITCH
10	1	1335M2006	BLOCK, NUT TRUNION
11	1	1335M2008	PIVOT PLATE
12	1	1335M2016	WELDMENT MOTOR BRKT
13	1	1335M2020	HD DWN BRKT
14	1	1335M2021	VALE, SWITCH ACTUATING
15	1	1335M2080	MOTOR COVER, CLEAR
16	1	1335M2081	PIVOT BRKT AIR LINE
17	1	1335M2084	PLATE, NUT #2-56
18	1	1335M2085	ADJUSTMENT NUT, 10-32
19	1	1335M2086	SUPPORT BLOCK
20	1	1335M2087	WASHER, STOP
21	1	1335M2088	STOP WASHER
22	1	1335M2089	NUT SPRING RETAINER
23	1	1335M2040	SCREW, ADJUSTMENT
24	1	1335M2042	COVER
25	1	1335M2047	POINTER, RUFFLE SIZE
26	1	1335M2049	SPACER, MOTOR, 3/8
27	1	1335M2080B	PIVOT ASSY
28	1	1335M2400	BALL SCREW AND NUT
29	1	AA198-7006	O RING, 1/8 I.D, 1/4 O.D
30	1	AA198R8508	FLOW CONTROL, 5/32 X 1/8"
31	1	AKC-6D-1.5	CYL, AIR, DA, 1-1/16, 1.5 S
32	1	AA1.8	CLAMP PLASTIC 1/8
33	1	AA13716	CLAMP, BLACK PLASTIC
34	1	AAQME-5-8	QUICK WALE ELBOW
35	1	AP-22E-103	STEP MOTOR/MODIFIED
36	2	BBVAF15	BEARING, THRUST 1/2 BORE
37	4	BBVAF15	WASHER, THRUST STEEL 1/2
38	2	CCCL10T	CLAMP COLLAR TRD, 10-32
39	2	CCCL18F	CLAMP COLLAR, 1/2
40	11"	MM130-10A1	TAPE UHMW, 1" W X .017K
41	1	MMBFM	JOINT UNIVERSAL MCD
42	1	NNE1/2-13	NUT ELASTIC 1/2-13
43	1	NNH10-32	#10-32 HEX NUT
44	1	NNH2-56	#2-56 HEX NUT
45	1	NNJ3/8-16	3/8-16 HEX, AM NUT
46	1	NNJ5/16-24	NUT, AM, 5/16-24
47	1	NNK1/4-20	KEP NUT, 1/4-20
48	1	RBLC02681	SPRING, COMP, 026X18X.25
49	2	SSA0204024M	3/8 X 3/4 X 5/16-18
50	1	SFC01040	1/4-20 X 5/8 FLAT ALLEN
51	1	SFC01096	1/4-20 X 1/2 FLAT ALLEN
52	1	SFC98032	#10-32 X 1/2 FLAT ALLEN
53	4	SFC98040	#10-32 X 5/8 FLAT ALLEN
54	1	SSHCA45096	1/2-13 X 1 1/2 L-HHCS
55	1	SSWB58N	PLUNGER BALL, 3/8, 16/5, R/L
56	2	SSPS0020	#2-56 X 5/16 PAN HD SLT
57	1	SSPS0032	#2-56 X 1/2 PAN HD SLT
58	1	SSPS0048	#2-56 X 3/4 PAN HD SLT
59	1	SSPS80024	#6-32 X 3/8 LG PAN HD
60	2	SSPS80024	#8-32 X 3/8 LG PAN HD

ATLANTA ATTACHMENT COMPANY

NAME: RUFFLER ASSEMBLY, TYP  
 PART NO.: 1325148  
 DRAWING NO.: 1325148  
 REV: 0

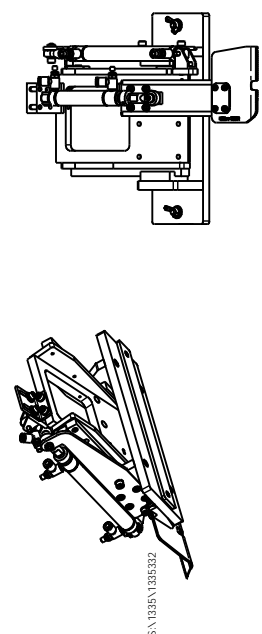
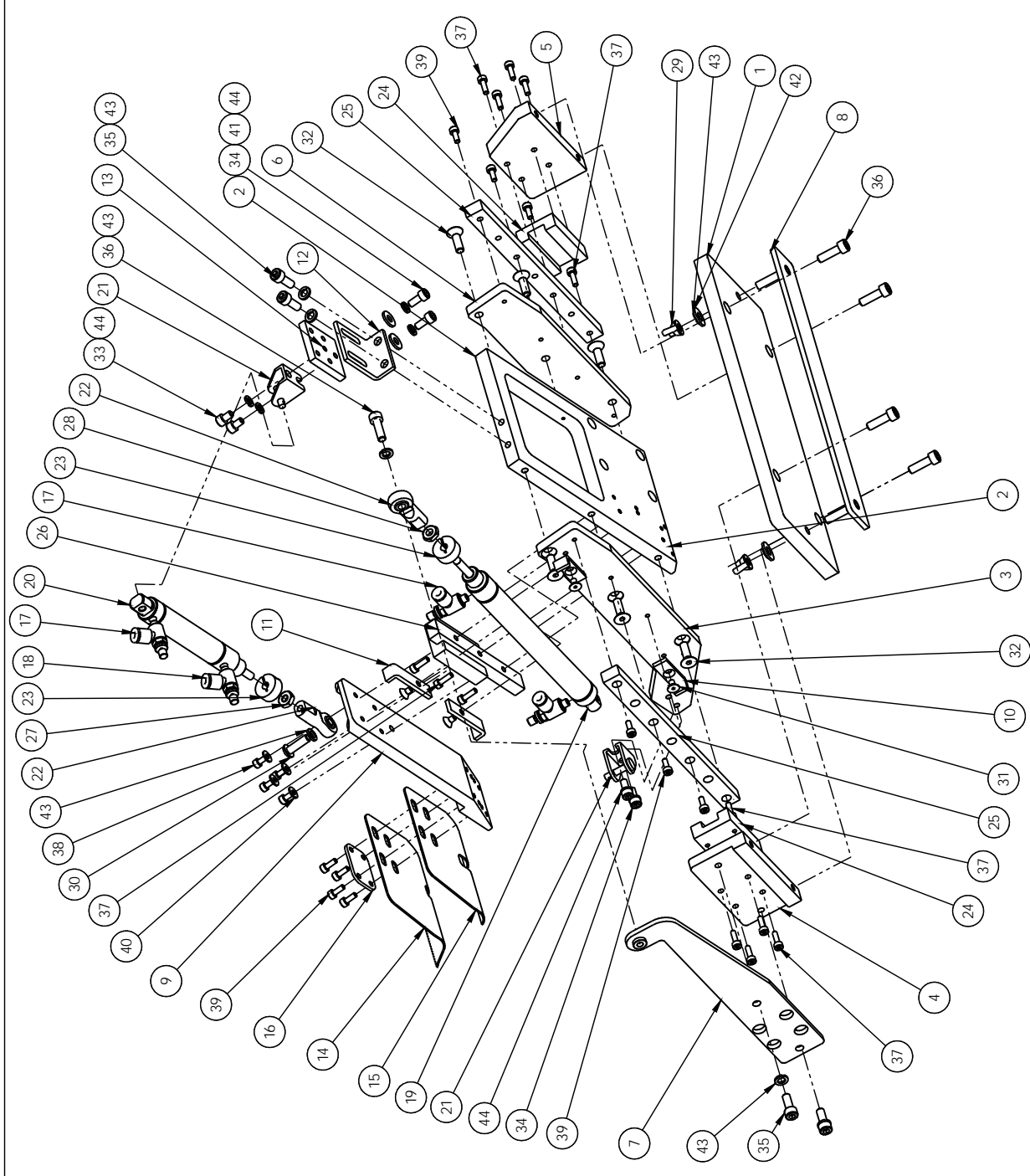
DATE: 12/22/2012  
 DWG SIZE: C-MECH 30.0000

SCALE: 1:3



From the library of: **Diagrams and Needle Corp**

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1335223	BASE MIG PLT FOLDER
2	1	1335224	BASE MIG PLATE
3	1	1335226	MIG PLT LH- RAIL
4	1	1335227	SUPPORT-SLIDE, LH SIDE
5	1	1335228	SUPPORT, RH
6	1	1335229	MIG PLT RH- RAIL
7	1	1335230	FOLDER SLIDE ARM
8	1	1335235	STUD PLATE-YAMATO1804
9	1	1335335	MIG PLT- HEAVY DUTY
10	2	1335338	BRG STOP
11	2	1335775	BEARING STOP, LONG
12	1	1335776	CYL. MOUNTING ANGLE
13	1	1335777	CYL. MOUNTING PLATE
14	1	1335M-2002E	BLADE, RUFFLER, 2.25 X 1.2
15	1	1335M-2002F	BLADE, RUFFLER, 2.25 X 1.2
16	1	1335M-5004	PLATE, WASHER, 136D/A@4PL
17	3	AA198RA510	FLOW CONTROL 5/32X10-32
18	1	AA198RR510	REV FL CONT.5/32X10-32
19	1	AAAC024DXP	CYL.BIMBA 9/16 B, 4 S
20	1	AAAC8DP-1.5	CYL. AIR, DA, 9/16B, 2S
21	2	AAF8P-8C	BRKT, PIVOT, 5/32 BORE
22	2	BBAW-3Z	BRG, ROD END, F, 10-32
23	2	CCCL3F	CLAMP COLLAR, 3/16
24	3	MMGN12HZ0HN	MG12H BEARING BLOCK
25	2	MMGNR12R0165HN	165MM RAIL - MG12H BLK
26	1	MMGNR12R090HN	12MM X 90MM RAIL
27	1	NNH10-32	#10-32 HEX NUT
28	1	NNJ10-32	NUT, JAM, THIN #10-32
29	2	NNW10-32	#10-32 WING NUT
30	1	SSBC98040	#10-32 X 5/8 BUT HEAD
31	4	SSF C80016	#6-32 X 1/4 FLAT ALLEN
32	6	SSF C98040	#10-32 X 5/8 FLAT ALLEN
33	2	SSSC90016	#8-32 X 1/4 SOC CAP
34	4	SSSC90024	#8-32 X 3/8 SOC CAP
35	4	SSSC98032	#10-32 X 1/2 SOC CAP
36	5	SSSC98040	#10-32 X 5/8 SOC CAP
37	13	SSSCM3X10	M3-0.5 X 10 SOC CAP
38	4	SSSCM3X6	M3-0.5 X 6 SOC CAP
39	10	SSSCM3X8	M3-0.5 X 8 SOC CAP
40	4	VWVF4	WASHER, FLAT #4
41	2	VWVF8	WASHER, FLAT #8
42	2	VWVF10	WASHER, FLAT #10
43	8	VWVL10	#10 LW
44	6	VWVL8	#8 LW



SA1335A1335332

NO.	REV.	DATE	BY	CHK.	APP.
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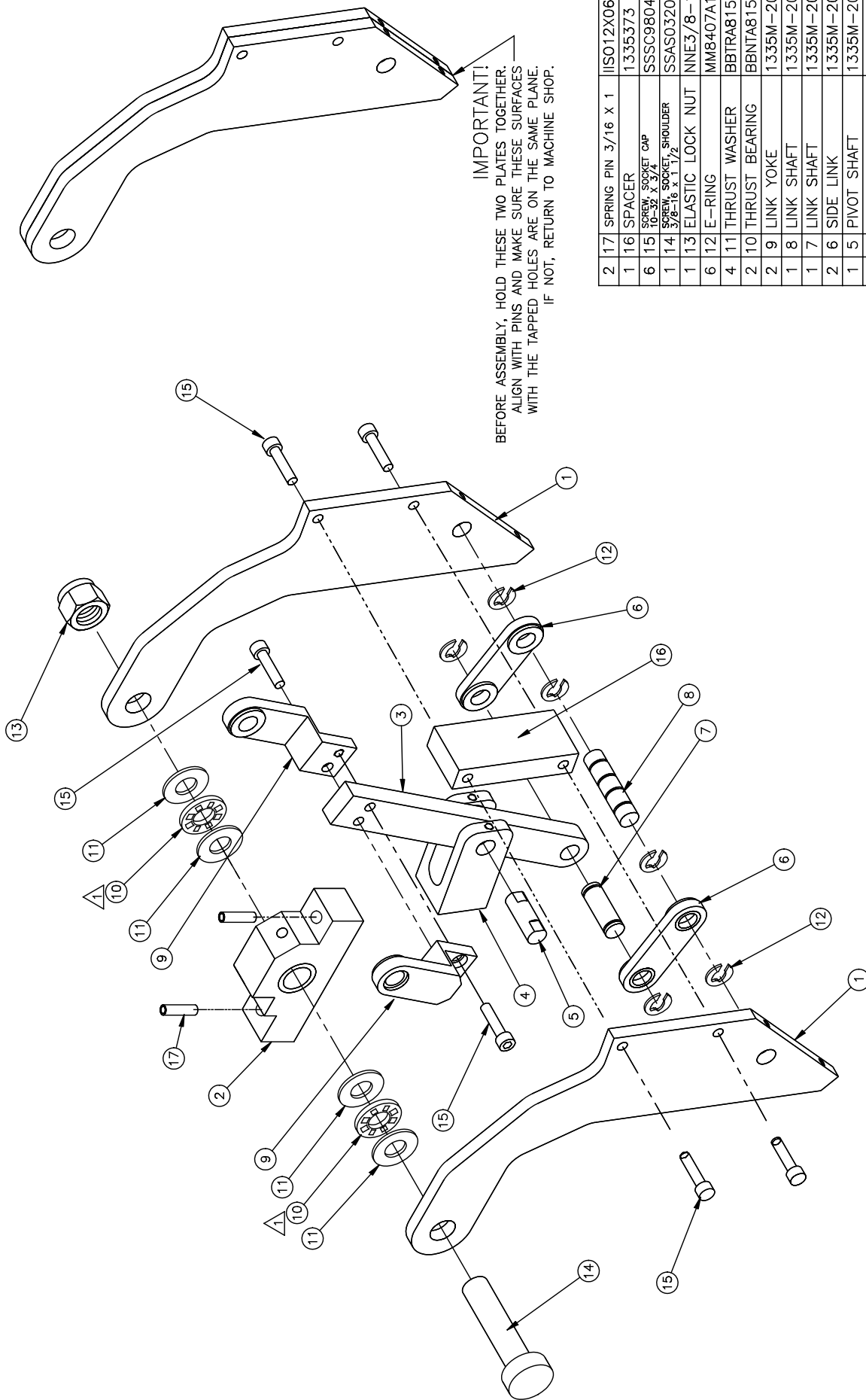
From the library of: Diamond Needle Corp

SHEET 1 OF 1

ATLANTA ATTACHMENT COMPANY

NAME: RUFFLER CYL LIFT ASSY  
 PART NO.: 1335235  
 DRAWING NO.: 1335234  
 DESIGNED BY: PRD  
 DRAWN BY: PRD  
 CHECKED BY: PRD  
 DATE: 10/27/2003  
 DWG. SIZE: C-MEGR 5/29/06

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**IMPORTANT!**  
 BEFORE ASSEMBLY, HOLD THESE TWO PLATES TOGETHER.  
 ALIGN WITH PINS AND MAKE SURE THESE SURFACES  
 WITH THE TAPPED HOLES ARE ON THE SAME PLANE.  
 IF NOT, RETURN TO MACHINE SHOP.

NOTES:  
 1 APPLY ACROLUBE GREASE BEFORE ASSEMBLY.

2	17	SPRING PIN 3/16 X 1	ISO12X064
1	16	SPACER	1335373
6	15	SCREW, SOCKET CAP	SSSC98048
1	14	SCREW, SOCKET SHOULDER	SSAS032096
1	13	ELASTIC LOCK NUT	NNE3/8-16
6	12	E-RING	MM8407A134
4	11	THRUST WASHER	BBTRA815
2	10	THRUST BEARING	BBNTA815
2	9	LINK YOKE	1335M-2015
1	8	LINK SHAFT	1335M-2014
1	7	LINK SHAFT	1335M-2013
2	6	SIDE LINK	1335M-2012
1	5	PIVOT SHAFT	1335M-2011
1	4	PIVOT BLOCK	1335M-2010
1	3	DRIVE LINK	1335M-2009
1	2	PIVOT BLOCK	1335M-2007
2	1	PIVOT ARM	1335M-2004A

3	246-07	12-18	18	XX
2	149-07	16-18	18	XX
1	138-07	8-17	18	XX
NO.	REVISION	DATE	DR.	CHK.

FINISH		NAME
PLAIN / CLEAN	PIVOT ASSY	
BLACK OXIDE		
BLACK ENAMEL		
SAND BLAST		
BLUFF		
PAINT		
CHROME		
UNFINISH		
OL		

2nd DES.		11335MFB
MATERIAL NOTED		
ASSEMBLY		1335382
DES. BY		PBD
DRAWING NO.		19298503
DR. BY		MATT DASHER
CHK. BY		MATT DASHER
SCALE		1/1.25
DATE		1-22-03
MACH. CL.		

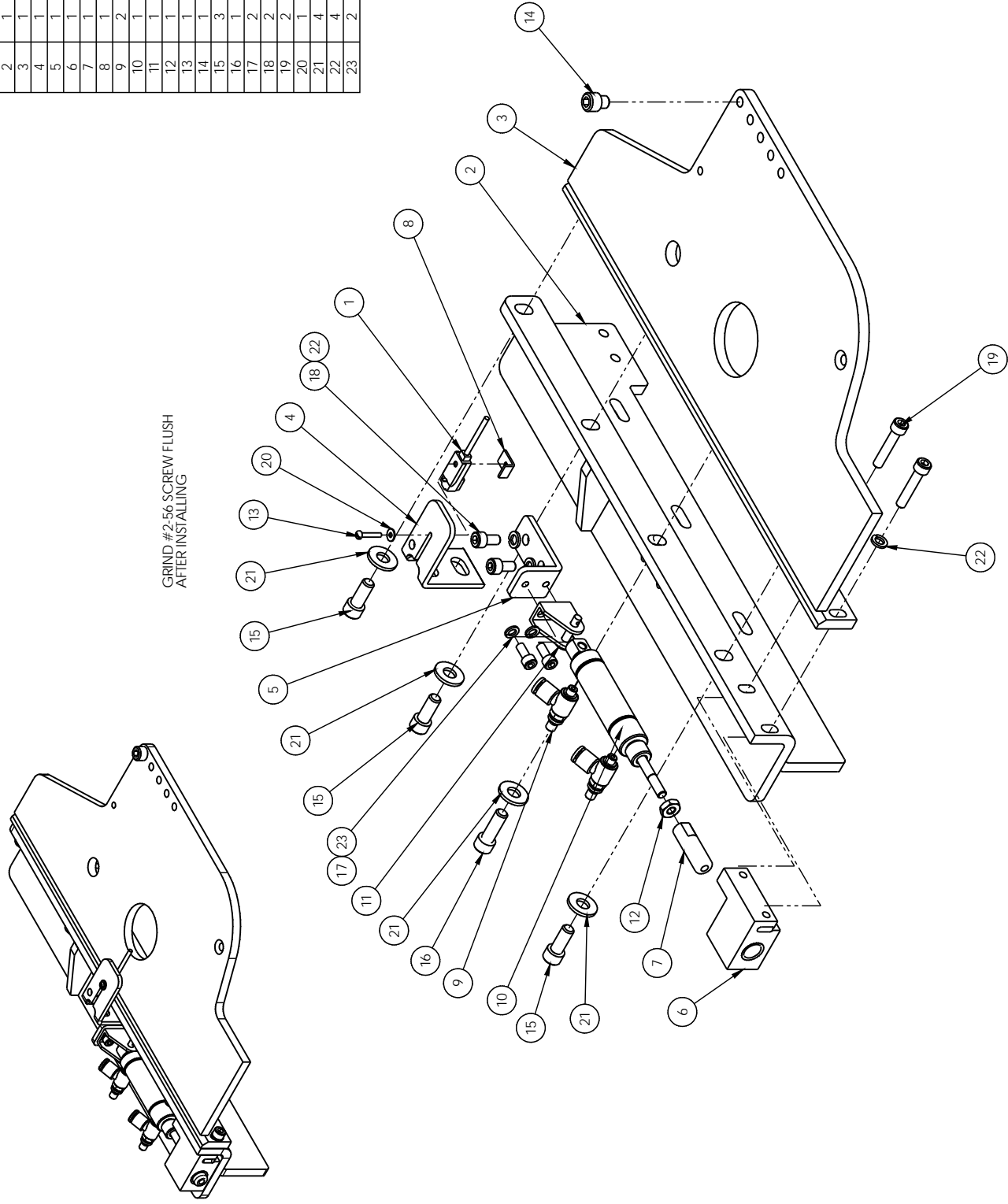


085-04

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ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1278-7055D	PROX SWITCH W/PLUG, 12"
2	1	1325150	RUFFLER MITG BRKT. WELD DT
3	1	1335315	BASE PLATE, RUFFLER MITG
4	1	1335325	MITG. BRKT. SENSOR
5	1	1335330	MITG. BRKT. LOCK PIN CYL.
6	1	1335334	CYL. MOUNT
7	1	1335M-2017	ROD. END
8	1	1335M-2034	PLATE, NUT #2-56
9	2	AA198RA510	FLOW CONTROL 5/32X10-32
10	1	AAC8DP-5	CYL. AIR DA. 9/16 B. 17/32
11	1	AAFBP-8C	BRKT. PIVOT 5/32 BORE
12	1	NNH10-32	#10-32 HEX NUT
13	1	SPF550032	#2-56 X 1/2 PAN HD SLOT
14	1	SSSC010165	1/4-20 X 1/4 SOC CAP SC
15	3	SSSC01040	1/4-20 X 5/8 SOC CAP
16	1	SSSC01048	1/4-20 X 3/4 SOC CAP
17	2	SSSC90024	#8-32 X 3/8 SOC CAP SC
18	2	SSSC98024	#10-32 X 3/8 SOC CAP
19	2	SSSC98064	#10-32 X 1 SOC CAP
20	1	WWF2	WASHER, FLAT #2
21	4	WWFS1/4	WASHER, FLAT 1/4
22	4	WM10	#10 LW
23	2	WW1B	#8 LW

GRIND #2-56 SCREW FLUSH  
AFTER INSTALLING



REV. NO.	DESCRIPTION	DATE	BY
1	ATLANTA ATTACHMENT COMPANY		

FINISH	DEFAULTS
MANUFACTURER	COMPARISONS
DESIGNER	DATE
DR BY	PRD
CHK BY	PRD
SCALE	1:1.5
DATE	
DWG. NO.	1325149
DWG. SIZE	0

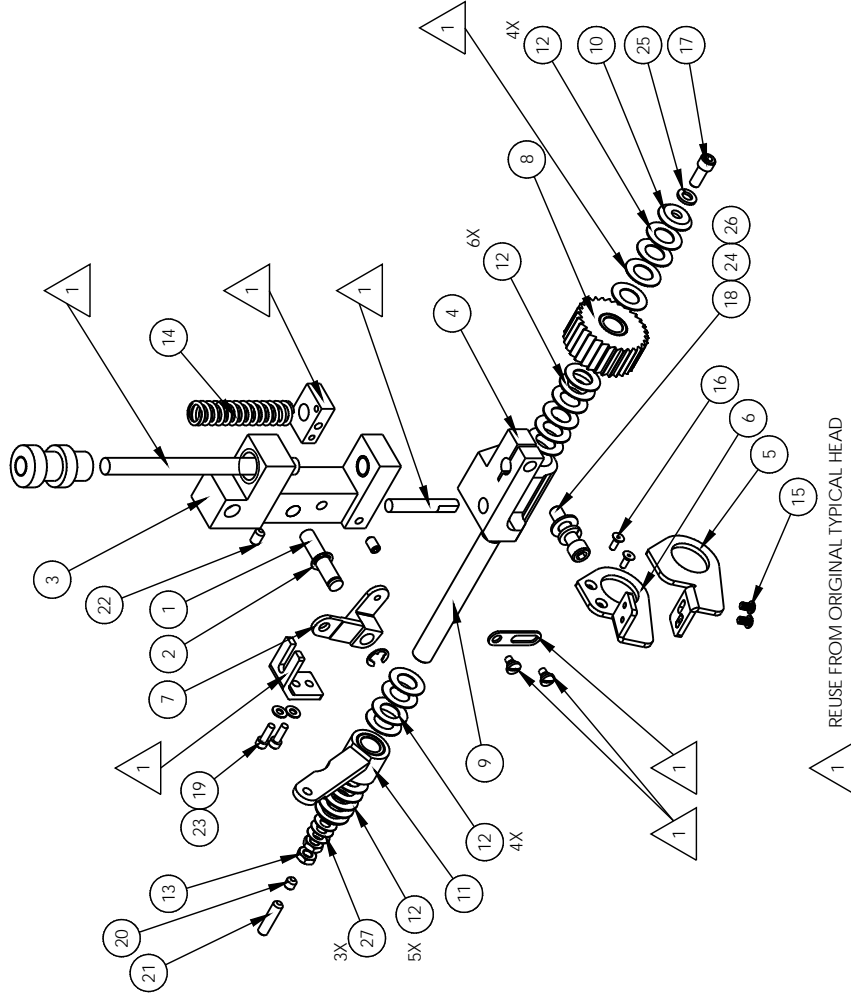


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Notes:

1. ARRANGE THE COMPONENTS AS SHOWN (APPLY TEFLON BASED GREASE TO BEARINGS AND A SMALL AMOUNT TO ALL MATING THRUST WASHER SURFACES)
2. SCREW IN THE SMALL SET SCREW TO LEAVE ABOUT 3/8" OF THREADS IN THE AXLE ON THE RIGHT SIDE.
3. INSTALL AND TIGHTEN THE LARGE SET SCREW (21) AGAINST THE SMALL SET SCREW TO FORM A STUD.
4. PRELOAD THE ASSEMBLY USING THE SOCKET CAP SCREW AND THE LOCK WASHER ON THE LEFT SIDE.
5. PRELOAD THE ASSEMBLY USING THE INSIDE JAM NUT UNTIL THE ROLLER HAS DRAG ON IT TO PREVENT PULLER ROLLER OVER-SPINNING AT THE HIGH SEWING SPEEDS.
6. TIGHTEN THE OUTSIDE JAM NUT TO LOCK THE PRELOAD SETTING.



ITEM NO.	Hardware Shown/Qty.	PART NUMBER	DESCRIPTION
1	1	0065375	UPPER ROLLER LIFT PIN
2	2	0095027	RING, RETAINING, YAMATO
3	1	1325157	PULLER BRACKET
4	1	1325158	YOKE, PULLER-HD
5	1	1325161	STRIPPER PLATE, EXTENDED
6	1	1325162	STRIPPER PLATE, EXTENDED
7	1	1334056	PULLER LIFT LINK, 11-64-40
8	1	1335397	PULLER ROLLER, HD, 2002MG
9	1	1335399	SHAFT, PULLER, HD
10	2	1335400	WASHER, HUB CAP, 1/4
11	1	1335414	DRIVE ARM, PULLER, HD
12	18	BBTRA815	WASHER, THRUST, STEEL, 1/2
13	2	NNJ1/4-28	NUT, HEX, JAM, 1/4-28
14	1	RRLC092HT11M	SPRING, COMP., 092X.60X2.75
15	2	SSBC90016	8-32 X 1/4 BUTTON CAP
16	2	SFC80024	6-32 X 3/8 FLAT CAP
17	1	SSSC05040	1/4-28 X 5/8, SOC CAP
18	1	SSSC20080	5/16-24 X 1-1/4 SOC CAP
19	2	SSSC90032	#8-32 X 1/2 SOC CAP SC
20	1	SSSS05016	1/4-28 X 1/4 KNURL PT
21	1	SSSS05064	SET SCREW 1/4-28X1
22	2	SSSSM6X10	M6 SET SCREW, 10MM L
23	2	WVMB5/32	WASHER, FLAT, 5/32", BRAS
24	1	WVWF5/16	WASHER, FLAT, SAE, 5/16
25	1	VVWL1/4	WASHER, LOCK, 1/4
26	1	VVWL5/16	WASHER, LOCK, 5/16
27	3	VVWS307-1	WASHER, SPRING, BELVEL

NO.	ECR NO.	DATE	DR	CK
2	2013	8/15	PD	RB
1	2013	8/5	PD	RB

FINISH		DEFAULTS	
PLAIN/CLEAN		COUNTERSINKS	
FLUR/RFINCH			
BLACK OXIDE			
SAND BLAST			
BLUF			
PAINT			
TEMP COAT			
UNFINISHED			
ZINC			

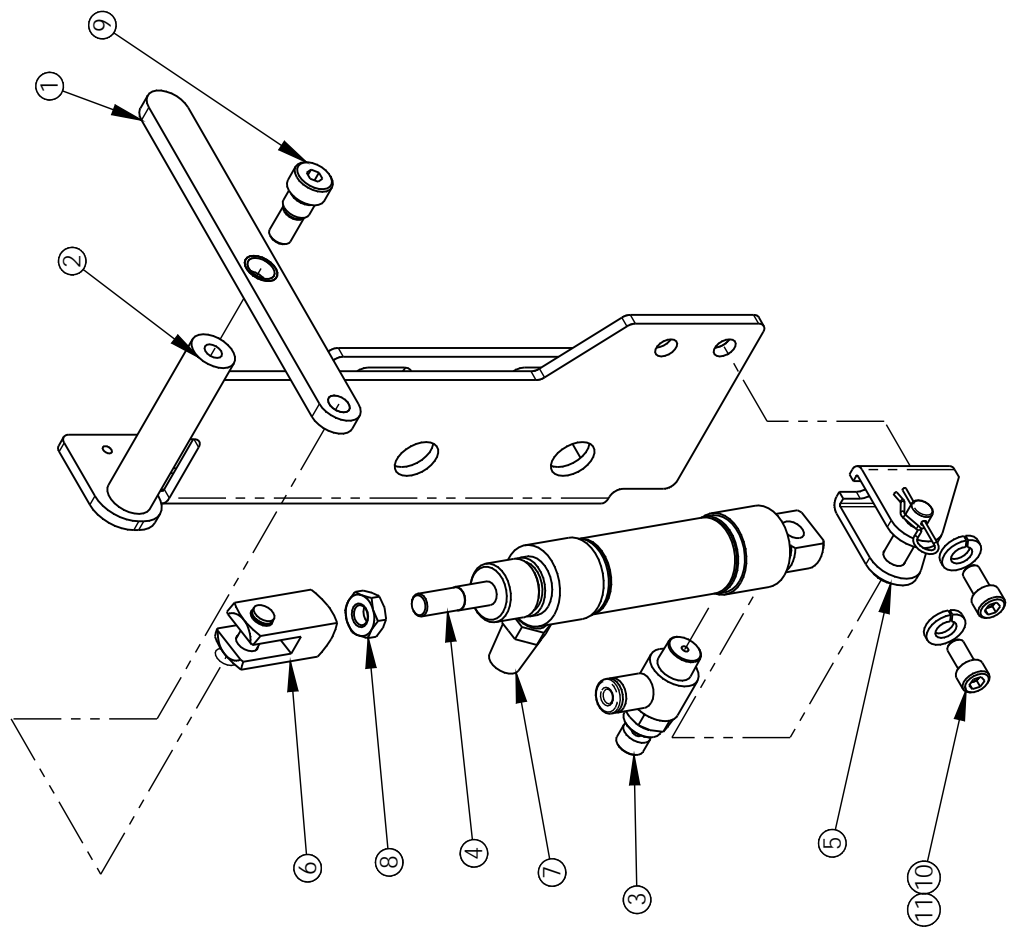




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NAME: PULLER SUB-ASSY		ATLANTA ATTACHMENT COMPANY	
2nd DRS: TYPICAL GK321-12			
MATERIAL: NOTED			
ASSEMBLY: 1325144		PART NO.: 1325160	
DES BY: FBD	DR BY: FBD	DRAWING NO.	REV
		1325160	2
SCALE: 1:3	DATE: 1/14/2013	DWG SIZE: B WEIGHT	



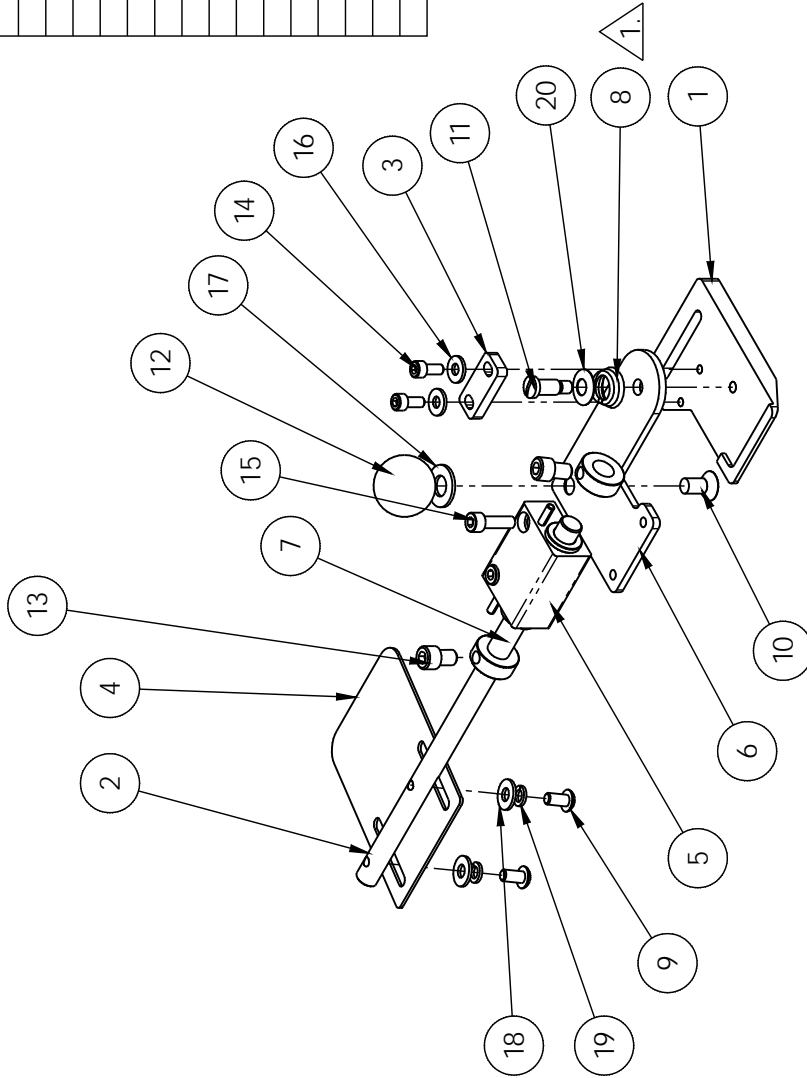
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	1335M-108	LEVER
2	1	1325171	MTG BRKT, FOOT LIFT
3	1	AA198RR508	FLOW CONTROL, 5/32 X 1/8"
4	1	AAC7DP-.5	CYLINDER, AIR, DA
5	1	AAFBP-11C	BRKT, PIVOT, 1/4 BORE
6	1	AAFCT-7	CLEVIS, AIR CYL, 1/4-28
7	1	AAFP18	MUFFLER, 1/8 NPT, BRONZ
8	1	NNJ1/4-28	1/4-28 HEX JAM NUT
9	1	SSAS020016	SHOULDER BOLT 1/4 X 1/4L
10	2	SSSC98024	#10-32 X 3/8 Lg. SHCS
11	2	WWLM6	M6 LOCK WASHER



S:\1325\1325173		RESEARCH & DEVELOPMENT	
WORK ORDER:	QTY. FOR TRIAL: 1	RETURN TO: P. DASHER	
MACHINE TIME:	QTY. PER ASSY: 1		
DESIGN TIME:			
NEEDED BY:			
CHECKED BY:			
<p>THE INFORMATION ON THIS DRAWING IS THE INTELLECTUAL PROPERTY OF ATLANTA ATTACHMENT COMPANY AND ITS AFFILIATES. THIS DRAWING MAY NOT BE COPIED IN ANY FORM WHATSOEVER. THIS INFORMATION MAY NOT BE USED BY ANY UNAUTHORIZED PERSON OR 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.</p>			
			
<p>FINISH</p> <p>BLANK/CLEAN</p> <p>BLACK OXIDE</p> <p>BLACK OXIDE</p> <p>HEAT TREAT</p> <p>SAND BLAST</p> <p>PAINT</p> <p>BLUF</p> <p>CLEAR CHROMATE</p> <p>TIME SAVE</p> <p>OTHER</p>		<p>DEFAULTS</p> <p>COUNTERSINKS</p> 	
<p>NAME: FOOT PRESSURE ASSY</p> <p>2ND DES: 11335MT</p> <p>MATERIAL: NOTED</p> <p>ASSEMBLY: 1325144</p> <p>DES BY: PBD</p> <p>DR BY: PBD</p> <p>CK BY:</p>		<p>ATLANTA ATTACHMENT COMPANY</p> <p>SCALE: 1:2</p> <p>DATE: 1/11/2013</p> <p>DWG SIZE: A</p> <p>WEIGHT: 1.430903</p>	
<p>PART NO. 1325173</p> <p>DRAWING NO. 1325173</p> <p>REV 0</p>		<p>SHEET 1 OF 1</p>	

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ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	1325174	MOUNT PLATE, SWING-OUT
2	1	1335154	PIVOT ROD, STRIP BLADE
3	1	1335239	STOP BLK-STRIPPER BLADE
4	1	1335475	STRIPPER BLADE-1804P
5	1	1335624	Block, Mounting
6	1	1335627	MOUNT ARM, STRIPPER BLADE
7	2	CCSC6F3.8	COLLAR,SET 3/8
8	1	RRBEEHIVEH	SPRING,HEAVY BEEHIVE
9	2	SSBC98024	#10-32 X 3/8 BUT HEAD
10	1	SSFC01032	1/4-20 X 1/2 FLAT ALIN CAP
11	1	SSM200246	SCREW,SHLDR,SLT,248X.437L
12	1	SSMBK13	KNOB,BLACK PLASTIC
13	2	SSSC01024	1/4-20 X 3/8 SOC.CAP
14	2	SSSC90024	#8-32 X 3/8 SOC CAP
15	2	SSSC98040	10-32 X 5/8 SOC CAP
16	2	WWF8	WASHER, FLAT #8
17	1	WWF5/16	WASHER,FLAT,SAE,5/16
18	2	WWF510	WASHER, FLAT #10
19	2	WWL10	#10 LW
20	1	WWWS307-1	WASHER,SPRING,BELVEL



1. CUT OFF ONE FULL COIL FROM THE BOTTOM OF THE SPRING (ITEM 8)

SHEET OF 1

FINISH	DEFAULTS	NAME	ATLANTA ATTACHMENT COMPANY
<input checked="" type="checkbox"/> BLAZING/CLAN	CONVERSIONS	2nd DES.	STRIPPER BLADE ASSY
<input type="checkbox"/> BLUR/RENCH		MATERIAL	AS NOTED
<input type="checkbox"/> BLACK/CONCH		ASSEMBLY	1325174
<input type="checkbox"/> SAND/BLAST		DES BY	FBD
<input type="checkbox"/> BLUF		DR BY	FBD
<input type="checkbox"/> PAINT		SCALE	1:2
<input type="checkbox"/> POLY/COAT/STRE		DATE	1/7/14/2013
<input type="checkbox"/> THIN/SAVE		DWG SIZE	B
<input type="checkbox"/> OTHER		WEIGHT	1.28POZ

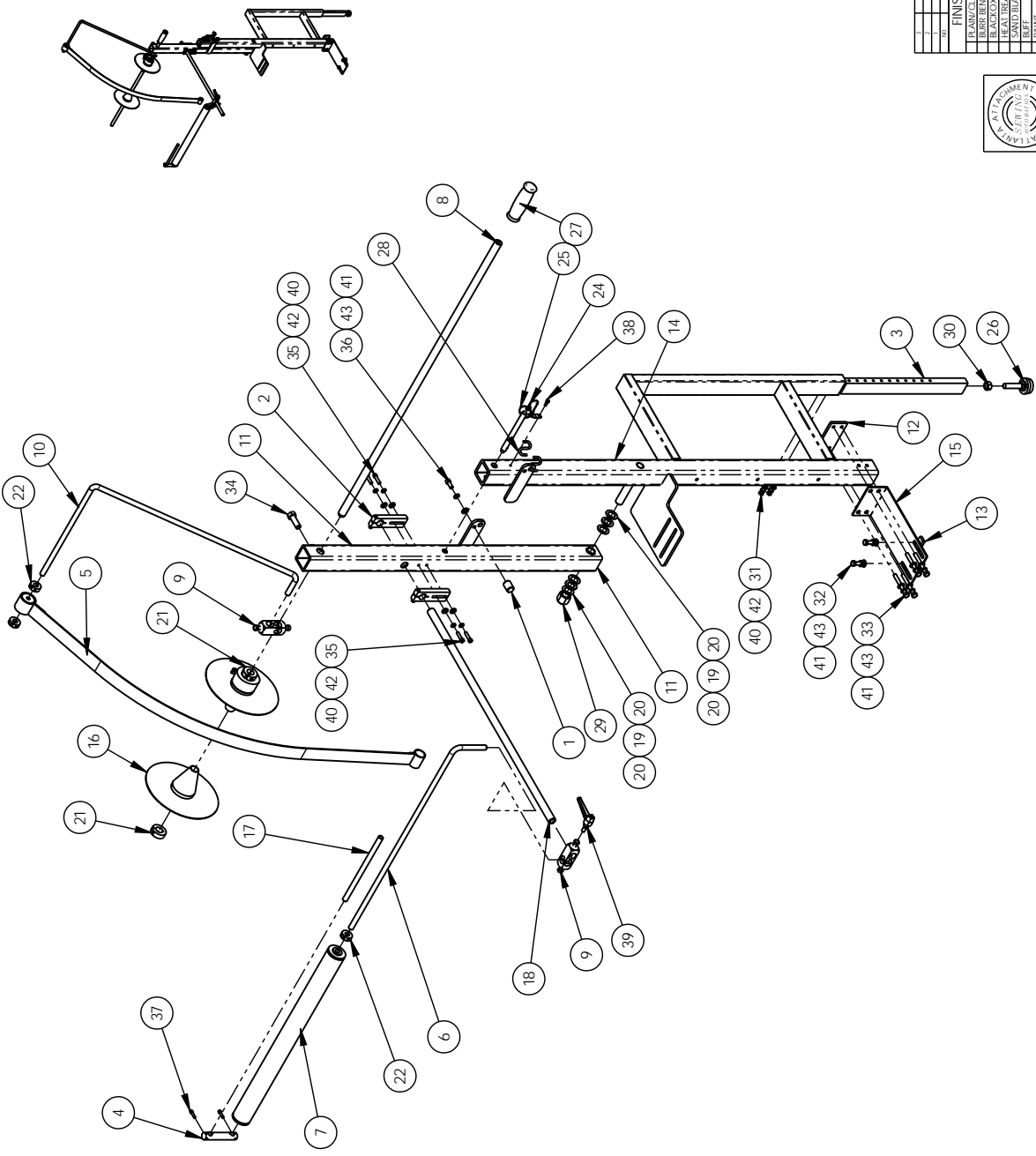


2013

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S:\1325\1325175

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	11200A	BUMPER 5/16-24
2	2	1325-346A	HOLDER, ROD, 3/4", SLOT
3	1	132556-273	LEG, 3/4 X 1-1/2 X 15 LG
4	1	1335-319B	ARM, 1/2" ROD CLAMP
5	1	1335-825	DRAG TENSION ASSEMBLY
6	1	1335-835A	ROD, 1/2" DIA, 90 DEG
7	1	1771-205	ROLLER, 2.00DX.51DX23.38L
8	1	1961-252E	ROD, ROLL, 3/8.0L
9	2	28201	BLOCK, CROSS (LARGE)
10	1	1335179	ROD, BENT, CRS, 1/2 OD
11	1	1335664	PIVOT, SWING ARM, UNWINDER
12	1	1335667	NUT, PLATE, 5/16-18 4X
13	1	1335794	NUT, PLATE, 5/16-18.2@2.25
14	1	1335931	MAIN SUPPORT, UNWINDER
15	1	1335932	STABILIZER, UNWINDER, 1335E
16	2	33008708	BALL BEARING, DISC ASSY
17	1	8732-0576	ROD, STRAIGHT, SS, 1/2 X
18	1	97-17111	TUBE, 3/4 X 30 X 1/8 WALL
19	2	BBN1A1220	BEARING, THRUST, 1750B
20	4	BB1RA1220	WASHER, THRUST, STEEL
21	2	CCCL12F	CLAMP, COLLAR, 3/4
22	3	CCCL18F	CLAMP, COLLAR, 1/2
23	2 FT	K-3594147	CHAIN, 190, 34W
24	1	MM30345121	LANYARD, 61 LONG
25	1	MM98320A525	QUICK RELEASE PIN, 1/2 DIA
26	1	MMFB4444	FOOT, RUBBER
27	1	MMGP-105	GRIP HANDLE, FOAM, 3/4 ID
28	2	MM6096	HOOK, S, 3/16 X 1-1/2"
29	1	NNE3/4-16	NUT, ELASTIC LOCK, 3/4-16
30	1	NNH1/2-13	NUT, HEX, 1/2-13
31	2	SHC10064	1/4-20X1 HEX HEAD
32	2	SHC10064	5/16-18 X 1 HEX HEAD
33	4	SHC10176	5/16-18 X 2-3/4 HEX HEAD
34	1	SSHC45096	1/2-13 X 1-1/2 HEX HEAD
35	4	SSCOT1064	1/4-20 X 1 SOC CAP
36	1	SSSC20048	5/16-24 X 3/4 SOC CAP
37	2	SSSC96048	#10-24 X 3/4 SOC CAP
38	1	SSSC98032	#10-32 X 1/2 SOC CAP
39	1	TH32425	HANDLE, THREADED, 5/16-18X3/4
40	6	WMF51/4	WASHER, FLAT, 1/4", SAE
41	7	WMF55/16	WASHER, FLAT, 5/16
42	6	WWL1/4	WASHER, 1/4
43	7	WWL5/16	5/16 LW



FINISH	DEFAULTS
BLAZZALAN	NAME
BLUR, BENCH	ROLLHOLDER ASSY/OVERHEAD
BLAZZALAN	2001 DES. FOR 1335M
BLAZZALAN	MATERIAL
BLAZZALAN	ASSEMBLY 11335M
BLAZZALAN	DES BY ENW
BLAZZALAN	CHK BY EJM
BLAZZALAN	SCALE 1:1
BLAZZALAN	DATE 3/1/2005
BLAZZALAN	DWG SIZE B
BLAZZALAN	WEIGHT 74.42604



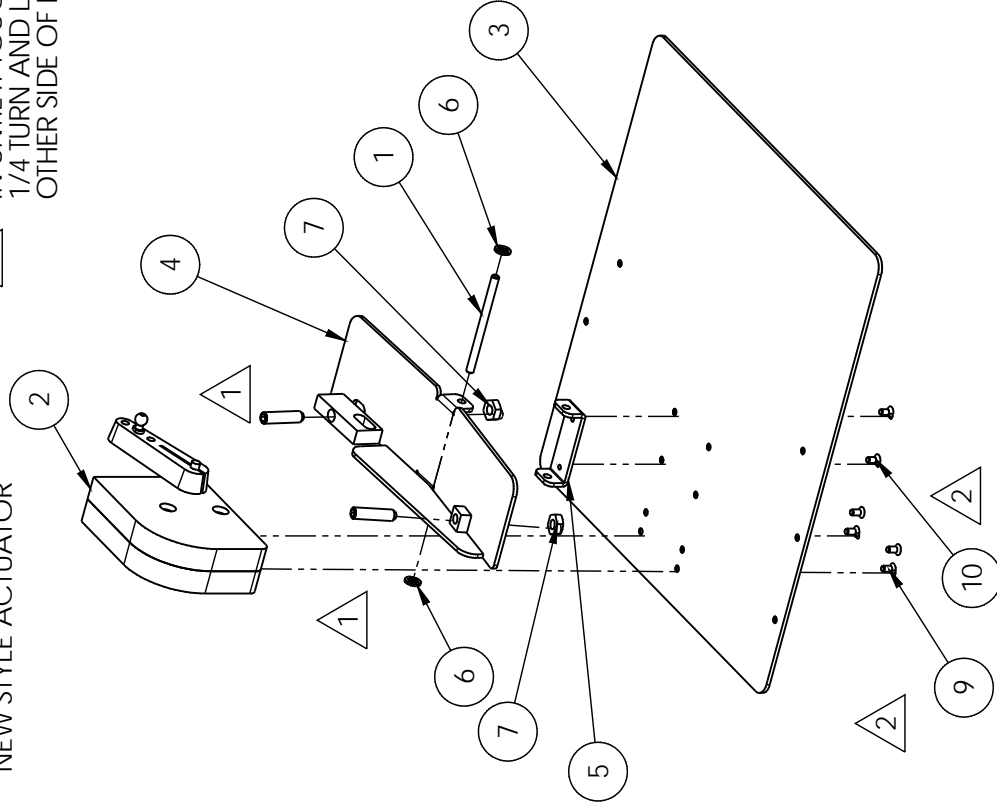
062-05

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From the library of: Diamond Needle Corp

PROVIDED WITH EFKA MOTOR  
SEE 4059-FP401D FOR  
NEW STYLE ACTUATOR

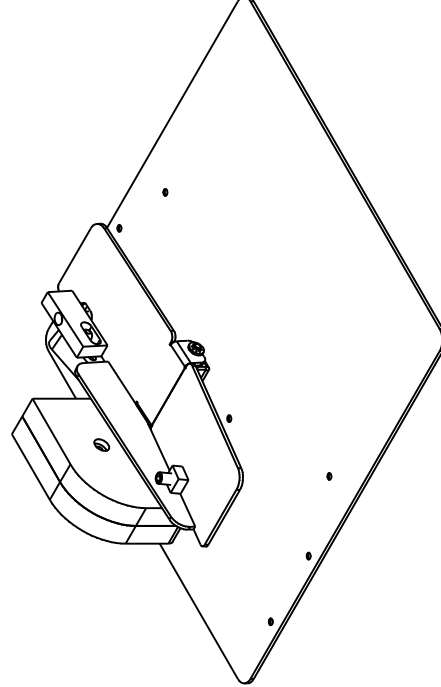
1 HOLD END OF PEDAL DOWN. TURN SCREW  
IN UNTIL IT TOUCHES PLATE. TURN ANOTHER  
1/4 TURN AND LOCK NUT IN PLACE. REPEAT ON  
OTHER SIDE OF PEDAL



NOTES:

- 2 COUNTERSUNK SCREWS SSFC98024 AND SSFPM5X10 SHOULD BE SECURED WITH BLUE LOCK-TITE.

ITEM NO.	Default/QTY.	PART NUMBER	DESCRIPTION
1	1	26058	ROD, STRAIGHT, 1018
2	AR	4059-EB301A	ACTUATOR/TREADLE, 9 PIN
3	1	4059030	BASE, FOOT PEDAL, 12X18
4	1	4059033	FOOT PEDAL WELDMENT
5	1	A3502-4	FOOT PEDAL, BRACKET
6	2	MM94807A029	PUSHNUT, ROUND, 1/4 DIA
7	2	NNJ3/8-16	3/8-16 JAM NUT
8	2	SSSS25096	3/8-16 SET SCREW, 1-1/2"
9	4	SSFPM5X10	SCREW, FLAT PHILLIPS
10	2	SSFC98024	# 10-32 X .375 FLAT CAP



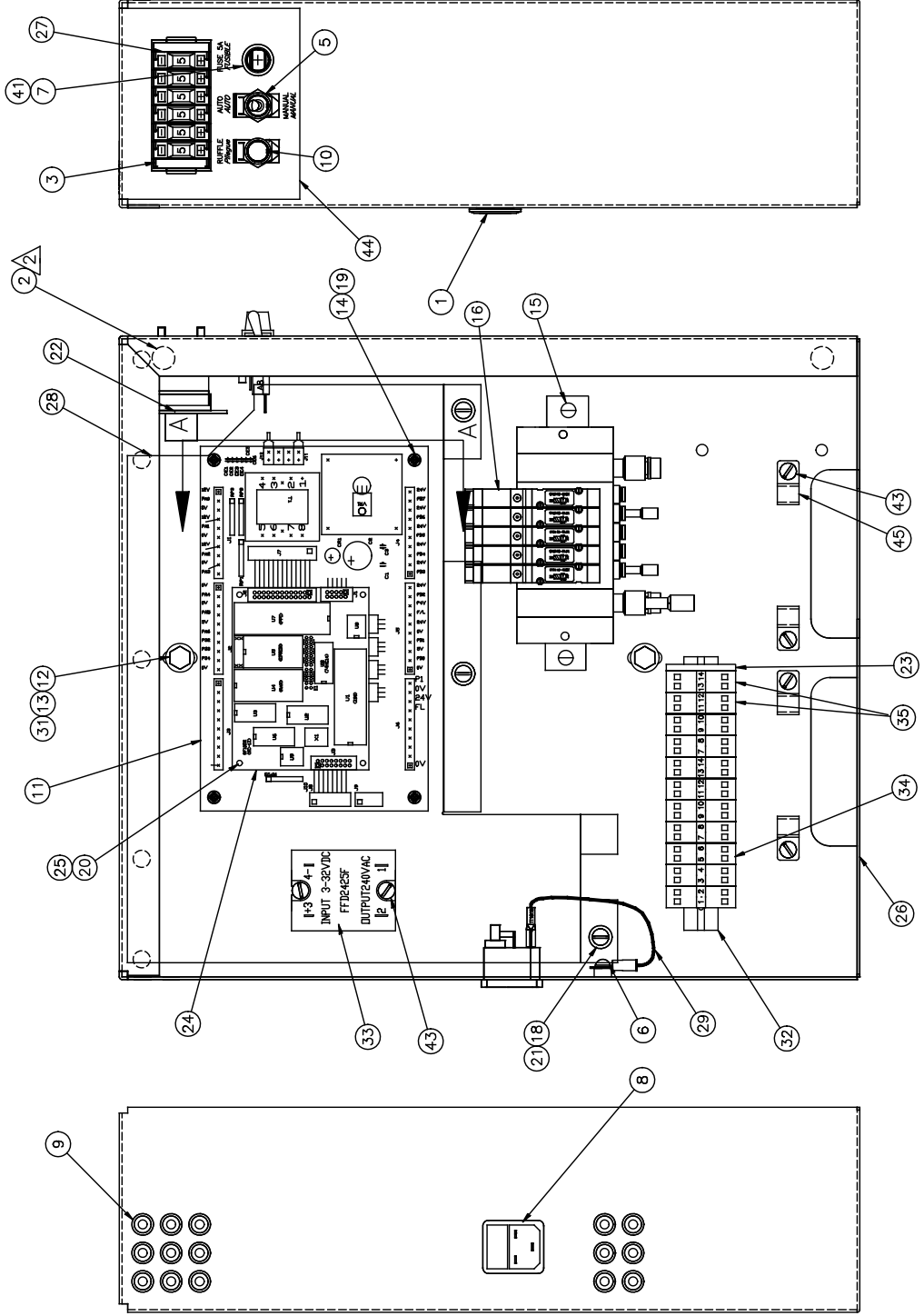
SA4059V4059-FP301D

3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50
FINISH	FLAME CLEAN	BLUR RENCH	BLACK OXIDE	SAND BLAST	BLUFF	PAINT	POSSIBLE	IMPROVE	OTHER	COMMENTS	DETAILS	NAME	FOOT PEDAL ASSY EFKA	2nd DES.	WITH EB401, 12" X 18"	MATERIAL	NOTED	ASSEMBLY	4059-FP301D	PART NO.	4059-FP301D	DES BY	ME	DR BY	Michael Elder	SCALE	1:4	DATE	11/10/2004	DWG SIZE	B	WEIGHT	14921115														

ATLANTA ATTACHMENT COMPANY  
303-04

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ATLANTA ATTACHMENT COMPANY  
NAME: FOOT PEDAL ASSY EFKA  
2nd DES. WITH EB401, 12" X 18"  
MATERIAL: NOTED  
ASSEMBLY: 4059-FP301D  
PART NO.: 4059-FP301D  
DES BY: ME  
DR BY: Michael Elder  
SCALE: 1:4  
DATE: 11/10/2004  
DWG SIZE: B  
WEIGHT: 14921115



VALVE DESIGNATION  
 La DESIGNACION de la VALVULA

RUFFLER UP/DN	5
RUFFLER LOCK	4
FOLDER UP/DN	3
PULLER LIFT	2
FOOT LIFT	1

NOTES:

- △ NOT SHOWN, SEE 125665C
- △ ON INSIDE OF DOOR.

NO.	FINISH	DESIGNATION	LEVEL	UNIT	GR.
11	095-11	7-28 TM RB			
10	143-08	6-26 MDF MF			
9	128-08	6-6 RA			
8	098-05	2-22 TM MD			
7	098-05	2-22 TM MD			
6	021-05	1-12 EM MD			
5	313-04	11-16 MD MD			
4	264-04	10-4 MD MD			
3	229-04	8-26 TM MD			
2	229-04	8-26 TM MD			
1	095-11	7-28 TM RB			



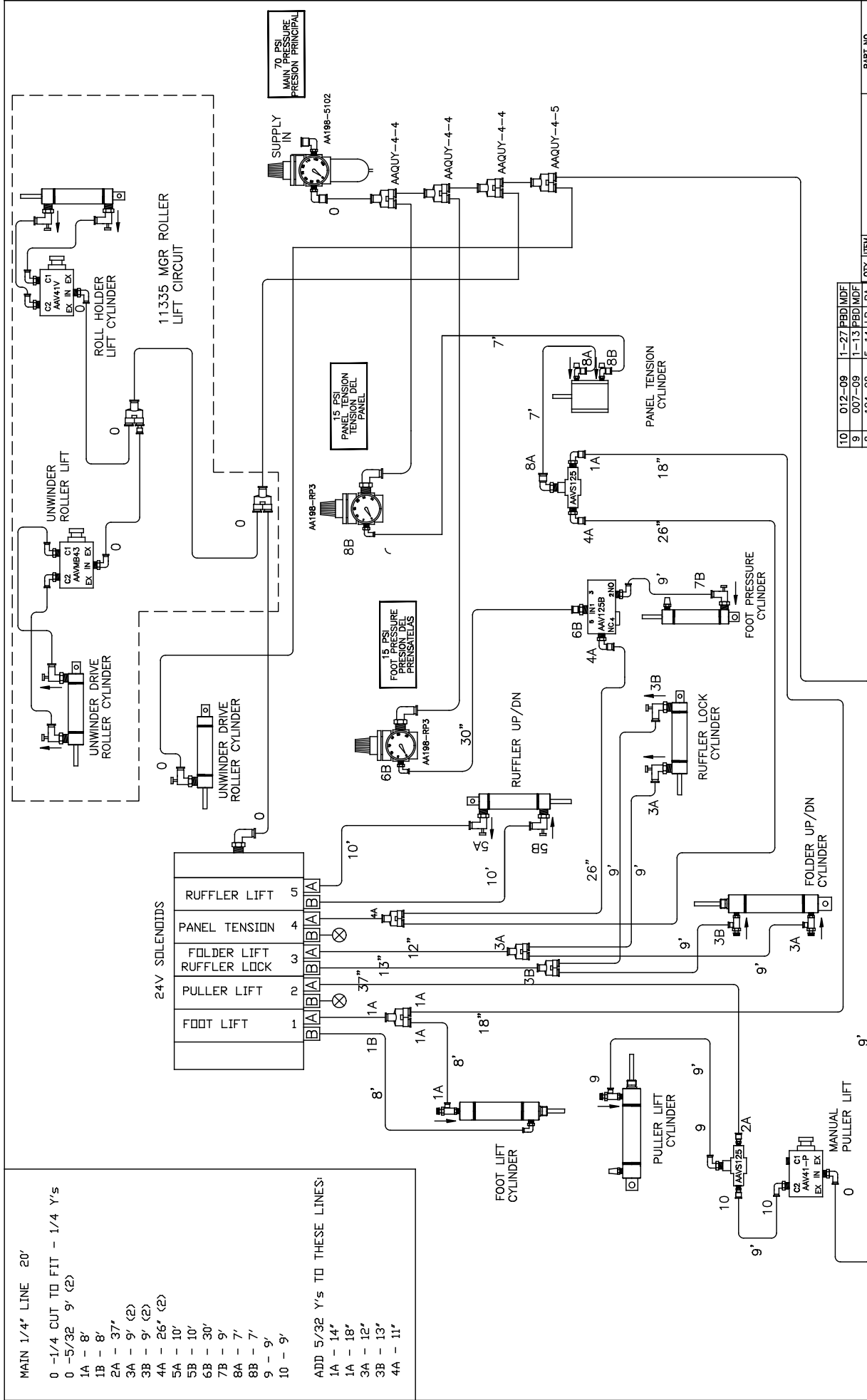
329-03

ATLANTA ATTACHMENT COMPANY

NAME	CONTROL BOX ASSY
2nd DES.	T335MNF
MATERIAL NOTED	
ASSEMBLY	T335Z97
DES. BY	TAO / 1
CHK. BY	JEFF THOMAS
DATE	192909B
SCALE	1/1.75 [DATE: 9/8/03]
REV	11

AR	NO.	DESCRIPTION	QTY	REF. NO.
A	54	INSF1024A POT SETTINGS		FF1024A-PGM
A	53	BARRIER STRIP		FF12F1042
A	52	CABLE, 26 CON RIBBON		1987149F
A	51	CABLE, JUMPER		1987149F5
A	50	CABLE, 3PIN FM MOLEX		1335-022
A	49	20W 1/2" X 1/2" THT		SSPS98080
A	48	1/2" X 1/2" THT		FF2501A40A
A	47	CABLE, SYNC FL		AP-28-812RA
A	46	CABLE, LOG/DIR/ENABLE		AP-28-810UA
A	45	1/8" IN. PLASTIC CLAMPS		A4F7/B
A	44	LABEL, CONTROL BOX		T335MNF-LAB1
A	43	20W 1/2" X 1/2" THT		SSPS98024
A	42	WIRING DIAGRAM		T335MNF-WD
A	41	FUSE, 5A, SLOW		FF313005
A	40	CABLE, PROX SWITCH		D411-1906B
A	39	CABLE, REMOTE		D211-705D
A	38	CABLE, TREADLE		D211-703C
A	37	CABLE, PULLER SYNC		FFRK44T-4
A	36	CABLE, EYE, 12 FT.		FF264-347
A	35	WAGO, DUAL, GRN		FF264-341
A	34	WAGO, DUAL, GREY		FF264-341
A	33	SOLID STATE RELAY		FFD2425F
A	32	MOUNT, WAGO		FF264-3BK16
A	31	WASHER, FLAT, SAE		WMFS1/4
A	30	CEE POWER CORD		EE37F3312
A	29	WIRE, GROUND		1981A-511
A	28	COVER, CONTROL BOX		1335M-501
A	27	THUMB WHEEL SWITCHES		FFCS2LST1
A	26	CONTROL BOX WELDMENT		T335MNF-505
A	25	20W 1/2" X 1/2" THT		SSPP80096
A	24	PC BOARD, ISOLATION		FF1035-02
A	23	WAGO, END CAP		FF264-371
A	22	PC BOARD, THTL		1987-517
A	21	20W 1/2" X 1/2" THT		SSPS98024
A	20	SPACER		FFB9F2809
A	19	SPACER, THREADED		FF67F4078
A	18	WASHER, #10 SAE		WMFS10
A	17	CABLE, THTL		1987-513A
A	16	SOLENOID ASSY		AAE1335-5
A	15	20W 1/2" X 1/2" THT		SSPS98032
A	14	20W 1/2" X 1/2" THT		SSPP80016
A	13	20W 1/2" X 1/2" THT		SSH001032
A	12	LOCK WASHER, 1/4"		WML1/4
A	11	PC BOARD		1987-149JC
A	10	SWITCH, PUSH BUTTON		FF23F118
A	9	HEYCO BUSHING		EESB-375-3
A	8	CONN, POWER ENTRY		FF10ESB1C
A	7	FUSE HOLDER		FF342558A
A	6	20W 1/2" X 1/2" THT		SSPS98016
A	5	SWITCH, TOGGLE		FF23F385
A	4	CABLE, 26 COND X 3		1987149F3
A	3	END CAP, PAIR		FFCS1
A	2	BUMPER		MMSLD-ECH
A	1	SLIDE LOCK		MM40450010

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NO.	REVISION	DATE	DR.	CHK.	DEFAULTS
10	012-09	1-27	PBD/MDP		
9	007-09	1-13	PBD/MDP		
8	104-08	5-14	LP RA		
7	099-08	5-7	RA RA		

NAME	DIAGRAM	PNEUMATIC	1335MIF
24V DES.	11335MIF		
MATERIAL	11335MIF		
DES. BY	T.OLEVICZ		
CHK. BY	DONNA WILLIS		
DATE	9-19-03		
SCALE	2/1		

REV	DATE	BY	CHK.	DESCRIPTION
10	125860A	11		
REV	125860A	11		

ATLANTA ATTACHMENT COMPANY

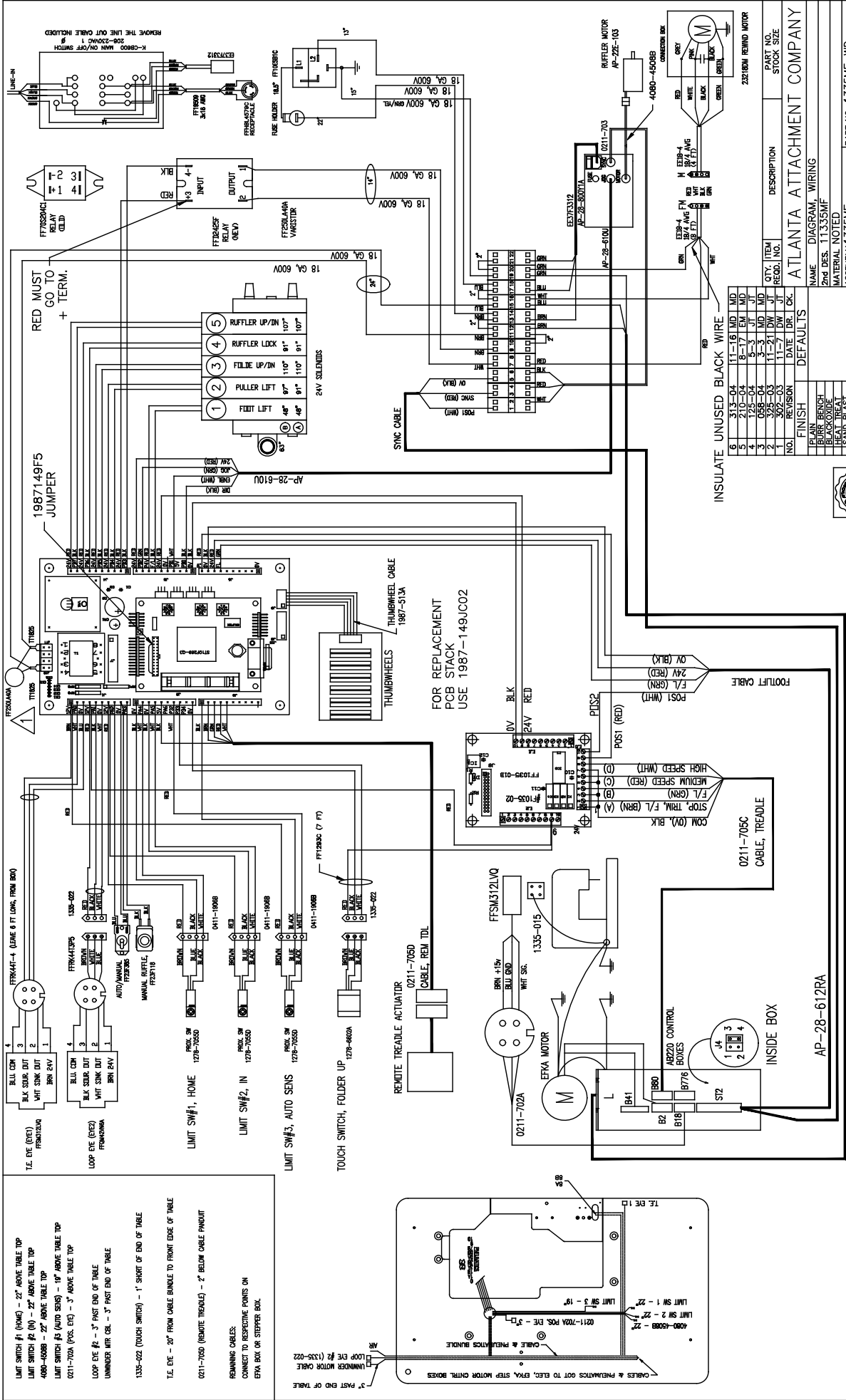
222-03

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METERED FLOW DIRECTION →

1/4" AIR LINE

5/32" AIR LINE



1987-149F5 JUMPER

1	110"	91"	110"	91"	107"
2	110"	91"	110"	91"	107"
3	110"	91"	110"	91"	107"
4	110"	91"	110"	91"	107"
5	110"	91"	110"	91"	107"

FOR REPLACEMENT PCB STACK USE 1987-149J002

1	110"	91"	110"	91"	107"
2	110"	91"	110"	91"	107"
3	110"	91"	110"	91"	107"
4	110"	91"	110"	91"	107"
5	110"	91"	110"	91"	107"

INSULATE UNUSED BLACK WIRE

6	11-16	MD	MD
7	11-16	MD	MD
8	11-16	MD	MD
9	11-16	MD	MD
10	11-16	MD	MD
11	11-16	MD	MD
12	11-16	MD	MD
13	11-16	MD	MD
14	11-16	MD	MD
15	11-16	MD	MD
16	11-16	MD	MD
17	11-16	MD	MD
18	11-16	MD	MD
19	11-16	MD	MD
20	11-16	MD	MD
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30	11-16	MD	MD
31	11-16	MD	MD
32	11-16	MD	MD
33	11-16	MD	MD
34	11-16	MD	MD
35	11-16	MD	MD
36	11-16	MD	MD
37	11-16	MD	MD
38	11-16	MD	MD
39	11-16	MD	MD
40	11-16	MD	MD
41	11-16	MD	MD
42	11-16	MD	MD
43	11-16	MD	MD
44	11-16	MD	MD
45	11-16	MD	MD
46	11-16	MD	MD
47	11-16	MD	MD
48	11-16	MD	MD
49	11-16	MD	MD
50	11-16	MD	MD

ATLANTA ATTACHMENT COMPANY

NAME	DIAGRAM, WIRING
2ND DES.	T1335SMF
MATERIAL NOTED	
ASSEMBLY	T1335SMF
DES. BY	PDASHER
DR. BY	PDASHER
CK. BY	JEFF THOMAS
SCALE	7/5
DATE	9-2-03
DWG SIZE	C

253-03

1987-149F5 JUMPER

1	110"	91"	110"	91"	107"
2	110"	91"	110"	91"	107"
3	110"	91"	110"	91"	107"
4	110"	91"	110"	91"	107"
5	110"	91"	110"	91"	107"

FOR REPLACEMENT PCB STACK USE 1987-149J002

1	110"	91"	110"	91"	107"
2	110"	91"	110"	91"	107"
3	110"	91"	110"	91"	107"
4	110"	91"	110"	91"	107"
5	110"	91"	110"	91"	107"

INSULATE UNUSED BLACK WIRE

6	11-16	MD	MD
7	11-16	MD	MD
8	11-16	MD	MD
9	11-16	MD	MD
10	11-16	MD	MD
11	11-16	MD	MD
12	11-16	MD	MD
13	11-16	MD	MD
14	11-16	MD	MD
15	11-16	MD	MD
16	11-16	MD	MD
17	11-16	MD	MD
18	11-16	MD	MD
19	11-16	MD	MD
20	11-16	MD	MD
21	11-16	MD	MD
22	11-16	MD	MD
23	11-16	MD	MD
24	11-16	MD	MD
25	11-16	MD	MD
26	11-16	MD	MD
27	11-16	MD	MD
28	11-16	MD	MD
29	11-16	MD	MD
30	11-16	MD	MD
31	11-16	MD	MD
32	11-16	MD	MD
33	11-16	MD	MD
34	11-16	MD	MD
35	11-16	MD	MD
36	11-16	MD	MD
37	11-16	MD	MD
38	11-16	MD	MD
39	11-16	MD	MD
40	11-16	MD	MD
41	11-16	MD	MD
42	11-16	MD	MD
43	11-16	MD	MD
44	11-16	MD	MD
45	11-16	MD	MD
46	11-16	MD	MD
47	11-16	MD	MD
48	11-16	MD	MD
49	11-16	MD	MD
50	11-16	MD	MD

ATLANTA ATTACHMENT COMPANY

NAME	DIAGRAM, WIRING
2ND DES.	T1335SMF
MATERIAL NOTED	
ASSEMBLY	T1335SMF
DES. BY	PDASHER
DR. BY	PDASHER
CK. BY	JEFF THOMAS
SCALE	7/5
DATE	9-2-03
DWG SIZE	C

253-03

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