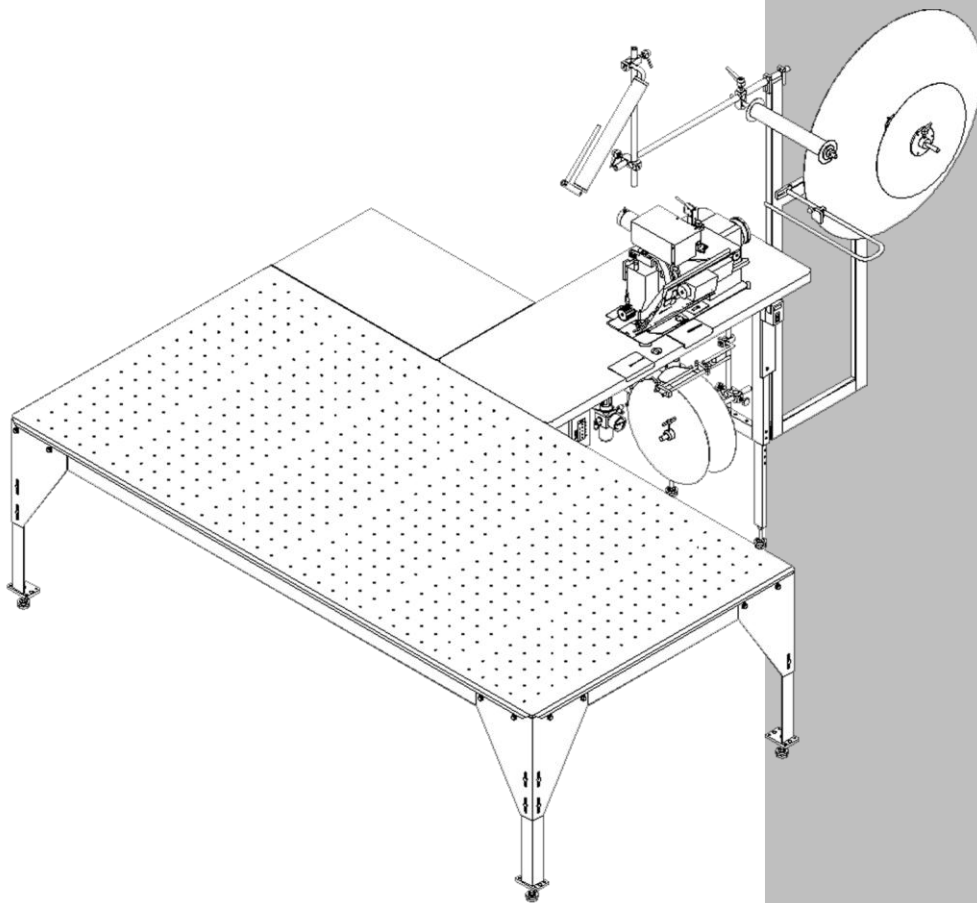




Model **1335MDS**

Revision 16 Updated Mar 7, 2012

Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

Atlanta Attachment Company

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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 1335MDS Continental Foundation Ruffler 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.

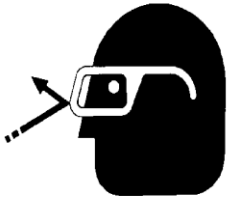
Signs on the Machine

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

Specifications

Electrical: 220 VAC, 5amp, 50/60 Hz Single Phase

Pneumatic: 70-80 PSI, 2 SCFM avg.

Sewing Head: Mitsubishi LS2-2210 Lockstitch

Sewing Speed: 3500 RPM

Needle (Standard): Schmetz DBX1 Size 140

Stitch Density: 6 SPI

Sewing Head: Juki MH481U Chainstitch

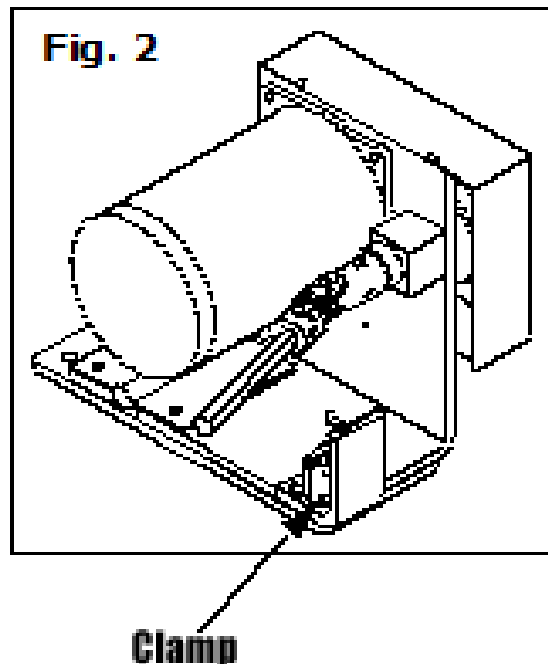
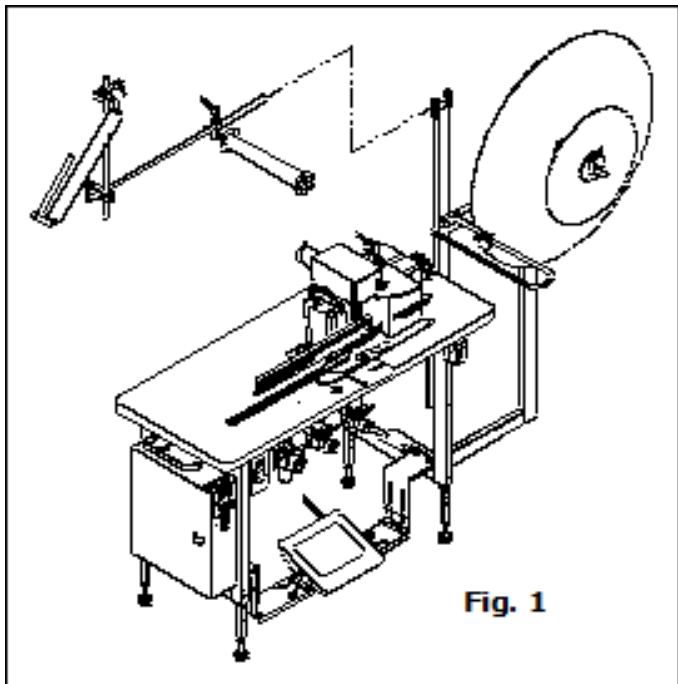
Sewing Speed: 3500 RPM

Needle (Standard): Schmetz TVx7 Size 16

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. (See Fig. 1)
- Check the oil level in the oil pan. To check oil, unclamp the puller motor bracket and lean the puller motor back. (See Fig. 2) Then lean the head back to access the oil pan. Be sure to re-clamp the puller motor bracket and insert the puller drive shaft into the u-joint.



Control Box Operation

Main Control Box:

The front of the main control box has an Auto/Manual Switch, a Manual Ruffle Pushbutton, a Panel/Frame switch, an Unwinder Reverse Switch, a Fuse Holder, and 2 banks of 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.

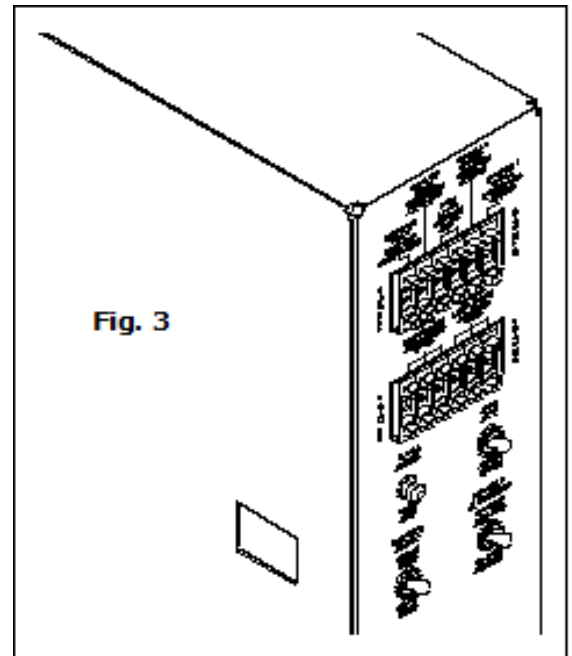
In Panel mode the Auto/Manual Switch turns on the automatic ruffling cycles for the corners. When this switch is in Manual the ruffling is disabled and the machine will only sew, trim, and foot lift. In Frames mode the Auto position allows the frame to be sewn without stopping by holding down the sew foot switch until the cycle is complete. When the switch is in the Manual position the machine will stop at the beginning and end of each ruffle cycle and the foot switch must be released and pressed again to continue the cycle.

The Manual Ruffle pushbutton turns on one ruffle cycle and is also the Reset button for the automatic cycle. Pushing this button once will turn on the ruffle cycle for one ruffle. 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 Panels / Frames switch selects the operation mode. In the Panels mode the machine will detect the edges of a panel being sewn to the gusset and stop at each corner. In Frames mode no panel is used. The machine will sew for a specified preset distance, stop and make ruffles, and sew again until a four sided "frame" has been created.

The Unwinder Reverse switch controls the direction of the Unwinder reel. Use to set the proper direction depending on how the gusset material is wound. The Unwinder will run whenever the Treadle is not in the neutral position (either sewing or healed back) and the Loop Eye is seeing the gusset material.

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



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Top Six Thumbwheels:

The top six thumbwheels control the sewing of the panel when in Panels mode and also control the ruffling in both Panels and Frames modes.

The first Thumbwheel on the left controls the on time of the Unwinder motor. It controls how long the motor runs after the Loop Eye has seen the gusset material. It is usually set to 9. The lower the number the less time the motor will run.

The second Thumbwheel controls the sewing speed of the sewing head during ruffling. Each increment is approximately 100 rpm. The normal setting is "6".

The third and fourth Thumbwheels together make up the Stop count for the corners when sewing in Panel mode. 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. If, after turning the corner, the right edge of the panel is to the left of 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.

The fifth Thumbwheel sets the number of ruffles to be sewn in each corner for both modes. Adjust this setting along with the ruffle size to achieve desired corner finish.

The sixth Thumbwheel sets the number of stitches sewn in each ruffle for both modes and is adjusted according to the ruffle size. There should be enough stitches to sew to the folded edge of each ruffle.

Lower Six Thumbwheels:

The lower six thumbwheels control the sewing in Frames mode. The first three thumbwheels on the left side set the length of the Short side of the Frame. The right three thumbwheels set the length of the Long side. The resolution is in centimeters.

Stepper Control Boxes

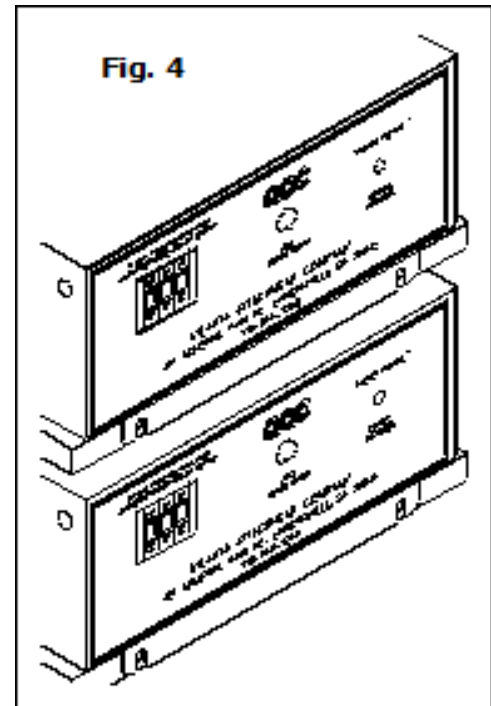
There are two stepping motor boxes located under the table. (Fig. 4) The box with the 10-turn adjustable potentiometer on the front controls the Ruffler and the box without controls the Puller.

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 to maximum and is locked in place by a small locking lever. Unlock to adjust.

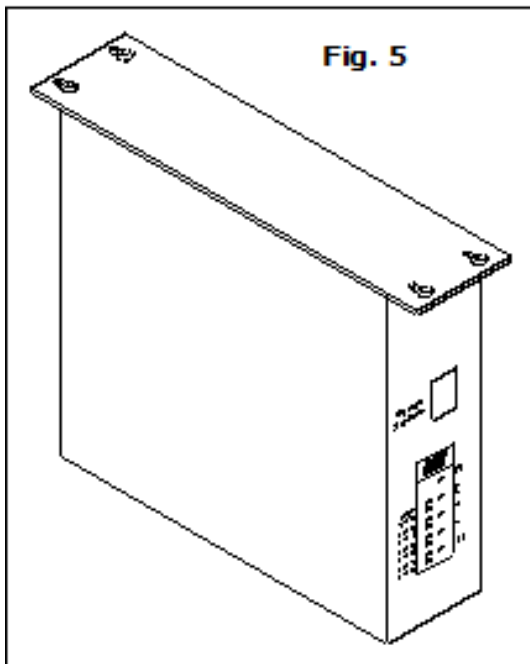
The Puller box has three Thumbwheels on the front which are set to synchronize the puller to the sewing head. The number is proportional to the stitch LENGTH and is not affected by sewing speed.

Each box has its own on/off switch on the back where the power cord plugs in. Leave this switch on all the time.

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.



Efka Control Boxes



The sewing machine is powered by the Efka motor controller located under the table. It has its own on/off switch which should be left on all the time. It also has some small buttons and LED's on the front to indicate the enabled functions. The only LED that should be on is the second to last from the bottom which sets the control to stop the machine needle down at neutral treadle and needle up after full heal back. The functions can be changed upon power up or after a full heal back. The control box has been preprogrammed to operate with the Ruffler. If the box were replaced, the new box would need to be programmed according to the included parameter list in order to function properly. Notice that the sewing head does not stop at normal needle up (lockstitch heads) position after full heal back, but stops at needle top dead center to allow more room for loading thicker material (the head actually turns in reverse for a moment).

Basic Machine Operation (Panel Mode)

Note: The puller roller has sharp edges. Keep hands and fingers away from the puller roller while loading the material under the presser foot.

Switch the Panels / Frames switch to Panels mode (up).

Loading the Gusset Roll and Unwinder

Remove the small disc from the Unwinder spindle. Load the gusset (or border) roll onto the Unwinder spindle so the good side is up and the flange is toward the large disc as the material comes off the roll to the left. The gusset must pass through the guide rod with the Loop Eye so that the Loop Eye will see the material when the loop gets too high. Replace the small disc onto the spindle with just enough pressure on the roll to cause it to turn with the spindle. Heal back on the treadle to activate the Unwinder and create a loop of gusset as you continue to load the machine. If the Unwinder runs in the wrong direction, flip the direction switch located on the main control box. Feed the gusset over the top rollers and down to the folder with the good side toward the sewing head. (When making continental foundations the good side will face the operator.)

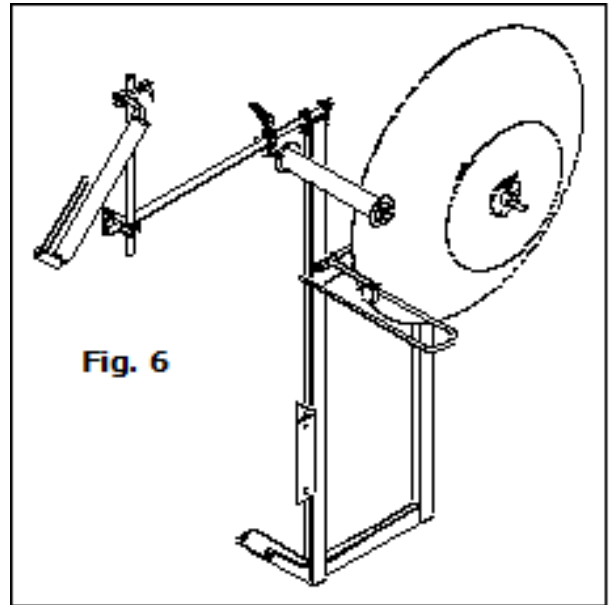


Fig. 6

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. Adjust the position of the overhead rollers to keep the gusset aligned with the folder.

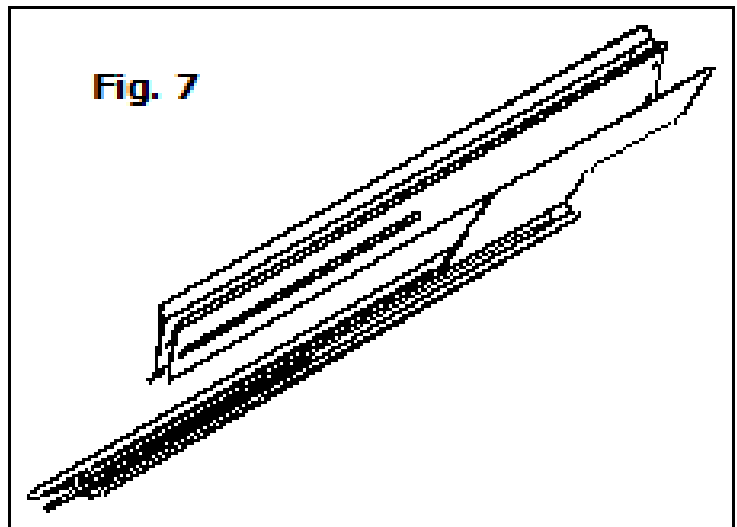


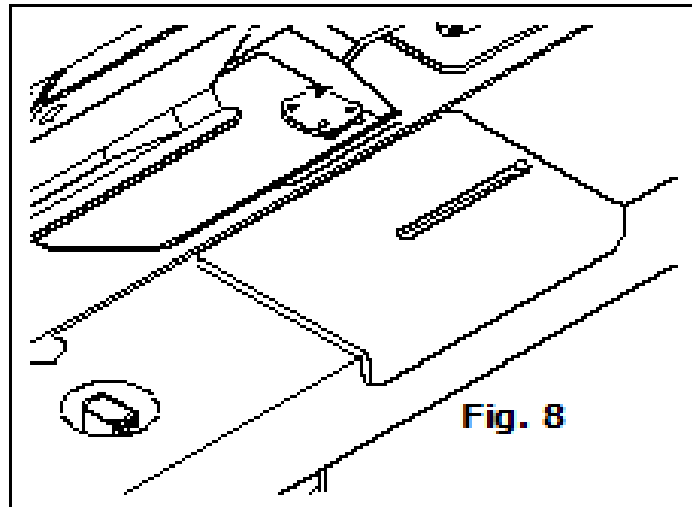
Fig. 7

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.

Sewing 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. Pull the gusset through the folder, under the presser foot and under the puller. 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).



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.

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 3 or 4 large 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 swing out 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.

Basic Machine Operation (Frames Mode)

Setting the Switches

Switch the Panels / Frames switch to the Frames mode (down).

Note: The front photocell and the "stop count" thumbwheels have no function in Frames mode.

Switch the Auto / Manual switch as desired. In Auto mode the machine will sew the frame completely as long as you keep the sew pedal pressed. In Manual mode the machine will stop at the start and end of each ruffle cycle and the sew pedal must be released and pressed again.

Setting the Thumbwheels

Adjust the lower six thumbwheels to the Frame size desired. The size displayed on the thumbwheels is in centimeters. Do to the corners and variations in material and other factors it may be necessary to adjust the numbers to get the exact size frame desired. For example: a test frame with an outside measurement of 150 x 203 was created with a thumbwheel setting of 130 187. Create a chart to cross reference between the different frame sizes and the actual numbers set in the thumbwheels.

Loading the Flange Roll and Folder

Load the front roll holder with the flanging required and adjust the edge guides and tension rods as necessary. Load the gusset through the folder, under the encoder roller, and under the presser foot with at least 1" of material past the needle. 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. If the detent sensor is not lit, the machine will keep running without making ruffles or measuring lengths.

Sewing the Frame

Press the Ruffle / Reset button twice to reset the program and prepare to start the cycle.

Step on the sew pedal and the machine will sew the first half of a short side, make a corner ruffle cycle, sew the first long side, make the second ruffled corner, sew the opposite short side, make the third corner ruffle, make the opposite long side, ruffle the last corner, and make the ending half short side. The machine will stop needle down and will not sew any more until the presser foot is raised.

Finishing the Frame

Swing out the folder and cut the gusset and flange. Raise the presser foot and remove the frame. Be sure the stitches do not pull out as you remove the frame as the starting and stopping stitch positions mark the seam location for finishing the frame.

Place the two ends of the frame together front to front with the starting and stopping stitches on top of each other. Sew the ends together right across the stitch position to complete the frame. Test fit the frame to a bed and adjust the thumbwheels as necessary to achieve the best fit.

Adjust the ruffle size and stitches the same as in Panels mode.

Continental Foundations

Continental foundations are made in the same way as the panels in Panels mode except it requires the Large "M" style folder. Turn off the power and remove the regular folder with the encoder on it by unplugging the encoder at the large 4 pin plug and removing the two wing screws which hold the folder to the bracket. Protect the exposed end of the plug with electrical tape to prevent accidental short circuit and damage to the control box (The voltage at the plug is only 5 volts). Install the large folder with the slots all the way to the left. Load the gusset material with the good side down at the presser foot. Adjust the folder and edge guides for the stitch margin desired. Adjust the overhead roller to keep the gusset aligned with the folder.

Continental foundations require smaller ruffles in the corners with more stitches per ruffle. Adjust as necessary to achieve a desirable corner finish. Also, the stop count will be a higher number due to the smaller stitch margin and will need to be adjusted for correct stopping position.

Efka 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 3500 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 (The second one from the bottom) 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

This is the main regulator which limits maximum pressure to the solenoid valves and cylinders.

Puller Pressure: 30 PSI

This is the Down pressure for the puller roller. Too much pressure may cause the puller roller to stall. Too little pressure may cause the roller to not feed properly.

Ruffle Blade Pressure 10 PSI

This is the Down pressure for the ruffling blade. If it is set too low the ruffles will not form properly due to slippage of the blade against the material. If it is set too high it will press the stripper blade down to touch the bed plate of the machine and pinch the panel causing difficulty in turning the corners.

Foot Sew Pressure: 15 PSI

This is the Down pressure on the presser foot while sewing straight (Not ruffling). It is set for best feeding of the feed dog. The pressure while ruffling is set by the knob on top of the sewing head. It is set to be very light so the ruffling blade can feed under the foot and form the ruffles properly.

Sewing Head

See Manufactures 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.

Unwinder Assembly

The Unwinder is belt driven from a right angle gear motor. The motor and bearings are permanently lubricated and require no regular maintenance. Check the belt tension periodically and adjust if necessary. Check the timing belt pulley and bearing set screws for tightness. The electric eye mounted on the guide rod should be set to "see" the gusset material before the loop is entirely used up.

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.

11335MD Recommended Spare Parts List

Contact AAC's sales department to order replacement parts.

- Phone: 770-963-7369
- Fax: 770-963-7641
- Email: sales@atlatt.com
- Website: www.atlatt.com

AAC Part # SP1335MD Spare Parts Kit

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1278-7055B	Prox Switch	6	1	GG100XL037	Gear Belt
2	2	1335M-2002C	Ruffler Blade	7	1	GG110XL75U	Gear Belt
3	1	B2030481000	Looper	8	1	GG187L050	Gear Belt
4	2'	EEFE-RR2	Reflective Tape	9	100	SNTVX7X110	Needle
5	1	FFSM312LVQ	Electric Eye				

Parameter Settings for Efka Controller

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

PARAMETER	RANGE	Lockstitch	Chainstitch	DESCRIPTION
290		0	0	Mode (Lockstitch) of operation. MUST SET THIS PARAMETER FIRST!
111	200-9900	400	400	Maximum speed when "129" is 0, 1, or 2.
161	0-1	1	1	Motor rotation
180	0-360	60	--	Degrees reverse run goes to get to needle up
181	0-999	1	--	Delay till reverse run starts after trim
182	0-1	1	0	Enable reverse run after trim to get to "true" needle up
219	20363	35	35	Braking power at stop
250	0-359	150	--	Thread trimmer activation andle
270	0-5	1	1	External handwheel sensor configuration
271	0-255	180	180	Ref angle for Position 1 from Position 2
272	020-255	100	100	Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111. (For Yamato and Pegasus, setting should be 100; for Rimoldi, setting should be 124)

Front panel LED's:

- LED 1: Off
- LED 2: Off
- LED 3: Off
- LED 4: Off
- LED 5: Off
- LED 6: Off
- LED 7: On, Stop at needle down.
- LED 8: Off, Stop at needle up.

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "311"
3. Press "E" once and "2.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E"
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
8. Run sewing head to save parameters before powering down

To Perform Master Reset of Parameters:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "591"
3. Press "E" twice and "093" is displayed.
4. Press "+" once, "094" is displayed.
5. Press "P" to exit programming mode with all default values.

1335M Folder Spacer Reference Chart

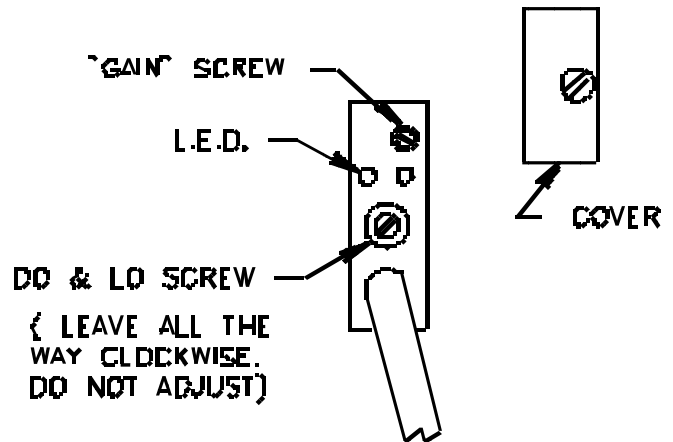
QUANTITY	ASBLY#	DESC.	PREFLANGED, OFFSETABLE, 6" CAPACITY								PREFLANGED, OFFSETABLE, 9" CAPACITY								CONTINENTAL BORDER, 18" CAPACITY							
			1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16
			A-2216K								A-2216L								A-2216M							
1	A-2216D40	L. GUIDE, 1/8, KEYED, ALU	2																							
2	A-2216D32	L. GUIDE, 3/16, KEYED, ALU		2																						
3	A-2216D33	L. GUIDE, 1/4, KEYED, ALU			2																					
4	A-2216D34	L. GUIDE, 5/16, KEYED, ALU				2																				
5	A-2216D35	L. GUIDE, 3/8, KEYED, ALU					2																			
6	A-2216D37	L. GUIDE, 7/16, KEYED, ALU						2																		
7	A-2216D38	L. GUIDE, 1/2, KEYED, ALU							2																	
8	A-2216D39	L. GUIDE, 9/16, KEYED, ALU								2																
1	A-2216D58	R. GUIDE, 1/16, KEYED, THDED	2																							
2	A-2216D51	R. GUIDE, 1/8, KEYED, THDED		2																						
3	A-2216D52	R. GUIDE, 3/16, KEYED, THDED			2																					
4	A-2216D53	R. GUIDE, 1/4, KEYED, THDED				2																				
5	A-2216D54	R. GUIDE, 5/16, KEYED, ALU					2																			
6	A-2216D55	R. GUIDE, 3/8, KEYED, ALU						2																		
7	A-2216D56	R. GUIDE, 7/16, KEYED, ALU							2																	
8	A-2216D57	R. GUIDE, 1/2, KEYED, ALU								2																
1	A-2216G14	SPACER, 1/16(2 HOLE)																								
2	A-2216G24	SPACER, 1/8(2 HOLE)	2																							
3	A-2216G32	SPACER, 3/16(2 HOLE)		2																						
4	A-2216G33	SPACER, 1/4(2 HOLE)			2																					
5	A-2216G29	SPACER, 5/16(2 HOLE)				2																				
6	A-2216G21	SPACER, 3/8(2 HOLE)					2																			
7	A-2216G30	SPACER, 7/16(2 HOLE)						2																		
8	A-2216G31	SPACER, 1/2(2 HOLE)							2																	
9	A-2216G34	SPACER, 9/16(2 HOLE)								2																
	SSBC98024	SCREW, 10-32 X 3/8																								
	SSBC98032	SCREW, 10-32 X 1/2																								
	SSBC98040	SCREW, 10-32 X 5/8	4	4																						
	SSBC98048	SCREW, 10-32 X 3/4			4	4																				
	SSBC98056	SCREW, 10-32 X 7/8					4	4																		
	SSBC98064	SCREW, 10-32 X 1							4	4																
	SSBC98072	SCREW, 10-32 X 1-1/8									4	4														

From the library of: Diamond Needle Corp

Electric Eye Sensor Adjustment

To adjust the sensor, first remove the clear plastic cover from the end of the sensor. There are two adjusting screws under the cover. One is labeled "GAIN" and is used to set the sensitivity of the sensor. The other screw is labeled "DO & LO" and should always be fully clockwise.

With the end of the sensor pointing at the center of the reflective tape, turn the "GAIN" screw counter-clockwise until the red LED indicator is off. Then turn the "GAIN" screw clockwise until the LED indicator comes on. Then turn the "GAIN" screw one full turn clockwise. The LED indicator should be blinking slowly. Cover the eye so that the sensor cannot see the reflective tape and the LED should go off.



Reflective Tape Maintenance

Use a soft cloth for cleaning.

Do not use chemicals or abrasives to clean it.

Avoid any contact with oils and liquids.

Do not touch the tape with bare fingers.

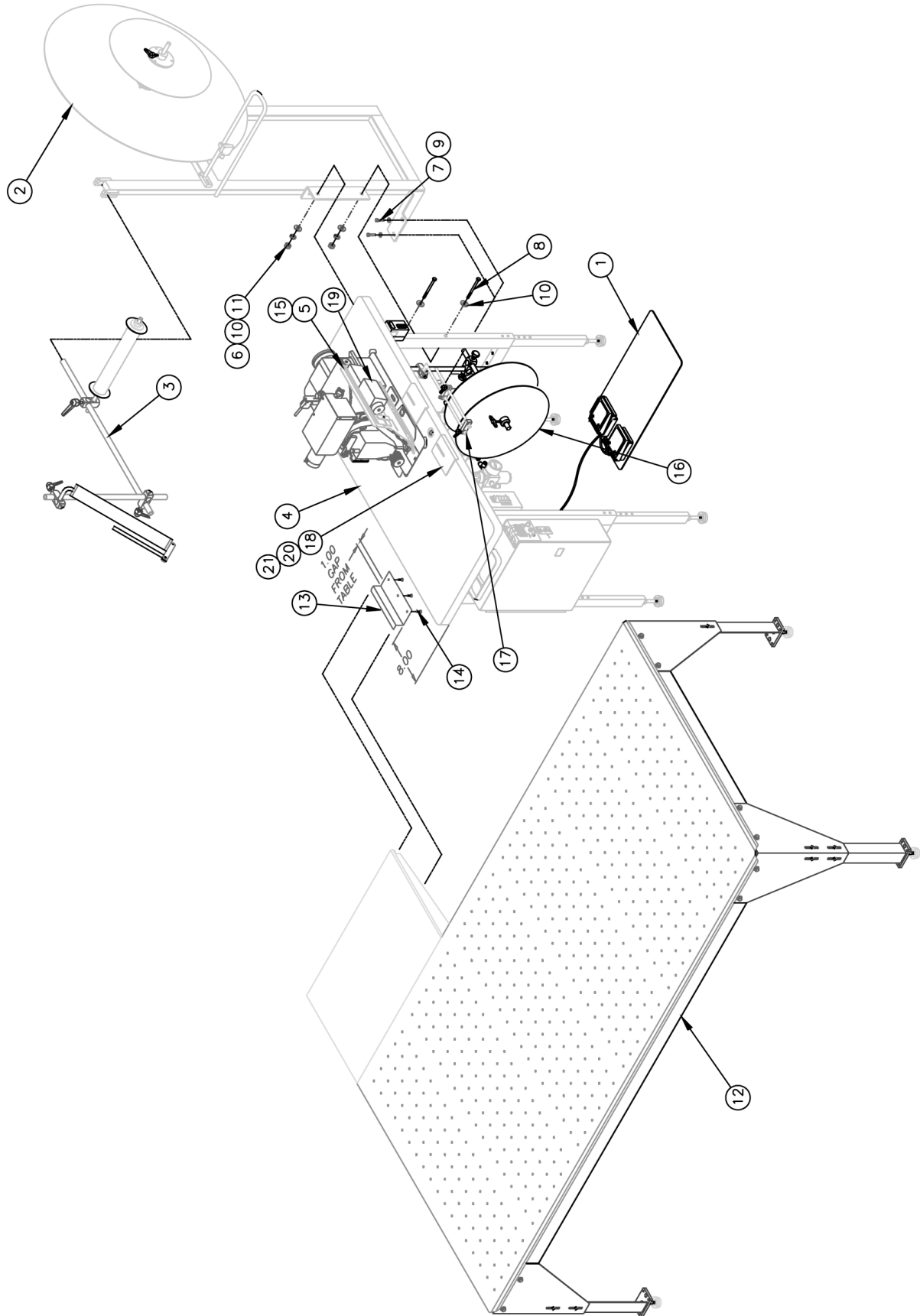
If tape is dirty or opaque, the eye may not function correctly.

Assembly Drawings & Parts Lists

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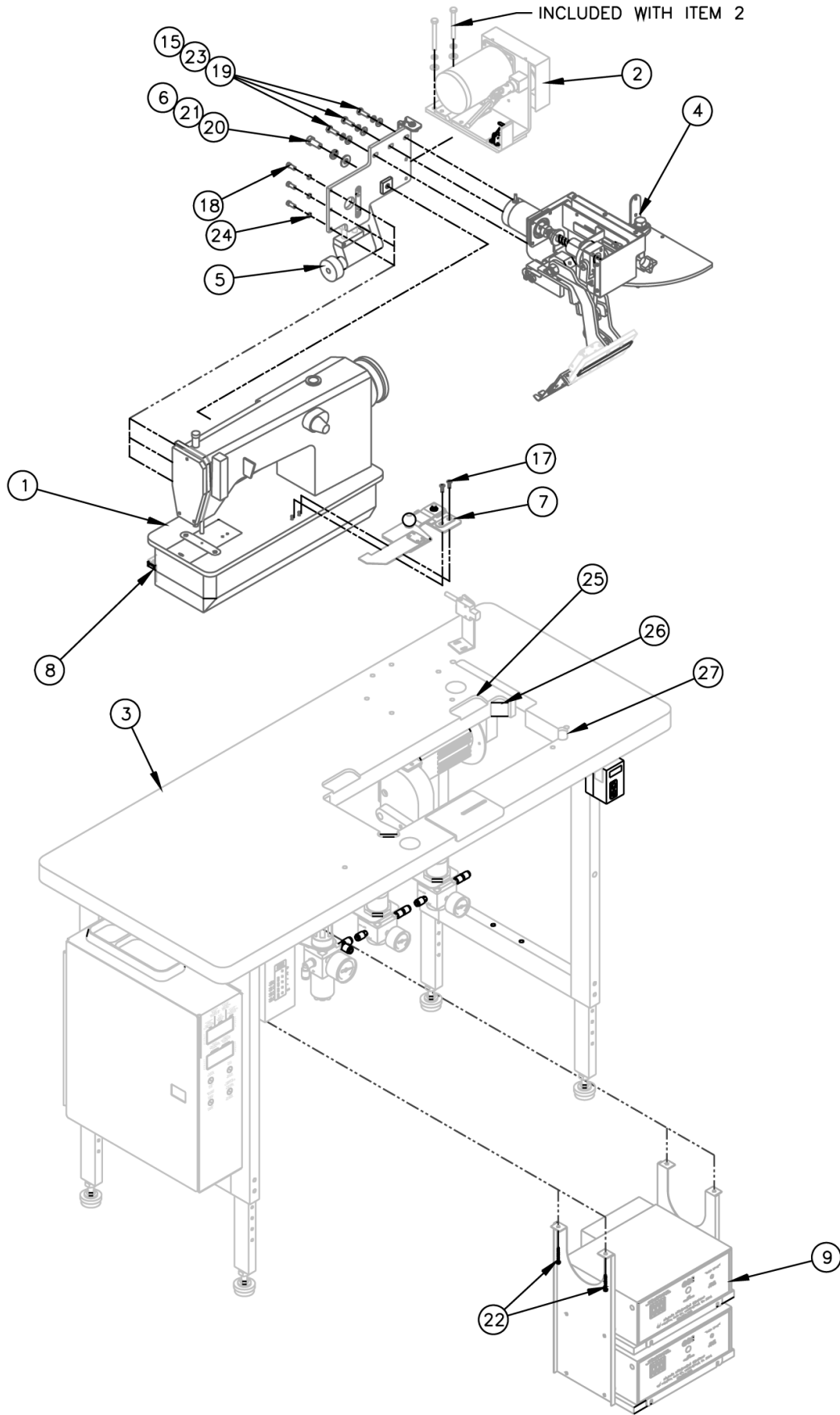
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11335MDS-SUAT Continental Foundation Ruffler

AAC Drawing Number 192904C Rev0

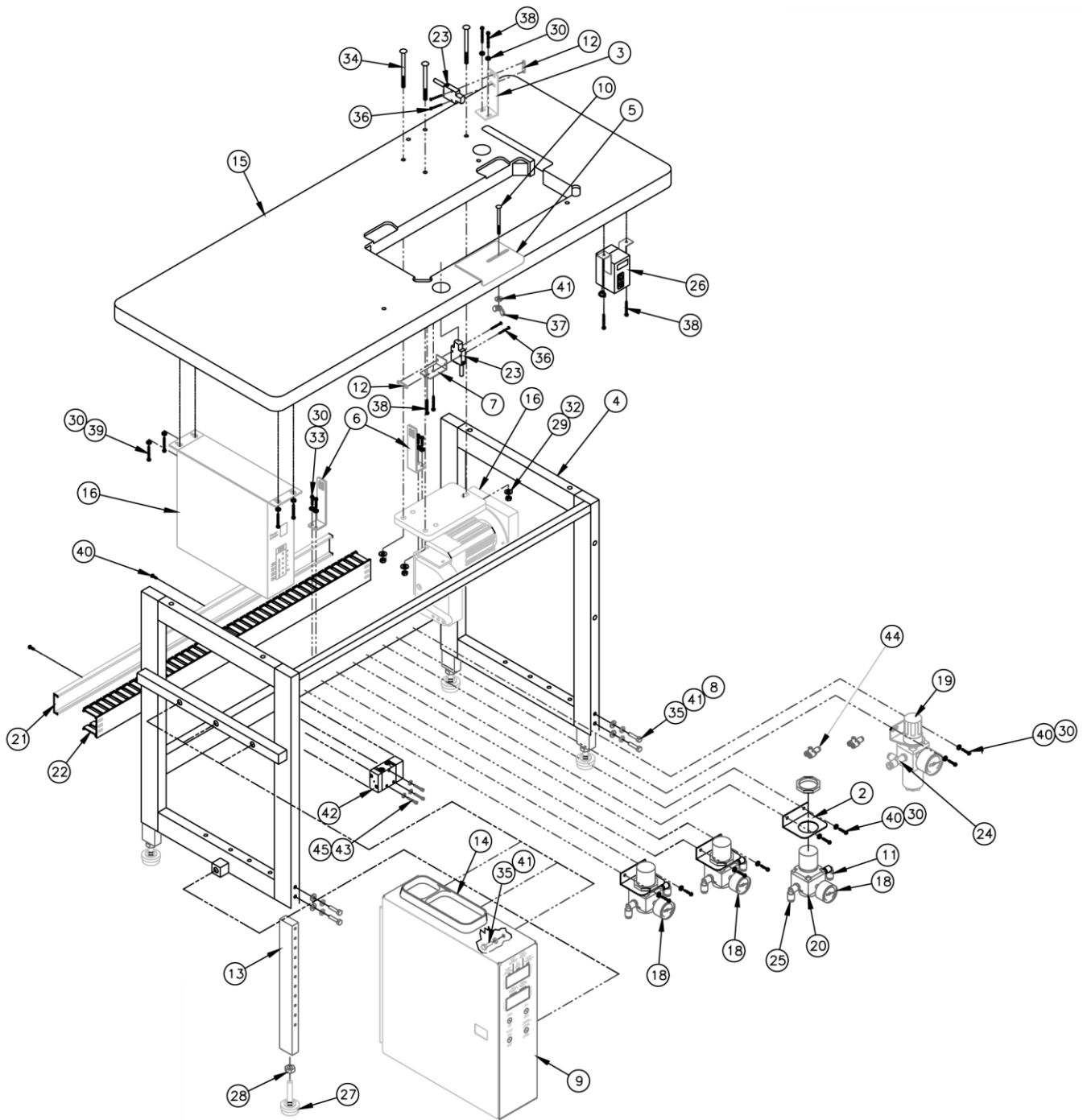
NO.	QTY	PART #	DESCRIPTION	
1	1	1278-6160E	Foot Switch Assy	Page 67
2	1	1335M-4000A	Unwinder Assy	Page 31
3	1	1335M-430	Guide Roller Assy	Page 33
4	1	1335MDS-G	Generic Console	Page 27
5	1	A-2216K5/16	Flat Folder	Page 37
6	2	NNH3/8-16	Hex Nut	
7	2	SSHC01048	Screw, Hex Cap	
8	2	SSHC25192	Screw, Hex Cap	
9	2	WWFS1/4	Flat Washer	
10	4	WWFS3/8	Flat Washer	
11	2	WWL3/8	Lock Washer	
12	1	11337AT	Air Table Assy	Page 35
13	1	1335081	Shelf Support	
14	3	SSZH#10064	Screw, Sheet Metal	
15	1	A-2216M5/16	Flat Folder	
16	1	778A-12	Roll Holder	
17	1	1334-2600	Tension Assy	Page 41
18	1	1335M-1002	Edge Guide	
19	1	1335M-2500	Encoder Assy	Page 65
20	1	SSBK01160	Carriage Bolt	
21	1	NNW1/4-20	Wing Nut	



1335MDS-G Generic Console

AAC Drawing Number 192875C Rev3

NO.	QTY	PART #	DESCRIPTION	
1	1	1335MD-10	Sewing Head Assy	Page 43
2	1	1335M-120	Puller Drive Assy	Page 45
3	1	1335MDS-1000	Stand & Motor	Page 29
4	1	1335M-2000	Ruffler Assy	Page 47
5	1	1335MDS-3000	Puller Assy	Page 49
6	1	WWFS5/16	Flat Washer	
7	1	1335M-5000A	Strip Blade Assy	Page 51
8	1	1335MD-6000	Footlift Assy	Page 53
9	1	1335M-9500	Step Box Assy	Page 55
10	1	1335M-LAB	Labels	
11	1	1335M-PAR	Parameter List	
12	1	1335M-PD	Pneumatic Diagram	Page 70
13	1	1335MDS-WD	Wiring Diagram	Page 72
14	1	1335MDS-WD1	Wiring Diagram	Page 73
15	3	WWFS1/4	Flat Washer	
16	10	SNTVX7X110	Needle, Size 110	
17	2	SSBC98032	Screw, Button Cap	
18	3	SSSC98040	Screw, Socket Cap	
19	3	SSHC01048	Screw, Hex Cap	
20	1	SSHC20064	Screw, Hex Cap	
21	1	WWL5/16	Lock Washer	
22	4	SSZH#10048	Screw, Sheet Metal	
23	3	WWL1/4	Lock Washer	
24	3	WWL10	Lock Washer	
25	2	MMF01E0418	Cushion Hinge	
26	2	MMF01A0419	Vibration Pad, Large	
27	2	MMF01A1419	Vibration Pad, Small	
28	1	1959-112	Thread Plate	

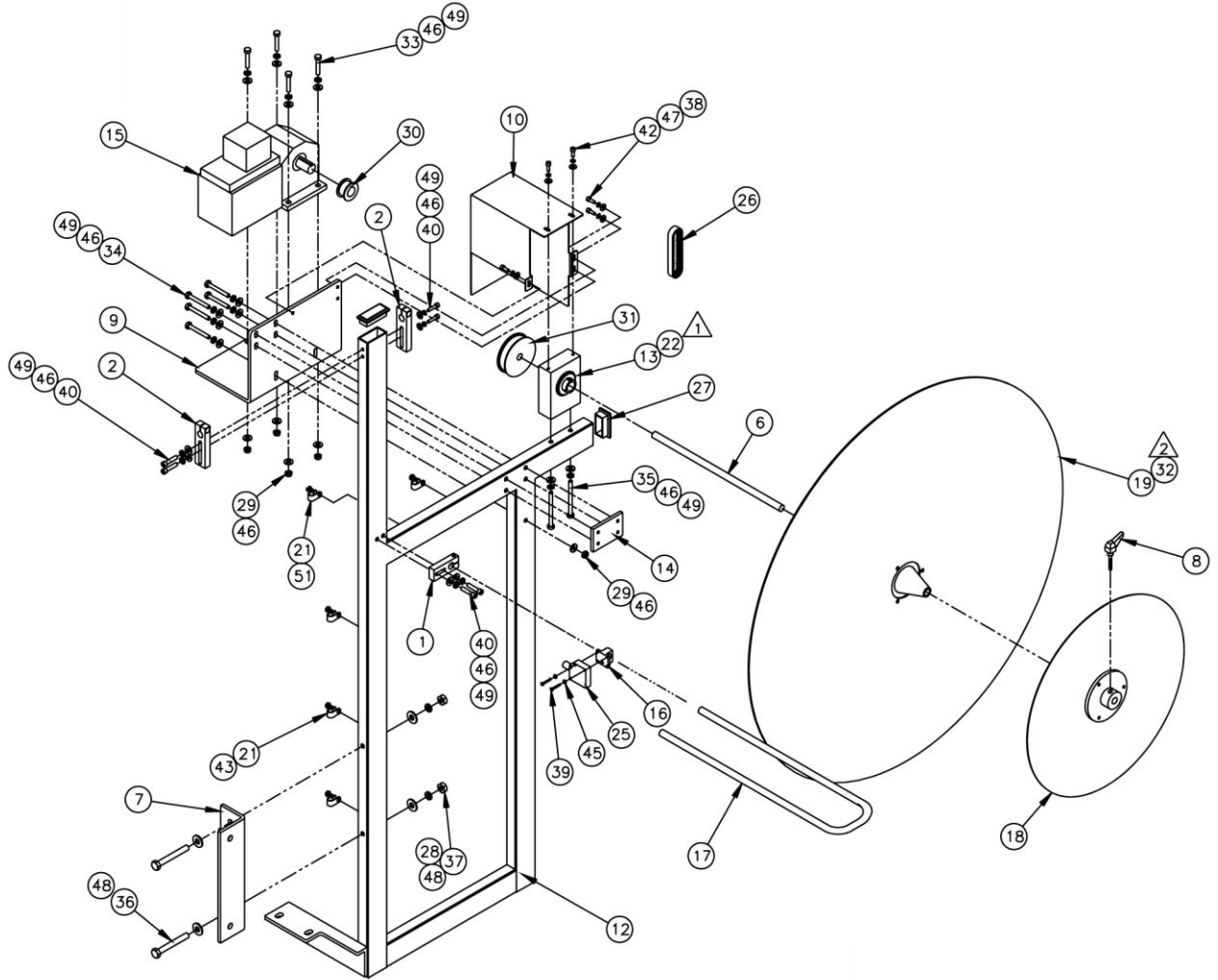


1335MDS-1000 Stand & Motor Assembly

AAC Drawing Number 192874C Rev2

NO.	QTY	PART #	DESCRIPTION
1	1	0211-702A	Sensor Cable
2	3	0411-071	Regulator Brkt
3	1	1278-6689B	Eye Mount
4	1	1335M-100	Frame
5	1	1335M-1002	Edge Guide
6	2	1335M-1003	Motor Control Brkt
7	1	1335M-1004	Eye Brkt
8	8	WWL1/4	Lock Washer
9	1	1335MDS-500	Control Box Assy
10	1	SSBK01160	Carriage Bolt
11	3	AAQPR-5-4	Reducer
12	2	1975-412A	Nut Plate
13	4	132556-273	Leg
14	1	26151	Tool Tray
15	1	4048-481	Table Top
16	1	4059-DC1500	DC Motor
17	2	4080-4508B	Cable
18	3	AA198-503	Air Gauge
19	1	AA198-5102	Regulator
20	3	AA198-RP3	Regulator
21	3'	EEDC2X2	Duct Cover
22	3'	EEDF2X2	Wire Duct
23	2	FFSM312LVQ	Electric Eye
24	1	AAQMT-4-8	Quick T
25	3	AAQMC-5-4	Quick Connect
26	1	K-CB600	Motor Starter
27	4	MMFB4444	Rubber Foot
28	4	NNH1/2-13	Hex Nut
29	3	NNH5/16-18	Hex Nut
30	18	WWFS10	Flat Washer
31	2	AAF3/16	Plastic Clamp
32	3	WWF5/16	Flat Washer
33	4	SSPS98032	Screw, Pan Head
34	3	SSBK10192	Carriage Bolt
35	12	SSHC01048	Screw, Hex Cap
36	4	SSPS70048	Screw, Pan Head
37	1	NNW1/4-20	Wing Nut
38	6	SSZH#10032	Screw, Sheet Metal
39	4	SSZH#10064	Screw, Sheet Metal
40	11	SSZS93032	Screw, Sheet Metal
41	13	WWFS1/4	Flat Washer
42	1	AAV125B	Pilot Valve
43	3	SSSC80064	Screw, Socket Cap
44	2	AAQMC-5-8	Quick Connect
45	3	WWFS6	Flat Washer

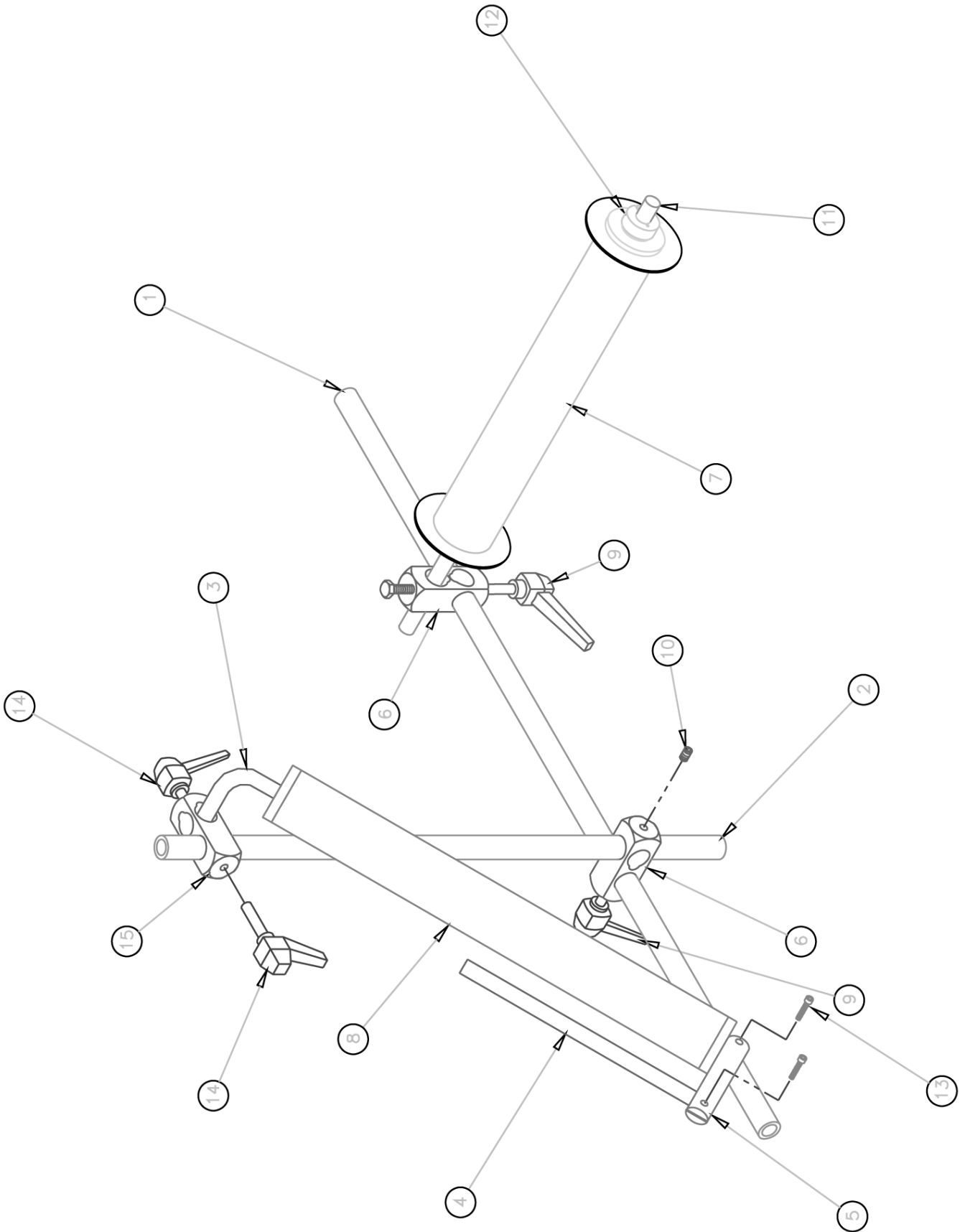
Page 69



1335M-4000A Unwinder Assembly

AAC Drawing Number 192821C Rev0

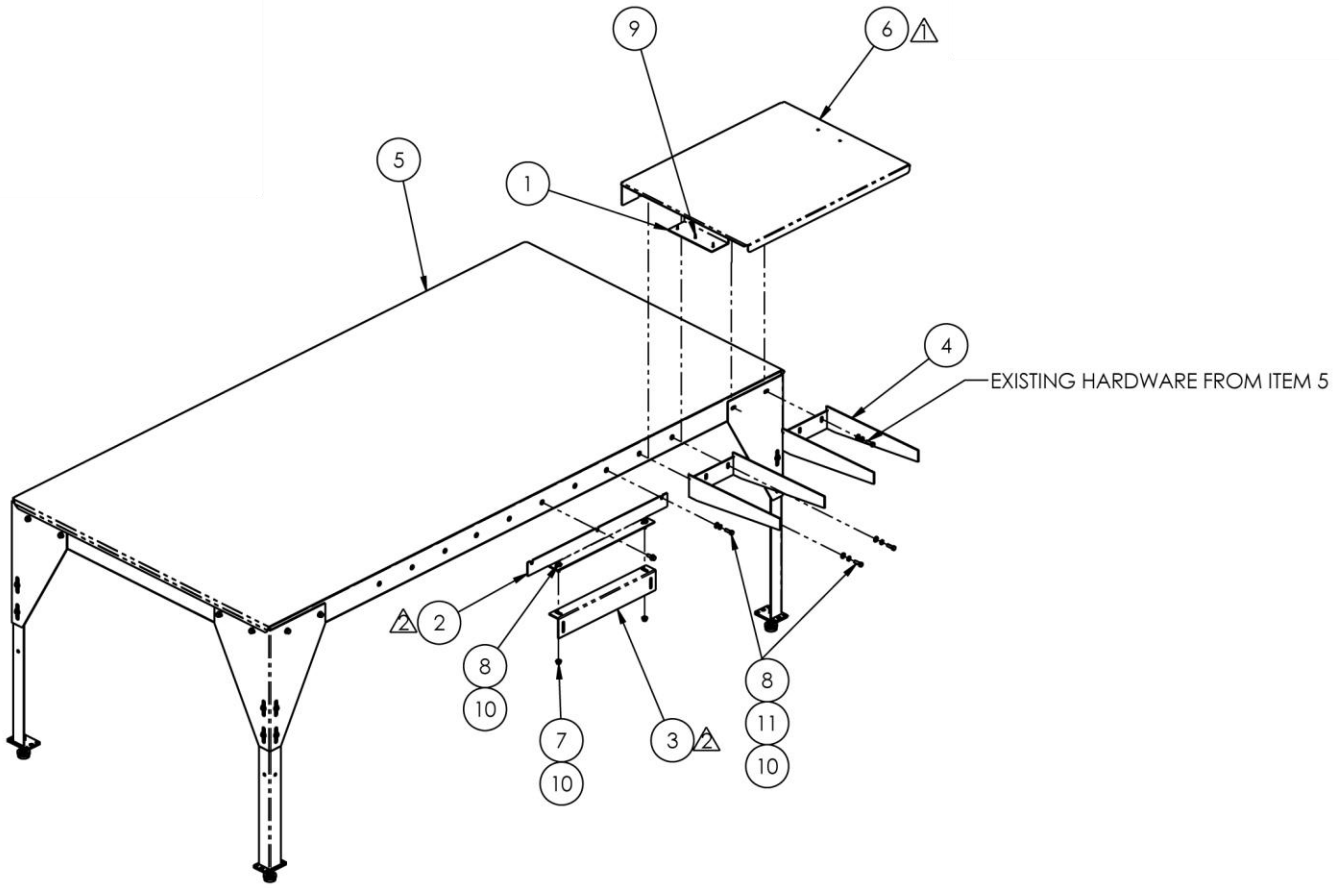
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1325-346	Rod Holder, 1/2	29	5	NNK1/4-20	Keq Nut
2	2	1325-346A	Rod Holder, 3/4	30	1	PP12LF050-3/4	Gear Pulley
6	1	1335M-4002A	Shaft, 3/4 x 22	31	1	PP24LB050M3	Gear Pulley
7	1	1335M-4003A	Support Brkt	32	1	SSHC01048	Screw, Hex Cap
8	1	TTH32415	Threaded Handle	33	4	SSHC01080	Screw, Hex Cap
9	1	1335M-4006	Motor Mount	34	5	SSHC01112	Screw, Hex Cap
10	1	1335M-4007	Belt Cover	35	2	SSHC01160	Screw, Hex Cap
12	1	1335M-4100A	Frame Weldment	36	2	SSHC25160	Screw, Hex Cap
13	1	1961-365	Bearing Block	37	2	WWL3/8	Lock Washer
14	1	1961-370	Nut Plate	38	5	WWL10	Lock Washer
15	1	23218DM	Motor Assy	39	2	SSPS70048	Screw, Pan Head
16	1	265155A	Eye Holder	40	6	SSSC01064	Screw, Socket Cap
17	1	1335-837	Rod, 1/2 U	42	5	SSSC98024	Screw, Socket Cap
18	1	A-202-1809	18" Disc	43	3	SSZS93032	Screw, Sheet Metal
19	1	A-202-3209	32" Disc	45	2	WWF4	Flat Washer
21	5	AAF1/8	Plastic Clamp	46	22	WWFS1/4	Flat Washer
22	2	BBS8703-88	Ball Bearing	47	5	WWFS10	Flat Washer
25	1	FFQM42VN6A	Electric Eye	48	4	WWFS3/8	Flat Washer
26	1	GG187L050	Gear Belt	49	17	WWL1/4	Lock Washer
27	2	MM132-1496	End Cap	51	2	SSPS90032	Screw, Pan Head
28	2	NNH3/8-16	Hex Nut				



1335M-430 Guide Roller Assembly

AAC Drawing Number 192822C Rev3

NO.	QTY	PART #	DESCRIPTION
1	1	97-1711	Tube, 3/4 x 30
2	1	97-1711C	Tube, 3/4 x 14
3	1	1335-835A	Bent Rod, 1/2 x 4 x 26
4	1	8732-0576	Rod, 1/2 x 9
5	1	1335-319B	Rod Clamp, 1/2
6	3	28201	Cross Block
7	1	1335-838	Roller, 2 x 18.5OL
8	1	1335-814D	Roller, 2 x 25.5OL
9	2	TTH32425	Threaded Handle
10	1	SSSS10048	Socket Cap Screw
11	1	8732-1536	Rod, 1/2 x 24
12	1	CCCL8F	Clamp Collar
13	2	SSSC95048	Screw, Socket Cap
14	2	TTH32426	Threaded Handle
15	1	28201A	Cross Block



NOTES

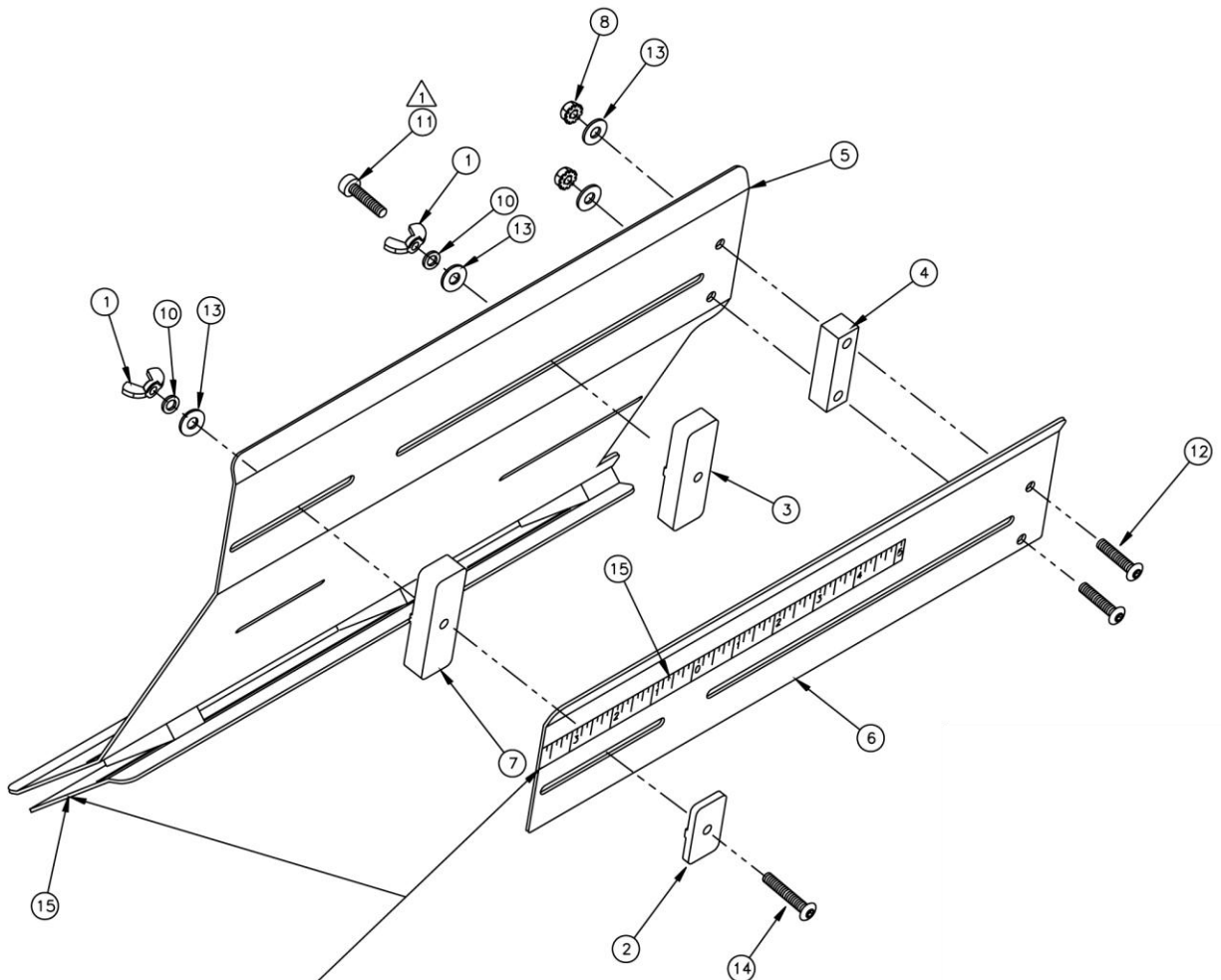
- ▲ MOUNTS BETWEEN FRAME AND TABLE LEG
- ▲ USED ONLY WHEN MACHINE CONSOLE IS ON CASTERS

11337AT Air Table Assembly


AAC Drawing Number 1337293 Rev5

NO.	QTY	PART #	DESCRIPTION
1	1	1335081	Support Shelf
2	AR	1337023	BRKT Table Ruffler
3	AR	1337024	Air Table Mount
4	2	1337A-0168B	Retainer BRKT
5	1	1337A-160	Air Table Assy.
6	1	1337A-175C	Air Table Shelf
7	2	NNK5/16-18	Kep Nut
8	6	SSHC10064	Hex Head
9	3	SSZH#10048	Sheet Metal Screw
10	8	WWFS5/16	Flat Washer
11	4	WWL5/16	Lock Washer

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TRIM RULE LABEL TO 3-3/4 ON THIS SIDE
AND APPLY AS SHOWN ABOVE THE SLOTS
ON BOTH TOP PLATES. LABEL MUST NOT
INTERFERE WITH ITEM #2

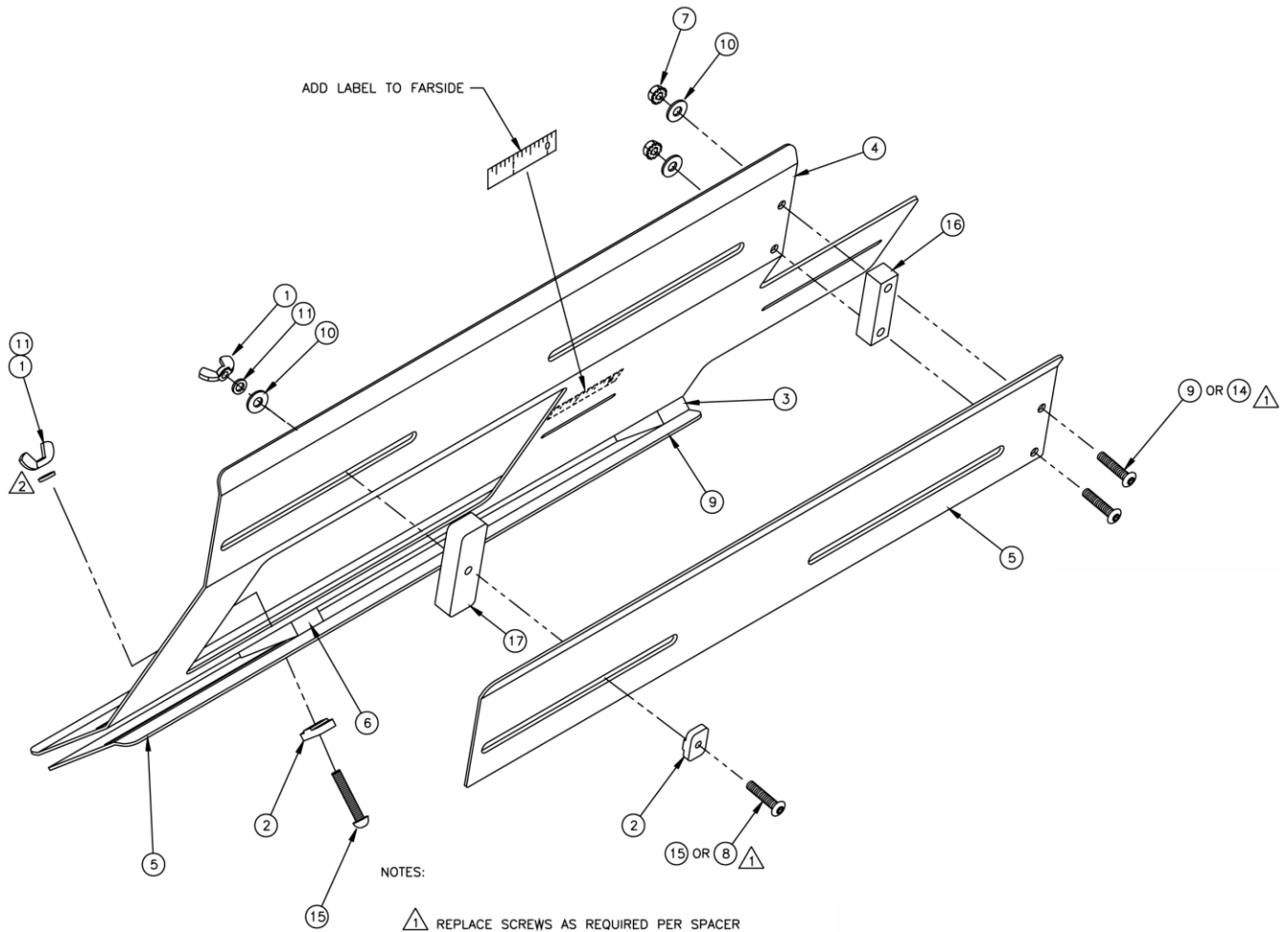
NOTES:
 LOCKTITE (262) TO ITEM 3

From the library of: Diamond Needle Corp

A-2216K5/16 Flat Folder, 5/16 x 6

AAC Drawing Number 192836C Rev3

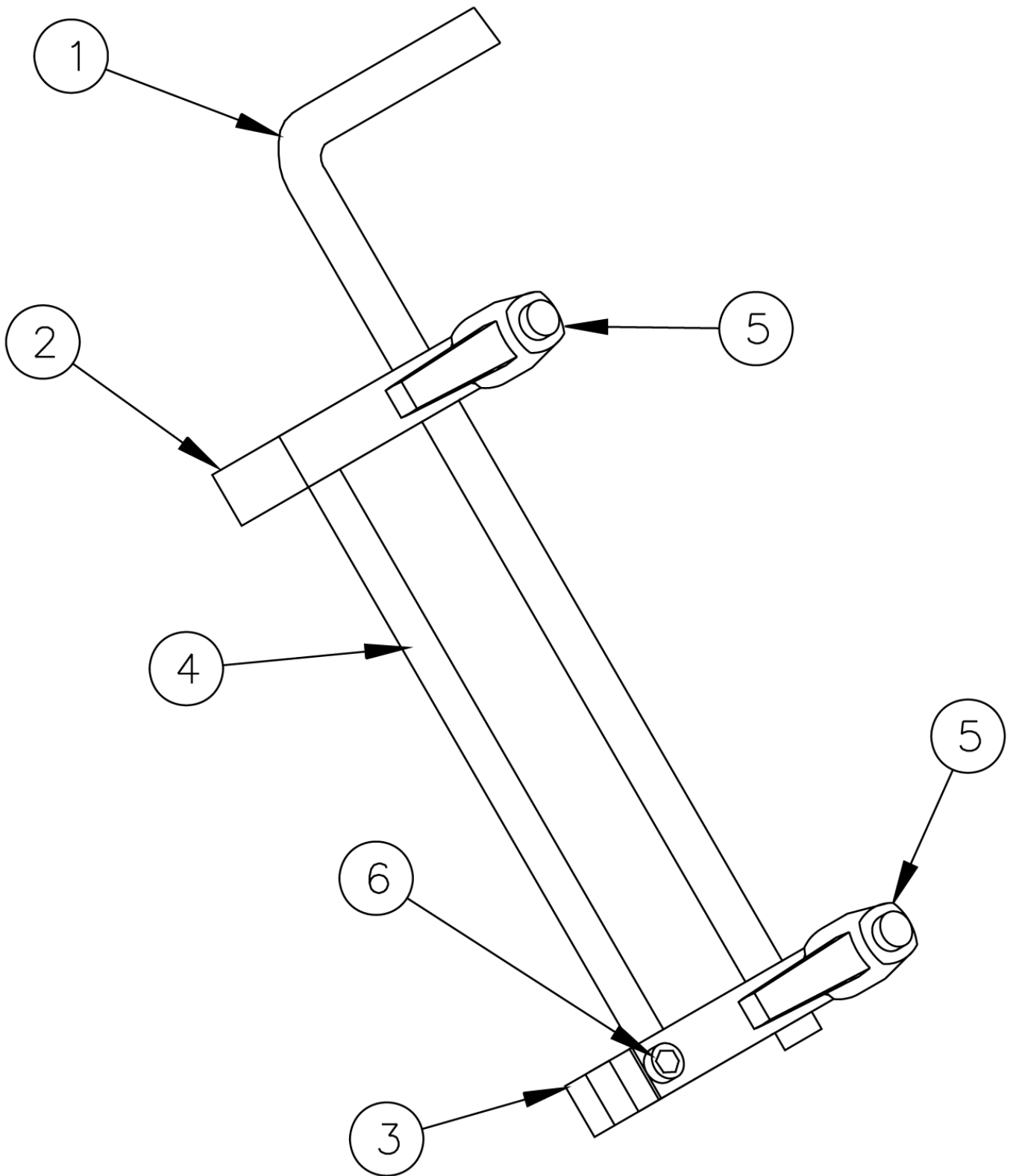
NO.	QTY	PART #	DESCRIPTION
1	4	NNW10-32	Wing Nut
2	2	A-2216D22	T-Nut
3	2	A-2216D53	Spacer, 1/4
4	2	A-2216G29	Spacer, 5/16
5	1	A-2216K02	Folder Plate
6	2	A-2216K04	Folder Top
7	2	A-2216D34	Guide, 5/16
8	4	NNK10-32	Kep Nut
10	4	WWL10	Lock Washer
11	2	SSSC98040	Screw, Socket Cap
12	4	SSBC98048	Screw, Button Cap
13	8	WWFS10	Flat Washer
14	2	SSBC98064	Screw, Button Cap
15	1	1335A-302	Label



A-2216M 5/16 Book Folder, 5/16 x 18"

AAC Drawing Number 192824C Rev6

NO.	QTY	PART #	DESCRIPTION
1	2	NNW10-32	Wing Nut
2	2	A-2216D22	T-Nut
3	1	A-2216G29	Spacer, 5/16
4	1	A-2216M02	Folder Plate
5	2	A-2216M04	Folder Top
6	1	A-2216D34	Guide, 5/16
7	4	NNK10-32	Kep Nut
8	1	SSBC98064	Screw, Button Cap
9	4	SSBC98048	Screw, Button Cap
10	5	WWFS10	Flat Washer
11	2	WWL10	Lock Washer
12	1	A-2216G34	Spacer, 9/16
13	1	A-2216D39	Guide, 9/16
14	2	SSBC98056	Button Cap Screw
15	2	SSBC98072	Button Cap Screw
16	1	A-2216G30	Spacer, 7/16
17	1	A-2216D37	Guide, 7/16

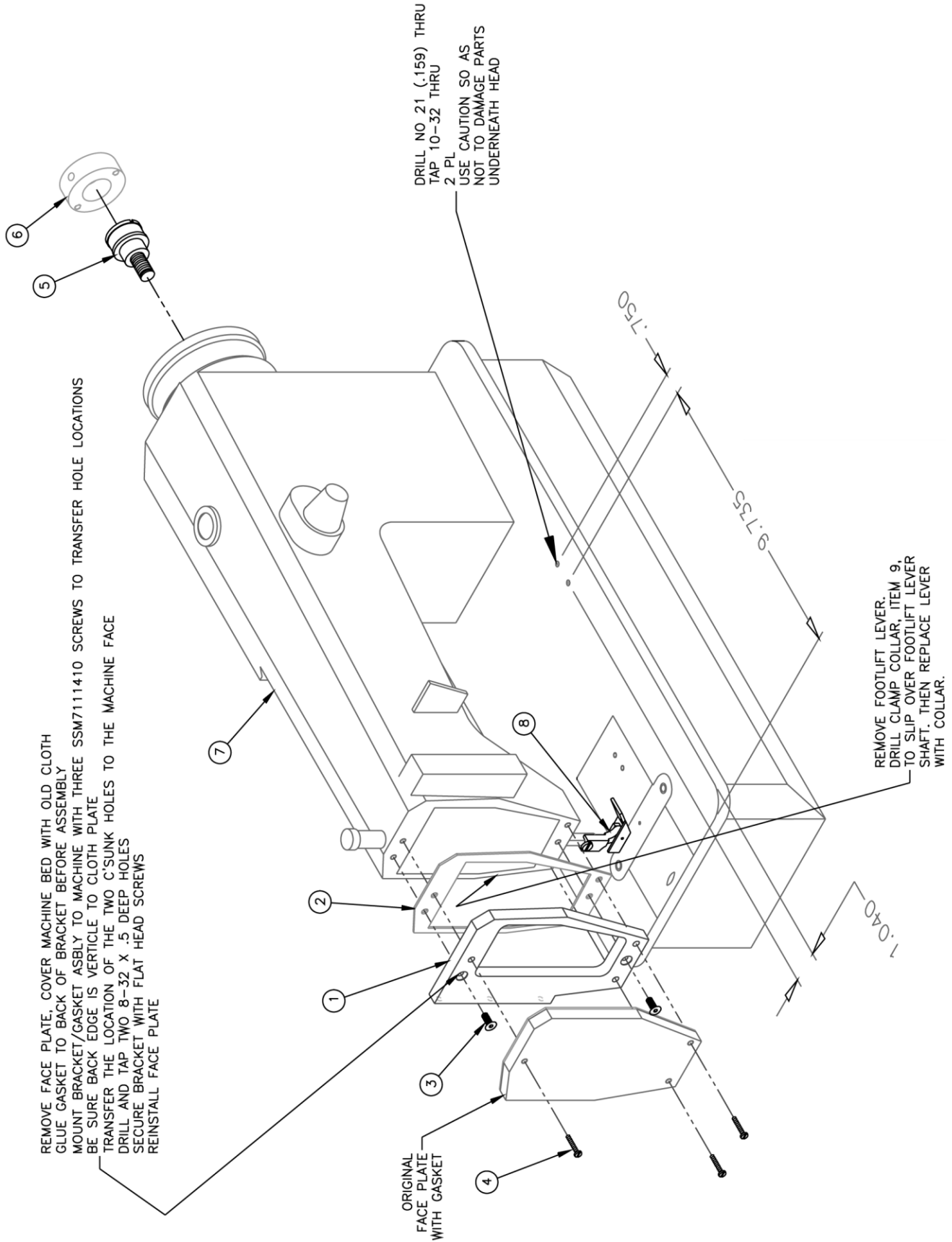


From the library of: Diamond Needle Corp

1334-2600 Tension Assembly

AAC Drawing Number 192511B Rev1

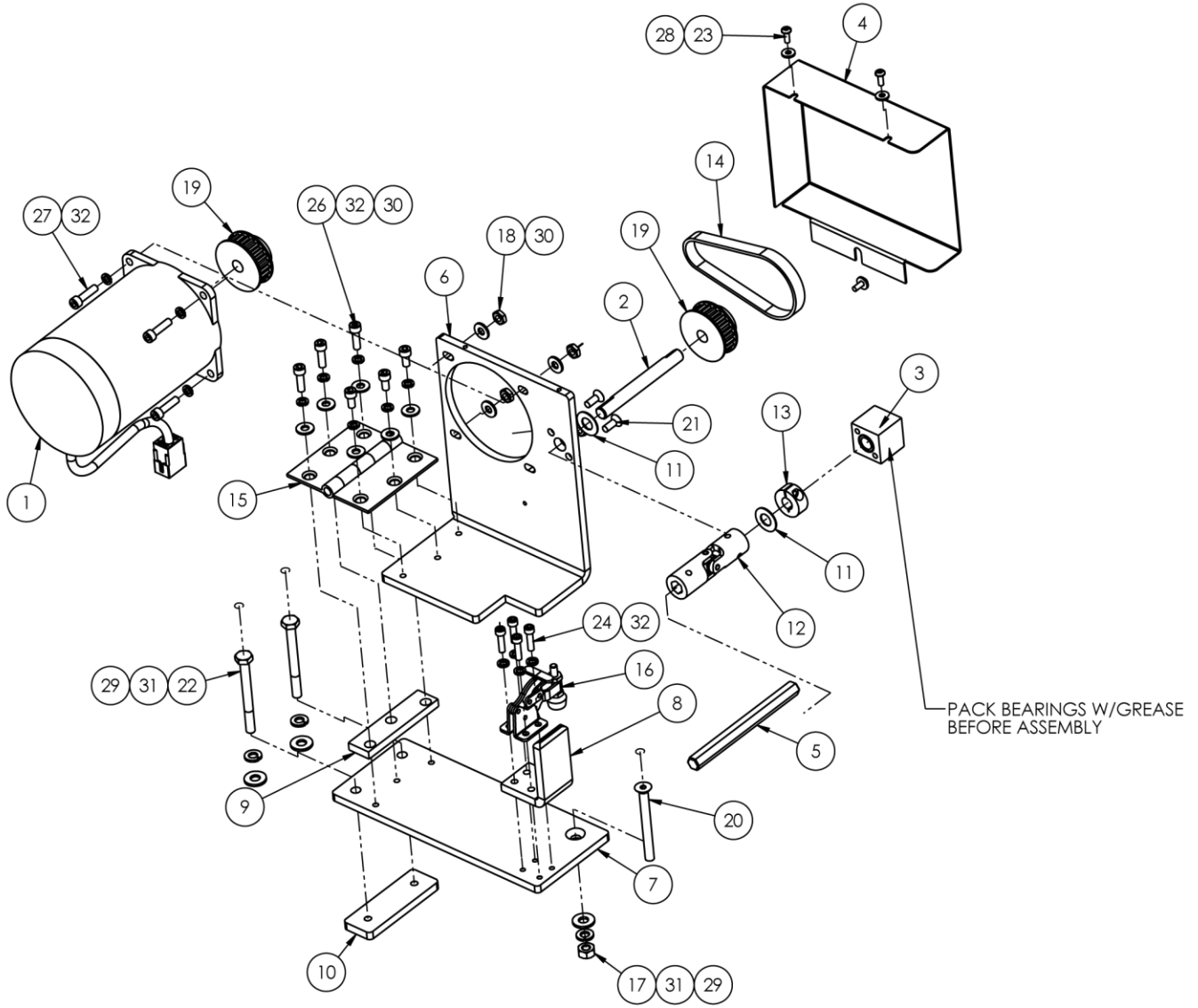
NO.	QTY	PART #	DESCRIPTION
1	1	1335-316B	Bent Rod
2	1	1335-318	Rod Slide Arm
3	1	1335-319	Rod Clamp Arm
4	1	1335-320B	Straight Rod
5	2	TTH34311	Threaded Handle
6	1	SSHC95048	Screw, Socket Cap



1335MD-10 Sewing Head Modification

AAC Drawing Number 192862C Rev1

NO.	QTY	PART #	DESCRIPTION
1	1	1335M-3009	Brkt
2	1	B1122552000	Gasket
3	2	SSFC90048	Screw, Flat Allen
4	3	SSM50267	Screw, Fillister Head
5	1	22100-019	Sync Adapter
6	1	1278-6364	Tape Mount Disc
7	1	SJUKI-481U	Sewing Head
8	1	M1191-019	Foot Ruffler, SN,NF
9	1	CCCL4F	Clamp Collar 1/4 in.

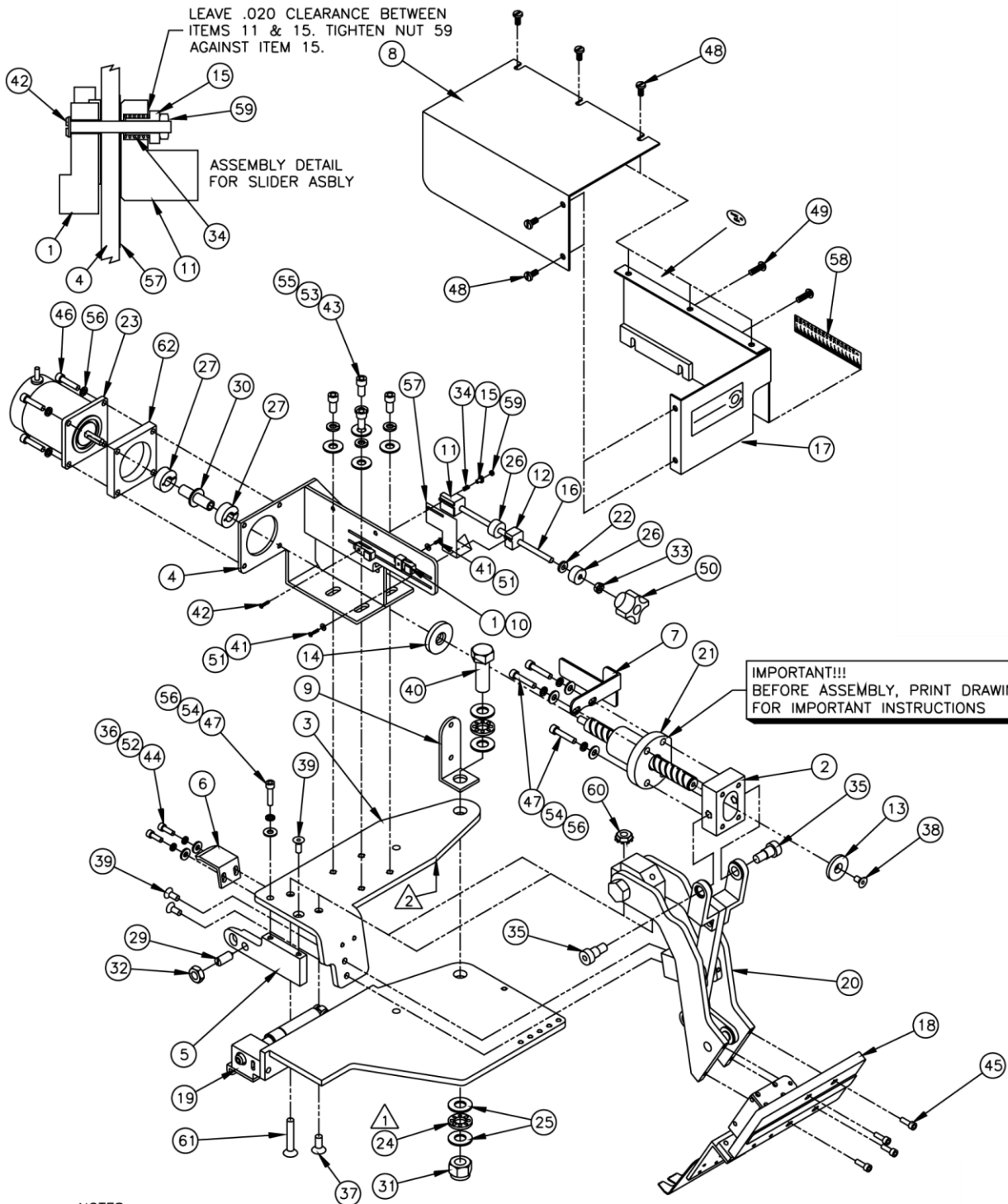


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1335M-120 Puller Drive Assembly

AAC Drawing Number 9001014 Rev4

NO.	QTY	PART #	DESCRIPTION
1	1	011-020	MOTOR, STEPPER W/PLUG
2	1	1335-116	SHAFT, FLATTED, 60C, .375
3	1	1335-119	BLOCK, BEARING
4	1	1335-124	GUARD, MOTOR BELT
5	1	1335M-121	HEX SHAFT, 3/8X4 3/8
6	1	1335M-127	MOUNT, MOTOR
7	1	1335M-128	PLATE, BASE
8	1	1335M-129	CLAMP SPACER
9	1	1335M-130	HINGE SPACER
10	1	1335M-131	PLATE, NUT, 1/4-20 @ 2.0
11	2	3517	WASHER, THRUST, BRONZE
12	1	3524-06A	U-JOINT, MODIFIED
13	1	CCCL6F	CLAMP COLLAR- 3/8
14	1	GG100XL037	BELT, GEAR, 1/5P, 3/8W
15	1	MM741-3A	HINGE, 3 X 3, STANLEY
16	1	MM8096307	CLAMP
17	1	NNH1/4-20	1/4-20 HEX NUT
18	4	NNH10-32	HEX-NUT 10-32 REG.
19	2	PP24XLB37M1	PULLEY, GEAR, 1/5 PITCH
20	1	SSFC01160	1/4-20 X 2-1/2 FLAT CAP
21	2	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
22	2	SSHC01160	1/4-20 X 2-1/2 HHCS
23	3	SSPS80024	#6-32 X 3/8 LG PAN HD
24	4	SSSC90040	8-32 X 5/8 SOC CAP SC
25	3	SSSC98024	10-32 X 3/8 SOC CAP
26	3	SSSC98040	10-32 X 5/8 SOC CAP
27	4	SSSC98048	10-32 X 3/4 SOC CAP
28	3	WWF6	DO NOT USE - SEE WWFS6
29	3	WWFS1/4	WASHER, FLAT, SAE, 1/4
30	10	WWFS10	WASHER, FLAT, #10, SAE
31	3	WWL1/4	WASHER, LOCK, 1/4
32	14	WWL10	WASHER, LOCK, #10, S/S



1335M-2000 Ruffler Assembly

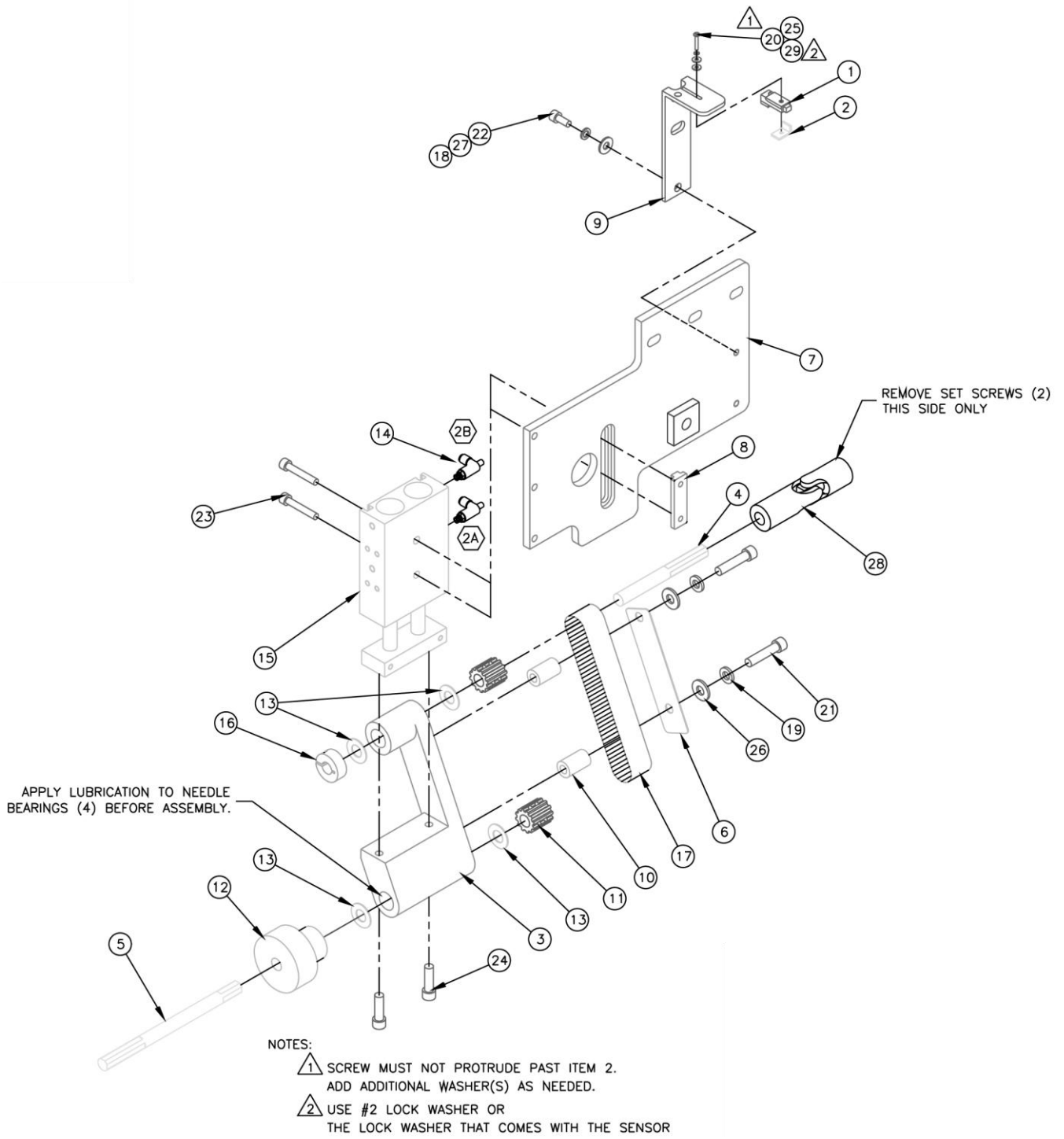
AAC Drawing Number 192706C Rev7

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	1278-7055D	Prox Switch	32	1	NNJ3/8-16	Jam Nut
2	1	1335M-2006	Trunion Block	33	1	NNK10-32	Kep Nut
3	1	1335M-2008	Pivot Plate	34	1	RRLC026B1	Spring
4	1	1335M-2016	Motor Brkt Weldment	35	2	SSAS024024M	Screw, Allen Shoulder
5	1	1335M-2019	Locking Lever	36	2	WWL8	Lock Washer
6	1	1335M-2020	Hold Down Brkt	37	2	SSFC01040	Screw, Flat Allen
7	1	1335M-2021	Vane	38	1	SSFC98024	Screw, Flat Allen
8	1	1335M-2030	Clear Cover	39	3	SSFC98040	Screw, Flat Allen
9	1	1335M-2031	Pivot Brkt	40	1	SSHC45096	Screw, Hex Cap
10	1	1335M-2034	Nut Plate	41	2	SSPS50032	Screw, Pan Head
11	1	1335M-2035	Adjustment Nut	42	1	SSPS50048	Screw, Pan Head
12	1	1335M-2036	Support Block	43	4	SSSC01032	Screw, Socket Cap
13	1	1335M-2037	Stop Washer	44	2	SSSC90024	Screw, Socket Cap
14	1	1335M-2038	Stop Washer	45	4	SSSC90032	Screw, Socket Cap
15	1	1335M-2039	Nut, Spring Retainer	46	4	SSSC98032	Screw, Socket Cap
16	1	1335M-2040	Adjustment Screw	47	5	SSSC98048	Screw, Socket Cap
17	1	1335M-2042	Cover	48	5	SSTS90024	Screw, Truss Head
18	1	1335M-2100A	Ruffler Cylinder Assy	49	2	SSTS98040	Screw, Truss Head
19	1	1335M-2200	Mount Angle Assy	50	1	TTCL1APPK1'	Plastic Knob
20	1	1335M-2300	Pivot Assy	51	2	WWF2	Flat Washer
21	1	1335M-2400	Ball Screw & Nut	52	2	WWF8	Flat Washer
22	1	AA198-7006	O-Ring	53	4	WWFS1/4	Flat Washer
23	1	AP-22E-103	Step Motor	54	5	WWFS10	Flat Washer
24	2	BBNTA815	Thrust Bearing	55	4	WWL1/4	Lock Washer
25	4	BBTRA815	Thrust Washer	56	9	WWL10	Lock Washer
26	2	CCCL10T	Clamp Collar	57	1	1335M-2047	Size Pointer
27	2	CCCL8F	Clamp Collar	58	AR	1325-4126	Scale Label
28	20"	MM132-10A1	Teflon Tape	59	1	NNH2-56	Hex Nut
29	1	SSMB58N	Ball Plunger	60	1	NNK1/4-20	Kep Nut
30	1	MM8FM	U-Joint	61	1	SSFC01096	Screw, Flat Allen
31	1	NNE1/2-13	Elastic Lock Nut	62	1	1335M-2049	Spacer

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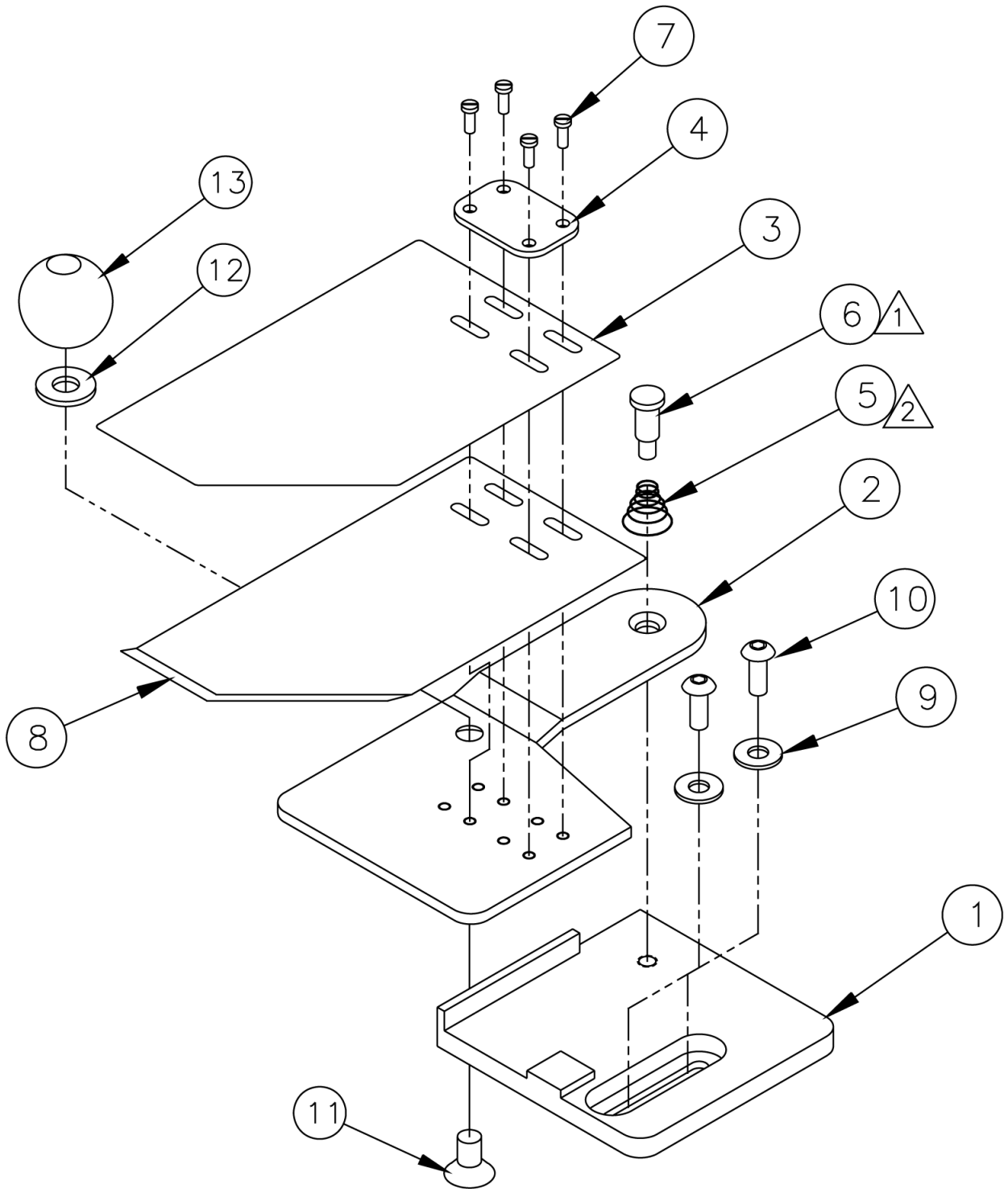
From the library of: Diamond Needle Corp



1335MDS-3000 Puller Assembly

AAC Drawing Number 192923C Rev1

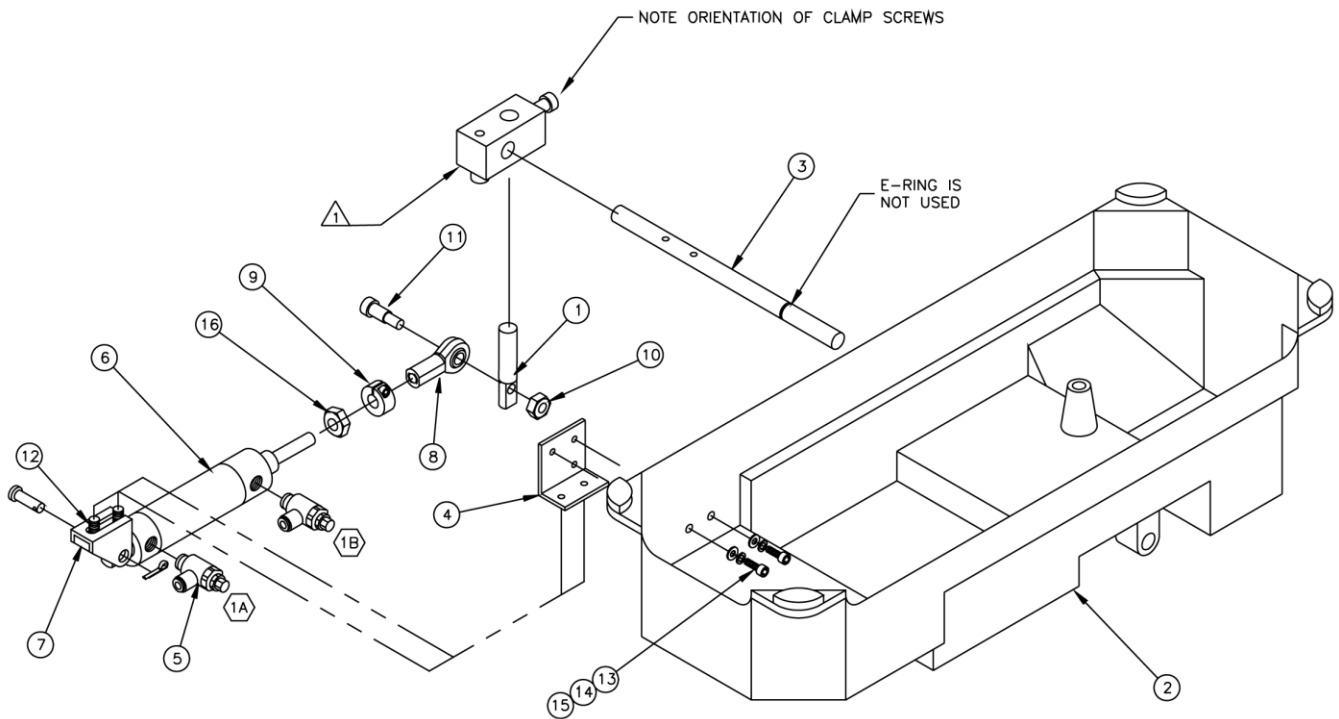
NO.	QTY	PART #	DESCRIPTION
1	1	1278-7055D	Prox Switch
2	1	1335M-2034	Nut Plate
3	1	1335M-3001	Yoke
4	1	1335M-3002	Shaft, .375 x 3.38
5	1	1335M-3003	Shaft, .375 x 5.33
6	1	1335M-3004	Belt Cover
7	1	1335M-3010	Cylinder Mount Brkt
8	1	1335M-3007	T-Nut
9	1	1335M-3008	Sensor Brkt
10	2	1535-241	Transfer Spacer
11	2	350196	Gear Pulley
12	1	3514-3CU	Fluted Roller
13	4	3517	Thrust Washer
14	2	AA198RA510	Flow Control
15	1	AACXSM2020	Air Cylinder
16	1	CCCL6F	Clamp Collar
17	1	GG110XL75U	Gear Belt
18	3	WWL10	Lock Washer
19	2	WWL1/4	Lock Washer
20	1	SSPS50032	Screw, Pan Head
21	2	SSSC01064	Screw, Socket Cap
22	3	SSSC98024	Screw, Socket Cap
23	2	SSSC98064	Screw, Socket Cap
24	2	SSSCM5X20	Screw, Socket Cap
25	2	WWF2	Flat Washer
26	2	WWFS1/4	Flat Washer
27	3	WWFS10	Flat Washer
28	1	3524-06A	U-Joint
29	1	WWSI2	Int. Tooth Washer



1335M-5000A Stripper Blade Assembly

AAC Drawing Number 192505B Rev2

NO.	QTY	PART #	DESCRIPTION
1	1	1335M-5001	Mounting Plate
2	1	1335M-5002	Mnt, Stripper Blade
3	1	1335M-5003B	Stripper Blade
4	1	1335M-5004	Washer Plate
5	1	RRBEEHIVEH	Spring
6	1	SSM200246	Screw, Shoulder
7	4	SSM22593	Screw, Fillister Head
8	1	1335M-5003C	Spacer
9	2	WWFS10	Flat Washer
10	2	SSBC98032	Screw, Button Cap
11	1	SSFC01032	Screw, Flat Allen
12	1	WWFS1/4	Flat Washer
13	1	SSMBK13	Plastic Knob



NOTES:
 △ PART OF SEWING HEAD

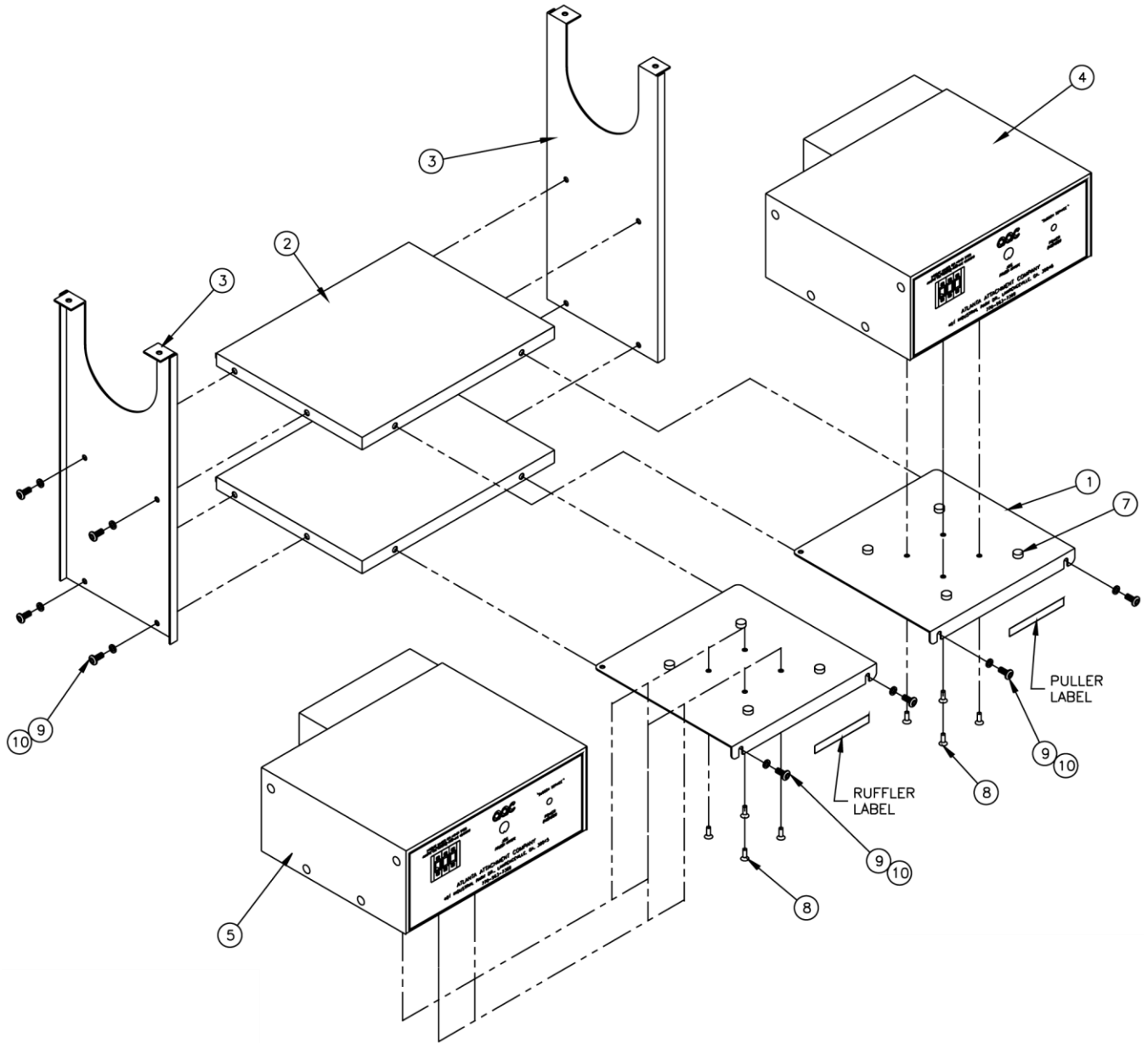
WHEN ADJUSTING THE FOOT LIFT, THE CYLINDER SHOULD
 BOTTOM OUT EXTENDED WHEN THE FOOT IS UP
 AND BOTTOM OUT ON THE COLLAR WHEN THE FOOT IS DOWN.
 DO NOT LET THE CYLINDER STOP ON THE ADJUSTABLE
 STOP SCREWS ON THE OIL PAN HARDWARE.

From the library of: Diamond Needle Corp

1335MD-6000 Footlift Assembly

AAC Drawing Number 192864C Rev3

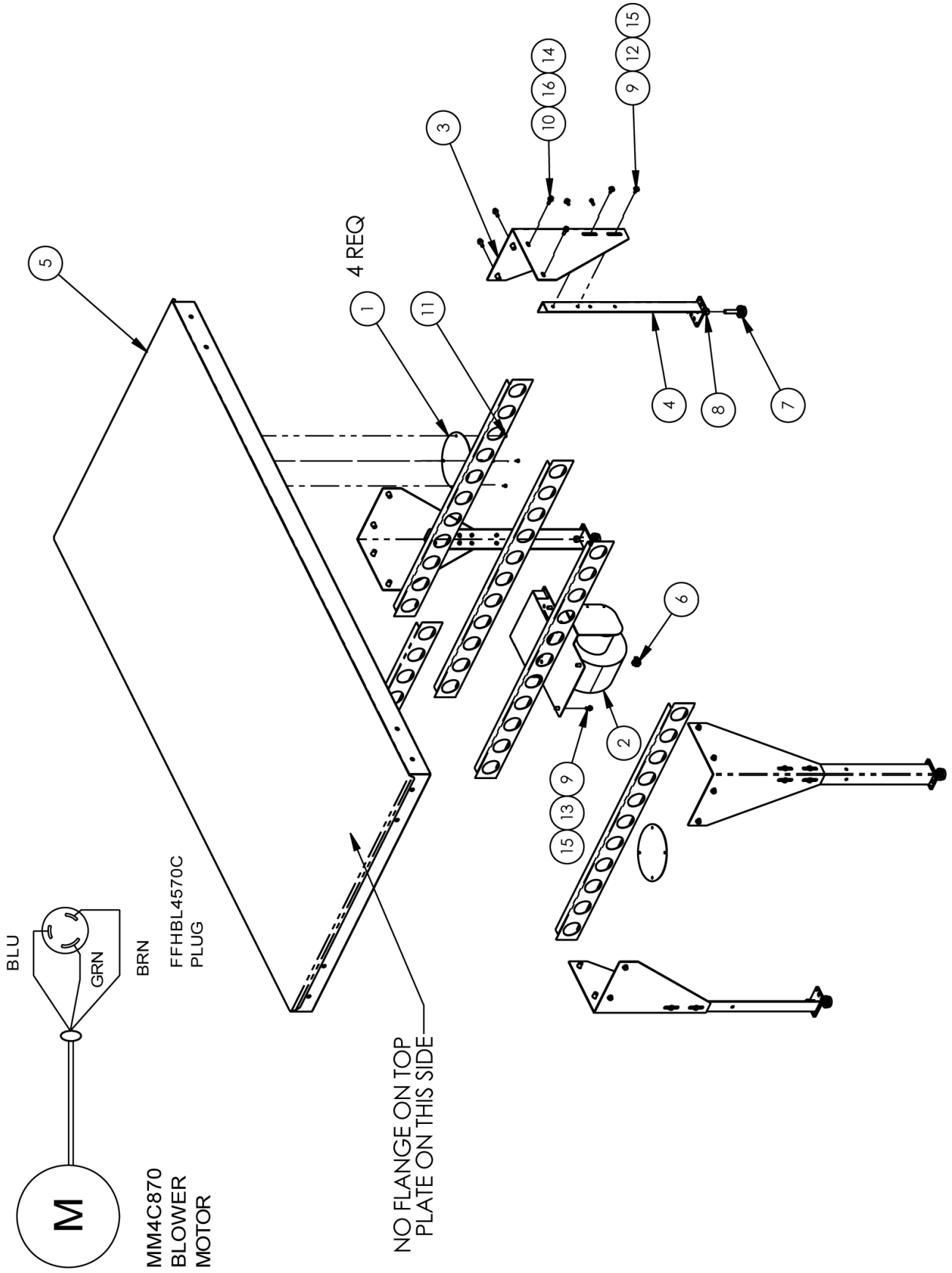
NO.	QTY	PART #	DESCRIPTION
1	1	1918-073	Footlift Link
2	1	1335M-6001	Oil Pan, Modified
3	1	1335M-6002	Shaft
4	1	32006524	Pivot Mnt Brkt
5	2	AA198RA508	Flow Control
6	1	AAC6DP-2	Air Cylinder
7	1	AAFBP-11C	Pivot Brkt
8	1	BBAW-5Z	Rod End
9	1	CCCL5F	Clamp Collar
10	1	NNH1/4-20	Hex Nut
11	1	SSAS020032	Screw, Allen Shoulder
12	2	SSBC98016	Screw, Button Cap
13	2	SSSC98024	Screw, Socket Cap
14	2	WWL10	Lock Washer
15	2	WWFS10	Flat Washer
16	1	NNJ5/16-24	Jam Nut



1335M-9500 Stepper Box Assembly

AAC Drawing Number 192710C Rev2

NO.	QTY	PART #	DESCRIPTION
1	2	1335M-9010	Step Box Brkt
2	2	1335M-9011	Shelf Motor Box
3	2	1335M-9012	Mnt, Ctrl Box
4	1	AP-28-800C	Control Box
5	1	AP-28-800Y1	Stepper Box
6	2	EE37F3312	Power Cord
7	8	MMSLD-ECH	Rubber Bumper
8	8	SSFC80032	Screw, Flat Allen
9	12	SSPP98032	Screw, Pan Phillips
10	12	WWL10	Lock Washer

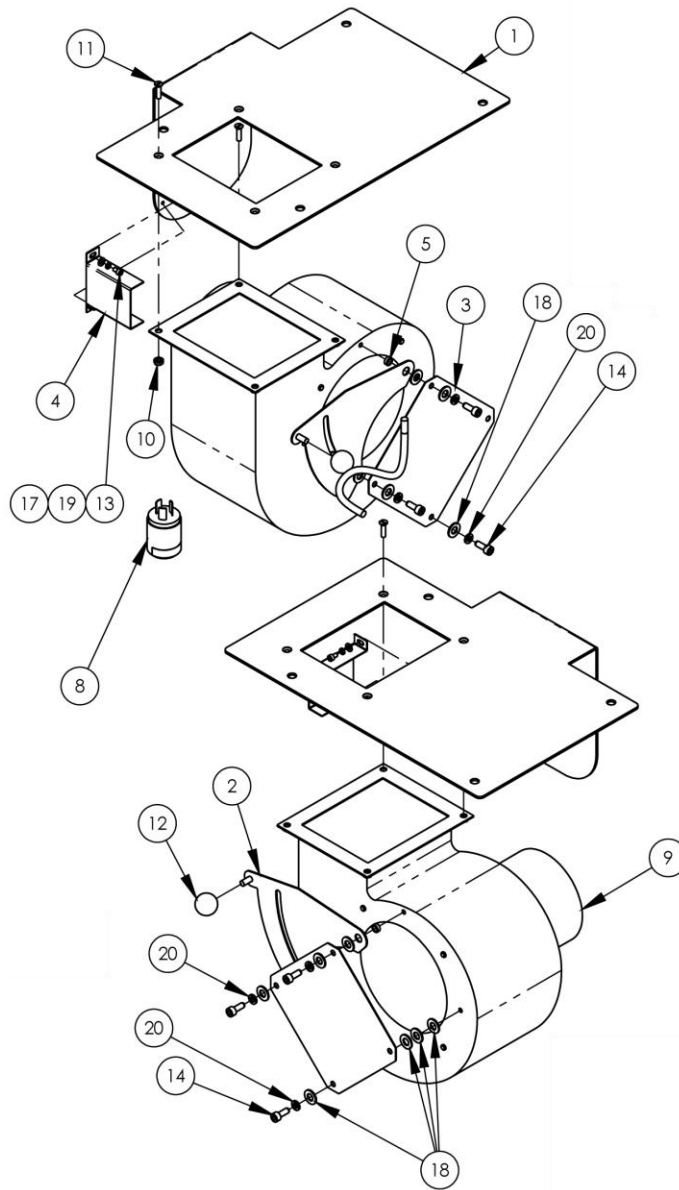


1337A-160 Air Table Assembly

AAC Drawing Number 1337296 Rev7

NO.	QTY	PART #	DESCRIPTION
1	4	1335-159	ACCESS COVER
2	1	1337135	BLOWER ASSY
3	4	1337A-0161	ANGLE, CORNER
4	4	1337A-0163	WELDMENT, LEG, TABLE
5	1	1337A-150	AIR TABLE ASSY
6	1	K-235	CONNECTOR,ROMEX,1/2"
7	4	MMFB4444	FOOT, RUBBER
8	4	NNH1/2-13	NUT,HEX,1/2-13
9	20	SSHC01048	1/4-20 X 3/4 HEX CAP
10	16	SSHC10064	5/16-18 X 1 HHCS
11	16	SSZH#10032	SCREW,SHT.METAL HEX 10
12	16	WWF1/4	WASHER, FLAT, 1/4", COM
13	4	WWFS1/4	WASHER,FLAT,SAE,1/4
14	16	WWFS5/16	WASHER,FLAT,SAE,5/16
15	20	WWL1/4	WASHER,LOCK,1/4
16	16	WWL5/16	WASHER, LOCK, 5/16

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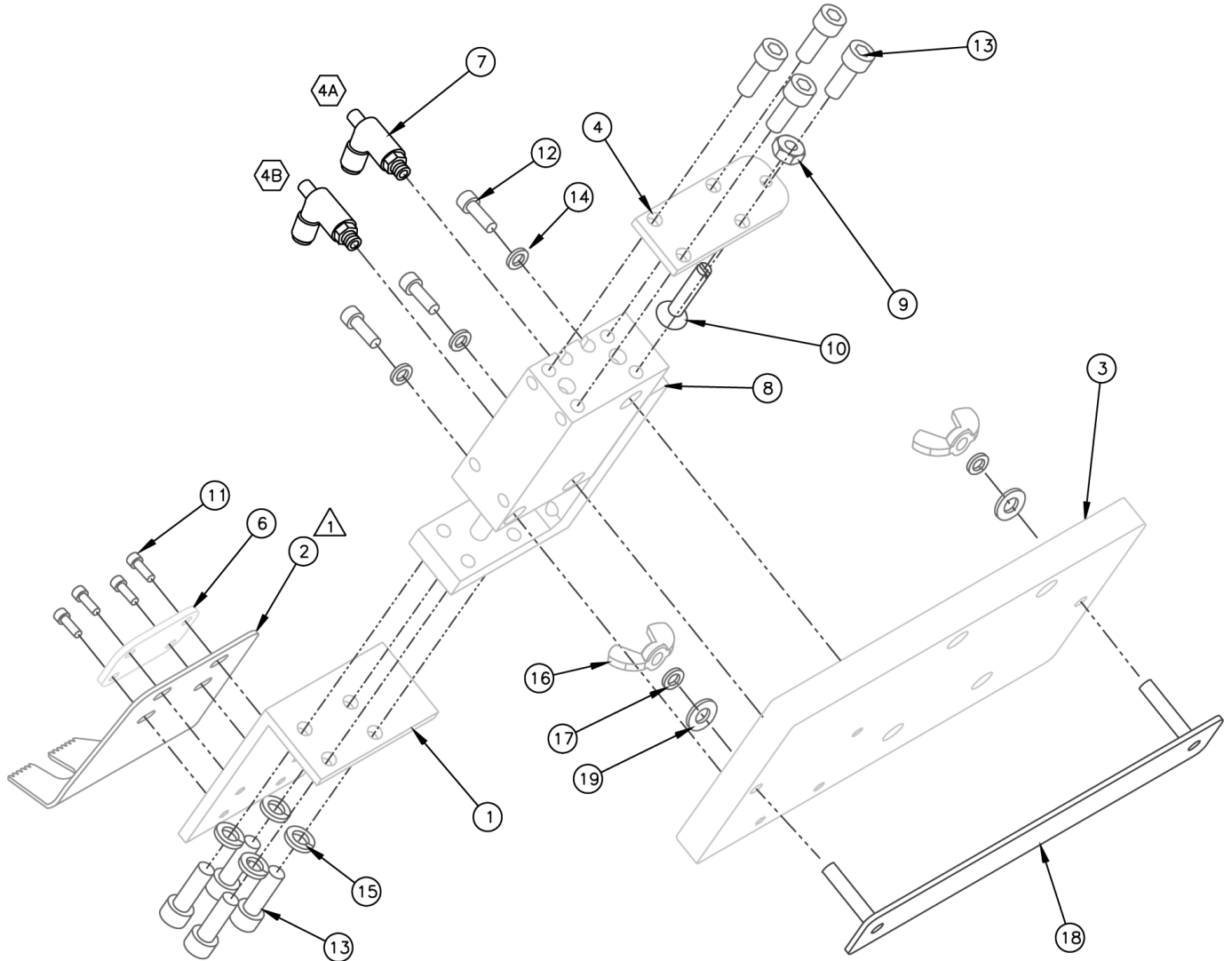


From the library of: Diamond Needle Corp

1337135 Blower Assembly

AAC Drawing Number 1337135 Rev2

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1337116	ADAPTOR, BLOWER	11	4	SSFS98048	#10-32 X 3/4, FLAT SLOT
2	1	1337133	SPACER, BLOWER ASSY	12	1	SSMBK13	KNOB, BLACK PLASTIC
3	1	1337134	GRILL, BLOWER INLET	13	2	SSSC90016	#8-32 X 1/4 SOC CAP SC
4	1	1337136	COVER, CAPACITOR	14	3	SSSCM6X16	M6X16 SOC CAP SCREW
5	1	1337137	SPACER	15	1	TT5802	TERMINAL RING, #10 STUD
6	2*	EERB44	STA KON WIRE JOINT	16	1	TTH6324K170	HANDLE, THR'D, M6 X 16MM
7	1	FF19509	CABLE, 3 COND, 18 AWG, SJTOW	17	2	WWF8	WASHER, FLAT, #8
8	1	FFHBL4570C	PLUG, 2P/3W, GROUNDING	18	12	WWFS5/16	WASHER, FLAT, SAE, 5/16
9	1	MM1TDT3	BLOWER, 230V, 559CFM	19	2	WWL8	WASHER, LOCK, #8
10	4	NNK10-32	KEP NUT, 10-32	20	3	WWLM6	M6 LOCK WASHER

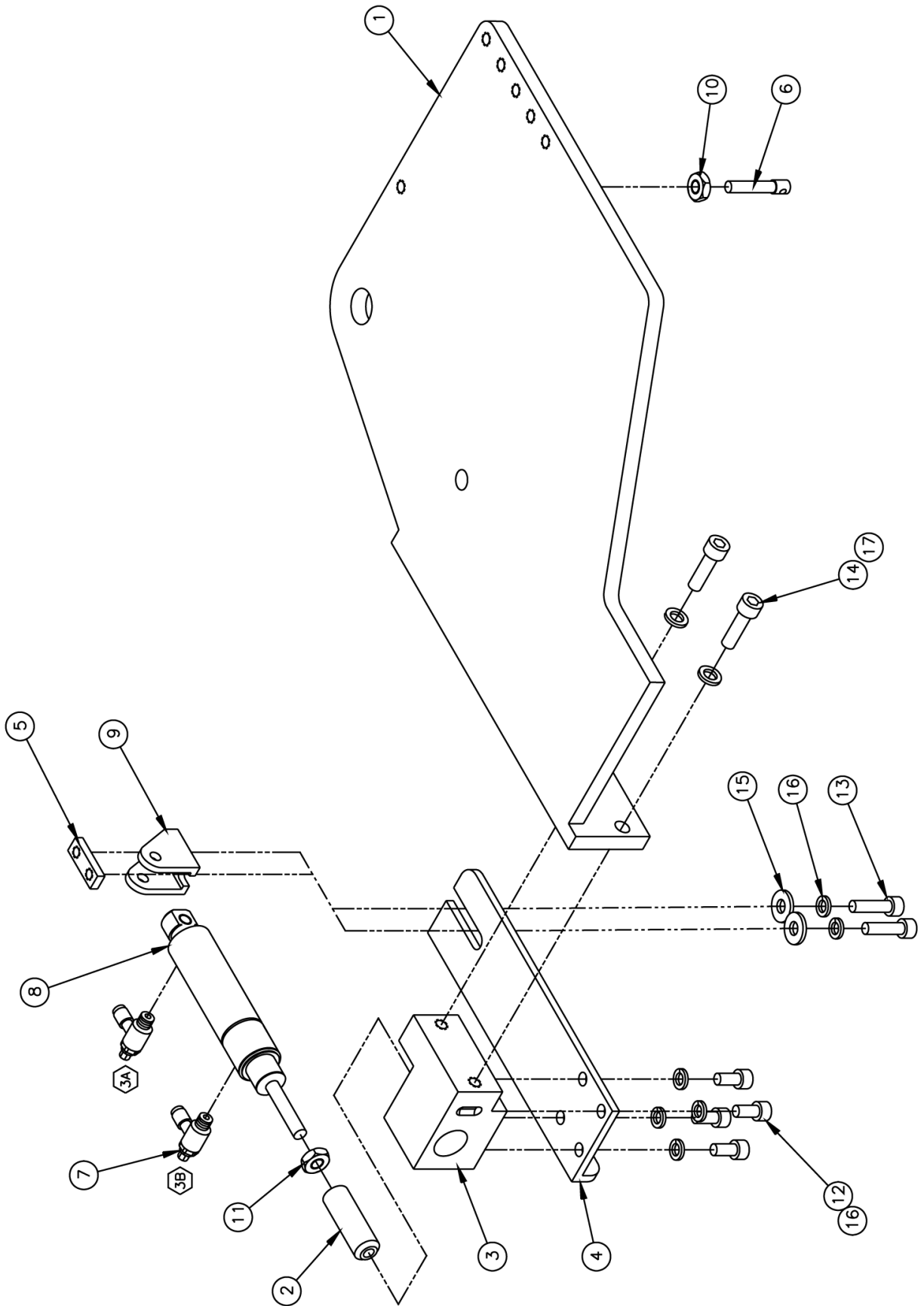


From the library of: Diamond Needle Corp

1335M-2100A Ruffler Cylinder Assembly

AAC Drawing Number 192504B Rev2

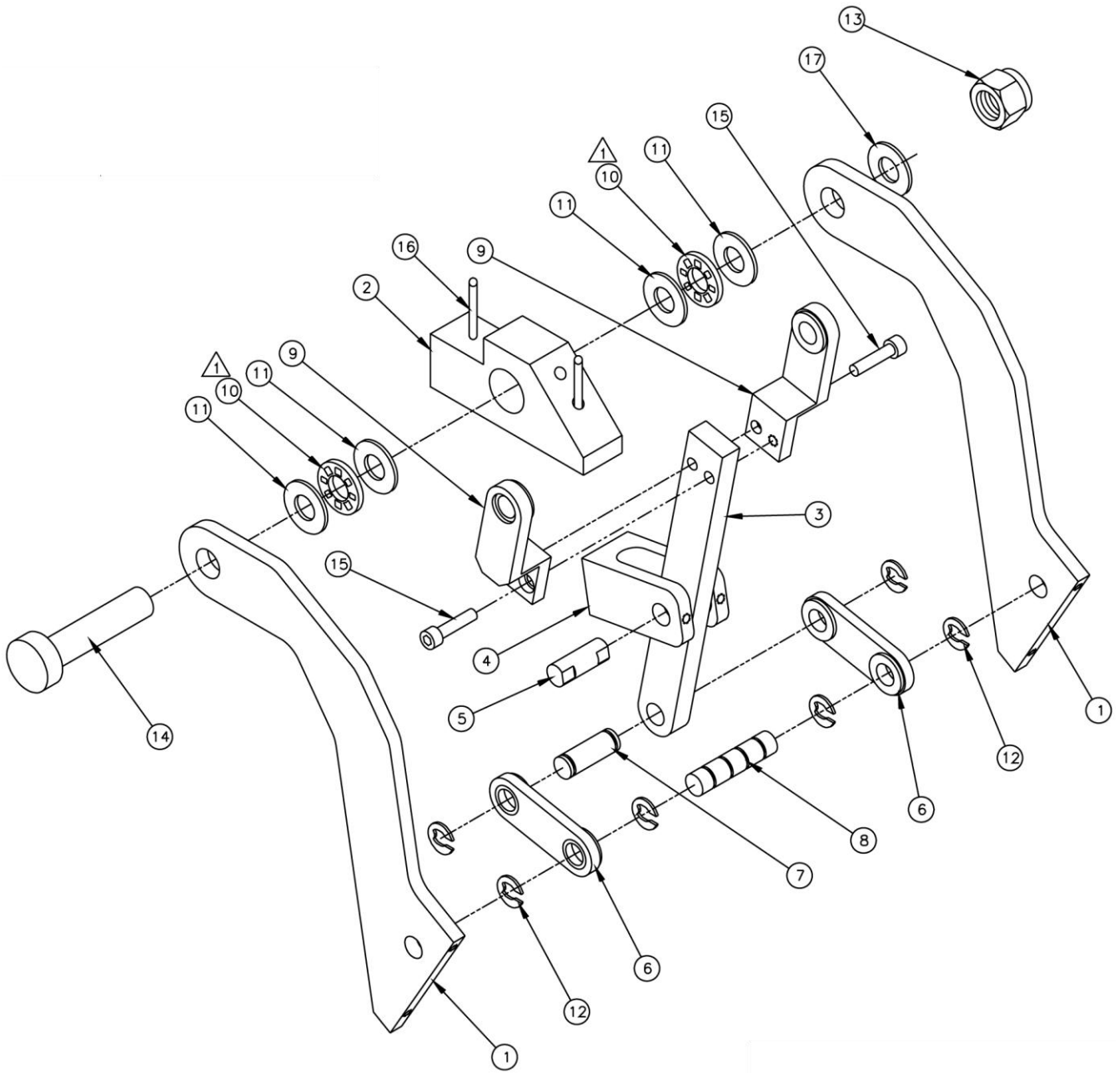
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1335M-2001	Ruffler Foot Brkt	11	4	SSM22593	Screw, Fillister Head
2	1	1335M-2002C	Stripper Blade	12	3	SSSC80064	Screw, Socket Cap
3	1	1335M-2003A	Cylinder Mount Plate	13	8	SSSCM4X10	Screw, Socket Cap
4	1	1335M-2033	Stop Mount	14	3	WWL6	Lock Washer
6	1	1335M-5004	Washer Plate	15	4	WWL8	Lock Washer
7	2	AA198RA510	Flow Control	16	2	NNW10-32	Wing Nut
8	1	AACMXH1025	Air Cylinder	17	2	WWL10	Lock Washer
9	1	NNH8-32	Hex Nut	18	1	1335M-2048	Stud Plate
10	1	SSFC90064M	Screw, Flat Allen	19	2	WWFS10	Flat Washer



1335M-2200 Ruffler Mounting Angle Assembly

AAC Drawing Number 192727C Rev1

NO.	QTY	PART #	DESCRIPTION
1	1	1335M-2005	Mounting Angle
2	1	1335M-2017	Rod End
3	1	1335M-2027	Cylinder Mount
4	1	1335M-2028	Cylinder Support
5	1	1335M-2046	Nut Plate
6	1	A-2206A	Threaded Rod
7	2	AA198RA510	Flow Control
8	1	AAC8DP-.5	Air Cylinder
9	1	AAFBP-8C	Pivot Brkt
10	1	NNH10-32	Hex Nut
11	1	NNH10-32S	Hex Nut, Small
12	4	SSSC90024	Screw, Socket Cap
13	2	SSSC90032	Screw, Socket Cap
14	2	SSSC98040	Screw, Socket Cap
15	2	WWF8	Flat Washer
16	6	WWL8	Lock Washer
17	2	WWL10	Lock washer



NOTES:

 APPLY ACROLUBE GREASE BEFORE ASSEMBLY.

1335M-2300 Pivot Assembly

AAC Drawing Number 192731C Rev3

NO.	QTY	PART #	DESCRIPTION
1	2	1335M-2004	Pivot Arm
2	1	1335M-2007	Pivot Block
3	1	1335M-2009	Drive Link
4	1	1335M-2010	Pivot Block
5	1	1335M-2011	Pivot Shaft
6	2	1335M-2012	Side Link
7	1	1335M-2013	Link Shaft
8	1	1335M-2014	Link Shaft
9	2	1335M-2015	Link Yoke
10	2	BBNTA815	Thrust Bearing
11	4	BBTRA815	Thrust Washer
12	6	MM8407A134	E-Ring
13	1	NNE3/8-16	Elastic Lock Nut
14	1	SSAS032096	Socket Shoulder Screw
15	2	SSSC98048	Screw, Socket Cap
16	2	IIS012X064	Spring Pin
17	1	WWFS3/8	Flat Washer

1335M-2400 Ball Screw and Nut Assembly

ITEM NO.	Default/ QTY.	PART NUMBER	DESCRIPTION
1	1	MM4R1616X162	BALL SCREW, 1.616X162L
2	1	MMR1616A2DFSV	BALL NUT
3	2	EE6X752	CABLE TIE, 5-3/4L

1

REMOVE CABLE TIE (ITEM 3) FROM THE NUT. DO NOT REMOVE THE ARBOR YET!

2

INSERT END OF THE SCREW (ITEM 1) INTO THE NUT (ITEM 2) AS SHOWN.

3

HOLDING THE SCREW (ITEM 1) AND THE NUT (ITEM 2) TOGETHER, TURN THE SCREW INTO THE BALL NUT AS SHOWN. THE ARBOR (REF) WILL BE EJECTED AS THE SCREW ENTERS THE NUT.

4

ONCE THE BALL NUT IS APPROX. CENTERED ON THE SCREW, PUT TIE WRAPS (ITEM #3) ON BOTH ENDS TO PREVENT THE BALL NUT FROM COMING OFF OF THE SCREW.

NOTE: NEVER REMOVE THE SCREW FROM THE NUT WITHOUT SIMULTANEOUSLY REPLACING THE ARBOR AS ALL THE BALLS WILL FALL OUT OF THE NUT!!

NOTES:

1 DO NOT DISASSEMBLE!
 1) REF. ONLY, INCLUDED WITH ITEM 1
 2) IF SHIPPING, BUBBLE WRAP SECURELY

S:\1335\1335M-2400

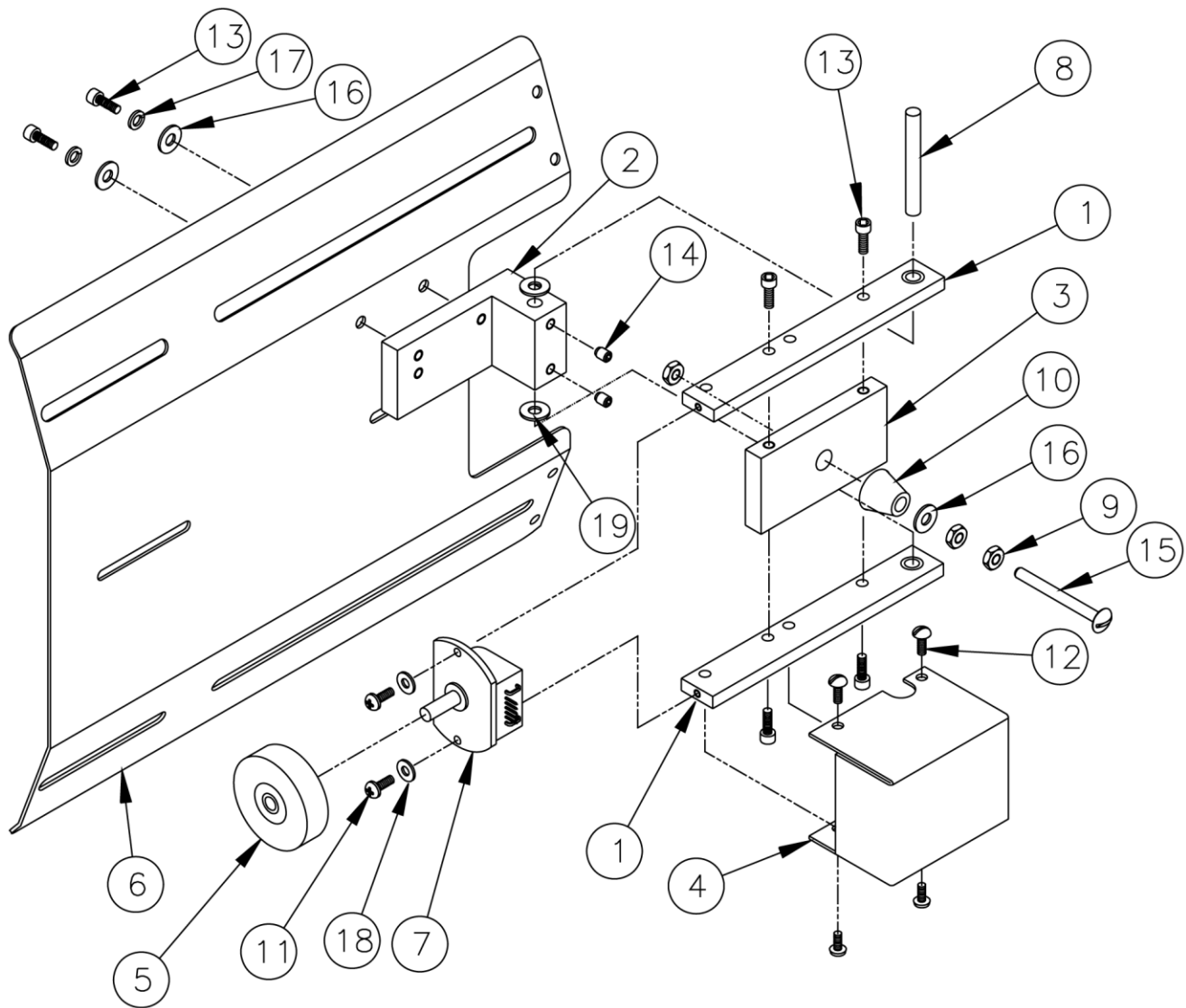
SHEET 1 OF 1

ATLANTA ATTACHMENT COMPANY

NAME: BALL SCREW AND NUT
 2nd DES: 11335M
 MATERIAL NOTED
 ASSEMBLY 1335M-2000
 DES. BY: PBD
 DR. BY: PBD
 CK. BY: -
 SCALE: 1:1
 DATE: 10/12/2004
 PART NO. 1335M-2400
 DRAWING NO. 9000982
 REV 2

022-03

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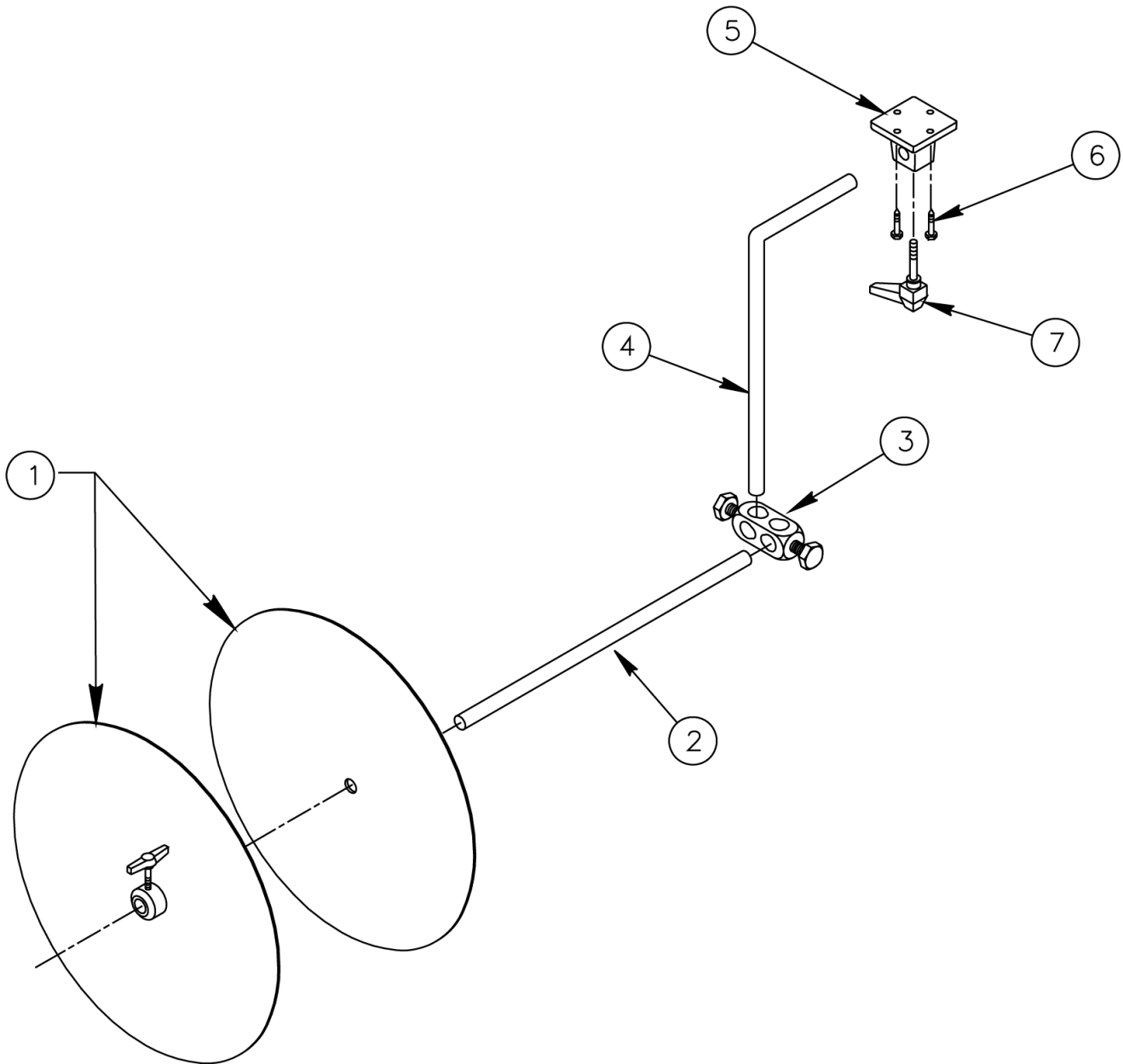


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1335M-2500 Encoder Assembly

AAC Drawing Number 192902C Rev1

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	1335M-2501	Side Brkt	11	2	SSPP80024	Screw, Pan Phillips
2	1	1335M-2502	Base Mount	12	4	SSPS98024	Screw, Pan Head
3	1	1335M-2503	Tension Plate	13	6	SSSC98032	Screw, Socket Cap
4	1	1335M-2504	Cover	14	2	SSSS98016	Screw, Socket Set
5	1	1981A-271	Wheel	15	1	SSTS95128	Screw, Truss Slotted
6	1	A-2216K03	Folder Plate	16	3	WWFS10	Flat Washer
7	1	EEH1-096-HS	Encoder	17	2	WWL10	Lock Washer
8	1	IID016X128	Dowel	18	2	WWL6	Lock Washer
9	3	NNH10-24	Hex Nut	19	2	BBTT601	Thrust Washer
10	1	RRBEEHIVEH	Spring				

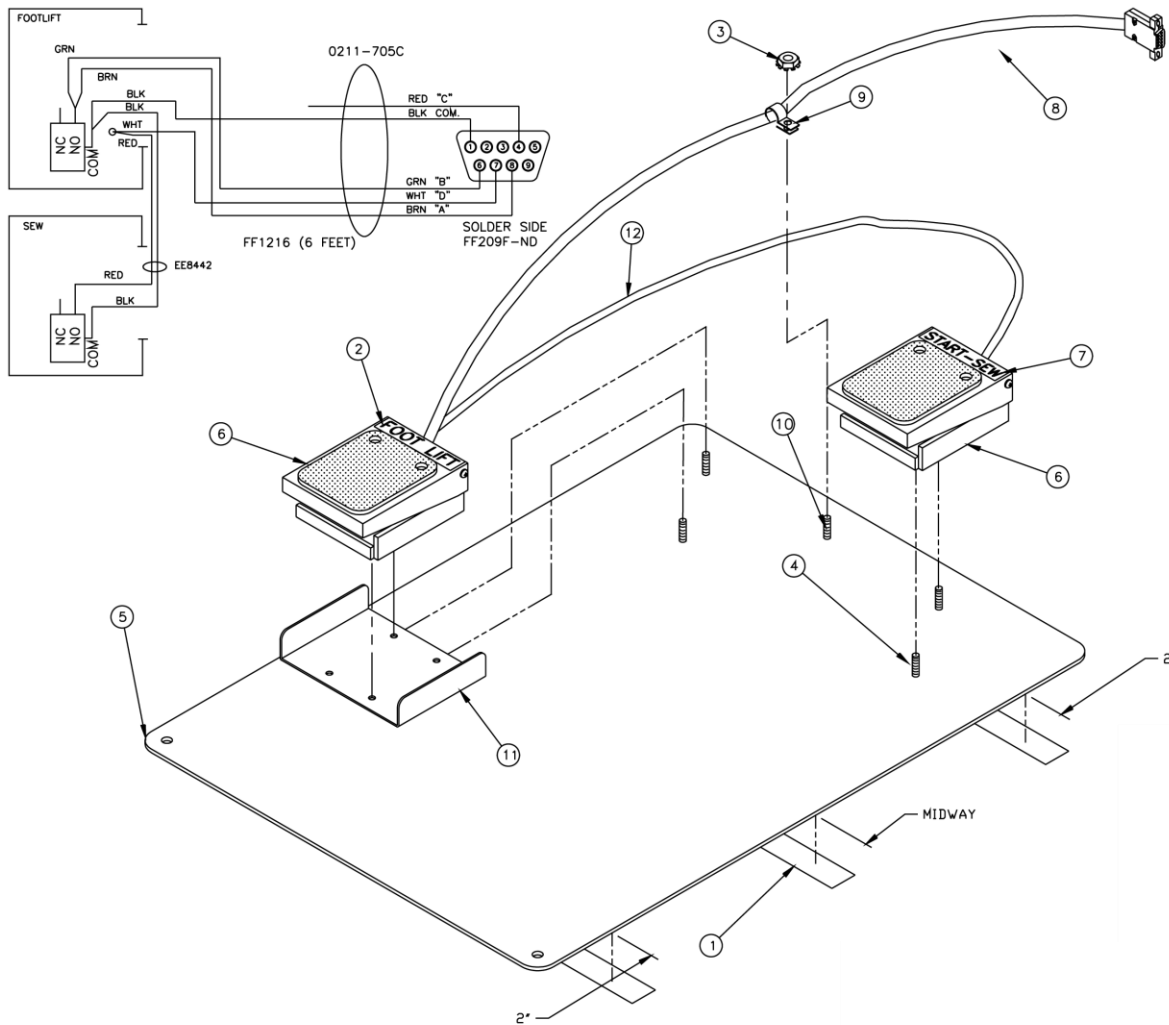


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778A-12 Roll Holder Assembly

AAC Drawing Number 298772C Rev0

NO.	QTY	PART #	DESCRIPTION
1	2	785-A9-12	Disc
2	1	780-101	Support Rod
3	1	A-U	Connector
4	1	273-4-407A	Support Rod
5	1	AA192-6A1	Mount
6	4	SSZH#10064	Screw, Sheet Metal
7	1	TTH32425	Threaded Handle

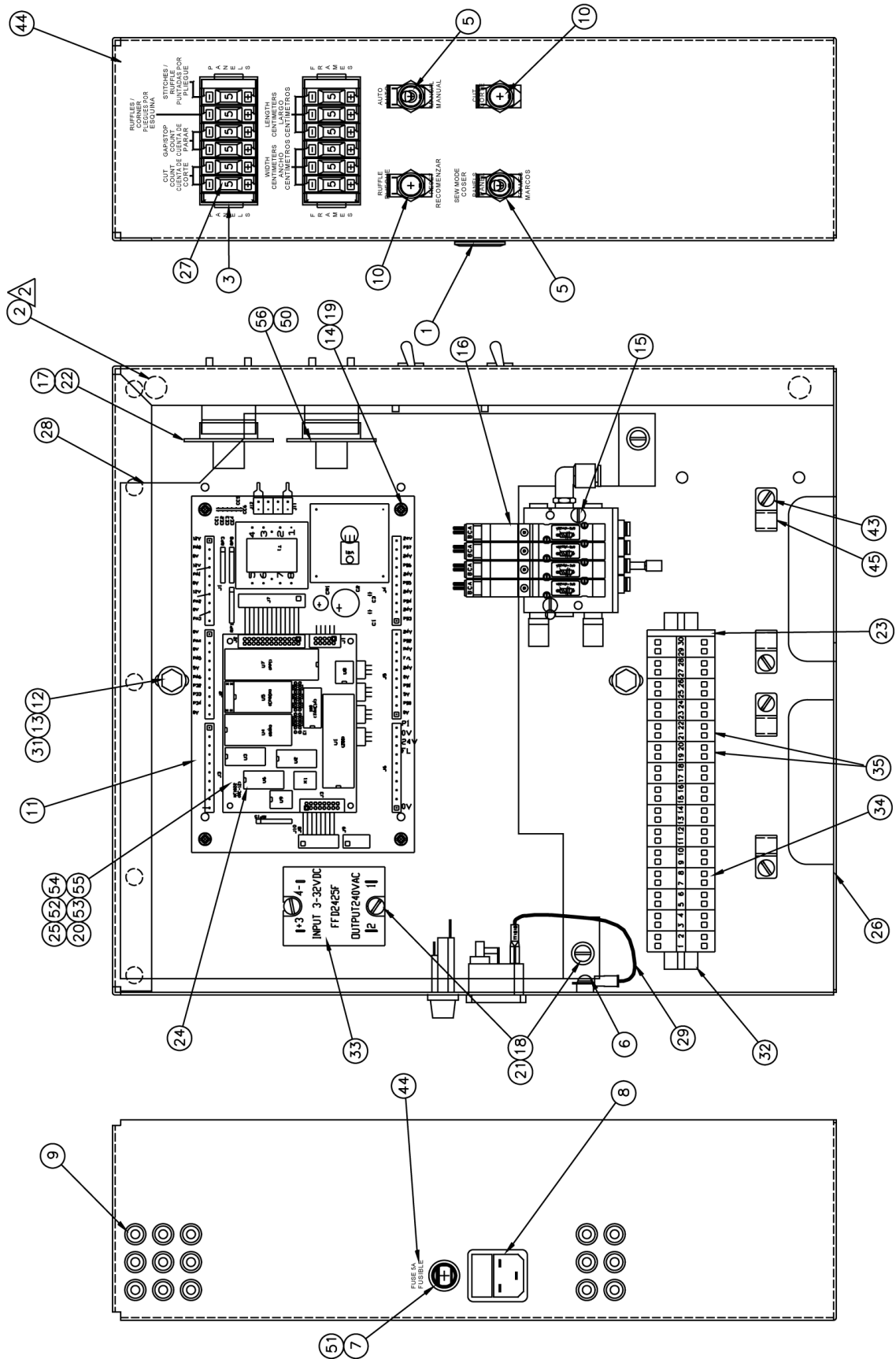


NOTE: THIS UNIT FOR USE WITH 1335MC TYPE UNITS ONLY. DO NOT PLUG DIRECTLY INTO EFKA CONTROL BOXES.

1278-6160E Foot Switch Assembly

AAC Drawing Number 192853C Rev2

NO.	QTY	PART #	DESCRIPTION
1	3'	MM6970T64	Abrasive Tape
2	AR	3844P-119B	Label
3	1	NNK6-32	Kep Nut
4	4	SSFC80016	Screw, Flat Allen
5	1	1278-5051B	Plate
6	2	1278-6161	Foot Pedal Mod.
7	AR	3844P-119A	Label
8	1	0211-705C	Cable
9	1	AAF3/8	Plastic Clamp
10	1	SSFC80024	Screw, Flat Allen
11	1	132556-010E	Guard
12	1	EE8442	Cable



From the library of: Diamond Needle Corp

1335MDS-500 Control Box Assembly

AAC Drawing Number 192873C Rev6

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	MM40450010	Slide Lock	32	1	FF264-3BKT8	Wago Mount
2	2	MMSLD-ECH	Bumper	33	1	FFD2425F	Solid State Relay
3	2	FFC5S1	End Cap	34	13	FF264-341	Dual Wago, Grey
4	1	1987149F	Cable	35	2	FF264-347	Dual Wago, Green
5	2	FF23F385	Toggle Switch	36	1	FF274-234	4 Pin Female Conn.
6	1	SSPS98016	Screw, Pan Head	37	2	0211-703	Cable
7	1	FF342838A	Fuse Holder	38	1	0211-705C	Cable
8	1	FF10ESB1C	Power Conn.	39	1	0211-705D	Cable
9	15	EESB-375-3	Heyco Bushing	40	3	0411-1906	Cable
10	2	FF23F118	Switch	41	1	1335MDS-WD2	Connection Diagram
11	1	1987-149JC	PC Board	42	1	1335MDS-WD1	Wiring Diagram
12	2	WWL1/4	Lock Washer	43	6	SSPS90024	Screw, Pan Head
13	2	SSH01032	Screw, Hex Cap	44	1	1335MDS-LAB	Label
14	4	SSPP80016	Screw, Pan Phillips	45	4	AAF1/8	Plastic Clamp
15	2	SSPS90080	Screw, Pan Head	46	1	AP-28-610U	Cable
16	1	AAE211E-4	Solenoid Assy	47	1	AP-28-612L	Cable
17	1	1987-513A	Cable	48	1	FF250LA40A	Varistor
18	3	WWFS10	Flat Washer	49	3	FFRK44T-4	Cable
19	4	FF67F4078	Threaded Spacer	50	1	1987-513B	Cable
20	4	FF89F2609	Spacer	51	1	FF313005	Fuse, 5A, Slow
21	3	SSPS98024	Screw, Pan Head	52	1	FF1035	Expander PCB
22	1	1987-517	PC Board	53	1	FF31-3-4	P.P.I. IC
23	1	FF264-371	Wago, End Cap	54	4	FF89F2608	Spacer
24	1	FF1035-04	PC Board	55	4	FF89F2610	Spacer
25	4	SSPS80144	Screw, Pan Head	56	1	1987-517B	PC Board
26	1	1335MDS-505	Control Box Weldment	57	1	1981A-273	Cable
27	12	FFC5.2LST1	Thumbwheel switches	58	1	1335MDS-510	Cable
28	1	1335MDS-501	Cover	59	1	1335MDS-PD	Pneumatic Diagram
29	1	1981A-511	Ground Wire	60	1	1987149F	Cable
30	2	EE37F3312	Power Cord	61	AR	FF1024A-PGM	POT Settings
31	2	WWFS1/4	Flat Washer				

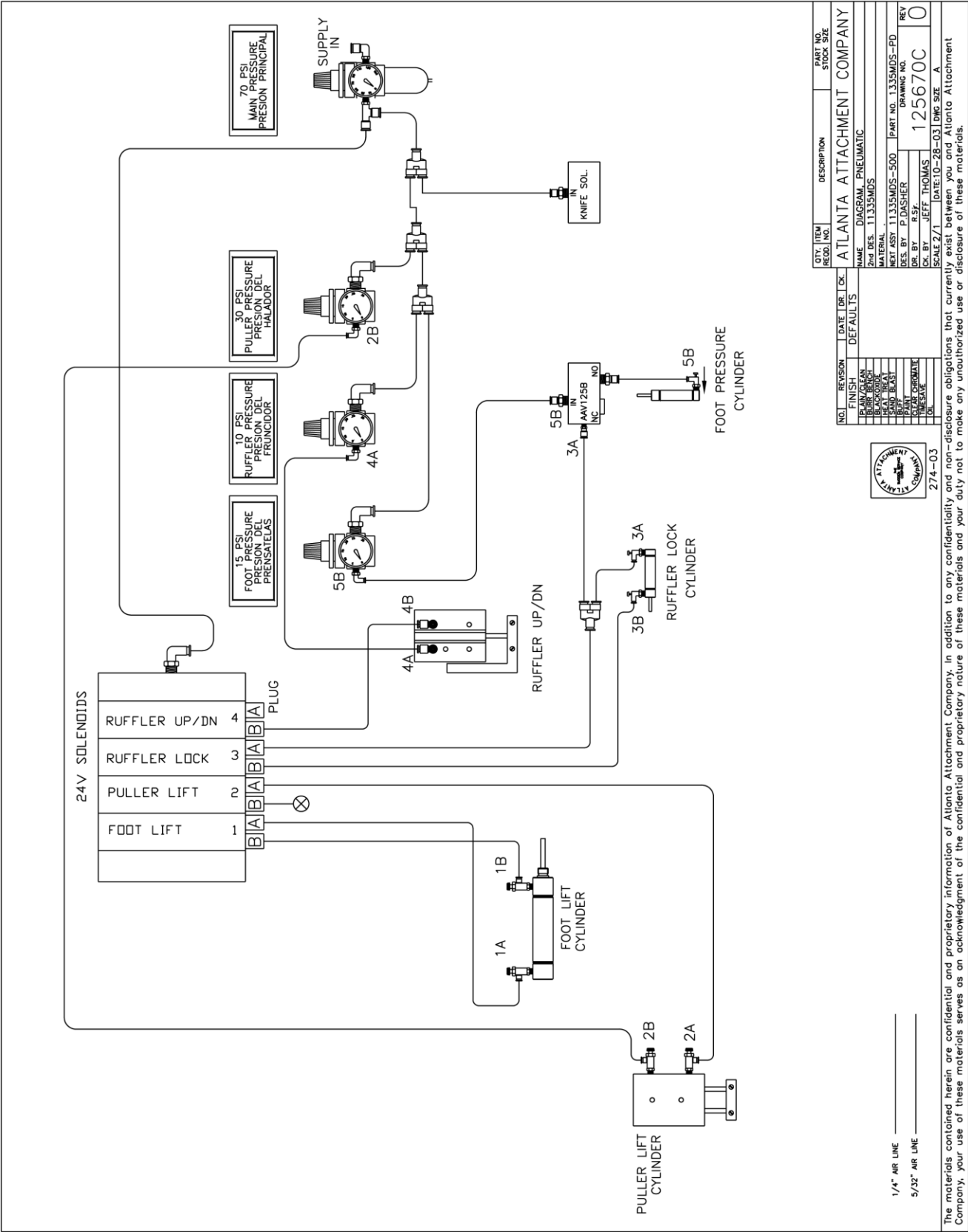
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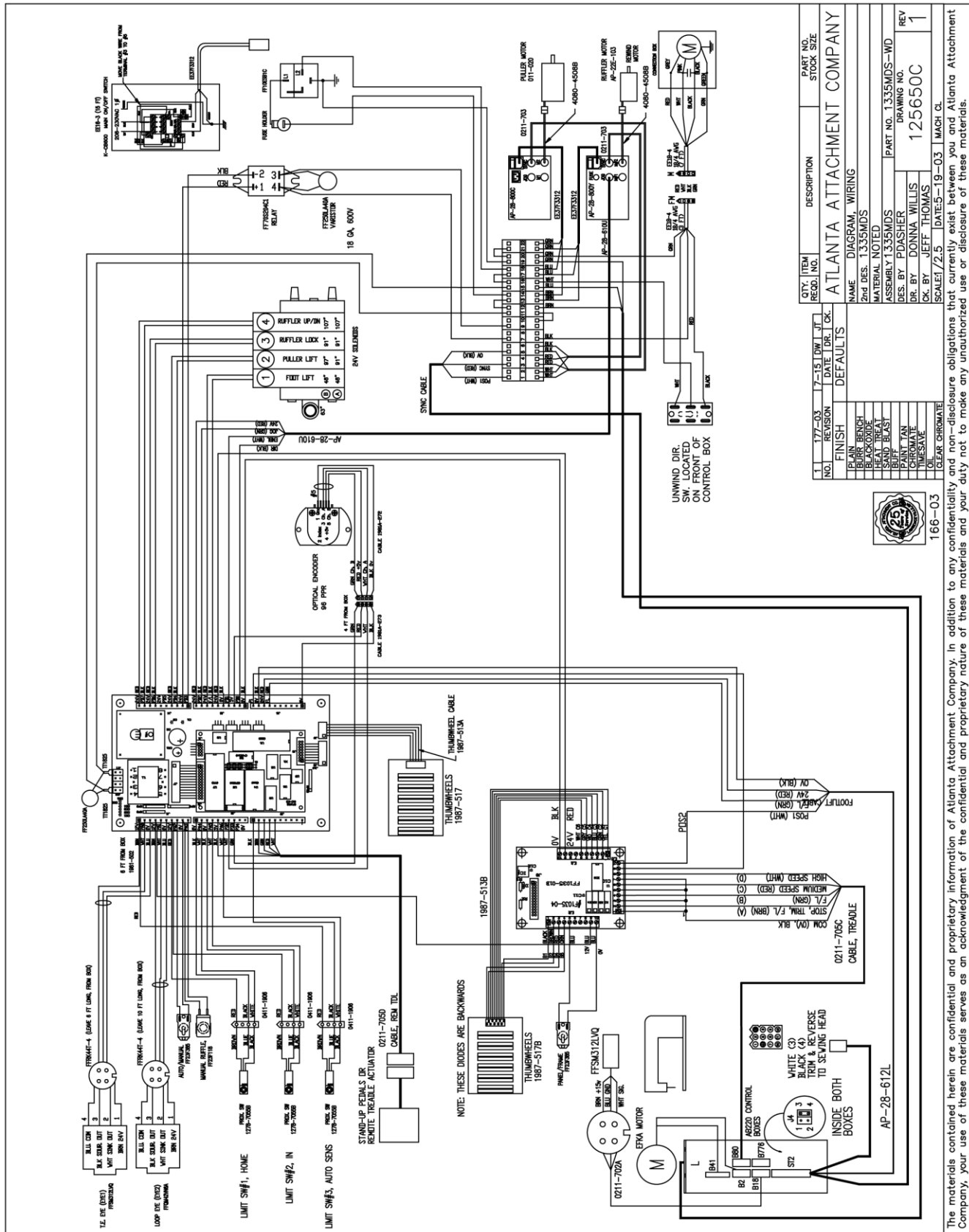
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1335MDS-PD Pneumatic Diagram



1335MDS-WD Wiring Diagram



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1335MDS-WD2 Connection Diagram

"SERGER RUN OUTPUT"



"RUN ENABLE INPUT"



NEW DRAWING
AWAITING DOCUMENTATION
SEE JERRY REVIS
mdasher 10-1-2003



235-03

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NO.	REVISION	DATE	DR.	CK.	DESCRIPTION	PART NO.	STOCK SIZE
	FINISH				ATLANTA ATTACHMENT COMPANY		
	PLAIN/CLEAN				NAME CONNECTION DIAGRAM		
	BURR BENCH				2nd DES. 1335MDS TO SERGER		
	BLACKOXIDE				MATERIAL		
	HEAT TREAT				NEXT ASSY.		
	SAND BLAST				SHEET METAL FAB		
	BUFF				X = ± .100		
	PAINT				.XX = ± .050		
	CLEAR CHROMATE				.XXX = ± .015		
	TIMESAVE				.XXXX = AS SPECIFIED		
	OIL				SCALE 1/1		
					DATE: 10-01-03		
					DWG SIZE: A		
					DES. BY P.DASHER		
					DR. BY MATT DASHER		
					CK. BY		
					PART NO. 1335MDS-WD2		
					DRAWING NO.		
					125576B		
					REV		
					0		

Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

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

Términos y Condiciones:

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

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

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



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