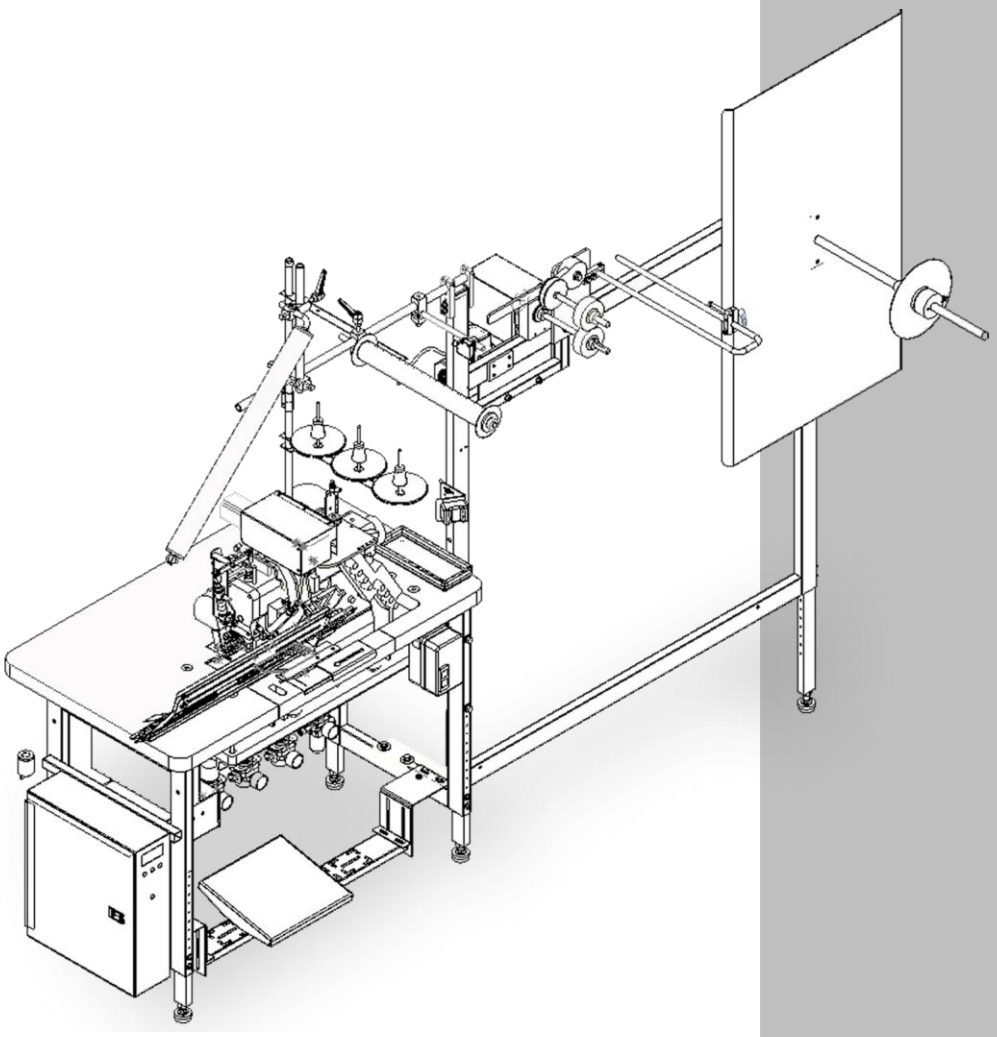
Model **1335MF**

Revision 5.1 Updated Jun 22, 2012

Technical Manual & Parts Lists



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Contents

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 1335MF Manual Pillowtop 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.

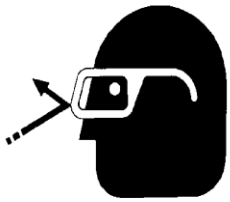
Faults or Errors

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 maintain a safe distance from people when operating.
- 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 leave machine unattended while machine is running.
- NEVER attempt to make any adjustments or repairs to the machine unless you have been properly trained.
- 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 Head:	Yamato VM1804P
Sewing Speed:	3500 RPM
Needle (Standard):	SN62X5721
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 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 Slow Blow 250v as necessary.

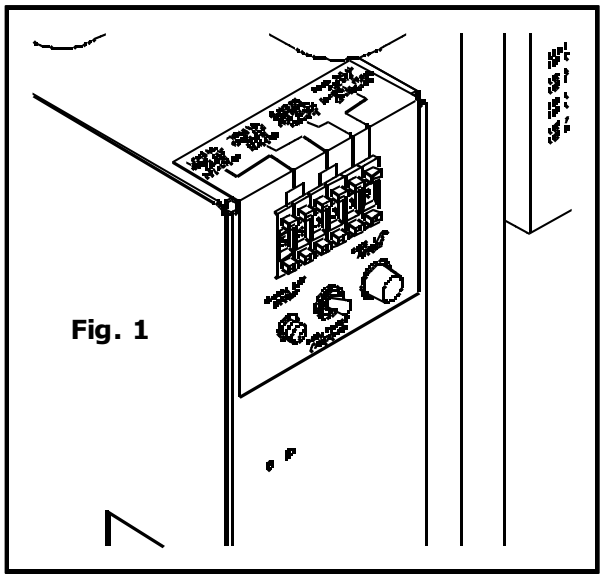


Fig. 1

Thumbwheels

The first 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 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".

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. 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 has two functions. When it is set to 1-7, 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 8 or 9 the ruffler will sew in "square corner" mode. In this mode, with the thumbwheel set to 8 the ruffler will sew to the corner, and make one ruffle while still sewing straight ahead. The ruffler will then stop and raise the presser foot. 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 then 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 set to 9, two ruffles will be created on each side of the corner instead of 1.

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

Stepper Control Boxes

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

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.

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.

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

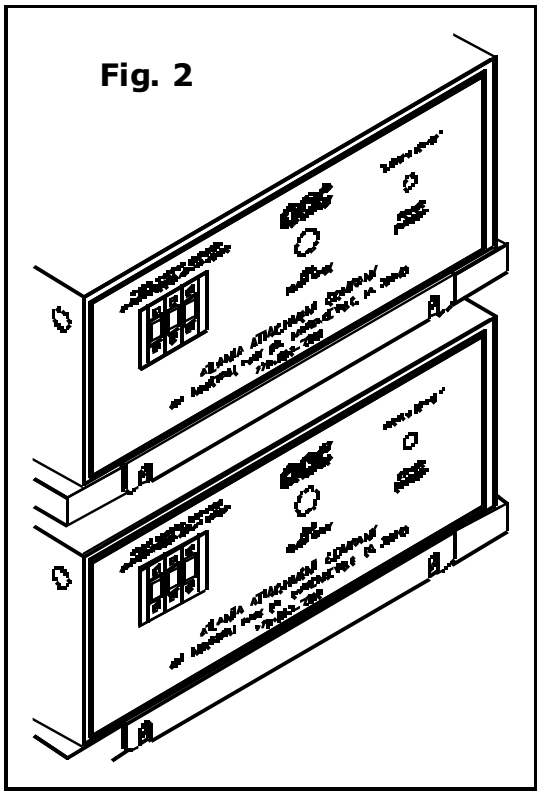


Fig. 2

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 at all times. 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).

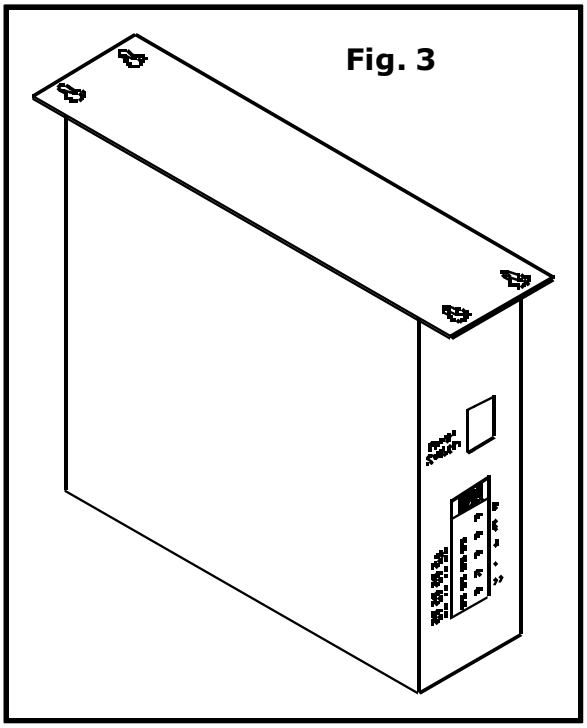


Fig. 3

Basic Machine Operation

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. 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)

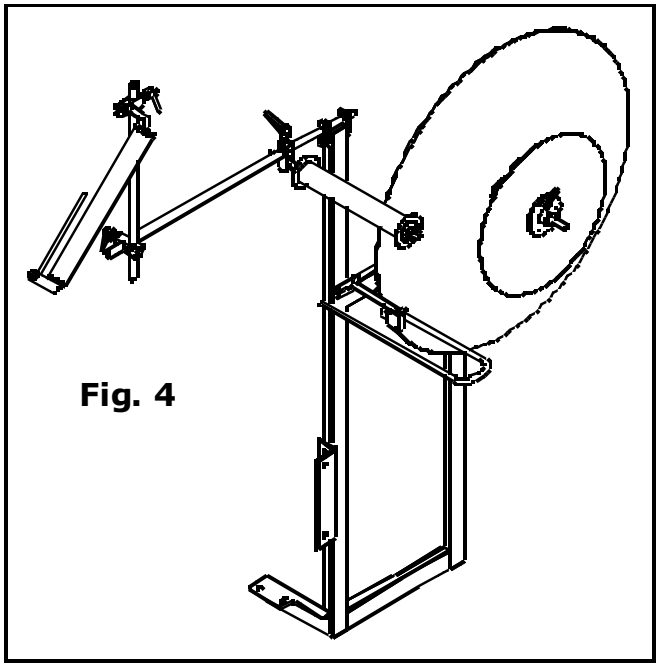


Fig. 4

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.

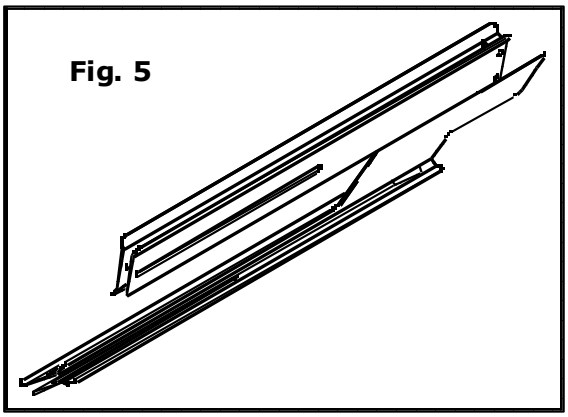


Fig. 5

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.

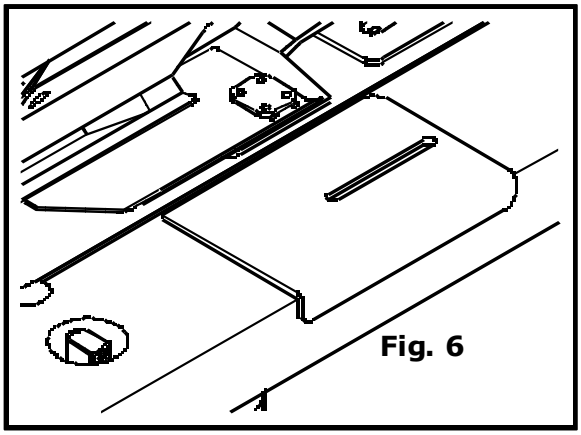


Fig. 6

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.

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 gear 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.

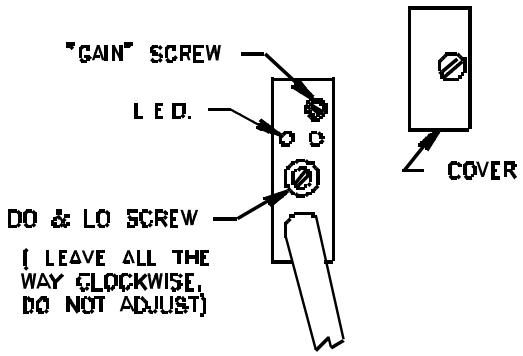
Weekly

- 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.

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.

11335MF 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 # SP1335MF Spare Parts Kit

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	ESCRIPTIO
1	1	1278-7055B	Prox Switch	5	1	GG169XL0	Gear Belt
2	2	1335M-2002C	Ruffler Blade	6	1	GG110XL7	Gear Belt
3	2'	EEFE-RR2	Reflective Tape	7	100	SN62X572	Needle
4	1	FFSM312LVQ	Electric Eye				

1335M EFKA Motor Parameter List

PARAMETER	RANGE	MITSUBISHI LOCHSTITCH	JUKI CHAINSTITCH	YAM 1804 CHAINSTITCH	YAM 2002 CHAINSTITCH	SING 300UX5 WALKING FOOT	1335M PARAMETER DESCRIPTION
Do this first	*****	****	****				Perform a master reset before programming, see below
290		0	5	5	5	5	Mode (Lockstitch) of operation. MUST SET THIS PARAMETER FIRST!
111	200-9900 rpm	400	400	350	320	250	Maximum speed when "129" is 0, 1, or 2.
153	0-50	--	--	--	--	35	Braking power at machine stand still
161	0-1	1	1	0	1	1	Motor rotation, 1=CCW
180	0-360 (175)	60	--	--	--	--	Degrees reverse run goes to get to needle up
181	0-999 (10)	01	--	--	--	--	Delay till reverse run starts after trim
182	0-1 (0)	1	0	0	0	0	Enable reverse run after trim to get to "true" needle up
202	0-500	50	50	500	500	500	Sew delay after foot lift off
219	1-55	35	--	--	35	35	Breaking power at stop
250	0-359	150	--	--	--	--	Thread trimmer activation angle
270	0-5	1	1	1	1	1	External handwheel sensor configuration. (Position 2)
271	0-255	180	180	165	165	165	Ref angle for Position 1 (Trim) from Position 2
272	020-255	100	100	100	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						**Programming Instructions:**
LED 2:	Off						1. Power on holding down the "P" button till "COD" is displayed.
LED 3:	Off						2. Press ">>" once and enter the number "311"
LED 4:	Off						3. Press "E" once and "2.0.0." is displayed this is a parameter
LED 5:	Off						4. Proceed to the parameter to be changed and press "E".
LED 6:	Off.						5. The value now shows in the screen, adjust to desired value.
LED 7:	ON, Stop at needle down.						6. Press "E" to enter value and continue with parameter setting.
LED 8:	OFF, Stop at needle up.						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	ASSLY#	PREFLANGED, OFFSETABLE, 6" CAPACITY A-2216K												PREFLANGED, OFFSETABLE, 9" CAPACITY A-2216L												CONTINENTAL BORDER, 18" CAPACITY A-2216M												
	PART#	DESC.	1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	1"	1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	1/8	3/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	1"
THRU HOLES	A-2216D40	L. GUIDE,1/8,KEYED,ALU	2												2											1											
	A-2216D32	L. GUIDE, 3/16,KEYED,ALU		2												2											1										
	A-2216D33	L. GUIDE, 1/4,KEYED,ALU			2												2										1		1								
	A-2216D34	L. GUIDE,5/16KEYED,ALU				2												2										1		1							
	A-2216D35	L. GUIDE,3/8,KEYED,ALU					2												2										1		1						
	A-2216D37	L. GUIDE,7/16,KEYED,ALU						2												2										1		1					
	A-2216D38	L. GUIDE,1/2,KEYED,ALU							2												2										1		1				
	A-2216D39	L. GUIDE,9/16,KEYED,ALU								2												2										1		1			
	A-2216D59	L. GUIDE,5/8,KEYED,ALU									2												2										1		1		
	A-2216D60	L. GUIDE,11/16,KEYED,ALU										2												2										1		1	
	A-2216D61	L. GUIDE,3/4,KEYED,ALU											2												2										1	1	2
	A-2216D65	R. GUIDE,7/8,KEYED,ALU																																			
	A-2216D30	L. GUIDE,1",KEYED,ALU																																			2
THREADED HOLES	A-2216D58	R. GUIDE,1/16,KEYED,THDED	2												2																						
	A-2216D51	R. GUIDE,1/8,KEYED,THDED		2												2											1										
	A-2216D52	R. GUIDE,3/16,KEYED,THDED			2												2										1		1							
	A-2216D53	R. GUIDE, 1/4,KEYED, THDED				2												2										1		1						
	A-2216D54	R. GUIDE,5/16,KEYED, THDED					2												2										1		1					
	A-2216D55	R. GUIDE,3/8,KEYED, THDED						2												2										1		1				
	A-2216D56	R. GUIDE,7/16,KEYED, THDED							2												2										1		1			
	A-2216D57	R. GUIDE,1/2,KEYED, THDED								2												2										1		1		
	A-2216D62	R. GUIDE,9/16,KEYED, THDED									2												2										1		1	
	A-2216D63	R. GUIDE,5/8,KEYED, THDED										2												2										1		1	
	A-2216D64	R. GUIDE,11/16,KEYED, THDED											2												2										1	1	2
THRU HOLES	A-2216G14	SPACER,1/16(2 HOLE)																																			
	A-2216G24	SPACER,1/8(2 HOLE)	2												2											1											
	A-2216G32	SPACER,3/16(2 HOLE)		2												2											1		1								
	A-2216G33	SPACER,1/4(2 HOLE)			2												2										1		1								
	A-2216G29	SPACER,5/16(2 HOLE)				2												2										1		1							
	A-2216G21	SPACER,3/8(2 HOLE)					2												2										1		1						
	A-2216G30	SPACER,7/16(2 HOLE)						2												2										1		1					
	A-2216G31	SPACER,1/2(2 HOLE)							2												2										1		1				
	A-2216G34	SPACER,9/16(2 HOLE)								2												2										1		1			
	A-2216G41	SPACER,5/8(2 HOLE)									2												2										1		1		
	A-2216G42	SPACER,11/16(2 HOLE)										2												2										1		1	
	A-2216G43	SPACER,3/4(2 HOLE)											2												2										1	1	2
	A-2216G36	SPACER,7/8"(2 HOLE)																																			
	A-2216G35	SPACER,1"(2 HOLE)																																			2
	SSBC08024	SCREW, 10-32 X 3/8																																			
	SSBC08032	SCREW, 10-32 X 1/2																																			
	SSBC08040	SCREW, 10-32 X 5/8	4	4											4	4										4	4										
	SSBC08048	SCREW, 10-32 X 3/4			4	4											4	4								2	2	4	4								
	SSBC08056	SCREW, 10-32 X 7/8					4	4											4	4								2	2	4	4						
	SSBC08064	SCREW, 10-32 X 1							4	4											4	4								2	2	4	4				
	SSBC08072	SCREW, 10-32 X 1-1/8									4												4									2	2	4			
	SSBC08036	SCREW, 10-32 X 1-1/2										4	4											4	4									2	6	6	
	1.5" WIDE GUIDES																																				8
	1335560	R. GUIDE,5/16,KEYED,ALU																																			
	1335561	R. GUIDE,3/8,KEYED,ALU																																			
	1335562	R. GUIDE,7/16,KEYED,ALU																																			
	1335640	R. GUIDE,1/2,KEYED,ALU																																			

Assembly Drawings & Parts Lists

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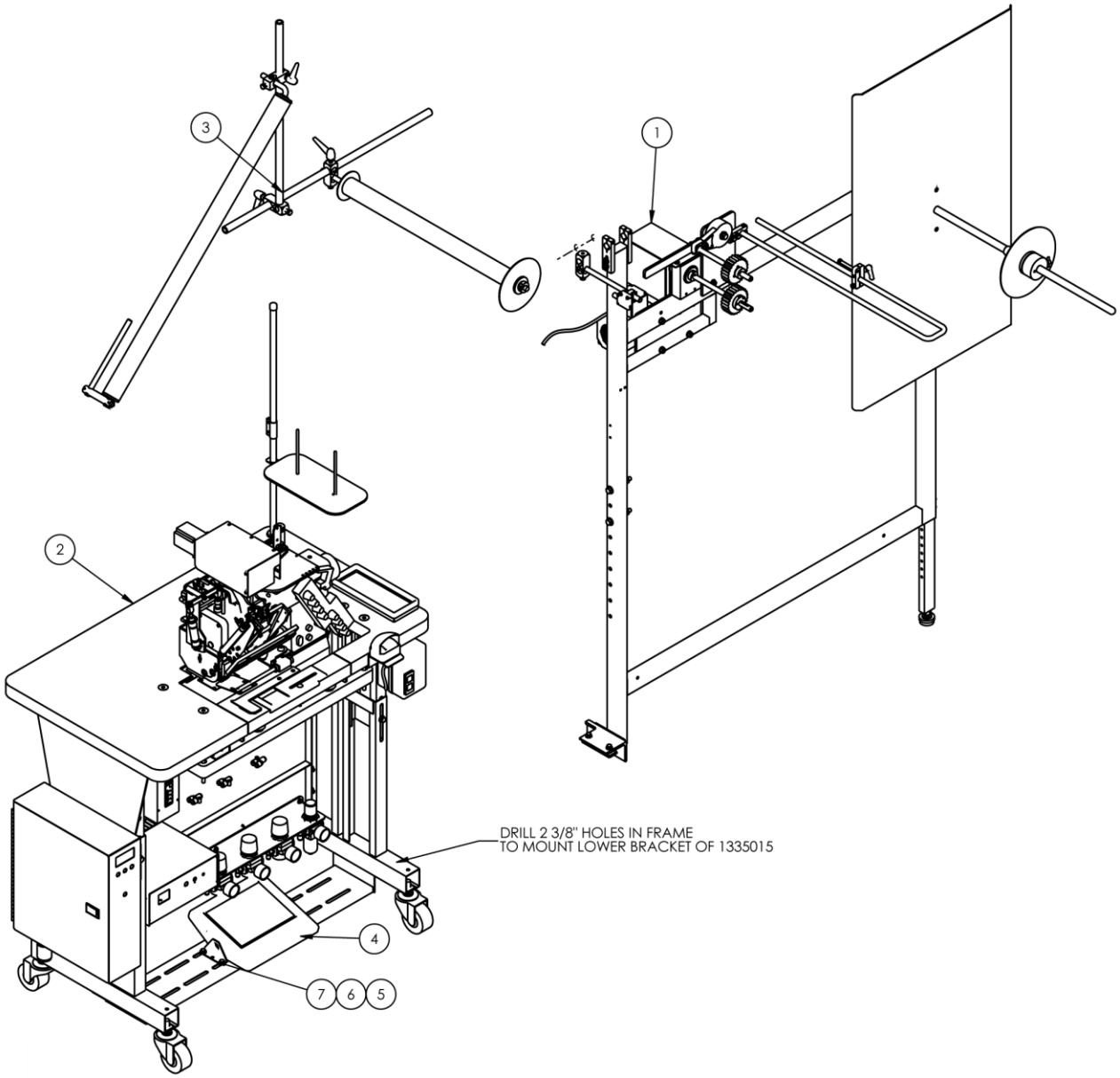
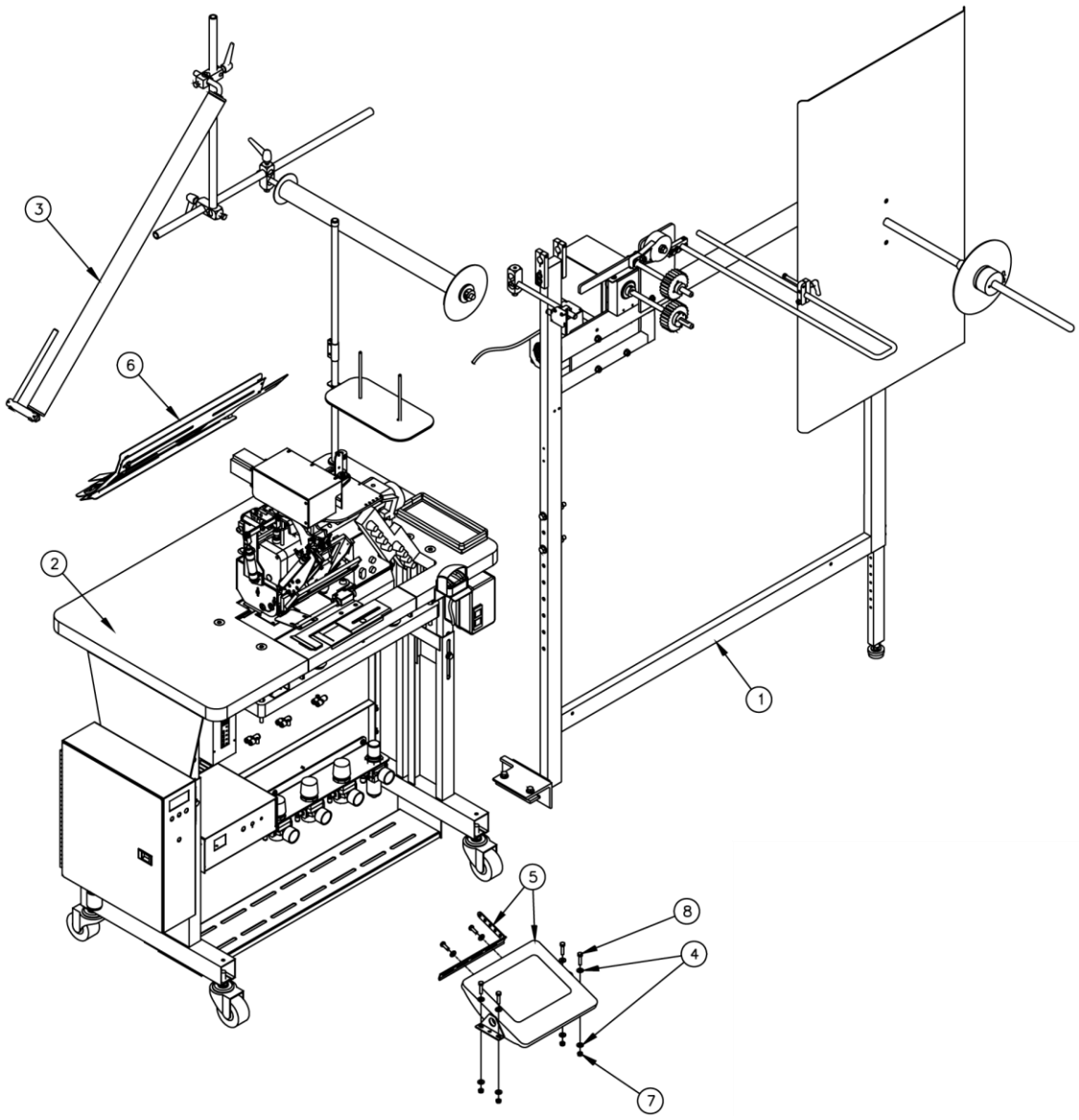


11335MFC Continental Foundation Ruffler

ACC Drawing Number 9000279 Rev10

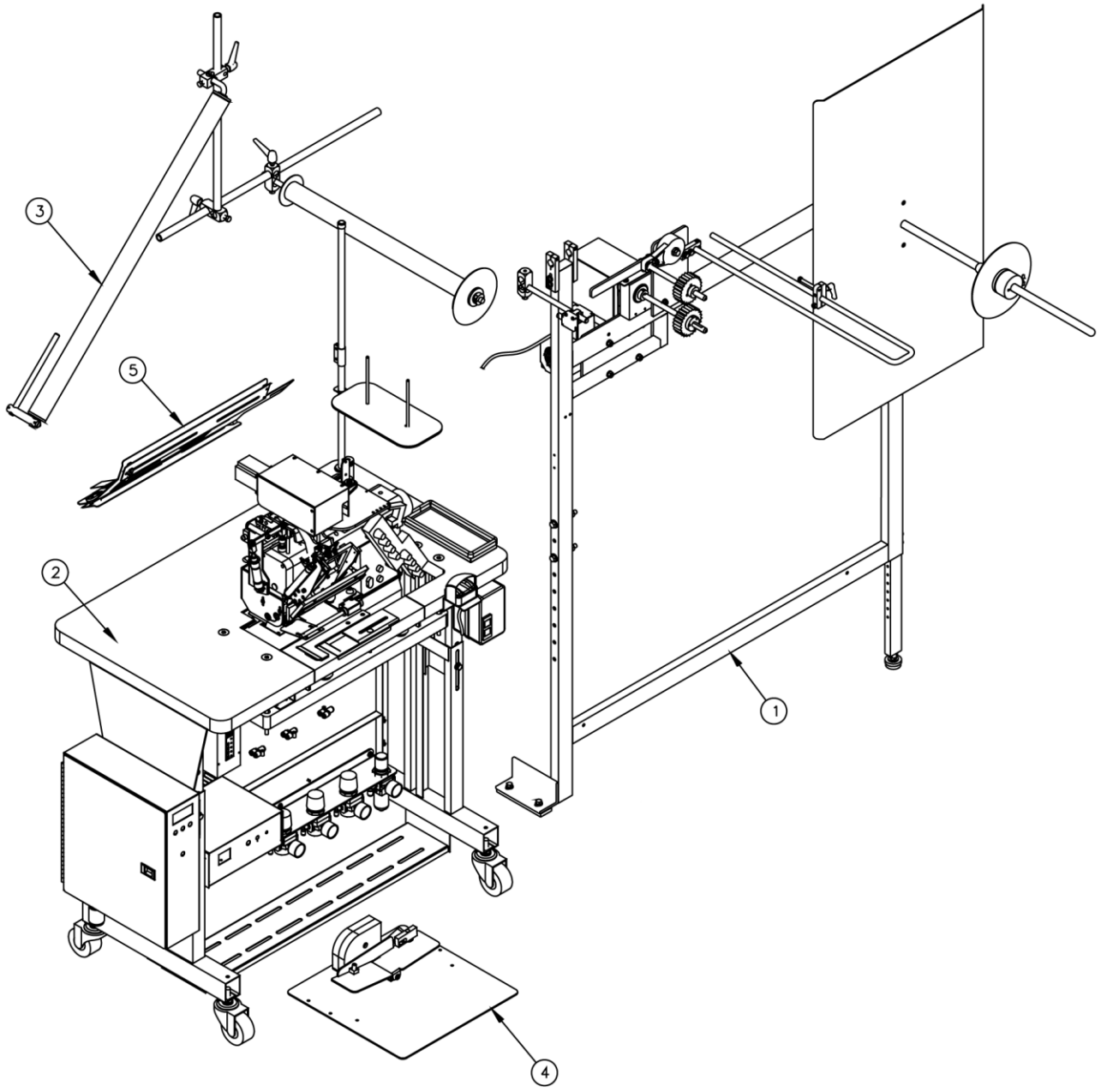
NO.	QTY	PART #	DESCRIPTION
1	1	1335105	UNWINDER ASSY (K3)
2	1	1335256	BASE CONSOLE
3	1	1335M-430E	GUIDE ROLLER ASSY
4	1	K-340	TREADLE W/BRACKETS
5	4	NNK1/4-20	KEP NUT, 1/4-20
6	4	SSHC01048	1/4-20 X 3/4 HEX HEAD
7	8	WWFS1/4	WASHER FLAT, 1/4



11335MFC-SD Continental Foundation Ruffler

ACC Drawing Number 192103B Rev2

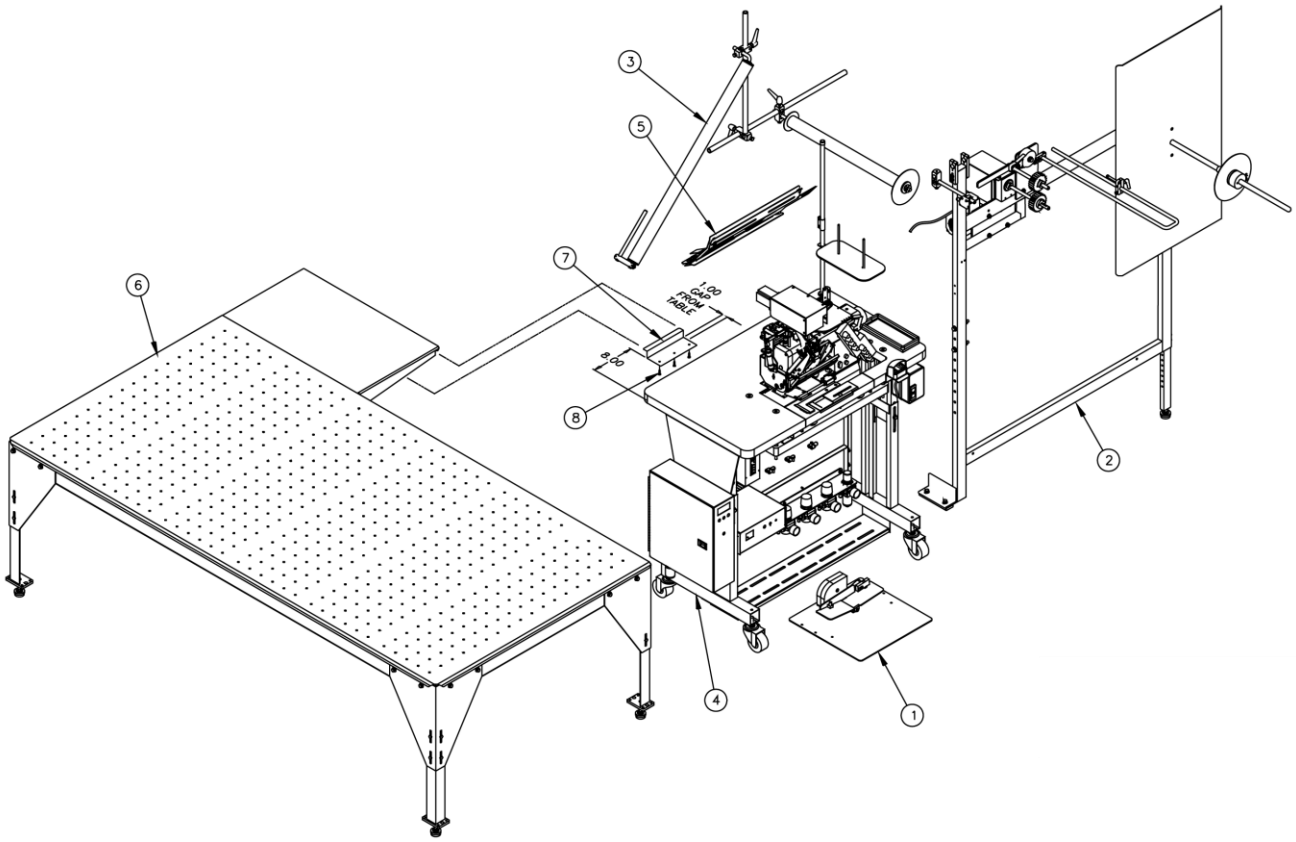
NO.	QTY	PART #	DESCRIPTION
1	1	1335105	Unwinder Assy.
2	1	1335256	Base Console
3	1	1335M-430E	Guide Roller Assy.
4	12	WWFS1/4	Flat Washer, SAE
5	1	A-2216M5/16	Folder
6	1	K-340	Foot Pedal
7	6	NNK1/4-20	Kep Nut
8	6	SSHC01048	Hex Cap Screw



11335MFC-SU Continental Foundation Ruffler

ACC Drawing Number 192072B Rev2

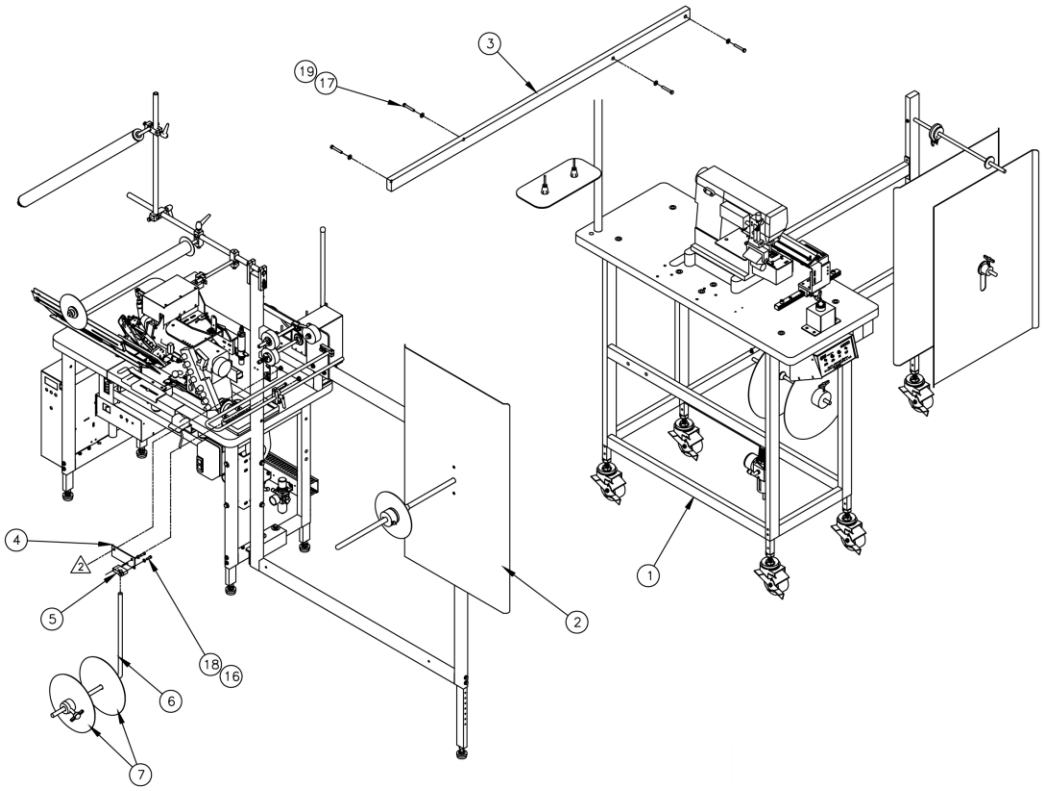
NO.	QTY	PART #	DESCRIPTION
1	1	1335105	Unwinder Assy.
2	1	1335256	Base Console
3	1	1335M-430E	Guide Roller Assy.
4	1	4059-FP301D	Foot Pedal
5	1	A-2216M5/16	Folder



11335MFC-SUAT Continental Ruffler, 16”

ACC Drawing Number 192954C Rev4

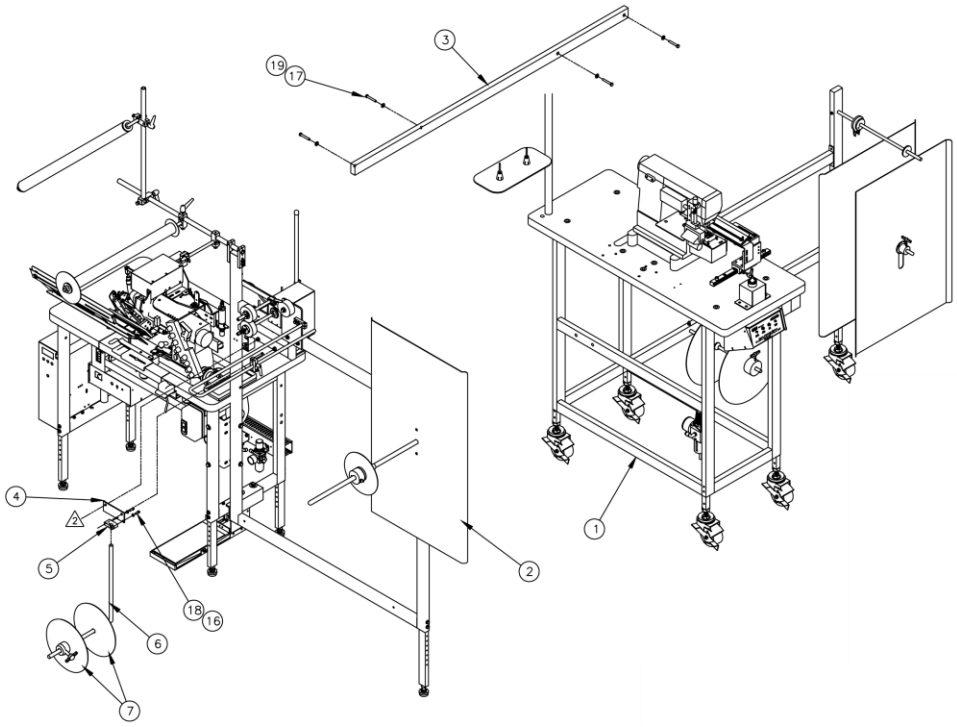
NO.	QTY	PART #	DESCRIPTION
1	1	4059-FP301D	Foot Pedal
2	1	1335105	Unwinder Assy.
3	1	1335M-430E	Guide Roller Assy.
4	1	1335256	Base Console Assy.
5	1	A-2216L5/16	Euro W/Flange Folder
12	1	11337AT	Air Table Assy.
13	1	1335081	Support Shelf
14	3	SSZH#10064	Sheet Metal Screw
15	10	SN62X5721	Needle size 21



11335MFC-34SD Manual Pillowtop Ruffler

ACC Drawing Number 192102B Rev1

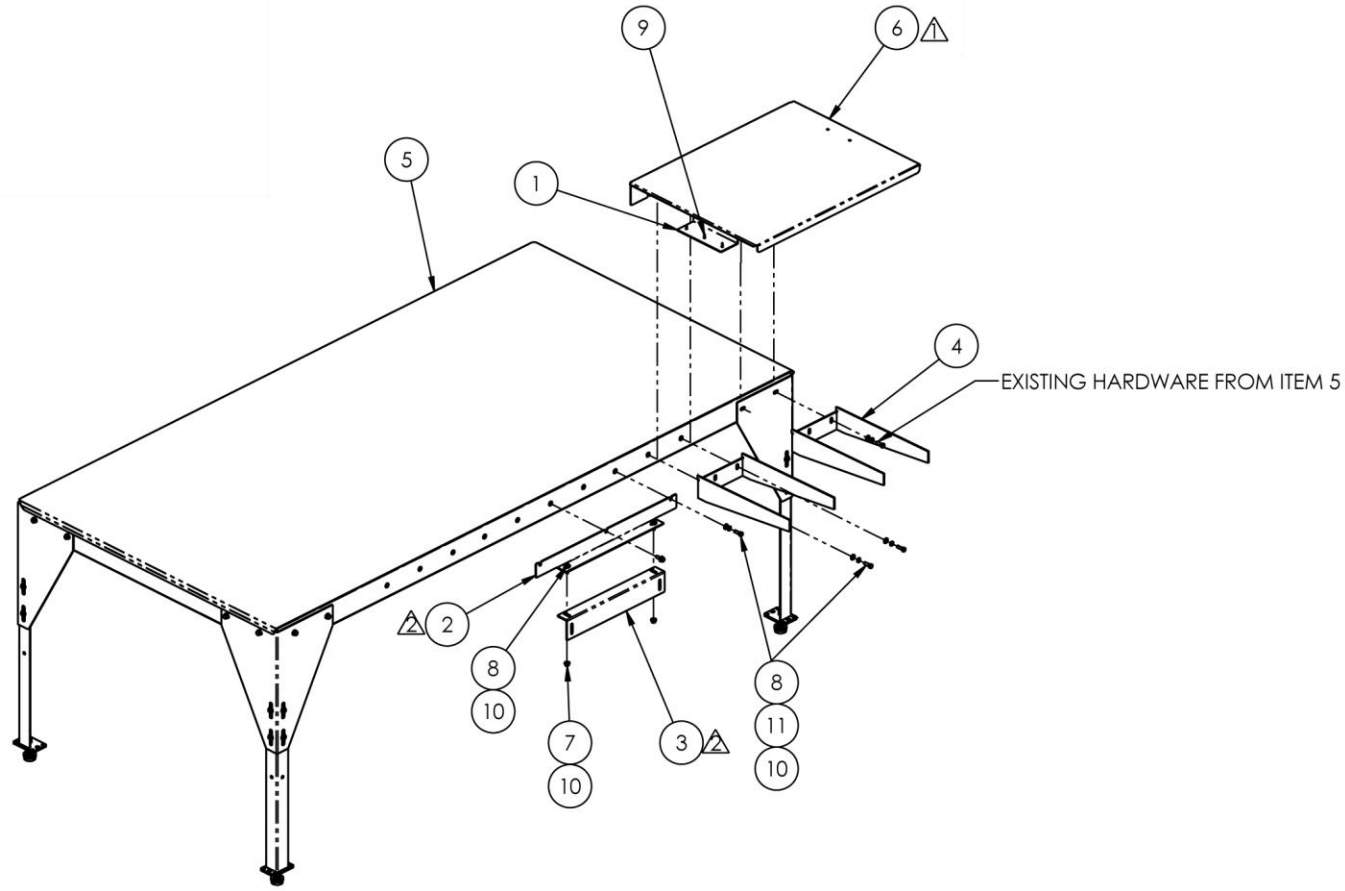
NO.	QTY	PART #	DESCRIPTION
1	1	1334S-02	Auto Flang Work Station
2	1	11335MFC-SD	Cont. Foundation Ruffler
3	1	1335-002	Joining Tube
4	1	1334035	Adaptor
5	1	320007	Rod Clamp
6	1	A-2212A	Bent Rod
7	2	785-A95-06	Disc Assy.
8	AR	1335M-03	Instructional
9	AR	1335MFC-34WD2	Wiring Diagram
10	1	4060-0652	PC Board
11	1	A-2216L5/16	Folder
12	AR	EP-1335M34	EPROM
13	4	FF67F4079	Spacer
14	3'	FF3251-2	Black Wire 22Ga
15	2'	FF8524-2	Red Wire 22Ga
16	2	WWL1/4	Lock Washer
17	4	SSHC10112	Hex Cap Screw
18	2	SSSC01040	Socket Cap Screw
19	4	WWF5/16	Flat Washer



11335MFC-34SU Manual Pillowtop Ruffler

ACC Drawing Number 192071B Rev4

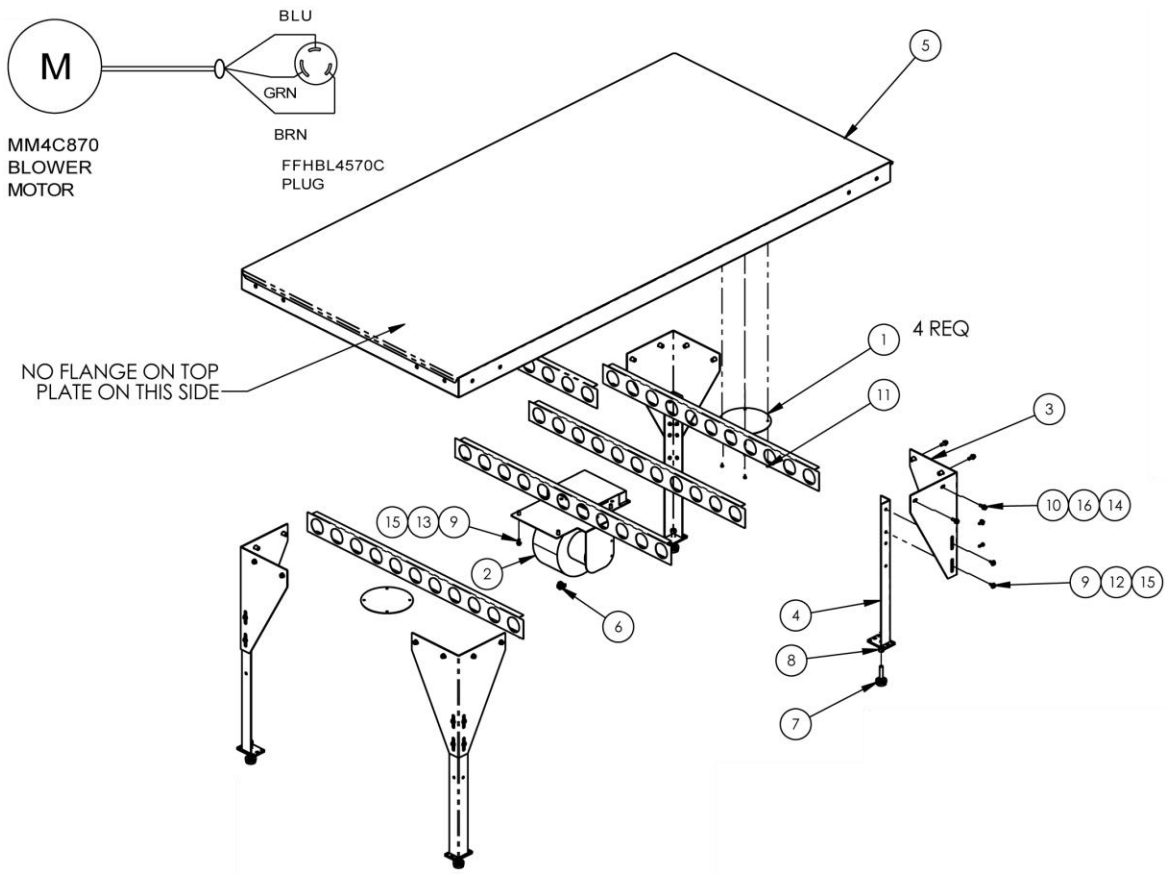
NO.	QTY	PART #	DESCRIPTION
1	1	1334S-02	Auto Flang Work Station
2	1	11335MFC-SD	Cont. Foundation Ruffler
3	1	1335-002	Joining Tube
4	1	1334035	Adaptor
5	1	320007	Rod Clamp
6	1	A-2212A	Bent Rod
7	2	785-A95-06	Disc Assy.
8	AR	1335M-03	Instructional
9	AR	1335MFC-34WD2	Wiring Diagram
10	1	4060-0652	PC Board
11	1	A-2216L5/16	Folder
12	AR	EP-1335M34	EPROM
13	4	FF67F4079	Spacer
14	3'	FF3251-2	Black Wire 22Ga
15	2'	FF8524-2	Red Wire 22Ga
16	2	WWL1/4	Lock Washer
17	4	SSHC10112	Hex Cap Screw
18	2	SSSC01040	Socket Cap Screw
19	4	WWF5/16	Flat Washer
20	1	1335M-2002E	Ruffler Blade
21	10	SN62X5721	Needle
22	10	SN11318GB	Needle



11337AT Air Table Assembly, Universal

ACC Drawing Number 1337293 Rev5

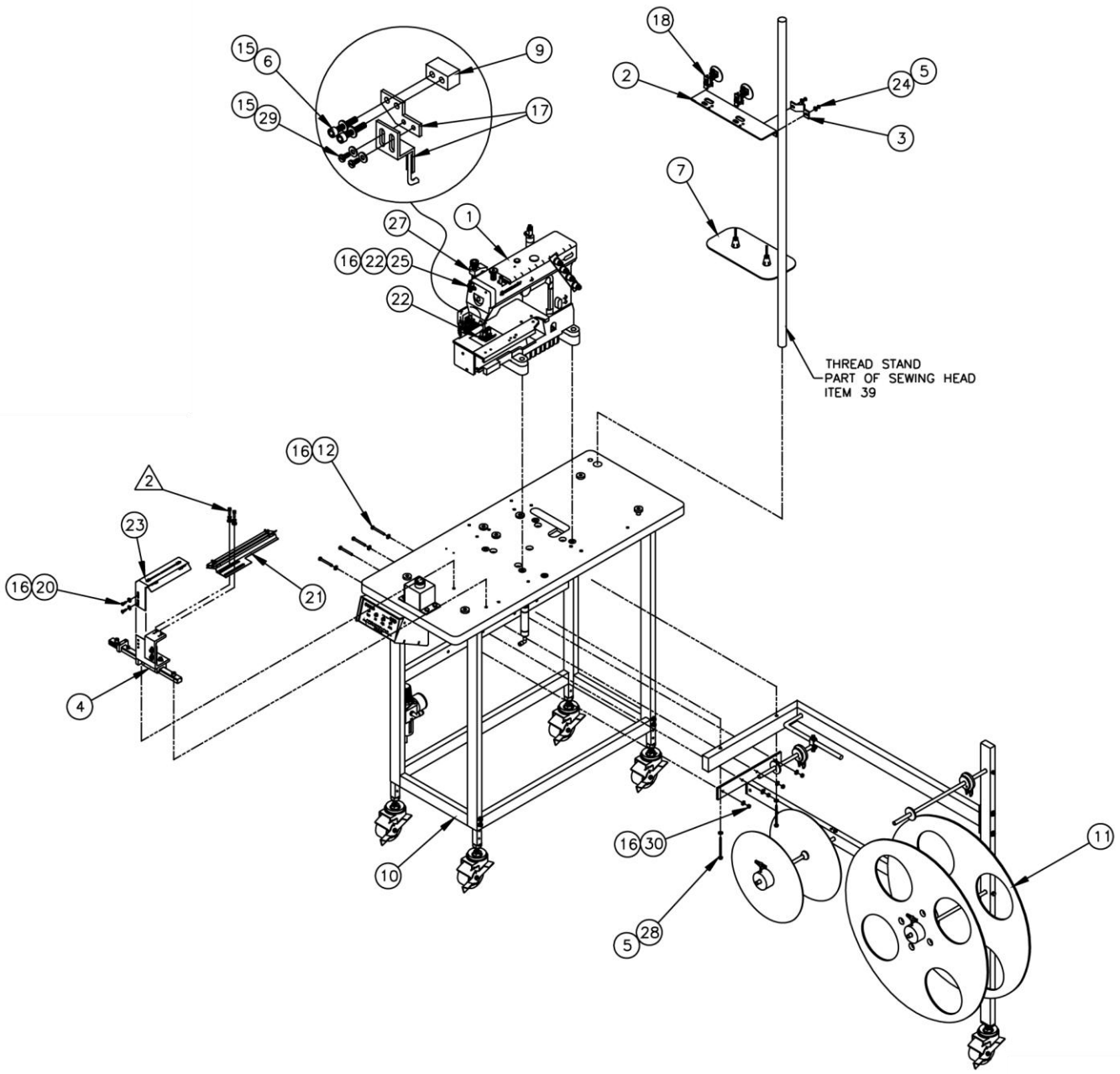
NO.	QTY	PART #	DESCRIPTION
1	1	1335081	SUPPORT, SHELF
2	AR	1337023	BRACKET, TABLE TOP RUFFLR
3	AR	1337024	MOUNT, AIR TABLE
4	2	1337A-0168B	BRACKET, RETAINER
5	1	1337A-160	AIR TABLE ASSY,SINGLE TBL
6	1	1337A-175C	SHELF, AIR TABLE,23"X30"
7	2	NNK5/16-18	KEP NUT, 5/16-18
8	6	SSHC10064	5/16-18 X 1" HEX HEAD
9	3	SSZH#10048	SCREW,SHT.METAL HEX 10
10	8	WWFS5/16	WASHER, FLAT, 5/16
11	4	WWL5/16	5/16 LW



1337A-160 Air Table Assembly, Single TBL

ACC Drawing Number 1337296 Rev7

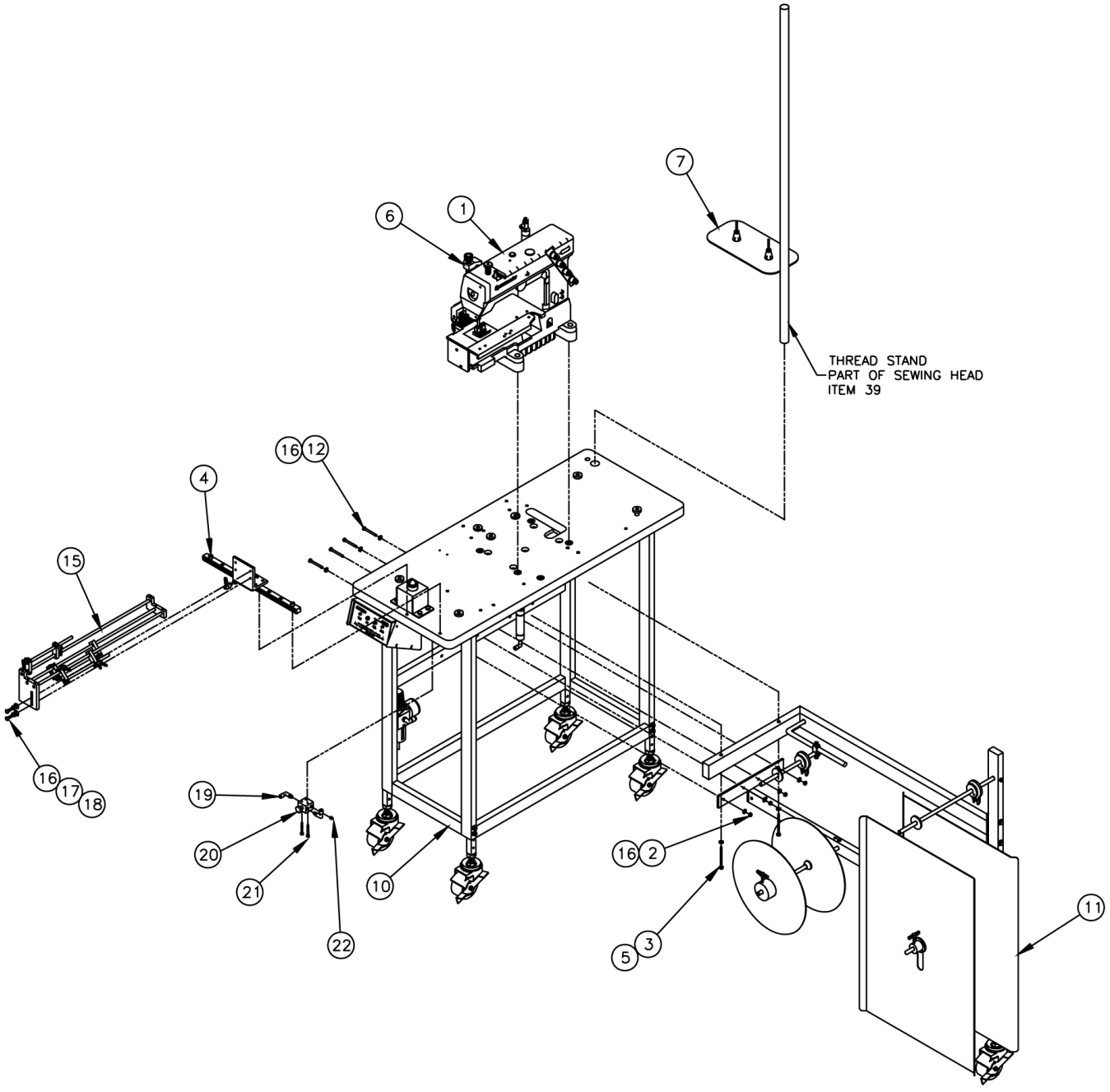
NO.	QTY	PART #	DESCRIPTION
1	4	1335-159	ACCESS COVER
2	1	1337135	BLOWER ASSY
3	4	1337A-0161	ANGLE, CORNER
4	4	1337A-0163	WELDMENT, LEG, TABLE
5	1	1337A-150	AIR TABLE ASSY
6	1	K-235	CONNECTOR,ROMEX,1/2"
7	4	MMFB4444	FOOT, RUBBER
8	4	NNH1/2-13	NUT,HEX,1/2-13
9	20	SSHC01048	1/4-20 X 3/4 HEX CAP
10	16	SSHC10064	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



1334S-01 Auto Flanging Workstation

ACC Drawing Number 192761C Rev4

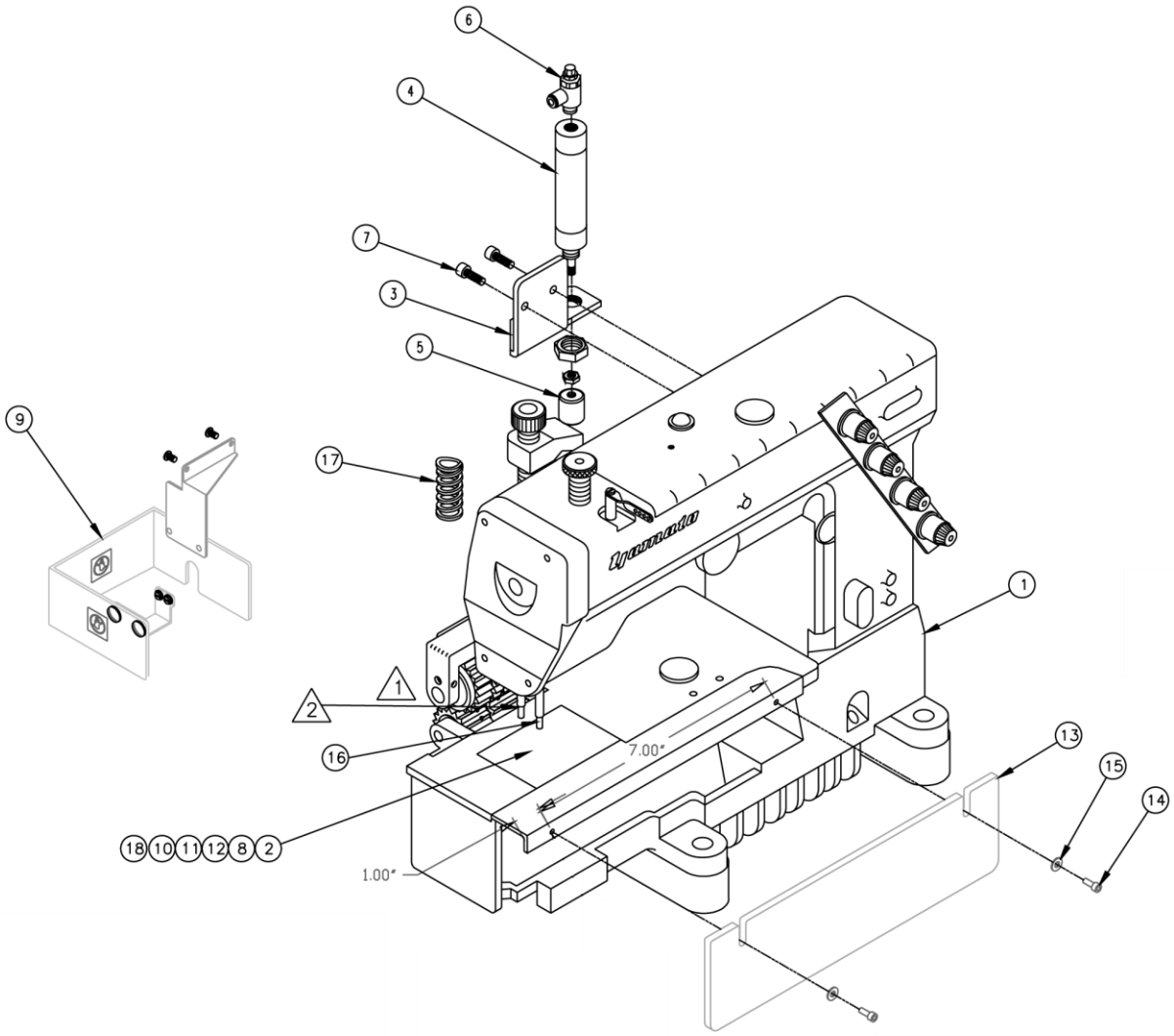
NO.	QTY	PART #	DESCRIPTION
1	1	1334-1000A	Sewing Head Assembly
2	1	0411-069B	THRD BRK BRKT
3	1	0411-070	Sens BRKT Clamp
4	1	1334-1100C	Folder Mount
5	4	WWFS10	Flat Washer
6	AR	WW000538	Washer
7	1	1959-112	2 Pos Thread Plate Assy.
8	1	1334-3011	Cable
9	1	1959-025	Spacer
10	1	1959-700A	Table & Frame
11	1	1959-800	Roll Holder
12	4	SSHC01128	Hex Cap Screw
13	AR	1959-PD	Pneumatic Diagram
14	AR	1334S-01WD	Wiring Diagram
15	AR	SSSCM4X20	Socket Cap Screw
16	12	WWFS1/4	Flat Washer
17	1	3151010	Wiper
18	2	4003-IS3WT2	Sensor
19	1	4003-MA3/FE	Cable
20	2	SSSC01048	Socket Cap Screw
21	1	661-A18-5/16	Folder
22	2	SSSCM6X20	Socket Cap Screw
23	1	661-A19	ADJ Flange Guide
24	2	SSPS98024	Pan Head Slotted Screw
25	1	AA2000F-03	Flow Control
26	1	AATPWL1	Wire Loom
27	1	RRLC105J10	Spring
28	2	SSZH#10192	Hex Sheet Metal Screw
29	AR	SSM110009	THRT PLT Screw
30	4	NNK1/4-20	Kep Nut



1334S-02 Auto Flanging Workstation

ACC Drawing Number 192070B Rev2

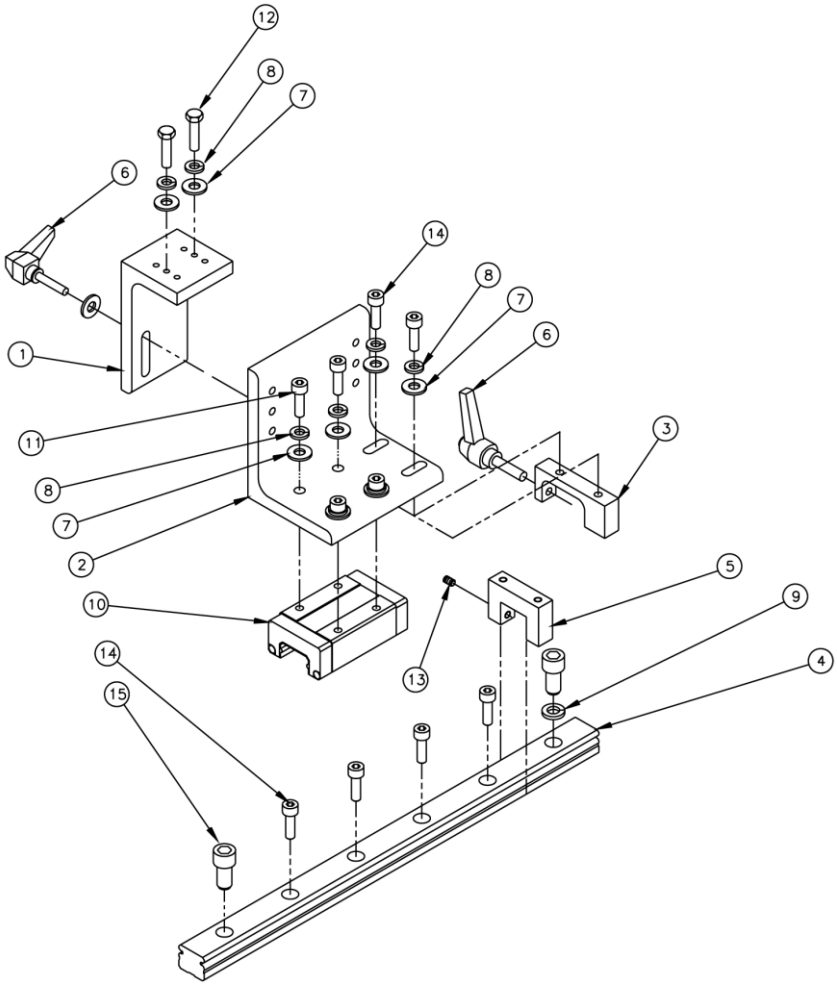
NO.	QTY	PART #	DESCRIPTION
1	1	1334-1000A	Sewing Head Assy
2	4	NNK1/4-20	Kep Nut
3	2	SSZH#10192	Hex Sheet Metal Screw
4	1	1334-1100D	Folder Mount
5	2	WWFS10	Flat washer
6	1	RRLC105J10	Spring
7	1	1959-112	2 POS Thread Plate Assy
8	1	1334-3012	Cable
9	1	AATPWL1	Wire Loom
10	1	1959-700B	Table & Frame
11	1	1959-800	Roll Holder
12	4	SSHC01128	Hex Cap Screw
13	AR	1959-PD	Pneumatic Diagram
14	AR	1334S-02WD	Wiring Diagram
15	1	1334-1200A	Material Guide
16	10	WWFS1/4	Flat washer
17	2	SSHC0164	Hex Cap Screw
18	2	WWL1/4	Lock Washer
19	2	AAQME-5-8	Quick Male Elbow
20	1	AAVMB43	Valve
21	2	SSZH#6096	Hex Screw
22	1	MM4554K11	Pipe Plug 1/8



1334-1000A Sewing Head Detail

ACC Drawing Number 192557C Rev3

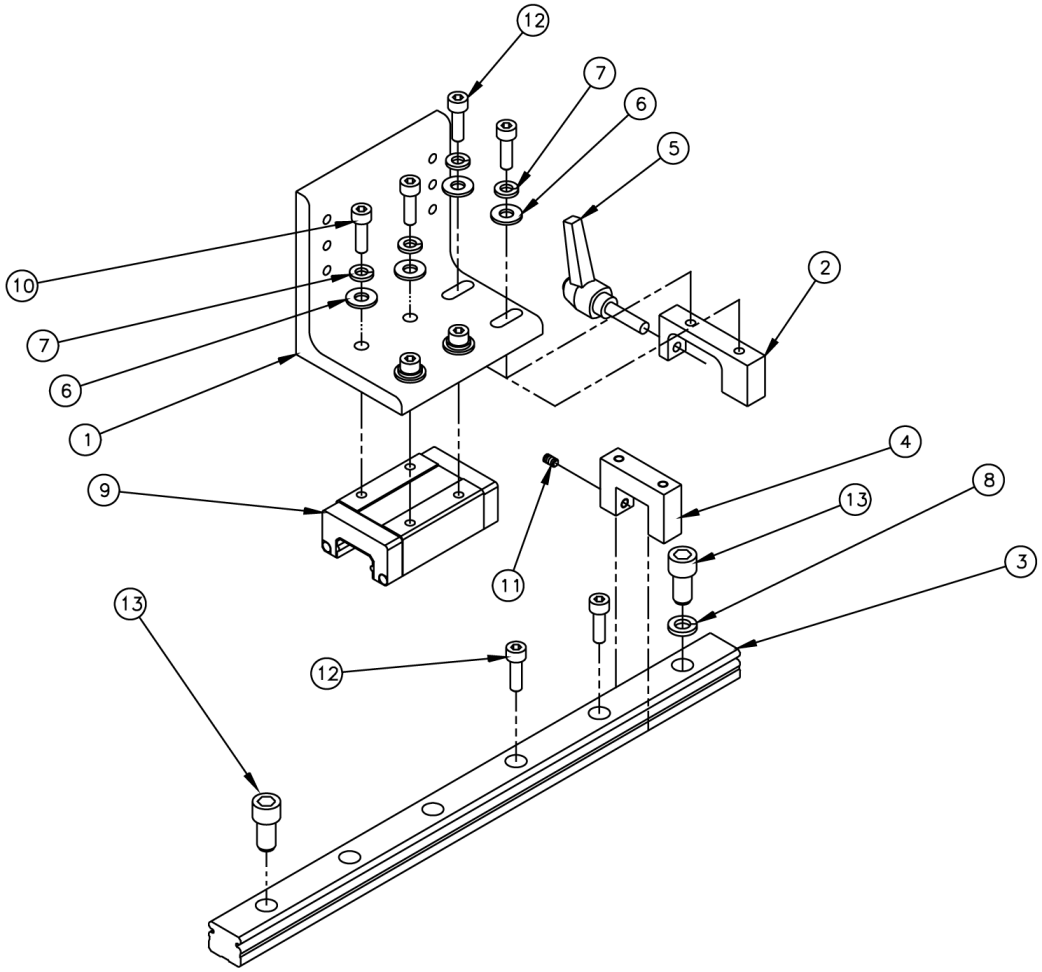
NO.	QTY	PART #	DESCRIPTION
1	1	SYAM-1804A	Yamato Sew Head
2	1	1862N94016	Needle Holder
3	1	112013	Brkt
4	1	AAC6S-1-H	Air Cylinder
5	1	11200A	Bumper
6	1	AA198RR508	Flow Control
7	2	SSSCM6X20	Screw, Socket Cap
8	1	54242B9016	Spreader
9	1	1959-412	Guard
10	1	54205A9016	Feed Dog
11	1	54420X9016	Presser Foot
12	1	54224A9016	Throat Plate
13	1	1334041	Guard
14	2	SSSC98032	Screw, Socket Cap
15	2	WWFS10	Flat Washer
16	1	3300012M	Needle Bar Mod
17	1	RRLC105J10	Puller Spring
18	1	1862N95016	Looper Holder
19	10	SN11318GB	Needle, Sys UY113,size 18



1334-1100C Flanger Folder Mount Assembly

ACC Drawing Number 192901C Rev2

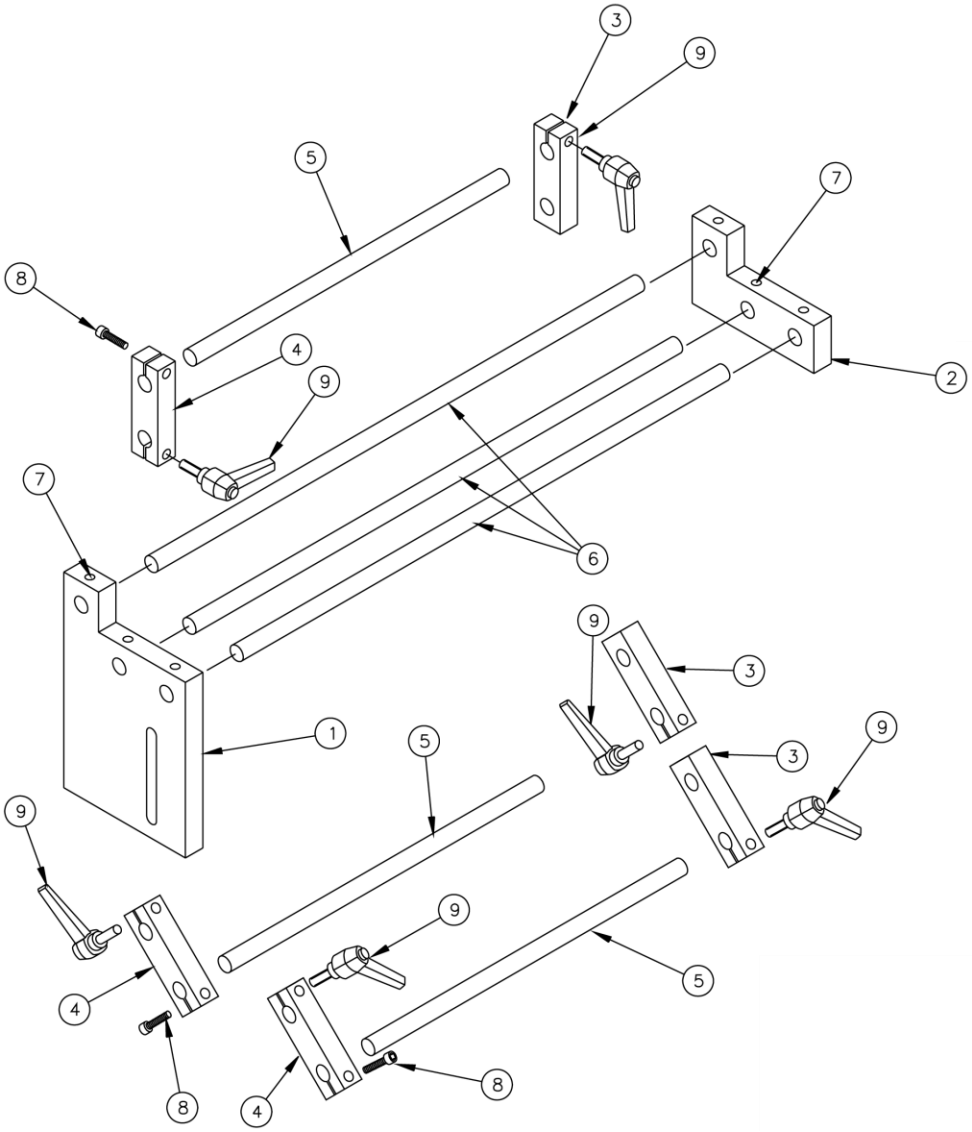
NO.	QTY	PART #	DESCRIPTION
1	1	1334-1003	Adj. Mount
2	1	1334-1005	Lower Angle Mount
3	1	1334-1006	Lock Handle Mount
4	1	MMAGR25360M	Rail
5	1	1335-310	Stop Block
6	2	TTH32416	Threaded Handle
7	10	WWFS1/4	Flat Washer
8	10	WWL1/4	Lock Washer
9	1	WWL3/8	Lock Washer
10	1	MMAGH25CAN	Bearing Block
11	4	SSSCM6X20	Screw, Socket Cap
12	2	SSHC01040	Screw, Socket Cap
13	1	SSSS98032	Screw, Socket Set
14	6	SSSC01048	Screw, Socket Cap
15	2	SSSC25048	Screw, Socket Cap



1334-1100D Flanger Folder Mount Assembly

ACC Drawing Number 192929C Rev1

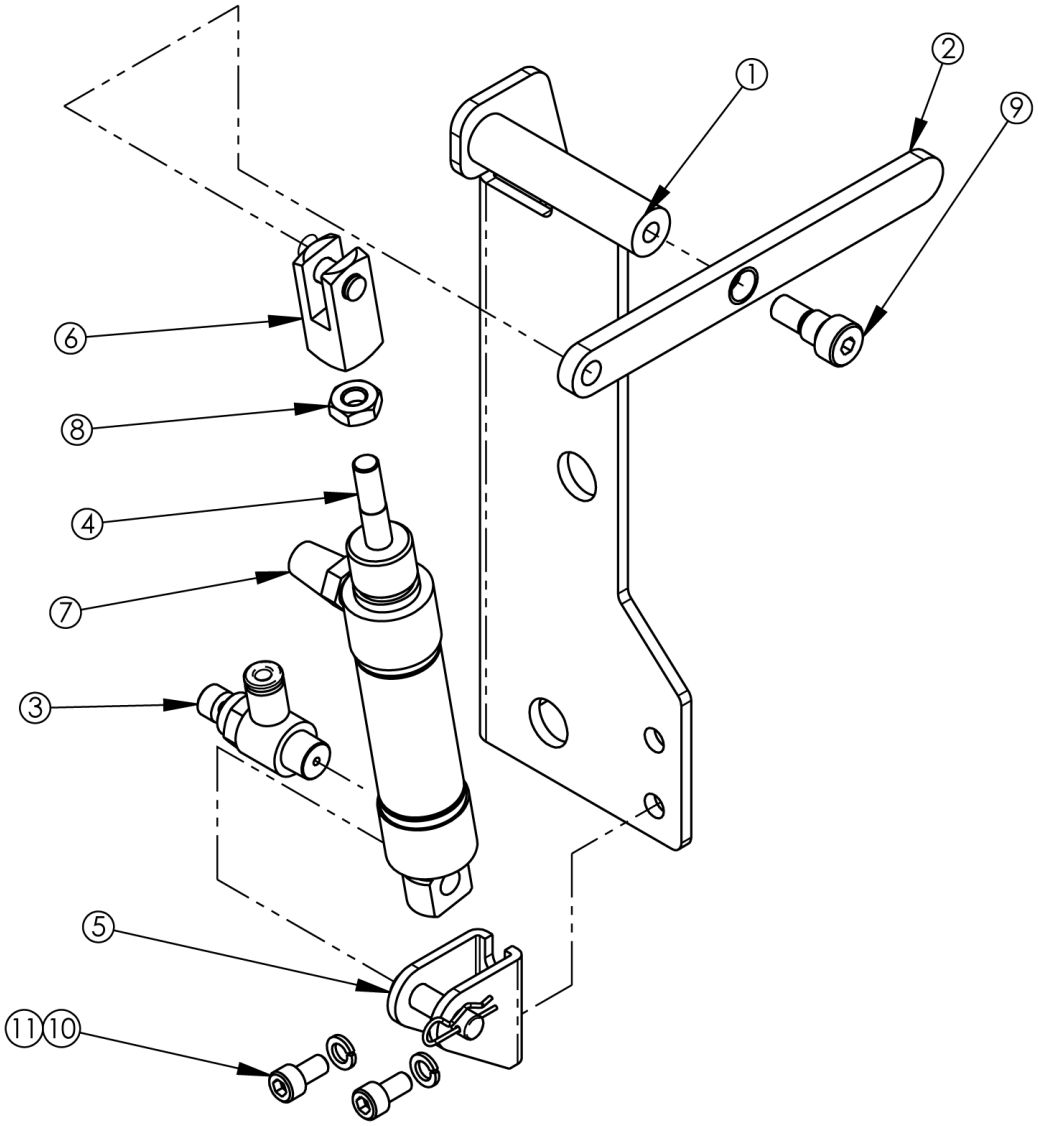
NO.	QTY	PART #	DESCRIPTION
1	1	1334-1005	Lower Angle Mount
2	1	1334-1006	Lock Handle Mount
3	1	MMAGR25360M	Linear Rail
4	1	1335-310	Stop Block
5	1	TTH32416	Threaded Handle
6	6	WWFS1/4	Flat Washer
7	6	WWL1/4	Lock Washer
8	1	WWL3/8	Lock Washer
9	1	MMAGH25CAN	Bearing Block
10	4	SSSCM6X20	Screw, Socket Cap
11	1	SSSS98032	Screw, Socket Set
12	4	SSSC01048	Screw, Socket Cap
13	2	SSSC25048	Screw, Socket Cap



1334-1200A Material Guide Assembly

ACC Drawing Number 192092B Rev0

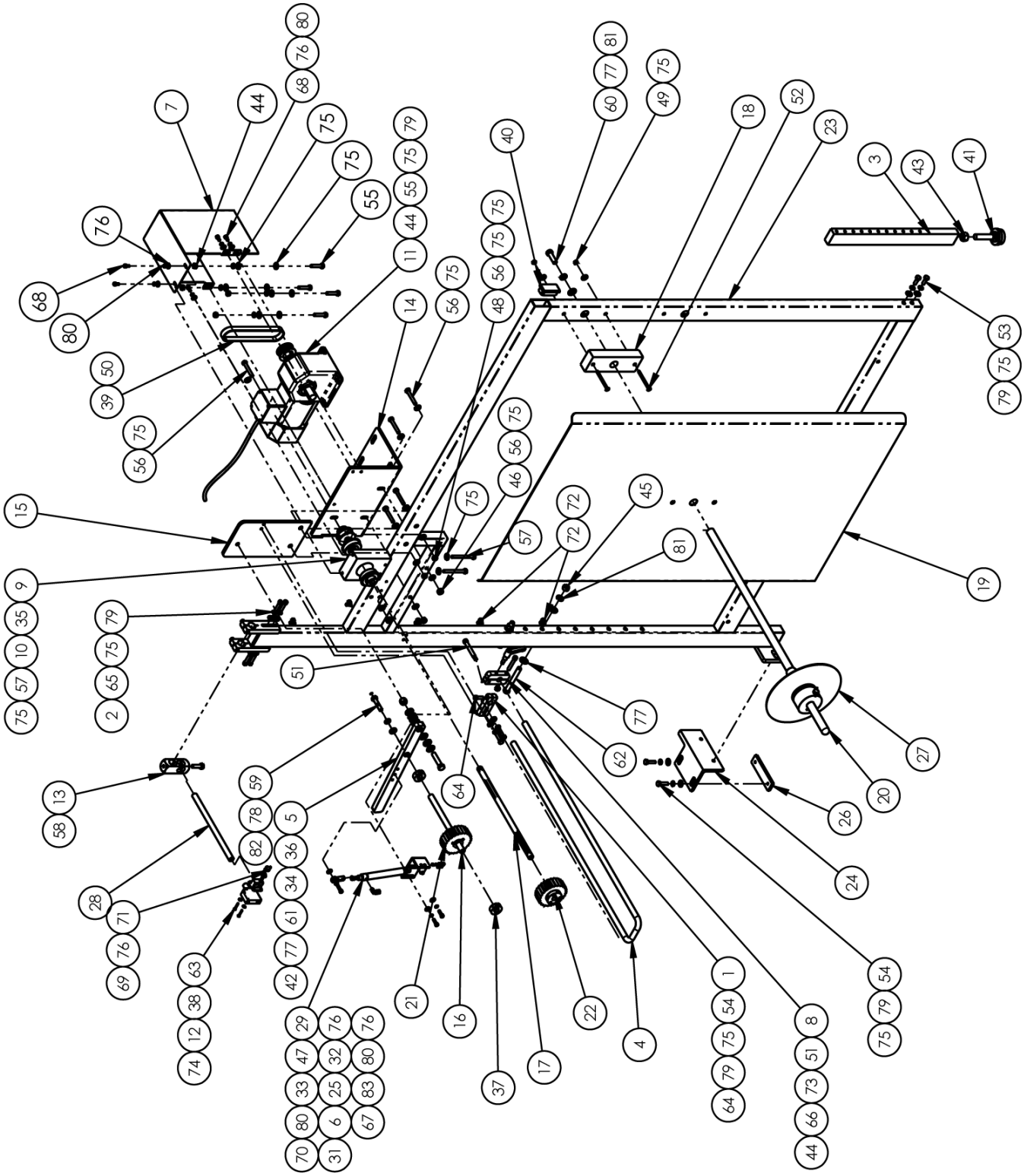
NO.	QTY	PART #	DESCRIPTION
1	1	1334-1023	Guide Mount
2	1	1334-1024	Support
3	3	1335-318	Rod Slide Arm
4	3	1335-319	Rod Clamp Arm
5	3	1335-320C	Rod, 3/8 x 9
6	3	1335Q-130A	Rod, 3/8 x 24
7	10	SSSS01024	Screw, Socket Set
8	3	SSSC95048	Screw, Socket Cap
9	6	TTH34311	Threaded Handle



1335271 Foot Pressure Assembly

ACC Drawing Number 1335271 Rev2

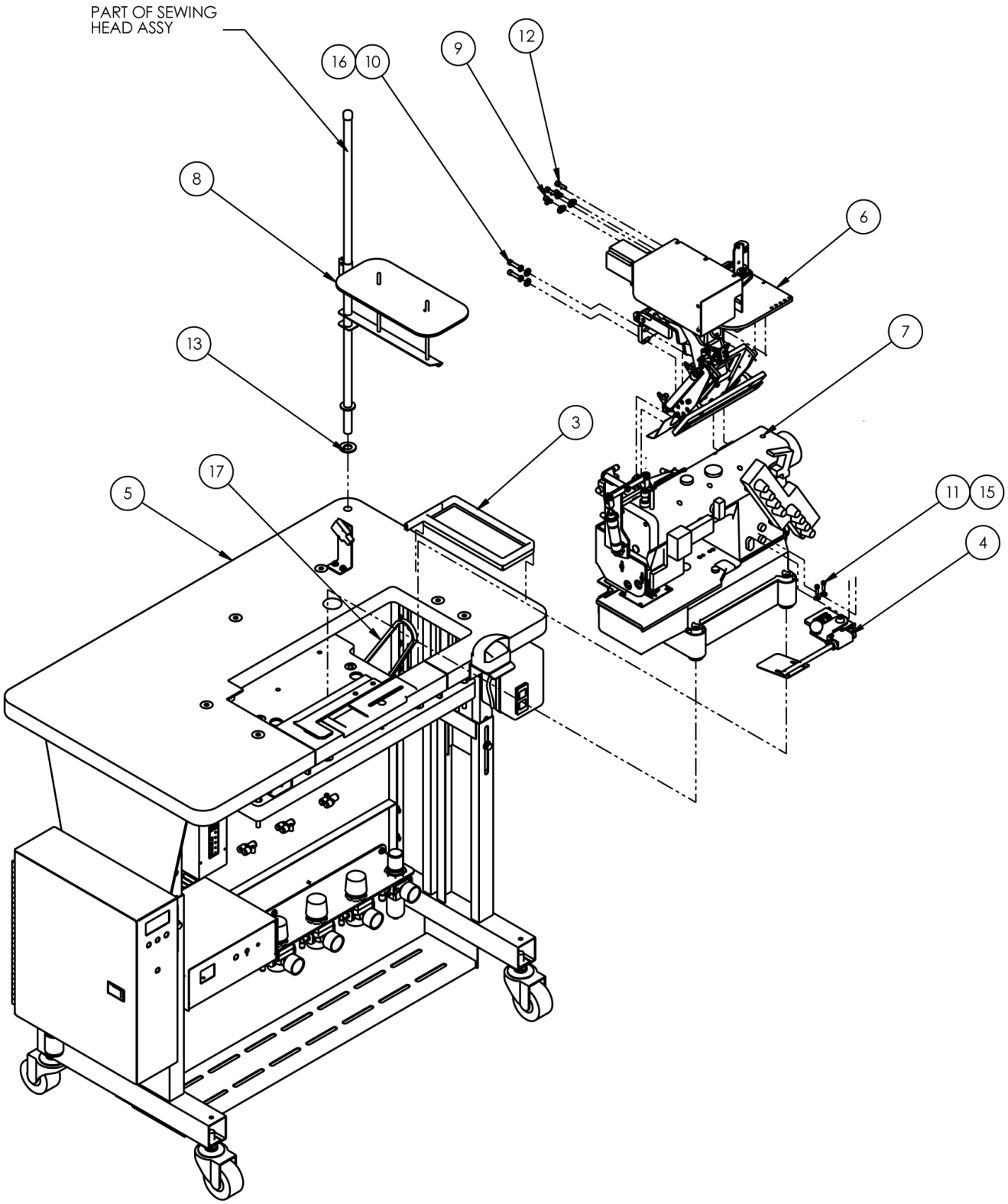
NO.	QTY	PART #	DESCRIPTION
1	1	1335207	MTG BRKT, FOOT LIFT
2	1	1335M-108	LEVER
3	1	AA198RR508	FLOW CONTROL,5/32 X 1/8"
4	1	AAC7DP-.5	CYLINDER,AIR,DA
5	1	AAFBP-11C	BRKT,PIVOT,1/4 BORE
6	1	AAFCT-7	CLEVIS,AIR CYL, 1/4-28
7	1	AAFP18	MUFFLER,1/8 NPT, BRONZ
8	1	NNJ1/4-28	1/4-28 HEX JAM NUT
9	1	SSAS020016	SHOULDER BOLT 1/4 X 1/4L



1335105 Unwinder Assembly

ACC Drawing Number 1335105 Rev15

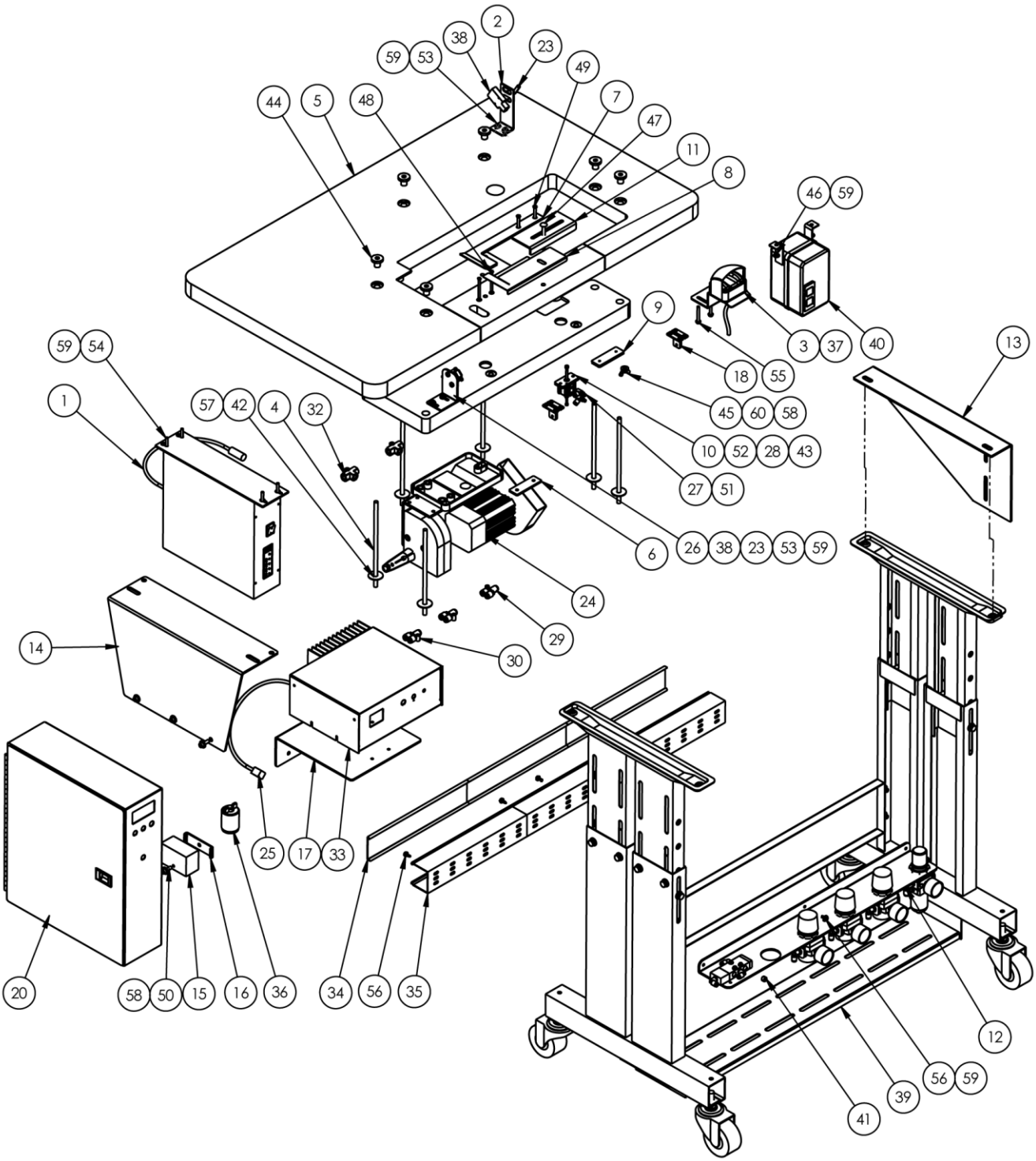
NO.	QTY	PART #	DESCRIPTION
1	1	1325-346	HOLDER,ROD,1/2 D,SLOT MNT
2	2	1325-346A	HOLDER, ROD, 3/4", SLOT
3	1	132556-273	LEG, 3/4 X 1-1/2 X 15 LG
4	1	1335-837A	ROD,1/2 DIA, 180 DEG
5	1	1335189	LINK, IDLER ROLLER
6	1	1335M-2046	PLATE,NUT,8-32@.43 CTC
7	1	1335M-4007	COVER, BELT
8	1	1347-001	EDGE GUIDE,SPLIT,(2 PCS)
9	1	1961-365	YOKE, BEARING
10	1	211-057	PULLEY, 3/8P, 12T,1/2B
11	1	23218DM	MOTOR ASSY,GEAR
12	1	265155A	HOLDER, EYE, 1/2 BORE
13	1	28201	CROSS BLOCK, LARGE
14	1	1335112	MOUNT,MOTOR
15	1	1335115	MOUNT, PINCH ROLLER
16	1	1335116	DRIVE ROD, ROLLER
17	1	1335117	SHAFT, DRIVE ROLLER
18	1	1335118	MOUNT, DISC
19	1	1335119	DISC
20	1	1335139	ROD,SS,3/4 X 28.0L
21	1	1335497	ROLLER, FLUTTED, IDLER,
22	1	1335498	DRIVE ROLLER, FLUTTED
23	1	1335771	UNWINDER FRAME (K3)
24	1	1335797	BRKT,SUPPORT
25	1	1335864	BRACKET, CYLINDER
26	1	1335897	PLATE,NUT,1/4-20@3.00 CTC
27	1	33008708	BALL BEARING DISC ASSY
28	1	8732-0576	ROD, STRAIGHT, SS, 1/2 X
29	1	AAC8DP-3	CYLINDER,AIR,DA
30	5	AAF1/8	1/8" PLASTIC CLAMP
31	1	AAFBP-8C	BRKT,PIVOT,5/32 BORE
32	1	AAQME-5-10	ELBOW, MALE,5/32X10-32
33	1	BBAW-3Z	BRG,ROD END,F, 10-32
34	2	BBNTA613	BEARING,THRUST,375BORE
35	2	BBS8701-88	BEARING,BALL,.50IDX1.75OD
36	4	BBTRA613	WASHER,THRUST,STL, .375B
37	2	CCCL8F	CLAMP COLLAR- 1/2
38	1	FFQM42VN6A	EYE,ELECTRIC,10-30VDC
39	1	GG157L050	BELT,GEAR,3/8P,1/2W
40	2	MM132-1496	PLUG 1 X 2
41	1	MMFB4444	FOOT, RUBBER
42	1	NNE3/8-16	NUT, ELASTIC 3/8-16
43	1	NNH1/2-13	1/2-13 HEX NUT
44	5	NNH1/4-20	1/4-20 HEX NUT
45	3	NNH3/8-16	3/8-16 HEX NUT
46	3	NNH5/16-18	5/16-18 HEX NUT
47	1	NNJ10-32	NUT,JAM,THIN #10-32
48	2	NNK1/4-20	KEP NUT, 1/4-20
49	2	NNK10-32	KEP NUT, 10-32
50	1	PP12LF050-3/4	PULLEY,GEAR,3/8P,.50B,12T
51	1	SSAS020128	5/16 X 2 1/4-20 SHLD, BOLT
52	2	SSFC98240	10-32 x 2 1/2 FLAT ALLEN
53	2	SSHC01048	1/4-20 X 3/4 HEX HEAD
54	4	SSHC01064	1/4-20 X 1 HEX HEAD
55	4	SSHC01080	1/4-20 X 1-1/4 HEX HEAD
56	5	SSHC01112	1/4-20 X 1-3/4 HEX HEAD
57	2	SSHC01160	1/4-20 X 2-1/2 HEX HEAD
58	1	SSHC10064	5/16-18 X 1" HEX HEAD
59	1	SSHC10096	5/16-18 X 1-1/2 HEX HEAD
60	1	SSHC25080	3/8-16 X 1-1/4 HEX HEAD
61	1	SSHC25112	3/8-16 X 1-3/4 HEX HEAD
62	2	SSHC25192	3/8-16 X 3 HEX HEAD
63	2	SSPS70048	#4-40 X 3/4 PAN HD SLOT
64	1	SSSC01048	1/4-20 X 3/4 SOC CAP
65	4	SSSC01064	1/4-20 X 1 SOC CAP
66	1	SSSC01096	1/4-20 X 1-1/2 SOC CAP
67	2	SSSC90024	#8-32 X 3/8 SOC CAP
68	5	SSSC98024	#10-32 X 3/8 SOC CAP
69	3	SSSC98040	#10-32 X 5/8 SOC CAP
70	1	SSSC98048	#10-32 X 3/4 SOC CAP
71	1	SSW#10	WING SCREW KNOB
72	5	SSZS93032	SCREW, SHT.METAL 10 ZIP
73	1	TTH32415	HANDLE,THREADED,1/4-20X7/
74	2	WWF4	WASHER, FLAT #4
75	32	WWFS1/4	WASHER FLAT, 1/4
76	9	WWFS10	WASHER, FLAT #10
77	6	WWFS3/8	WASHER, FLAT, 3/8
78	1	WWFS5/16	WASHER, FLAT, 5/16
79	16	WWL1/4	1/4 LW
80	8	WWL10	#10 LW
81	3	WWL3/8	3/8 LW
82	1	WWL5/16	5/16 LW
83	2	WWL8	#8 LW



1335256 Base Console

ACC Drawing Number 1335256 Rev7

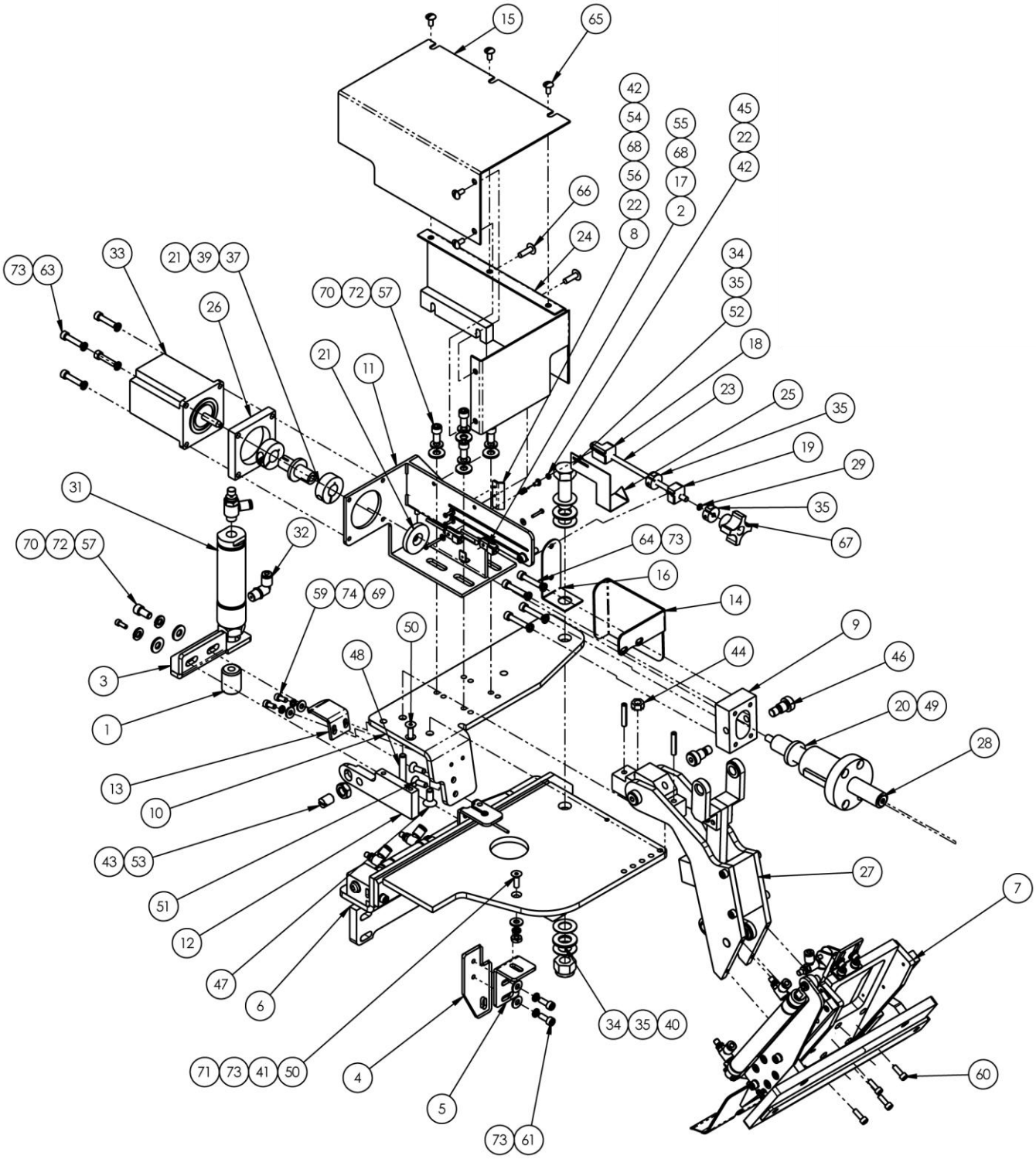
NO.	QTY	PART #	DESCRIPTION
NS	AR	1335MF-PD	DIAGRAM, PNEUMATIC
3	1	26151	TOOL TRAY, 1X3.5X9
4	1	1335182	STRIPPER BLADE ASSY
5	1	1335258	RUFFLER ASSY,YAM [illegible]M1804P
6	1	1335425	SEW HEAD SUBASSEMBLY
7	1	1959-112	2 POS THREAD PLATE [illegible]SSY
8	2	SSSC01032	1/4 - 20 x 1/2 LG SHCS
9	2	SSSC05064	1/4-28 X 1 SOC CAP
10	2	SSSC98040	#10-32 X 5/8 SOC CAP
11	2	SSSCM6X20	M6-1.0 X 20 SOC CAP
12	1	WWF5/8	WASHER, FLAT, 5/8
13	4	WWFS1/4	WASHER FLAT, 1/4
14	2	WWFS10	WASHER, FLAT #10
15	6	WWL1/4	1/4 LW
16	1	ZX3833	V-BELT,3/8 X 33



1335257 Stand / Motor Assembly

ACC Drawing Number 1335257 Rev17

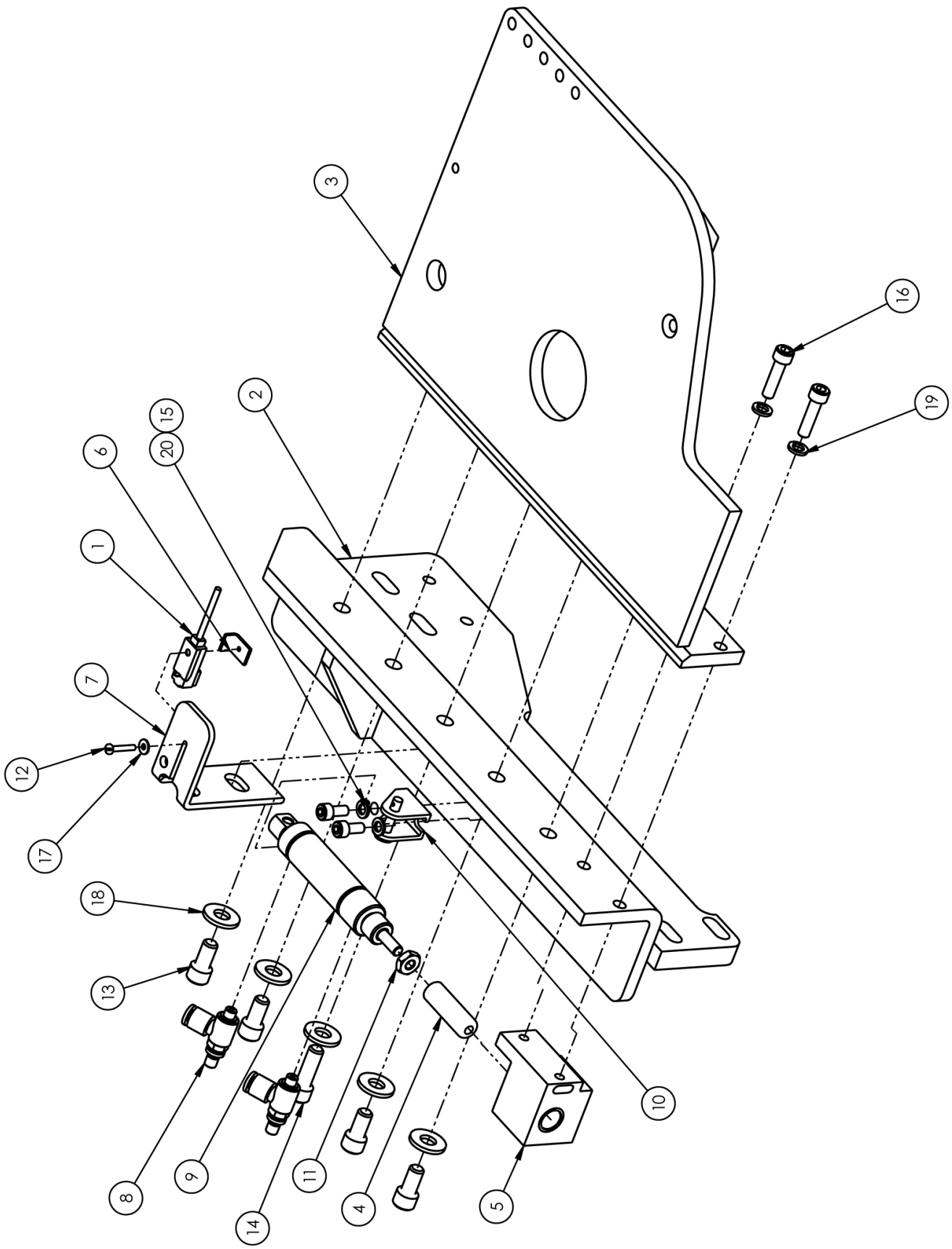
NO.	QTY	PART #	DESCRIPTION
1	1	0211-702A	CABLE,POS. SENSOR,6'
2	1	1278-6689B	BRACKET, EYE MOUNT
3	1	1278-6718A	BRKT,OPTO TOUCH SWITCH
4	6	1335244	ROD THRD,5/16-18 X 8.75
5	1	1335247	TABLE TOP,MAIN,W/ SUPPORT
6	1	1335274	WASHER PLATE - PANEL TENS
7	1	1335275	TOP PLATE- PANEL TENSION
8	1	1335278	PANEL TENSION FINGER
9	1	1335280	NUT PLATE - PANEL TENSION
10	1	1335281	NUT PLATE - PANEL TENSION
11	1	1335284	EDGE GUIDE
12	1	1335716	PNEUMATIC, SHELF
13	1	1335774	BRACKET, TABLE MOUNT
14	1	1335784	BRKT,ANGLE,CONTROL BOX
15	1	1335785	SPACER BLOCK
16	1	1335786	SPACER HOLDER
17	1	1335936	BRKT,MNT,STEP BOX
18	4	1335M-114	HINGE BRKT
NS	AR	1335M-LAB	LABELS
20	1	1335MF-500	CONTROL BOX ASSY
NS	AR	1335MF-PD	PNEUMATIC DIAGRAM
NS	AR	1335MF-WD	WIRING DIAGRAM
23	1	4059-DC1500	MOTOR & CONTROLLER
24	1	4080-4508B	CABLE,STEP MOTOR,4 AMP,7'
25	2	AA198RA510	FLOW CONTROL,5/32X10-32
26	1	AACNCQ2B16-10D	COMPACT, 16MM BORE, 10MM
27	2	AAQUY-4-4	Y UNION, 1/4X1/4
28	1	AAQUY-5-4	Y UNION, 5/32X1/4
29	3	AAQUY-5-5	QUICK UNION Y, 5/32
30	2	AAVS125	SHUTTLE VALVE,1/8"PORT
31	1	AP-28-800Y1	BOX,STEPPER,H.S. (X5)
32	3	EEDC2X2	COVER,WIRE DUCT
33	3	EEDF2X2	DUCT,WIRE,2X2, MOD
34	1	FFHBL4579C	RECEPTACLE,3 POLE,3W
35	1	FFOTBVN6	SWITCH,OPTO-TOUCH
36	2	FFSM312LVQ	BANNER MINI-BEAM
37	1	K-CB600	MOTOR STARTER,ELEC
38	1	MM4554K11	PLUG, 1/8" PIPE
39	6	NNH5/16-18	5/16-18 HEX NUT
40	1	NNHM4X0.7	M4 X 0.7 HEX NUT
41	6	NNM103	NUT,RECESSED,5/16-18
42	1	NNW1/4-20	NUT, WING, 1/4-20
43	2	SSBC90024	#8-32 X 3/8 BUT HEAD
44	1	SSBK01160	1/4-20 X 2 1/2 BOLT, CARG
45	2	SSFS90128	#8-32 X 2 FLAT SLOTTED
46	2	SSFS98112	#10-32 X 1-3/4 FLAT SLOT
47	4	SSSC01048	1/4-20 X 3/4 SOC CAP
48	2	SSSCM3X30	M3-0.5 X 30 SOC CAP
49	1	SSSCM4X40	M4-0.7 X 40 SOC CAP
50	4	SSZH#10032	#10 X 1/2 HSMS
51	4	SSZH#10064	#10 X 1 HSMS
52	2	SSZH#10096	#10 X 1-1/2 HSMS
53	6	SSZS93032	SCREW, SHT.METAL 10 ZIP
54	6	WWFE020	WASHER,FENDER,5/16
55	5	WWFS1/4	WASHER FLAT, 1/4
56	12	WWFS10	WASHER, FLAT #10
57	1	WWL1/4	1/4 LW
58	2	1975-412A	PLATE,NUT,4-40,.95CTC
59	1	K-4D	HD T LEG ADJ STAND



1335258 Ruffler Assembly, Yam VM 1804P

ACC Drawing Number 1335258 Rev13

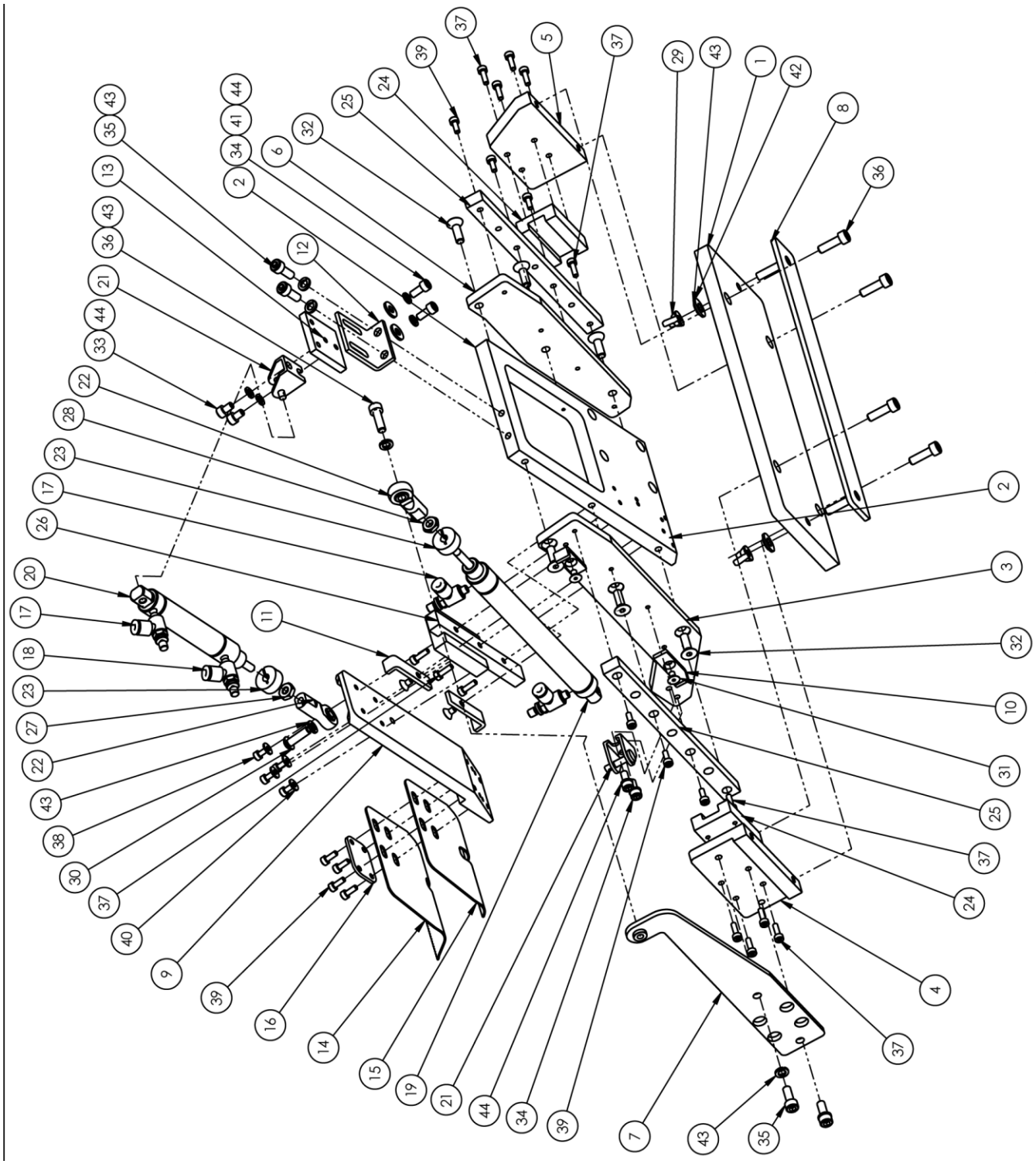
NO.	QTY	PART #	DESCRIPTION
1	1	11200A	BUMPER 5/16-24
2	2	1278-7055D	PROX SWITCH W/PLUG,12"
3	1	1335213	FOOT LIFT BRKT
4	1	1335217	SUPPORT BRKT-RUFFLER
5	1	1335218	ADJ ANGLE-RUFFLER SUPP
6	1	1335260	RUFFLER MTG ANGLE ASSY
7	1	1335332	RUFFLER CYL LIFT ASSY
8	1	1335M-001	BRACKET, STOP, PRX SWITCH
9	1	1335M-2006	BLOCK, NUT TRUNION
10	1	1335M-2008	PIVOT PLATE
11	1	1335M-2016	MTG BRKT WELDT
12	1	1335M-2019	LOCKING LEVELR
13	1	1335M-2020	HLD DWN BRKT
14	1	1335M-2021	VANE, SWITCH ACTUATING
15	1	1335M-2030	MOTOR COVER, CLEAR
16	1	1335M-2031	PIVOT BRKT AIR LINE
17	1	1335M-2034	PLATE, NUT #2-56
18	1	1335M-2035	ADJUSTMENT NUT, 10-32
19	1	1335M-2036	SUPPORT BLOCK
20	1	1335M-2037	WASHER, STOP
21	1	1335M-2038	STOP WASHER
22	1	1335M-2039	NUT,SPRING RETAINER
23	1	1335M-2040	SCREW, ADJUSTMENT
24	1	1335M-2042	COVER
25	1	1335M-2047	POINTER, RUFFLE SIZE
26	1	1335M-2049	SPACER, MOTOR, 3/8
27	1	1335M-2300B	PIVOT ASSY
28	1	1335M-2400	BALL SCREW AND NUT
29	1	AA198-7006	O RING, 1/8 ID, 1/4 OD
30	1	AA198RR508	FLOW CONTROL,5/32 X 1/8"
31	1	AAC6D-1.5	CYL, AIR, DA 1-1/16 B,1.5 S
32	1	AAQME-5-8	QUICK MALE ELBOW
33	1	AP-22E-103	STEP MOTOR,MODIFIED
34	2	BBNTA815	BEARING,THRUST,1/2BORE
35	4	BBTRA815	WASHER,THRUST,STEEL 1/2
35	2	CCCL10T	CLAMP COLLAR TRD, 10-32
37	2	CCCL8F	CLAMP COLLAR- 1/2
38	2	IIS012X064	SPRING PIN 3/16 DIA
39	1	MM8FM	JOINT,UNIVERSAL,MOD
40	1	NNE1/2-13	NUT, ELASTIC 1/2-13
41	1	NNH10-32	#10-32 HEX NUT
42	1	NNH2-56	#2-56 HEX NUT
43	1	NNJ3/8-16	3/8-16 HEX JAM NUT
44	1	NNK1/4-20	KEP NUT, 1/4-20
45	1	RRLC026B1	SPRING,COMP .026X.18X.25
46	2	SSAS024024M	3/8 X 3/4 X 5/16-18
47	1	SSFC01040	1/4-20 X 5/8 FLAT ALLEN
48	1	SSFC01096	1/4-20 X 1-1/2 FLAT ALLEN
49	1	SSFC98032	#10-32 X 1/2 FLAT ALLEN
50	2	SSFC98040	#10-32 X 5/8 FLAT ALLEN
51	2	SSFC98040S	#10-32 X 5/8 S/S FLAT ALLEN
52	1	SSHC45096	1/2-13 X 1 1/2 L HHCS
53	1	SSMB58N	PLUNGER,BALL,3/8-16X5/8L
54	2	SSPS50020	#2-56 X 5/16 PAN HD SLOT
55	1	SSPS50032	#2-56 X 1/2 PAN HD SLOT
56	1	SSPS50048	#2-56 X 3/4 PAN HD SLOT
57	5	SSSC01032	1/4-20 X 1/2 SOC CAP
58	1	SSSC85024	#6-40 X 3/8 SOC CAP
59	2	SSSC90024	#8-32 X 3/8 SOC CAP
60	4	SSSC90032	#8-32 X 1/2 SOC CAP
61	2	SSSC98032	#10-32 X 1/2 SOC CAP
62	1	SSSC98048	#10-32 X 3/4 SOC CAP
63	4	SSSC98056	#10-32 X 7/8 SOC CAP
64	4	SSSC98064	#10-32 X 1 SOC CAP
65	5	SSTS90024	#8-32 X 3/8 TRUSS HD
66	2	SSTS98040	#10-32 X 5/8 TRUSS HD
67	1	TTCL1APPK1	PLASTIC KNOB, #10-32
68	4	WWF2	WASHER, FLAT #2
69	2	WWF8	WASHER, FLAT #8
70	6	WWFS1/4	WASHER FLAT, 1/4
71	3	WWFS10	WASHER, FLAT #10
72	6	WWL1/4	1/4 LW
73	11	WWL10	#10 LW
74	2	WWL8	#8 LW
75	1	WWSI6	WASHER,INT. TOOTH



1335260 Ruffler MTG Angle Assembly

ACC Drawing Number 1335260 Rev2

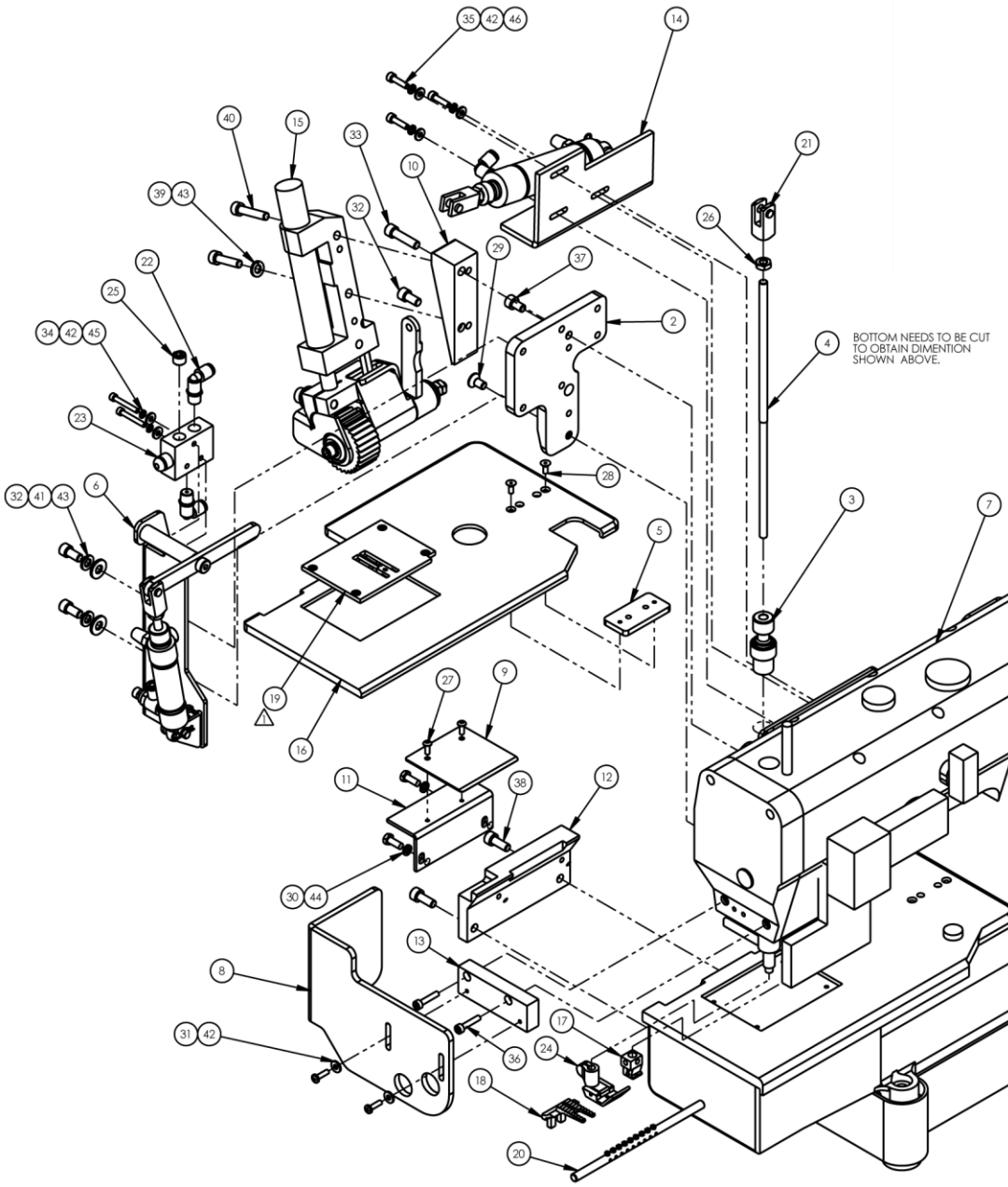
NO.	QTY	PART #	DESCRIPTION
1	1	1278-7055D	PROX SWITCH W/PLUG,12"
2	1	1335214	RUFFLER MTG BRKT - 1804A
3	1	1335220	BASE PLATE, RUFFLER MTG
4	1	1335M-2017	ROD, END
5	1	1335M-2027A	CYL. MOUNT
6	1	1335M-2034	PLATE, NUT #2-56
7	1	1335M-3008A	MTG. BRKT. SENSOR
8	2	AA198RA510	FLOW CONTROL,5/32X10-32
9	1	AAC8DP-.5	CYL,AIR,DA,9/16 B,1/2S
10	1	AAFBP-8C	BRKT,PIVOT,5/32 BORE
11	1	NNH10-32	#10-32 HEX NUT
12	1	SSPS50032	#2-56 X 1/2 PAN HD SLOT
13	4	SSSC01032	1/4 - 20 x 1/2 LG SHCS
14	1	SSSC01048	1/4-20 X 3/4 SOC CAP
15	2	SSSC90024	#8-32 X 3/8 SOC CAP
16	2	SSSC98048	#10-32 X 3/4 SOC CAP
17	1	WWF2	WASHER, FLAT #2
18	5	WWFS1/4	WASHER FLAT, 1/4
19	2	WWL10	#10 LW
20	2	WWL8	#8 LW



1335332 Ruffler Cylinder Lift Assembly

ACC Drawing Number 1335332 Rev8

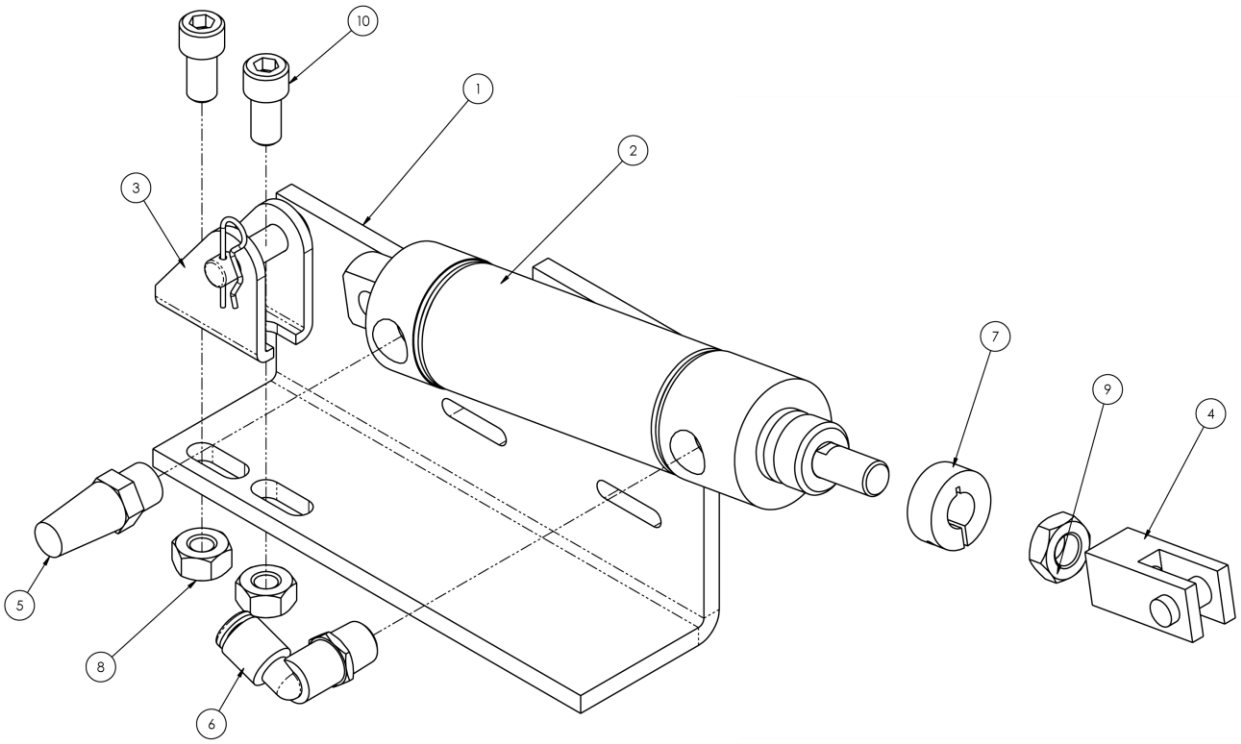
NO.	QTY	PART #	DESCRIPTION
1	1	1335223	BASE MTG PLT, FOLDER
2	1	1335224	BASE MTG PLATE
3	1	1335226	MTG PLT LH- RAIL
4	1	1335227	SUPPORT-SLIDE, LH SIDE
5	1	1335228	SUPPORT, RH
6	1	1335229	MTG PLT RH- RAIL
7	1	1335230	FOLDER SLIDE ARM
8	1	1335235	STUD PLATE-YAMATO1804
9	1	1335335	MTG PLT- HEAVY DUTY
10	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 12
15	1	1335M-2002F	BLADE, RUFFLER, 2.25 X 12
16	1	1335M-5004	PLATE, WASHER, 136DIA@4PL
17	3	AA198RA510	FLOW CONTROL,5/32X10-32
18	1	AA198RR510	REV FL CONT,5/32X10-32
19	1	AAC024DXP	CYL,BIMBA,9/16 B,4 S
20	1	AAC8DP-1.5	CYL, AIR, DA, 9/16B, 2S
21	2	AAFBP-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	MGN12H BEARING BLOCK
25	2	MMGNR12R0165HN	165MM RAIL - MGN12H 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	SSFC80016	#6-32 X 1/4 FLAT ALLEN
32	6	SSFC98040	#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	WWF4	WASHER, FLAT #4
41	2	WWF8	WASHER, FLAT #8
42	2	WWFS10	WASHER, FLAT #10
43	8	WWL10	#10 LW
44	6	WWL8	#8 LW



1335425 Sew Head Sub Assembly

ACC Drawing Number 1335425 Rev4

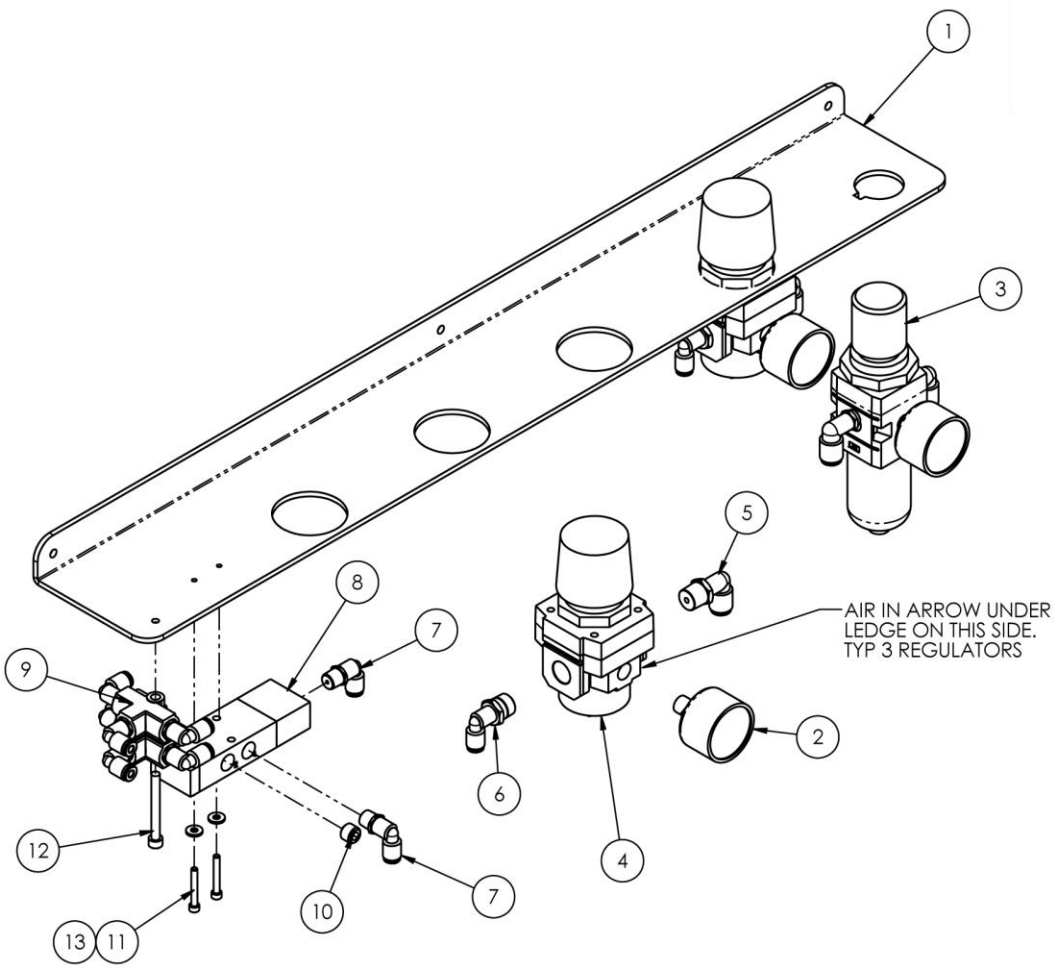
NO.	QTY	PART #	DESCRIPTION
1	1	1278-6364	DISC, TAPE MOUNTING
2	1	1335201	RUFFLER MTG BRKT-YA-1804
3	1	1335208	FOOT LIFT ADJ - MOD
4	1	1335209	FOOT LIFT PIN
5	1	1335233	NUT PLATE
6	1	1335271	FOOT PRESSURE ASSY
7	1	1335279	SEWING HEAD, MODIFIED
8	1	1335417	PULLER GUARD-HD
9	1	1335418	PULLER WEAR PLATE
10	1	1335421	BRKT, PULLER MOUNT, YAM
11	1	1335422	COVER, BOTTOM PULLER
12	1	1335423	SPACER, PULLER PLATE
13	1	1335424	SPACER, GUARD,1804P
14	1	1335426	PULLER LIFT ASSY-1804P
15	1	1335428	PULLER MOD, YAMATO 1804
16	1	1335429	SEWING HEAD PLATE MOD
17	1	1862N14001	NEEDLE CHUCK,1N 1804
18	1	1888N12S01	FEED DOG 1N
19	1	1888N13S01	PLATE, NEEDLE, 1N
20	1	54242B9016	SPREADER,9NDL 1/4 GA
21	1	AAFCT-7	CLEVIS,AIR CYL, 1/4-28
22	2	AAQME-5-8	QUICK MALE ELBOW
23	1	AAV41-P	HUMPHREY VALVE,4 WAY
24	1	M1V67-016	FOOT,1N,RUFFLER
25	1	MM4554K11	PLUG, 1/8" PIPE
26	1	NNJ1/4-28	1/4-28 HEX JAM NUT
27	2	SSBC80024	#6-32 X 3/8 BUT HEAD
28	2	SSFC80024	#6-32 X 3/8 FLAT ALLEN
29	1	SSFCM6X12	M6-1.0 X 12 FLAT ALLEN
30	2	SSHC98032	#10-32 X 1/2 HEX HEAD SS
31	2	SSPP80032	#6-32 X 1/2 PAN HD PHIL
32	3	SSSC05032	1/4-28 X 1/2 SOC CAP
33	1	SSSC05064	1/4-28 X 1 SOC CAP
34	2	SSSC80064	#6-32 X 1 SOC CAP
35	3	SSSCM4X16	M4-0.7 X 16 SOC CAP
36	2	SSSCM4X20	M4-0.7 X 20 SOC CAP
37	1	SSSCM6X10	M6-1.0 X 10 SOC CAP
38	2	SSSCM6X16	M6-1.0 X 16 SOC CAP
39	1	SSSCM6X25	M6-1.0 X 25 SOC CAP
40	1	SSSCM6X30	M6-1.0 X 30 SOC CAP
41	2	WWFS1/4	WASHER FLAT, 1/4
42	7	WWFS6	WASHER, FLAT, #6
43	3	WWL1/4	1/4 LW
44	2	WWL10	#10 LW
45	2	WWL6	WASHER,LOCK,6
46	3	WWL8	#8 LW



1335426 Puller Lift Assembly 1804P

ACC Drawing Number 1335426 Rev1

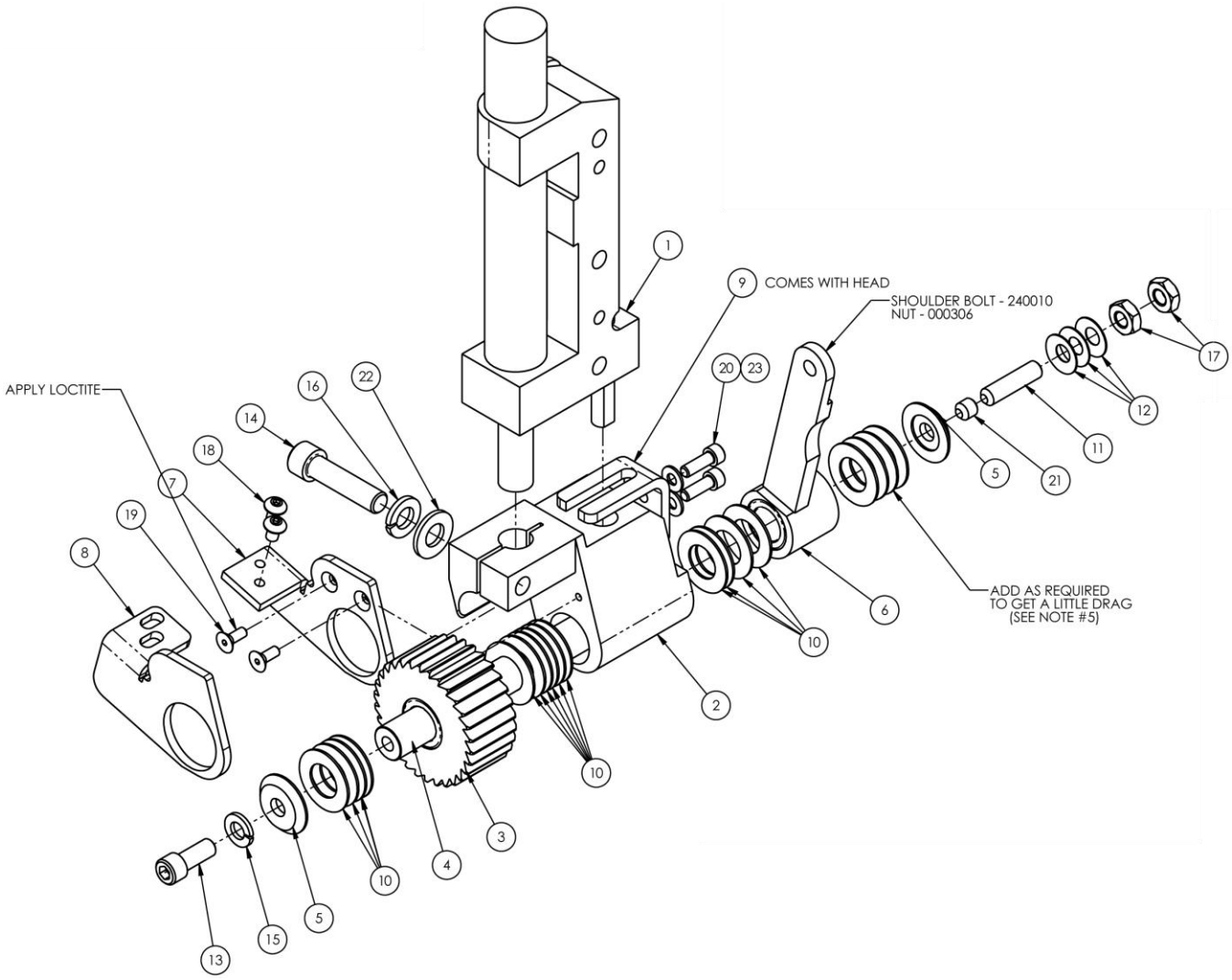
NO.	QTY	PART #	DESCRIPTION
1	1	132556-148D	BRACKET PULLER LIFT-HD
2	1	AAC6DX-1.5	CYLINDER,AIR,DA,PIVOT
3	1	AAFBP-11C	BRKT,PIVOT,1/4 BORE
4	1	AAFCT-11	CLEVIS, CYL, 5/16-24 ,1/4
5	1	AAFP18	MUFFLER,1/8 NPT, BRONZ
6	1	AAQME-5-8	QUICK MALE ELBOW
7	1	CCCL5F	CLAMP COLLAR,5/16" BORE
8	2	NNH1/4-20	1/4-20 HEX NUT
9	1	NNJ5/16-24	5/16-24 HEX JAM NUT
10	2	SSSC01032	1/4-20 X 1/2 SOC CAP



1335716 Pneumatic, Shelf

ACC Drawing Number 1335716 Rev3

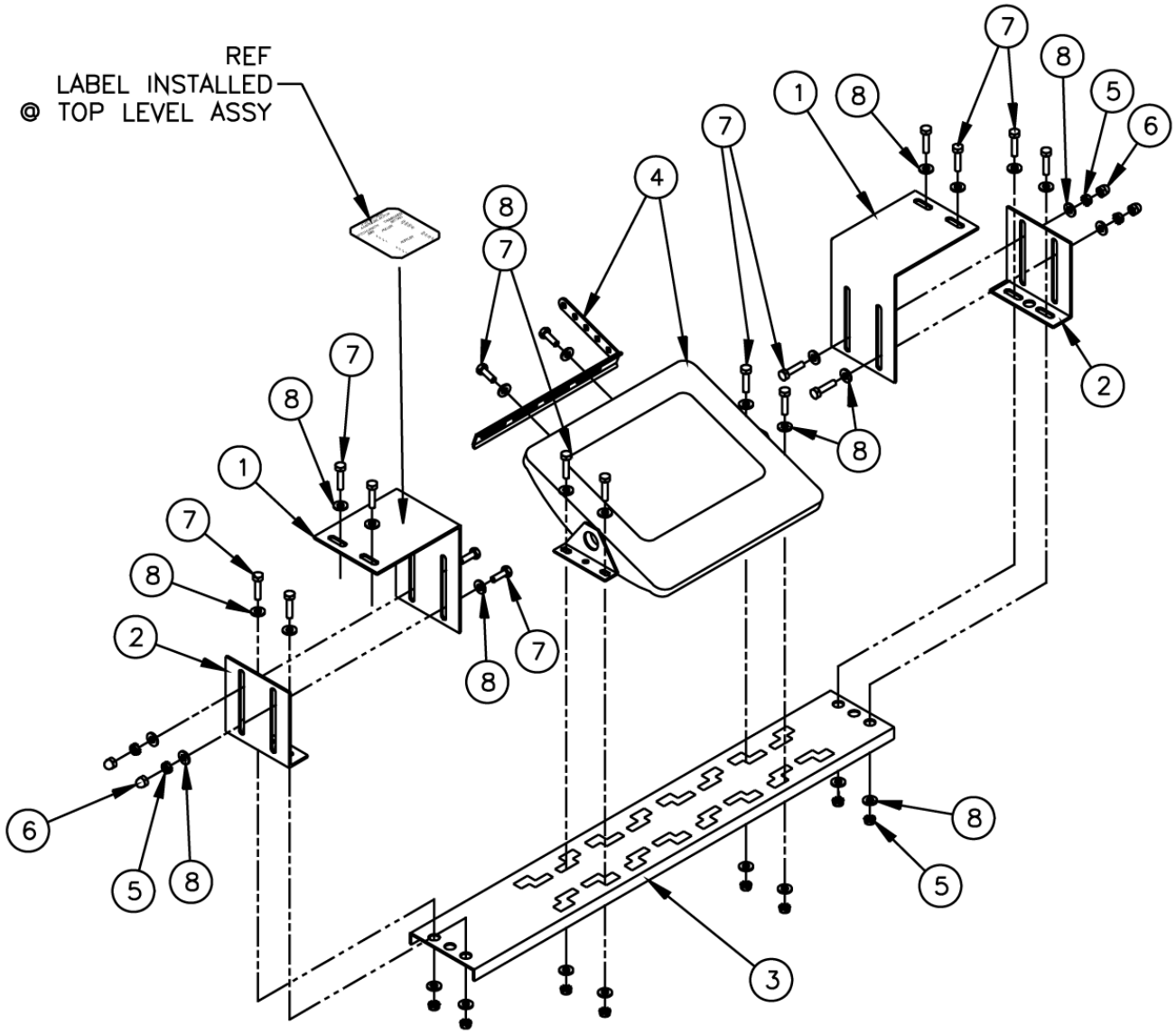
NO.	QTY	PART #	DESCRIPTION
1	9	AAQME-5-8	QUICK MALE ELBOW
2	2	AAVS125	SHUTTLE VALVE,1/8"PORT
3	2	SSSC80064	#6-32 X 1 SOC CAP
4	2	WWFS6	WASHER, FLAT, #6
5	1	1335715	BRACKET, PNEUMATIC
6	1	AA198-503	0-30PSI AIR GAGE 1/8NPT
7	1	AA198-5102	REGULATOR W/GAUGE & NUT
8	1	AA198-RP3	REGULATOR,PRECISION AIR
9	2	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT
10	2	AAQME-5-4	ELBOW, MALE 5/32X1/4NPT
11	1	AAV125B	PILOT VALVE
12	1	MM4554K11	PLUG, 1/8" PIPE
13	1	SSSC98112	SCR, SOC CAP 10-32 X 1-3/4



1335428 Puller Modification, Yamato 1804

ACC Drawing Number 1335428 Rev8

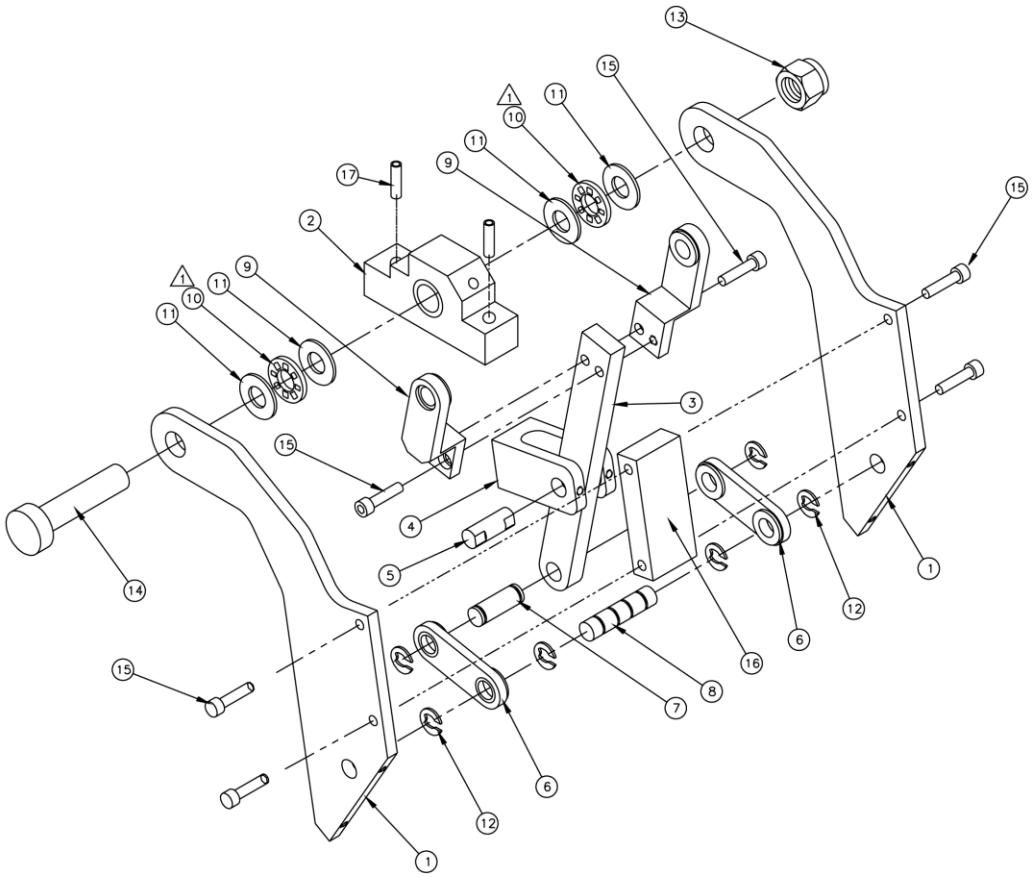
NO.	QTY	PART #	DESCRIPTION
1	1	1335394	PULLER,MOD,MG2002/VM1804
2	1	1335395	YOKE, PULLER-HD
3	1	1335397	PULLER ROLLER, HD, 2002MG
4	1	1335399	SHAFT, PULLER, HD
5	2	1335400	WASHER, HUB CAP, 1/4
6	1	1335414	DRIVE ARM, PULLER,HD
7	1	1335928	STRIPPER PLATE
8	1	1335929	STRIPPER PLATE
9	1	3100612	UPPER FEED ROLLER YOKE GU
10	18	BBTRA815	WASHER,THRUST,STEEL 1/2
11	1	SSSS05064	SET SCREW1/4-28X1
12	3	WWS307-1	WASHER,SPRING,BELVEL
13	1	SSSC05040	1/4-28 X 5/8 SOC CAP
14	1	SSSC20080	5/16-24 X 1-1/4 SOC CAP
15	1	WWL1/4	1/4 LW
16	1	WWL5/16	5/16 LW
17	2	NNJ1/4-28	1/4-28 HEX JAM NUT
18	2	SSBC90016	#8-32 X 1/4 BUT HEAD
19	2	SSFC80024	#6-32 X 3/8 FLAT ALLEN
20	2	SSSC90032	#8-32 X 1/2 SOC CAP
21	1	SSSS05016	1/4-28 X 1/4 KNURL PT
22	1	WWFS5/16	WASHER, FLAT, 5/16
23	2	WWB5/32	WASHER, FLAT, 5/32", BRAS



1335M-1005 Sit-Down Treadle Assembly

ACC Drawing Number 192857C Rev1

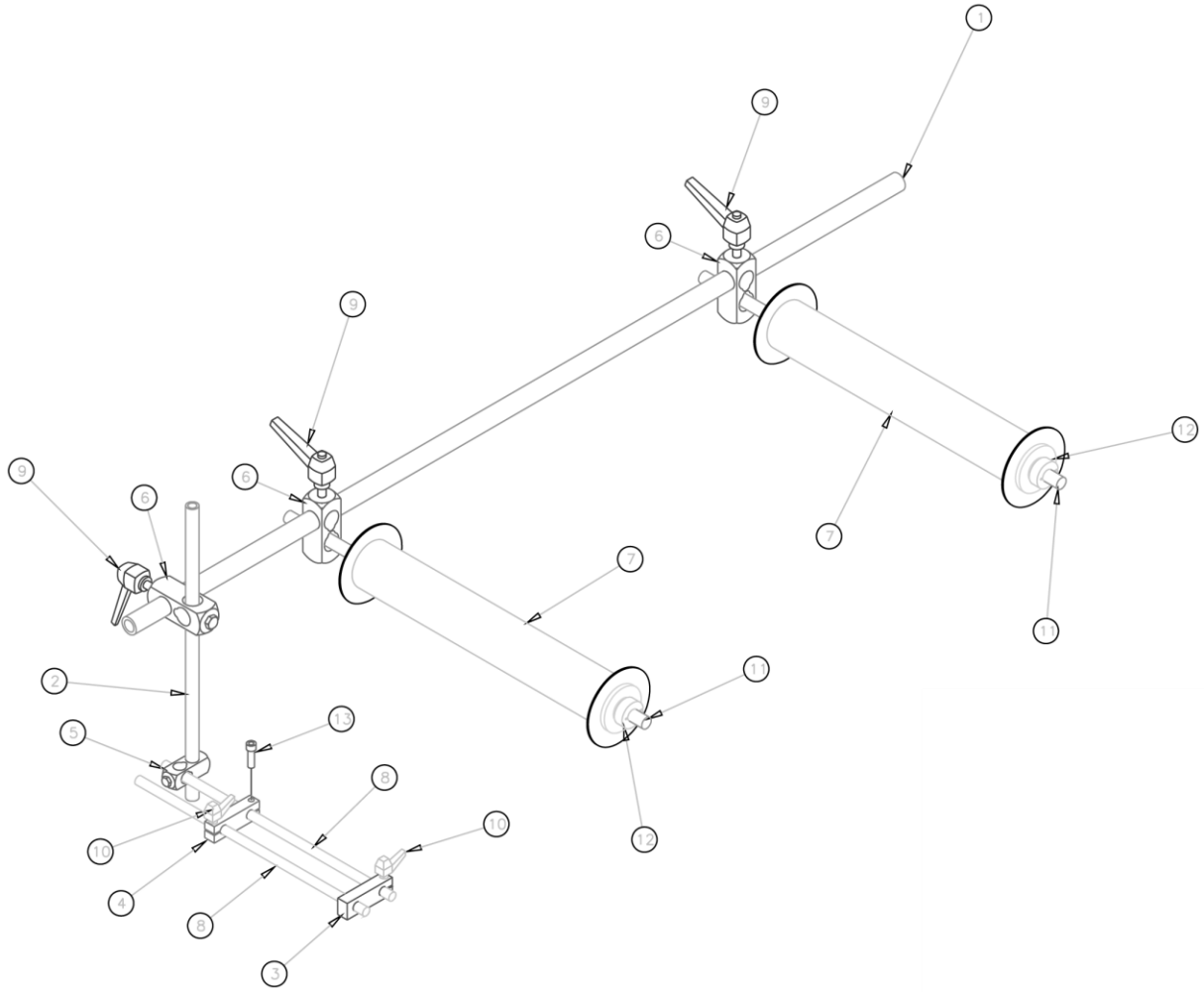
NO.	QTY	PART #	DESCRIPTION
1	2	1335M-105	Treadle Brkt
2	2	160929A	Show Stand Brkt
3	1	K-100-30M	Treadle Brace
4	1	K-340	Threadle W/BRKT
5	12	NNK1/4-20	Kep Nut
6	4	NNC1/4-20	Cap Nut
7	18	SSHC01048	Screw, Hex Cap
8	30	WWFS1/4	Flat Washer



1335M-2300B Pivot Assembly

ACC Drawing Number 192985C Rev3

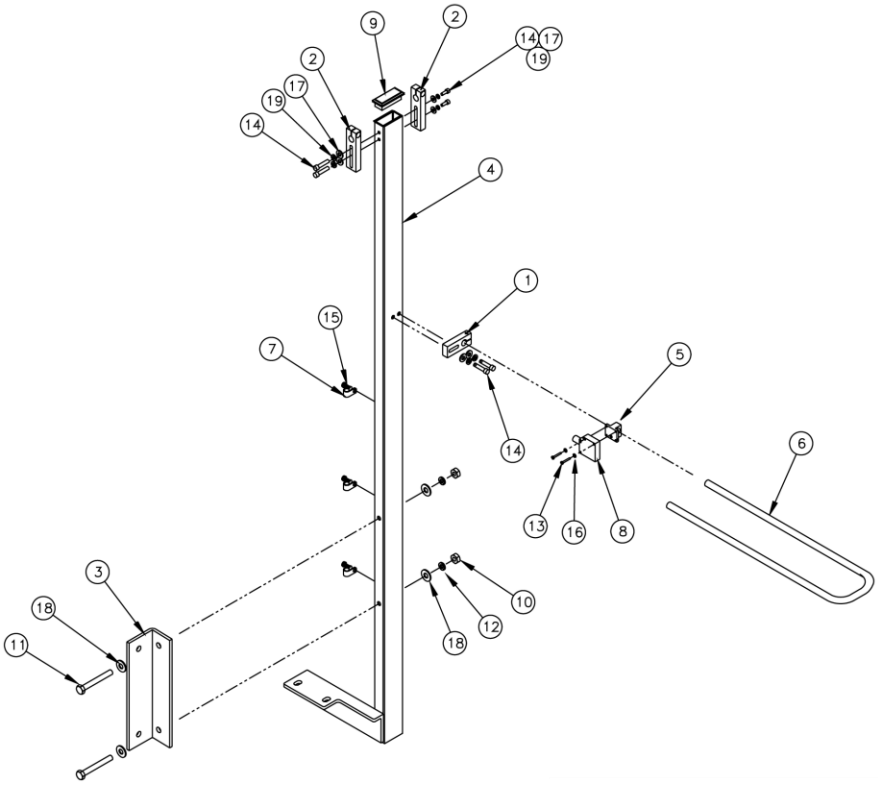
NO.	QTY	PART #	DESCRIPTION
1	2	1335M-2004A	Pivot Arm
2	1	1335M-2007	Pivot Block
3	1	1335M-2009	Drive Link
4	1	1335M-2010	Pivot Block
5	1	1335M-2011	Pivot Shaft
6	2	1335M-2012	Side Link
7	1	1335M-2013	Link Shaft
8	1	1335M-2014	Link Shaft
9	2	1335M-2015	Link Yoke
10	2	BBNTA815	Thrust Bearing
11	4	BBTRA815	Thrust Washer
12	6	MM8407A134	E-Ring
13	1	NNE1/2-13	Elastic Lock Nut
14	1	SSHC45160	Screw, Hex Cap
15	6	SSSC98048	Screw, Socket Cap
16	1	1335373	Spacer
17	2	IIS012X064	Spring Pin



1335M-420 Guide Roller Assembly

ACC Drawing Number 192832C Rev0

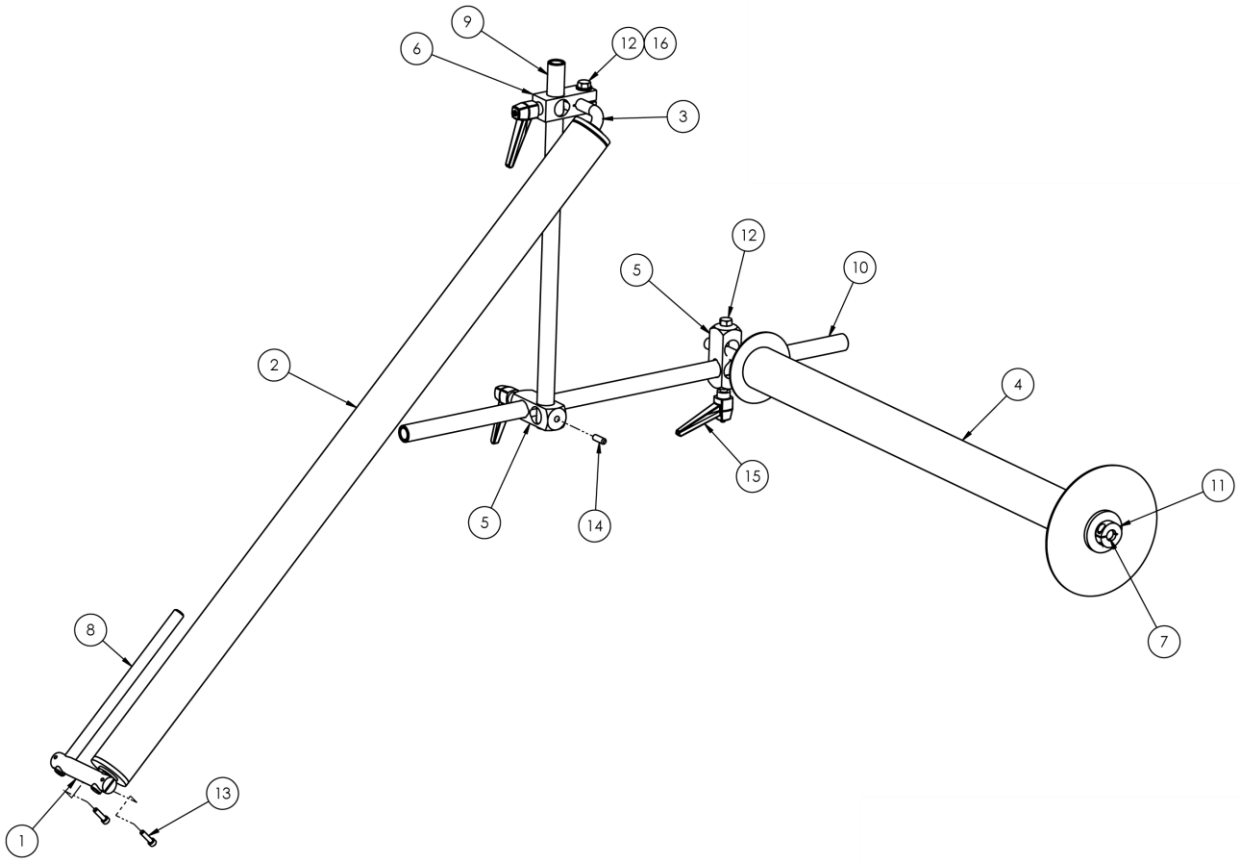
NO.	QTY	PART #	DESCRIPTION
1	1	97-1711	Tube, 3/4 x 30
2	1	8732-0576	Tube, 1/2 x 9
3	1	1335-318	Rod Slide Arm
4	1	1335-319	Rod Clamp Arm
5	1	A-U	Cross Block, 1/2
6	3	28201	Cross Block, 3/4
7	2	1335-814	Roller, 2 x 9
8	2	1335-320B	Rod, 3/8 x 11 s/s
9	3	TTH32425	Threaded Handle
10	2	TTH34311	Threaded Handle
11	2	8732-0896	Rod, 1/2 x 14
12	2	CCCL8F	Clamp Collar
13	1	SSSC95048	Screw, Socket Cap



1335M-4200A Support Frame Assembly

ACC Drawing Number 192833C Rev0

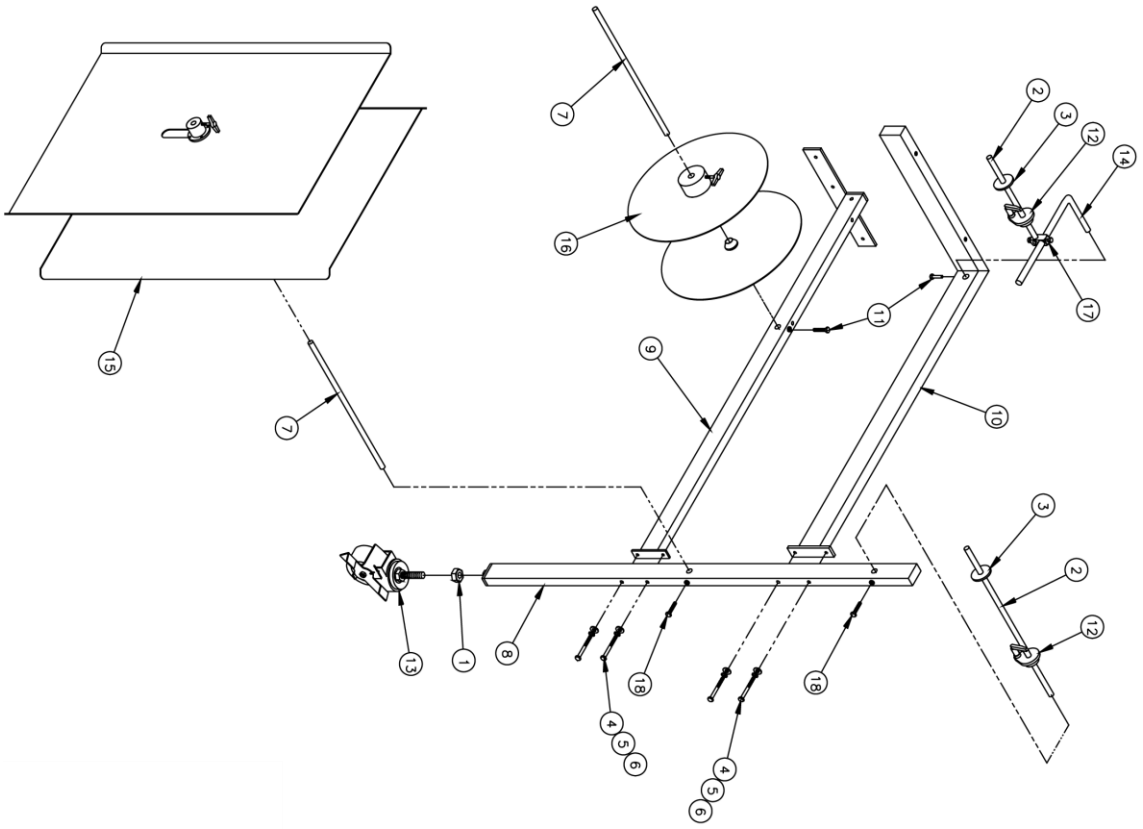
NO.	QTY	PART #	DESCRIPTION
1	1	1325-346	Rod Holder, 1/2
2	2	1325-346A	Rod Holder, 3/4
3	1	1335M-4003A	Support Brkt
4	1	1335M-4201	Frame Support
5	1	265155A	Eye Holder
6	1	1335-837	Rod, 1/2 U
7	3	AAF1/8	Plastic Clamp
8	1	FFQM42VN6A	Electric Eye
9	1	MM132-1496	End Cap
10	2	NNH3/8-16	Hex Nut
11	2	SSHC25160	Screw, Hex Cap
12	2	WWL3/8	Lock Washer
13	2	SSPS70048	Screw, Pan Head
14	6	SSSC01064	Screw, Socket Cap
15	3	SSZS93032	Screw, Sheet Metal
16	2	WWF4	Flat Washer
17	6	WWFS1/4	Flat Washer
18	4	WWFS3/8	Flat Washer
19	6	WWL1/4	Lock Washer



1335M-430E Guide Roller Assembly

ACC Drawing Number 9000912 Rev1

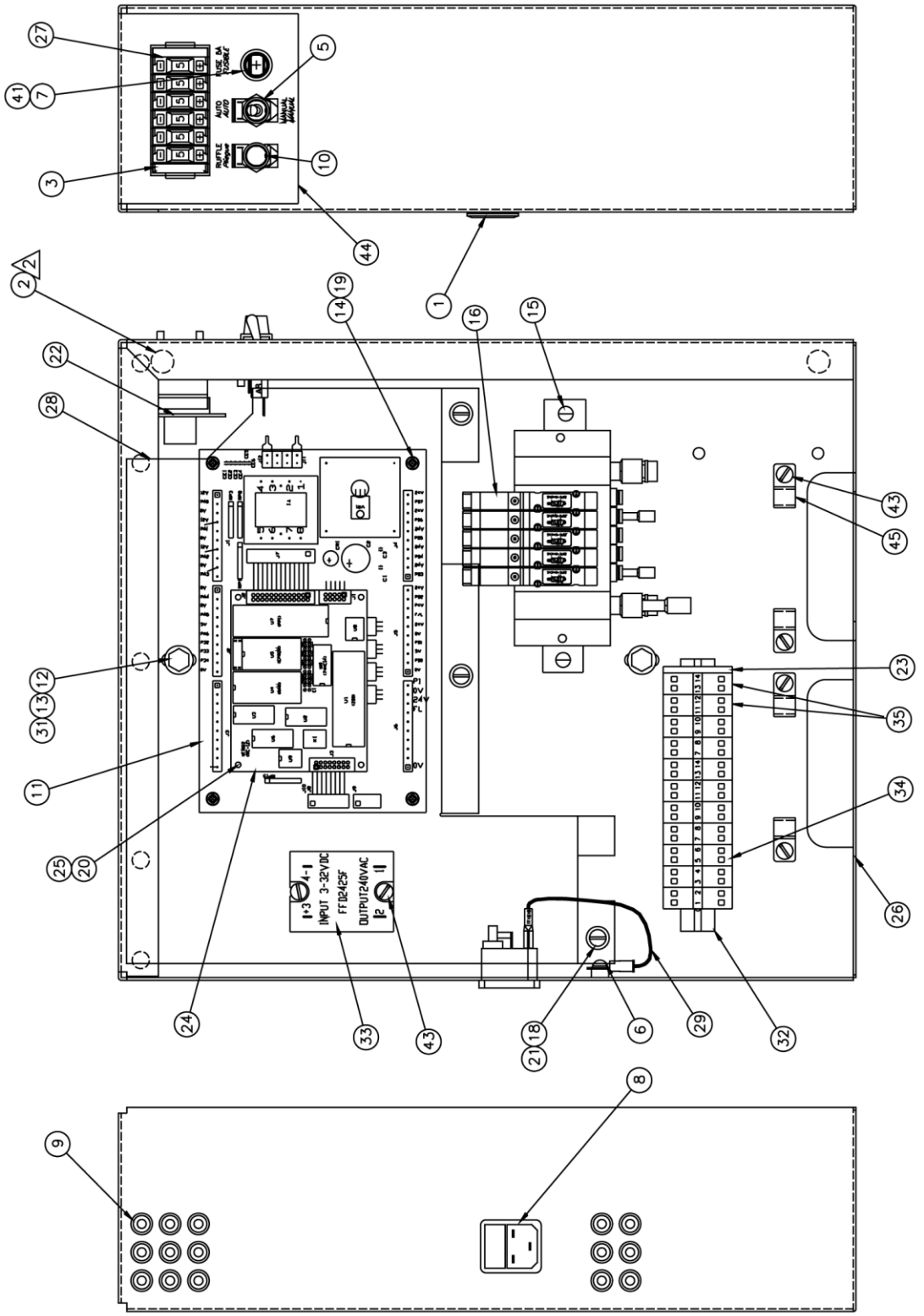
NO.	QTY	PART #	DESCRIPTION
1	1	1335-319B	ARM, 1/2" ROD CLAMP
2	1	1335-814E	ROLLER ASSY, 16 L, 2OD, .
3	1	1335-835E	ROD,BENT90DEG,1/2CRS,4X38
4	1	1335-838E	ROLLER ASSY W/FLANGE
5	2	28201	CROSS BLOCK, LARGE
6	1	28201A	CROSS BLOCK, LARGE
7	1	780-100	ROD,STRAIGHT,CRS,1/2
8	1	8732-0576	ROD, STRAIGHT, SS, 1/2 X
9	1	97-1711C	TUBE, 3/4 OD X 17.0L
10	1	97-1711E	TUBE, 3/4 OD X 24.0L
11	2	CCCL8F	CLAMP COLLAR- 1/2
12	2	SSHC10064	5/16-18 X 1" HEX HEAD
13	2	SSSC95048	#10-24 X 3/4 SOC CAP
14	1	SSSS01048	1/4-20 X 3/4 KNURL PT
15	3	TTH32425	HANDLE,THRDED,5/16-18X3/4
16	1	WWFS5/16	WASHER, FLAT, 5/16



1959-800 Roll Holder Assembly

ACC Drawing Number 192739C Rev4

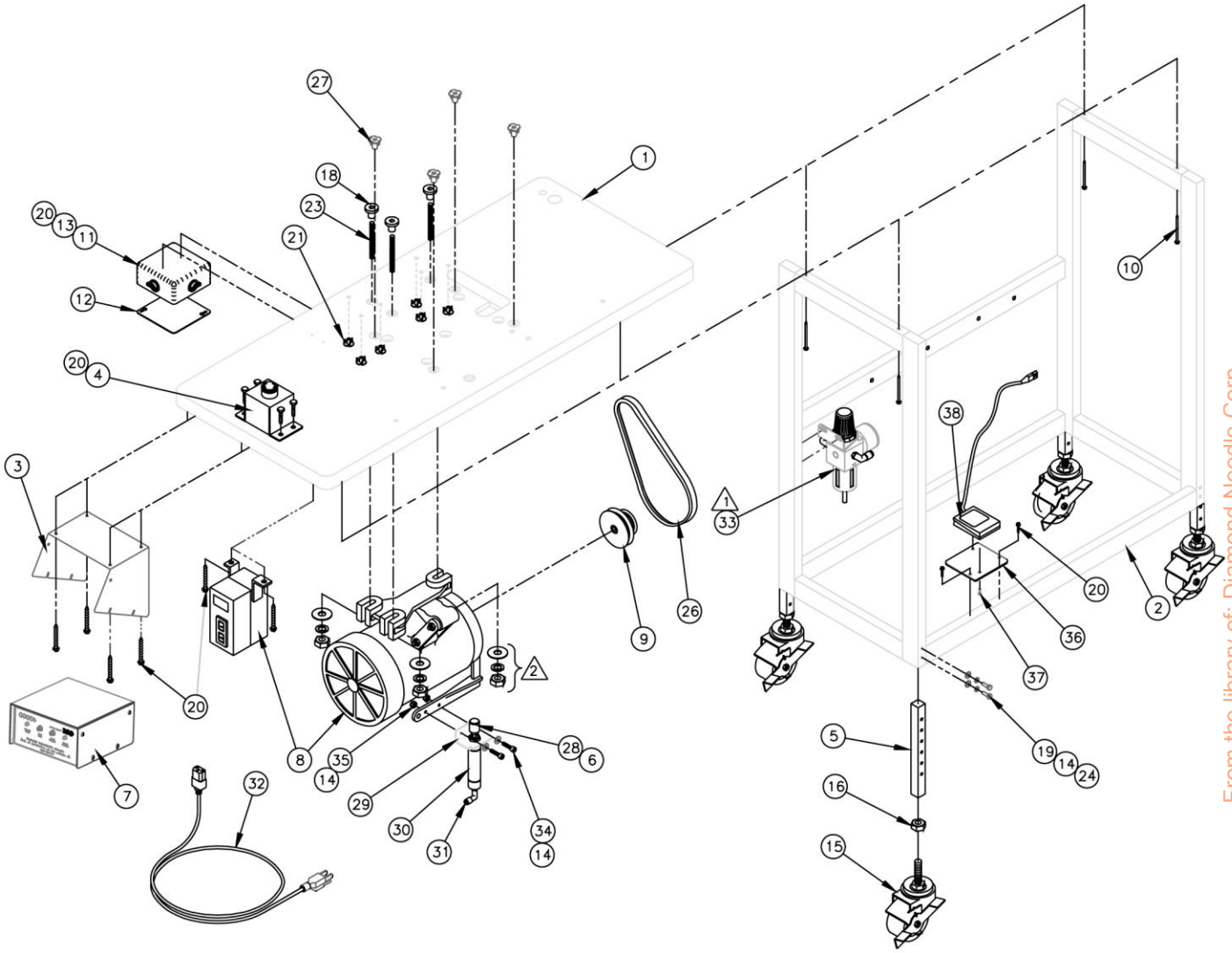
NO.	QTY	PART #	DESCRIPTION
1	1	NNH1/2-13	Hex Nut
2	2	1959-802	Rod, 3/8 x 28
3	2	A-4-024	Hub
4	4	SSHC01160	Screw, Hex Cap
5	4	WWL1/4	Lock Washer
6	4	WWFS1/4	Flat Washer
7	2	1959-101	Rod, 1/4 x 17
8	1	1959-105	Tube Assy
9	1	1959-106B	Tube w/ Flange
10	1	1959-107	Material Frame Assy
11	4	SSHC01080	Screw, Hex Cap
12	2	4009-1	Material Controler
13	1	MM503022LB	Caster
14	1	780-102	Rod, L, 1/2 x 6 x 12
15	2	785-A95-36	Disc Assy, 36”
16	2	786B16-2.2	Disc & Cone Assy
17	4	A-U	Rod Connector
18	2	SSHC10064	5/16- 18x1



1335MF-500 Control Box Assembly

ACC Drawing Number 192909B Rev11

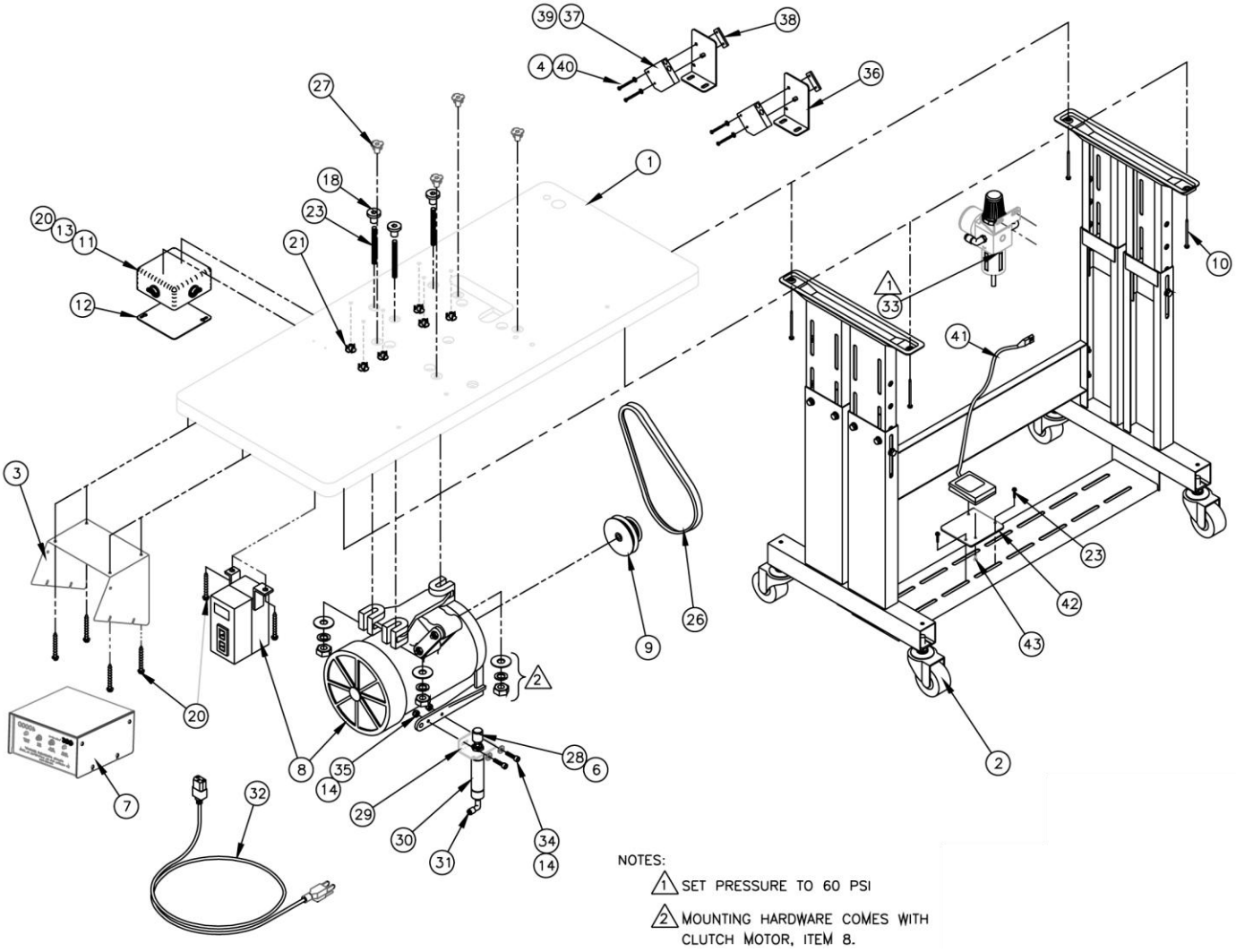
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	MM40450010	Slide Lock	28	1	1335M-501	Control Box Cover
2	2	MMSLD-ECH	Bumper	29	1	1981A-511	Ground Wire
3	1	FFC5S1	End Cap, Pair	30	1	EE7F3312	CEE Power Cord
4	1	1987149F3	Cable	31	2	WWFS1/4	Flat Washer SAE
5	1	FF2F385	Toggle Switch	32	1	FF264-3BKT6	Wago Mount
6	1	SSPS98016	Slotted Pan Screw	33	1	FFD2425F	Solid State Relay
7	1	FF342838A	Fuse Holder	34	9	FF264-341	Dual Wago, Grey
8	1	FF10ESB1C	Conn. Power Entry	35	2	FF264-347	Dual Wago, Grn
9	15	EESB-375-3	Heyco Bushing	36	1	FFRK44T-4	Eye Cable 12'
10	1	FF23F118	Push Button Switch	37	1	0211-703D	Puller Sync Cable
11	1	1987-149JC	PC Board	38	1	0211-705C	Treadle Cable
12	2	WWL1/4	Lock Washer	39	1	0211-705D	Remote Cable
13	2	SSHC01032	Hex Cap Screw	40	3	0411-1906B	Prox Switch Cable
14	4	SSPP80016	Pan HD Phillips Screw	41	1	FF313005	Slow Fuse, 5A
15	2	SSPS98032	Pan HD Slotted Screw	42	AR	SEE NEXT LEVEL	Wiring Diagram
16	1	AAE1335-5	Solenoid Assembly	43	6	SSPS90024	Pan Slotted Screw
17	1	1987-513A	Cable	44	AR	1335MF-LAB1	Control Box Lable
18	3	WWFS10	Washer SAE	45	4	AAF1/8	Plastic Clamps, 1/8"
19	4	FF67F4078	Threaded Spacer	46	1	AP-28-610UA	Cable, Jog/Dir/Enable
20	4	FF89F2609	Spacer	47	1	AP-28-612RA	Sync Cable Fl
21	3	SSPS98024	Pan HD Slotted Screw	48	1	FF250LA40A	MTL Oxide Varistor
22	1	1987-517	PC Board, THWL	49	6	SSPS90080	Pan Slotted Screw
23	1	FF264-371	End Cap Wago	50	2	1335-022	Cable, 3pin FM Molex
24	1	FF1035-02	PC Board, Isolation	51	1	1987149F5	Cable, Jumper
25	4	SSPP80096	Pan Phil. Screw	52	1	1987149F	Cable ribbon 26 Con.
26	1	1335M-505	Control Box Weldment	53	9	FF12F1042	Barrier Strip
27	6	FFC5.2LST1	Thumb Wheel Switches	54	AR	FF1024A-PGM	INS,FF1024A Pot Settings



1959-700A Table and Frame Assembly

ACC Drawing Number 192766C Rev3

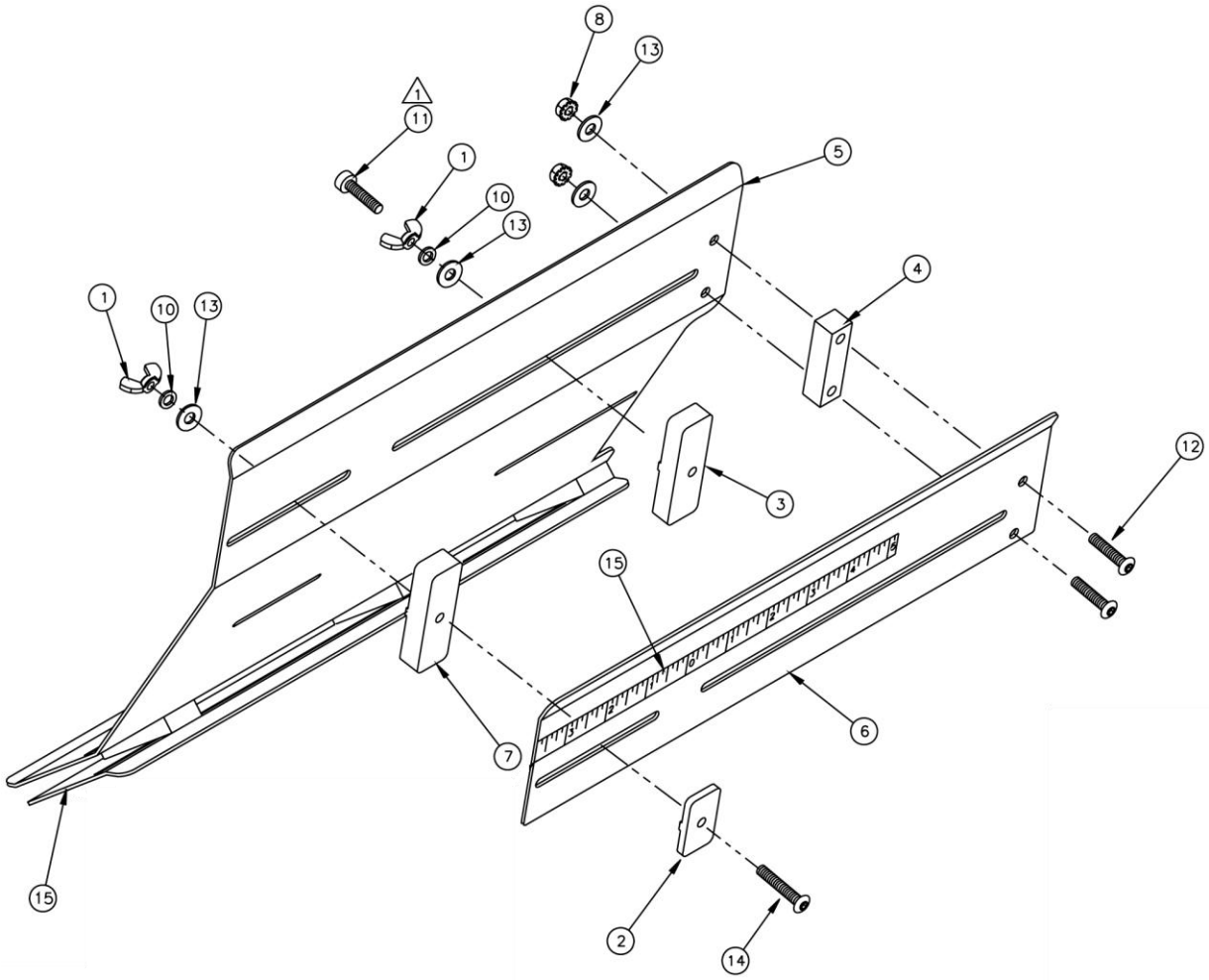
NO.	QTY	PART #	DESCRIPTION
1	1	1959-004	Table Top
2	1	1959-110	Stand
3	1	1959-120	Mount Brkt
4	1	213-005	Stop Button
5	4	26127	Leg
6	1	NNJ1/4-20	Jam Nut
7	1	4000D1-500	Control Box
8	1	4058-2	Motor
9	1	PPM616	Pulley
10	4	SSZH#10192	Sheet Metal Screw
11	1	K-233	Electical box
12	1	K-234	Cover
13	3	K-235	Romex Connector
14	12	WWFS1/4	Flat Washer
15	4	MM503022LB	Caster
16	4	NNH1/2-13	Hex Nut
17	7	NNH5/16-18	Hex Nut
18	7	NNM103	Recessed Nut
19	8	SSHC01048	Screw, Hex Cap
20	12	SSZH#10064	Screw, Sheet Metal
21	6	TTIW1/4-20	Threaded Insert
22	7	WWF5/16	Flat Washer
23	3	010-054	Threaded Rod
24	8	WWL1/4	Lock Washer
25	7	WWL5/16	Lock Washer
26	1	ZX3836	Belt
27	4	TTIW3/8-16	Recessed Nut
28	1	11200	Bumper
29	1	97-2602	Clutch Cylinder Brkt
30	1	AAC7DP-2	Air Cylinder
31	1	AAQME-5-8	Quick Male Elbow
32	1	EE37F3311	Power Cord
33	1	AA198-5/32	Air Regulator
34	2	SSSC01048	Screw, Socket Cap
35	2	NNK1/4-20	Kep Nut
36	1	1961-159	Foot Pedal Plate
37	2	SSFC80016	Flat Allen Screw
38	1	EE24F163	Foot Switch
39	AR	1334S-01WD	Wiring Diagram



1959-700B Table and Frame Assembly

ACC Drawing Number 192981C Rev4

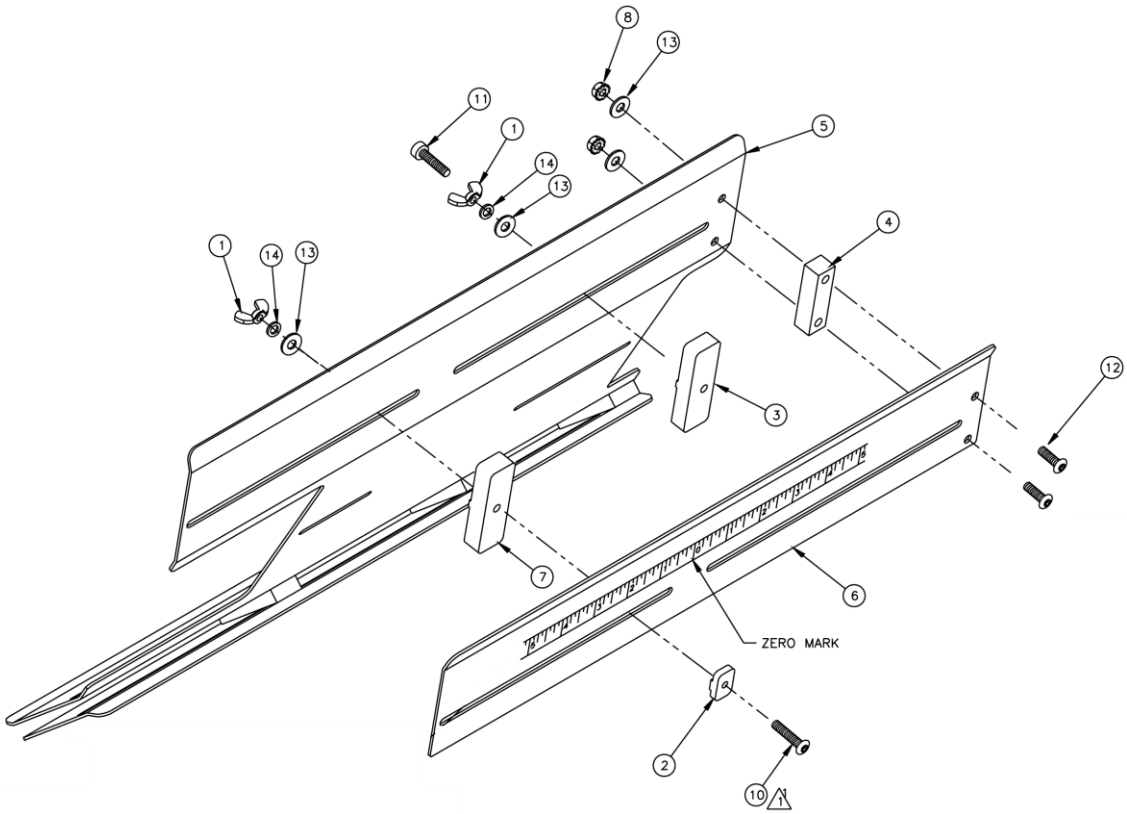
NO.	QTY	PART #	DESCRIPTION
1	1	1330222	Table Top
2	1	K-4D	Stand
3	1	1959-120	MNT BRKT
4	4	WWF4	Washer
6	1	NNJ1/4-20	Jam Nut
7	1	4000D2-500	Control Box
8	1	4058-2	Motor
9	1	PPM616	Pulley
10	4	SSZH#10192	Sheet Metal Screw
11	1	K-233	Elec. Box
12	1	K-234	Cover
13	3	K-235	Romex Conn
14	6	WWFS1/4	Flat Washer SAE
17	3	NNH5/16-18	Hex Nut
18	3	NNM103	Recessed Nut
20	12	SSZH#10064	Sheet Metal Screw
21	5	TTIW1/4-20	Threaded Insert
22	3	WWF5/16	Flat Washer
23	3	010-054	THD Rod, 5/16-18x3.25L
25	3	WWL5/16	Lock Washer
26	1	ZX3836	Belt
27	4	TTIW3/8-16	Recessed Nut
28	1	11200	Bumper
29	1	97-2602	Clutch Cylinder BRKT
30	1	AAC7DP-2	Air Cylinder
31	1	AAQME-5-8	Quick Male Elbow
32	1	EE37F3311	Power Cord
33	1	AA198-5/32	Air Regulator
34	2	SSSC01048	Socket Cap Screw
35	2	NNK1/4-20	Kep Nut
36	2	1278-6689B	Eye Mount
37	2	FFQM42VN6A	Eye
38	2	1975-412A	Nut Plate
39	2	FFRK44T-4	Cable
40	4	SSPS70048	Pan HD Slotted Screw
41	1	EE24F163	Treadlite Footswitch
42	1	1961-159	Foot Pedal Plate
43	2	SSFS80016	Flat Slotted Screw



A-2216K5/16 Flat Folder W/Flange

ACC Drawing Number 192836C Rev3

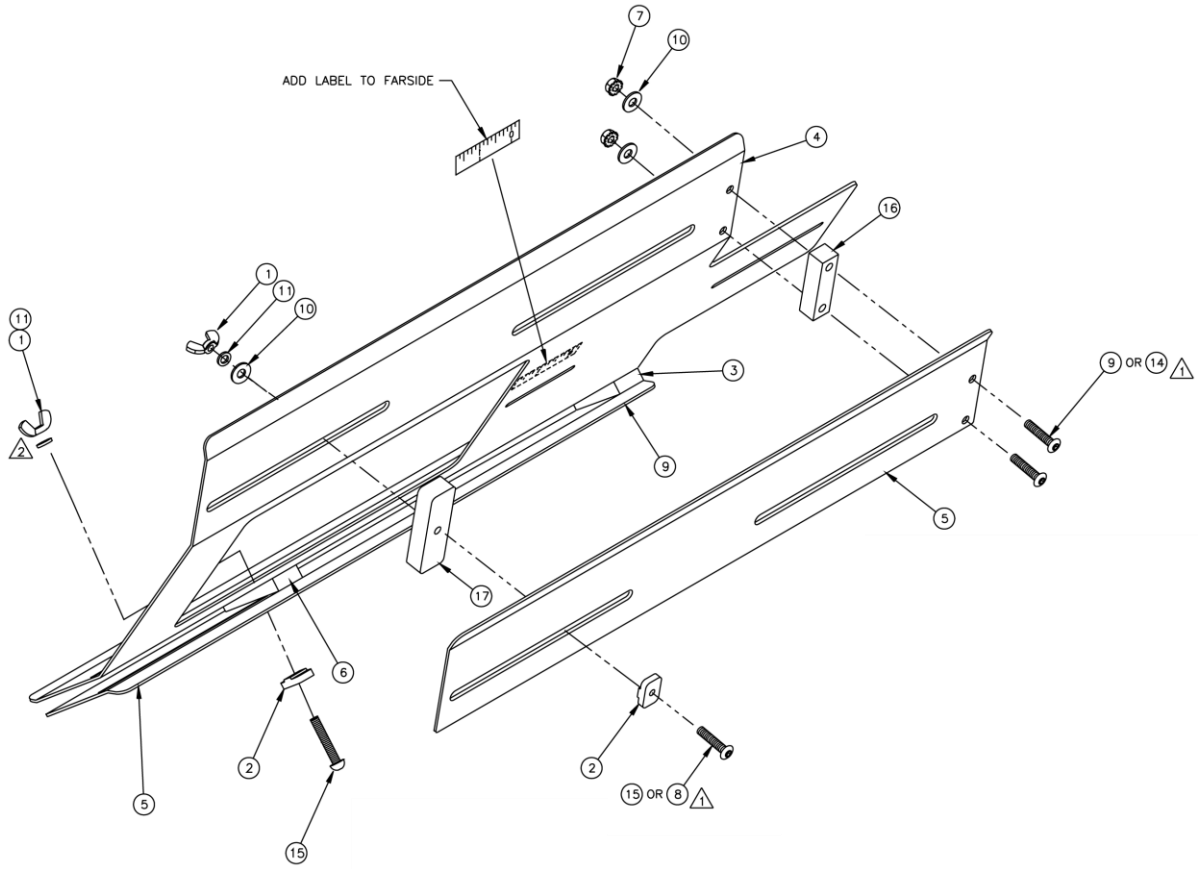
NO.	QTY	PART #	DESCRIPTION
1	4	NNW10-32	Wing Nut
2	2	A-2216D22	T-Nut
3	2	A-2216D53	Spacer, 1/4
4	2	A-2216G29	Spacer, 5/16
5	1	A-2216K02	Folder Plate
6	2	A-2216K04	Folder Top
7	2	A-2216D34	Guide, 5/16
8	4	NNK10-32	Kep Nut
10	4	WWL10	Lock Washer
11	2	SSSC98040	Screw, Socket Cap
12	4	SSBC98048	Screw, Button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



A-2216L5/16 Euro Folder W/Flange

ACC Drawing Number 192823C Rev3

NO.	QTY	PART #	DESCRIPTION
1	6	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-2216L02	Folder Plate
6	2	A-2216L04	Folder Top
7	2	A-2216D34	Guide, 5/16
8	4	NNK10-32	Kep Nut
10	2	SSBC98064	Screw, Button Cap
11	2	SSSC90040	Screw, Socket Cap
12	6	SSBC98048	Screw, Button Cap
13	8	WWFS10	Flat Washer
14	8	WWL10	Lock Washer
15	AR	1335A-302	Rule Label
16	2	A-2216D37	Left Folder Guide
17	2	A-2216D55	Folder Guide
18	2	A-2216G30	Folder Spacer
19	2	SSBC98056	Button Cap Screw

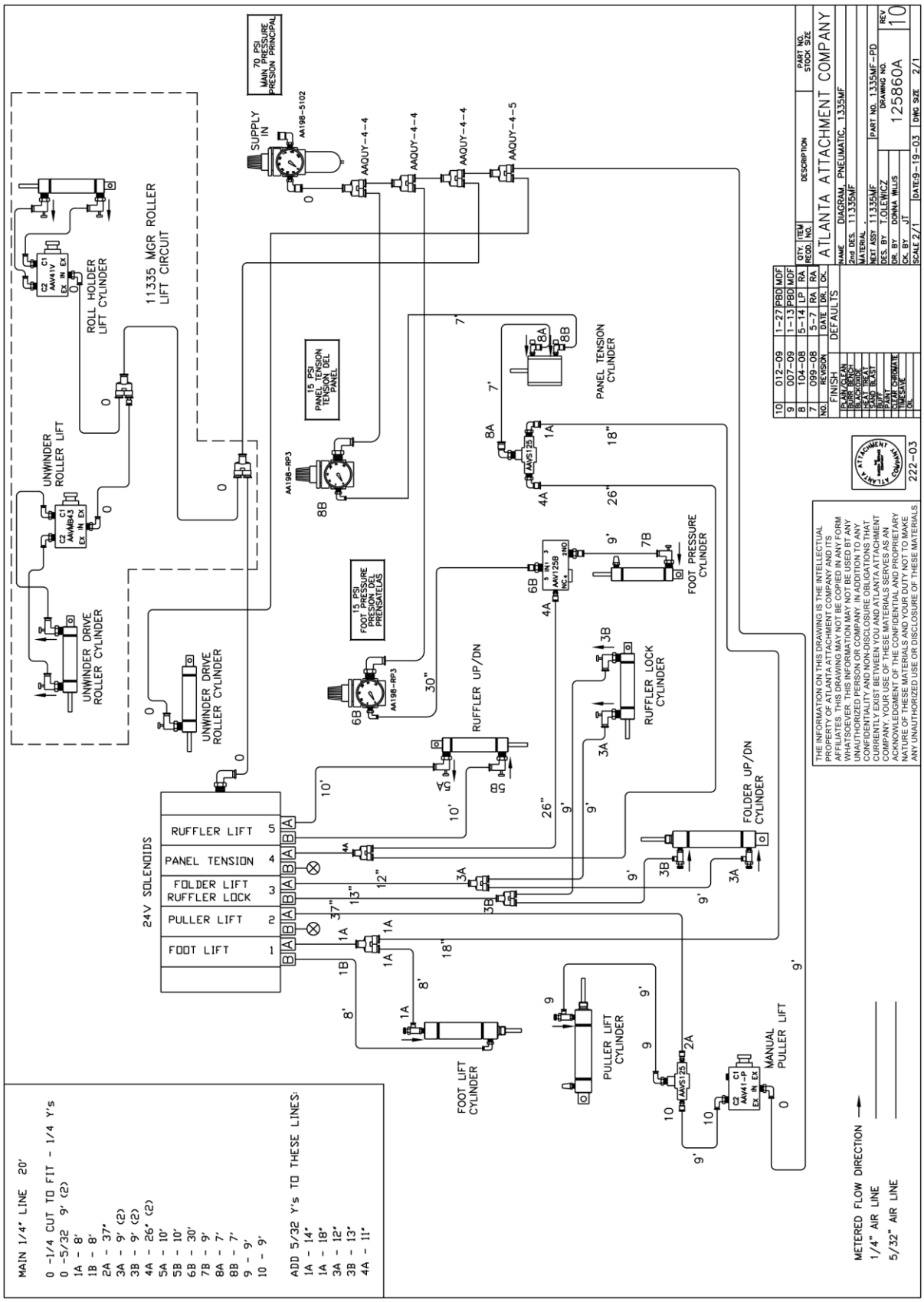


A-2216M5/16 Continental Book Folder

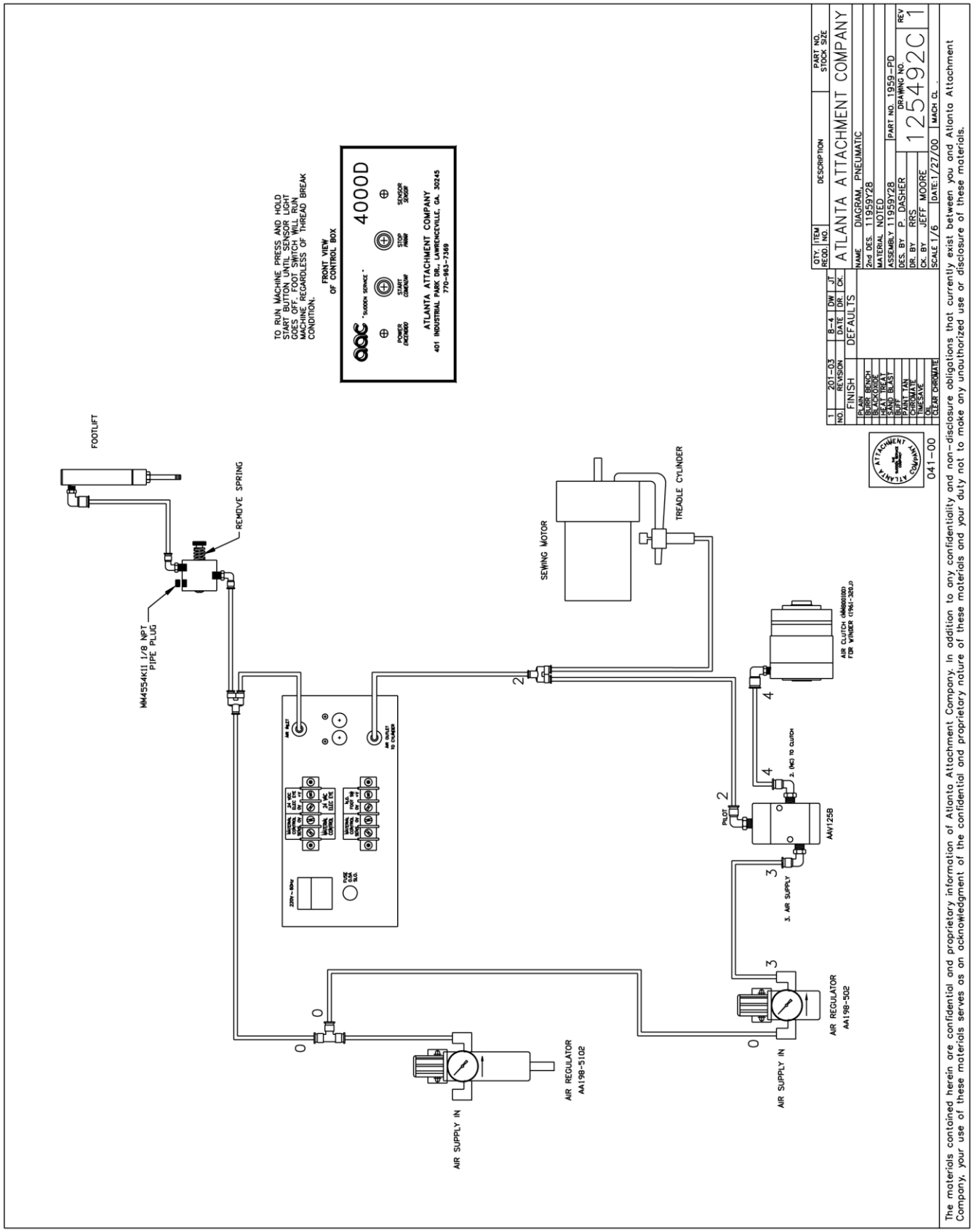
ACC Drawing Number 192824C Rev6

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

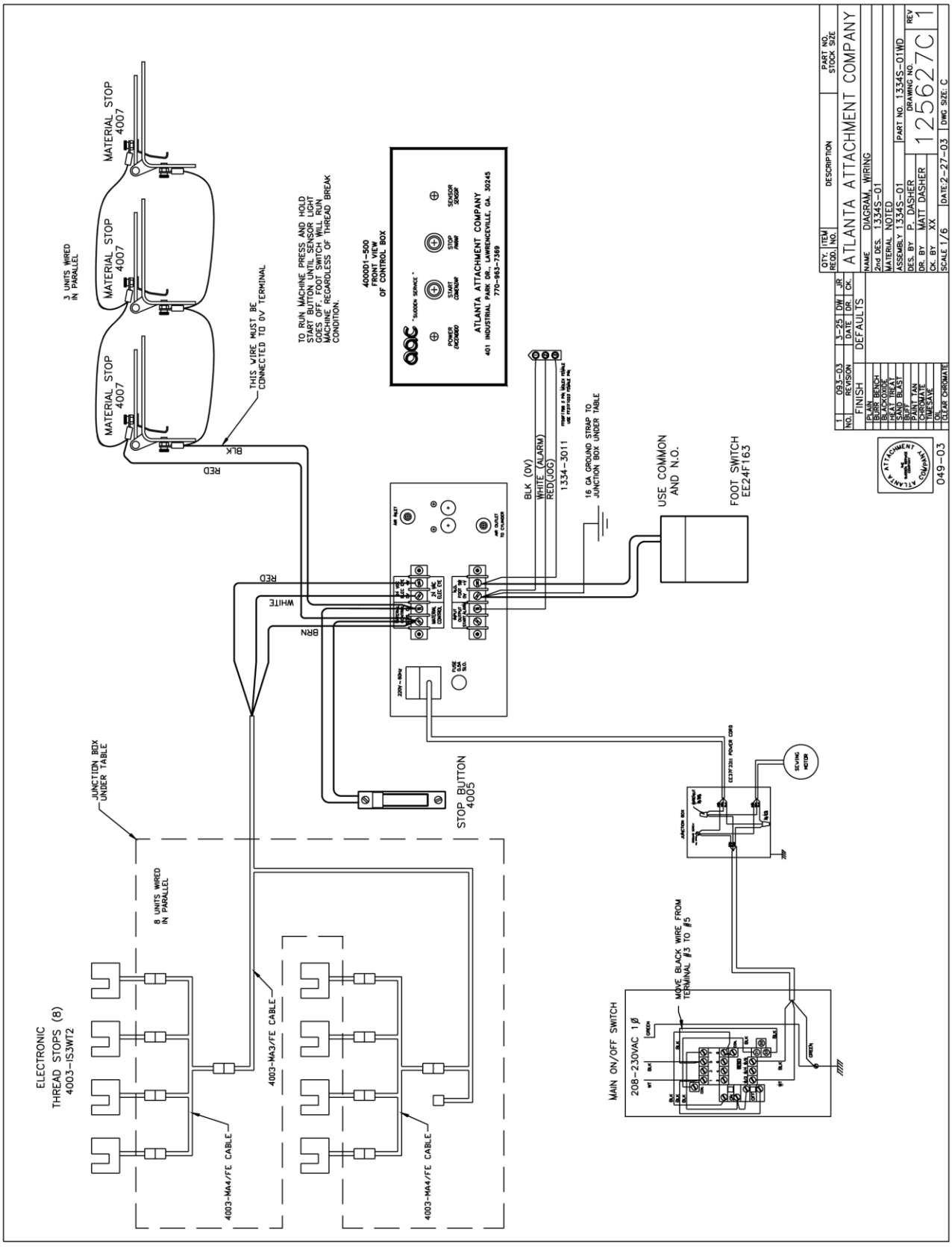
1335MF-PD Pneumatic Diagram



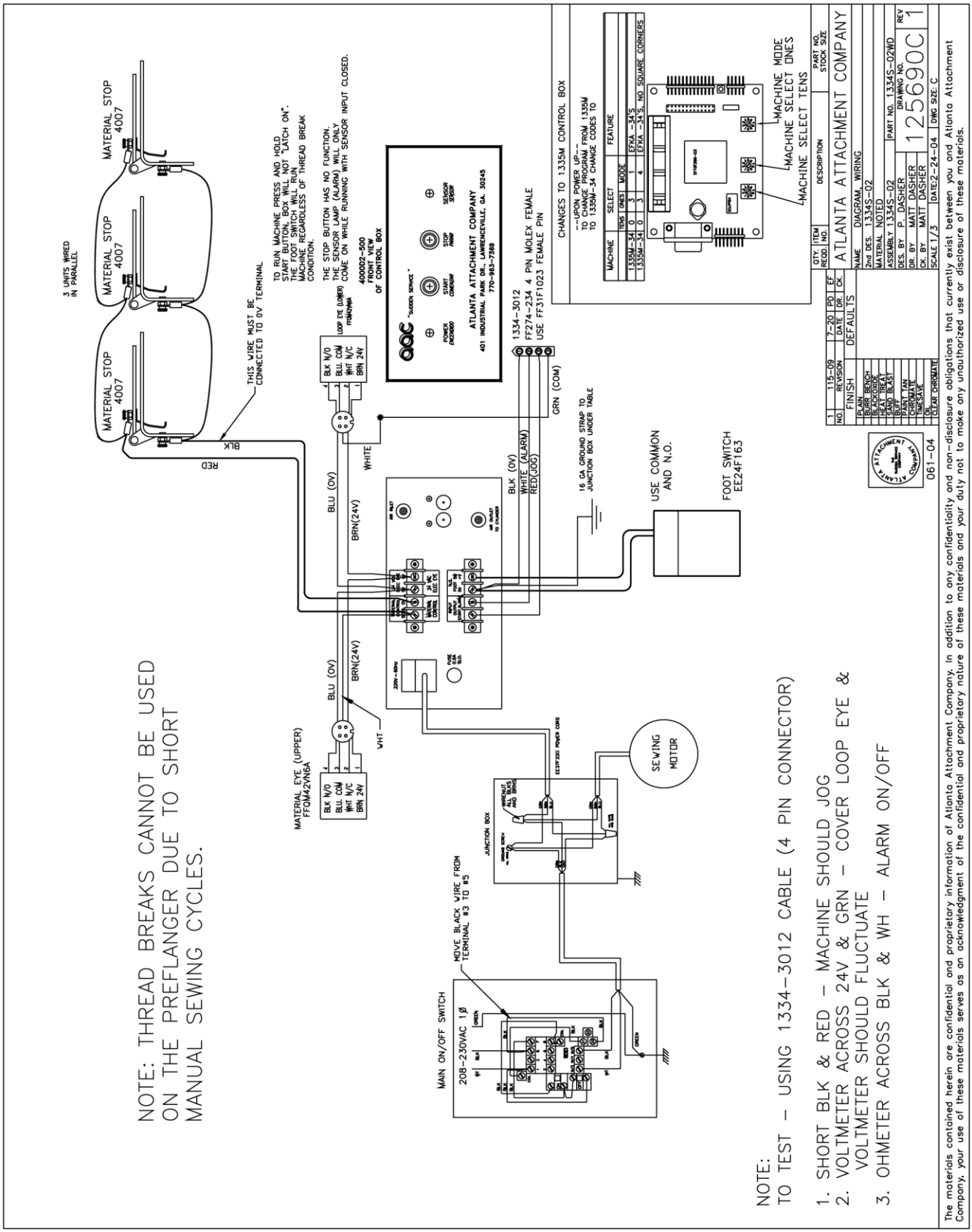
1959-PD Pneumatic Diagram



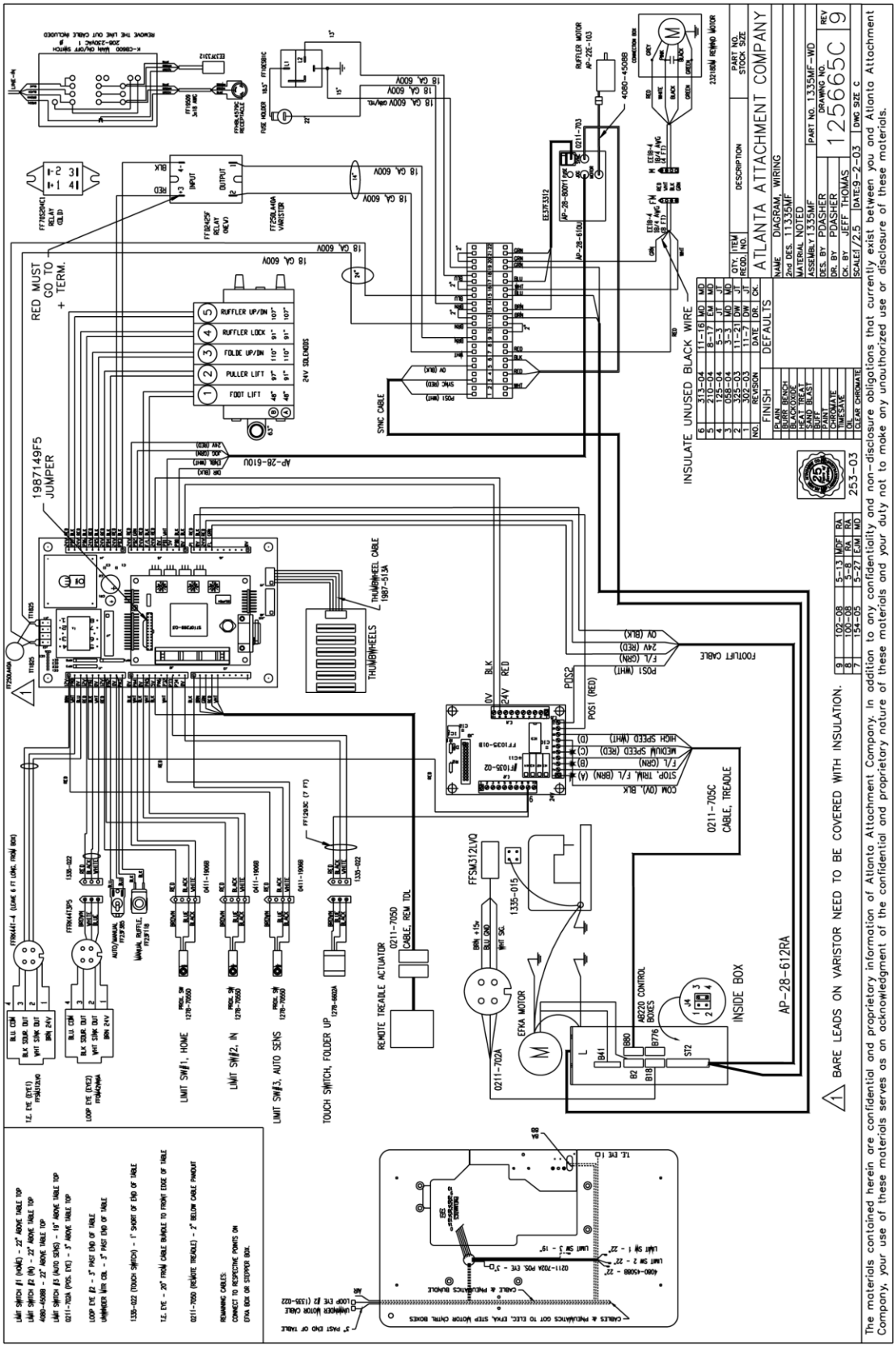
1334S-01WD Wiring Diagram



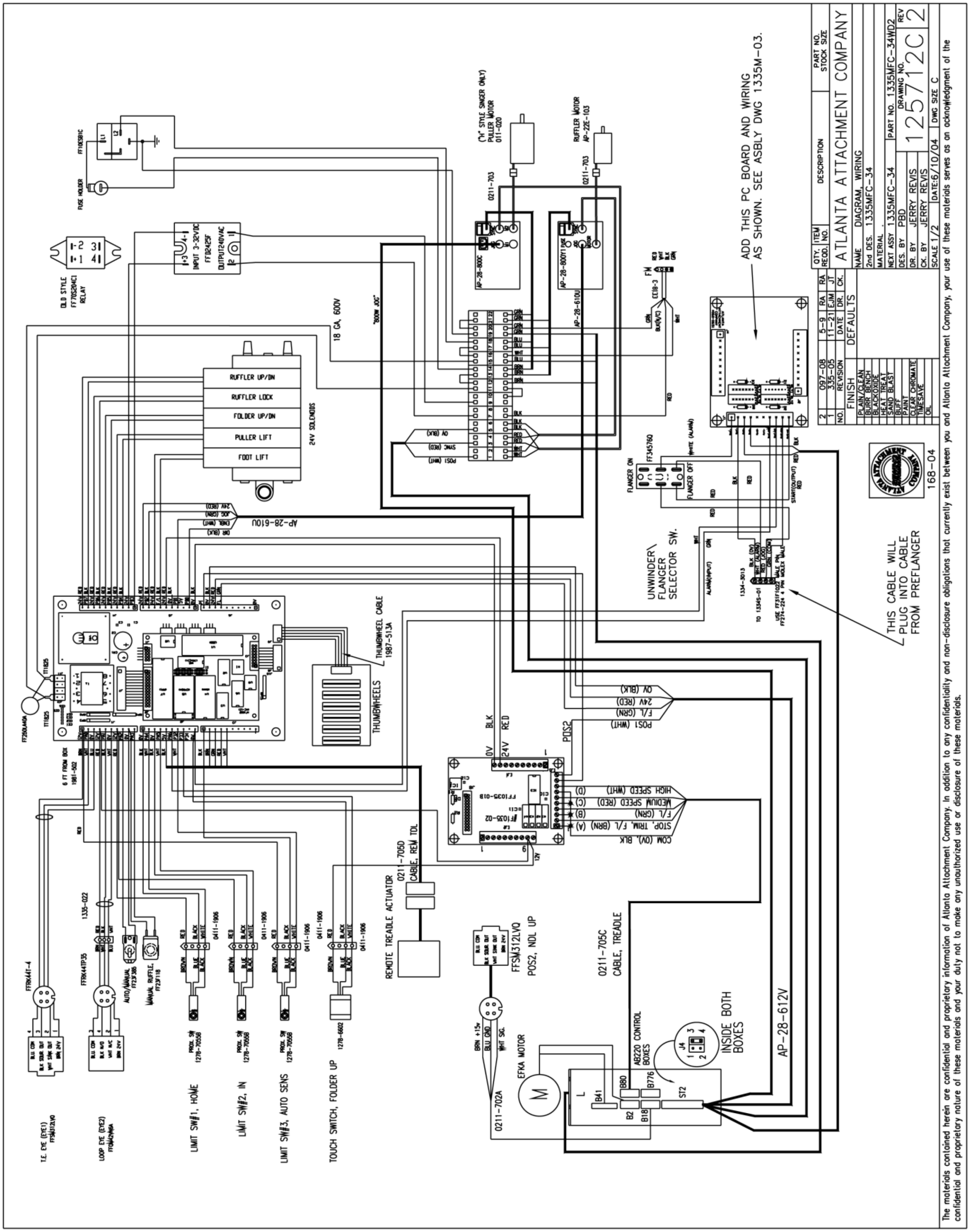
1334S-02WD Wiring Diagram



1335MF-WD Wiring Diagram



1335MFC-34WD2 Wiring Diagram



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 Garantia

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libres de defectos de mate-rial 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 prim-ero.
- 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 cual-quier 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 peri-odo de ochocientas (800) horas.
- Componentes mecánicos que fallen por defectos de materiales o de fabricación que han sido manu-facturados 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 neumáti-cas.
- 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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