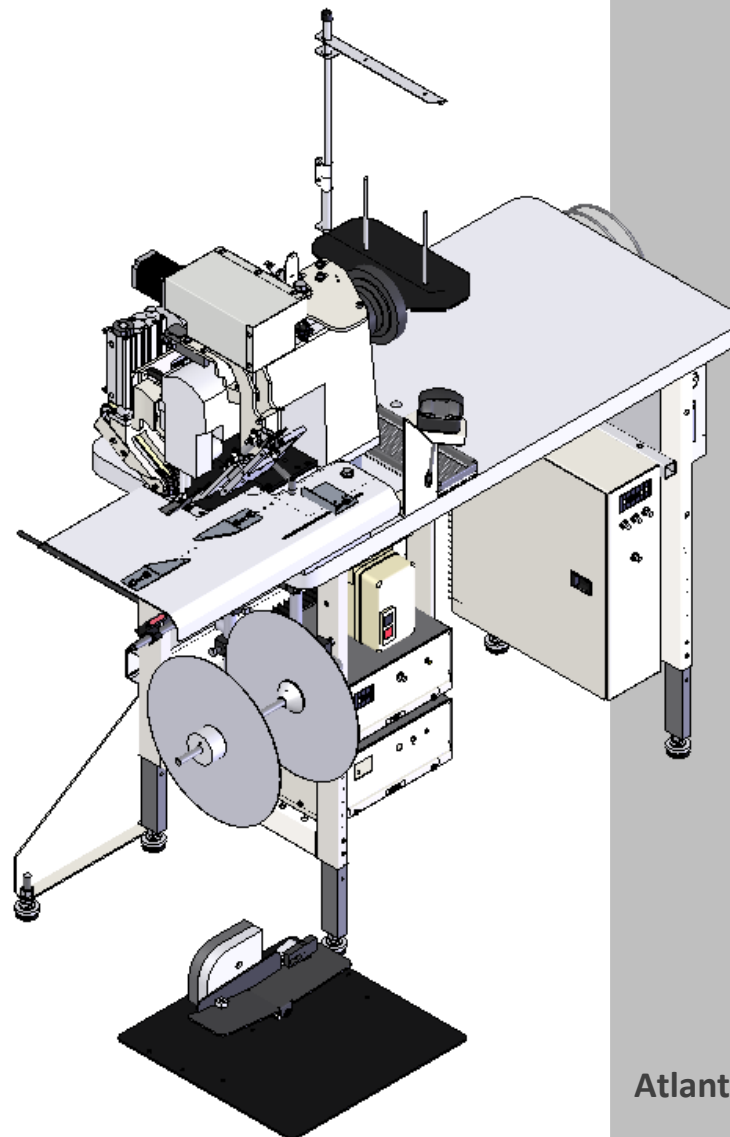




Model **1335 MHP-SU**

Revision 0 Created May 30, 2012

# Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

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## Important Safety Instruction



This part of the Instruction Material is provided for the safe use of your equipment. It contains important information to help work safely with the unit and describes the dangers inherent in machinery. Some of these dangers are obvious, while others are less evident.

### Mandatory Information

All persons operating and/or working on the 1335MHP-SU manual ruffler, Heavy duty 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.

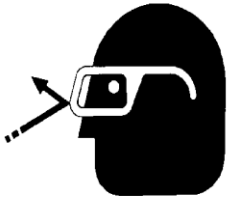
## Signs on the Machine

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.

Tighten 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.

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## 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 attempt to make any adjustments or repairs to the machine while running. Repairs or maintenance should be performed by trained personnel only.
- NEVER work under the machine unless it is safely supported with stands, blocks or a hoist and blocks.
- NEVER touch hot parts of machine.



## General Machine Data

### Electrical & Pneumatic Specifications

Electrical:	220 VAC, 5amp, 50/60 Hz Single Phase
Pneumatic:	70-80 PSI, 2 SCFM avg.
Sewing Head:	Singer 300UX5
Sewing Speed:	3500 RPM
Needle (Standard):	SN62X8524
Stitch Density:	4-5 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.

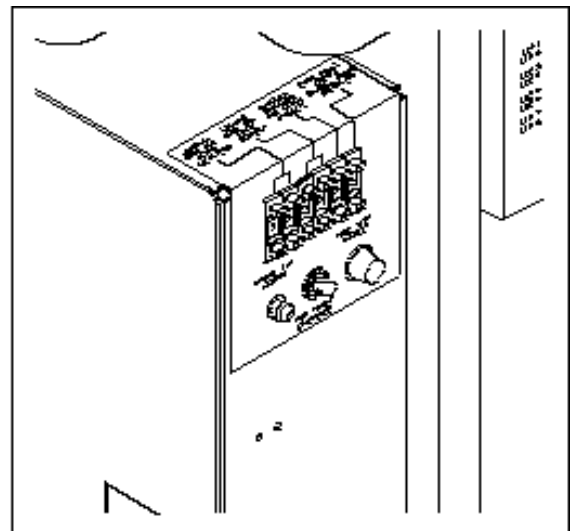
**Note: The on/off switch only switches one line and does not make the box safe to work on. Always disconnect the main power cord before servicing the control box.**

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 push button 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 heeled 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.



### 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 have no functions

The fifth thumbwheel sets the number of ruffles to be sewn in the corner.

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 Box

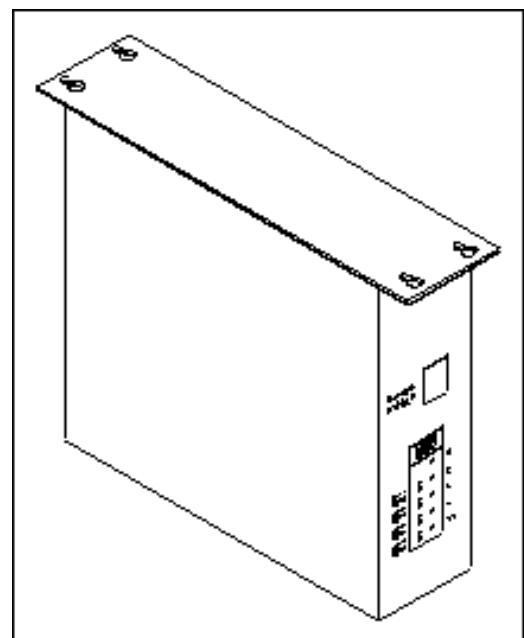
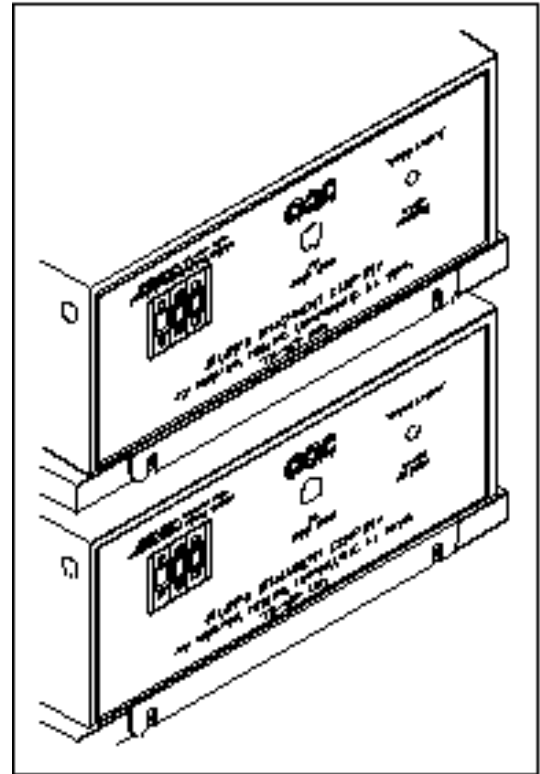
There is a stepping motor box located under the table.

The Ruffler box has three Thumbwheels on the front which are set to synchronize the Ruffler to the sewing head. The number is proportional to the stitch LENGTH and is not affected by sewing speed. The 10-turn potentiometer is used to set the speed of the Ruffler during the feed in to pleat and feed out to make the next ruffle. It is set to maximum and is locked in place by a small locking lever. Unlock to adjust. The box has its own on/off switch on the back where the power cord plugs in. Leave this switch on all the time.

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

### Efka Control Box

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).



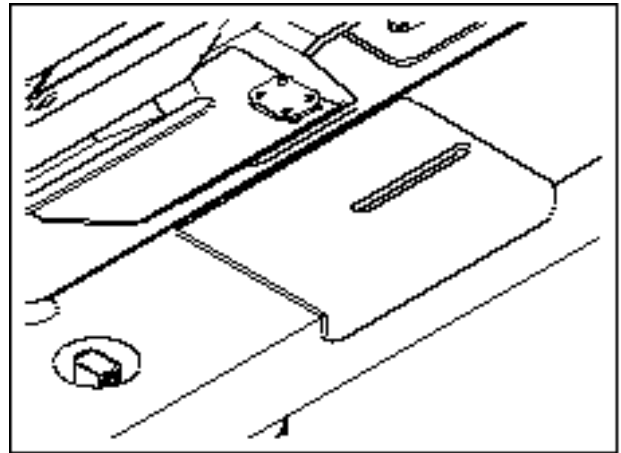
## Efka Control Box Settings

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 make 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.

## Basic Machine Operation

### 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 border. This is the guide for alignment of the ruffles left to right.



### Making the Ruffles

Heal back to lift the foot and puller and load the "bucket" onto the sewing machine with the bottom panel to the left and the right edge of the border against the edge guide. If flanging is also being added, be sure the flange is under the foot also. Sew up to the first corner, stopping at a predetermined point marked on the cloth plate. Activate the "wipe" switch to turn on the ruffler. Sew the corner ruffles and continue to the next corner. Repeat for all four corners. Heal back to lift the foot and remove the border from the machine and cut the flange free.

### Adjusting the Corner Ruffles

The ruffles should be set so the outer edge of the border lays flat for taping. A typical ruffled corner 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.

# 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.

## 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.

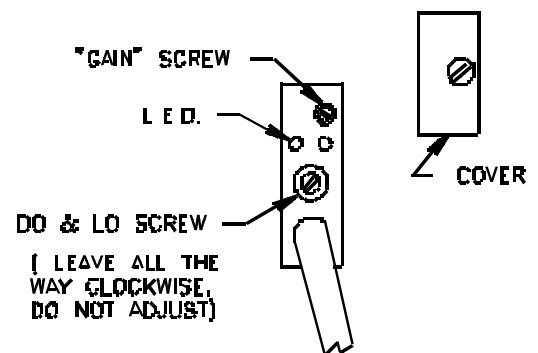
### Weekly

- 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.

# Parameter Settings for Efka Controller

1335M EFKA Motor Parameter List

PARAMETER	RANGE	MITSUBISHI LOCHSTITC H	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 Mode (Lockstitch) of operation. <b>MUST SET THIS PARAMETER FIRST!</b>
290		0	5	5	5	5	
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 Riboldi, setting should be 124)
<b>Front panel LED's:</b>							
LED 1:	Off						<b>Programming Instructions:</b>
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.
							<b>8. Run sewing head to save parameters before powering down</b>
							<b>To Perform Master Reset of Parameters:</b>
							1. Power on holding down the "P" button till "COD" is displayed.
							2. Press ">>" once and enter the number "591"
							3. Press "E" twice and "093" is displayed.
							4. Press "+" once, "094" is displayed.
							5. Press "P" to exit programming mode with all default values.

# 1335M Folder Spacer Reference Chart

QUANTITY	ASBLY#	PREFLANGED, OFFSETABLE, 6" CAPACITY A-2216K								PREFLANGED, OFFSETABLE, 9" CAPACITY A-2218L								CONTINENTAL BORDER A-2218M							
		1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1/8"	1/4"	3/8"	1/2"	5/8"	3/4"	1/8"	1/4"	3/8"	1/2"	5/8"	3/4"	1"			
	PART#	DESC.																							
	A-2218D40	L. GUIDE, 1/8 KEYED, ALU																							
	A-2218D32	L. GUIDE, 3/16 KEYED, ALU																							
	A-2218D33	L. GUIDE, 1/4 KEYED, ALU																							
	A-2218D34	L. GUIDE, 5/16 KEYED, ALU																							
	A-2218D35	L. GUIDE, 3/8 KEYED, ALU																							
	A-2218D37	L. GUIDE, 7/16 KEYED, ALU																							
	A-2218D38	L. GUIDE, 1/2 KEYED, ALU																							
	A-2218D39	L. GUIDE, 9/16 KEYED, ALU																							
	A-2218D59	L. GUIDE, 5/8 KEYED, ALU																							
	A-2218D60	L. GUIDE, 11/16 KEYED, ALU																							
	A-2218D61	L. GUIDE, 3/4 KEYED, ALU																							
	A-2218D65	R. GUIDE, 7/8 KEYED, ALU																							
	A-2218D30	L. GUIDE, 1", KEYED, ALU																							
	A-2218D58	R. GUIDE, 1/8 KEYED, THDED																							
	A-2218D51	R. GUIDE, 1/8 KEYED, THDED																							
	A-2218D52	R. GUIDE, 3/16 KEYED, THDED																							
	A-2218D53	R. GUIDE, 1/4 KEYED, THDED																							
	A-2218D54	R. GUIDE, 5/16 KEYED, THDED																							
	A-2218D55	R. GUIDE, 3/8 KEYED, THDED																							
	A-2218D56	R. GUIDE, 7/16 KEYED, THDED																							
	A-2218D57	R. GUIDE, 1/2 KEYED, THDED																							
	A-2218D62	R. GUIDE, 5/8 KEYED, THDED																							
	A-2218D63	R. GUIDE, 5/8 KEYED, THDED																							
	A-2218D64	R. GUIDE, 11/16 KEYED, THDED																							
	A-2218G14	SPACER, 1/16(2 HOLE)																							
	A-2218G24	SPACER, 1/8(2 HOLE)																							
	A-2218G32	SPACER, 3/16(2 HOLE)																							
	A-2218G33	SPACER, 1/4(2 HOLE)																							
	A-2218G29	SPACER, 5/16(2 HOLE)																							
	A-2218G21	SPACER, 3/8(2 HOLE)																							
	A-2218G30	SPACER, 7/16(2 HOLE)																							
	A-2218G31	SPACER, 1/2(2 HOLE)																							
	A-2218G34	SPACER, 9/16(2 HOLE)																							
	A-2218G41	SPACER, 5/8(2 HOLE)																							
	A-2218G42	SPACER, 11/16(2 HOLE)																							
	A-2218G43	SPACER, 3/4(2 HOLE)																							
	A-2218G36	SPACER, 7/8(2 HOLE)																							
	A-2218G35	SPACER, 1"(2 HOLE)																							
	SSBC08024	SCREW, 10-32 X 3/8																							
	SSBC08032	SCREW, 10-32 X 1/2																							
	SSBC08040	SCREW, 10-32 X 5/8																							
	SSBC08048	SCREW, 10-32 X 3/4																							
	SSBC08056	SCREW, 10-32 X 7/8																							
	SSBC08064	SCREW, 10-32 X 1																							
	SSBC08072	SCREW, 10-32 X 1-1/8																							
	SSBC08080	SCREW, 10-32 X 1-1/2																							
	1.5" WIDE GUIDES																								
	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																							

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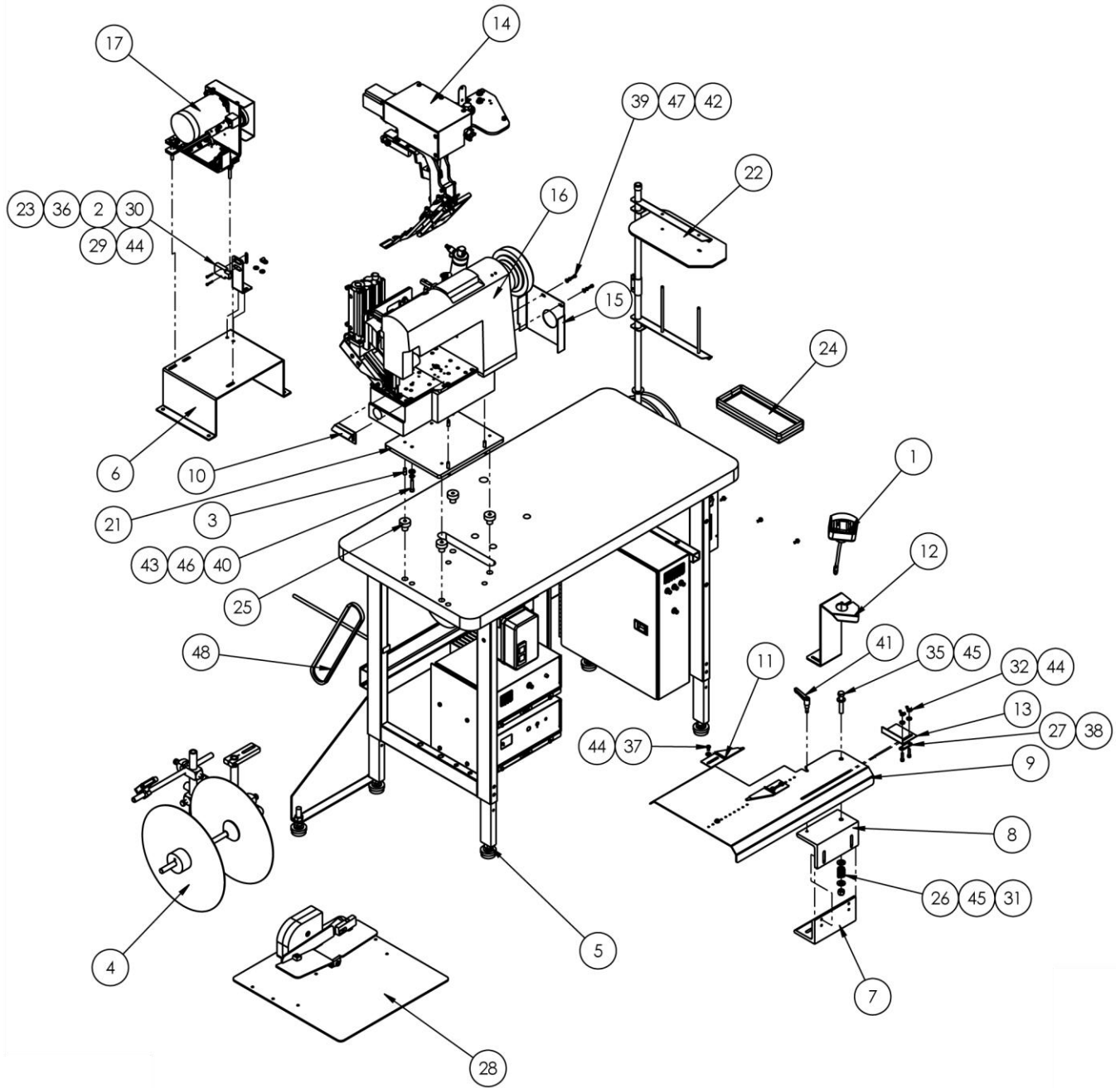


## Assembly Drawings & Parts Lists

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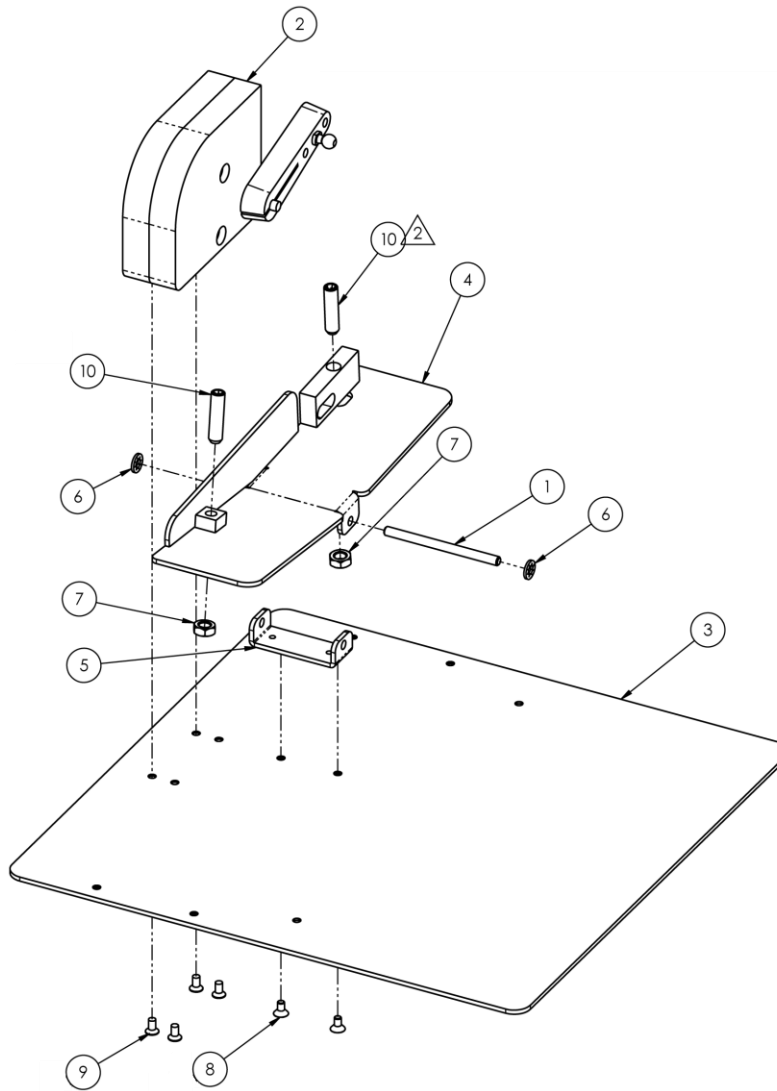


# 11335MHP-SU Manual Ruffler, Heavy Duty

AAC Drawing Number 9001817 Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1	1278-6602A	TOUCH SWITCH ASSY W/3 PIN
2	1	1278-6689B	BRACKET, EYE MOUNT
3	4	1335-408	STUD, THREADED, 1/4-20
4	1	1335575	ROLL HOLDER ASBLY
5	1	1335866	STAND AND MOTOR ASSEMBLY
6	1	1335883	MOUNT, PULLER DRIVE
7	1	1335884	MOUNT , TABLE GUIDE
8	1	1335885	MOUNT , SWING OUT
9	1	1335886	CLOTH PLATE, SWING OUT
10	1	1335887	PLATE, CLOTH SUPPORT
11	2	1335890	EDGE GUIDE, LEFT
12	1	1335891	BRKT,OPTO TOUCH SWITCH
13	1	1335892	EDGE GUIDE, BORDER
14	1	1335894	RUFFLER ASSY
15	1	1335896	COVER, BELT GUARD
16	1	1335A-10B	SEWING HEAD ASSY,300UX5
17	1	1335M-120	PULLER DRIVE ASSY
18	*1	1335M-2002E	BLADE,RUFFLER
19	1	1335MHP-PD	DIAGRAM, PNEUMATIC
20	1	1335MHP-WD	DIAGRAM, WIRING
21	1	1338112	PLATE,ADAPTER,1338
22	1	1959-112	2 POS THREAD PLATE ASSY
23	1	1975-412A	PLATE,NUT,4-40,.95CTC
24	1	26151	TOOL TRAY, 1X3.5X9
25	4	228444	MACHINE CUSHION
26	1	273-4F	SPRING,CMP,.09X.16X.38X.7
27	1	40-583	PLATE,NUT,10-32@1.00 CTC
28	1	4059-FP301D	FOOT PEDAL ASSY,EFKA
29	1	AAF3/16	CLAMP, BLACK PLASTIC
30	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
31	1	NNE3/8-16	NUT, ELASTIC 3/8-16
32	2	NNW10-32	#10-32 WING NUT
33	1	PTS2	THREAD STAND
34	*10	SN62X8524	NEEDLE,SIZE 180/24
35	1	SSH25144	3/8-16X2-1/4 HEX CAP SC
36	2	SSPS70048	#4-40 X 3/4 PAN HD SLOT
37	4	SSPS98024	10-32X3/8 PAN HD SLOT
38	2	SSSC98048	10-32 X 3/4 SOC CAP
39	2	SSSCM4X10	SCREW,SOC CAP,M4-0.7X8
40	4	SSSCM6X30	M6X30 SOC CAP SCREW
41	1	TTH32415	HANDLE,THREADED,1/4-20X7/
42	2	WWF6	DO NOT USE - SEE WWFS6
43	4	WWFS1/4	WASHER,FLAT,SAE,1/4
44	8	WWFS10	WASHER, FLAT, #10, SAE
45	3	WWFS3/8	WASHER,FLAT,SAE,3/8
46	4	WWL1/4	WASHER,LOCK,1/4
47	2	WWL8	WASHER,LOCK,#8
48	1	ZX3830	V-BELT,3/8 X 30

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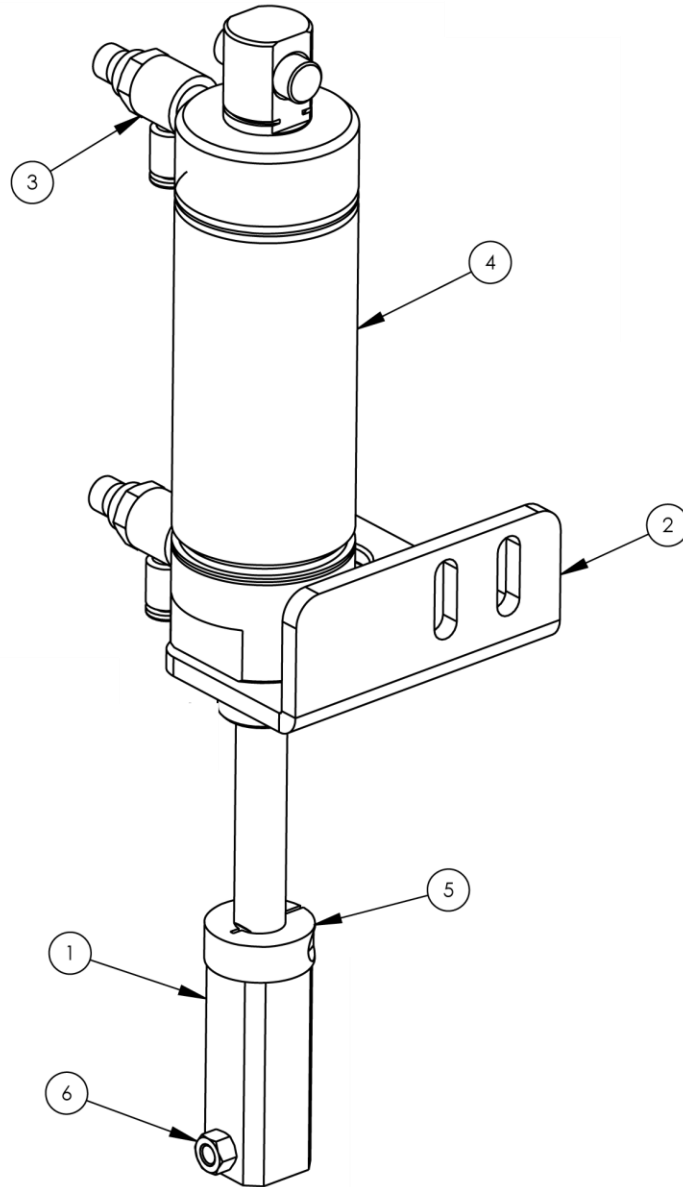


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## 4059-FP301D Foot Pedal Assembly

AAC Drawing Number 9000033 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	26058	ROD, STRAIGHT, 1018
2	1	4059-2-22A	REMOTE ACTUATOR
3	1	4059030	PEDAL, FOOT PEDAL, 12X18
4	1	4059033	FOOT PEDAL WELDMENT
5	1	A3502-4	FOOT PEDAL, BRACKET
6	2	MM94807A029	PUSHNUT, ROUND, 1/4 DIA
7	2	NNJ3/8-16	3/8-16 HEX JAM NUT
8	2	SSFC98024	#10-32 X 3/8 FLAT ALLEN
9	4	SSFPM5X10	M5-0.80 X 10 FLAT PHILLIPS
10	2	SSSS25096	3/8-16 SET SCREW, 1-1/2"

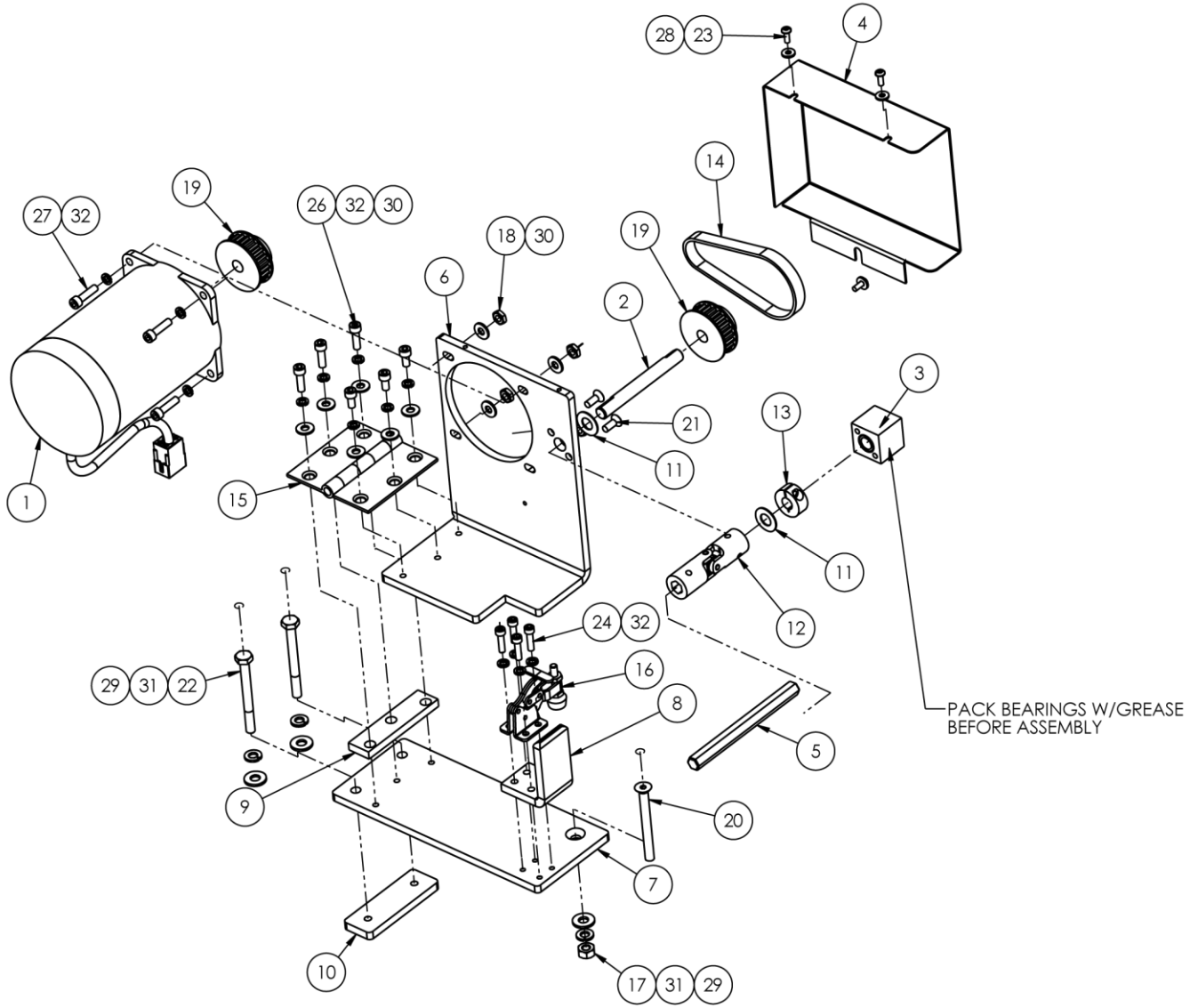


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## 1335-110B Footlift Assembly

AAC Drawing Number 9000989 Rev7

NO.	QTY	PART #	DESCRIPTION
1	1	1317307	CYLINDER END, FOOT LIFT
2	1	1335910	BRACKET, CYLINDER
3	2	AA198RA508	Body
4	1	AAC5DP-2	AIR CYLINDER, SMC
5	1	CCSCL7F	CLAMP COLLAR- 7/16
6	1	NNHM5X0.8	M5 X 0.8 HEX NUT

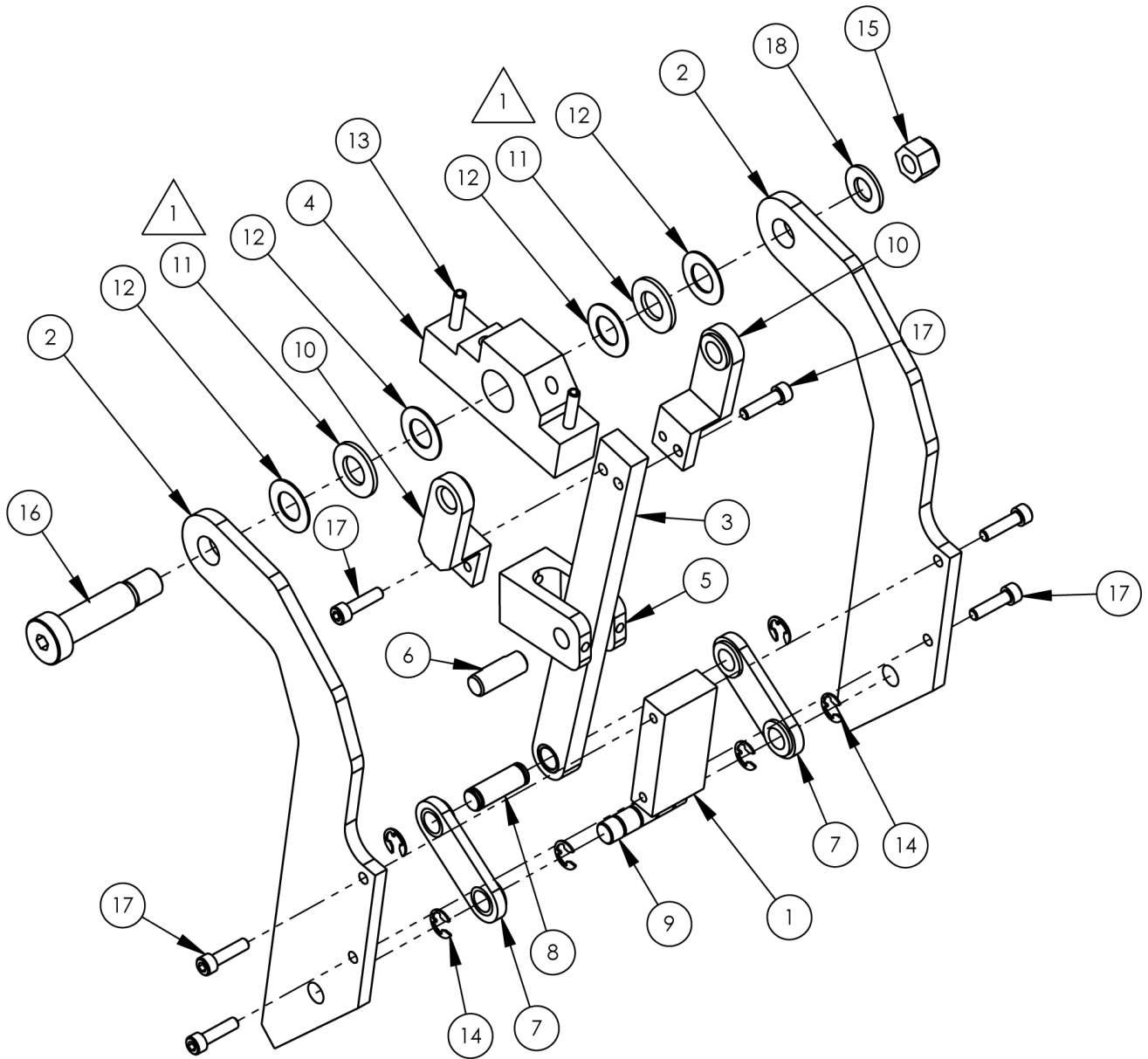


# 1335M-120 Puller Drive Assembly

AAC Drawing Number 9001014 Rev4

NO.	QTY	PART #	DESCRIPTION
1	1	011-020	MOTOR, STEPPER W/PLUG
2	1	1335-116	SHAFT, FLATTED, 60C, .375
3	1	1335-119	BLOCK, BEARING
4	1	1335-124	GUARD, MOTOR BELT
5	1	1335M-121	HEX SHAFT, 3/8X4 3/8
6	1	1335M-127	MOUNT, MOTOR
7	1	1335M-128	PLATE, BASE
8	1	1335M-129	CLAMP SPACER
9	1	1335M-130	HINGE SPACER
10	1	1335M-131	PLATE, NUT, 1/4-20 @ 2.0
11	2	3517	WASHER, THRUST, BRONZE
12	1	3524-06A	U-JOINT, MODIFIED
13	1	CCCL6F	CLAMP COLLAR- 3/8
14	1	GG100XL037	BELT, GEAR, 1/5P, 3/8W
15	1	MM741-3A	HINGE, 3 X 3, STANLEY
16	1	MM8096307	CLAMP
17	1	NNH1/4-20	1/4-20 HEX NUT
18	4	NNH10-32	HEX-NUT 10-32 REG.
19	2	PP24XLB37M1	PULLEY, GEAR, 1/5 PITCH
20	1	SSFC01160	1/4-20 X 2-1/2 FLAT CAP
21	2	SSFC98032	10-32 X 1/2 FLAT ALLEN CAP
22	2	SSH01160	1/4-20 X 2-1/2 HHCS
23	3	SSPS80024	#6-32 X 3/8 LG PAN HD
24	4	SSSC90040	8-32 X 5/8 SOC CAP SC
25	3	SSSC98024	10-32 X 3/8 SOC CAP
26	3	SSSC98040	10-32 X 5/8 SOC CAP
27	4	SSSC98048	10-32 X 3/4 SOC CAP
28	3	WWF6	DO NOT USE - SEE WWFS6
29	3	WWFS1/4	WASHER, FLAT, SAE, 1/4
30	10	WWFS10	WASHER, FLAT, #10, SAE
31	3	WWL1/4	WASHER, LOCK, 1/4
32	14	WWL10	WASHER, LOCK, #10, S/S

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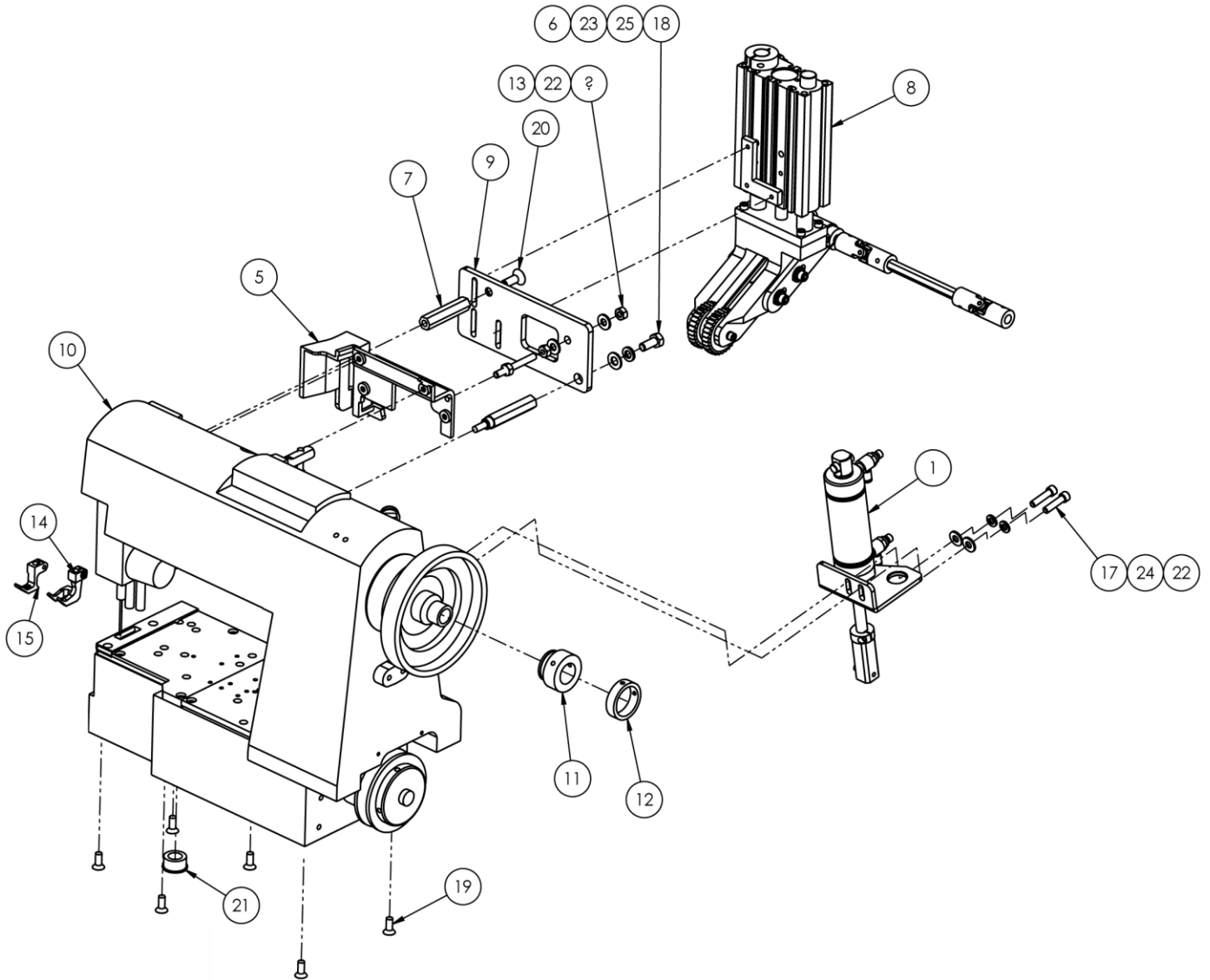




# 1335M-2300A Pivot Assembly

AAC Drawing Number 9000972 Rev4

NO.	QTY	PART #	DESCRIPTION
1	1	1335373	SPACER, RUFFLER PIVOT
2	2	1335409	PIVOT ARM
3	1	1335411	DRIVE LINK, 11335MH, 300U
4	1	1335M-2007	PIVOT BLOCK
5	1	1335M-2010	BLOCK, DRIVE LINK PIVOT
6	1	1335M-2011	PIVOT SHAFT
7	2	1335M-2012	SIDE LINK
8	1	1335M-2013	LINK SHAFT
9	1	1335M-2014	LINK SHAFT
10	2	1335M-2015	LINK YOKE
11	2	BBNTA815	BEARING, THRUST, 1/2 BORE
12	4	BBTRA815	WASHER, THRUST, STEEL 1/2
13	2	IIS012X064	SPRING PIN 3/16 DIA
14	6	MM8407A134	RING, RETAINING, "E", 3/8"
15	1	NNE3/8-16	NUT, ELASTIC 3/8-16
16	1	SSAS032096	SHOULDER BOLT 1/2 X .1.50
17	6	SSSC98048	#10-32 X 3/4 SOC CAP
18	1	WWFS3/8	WASHER, FLAT, 3/8

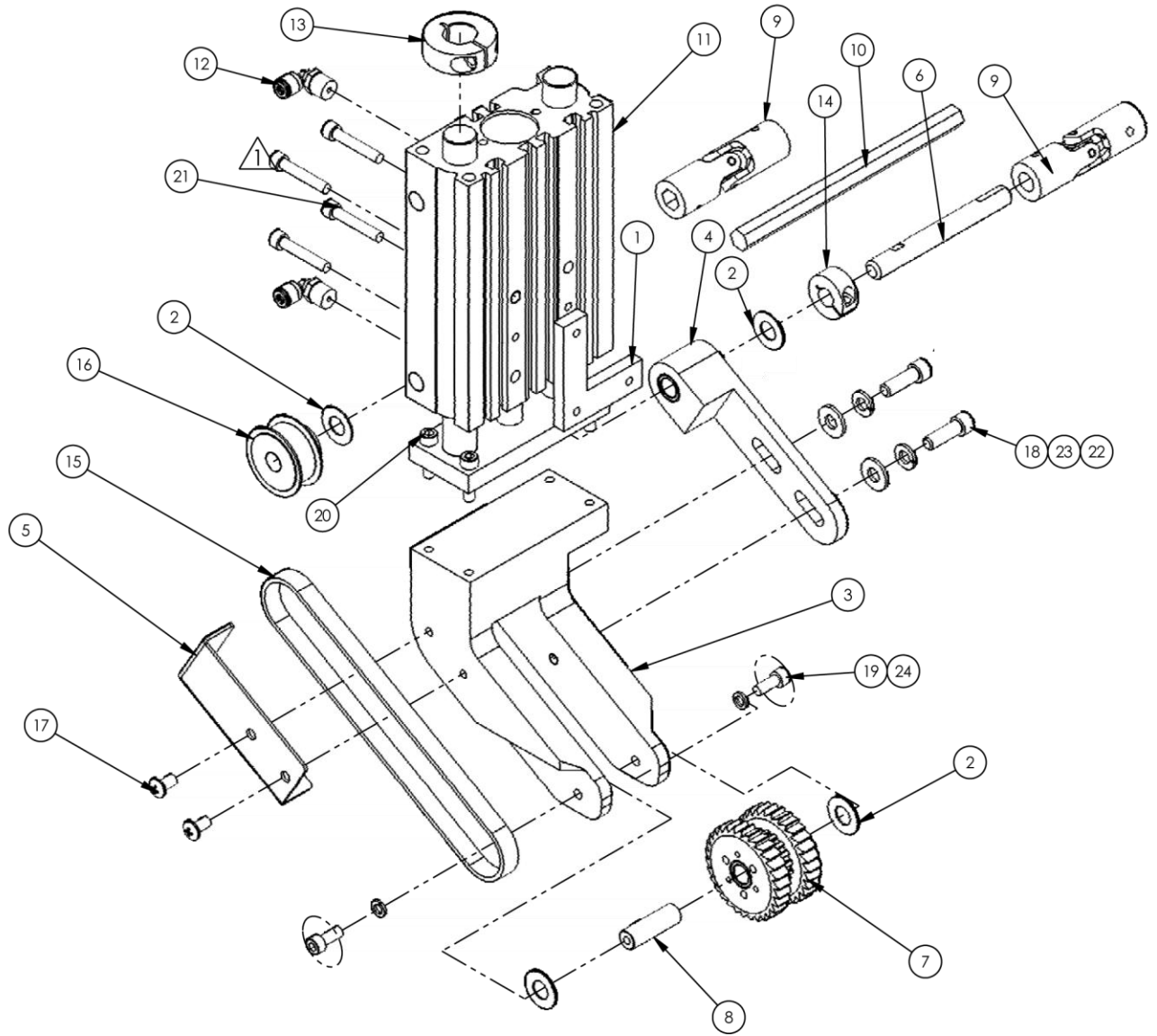


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# 1335A-10B Sew Head Assembly

AAC Drawing Number 9001052 Rev4

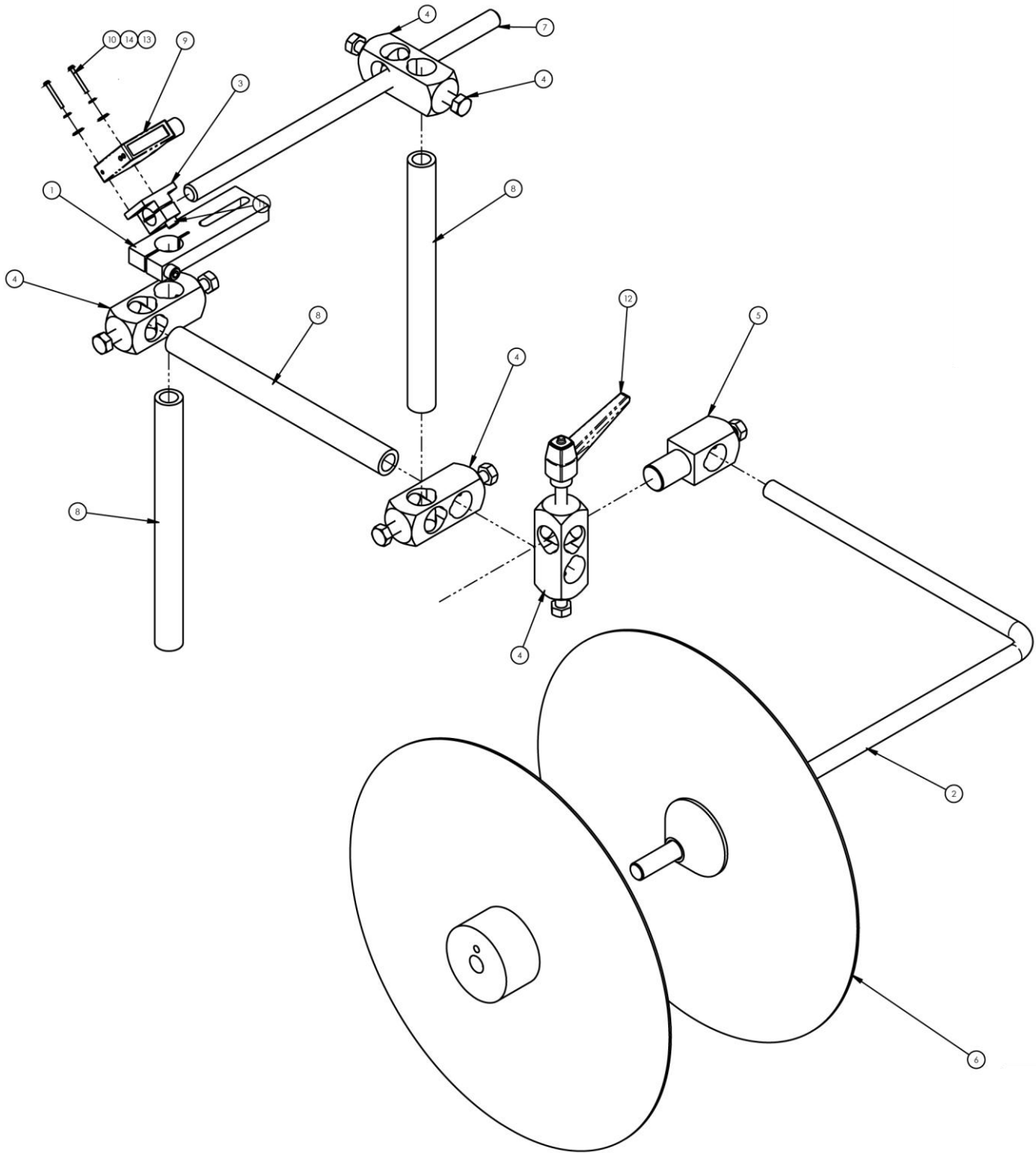
NO.	QTY	PART #	DESCRIPTION
1	1	1335-110B	FOOTLIFT ASSY.
2	1	1335-403C	BED PLATE, LEFT, MOD
3	1	1335-404	PLATE, THROAT
4	1	1335-405A	PLATE, BED, RIGHT, RUFFLE
5	1	1335051	Cover, Rear
6	1	1335054A	Standoff, Puller Plate
7	1	1335055A	Standoff, Puller Plate
8	1	1335140B	PULLER ASSY,300UX5 RINGER
9	1	1335412	PLATE, PULLER MNT, 1335MS
10	1	1335Q-10M2	SEWING HEAD, MODIFIED
11	1	311-128	HUB, HANDWHEEL, TAPE MOUN
12	1	311-129	SLEEVE TAPE MOUNT ADJUST
13	1	AP-1883	Rod, Threaded
14	1	M1T31-052A	FOOT, HOLDING, RUFFLER
15	1	M1T31-052B	FOOT, WALKING, RUFFLER
16	3	NNH1/4-20	NUT,HEX,1/4-20
17	2	SSSC01064	1/4-20 X 1 SOC CAP
18	1	SSHC10048	5/16-18 X 3/4 HHCS
19	6	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
20	1	SSFC10056	5/16-18X7/8 FLAT HD CAP
21	1	TA2351004-R0	RUBBER PLUG
22	4	WWFS1/4	WASHER,FLAT,SAE,1/4
23	1	WWFS5/16	WASHER,FLAT,SAE,5/16
24	2	WWL1/4	WASHER,LOCK,1/4
25	1	WWL5/16	WASHER, LOCK, 5/16



# 1335140B Puller Assembly

AAC Drawing Number 9000449 Rev2

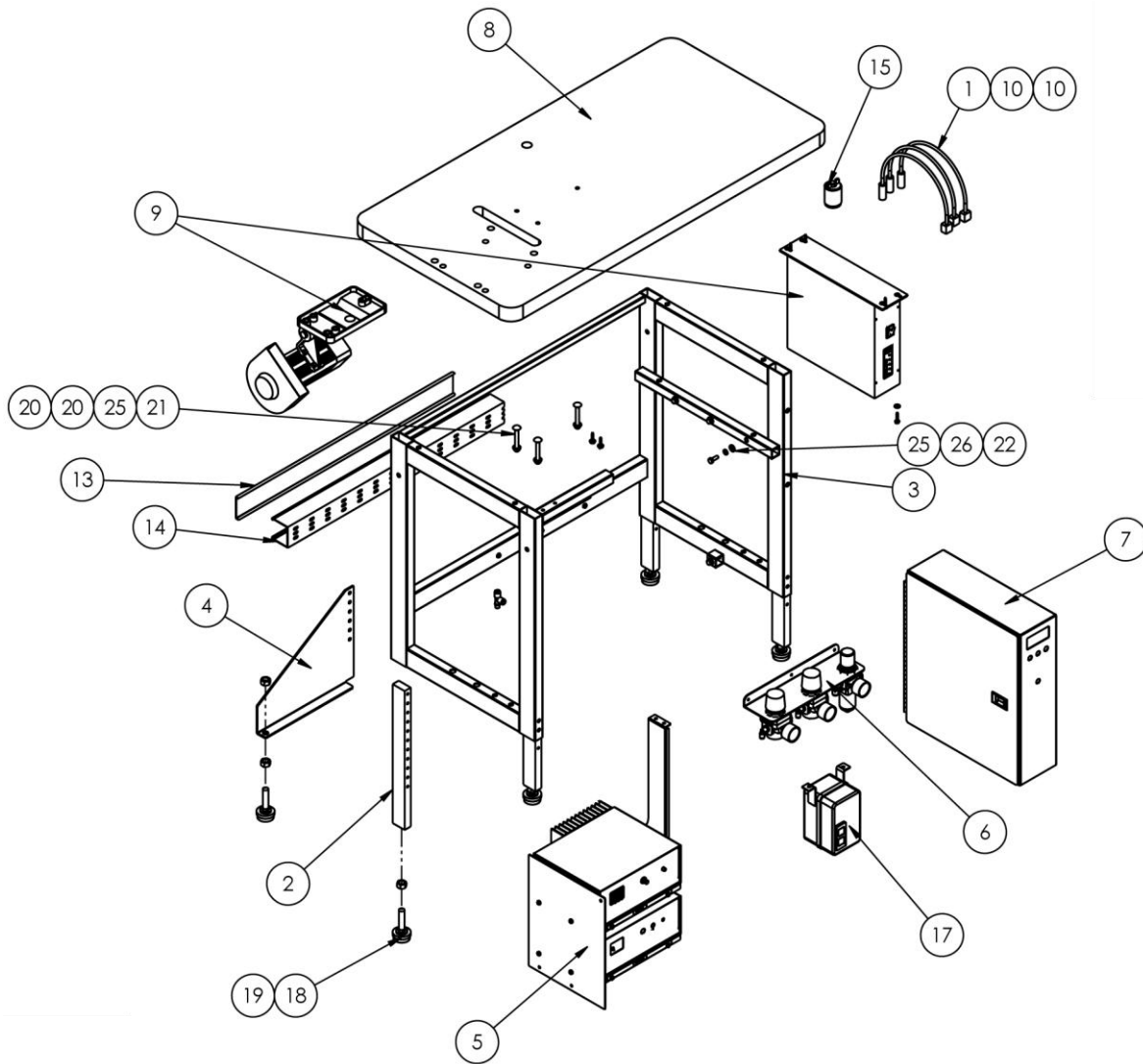
NO.	QTY	PART #	DESCRIPTION
1	1	1335053A	PLATE,NUT,"L",10-32,3 PL
2	4	3517	WASHER,THRUST,BRONZE
3	1	1335134	YOKE,PULLER,CENTER DRIVE
4	1	1335143	SUPPORT, DRIVE
5	1	1335449	BELT GUARD,
6	1	1335540	DRIVE SHAFT, TOP
7	1	1335743	PULLER ROLLER ASSEMBLY
8	1	1335748	SHAFT, PULLER, IDLER
9	2	3524-06A	U-JOINT,MODIFIED
10	1	3524-6352	SHAFT,3/8 HEX,5.50L
11	1	AACMGPM25100	CYLINDER,AIR,GUIDED
12	2	AAQME-M4-8	QUICK MALE ELBOW
13	1	CCCL10F	CLAMP COLLAR- 5/8 ID
14	1	CCCL6F	CLAMP COLLAR- 3/8
15	1	GG150XL037U	BELT,GEAR,1/5P,3/8W
16	1	PP18XL037M	PULLEY,GEAR,1/5P,18T,3/8B
17	2	SSPP98024	10-32 X 3/8 PAN HD PHILIP
18	2	SSSC01048	1/4-20 X 3/4" SOC CAP SC
19	2	SSSC98032	10-32X1/2, SOC CAP
20	4	SSSC98048	10-32 X 3/4 SOC CAP
21	4	SSSC98072	10-32 X 1-1/8 SOC CAP
22	2	WWFS1/4	WASHER,FLAT,SAE,1/4
23	2	WWL1/4	WASHER,LOCK,1/4
24	2	WWL10	WASHER,LOCK,#10,S/S



# 1335575 Roll Holder Assembly

AAC Drawing Number 1335575 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	1325-346A	HOLDER, ROD, 3/4", SLOT
2	1	1335598	ROD, SS BENT, 90 DEG
3	1	265155A	HOLDER, EYE, 1/2 BORE
4	4	28201	BLOCK,CROSS,(LARGE)
5	1	28201B	LARGE PIVOT BLOCK
6	2	786B12-2.2	DISC & CONE BEARING ASSY
7	1	8732-0736	ROD, ST, CRS, 1/2 X 11.5
8	3	8748-0512	ROD,STRA,CRS,3/4X8
9	1	FFQM42VN6A	EYE,ELECTRIC,10-30VDC
10	2	SSPS50048	#2-56 X 3/4 PAN HD SLOT
11	1	SSSC98040	#10-32 X 5/8 SOC CAP
12	1	TTH32426	HANDLE,THRD,5/16-18X1-1/4
13	2	WWF4	WASHER, FLAT #4
14	2	WWL4	#4 LW



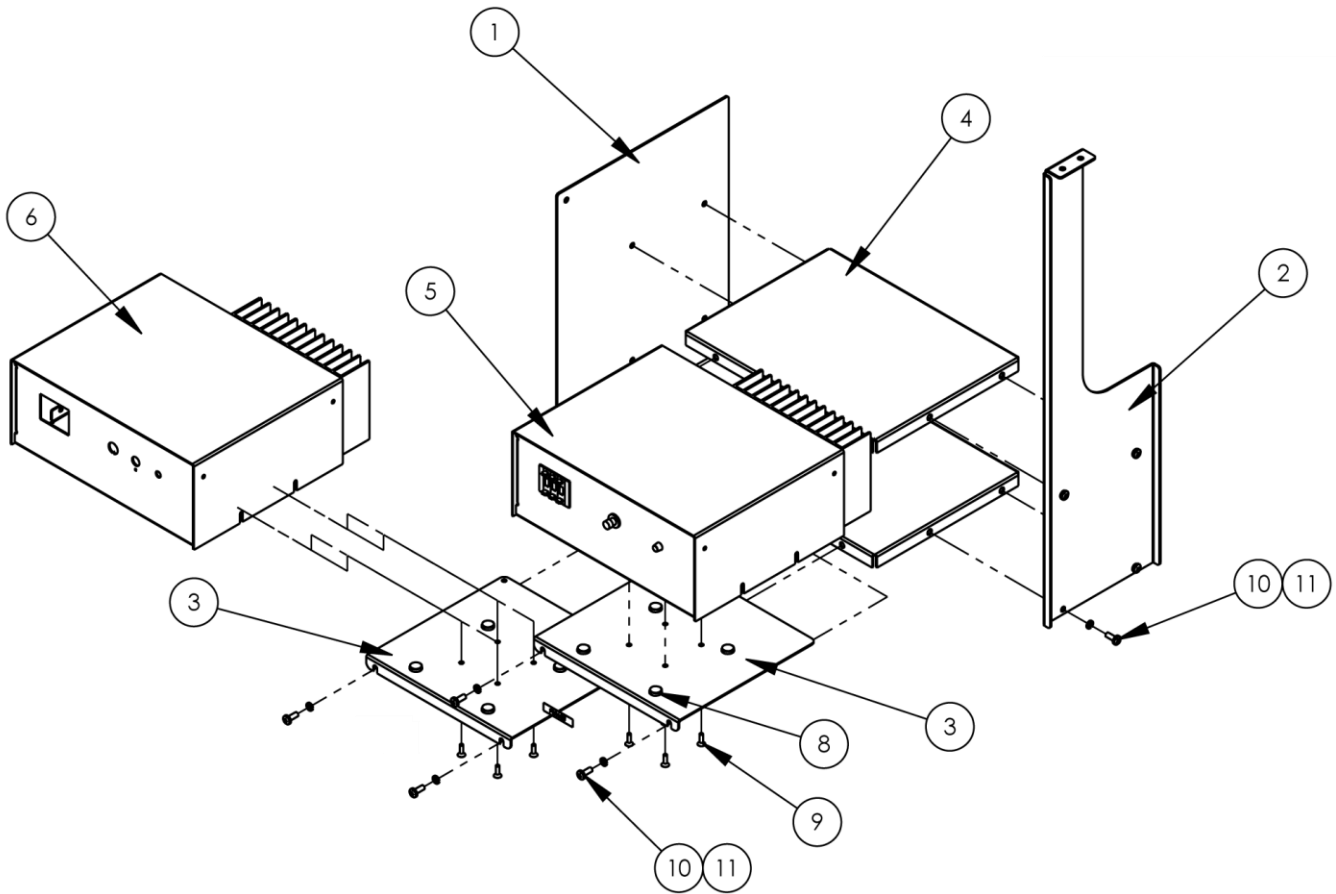
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## 1335866 Stand and Motor Assembly

AAC Drawing Number 1335866 Rev 3

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	0211-702A	CABLE,POS. SENSOR,6'	14	1	EEDF2X2	DUCT,WIRE,2X2, MOD
2	4	132556-273	LEG, 3/4 X 1-1/2 X 15 LG	15	1	FFHBL4579C	RECEPTACLE,3 POLE,3W
3	1	1335873	FRAME WELDT, 1335MHP	16	1	FFRK44T3P5	CABLE, EURO-3P
4	1	1335877	LEG EXT BKT	17	1	K-CB600	MOTOR STARTER,ELEC
5	1	1335878	STEPPER BOX ASSY	18	5	MMFB4444	FOOT, RUBBER
6	1	1335881	PNEUMATIC, SHELF	19	6	NNH1/2-13	NUT,HEX,1/2-13
7	1	1335MHP-500	CONTROL BOX ASSY	20	3	NNJ5/16-18	5/16-18 HEX JAM NUT
8	1	4048-300UX5P	TABLE TOP, 11335MHP	21	3	SSBK10160	BOLT, CARRAGE, 5/16X2.5
9	1	4059-DC50	MOTOR,L/S,HIGH TORQ	22	4	SSHCO1048	1/4-20 X 3/4 HEX HEAD
10	2	4080-4508B	CABLE,STEP MOTOR,4 AMP,7'	23	6	SSZH#10064	SCREW,SHT.METAL HEX 10
11	1	AAQMT-4-8	MALE RUN T 1/4 X 1/8 NPT	24	6	SSZS93032	SCREW, SHT.METAL 10 ZIP
12	1	AAQUY-5-4	Y UNION, 5/32X1/4	25	13	WWFS10	WASHER, FLAT #10
13	1	EEDC2X2	COVER,WIRE DUCT	26	4	WWL1/4	1/4 LW



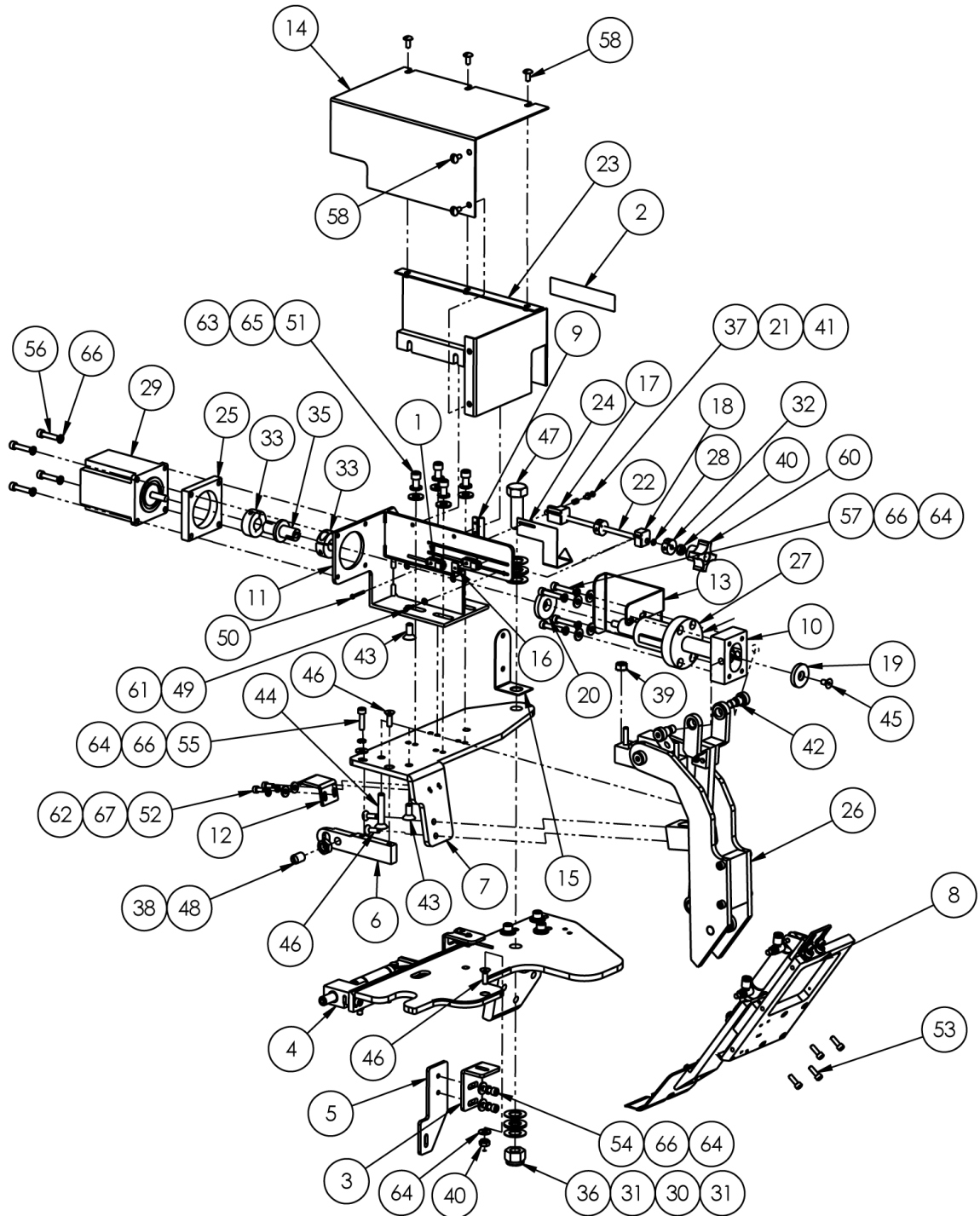
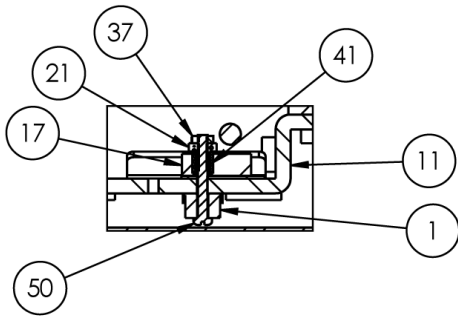


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## 1335878 Stepper Box Assembly

AAC Drawing Number 1335878 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1335879	MOUNT, CTRL BOX, SIDE
2	1	1335880	MOUNT, CTRL BOX, SIDE
3	2	1335M-9010	BRKT, STEPPER BOX BASE
4	2	1335M-9011	BOX , SHELF MOTOR
5	1	AP-28-800C1	BOX,STEPPER
6	1	AP-28-800Y1	BOX,STEPPER,H.S. (X5)
7	1	EE37F3312	CEE POWER CORD, 9'
8	8	MMSLD-ECH	1/2" DIA RUBBER BUMPER
9	8	SSFC80032	#6-32 X 1/2 FLAT ALLEN
10	12	SSPP98032	#10-32 X 1/2 PAN HD PHIL
11	12	WWL10	#10 LW

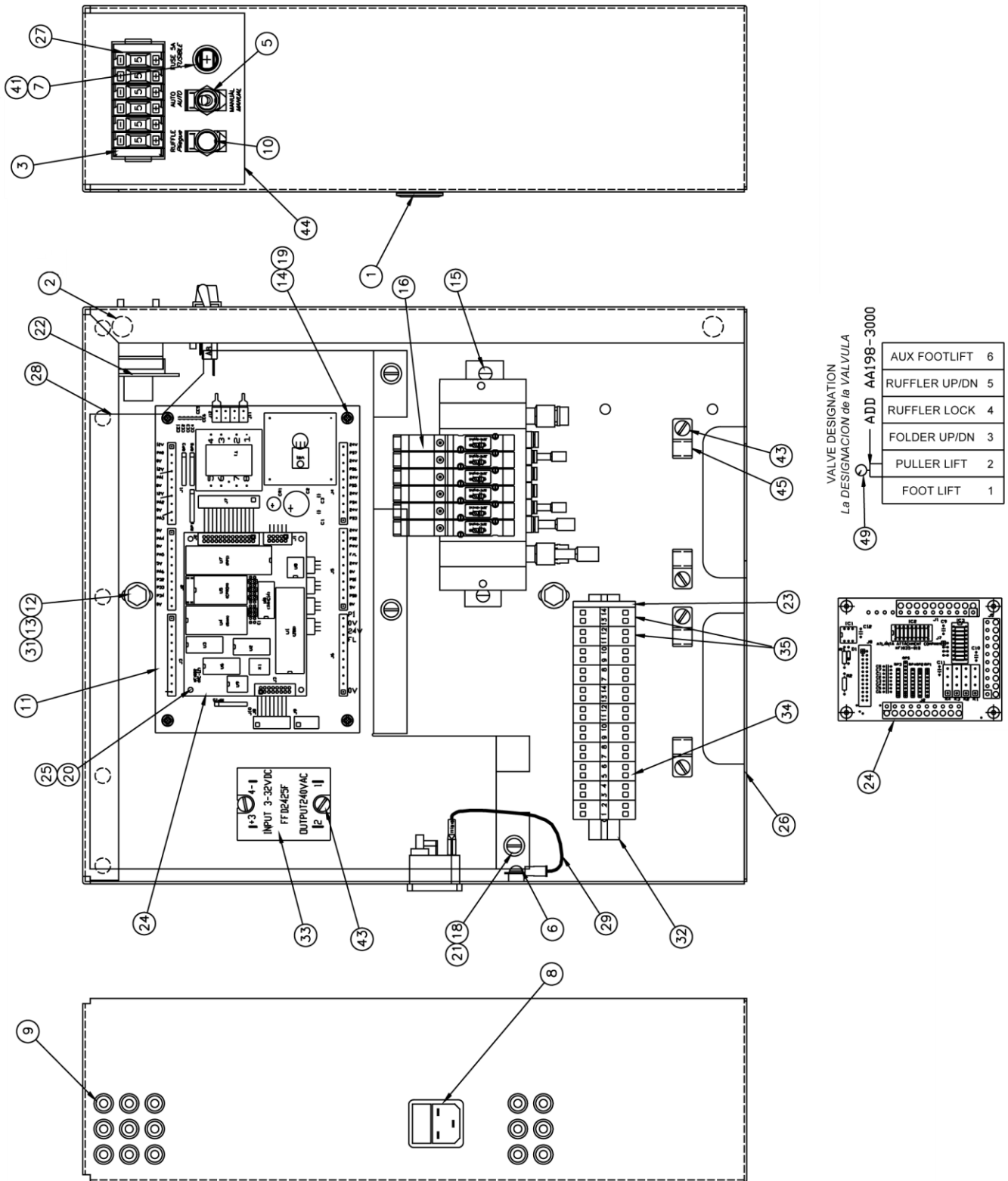


# 1335894 Ruffler Assembly

AAC Drawing Number 1335894 Rev 0

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	1278-7055D	PROX SWITCH W/PLUG,12"	35	1	MM8FM	JOINT,UNIVERSAL,MOD
2	1	1325-4126	LABEL, SCALE, METRIC	36	1	NNE1/2-13	NUT, ELASTIC 1/2-13
3	1	1335218	ADJ ANGLE-RUFFLER SUPP	37	1	NNH2-56	#2-56 HEX NUT
4	1	1335298A	RUFFLER MTG ANGLE ASSY	38	1	NNJ3/8-16	3/8-16 HEX JAM NUT
5	1	1335323	SUPPORT BRKT-RUFFLER	39	1	NNK1/4-20	KEP NUT, 1/4-20
6	1	1335324	LOCKING LEVER	40	2	NNK10-32	KEP NUT, 10-32
7	1	1335410	PLATE, PIVOT, RUFFLER ASS	41	1	RRLC026B1	SPRING,COMP .026X.18X.25
8	1	1335893	RUFFLER ASSY, NO FOLDER	42	2	SSAS024024M	3/8 X 3/4 X 5/16-18
9	1	1335M-001	BRACKET, STOP, PRX SWITCH	43	2	SSFC01040	1/4-20 X 5/8 FLAT ALLEN
10	1	1335M-2006	BLOCK, NUT TRUNION	44	1	SSFC01096	1/4-20 X 1-1/2 FLAT ALLEN
11	1	1335M-2016	MTG BRKT WELDT	45	1	SSFC98024	#10-32 X 3/8 FLAT ALLEN
12	1	1335M-2020	HLD DWN BRKT	46	4	SSFC98040	#10-32 X 5/8 FLAT ALLEN
13	1	1335M-2021	VANE, SWITCH ACTUATING	47	1	SSHC45096	1/2-13 X 1 1/2 L HHCS
14	1	1335M-2030	MOTOR COVER, CLEAR	48	1	SSMB58N	PLUNGER,BALL,3/8-16X5/8L
15	1	1335M-2031	PIVOT BRKT AIR LINE	49	2	SSPS50032	#2-56 X 1/2 PAN HD SLOT
16	1	1335M-2034	PLATE, NUT #2-56	50	1	SSPS50048	#2-56 X 3/4 PAN HD SLOT
17	1	1335M-2035	ADJUSTMENT NUT, 10-32	51	4	SSSC01032	1/4-20 X 1/2 SOC CAP
18	1	1335M-2036	SUPPORT BLOCK	52	2	SSSC90024	#8-32 X 3/8 SOC CAP
19	1	1335M-2037	WASHER, STOP	53	4	SSSC90032	#8-32 X 1/2 SOC CAP
20	1	1335M-2038	STOP WASHER	54	2	SSSC98032	#10-32 X 1/2 SOC CAP
21	1	1335M-2039	NUT,SPRING RETAINER	55	1	SSSC98048	#10-32 X 3/4 SOC CAP
22	1	1335M-2040	SCREW, ADJUSTMENT	56	4	SSSC98056	#10-32 X 7/8 SOC CAP
23	1	1335M-2042	COVER	57	4	SSSC98064	#10-32 X 1 SOC CAP
24	1	1335M-2047	POINTER, RUFFLE SIZE	58	5	SSTS90024	#8-32 X 3/8 TRUSS HD
25	1	1335M-2049	SPACER, MOTOR, 3/8	59	2	SSTS98040	#10-32 X 5/8 TRUSS HD
26	1	1335M-2300A	PIVOT ASSY	60	1	TTCL1APPK1	PLASTIC KNOB, #10-32
27	1	1335M-2400	BALL SCREW AND NUT	61	2	WWF2	WASHER, FLAT #2
28	1	AA198-7006	O RING, 1/8 ID, 1/4 OD	62	2	WWF8	WASHER, FLAT #8
29	1	AP-22E-103	STEP MOTOR,MODIFIED	63	4	WWFS1/4	WASHER FLAT, 1/4
30	2	BBNTA815	BEARING,THRUST,1/2BORE	64	8	WWFS10	WASHER, FLAT #10
31	4	BBTRA815	WASHER,THRUST,STEEL 1/2	65	4	WWL1/4	1/4 LW
32	2	CCCL10T	CLAMP COLLAR TRD, 10-32	66	12	WWL10	#10 LW
33	2	CCCL8F	CLAMP COLLAR- 1/2	67	2	WWL8	#8 LW
34	1	MM130-10A1	TAPE, UHMW, 1" W X .01 TK				

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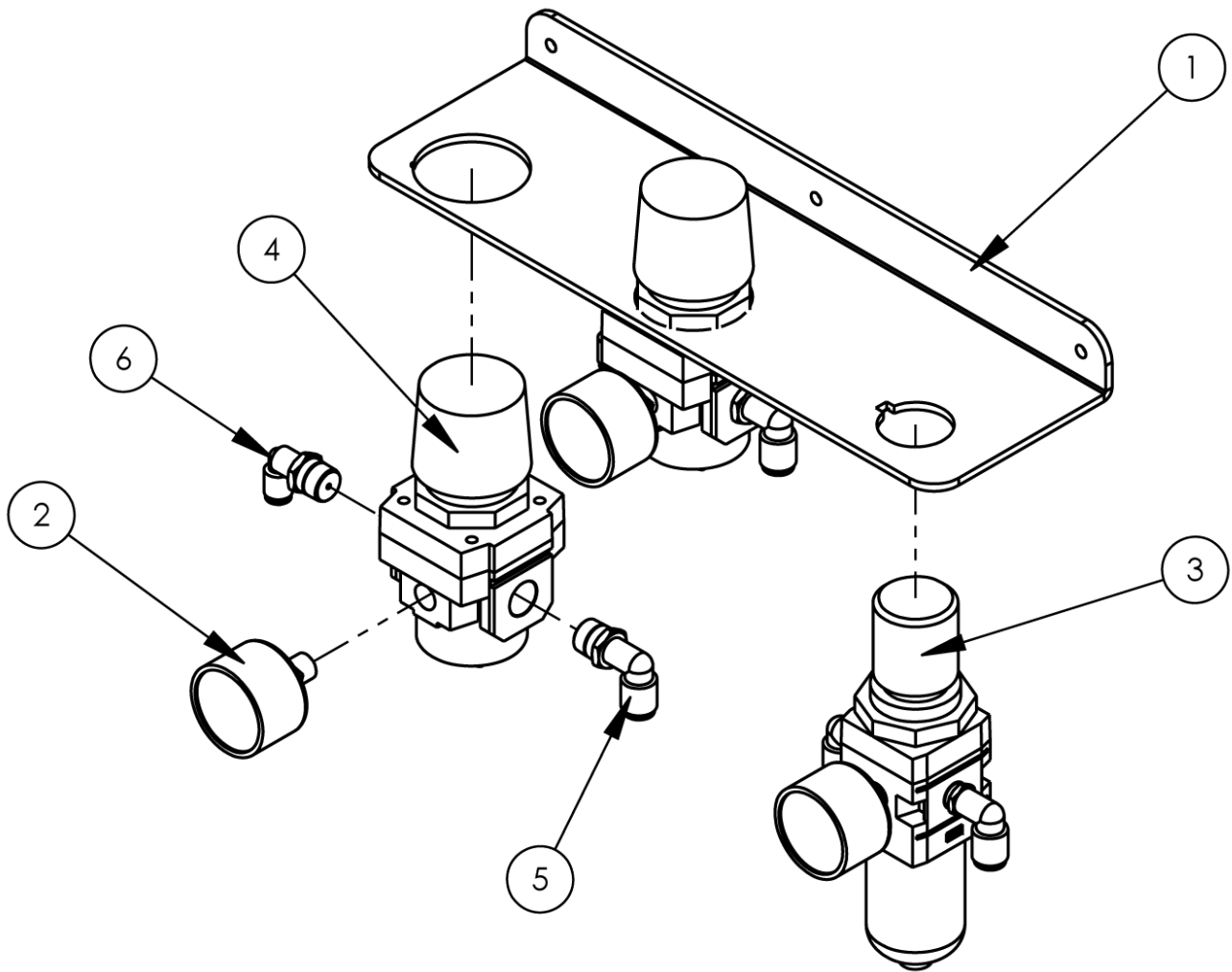
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# 1335MHP-500 Control Box Assembly

AAC Drawing Number 125712B Rev 2

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	MM40450010	SLIDE LOCK	27	6	FFC5.2LST1	THUMB WHEEL SWITCHES
2	2	MMSLD-ECH	BUMPER	28	1	1335M-501	CONTROL BOX COVER
3	1	FFC5S1	END CAP	29	1	1981A-511	GROUND WIRE
4	1	1987149F	CABLE	30	2	EE37F3312	CEE POWER CORD
5	1	FF23F385	TOGGLE SWITCH	31	2	WWFS1/4	FLAT WASHER
6	1	SSPS98016	SLOTTED PAN HD SCREW	32	1	FF264-3BKT6	WAGO MOUNT
7	1	FF342838A	FUSE HOLDER	33	1	FFD2425F	SOLID STATE RELAY
8	1	FF10ESB1C	POWER ENTRY CONN.	34	9	FF264-341	GREY DUAL WAGO
9	15	EESB-375-3	HEYCO BUSHING	35	2	FF264-347	GREEN DUAL WAGO
10	1	FF23F118	PUSH BUTTON SWITCH	36	1	FFRK44T-4	CABLE
11	1	1987-149JC	PC BOARD	37	2	0211-703E	CABLE
12	2	WWL1/4	LOCK WASHER	38	1	0211-705C	CABLE
13	2	SSHC01032	HEX CAP SCREW	39	1	0211-705D	CABLE
14	4	SSPP80016	PHILLIPS PAN HD SCREW	40	3	0411-1906	CABLE
15	2	SSPS98032	SLOTTED PAN HD SCREW	41	1	FF313005	FUSE
16	1	AAE1335-6	SOLENOID ASSEMBLY	42	AR	1335MHP-WD	WIRING DIAGRAM
17	1	1987-513A	CABLE	43	6	SSPS90024	SLOTTED PAN HD SCREW
18	5	WWFS10	WASHER	44	AR	1335MF-LAB1	LABEL
19	4	FF67F4079	THREADED SPACER	45	4	AAF1/8	PLASTIC CLAMPS
20	4	FF89F2608	SPACER 3/8	46	1	AP-28-610UA	CABLE
21	3	SSPS98024	SLOTTED PAN HD SCREW	47	1	AP-28-612U1	CABLE
22	1	1987-517	PC BOARD	48	1	FF250LA40A	OXIDE VARISTOR
23	1	FF264-371	END CAP WAGO	49	1	A198-3000	REGULATOR
24	1	FF1035-04	PC BOARD ISOLATION	50	1	1987149F2	CABLE
25	4	SSPP80096	PHILLIPS PAN HD SCREW	51	1	1335-022	CABLE
26	1	1335M-505	CONTROL BOX WELDMENT	52	1	FF1024A-PGM	POT SETTINGS

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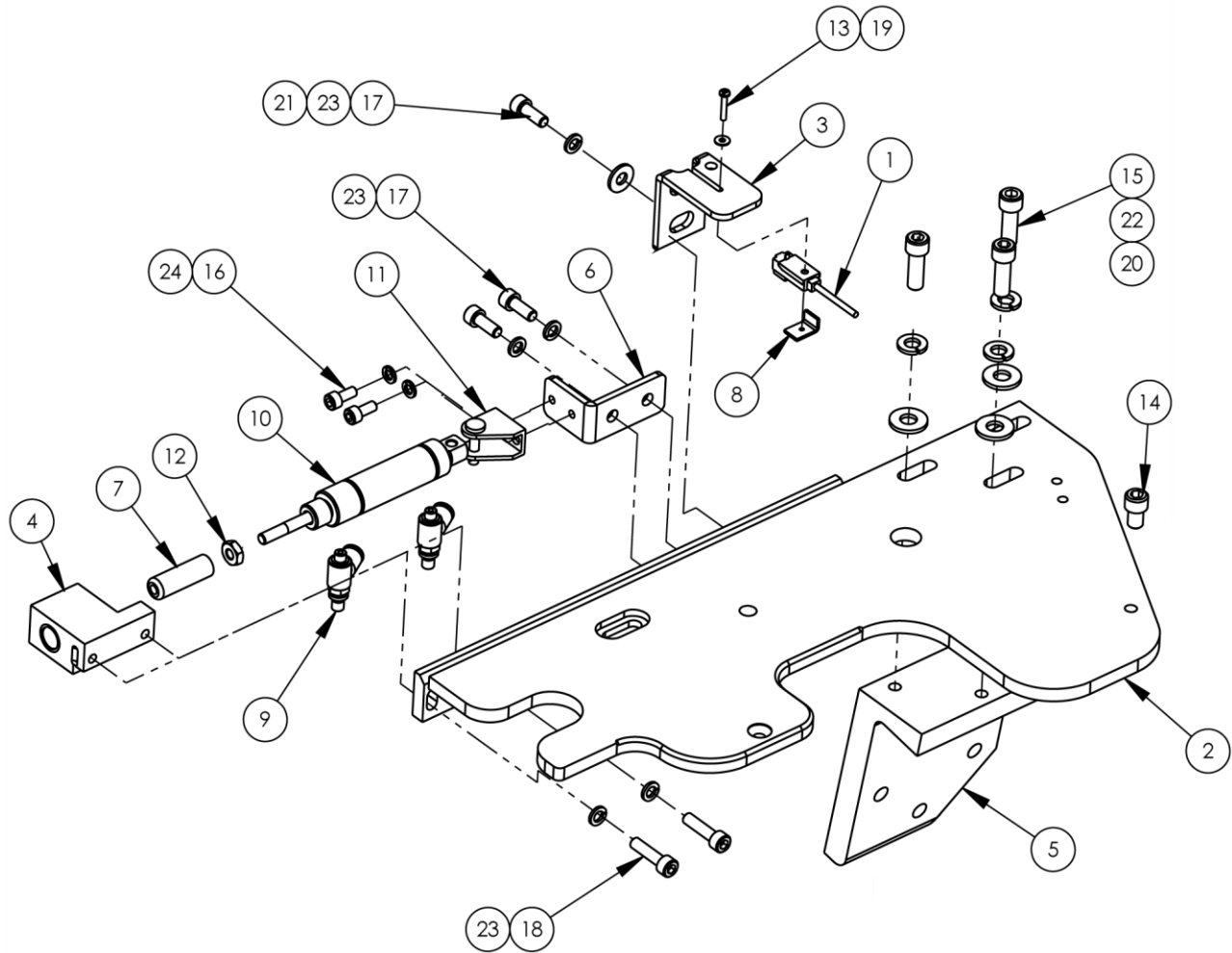


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## 1335881 Pneumatic Shelf

AAC Drawing Number 1335881 Rev 0

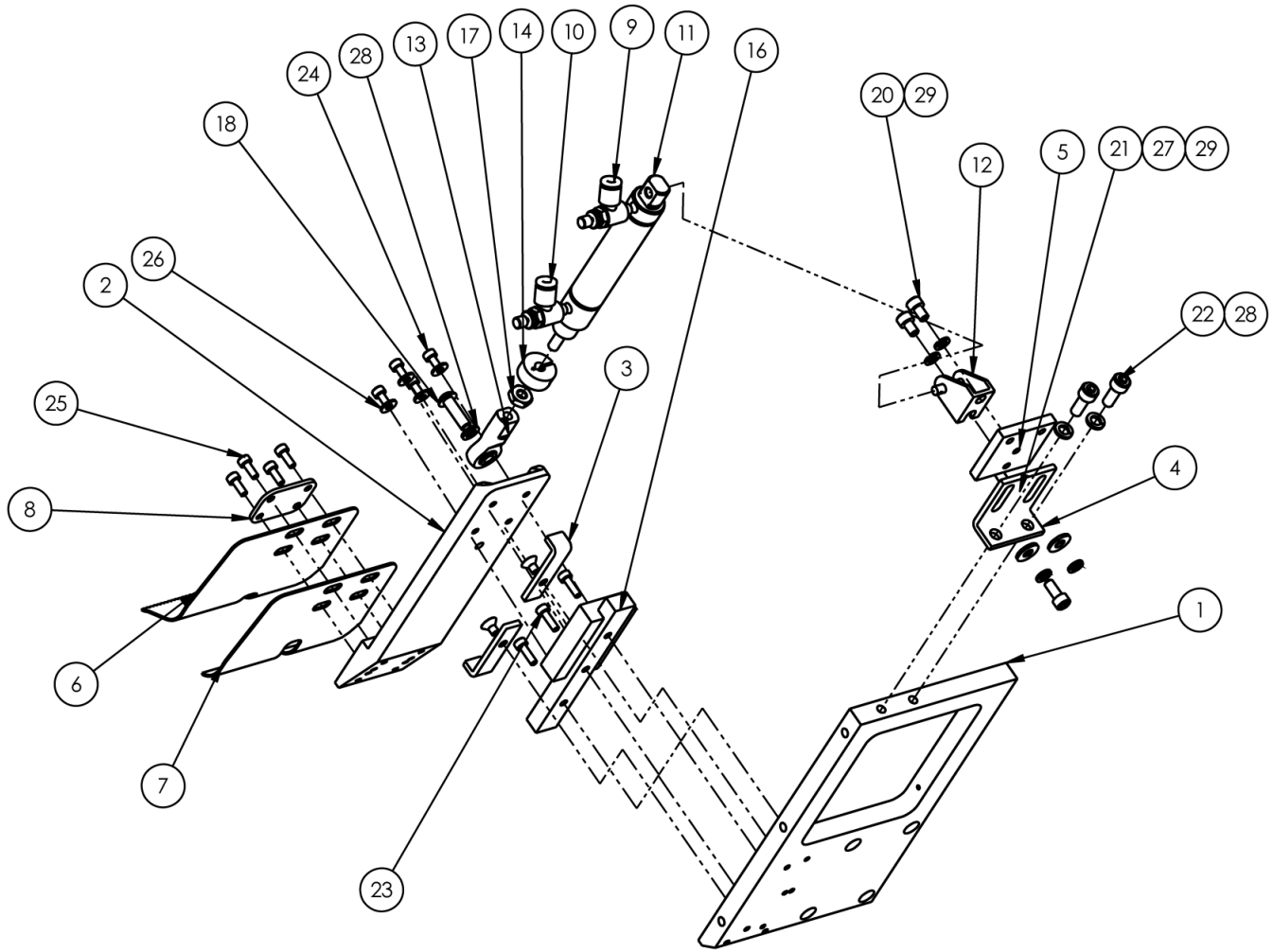
NO.	QTY	PART #	DESCRIPTION
1	1	1335882	BRACKET, PNEUMATIC
2	2	AA198-503	0-30PSI AIR GAGE 1/8NPT
3	1	AA198-5102	REGULATOR W/GAUGE & NUT
4	2	AA198-RP3	REGULATOR,PRECISION AIR
5	2	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT
6	2	AAQME-5-4	ELBOW, MALE 5/32X1/4NPT



## 1335298A Ruffler Mounting Angle assembly

AAC Drawing Number 9000931 Rev 5

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1278-7055D	PROX SWITCH W/PLUG,12"	13	1	SSPS50032	#2-56 X 1/2 PAN HD SLOT
2	1	1335315A	BASE PLATE, RUFFLER MTG	14	1	SSSC01024	1/4-20 X 3/8 SOC CAP SC
3	1	1335325	MTG. BRKT. SENSOR	15	3	SSSC01048	1/4-20 X 3/4 SOC CAP
4	1	1335334	CYL. MOUNT	16	2	SSSC90024	#8-32 X 3/8 SOC CAP
5	1	1335401	REAR MOUNT, 1335MH	17	3	SSSC98032	#10-32 X 1/2 SOC CAP
6	1	1335407	MNT BRKT,LOCK PIN CYL.	18	2	SSSC98048	#10-32 X 3/4 SOC CAP
7	1	1335M-2017	ROD, END	19	1	WWF2	WASHER, FLAT #2
8	1	1335M-2034	PLATE, NUT #2-56	20	3	WWFS1/4	WASHER FLAT, 1/4
9	2	AA198RA510	FLOW CONTROL,5/32X10-32	21	1	WWFS10	WASHER, FLAT #10
10	1	AAC8DP-.5	CYL,AIR,DA,9/16 B,1/2S	22	3	WWL1/4	1/4 LW
11	1	AAFBP-8C	BRKT,PIVOT,5/32 BORE	23	5	WWL10	#10 LW
12	1	NNH10-32	#10-32 HEX NUT	24	2	WWL8	#8 LW



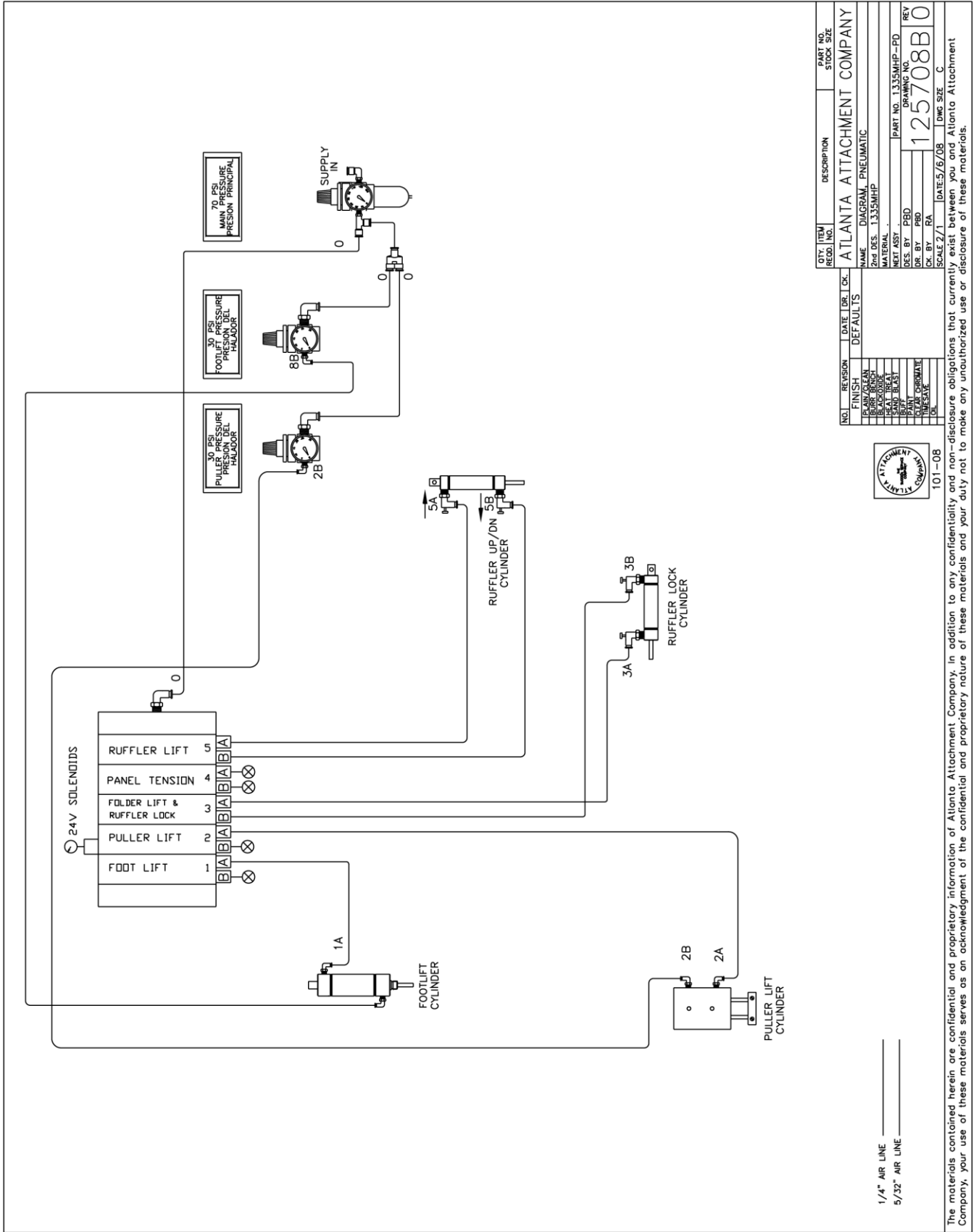
## 1335893 Ruffler Assembly, no folder

AAC Drawing Number 1335893 Rev 0

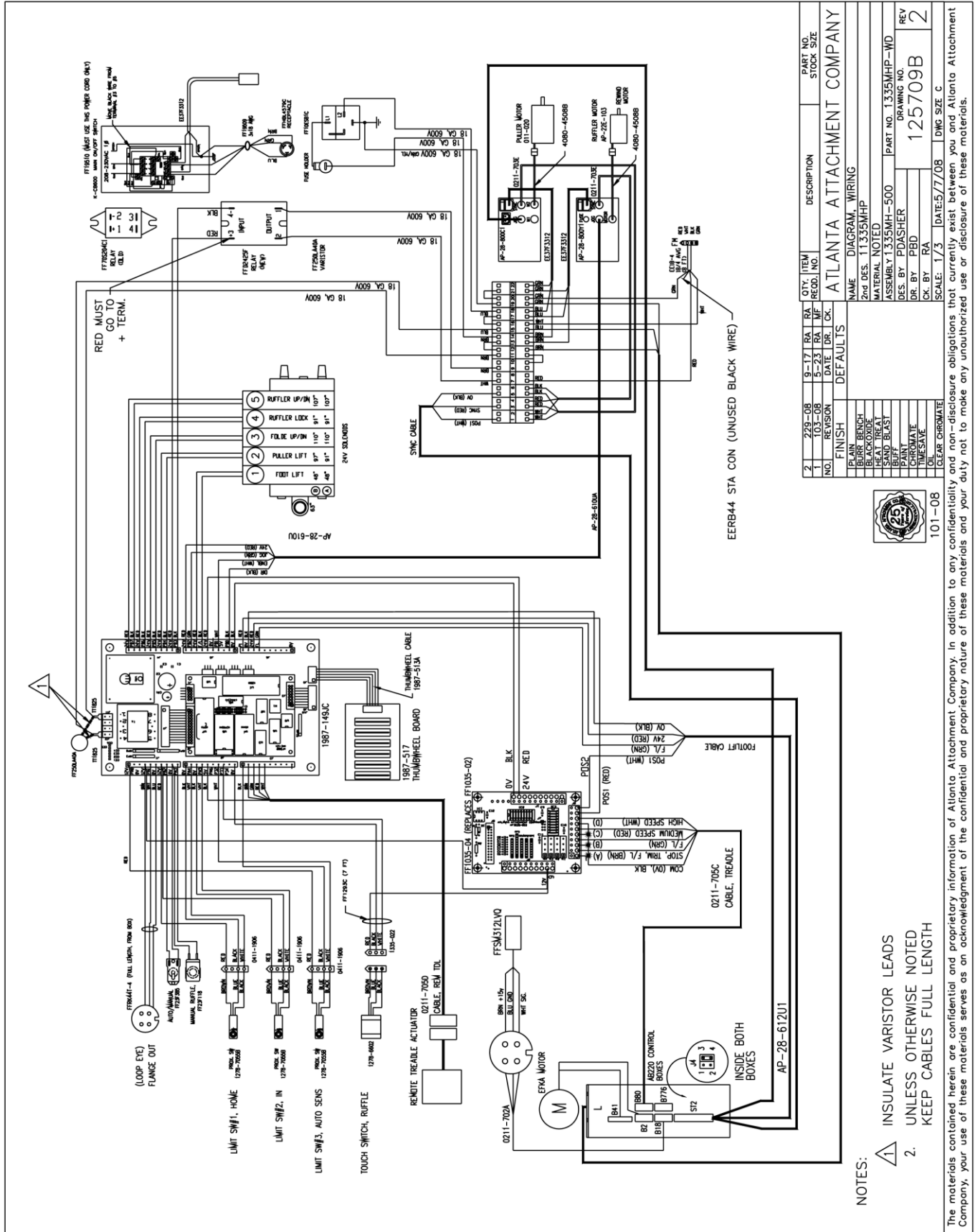
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1335224	BASE MTG PLATE	16	1	MMGNR12R090HN	12MM X 90MM RAIL
2	1	1335335	MTG PLT- HEAVY DUTY	17	1	NNH10-32	#10-32 HEX NUT
3	2	1335775	BEARING STOP, LONG	18	1	SSBC98040	#10-32 X 5/8 BUT HEAD
4	1	1335776	CYL. MOUNTING ANGLE	19	2	SSFC80016	#6-32 X 1/4 FLAT ALLEN
5	1	1335777	CYL. MOUNTING PLATE	20	2	SSSC90016	#8-32 X 1/4 SOC CAP
6	1	1335M-2002E	BLADE, RUFFLER, 2.25 X 12	21	2	SSSC90024	#8-32 X 3/8 SOC CAP
7	1	1335M-2002F	BLADE, RUFFLER, 2.25 X 12	22	2	SSSC98032	#10-32 X 1/2 SOC CAP
8	1	1335M-5004	PLATE, WASHER, 136DIA@4PL	23	3	SSSCM3X10	M3-0.5 X 10 SOC CAP
9	1	AA198RA510	FLOW CONTROL,5/32X10-32	24	4	SSSCM3X6	M3-0.5 X 6 SOC CAP
10	1	AA198RR510	REV FL CONT,5/32X10-32	25	4	SSSCM3X8	M3-0.5 X 8 SOC CAP
11	1	AAC8DP-1.5	CYL, AIR, DA, 9/16B, 2S	26	4	WWF4	WASHER, FLAT #4
12	1	AAF8P-8C	BRKT,PIVOT,5/32 BORE	27	2	WWF8	WASHER, FLAT #8
13	1	BBAW-3Z	BRG,ROD END,F, 10-32	28	3	WWL10	#10 LW
14	1	CCCL3F	CLAMP COLLAR- 3/16	29	4	WWL8	#8 LW
15	1	MMGN12HZ0HN	MGN12H BEARING BLOCK				



# 1335MHP-PD Pneumatic Diagram



# 1335MHP-WD Wiring Diagram



From the library of: Diamond Needle Corp

# Atlanta Attachment Company (AAC) Statement of Warranty

## Manufactured Products

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

## Terms and Conditions:

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

## What Is Covered

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

## What Is Not Covered

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

# Declaración de Garantía

## Productos Manufacturados

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

## Términos y Condiciones:

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

## Lo Que Está Garantizado

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

## Lo Que No Está Garantizado

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





From the library of: Diamond Needle Corp

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