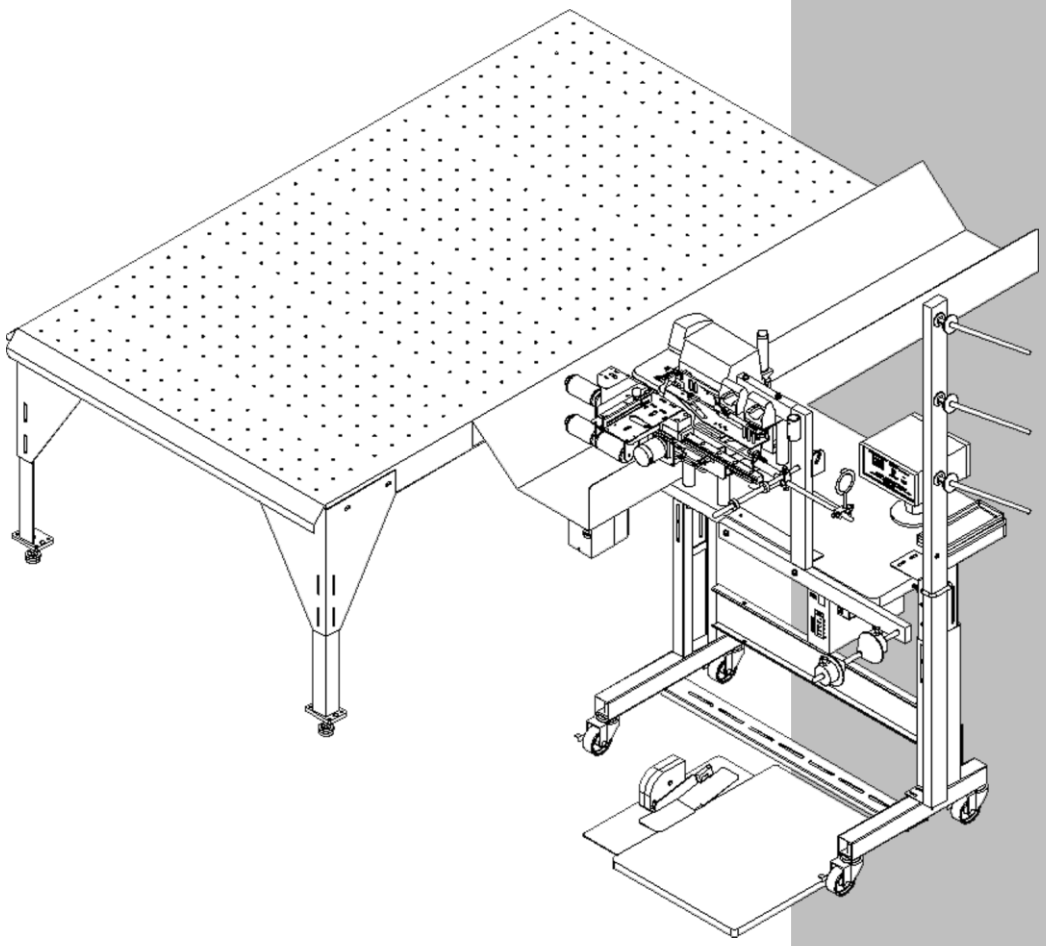
Model **1339HFJ**

Revision 2.1 Updated Aug 27, 2012

Technical Manual & Parts Lists



Atlanta Attachment Company

362 Industrial Park Drive

Lawrenceville, GA 30046

770-963-7369 • www.atlatt.com

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Foreign Patents: 9-520,472 ● 0,537,323 ● 92,905,522.6 ● 96,936,922.2 ● 2,076,379 ● 2,084,055
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IMPORTANT

It is important to read and understand the information contained within this manual before attempting to operate the machine. Atlanta Attachment Co., Inc. shall not be held liable for damage resulting from misuse of the information presented within, and reserves the right to change the information contained within, without prior notification.

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 1339HFJ27 Cap & Flange Workstation should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

- The Instruction Material comprises:
- Safety information
- Operator Instructions
- Electrical and Pneumatic diagrams

And may also include;

- A list of recommended spare parts
- Instruction Manual(s) for components made by other manufacturers
- The layout and installation diagram containing information for installation

Intended Use

Our machines are designed and built in line with the state of the art and the accepted safety rules. However, all machines may endanger the life and limb of their users and/or third parties and be damaged or cause damage to other property, particularly if they are operated incorrectly or used for purposes other than those specified in the Instruction Manual.

Exclusion of Misuse

Non-conforming uses include, for example, using the equipment for something other than it was designed for, as well as operation without duly installed safety equipment. The risk rests exclusively with the end user.

Conforming use of the machine includes compliance with the technical data, information and regulations in all parts of the complete Instruction Material, as well as compliance with the maintenance regulations. All local safety and accident prevention regulations must also be observed.

Liability

The machine should only be operated when in perfect working order, with due regard for safety and the potential dangers, as well as in accordance with the Instruction Material. Faults and malfunctions capable of impairing safety should be remedied immediately. We cannot accept any liability for personal injury or property damage due to operator errors or non-compliance with the safety instructions contained in this booklet. The risk rests exclusively with the end user.

The Instruction Material should always be kept near the machine so that it is accessible to all concerned.

The local, general, statutory and other binding regulations on accident prevention and environmental protection must also be observed in addition to the Instruction Material. The operating staff must be instructed accordingly. This obligation also includes the handling of dangerous substances and provision/use of personal protective equipment.

The Instruction Material should be supplemented by instructions, including supervisory and notification duties with due regard for special operational features, such as the organization of work, work sequences, the personnel deployed, etc.

The personnel's awareness of the dangers and compliance with the safety regulations should be checked at irregular intervals.

Choice and Qualification of Personnel

Ensure that work on the machine is only carried out by reliable persons who have been appropriately trained for such work - either within the company, by our field staff or at our office - and who have not only been duly appointed and authorized, but are also fully familiar with the local regulations. Work on the machine should only be carried out by skilled personnel, under the management and supervision of a duly qualified engineer.

This not only applies when the machine is used for production, but also for special work associated with its operation (start-up and maintenance), especially when it concerns work on the hydraulic or electrical systems, as well as on the software/serial bus system.

Training

Everyone working on or with the machine should be duly trained and informed with regard to correct use of the safety equipment, the foreseeable dangers which may arise during operation of the machine and the safety precautions to be taken. In addition, the personnel should be instructed to check all safety mechanisms at regular intervals.

Responsibilities

Clearly define exactly who is responsible for operating, setting-up, servicing and repairing the machine. Define the responsibilities of the machine operator and authorize him to refuse any instructions by third parties if they run contrary to the machine's safety. This applies in particular for the operators of machines linked to other equipment. Persons receiving training of any kind may only work on or with the machine under the constant supervision of an experienced operator. Note the minimum age limits permitted by law.

A Word to the Operator

The greatest danger inherent in our machines:
is that of fingers, hands or loose clothing being drawn into a machine by live, coasting or rotating tools or assemblies or of being cut by sharp tools or burned by hot elements.

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines

All machines are delivered with safety equipment, which shall not be removed or bypassed during operation.

The correct functioning of safety equipment on machines and systems should be checked every day and before every new shift starts, after maintenance and repair work, when starting up for the first time and when restarting (e.g. after prolonged shutdowns).

If safety equipment has to be dismantled for setting-up, maintenance or repair work, such safety equipment shall be replaced and checked immediately upon completing the maintenance or repair work. All protective mechanisms shall be fitted and fully operational whenever the machine is at a standstill or if it has been shut down for a longer period of time.

Damage

If any changes capable of impairing safety are observed in the machine or its mode of operation, such as malfunctions, faults or changes in the machine or tools, appropriate steps must be taken immediately, the machine switched off and a proper lockout tagout procedure followed. The machine should be examined for obvious damage and defects at least once per shift. Damage found shall be immediately remedied by a duly authorized person before resuming operation of machine.

The machine should only be operated when in perfect working order and when all protective mechanisms and safety equipment, such as detachable protective mechanisms, emergency STOP systems, etc. are in place and operational.

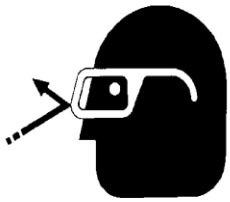
Faults or Errors

The machine must be switched off and all moving or rotating parts allowed to come to a standstill and secured against accidental restart before starting to remedy any faults or errors.

Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.
Clothing, Jewelry, Protective Equipment
Long loose hair, loose-fitting clothes, gloves and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

Protective Eyewear



Protective eyewear that has been tested by the local authorities should be worn whenever there is a possibility of loose or flying objects or particles such as when cleaning the machine with compressed air.

Tools

Always count the number of tools in your possession before starting work on the machine. This will allow you to check that no tools have been left behind inside the machine. Never leave a tool in the machine while working.

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

Smoking and open flame (e.g. welding work) should be prohibited in the production area due to the risk of fire and explosions.

Workplace

A clear working area without any obstructions whatsoever is essential for safe operation of the machine. The floor should be level and clean, without any waste.

The workplace should be well lit, either by the general lighting or by local lights.

Emergency STOP

The emergency STOP buttons bring all machine movements to a standstill. Make sure you know exactly where they are located and how they work. Try them out. Always ensure easy access to the nearest emergency STOP button while working on the machine.

First Aid

1. Keep calm even when injured.
2. Clear the operator from the danger zone. The decision of what to do and whether to seek additional assistance rests entirely with you, particularly if someone has been trapped.
3. Give First Aid. Special courses are offered by such organizations as the employers' liability insurance association. Your colleagues should be able to rely on you and vice versa.
4. Call an ambulance. Do you know the telephone numbers for the ambulance service, police and fire service?

Important Notices

Reporting and Fighting Fires

Read the instructions posted in the factory with regard to reporting fires and the emergency exits. Make sure you know exactly where the fire extinguishers and sprinkler systems are located and how they are operated. Pass on the corresponding information to the firemen when they arrive. Ensure there are enough signs to avoid fire hazards.

The following fire extinguishers may be used:
- Dry powder extinguishers, ABC fire-extinguishing powder.
- Carbon dioxide fire extinguishers to DIN 14461 for electronic components. Great care must be exercised when using carbon dioxide fire extinguishers in confined, badly ventilated rooms (see DIN 14406 and 14270).

Isolate the machine from the power supply if a fire breaks out. Do not use water on burning electrical parts until it is absolutely certain that they have been completely disconnected from the power supply. Burning oils, lubricants, plastics and coatings on the machine can give off gases and vapors that may be harmful to your health.
A qualified person should be consulted to repair the damage after a fire.

Electrical Power Supply

Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.
In practice, this may mean that the technician, electrician and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.

Energy sources (electrical/pneumatic/hydraulic, etc.) for the equipment shall be turned off or disconnected and the switches locked or labeled with a warning tag. It is the responsibility of the employer to establish control procedures. Follow lockout/tagout procedures before, setup and/or any service or maintenance work is performed, including lubrication, cleaning or clearance of jams.

Caution: The machine is still not completely de-energized even when the master switch is off.

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.

- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

- Kinetic energy - Note that some motors or spindles, for example, may continue to run or coast run on after being switched off.

- Potential energy - Individual assemblies may need to be secured if necessary for repair work.

Delivery of the Machine/Packaging

Note any markings on the packaging, such as weights, lifting points and special information. Avoid temperature fluctuations. Condensation may damage the machine.

Transport Damage

The packaging and machine must immediately be examined for signs of damage in transit. Such damage must be reported to the shipper/transporter within the applicable time limits. Contact Atlanta Attachment Company and/or your transport insurer immediately, if signs of damage are visible. Never operate a damaged machine.

Interim Storage

If the machine has to be stored temporarily, it must be oiled or greased and stored in a dry place where it is protected from the weather in order to avoid damage. A corrosion-inhibiting coating should be applied if the machine has to be stored for a longer period of time and additional precautions taken to avoid corrosion.

Transporting the Machine

Disconnect the machine from all external connections and secure any loose assemblies or parts. Never step under a suspended load. When transporting the machine or assemblies in a crate, ensure that the ropes or arms of a forklift truck are positioned as close to the edge of the crate as possible. The center of gravity is not necessarily in the middle of the crate. Note the accident prevention regulations, safety instructions and local regulations governing transport of the machine and its assemblies.

Only use suitable transport vehicles, hoisting gear and load suspension devices that are in perfect working order and of adequate carrying capacity. Transport should only be entrusted to duly qualified personnel.

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.
All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.
Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.

Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.
Protect against unauthorized access.
Ensure that the machine and accessories are set up in a stable position.
Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Local Regulations

Particular attention must be paid to local and statutory regulations, etc. when installing machines and the plant (e.g. with regard to the specified escape routes). Note the safety zones in relation to adjacent machines.

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.
Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.
Retighten all screw connections that have to be loosened for the maintenance and repair work. Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

The activities and intervals specified in the Instruction Manual for carrying out adjustments, maintenance and inspections must be observed and parts replaced as specified.

All hydraulic and pneumatic lines should be examined for leaks, loose connections, rubbing and damage whenever the machine is serviced. Any defects found must be remedied immediately.

Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard. Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control.

When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

Repair

Replacement Parts

We cannot accept any liability whatsoever for damage due to the use of parts made by other manufacturers or due to unqualified repair or modification of the machine.

Repair, Electrical

The power supply must be switched off (master switch off) and secured so that it cannot be switched on again inadvertently before starting any work on live parts.

Those parts of the machine and plant on which inspection, maintenance or repair work is to be carried out must be isolated from the power supply, if specified. The isolated parts must first be checked to determine that they are truly de-energized before being grounded and short-circuited. Adjacent live parts must also be isolated.

The protective measures implemented (e.g. grounding resistance) must be tested before restarting the machine after all assembly or repair work on electric parts.

Signal generators (limit switches) and other electrical parts on the safety mechanisms must not be removed or bypassed. Only use original fuses or circuit overloads with the specified current rating. The machine must be switched off immediately if a fault develops in the electrical power supply.

The electrical equipment of our machines must be checked at regular intervals and any defects found must be remedied immediately.

If it is necessary to carry out work on live parts, a second person should be on hand to operate the emergency OFF switch or master switch with voltage release in the event of an emergency. The working area should be cordoned off and marked by a warning sign. Only use electrically insulated tools.

Ventilation/Hazardous Gases

It is the end users responsibility to ensure adequate ventilation is provided to exhaust any and all noxious or hazardous gases that may be present in the working environment.

Hydraulic and Pneumatic Systems

Work on hydraulic or pneumatic equipment shall only be carried out by persons with training, knowledge and experience of hydraulic systems. Pressure lines shall be depressurized before starting any repair work.

General Liability

Liability for machine damage and personal injury is extinguished completely if any unauthorized conversions or modifications are undertaken. The machine must not be modified, enlarged or converted in any way capable of affecting safety without the manufacturer's prior approval.

Starting Machine Movements

Read the Instruction Manual carefully to establish which keys and functions start machine movements.

A Word to the End User

The end user has sole responsibility to enforce the use of safety procedures and guards on the machine. Any other safety devices or procedures due to local regulations should be should be retrofitted in accordance to these regulations and/or the EC Directive on the safety of machines.

Operator's position must always be readily accessible. Escape routes must always be kept clear and safety areas should be identified.

Safety Precautions

Safety should be a constant concern for everyone. Always be careful when working with this equipment. While normal safety precautions were taken in the design and manufacture of this equipment, there are some potential safety hazards.
Everyone involved with the operation and maintenance of this equipment should read and follow the instructions in this manual.
Operate the equipment only as stated in this manual. Incorrect use could cause damage to the equipment or personal injury.
It is the owner's responsibility to make certain that the operator reads and understands this manual before operating this equipment. It is also the owner's responsibility to make certain that the operator is a qualified and physically able individual, properly trained in the operation of this equipment.
Specific safety warning decals are located on the equipment near the immediate areas of potential hazards. These decals should not be removed or obliterated. Replace them if they become non-readable.

- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS operate equipment in daylight or with adequate working lights.
- Follow daily and weekly checklists, making sure hoses are tightly secured and bolts are tightened.
- ALWAYS watch and avoid holes or deep depressions.
- ALWAYS wear adequate eye protection when servicing the hydraulic system and battery.
- NEVER operate a poorly maintained machine.
- NEVER allow persons to operate this machine without proper instruction.
- NEVER put hands or feet under any part of the machine while it is running.
- NEVER attempt to make any adjustments or repairs to the machine while running. Repairs or maintenance should be performed by trained personnel only.
- NEVER work under the machine unless it is safely supported with stands, blocks or a hoist and blocks.
- NEVER touch hot parts of machine.

Electrical & Pneumatic Specifications

Electrical: 220 VAC, 5amp, 50/60 Hz Single Phase
Pneumatic: 70 PSI, 20 SCFM avg. (3/8" Airline).
Set the regulator to 70 PSI.
Pressure setting valves:

Parameter Settings for Efka Controller (11338SFJ27-PAR1)

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

PARAMETER	RANGE	VALUE	DESCRIPTION
Do this first	*****	****	Perform a master reset before programming, see below
290		5	Mode of operation. MUST SET THIS PARAMETER FIRST!
111	200-9900 rpm	300	Maximum speed.
117	400-9900rpm	300	High lift walking speed limitation.
123	4000-9900rpm	300	Speed Limitation n11.
137	0-1	1	High lift on/off.
153	0-50	35	Braking power at standstill.
161	0-1	0=CW	Motor rotation.
204	001-100	100	Footlift (FL) holding power.
213	001-100	100	Bactack (VR) holding power
240	0-54	14	High lift output (flip/flop 1)
241	0-54	16	Stitch cond. Output (edgeguide)
242	0-54	22	Speed limitation output (flip/flop 2)
270	0-5	1	External handwheel sensor configuration.
272	020-255	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.
ENTER CODE 5913			
340		50	IN1 Threshold
344		50	IN3 Threshold
436		0	Use code "5913". This disables an input that was causing box to reset itself.

Front panel LED's:

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

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "311"
3. Press "E" once and "2.0.0." is displayed. This is a parameter.
4. Press "E" again and the value for parameter 200 is displayed.
5. With the value on the screen, adjust to desired setting.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
8. **Run sewing head to save parameters before powering down**

To Perform Master Reset of Parameters:

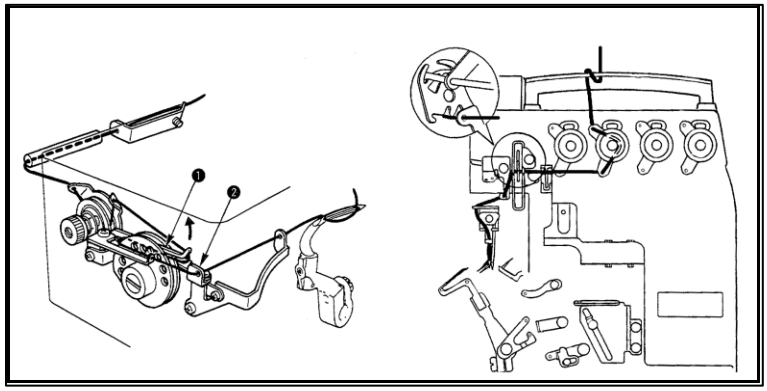
1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "591"
3. Press "E" twice and "093" is displayed.
4. Press "+" once, "094" is displayed.
5. Press "P" to exit programming mode with all default values.

Machine Operation

Threading the Sewing Head

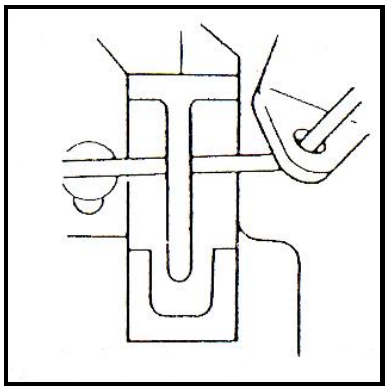
Refer to the illustration below for threading directions.

Warning: To avoid injury, disconnect the power source before threading the machine, making adjustments or performing maintenance.

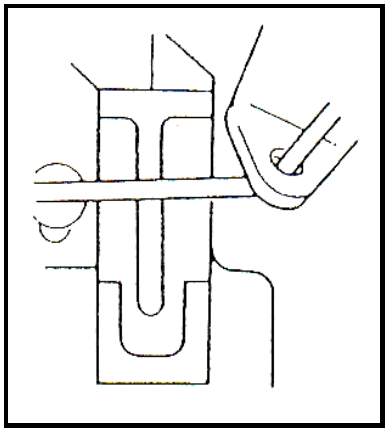


Threading the Thread Lubricator

When the needle cooler is used, pass the thread under the center finger.

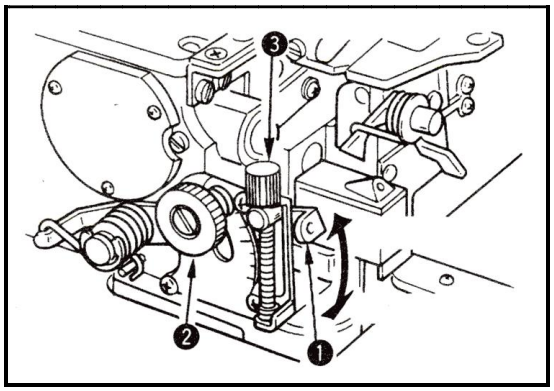


When the needle cooler is not used, pass the thread over the center finger.



Adjustments

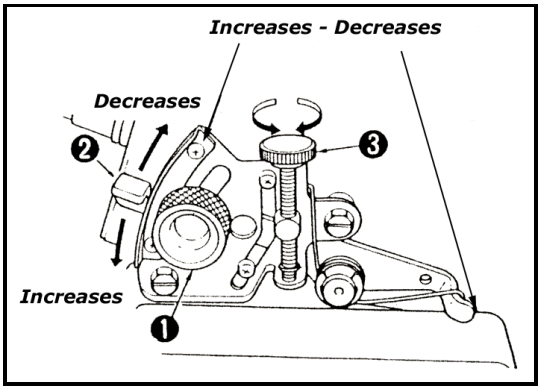
The adjustments mentioned below will have already been made at the factory before the unit is shipped. These instructions are for reference only.
Warning: To avoid injury, disconnect the power source before making adjustments



Differential Feed Mechanism

1. Loosen the differential feed lock nut (2).
   Move the lever (1) up for shorter stitch or down for longer stitch.
2. When you want to move the lever (1) only slightly, use the adjustment screw (3).
3. After the adjustments have been made, securely tighten the lock nut (2).

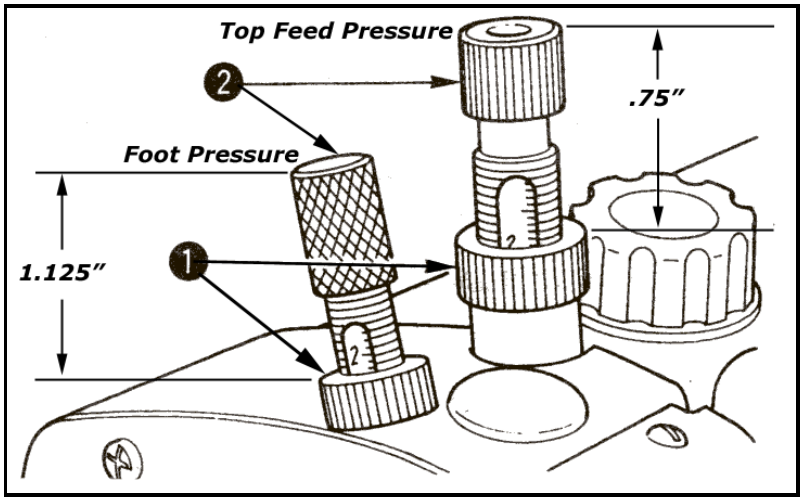
Changing the Top Feed Amount (Horizontal Stroke)



The top feed amount (horizontal stroke) is changed by loosening the locknut (1) and moving the adjusting lever (2). The fine adjusting screw (3) can be used to move the lever with precision.
After the adjustment has been made, securely tighten the lock nut (1).

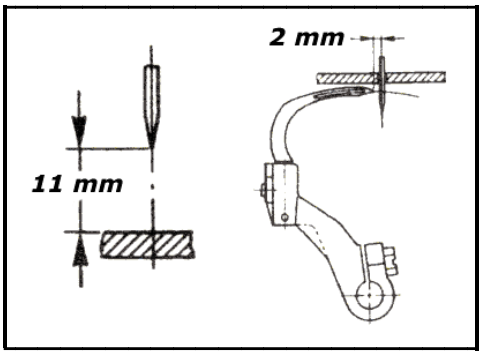
Adjusting Top Feed & Foot Pressure

Loosen the nut (1) and turn the presser spring regulator (2) until the distance shown in the illustration on the left is achieved.
If the top feed pressure is higher than necessary, extra wear and tear will occur. This will affect the durability and performance of the machine.
Warning: To avoid injury, disconnect the power source before making adjustments

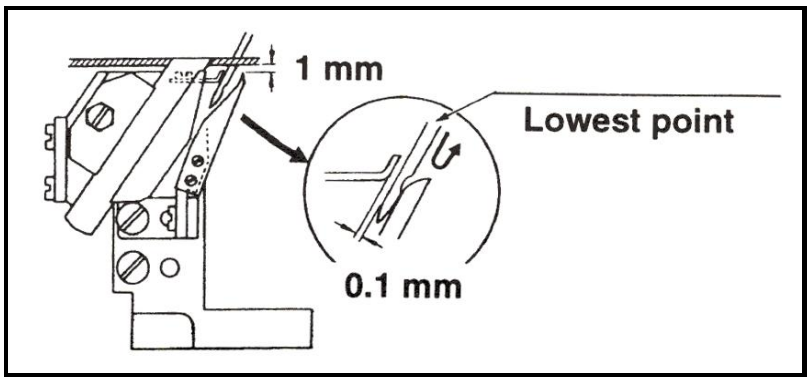


Adjusting the Timing of Loopers and Needle Guard

The looper and needle guard are set according to the dimensions in the illustrations on the left at the factory. Adjustment will depend on the sewn products and thread being used.

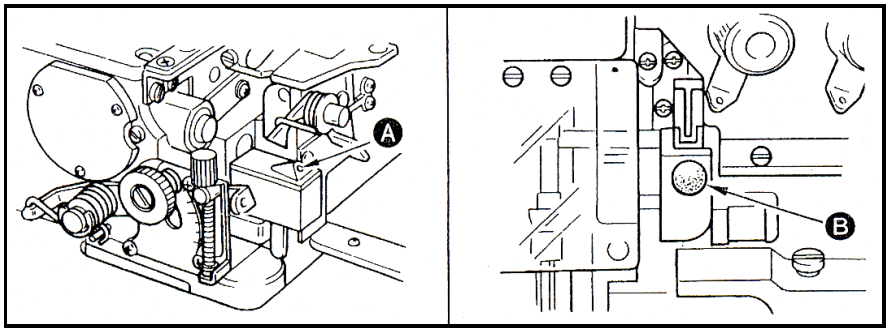


Warning: These adjustments should be made by a qualified technician. To avoid injury, disconnect the power source before making adjustments. Be sure that all screws are tightened and that none of the components come in contact with each other before restoring power to the machine.



Lubricating the Needle Cooler

1. Open the cloth plate cover and add silicon oil at point (A).
2. Remove plug (B), and add silicon oil.
3. Saturate the oil felt with silicon oil.



Machine Maintenance

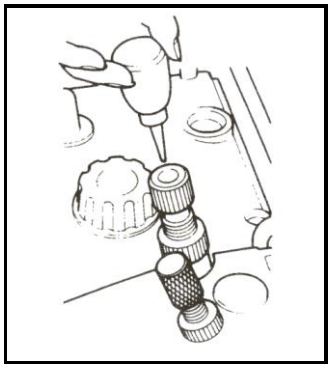
Regularly scheduled maintenance of the model 1338 unit reduces possible problems and downtime. Proper care will also ensure a longer life and better performance of the machine.

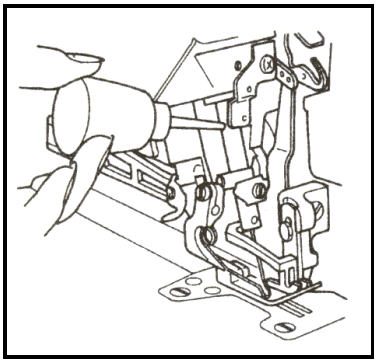
Perform the following procedures to properly maintain the machine.

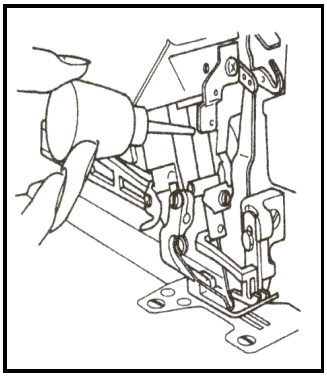
1. Clean the machine once or twice a day.
   A. Wipe off both electric photo eyes with a clean, nonabrasive, dry cloth.
   B. Use a blow-off hose to remove and excess lint, thread or other clippings.
   C. Clean the lint from the edge guide drive belt and pulley.
2. Refer to the Juki sewing head manuals for the manufacturer's recommendations and guidelines for maintenance and lubrication of the sewing head.
3. Check the main air filter weekly. Change the filter element once every 6 months.
4. Lubricate the linear rail bearing on the flange guide assembly with bearing grease once every month.
5. Change the oil and filter in the sewing machine every 3 to 4 months.

If the pointer bar of the oil gauge falls below the lower marker line of the gauge, add oil.

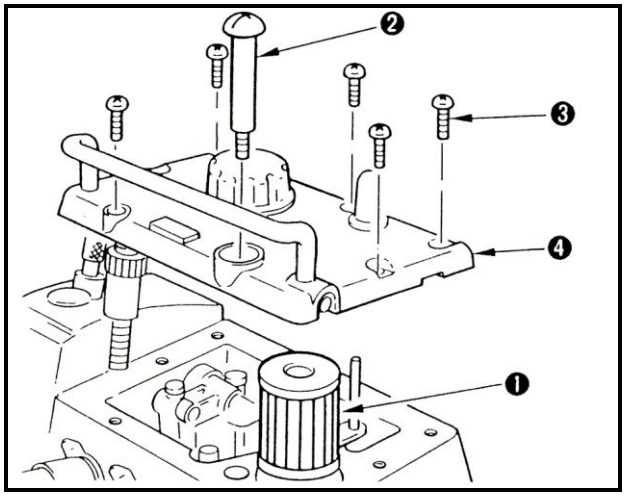
Apply two or three drops of oil to the needle bar and upper looper guide and presser spring regulator before operating the machine for the first time and after a long period of disuse.



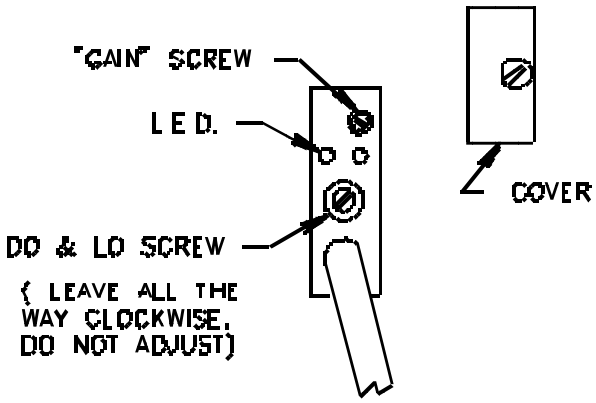




Over time, the filter (1) may become clogged with dirt. If the machine continues to run, the oil may not be able to pass through the filter and the machine may wear out abnormally or seize completely. To check and replace filter:
Remove the oil discharging screw (2).
Remove screws (3), and lift the top cover (4).
Remove cartridge filter (1). Check the filter and clean or replace if necessary.



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". On the handwheel sew eye, this screw should be set to the maximum clockwise position. On the border edge guide eye, this screw should be set to the maximum counter-clockwise position.

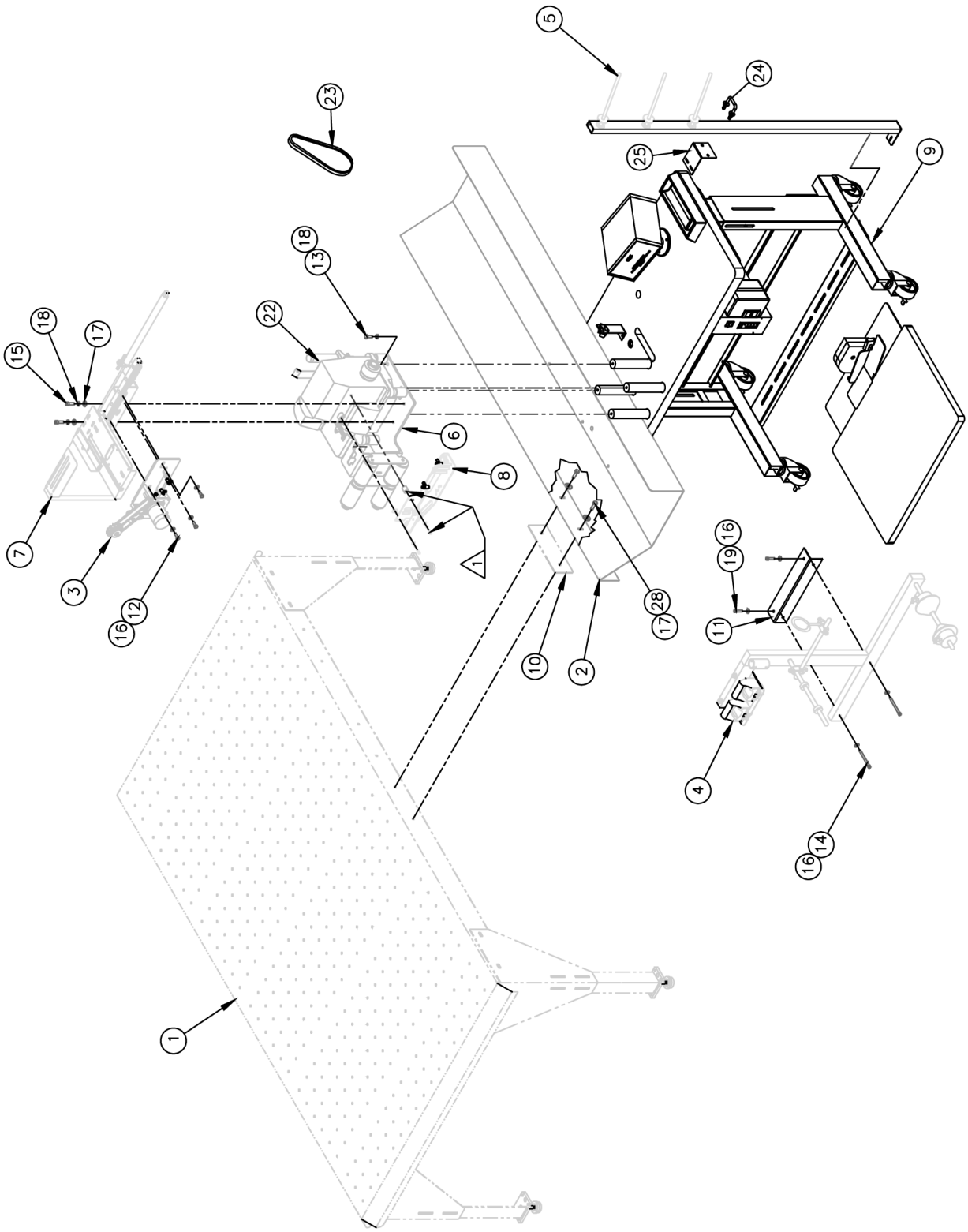
With the end of the sensor pointing at the center of the reflective tape, turn the "GAIN" screw counter-clockwise until the red LED indicator is off. Then turn the "GAIN" screw clockwise until the LED indicator comes on. Then turn the "GAIN" screw one full turn clockwise. The LED indicator should be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

Reflective Tape Maintenance

Use a soft cloth for cleaning.
Do not use chemicals or abrasives to clean it.
Avoid any contact with oils and liquids.
Do not touch the tape with bare fingers.
If tape is dirty or opaque, the eye may not function correctly.

Assembly Drawings & Parts Lists

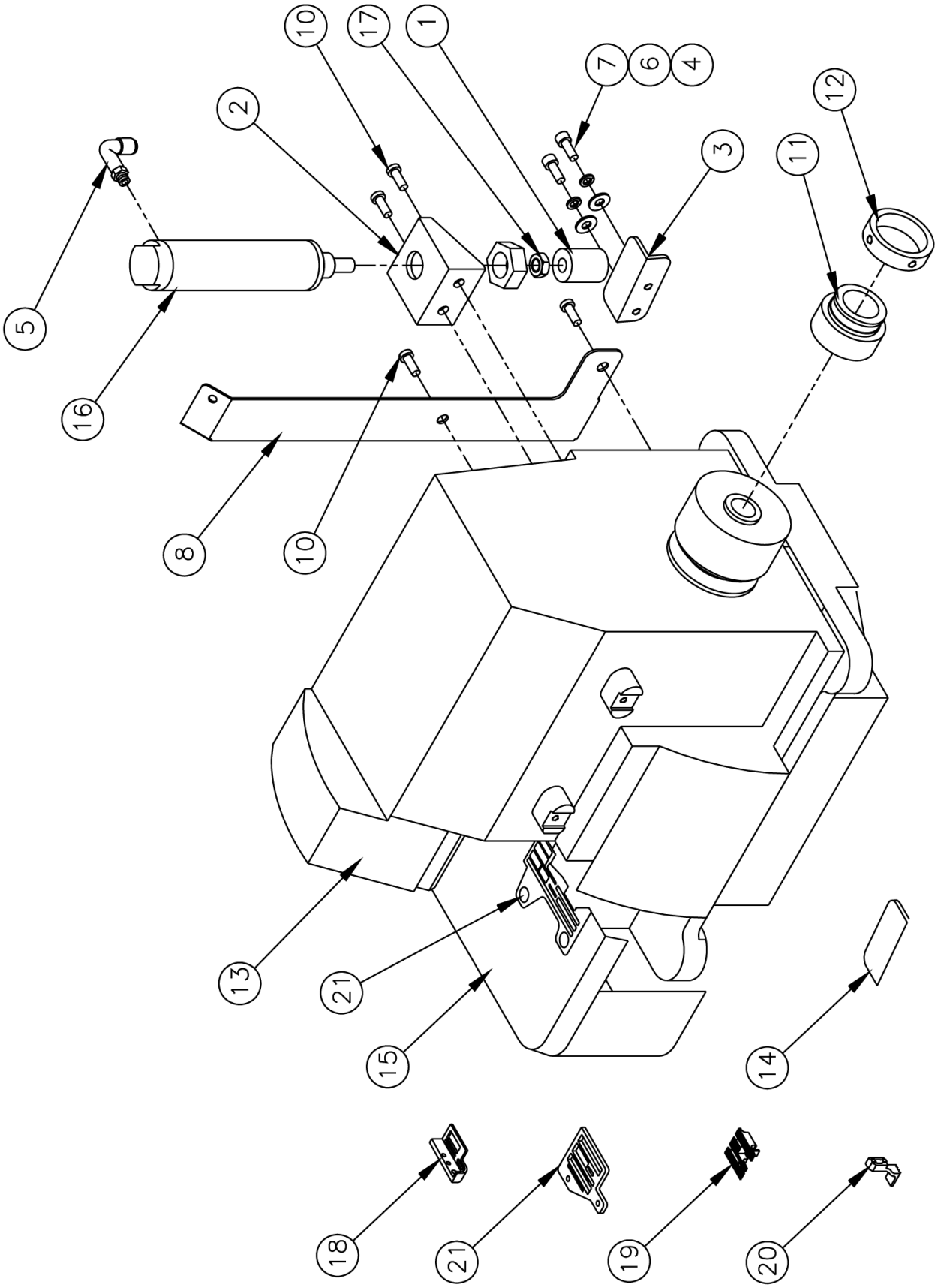
The materials contained herein are confidential and proprietary information of Atlanta Attachment Company. In addition to any confidentiality and non-disclosure obligations that currently exist between you and Atlanta Attachment Company, your use of these materials serves as an acknowledgment of the confidential and proprietary nature of these materials and your duty not to make any unauthorized use or disclosure of these materials.



11339HFJ27 Cap/Flange Workstation

AAC Drawing Number 192122B Rev 3

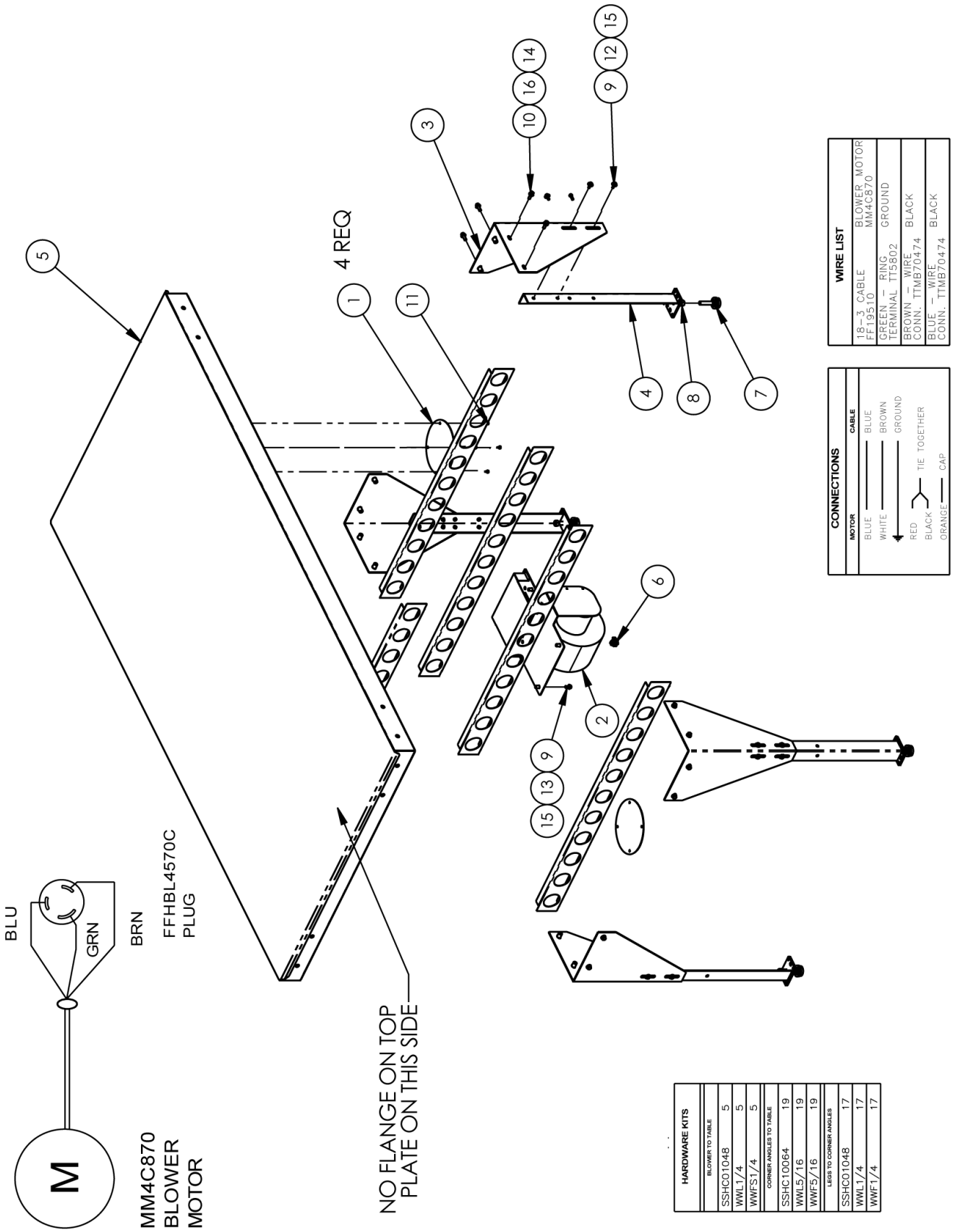
NO.	QTY	PART #	DESCRIPTION	
1	1	1337A-160	Air Table Assy	Page 22
2	1	1338-022	Border Tray	
3	1	1338-2000	Edge Guide Assy	Page 28
4	1	1338-3000	Flange Holder Assy	Page 30
5	1	1338-5000A	Roll Holder Assy	Page 32
6	1	1338-6000	Sew Head Mount Assy	Page
7	1	1338-7000A	Flange Guide Assy	Page 36
8	1	1339-100	Pneumatic Binder Assy	Page 38
9	1	1338H-1000	Console Assy	Page 24
10	AR	1338-023	Spacer	
11	1	1338-031	Brkt	
12	3	SSHC01048	Screw, Hex Cap	
13	4	SSHC10048	Screw, Hex Cap	
14	2	SSSC01080	Screw, Socket Cap	
15	2	SSSC10040	Screw, Socket Cap	
16	9	WWFS1/4	Flat Washer	
17	2	WWFS5/16	Flat Washer	
18	6	WWL5/16	Lock Washer	
19	4	SSZH#01096	Screw, Sheet Metal	
20	AR	1338-LAB	Labels	
21	AR	11338SFJ27-PAR1	Parameter Settings	Page 10
22	1	11338HSJ27	Sew Head Assy	Page 20
23	1	ZX3844	Belt	
24	1	MM3060T44	U-Bolt	
25	1	1338106	Brkt	



11338HSJ27 Sew Head Assembly

AAC Drawing Number 192979C Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	11200A	Bumper
2	1	112J27-01	Footlift Mnt Brkt
3	1	112J27-02	Arm Extension
4	2	WWL10	Lock Washer
5	1	AAQME-5-8	Elbow Fitting
6	2	WWFS10	Flat Washer
7	2	SSSC98032	Screw, Socket Cap
8	1	1338-012	Thread Guide
9	10	SN135X722	Needle
10	4	SSM7151210	Screw
11	1	311-128	Tape Mount Hub
12	1	311-129	Tape Mount Sleeve
13	1	SJUKI-6916A	Sewing Head
14	1	49005	Throat Plate Mount
15	1	49021	Cloth Plate
16	1	AAC6DP-2	Air Cylinder
17	1	NNJ5/16-24	Jam Nut
18	1	M1J27-002A	Presser Foot
19	1	M2J27-001	Feed Dog, Main
20	1	M2J27-002A	Feed Dog, Top
21	1	M3J27-001	Throat Plate



1337A-160 Air Table Assembly

AAC Drawing Number 1337296 Rev 7

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

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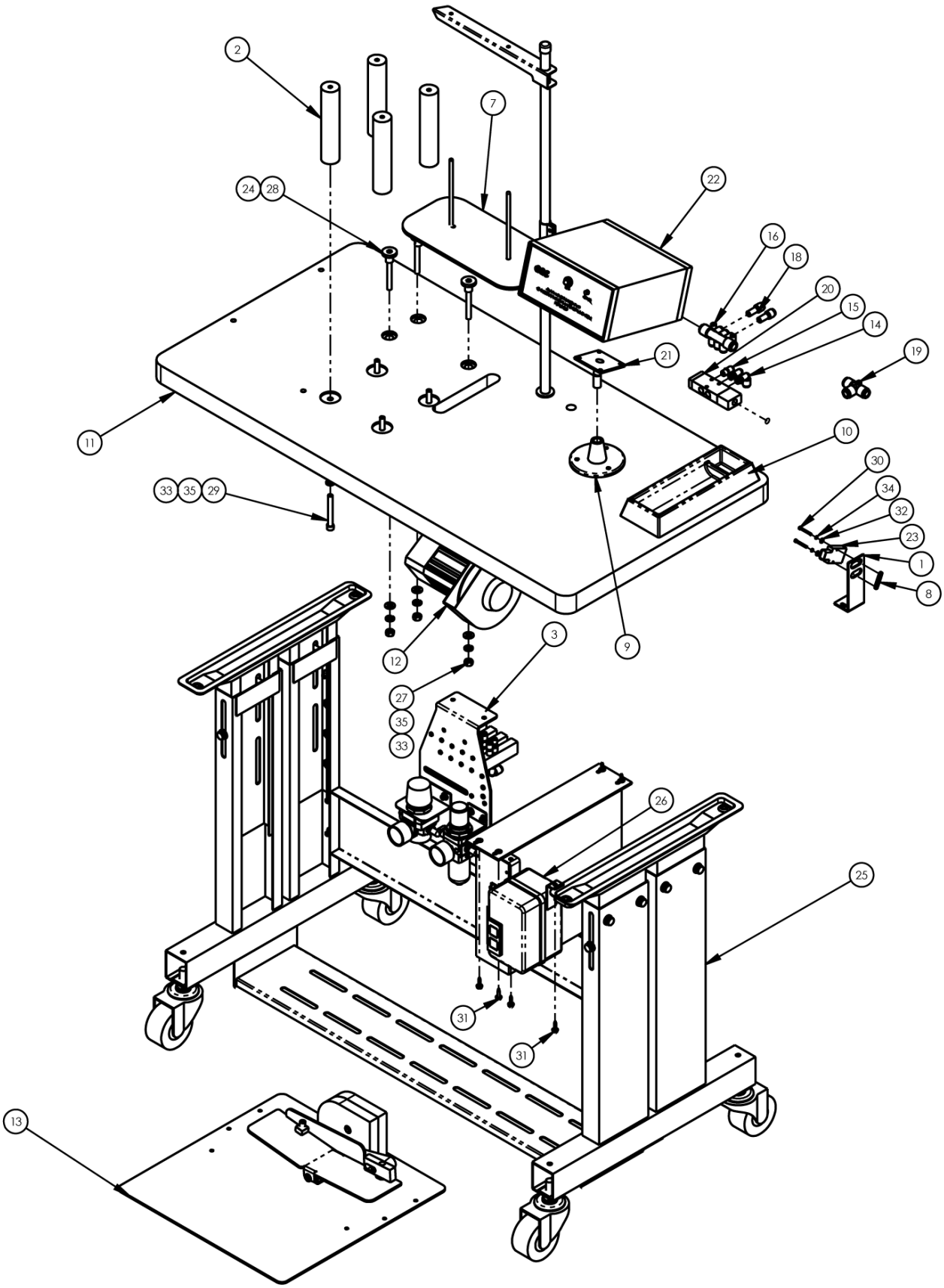
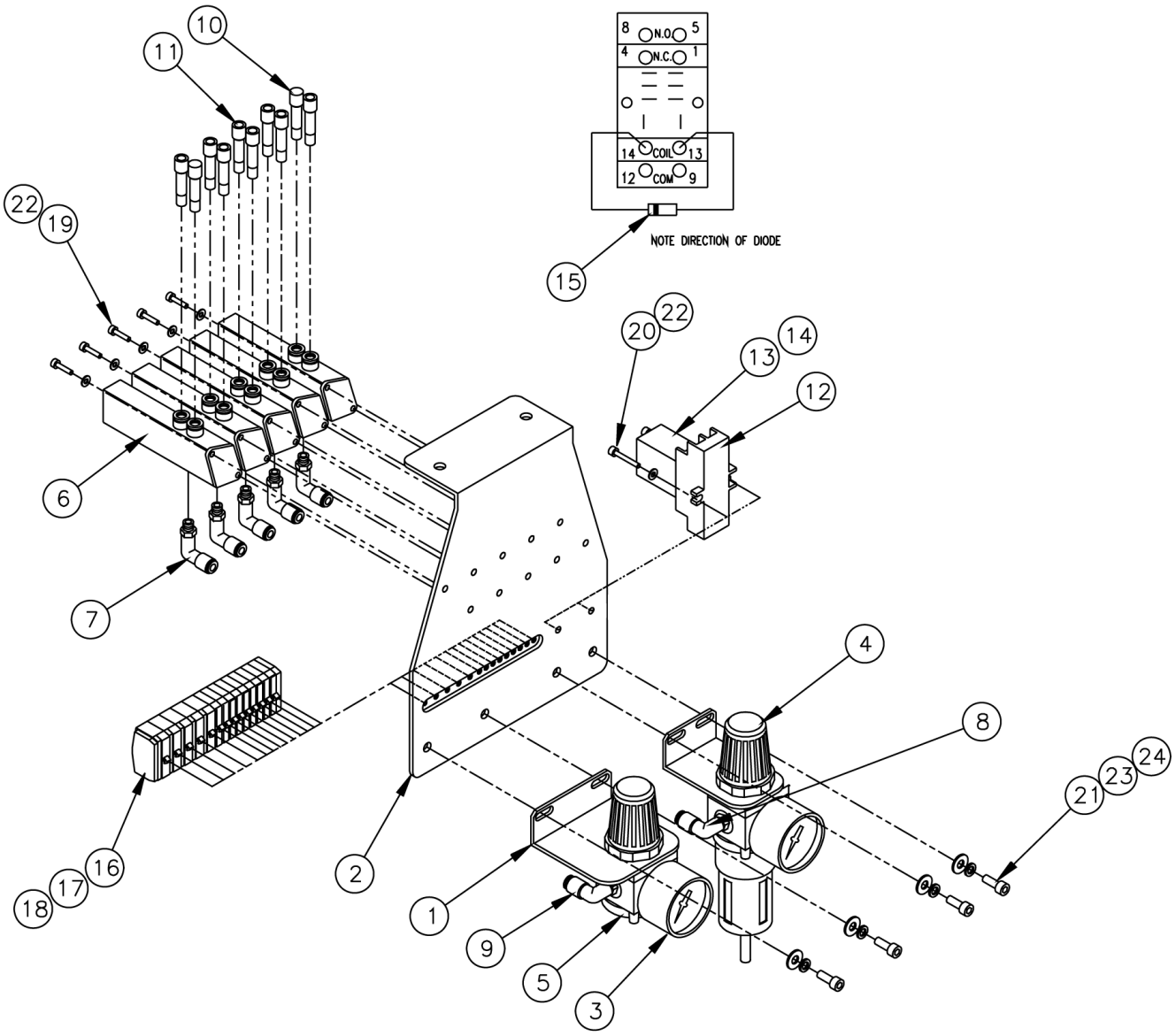


1338H-1000 Console Assembly

AAC Drawing Number 9000105 Rev 2

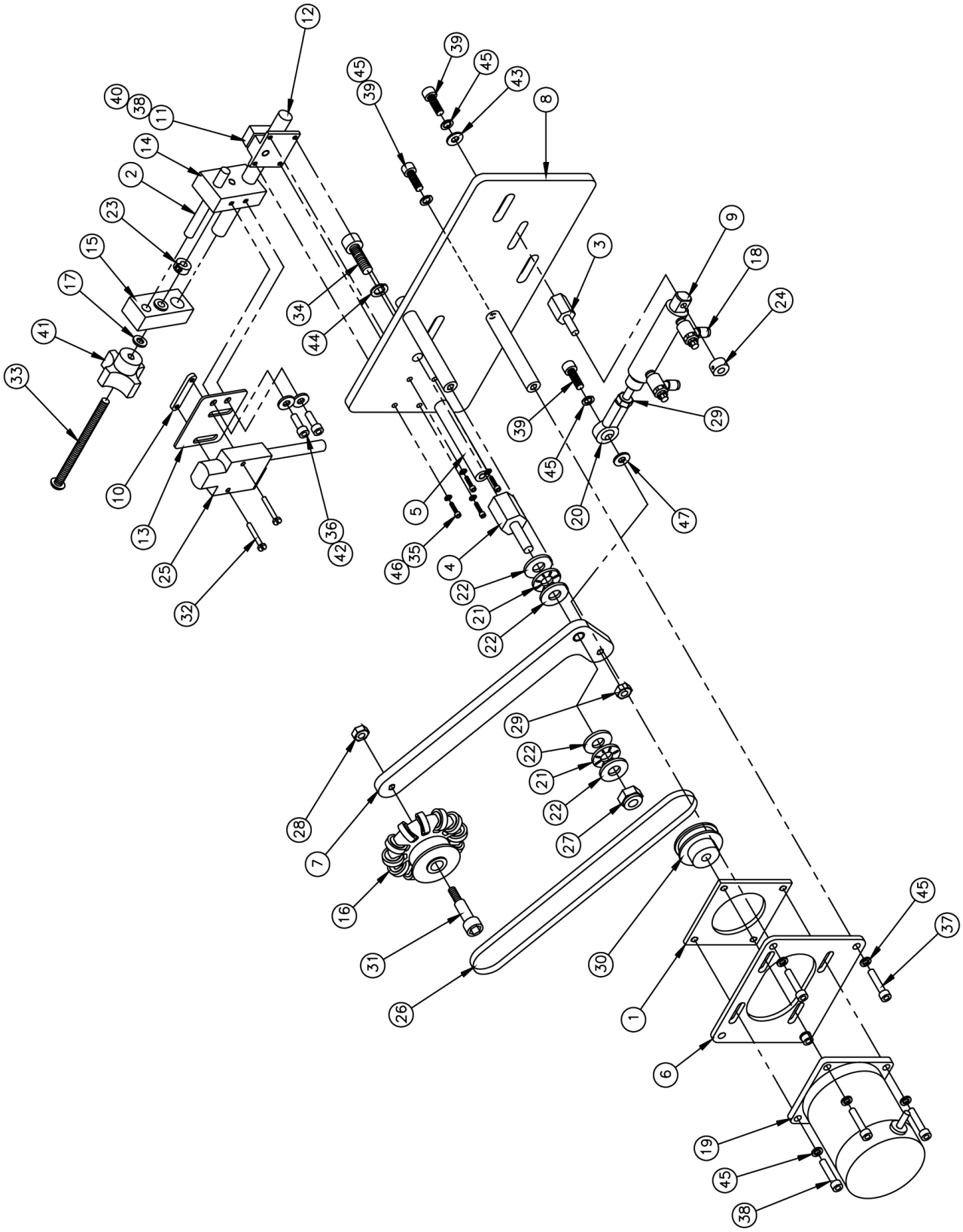
NO.	QTY	PART #	DESCRIPTION	
1	1	1278-6689B	BRACKET, EYE MOUNT	
2	4	1338-018	SPACER, HEAD	
3	1	1338-1500	PNEUMATIC PANEL ASSY 1338	Page 26
4	1	1338-4000	ELECTRICAL COMPONENTS	
5	AR	1338-PD	DIAGRAM,PNEUMATIC	Page 41
6	AR	1338-WD	DIAGRAM,WIRING	Page 42
7	1	1959-112	2 POS THREAD PLATE ASSY	
8	1	21114A	BASE,STAND,1/2"BORE	
9	1	4048-1338	TABLE TOP	
10	1	4059-DC1500	MOTOR,DC WITH CONTROLLER	
11	1	4059-FP301D	FOOT PEDAL ASSY,EFKA	
12	2	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8	
13	1	AAQME-5-8	QUICK MALE ELBOW	
14	1	AAQMF-144	6-STATION AIR MANIFOLD	
15	1	AAQPP-11	PLUG, QUICK 3/8 TUBE	
16	2	AAQPR-3-4	QUICK REDUCER 3/8-1/4	
17	1	AAQUT-3-3	QUICK UNION T 3/8X3/8	
18	1	AAV125B	PILOT VALVE	
19	1	AP-28-607	MOUNTING POST, 2 X 2	
20	1	AP-28-640	CONTROL BOX,COMPLETE	
21	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	
22	3	K-102-21	ROD,TH,5/16-18,2-1/2L	
23	1	K-CB600	MOTOR STARTER,ELEC	
24	3	NNH5/16-18	5/16-18 HEX NUT	
25	3	NNM103	NUT,RECESSED,5/16-18	
26	4	SSSC10160	5/16-18 X 2-1/2 SOC CAP	
27	2	SSSC70064	#4-40 X 1 SOC CAP	
28	6	SSZH#10048	SCREW,SHT.METAL HEX 10	
29	2	WWF4	WASHER, FLAT #4	
30	7	WWFS5/16	WASHER, FLAT, 5/16	
31	2	WWL4	#4 LW	
32	7	WWL5/16	5/16 LW	
33	1	1975-412A	PLATE,NUT,4-40,.95CTC	
34	1	K-4D	HD T LEG ADJ STAND	



1338-1500 Pneumatic Panel Assembly

AAC Drawing Number 192047B Rev 1

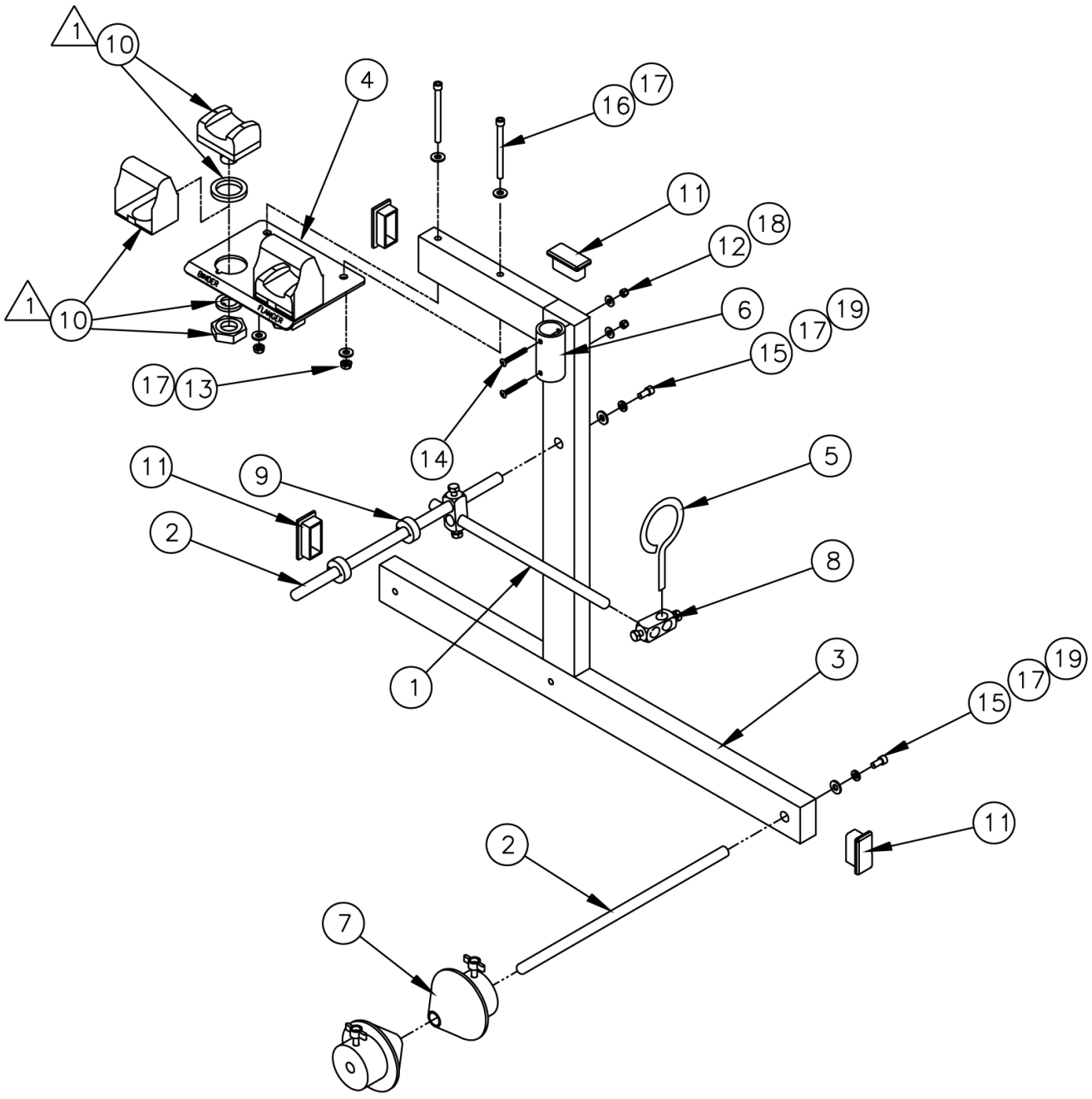
NO.	QTY	PART #	DESCRIPTION
1	1	0411-071	Regulator Brkt
2	1	1338-024	Pneumatic Panel
3	1	AA198-503	Air Guage
4	1	AA198-5102	Regulator
5	1	AA198-RP3	Regulator
6	5	AAEVQZ2121	Valve
7	5	AAQME-4-8	Quick Male Elbow
8	3	AAQME-4-4	Quick Male Elbow
9	1	AAQME-5-4	Quick Male Elbow
10	2	AAQPP-07	Quick Plug
11	8	AAQPR-5-4	Quick Reducer
12	1	EE27E487	Terminal Socket
13	1	EEK10P11D1	Relay, 24VDC
14	1	EE20C297	Retaining Spring
15	1	FF1N4937	Diode, 200NS, 1A
16	9	FF264-311	Single Wago
17	5	FF264-341	Dual Wago
18	1	FF264-371	End Wago
19	10	SSSC70024	Screw, Socket Cap
20	2	SSSC70048	Screw, Socket Cap
21	4	SSSC98032	Screw, Socket Cap
22	12	WWF4	Flat Washer
23	4	WWFS10	Flat Washer
24	4	WWL10	Lock Washer



1338-2000 Edge Guide Assembly

AAC Drawing Number 192042B Rev 3

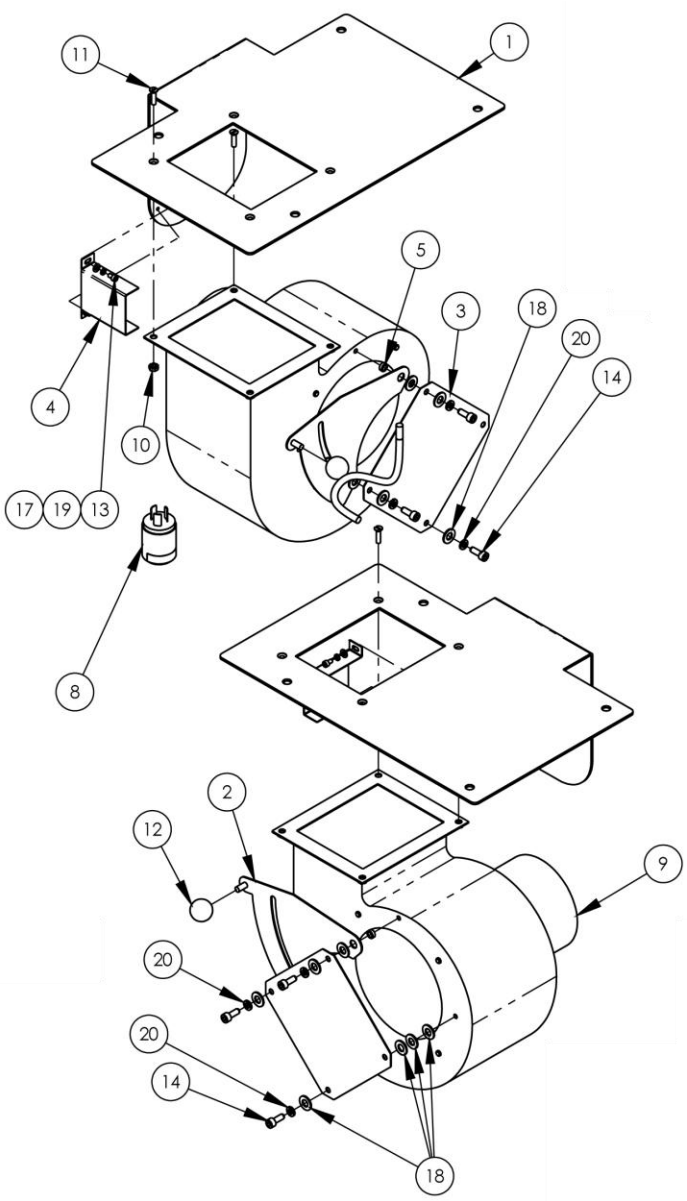
NO.	QTY	PART #	DESCRIPTION
1	1	1278-6690	Nut Plate
2	1	1278-6942	Rod, Eye Mount
3	1	12787-1620	Standoff, Pivot
4	1	12787-1632	Standoff
5	3	12787-1634	Standoff, 2.5L
6	1	132556-511	Motor Mount
7	1	132556-513	Pivot Arm
8	1	1338-001	Mount Plate
9	1	1975-213	Air Cylinder
10	1	1975-412A	Nut Plate
11	1	23132A	Eye Holder
12	1	40-508	Shaft, Roller
13	1	40-551A	Adj. Plate
14	1	40-553	Eye Mount
15	1	40-554	Adj. Bar
16	1	40-630	Guide Wheel Assy
17	1	AA198-7006	O-Ring
18	2	AA198RR510	Flow Control
19	1	AP-22E-103	Step Motor
20	1	BBAW-3Z	Rod End Bearing
21	2	BBNTA411	Thrust Bearing
22	4	BBTRA411	Thrust Washer
23	1	CCCL10T	Clamp Collar
24	1	CCSC33/16M	Set Collar
25	1	FFSM312LVQ	Electric Eye
26	1	GG6R195018	Belt
27	1	NNE1/4-20	Elastic Lock Nut
28	1	NNH10-24	Hex Nut
29	2	NNH10-32	Hex Nut
30	1	PP40DF1808	Gear Pulley
31	1	SSAS016064	Screw, Allen Shoulder
32	2	SSPS70040	Screw, Pan Head
33	1	SSPS98192F	Screw, Pan Head
34	1	SSSC01048	Screw, Socket Cap
35	4	SSSC70024	Screw, Socket Cap
36	2	SSSC90032	Screw, Socket Cap
37	3	SSSC98032	Screw, Socket Cap
38	5	SSSC98040	Screw, Socket Cap
39	5	SSSC98048	Screw, Socket Cap
40	1	SSW#10	Wing Screw Knob
41	1	TTCL1APPK1	Plastic Knob
42	2	WWF8	Flat Washer
43	1	WWFS10	Flat Washer
44	1	WWL1/4	Lock Washer
45	12	WWL10	Lock Washer
46	4	WWL4	Lock Washer
47	1	WWB10S	Brass Washer



1338-3000 Flange Holder Assembly

AAC Drawing Number 192043B Rev 0

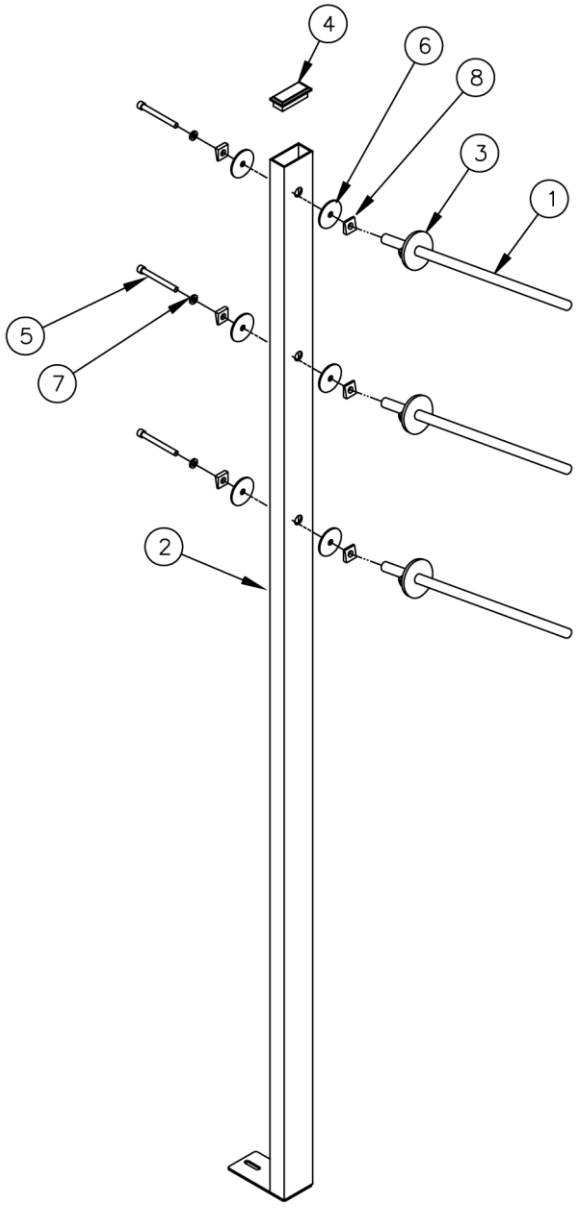
NO.	QTY	PART #	DESCRIPTION
1	1	1335-320C	Rod, 3/8 x 9
2	2	1335-816	Rod, 1/2 x 13.31
3	1	1338-008	Frame, Roll Holder
4	1	1338-027	Sensor Brkt
5	1	1338-028	Ring, Tape Guide
6	1	13453385	Scissor Holder
7	2	787-4A-032	Cone Bearing Assembly
8	2	A-U	Rod Connector
9	2	CCCL8F	Clamp Collar
10	2	FF0TBVN6	Switch
11	4	MM132-1496	End Cap
12	2	NNE10-32	Elastic Lock Nut
13	2	NNK1/4-20	Kep Nut
14	2	SSBC98096	Screw, Button Cap
15	2	SSSC01032	Screw, Socket Cap
16	2	SSSC01160	Screw, Socket Cap
17	6	WWFS1/4	Flat Washer
18	2	WWFS10	Flat Washer
19	2	WWL1/4	Lock Washer



1337135 Blower Assembly

AAC Drawing Number 1337135 Rev2

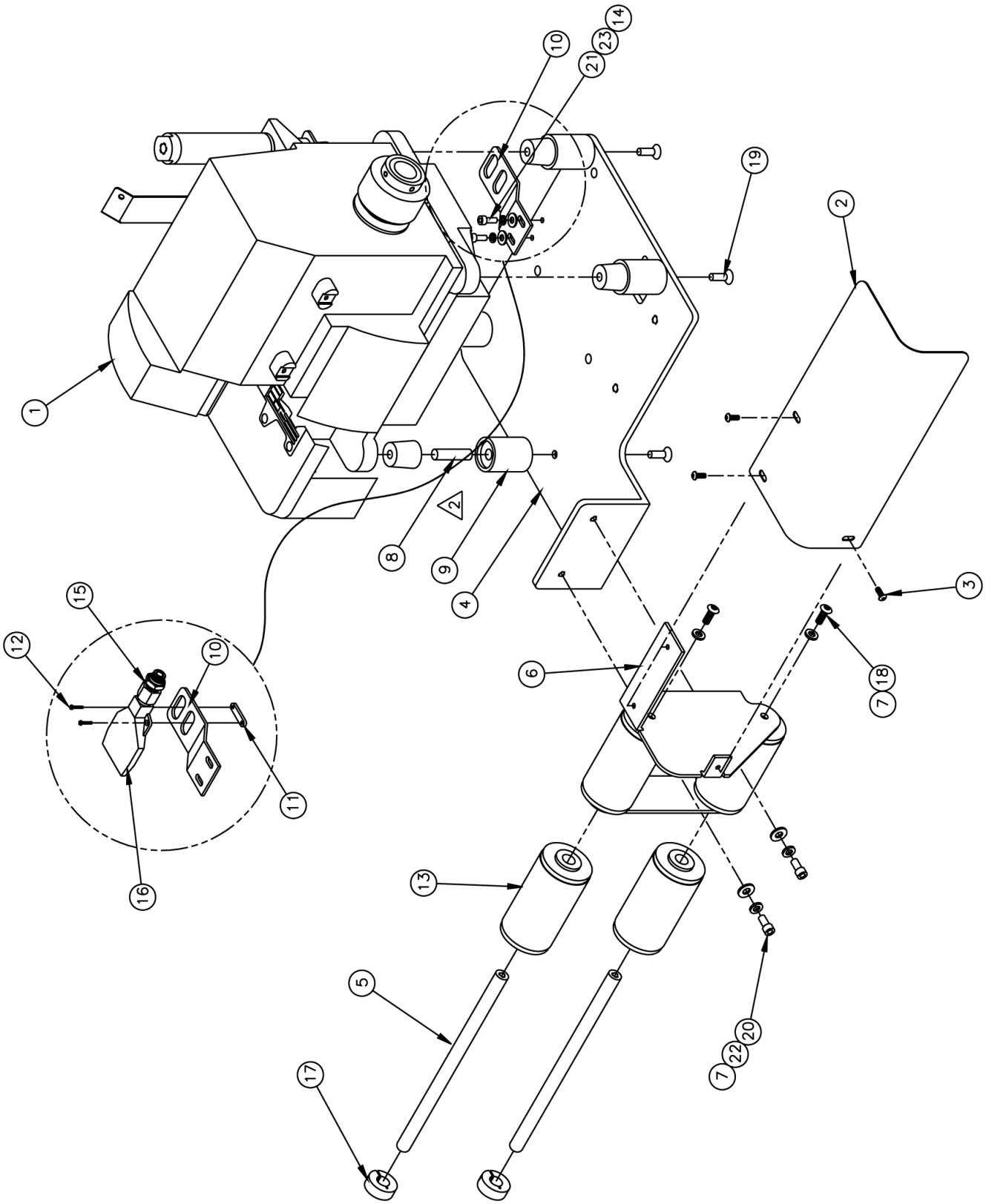
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1337116	ADAPTOR, BLOWER	11	4	SSFS98048	#10-32 X 3/4, FLAT SLOT
2	1	1337133	SPACER, BLOWER ASSY	12	1	SSMBK13	KNOB,BLACK PLASTIC
3	1	1337134	GRILL,BLOWER INLET	13	2	SSSC90016	#8-32 X 1/4 SOC CAP SC
4	1	1337136	COVER,CAPACITOR	14	3	SSSCM6X16	M6X16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



1338-5000A Tape Roll Holder Assembly

AAC Drawing Number 192119A Rev 1

NO.	QTY	PART #	DESCRIPTION
1	3	1335-816	Rod, S/S, 13.31l
2	1	1338-025C	Tube, Roll Holder
3	3	A-4-032	Hub
4	1	MM132-1496	End Cap
5	3	SSSC01128	Screw, Socket Cap
6	6	WWFE016	Fender Washer
7	3	WWL1/4	Lock Washer
8	6	WWSQ044	Square Washer



1338-6000 Sewing Head Mount Assembly

AAC Drawing Number 192778C Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1	11338HSJ27	Sew Head Assy
2	1	1338-030	Motor Cover
3	3	SSBC98024	Screw, Button Cap
4	1	1338-003	Mount Plate
5	2	1338-004	Rod, 1/2 x 9
6	1	1338-005	Plate, Roller Mount
7	4	WWL1/4	Lock Washer
8	4	IID020X080	Dowel Pin
9	4	1338-017	Isolator Mount
10	1	1338-029	Air Nozzle Brkt
11	1	1975-412A	Nut Plate
12	2	SSPS70048	Screw, Pan Head
13	4	33005671	Roller
14	2	WWL10	Lock Washer
15	1	AAQBC-4-4	Bulkhead Union
16	1	MM5329K21	Air Nozzle
17	2	CCCL8F	Clamp Collar
18	2	SSBC01032	Screw, Button Cap
19	4	SSFC01048	Screw, Flat Allen
20	2	SSSC01032	Screw, Socket Cap
21	2	SSSC98032	Screw, Socket Cap
22	2	WWFS1/4	Flat Washer
23	2	WWFS10	Flat Washer

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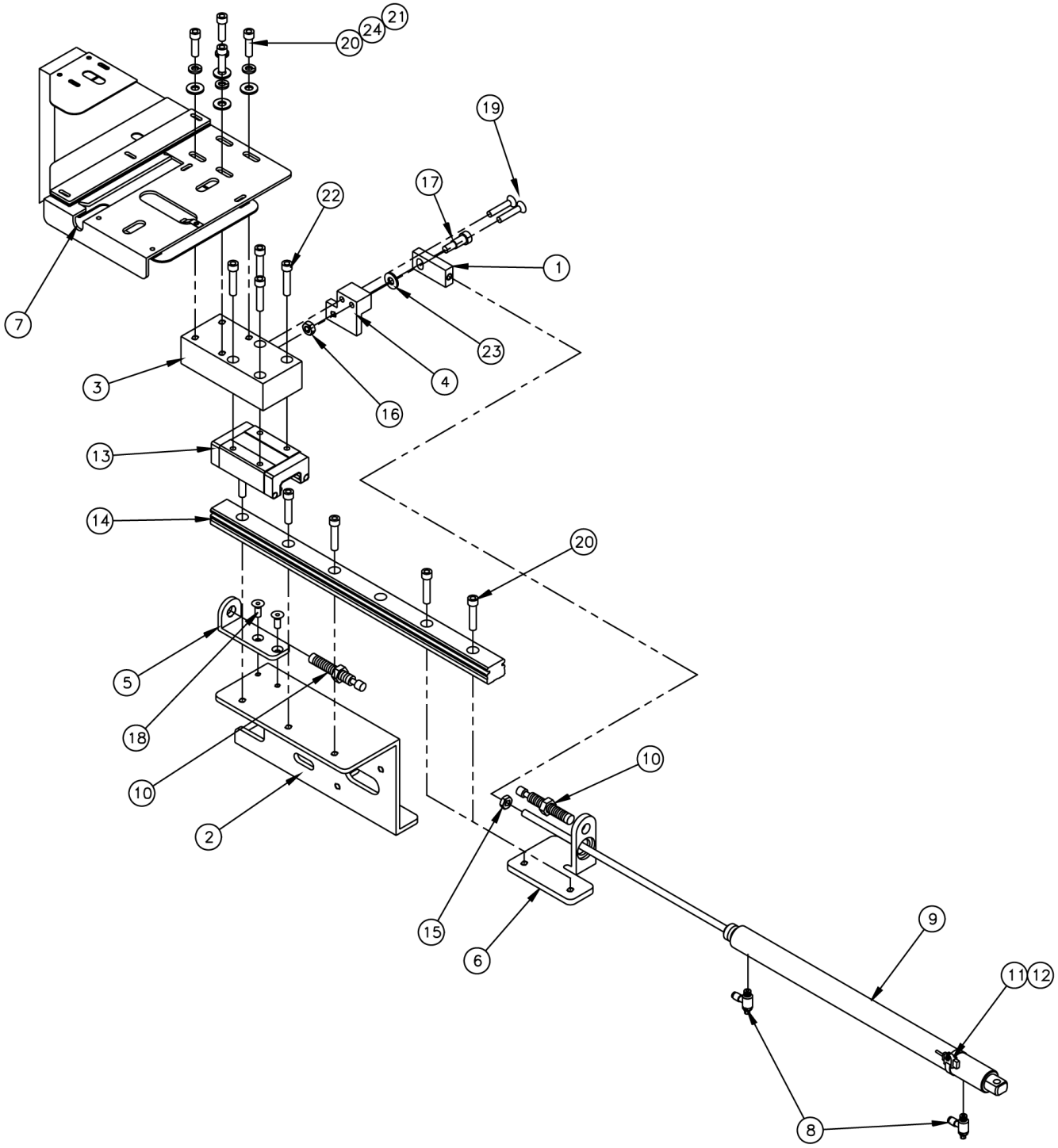

1338-7000A Flange Guide Assembly

AAC Drawing Number 192124B Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1335-345	Rod Link
2	1	1338-002	Mount Brkt
3	1	1338-006	Spacer
4	1	1338-007	Mount Block
5	1	1338-013	Shock Absorber Mount
6	1	1338-014	Cylinder Mount Brkt
7	1	552-48	Right Angle Guide
8	2	AA198RA508	Flow Control
9	1	AACM0410DXP	Air Cylinder
10	2	AACSS04	Shock Absorber
11	1	AAEHSKQ	Switch
12	1	AAFD35456-6	Band For Switch
13	1	MMAGH25CAN	Bearing Block
14	1	MMAGR25360N	Linear Rail
15	1	NNJ1/4-28	Jam Nut
16	1	NNK1/4-20	Kep Nut
17	1	SSAS020032	Screw, Allen Shoulder
18	2	SSFC98032	Screw, Flat Allen
19	2	SSFC98064	Screw, Flat Allen
20	9	SSSC01048	Screw, Socket Cap
21	4	WWL1/4	Lock Washer
22	4	SSSCM6X30	Screw, Socket Cap
23	1	WWFF1/4A	Felt Washer
24	4	WWFS1/4	Flat Washer

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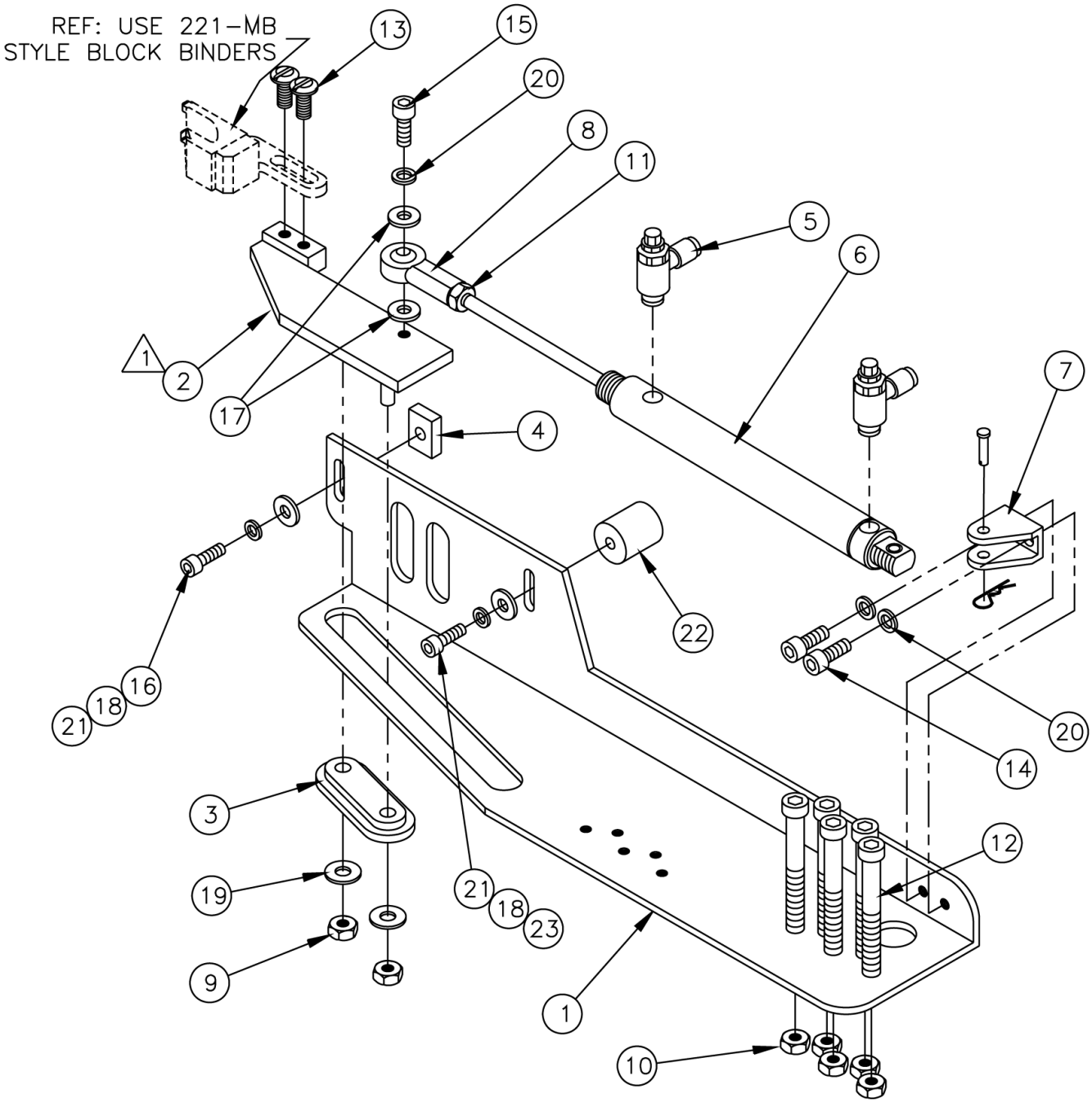
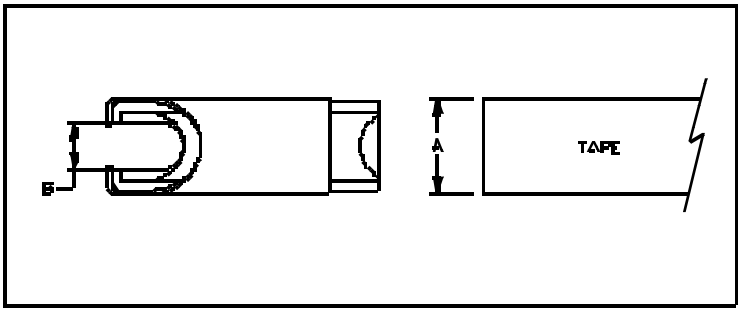


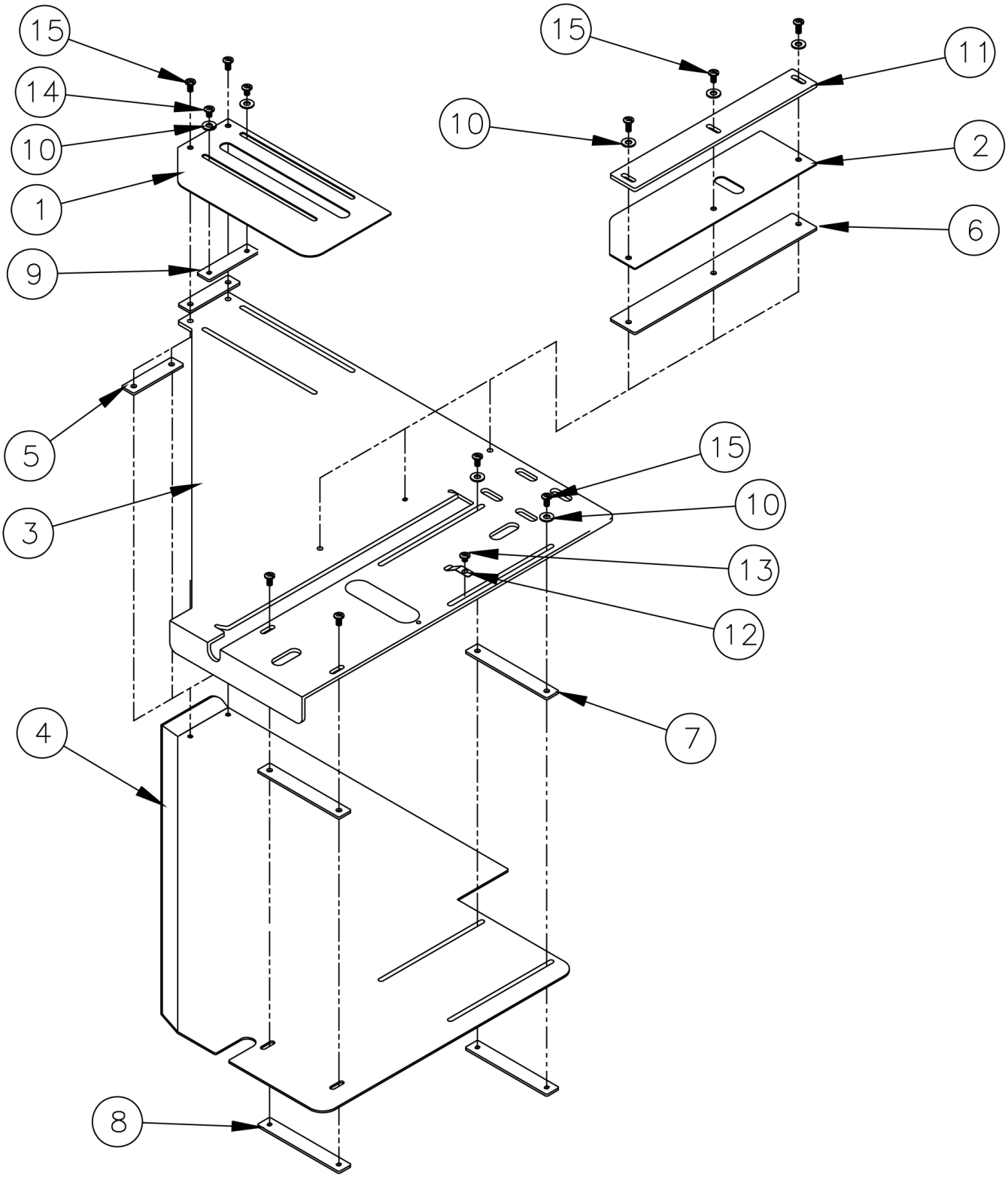
1339-100 Pneumatic Binder Assembly

AAC Drawing Number 192046B Rev 4

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1339-101	Main Mount	13	2	SSPS98032	Screw, Pan Head
2	1	1339-102	Plate, Binder Mount	14	2	SSSC98024	Screw, Socket Cap
3	1	1339-103	Side Block	15	1	SSSC98032	Screw, Socket Cap
4	1	1339-104	Spacer Block	16	1	SSSC90048	Screw, Socket Cap
5	2	AA198RA510	Flow Control	17	1	WWB10S	Brass Washer
6	1	AAC8DP-3	Air Cylinder	18	2	WWF8	Flat Washer
7	1	AAFBP-8C	Pivot Brkt	19	2	WWFS10	Flat Washer
8	1	BBAW-3Z	Rod End	20	3	WWL10	Lock Washer
9	2	NNE10-32	Elastic Lock Nut	21	2	WWL8	Lock Washer
10	5	NNH10-24	Hex Nut	22	1	1339-104A	Spacer
11	1	NNH10-32	Hex Nut	23	1	SSSC90080	Screw, Socket Cap
12	5	SSAS016128	Screw, Allen Shoulder				

Binder	**Size**
221-MB056016	A=22mm B=6.4mm / A=7/8” B=1/4”
221-MB060016	A=15/16” B=1/4”
221-MB060016A	A=15/16” B=1/4”
221-MB060016B	A=15/16” B=1/4”
221-MB060024	A=15/16” B=3/8”
221-MB064020	A=1” B=5/16”
221-MB064024A	A=1” B=3/8”
221-MB068024A	A=1-1/16” B=3/8”
221-MB068024B	A=1-1/16” B=3/8”
221-MB076024	A=1-3/16” B=3/8”
221-MB080024	A=1-1/4” B=3/8”
221-MB088024	A=1-3/8” B=3/8”
221-MB092028	A=1-7/16” B=3/8”
221-MB092032	A=1-7/16” B=1/2”



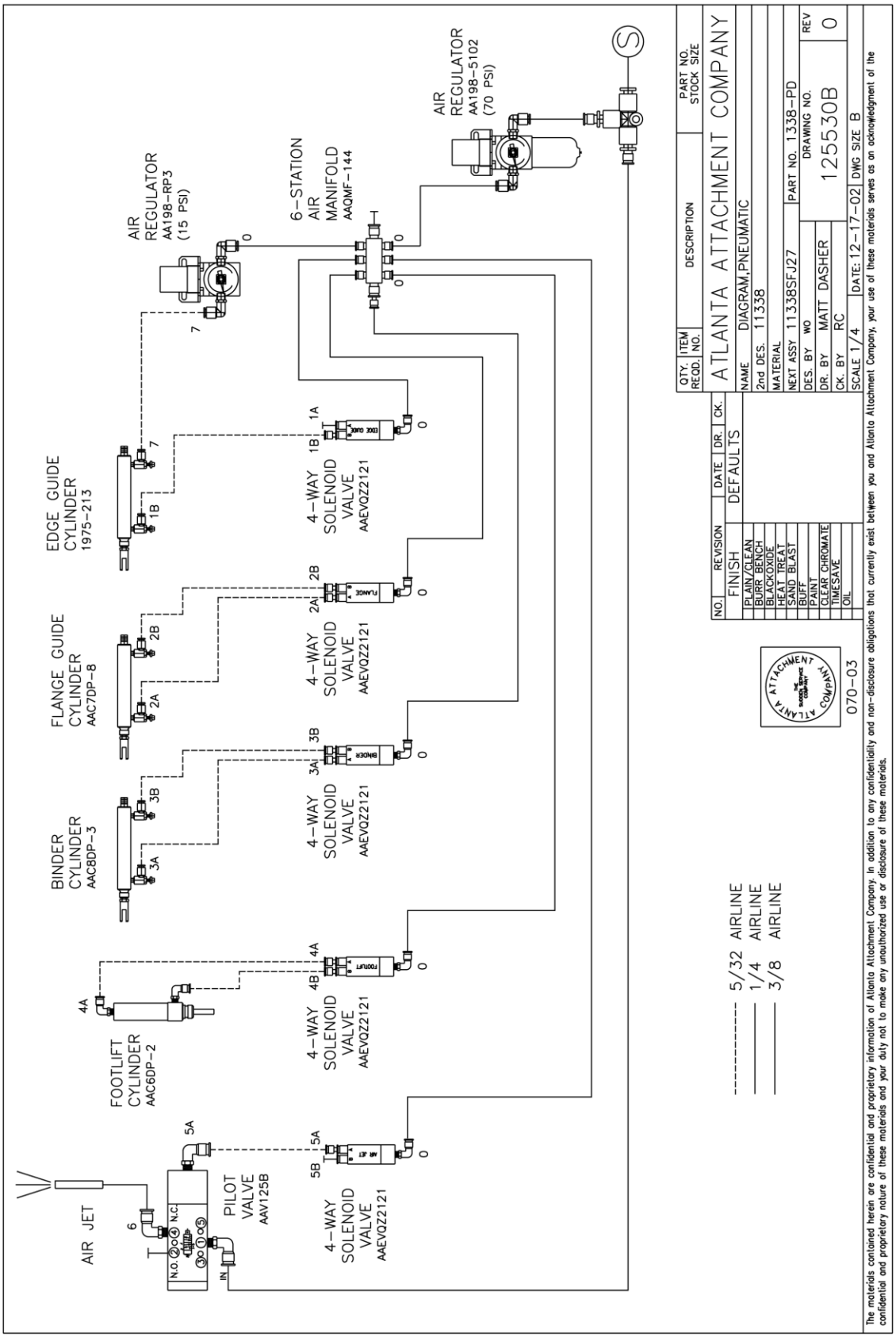


552-48 Right Angle Guide Assembly

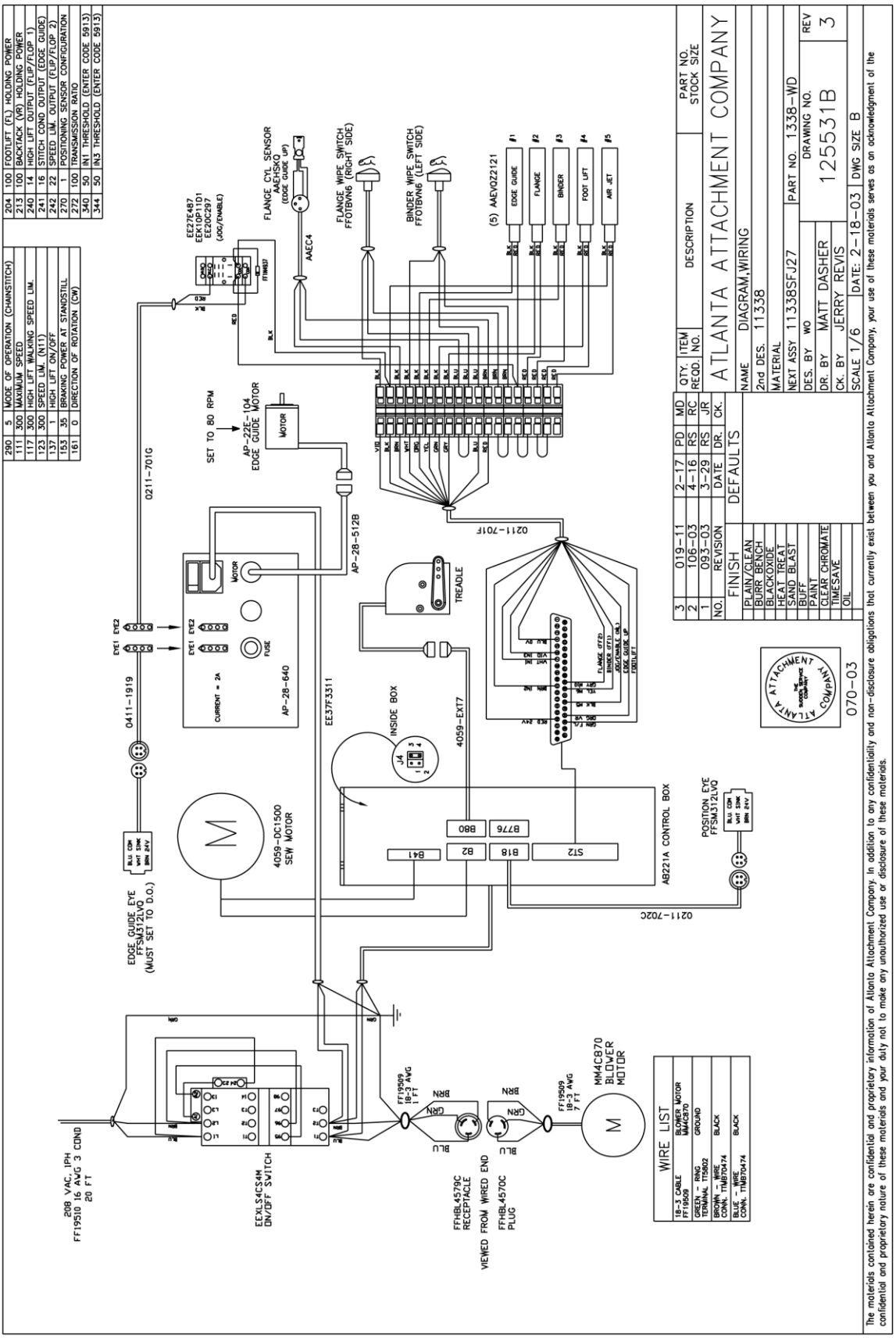
AAC Drawing Number 192123B Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	F552-501A	Left Top Plate
2	1	F552-401B	Right Top Plate
3	1	F552-502	Middle Plate
4	1	F552-503	Bottom Plate
5	2	F552-404A	Spacer
6	1	F552-404B	Spacer
7	2	F552-404D	Spacer
8	2	F552-404E	Nut Plate
9	1	F552-404F	Nut Plate
10	7	WWFS6	Flat Washer
11	1	F552-405	Spacer
12	1	F552-406	Flange Spring
13	1	SSTS85008	Screw, Truss Head
14	2	SSTS85016	Screw, Truss Head
15	11	SSTS85024	Screw, Truss Head

1338-PD Pneumatic Diagram



1338-WD 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.

Atlanta Attachment Company
362 Industrial Park Drive
Lawrenceville, GA 30046
770-963-7369
www.atlatt.com

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