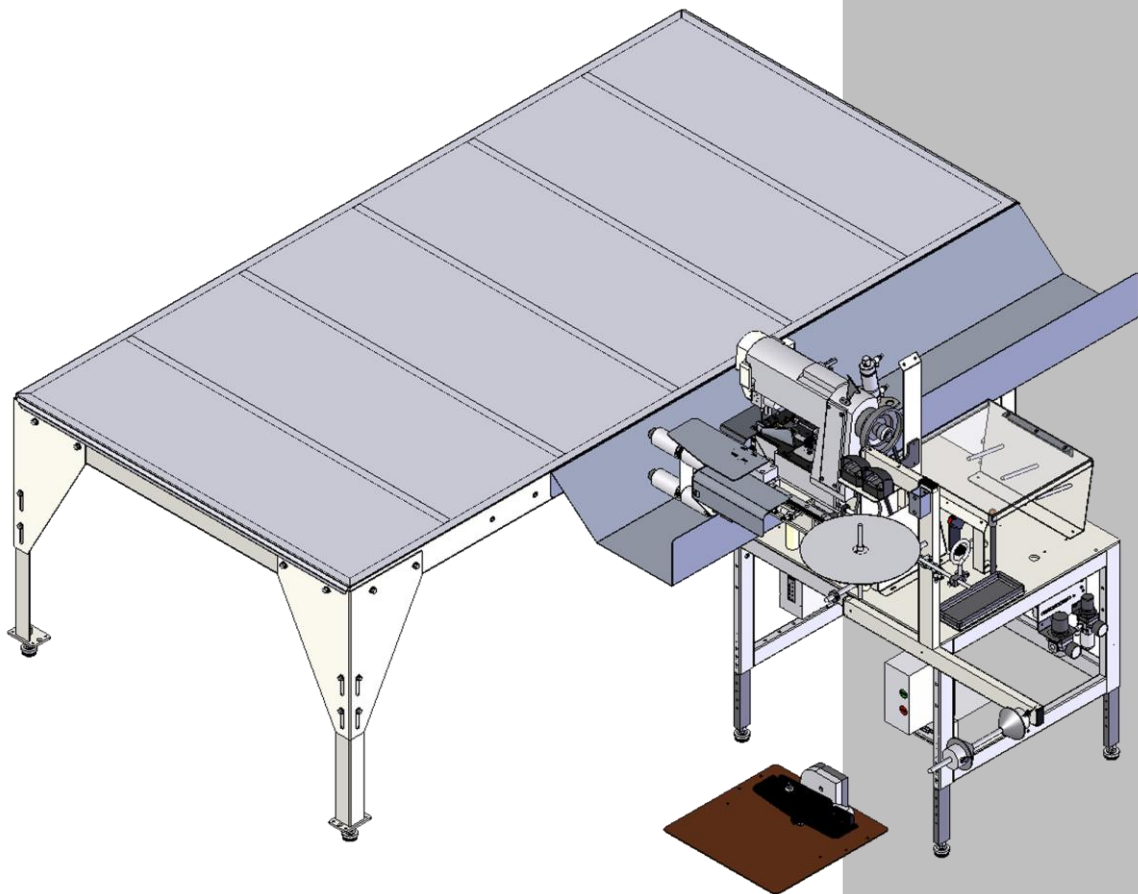




Model **1344S88UK**

Revision 2 Updated Mar 29, 2012

Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

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Contents

Important Safety Instruction	1
Mandatory Information	1
Scope of the Instruction Material.....	1
Intended Use	1
Exclusion of Misuse.....	1
Liability.....	2
Choice and Qualification of Personnel	2
Training.....	2
Responsibilities.....	2
A Word to the Operator	3
Safety Equipment on the Machines	3
Damage	3
Faults or Errors	3
Signs on the Machine.....	3
Protective Eyewear	4
Tools	4
Oils, Lubricants, Chemicals.....	4
No Smoking, Fire, Explosion Hazard.....	4
Workplace.....	4
Emergency STOP.....	4
First Aid	4
Important Notices.....	5
Reporting and Fighting Fires	5
Electrical Power Supply.....	5
Delivery of the Machine/Packaging.....	6
Transport Damage.....	6
Interim Storage.....	6
Transporting the Machine	6
Workplace Environment	7
Local Regulations	7
Maintenance	7
General Safety Instructions.....	7
Maintenance, Care, Adjustment.....	7
Waste, Disassembly, Disposal	7
Repair	8
Replacement Parts.....	8

Repair, Electrical.....	8
Ventilation/Hazardous Gases.....	8
Hydraulic and Pneumatic Systems.....	8
General Liability.....	9
Starting Machine Movements.....	9
A Word to the End User.....	9
Safety Precautions.....	10
General Machine Data.....	11
Electrical & Pneumatic Specifications.....	11
Installation & Setup.....	11
Parameter Settings for Efka Controller.....	12
Electric Eye Sensor Adjustment.....	13
Reflective Tape Maintenance.....	13
Servicing the Sew Head.....	14
Installation.....	14
Lubrication.....	15
Setting the Needle.....	16
Threading the Machine.....	17
Upper Threading.....	17
Lower Threading.....	17
Threading the Loopers.....	18
Tension.....	18
Pressure.....	18
Presser Foot Pressure.....	18
Alternating Pressers.....	18
Alternating Presser with Pneumatic Pressure Control.....	19
Upper Feed Roll Pressure.....	19
Stitch Length.....	19
Machine with Puller Feed.....	20
Presser Bar Lift.....	20
Machines with Alternating Pressers.....	21
Setting the Height of Feed Bar.....	22
Centralizing the Feed Dog.....	22
Setting the Height of the Feed Dog.....	22
Timing the Feed Lift Eccentric.....	23
Needle Bar Positioning.....	23
Positioning the Loop Deflectors.....	23

Technical Manual & Parts Lists

Setting the Distance from the Looper to the Needle.....	24
Sidewise Setting.....	24
Lengthwise Setting & Setting the Height of the Needle Bar	24
Timing Looper Driving Crank	25
Setting the Needle Guards	25
Positioning Spreader	26
Sidewise and Height Setting	26
Changing Movement of Spreader	26
Adjusting Needle Thread Take-Up.....	27
Adjusting Needle Thread Tension Releaser	27
Adjusting Looper Thread Take-Up.....	27
Singer® 300UX5 Assembly Drawings & Parts Lists.....	29
Upper Shaft Assembly	31
Front Assembly Sewing Arm.....	33
External Parts Sewing Arm.....	35
Lower Shaft Assembly.....	37
Front Assembly Sewing Bed	39
Cross Shaft in Sewing Bed	41
External Parts Sewing Arm.....	43
External Parts Sewing Arm.....	45
External Parts Sewing Arm.....	47
External Parts Sewing Arm.....	49
Assembly Drawings & Parts Lists	51
11344S88UK Main Assembly	52
4059-FP301D Foot Pedal Assembly.....	53
1337A-160 Air Table Assembly.....	55
1338-2000 Edge Guide Assembly	57
1338-3000 Touch Switch Assembly.....	58
1338041 Front Roller Assembly.....	59
1344016 Console Assembly	61
1338046 Sewing Head Assembly	62
1339-1500 Pneumatic Panel Assembly	63
1344S88-PD Pneumatic Diagram.....	64
1344S88-WD Wiring Diagram.....	65

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 1349S88B Auto Faux Hemmer with Flanging 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.

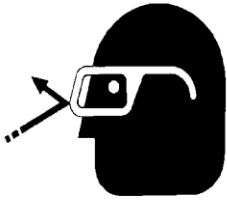
Signs on the Machine

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.

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 PSI, 20 SCFM avg. (3/8" Airline).

Set the regulator to 70 PSI.

Pressure setting valves:

Installation & Setup

Remove all packing material (bubble wrap, foam padding, etc.).

Assemble the border tray to the main console assembly. Refer to the assembly drawing on page 52.

Assemble the air table to the border tray. Refer to the assembly drawing on page 54.

Position the machine in a desired location on a sound and reasonably level floor. Adjust the leveling feet as required.

Make sure that there is sufficient lighting over the machine.

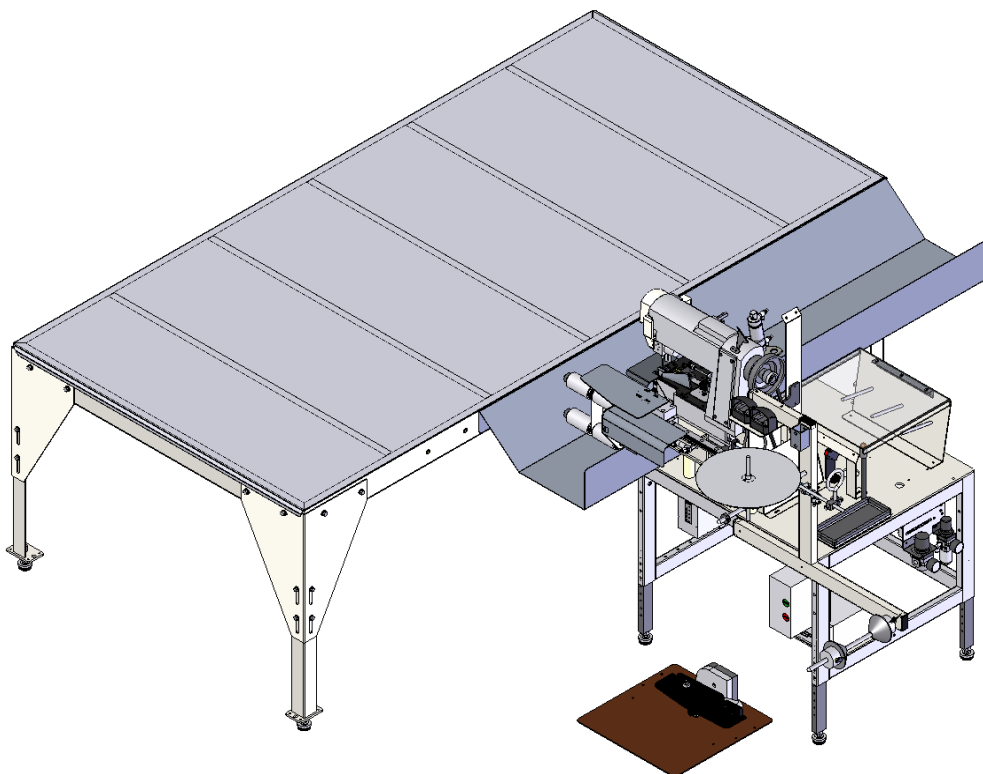
Clean the machine of any dust that may have accumulated during shipping.

Make required electric and pneumatic connections using only appropriate connectors.

Make sure the voltage has been set correctly.

Important! - Before shipping, all oil from the sewing head is drained. Be sure to supply oil to the sewing head before using the machine.

Set Edge Guide Wheel to 80 RPM.



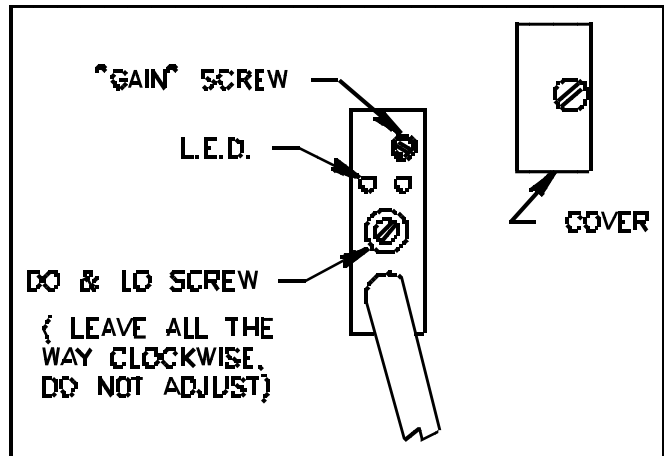
Parameter Settings for Efka Controller

11339HFS88PAR1			
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	1=CCW	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	0	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
Set Needle Position Up (270 MUST BE "0") (Direct Drive - No Position Sensor)			
			Set to 1st needle position "Down" and 2nd Needle position "UP".
			Go to parameter 171
			Press [E], display shows SR2
			Press [>>] display shows P1E (Start pos1)
			Turn handwheel in direction of sew until needle is at down position.
			Note parameter setting.
			Press [E]
			Display shows P2E = (Start pos2)
			Turn handwheel in direction of sew until needle is at up position.
			Note parameter setting.
			Press [E]
			Display shows P1A = (End pos1) rotate handwheel to same number as P1E+60.
			Press [E]
			Display shows P2A = (End pos2) rotate handwheel to same number as P2E+60.
			Press [E]
			Press [P]
			Press [P]
			Run machine and heel back to save settings.
Front panel LED's:			Programming Instructions:
LED 1:	Off		1. Power on holding down the "P" button till "COD" is displayed.
LED 2:	Off		2. Press ">>" once and enter the number "3112"
LED 3:	Off		3. Press "E" once and "2.0.0." is displayed. This is a parameter.
LED 4:	Off		4. Press "E" again and the value for parameter 200 is displayed.
LED 5:	Off		5. With the value on the screen, adjust to desired setting.
LED 6:	Off		6. Press "E" to enter value and continue with parameter setting.
LED 7:	On, Stop at needle down.		7. Repeat for other parameters, press "P" once when complete.
LED 8:	Off		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 "5913"
			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.

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.

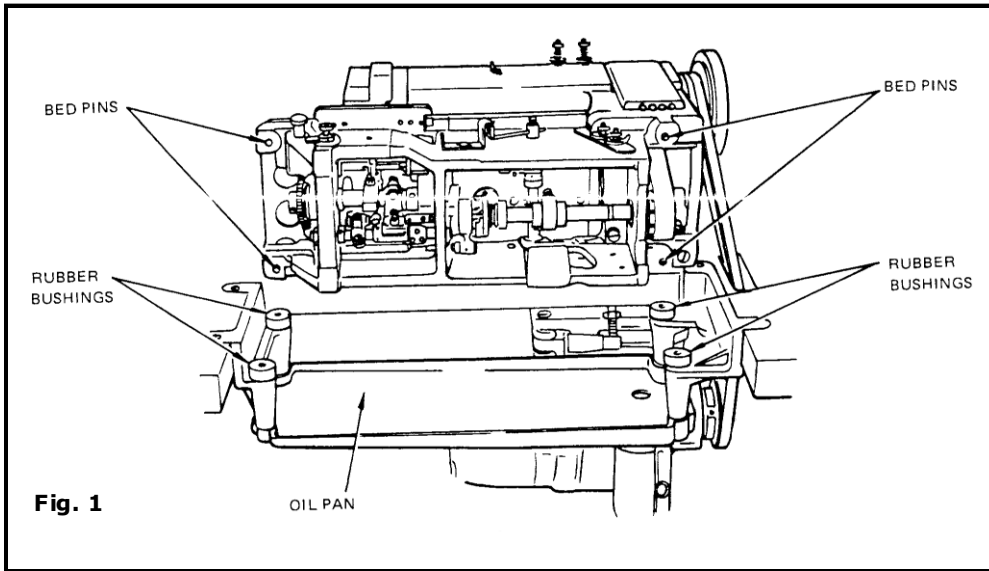
With the end of the sensor pointing at the center of the reflective tape, turn the “GAIN” screw counter-clockwise until the red LED indicator is off. Then turn the “GAIN” screw clockwise until the LED indicator comes on. Then turn the “GAIN” screw one full turn clockwise. The LED indicator should be 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.

Servicing the Sew Head

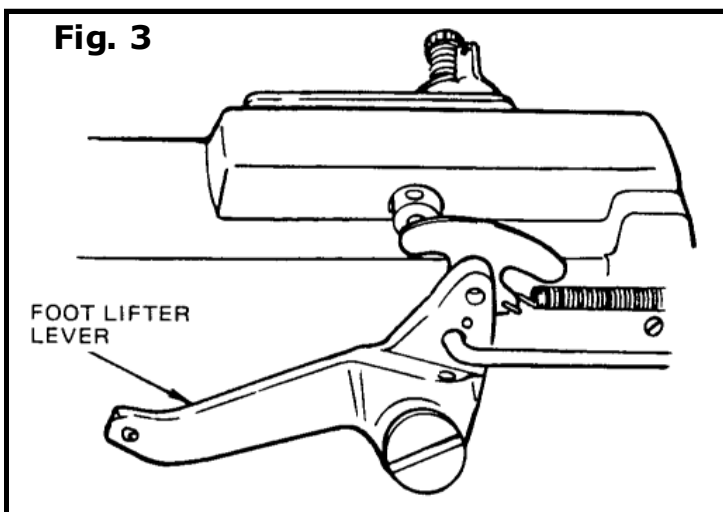
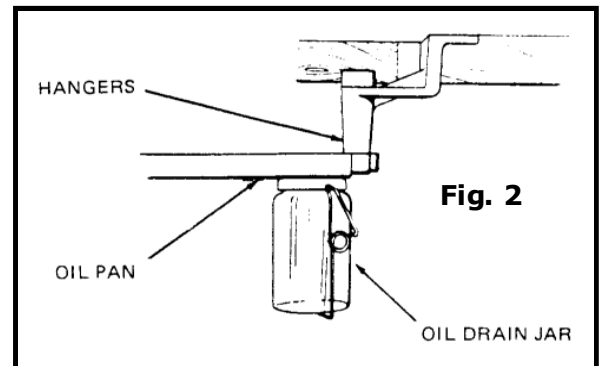


Installation

Assemble the oil pan to the hangers. Insert the assembled oil pan into the machine cut-out table placing four rubber bushings in the hanger holes as shown in Fig. 1. Attach the oil drain jar to the oil pan as shown in Fig. 2.

Place the machine on the oil pan assembly with the four bed pins passing through the four rubber bushings shown in Fig. 1.

Connect the foot lifter treadle to the foot lifter lever, Fig. 3, at the back of the machine by chain furnished for this purpose.



Lubrication

Machines of Class 300U have a semi-automatic lubricating system comprising of a hollow arm shaft and a hollow bed shaft which act as oil reservoirs. The oil is distributed to all of the principal bearings by centrifugal force through small jets in the shafts when the machine is in operation. Provision is also made for hand lubricating other movable parts which are not lubricated from the reservoirs.

Caution: User Singer Oil, “Type B” or “Type D”. Use “Type D” oil when oil is desired which will produce minimum stain on fabrics even after long period of storage.

Do not use additives in sewing machine oil as they may cause a reduction in the normal flow of oil that can result in damage to the machine.

Before starting the machine, the machine must be oiled as instructed. Failure to do this will result in damage to the machine.

The Pressure Oil Can, furnished with the machine is to be used to oil all points requiring lubrication.

To Oil the Arm Shaft

To fill the arm shaft reservoir, insert spout of the pressure oil can in hole, Fig. 4, and inject 1 shot of oil into shaft twice daily.

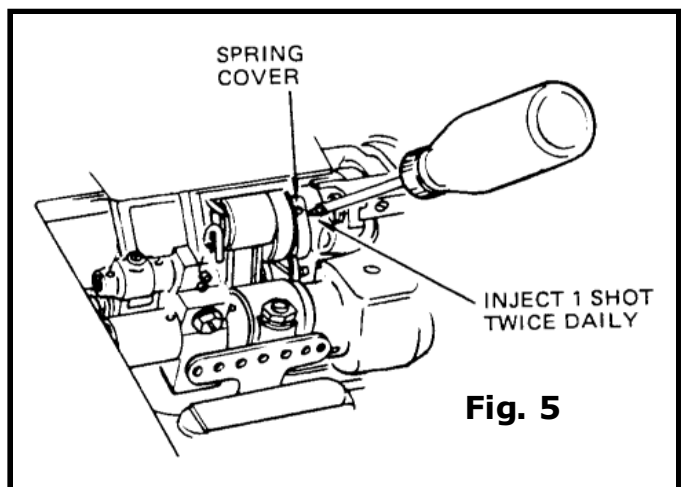
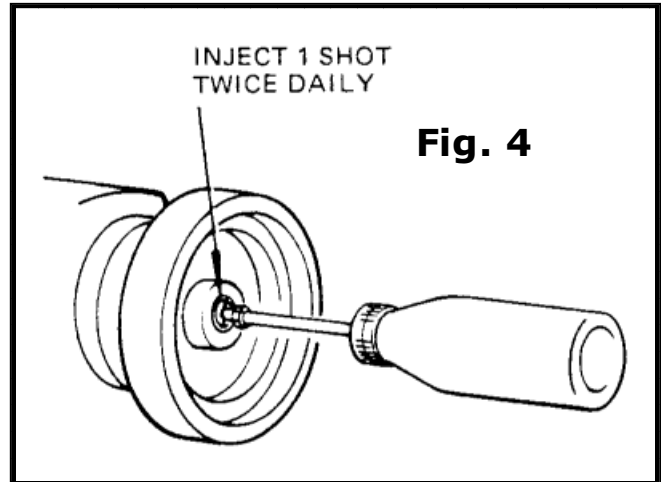
To Oil the Bed Shaft

To fill the bed shaft reservoir, push the spring cover, Fig. 5, to the left and insert spout of pressure oil can into the hole and inject 1 shot of oil into shaft twice daily. Close oil hole spring cover.

Other Oiling Points

Applying oil to all work plate and arm oil holes, needle bar bearings and connections, needle bar rock frame bearings, looper rocker sleeve and presser lifting mechanism.

Caution: For machines in continuous use, all oiling points must be oiled daily. Occasionally oil tension release mechanism and looper pull-out rack.



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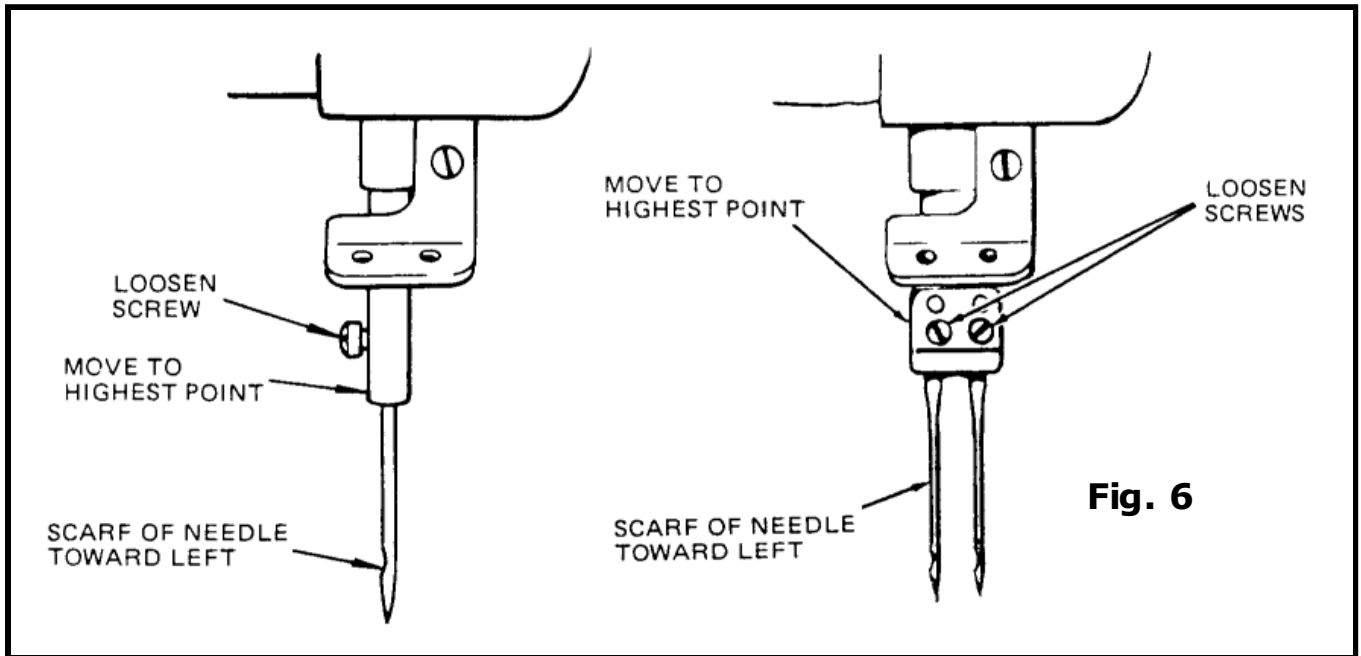
Setting the Needle

Refer to Fig. 6.

Turn the machine pulley over toward the operator until the needle bar is at its highest point.

Loosen the needle set screw.

Insert the needle into the needle bar and clamp as far as it will go making certain that the scarf of the needle faces toward the left.



Threading the Machine

Either left twist or right twist thread may be used in the needles and loopers. Rough or uneven thread or thread which passes through the needle eye with difficulty will interfere with successful operation of the machine.

Upper Threading

Turn the machine pulley over toward the operator until the needle bar is at its highest point. Pass the thread from the unwinder through the threading points indicated in Fig. 7. Draw approximately two inches of thread through the needle eye with which to start sewing. Make certain that each thread passes through the thread tension device.

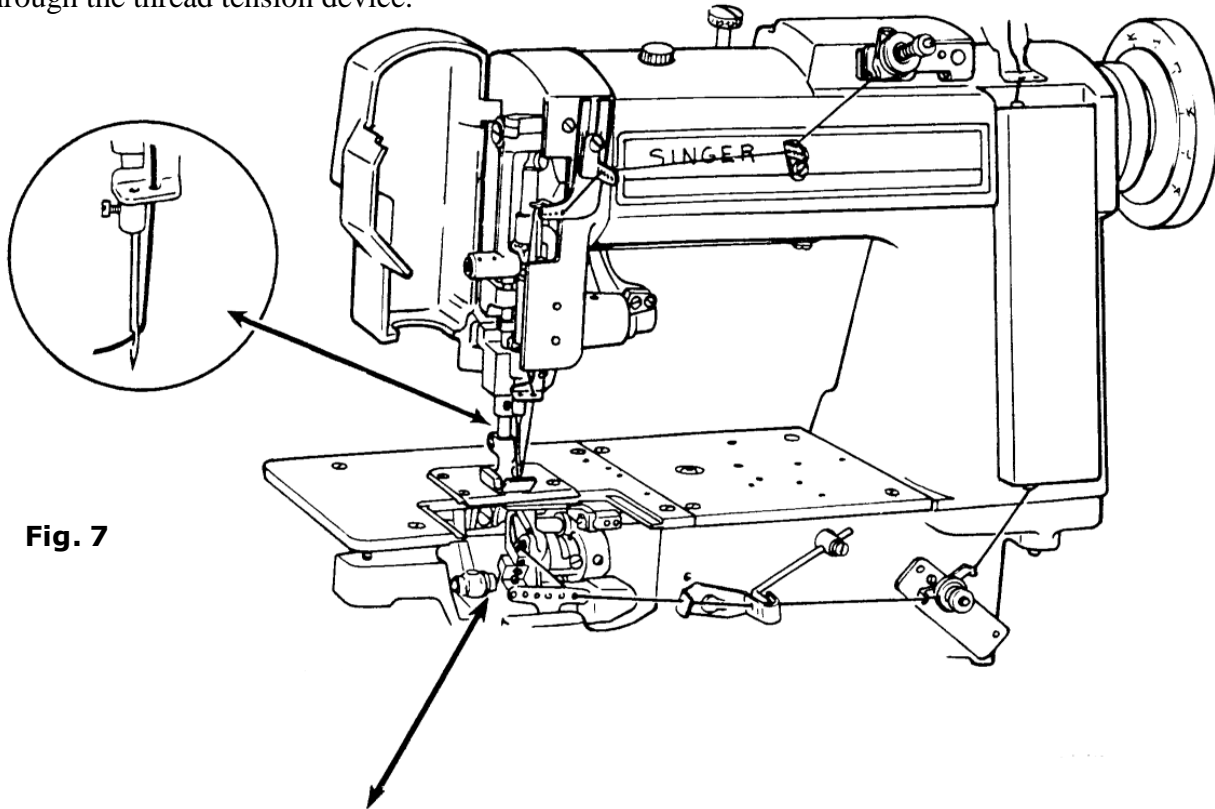
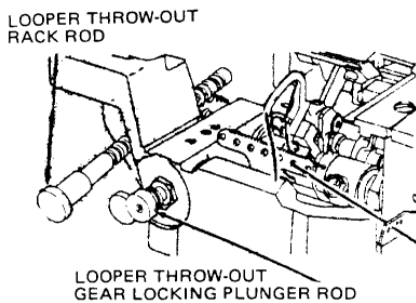


Fig. 7



Lower Threading

Open the front table section, remove the bed slide and turn the machine pulley over toward the operator until the needle bar is at its highest point. Move the looper throw-out gear locking plunger rod and looper throw-out rack rod, Fig. 7, out as far as possible. This will place loopers in position for easier threading and prevent accidental operation of machine until loopers are returned to sewing position.

Threading the Loopers

Pass the thread from the unwinder through the threading points as indicated. Draw approximately two inches of thread through the looper eye with which to start sewing.

Tension

Tension on the thread should be as light as possible while still sufficient to set the stitch correctly in material.

Needle Thread Tension

To regulate the needle thread tension, turn the thumb screw indicated in Fig. 8 as may be required.

Important: Regulate the needle thread tension only when the presser foot is down.

Looper Thread Tension

To regulate the looper thread tension, turn the thumb screws as indicated in Fig. 9 as may be required.

Pressure

Pressure on material should be as light as possible while still sufficient to insure correct feeding.

Presser Foot Pressure

To regulate the presser foot pressure, loosen the lock screw, Fig. 10, at the rear of the machine. Tighten the thumb screw to increase pressure; loosen to decrease pressure. When the correct feeding pressure is attained, tighten the lock screw.

Alternating Pressers

To increase pressure, loosen the lower lock nut and loosen the lock screw, then tighten the upper lock nut, see Fig. 11. When the correct pressure is attained, tighten the lock screw. Then tighten the lower lock nut. To decrease pressure, loosen the upper lock nut and loosen the lock screw, then tighten the lower lock nut. When correct pressure is attained, tighten the lock screw. Then tighten the upper lock nut.

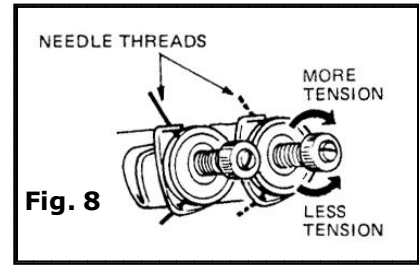


Fig. 8

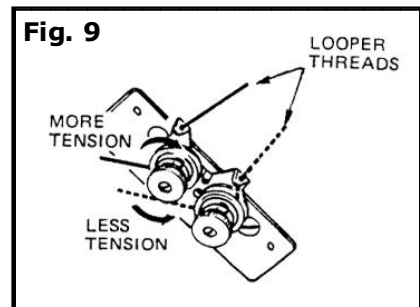


Fig. 9

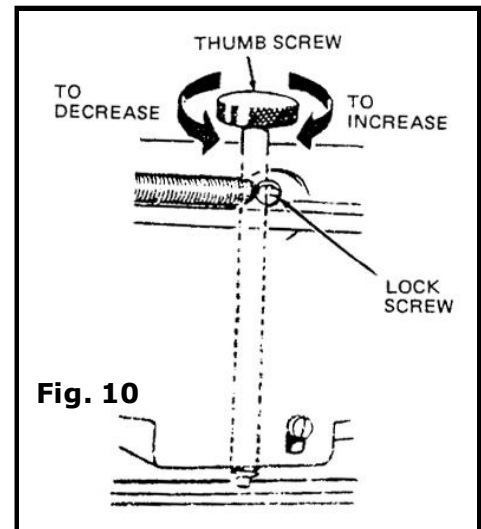


Fig. 10

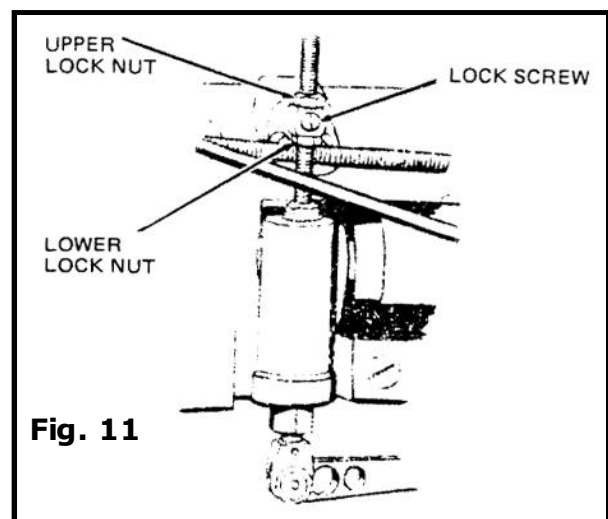
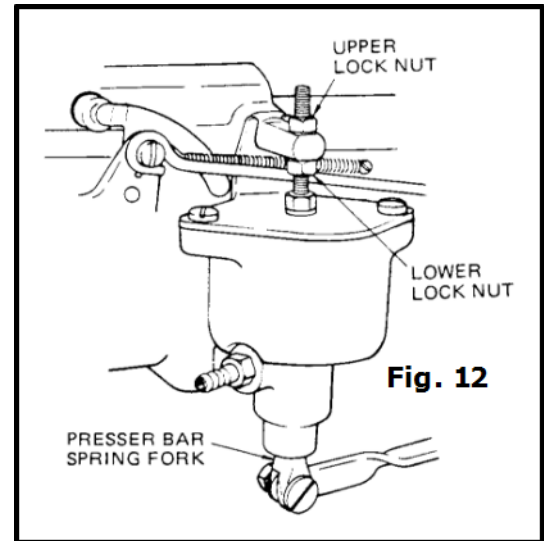


Fig. 11

Alternating Presser with Pneumatic Pressure Control

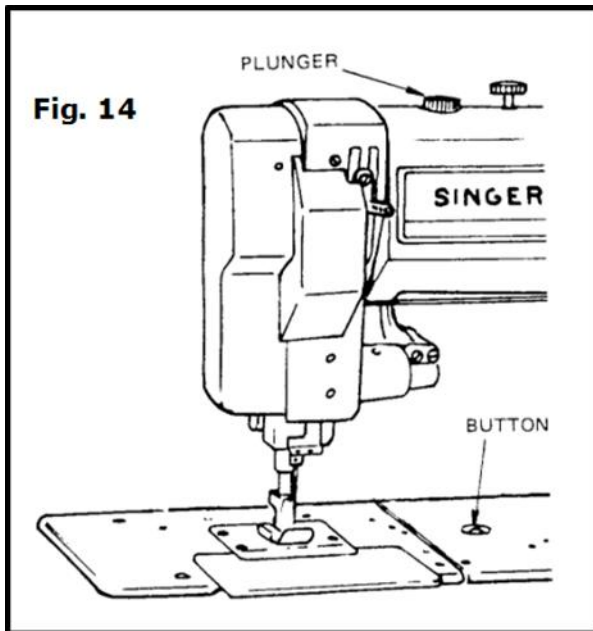
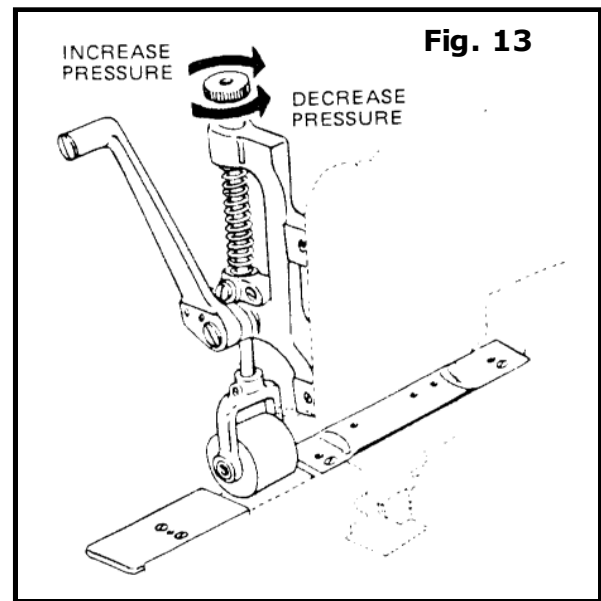
Adjust the height of the Pressure Cylinder with the presser feet resting on the throat plate. There should be a clearance of 1/4" between the Presser Bar Spring Fork and bottom of the cylinder. To raise the cylinder, loosen the lower lock nut and tighten upper lock nut, see Fig. 12. To lower the cylinder, loosen the upper lock nut and tighten the lower lock nut. When correct adjustment is attained, tighten both lock nuts.

Regulate air pressure: The correct air pressure is set for average feeding when the Presser Bar Spring Fork rises to approximately 1/16" from the bottom of the cylinder.



Upper Feed Roll Pressure

To regulate the pressure of the upper feed roll, turn the thumb screw as shown in Fig. 13.



Stitch Length

To adjust the stitch length, depress the plunger, Fig. 15, located on top of the arm. Continue to hold the plunger down and turn the machine pulley toward the operator until the plunger enters the notch in the arm shaft eccentric. Then turn the plunger to lock in

position. Depress the button located on the machine bed. Hold down and turn the machine pulley toward the operator to increase length of the stitch, or away from the operator to decrease the length of the stitch. Letter "A" on the machine pulley indicates the lowest stitch. When desired length is indicated by a letter and is opposite of the arrow on the front of the machine, release button and turn the plunger to the right or left until it springs outward.

Caution: Never turn the machine pulley with the plunger in the locked position until the button on the machine bed is depressed.

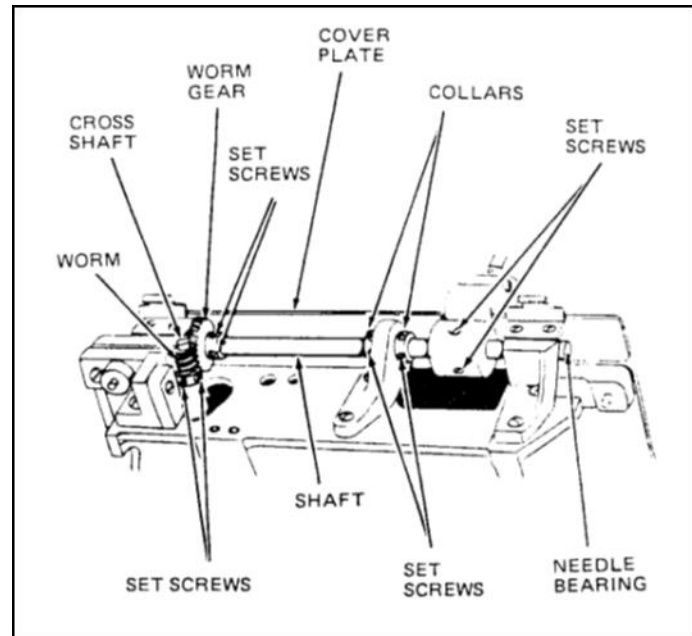
Machine with Puller Feed

The length of the stitch is determined by the stitch gears in the puller feed mechanism. The compound feed stitch length should be set slightly shorter than the stitch length of the puller feed.

To change the Puller Feed gears for adjusting stitch length, remove the two cover plate screws and remove the cover plate, Fig. 15. Loosen the set screws. Slide the puller feed shaft to the right far enough to allow removal of the worm and worm gear. Place the new worm on the cross shaft. Turn the worm in the operating direction and tighten the first set screw into the flat of the shaft. Then securely tighten both set screws, checking for excessive end play. Engage the new worm gear with the worm and slide the puller feed shaft through the worm gear until the end of the shaft is flush with the needle bearing.

Remove the end play in the shaft

by setting the two collars against the bracket and tightening the four set screws. Align the lower feed roll with the upper feed roll and tighten the two set screws. Center the worm gear on the center of the worm. Tighten the two set screws with the first screw in the spline of the shaft. Replace the cover plate and adjust the compound feed.



Presser Bar Lift

When the presser foot is raised by the presser bar lifter and the needle is at its highest position, the point of the needle should not protrude below the presser foot.

To adjust, turn the machine pulley over toward the operator until the needle is at its highest position. Loosen the set screw, Fig. 16. Raise the presser foot to the correct height, place the stop collar against the upper bracket, and tighten the set screw.

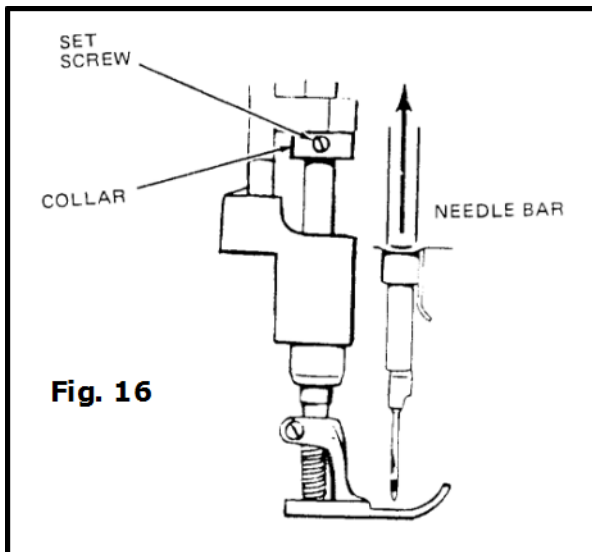


Fig. 16

Machines with Alternating Pressers

The lift of the vibrating and lifting pressers is controlled by an adjustable eccentric. To adjust, remove the arm cover at the rear of the machine. Turn the machine pulley over toward the operator until the feeding presser is down. Loosen the two lock screw, Fig. 17, and the two clamp screws. Insert a screw driver into the notch of the adjusting disc, and turn the machine pulley as indicated in Fig. 17. Then tighten the two clamp screws and the two lock screws.

When it is desirable to have either one of the pressers lift higher than the other, turn the machine pulley over toward the operator until the lifting presser is at its highest position. Loosen the tow clamp screws, Fig. 18, and turn the lifting rock shaft crank up or down until the desired lift of each presser is attained. Then tighten the tow clamp screws.

Caution: Limit lift of pressers to a minimum required for the work, as this permits higher speeds.

The vibrating presser should be timed so that under normal sewing conditions, the presser foot will seat on the material at approximately the same time the needle enters the material. This timing can be advanced or retarded slightly depending on the type of operation being performed, such as sewing over seams. To adjust, loosen the tow holding screws, Fig. 18, not more than one half turn. Then turn the adjustable eccentric, Fig. 17, until the vibrating presser seats at the correct time. Securely tighten the tow holding screws after the adjustment is made.

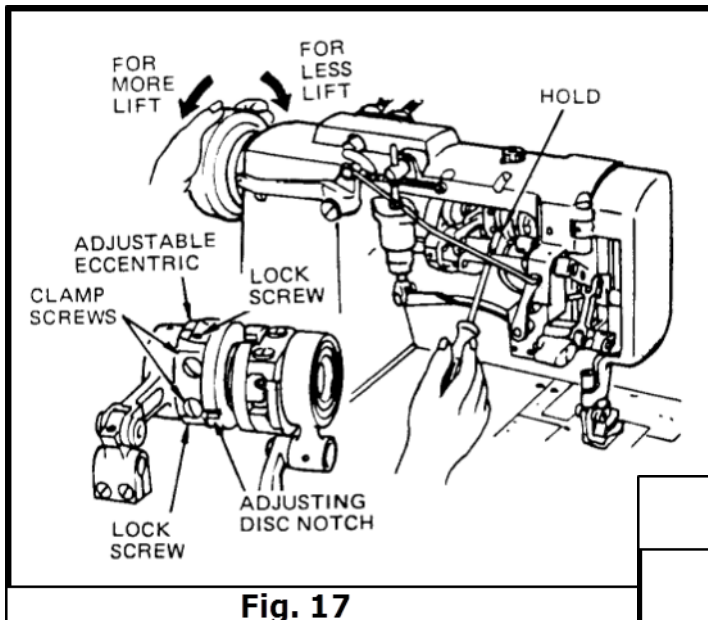


Fig. 17

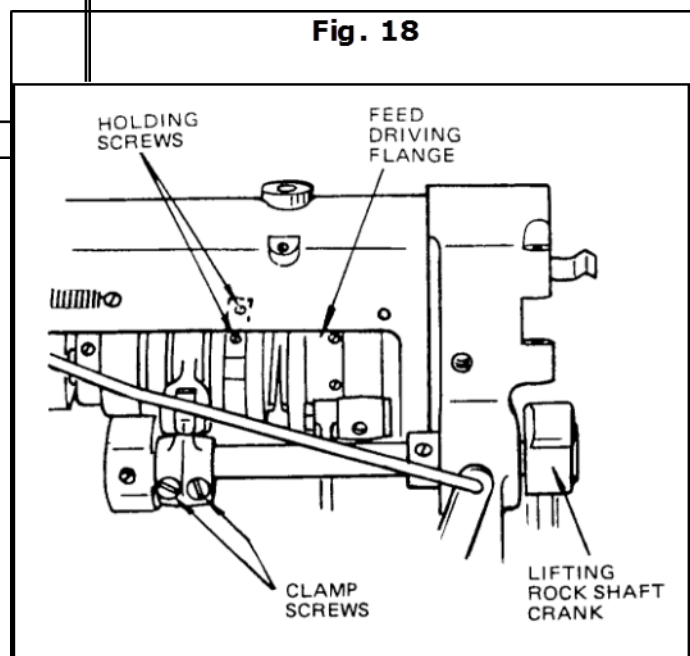


Fig. 18

Setting the Height of Feed Bar

When the feed bar is set at the correct height, the feed lift link clamp will be aligned with the rock shaft timing flat. To adjust, make certain that the feed lifting crank timing screw, Fig. 19, engages the shaft spot correctly. Loosen the clamp screw and move the feed lift clamp link to the correct position. Then tighten the clamp screw.

Centralizing the Feed Dog

Sidewise Setting

The needle should enter the needle hole of the feed dog with the same clearance between the needle and the left or right side of the hole. To adjust, loosen the feed dog screws, Fig. 20. Move the feed dog until the correct clearance is attained. Hold in position, and tighten the feed dog screws.

Additional adjustment, if necessary, may be attained by loosening the four shaft collar set screws, the two rock shaft crank clamp screws, Fig. 20, and the feed lifting clamp screw, Fig. 19. Move the complete assembly to required position and tighten screws.

Lengthwise Setting

The feed dog should clear the ends of the feed slots in the throat plate equally at both ends of the feed travel. To adjust, set the feed for the desired stitch length. Loosen the two rock shaft crank clamp screws, Fig. 20. Move the feed rocker forward or backward until the correct positioning is attained. Then tighten the two clamp screws.

Setting the Height of the Feed Dog

When the feed dog height is set correctly, approximately the full depth of the teeth will show above the throat plate. To adjust, loosen the lock nuts, Fig. 21, and slightly loosen the feed dog clamping screw. To raise the feed dog turn the jack screw clockwise; to lower, turn the jack screw counter-clockwise and tap the feed dog down. When the correct setting is attained, tighten the clamping screws and lock the nuts.

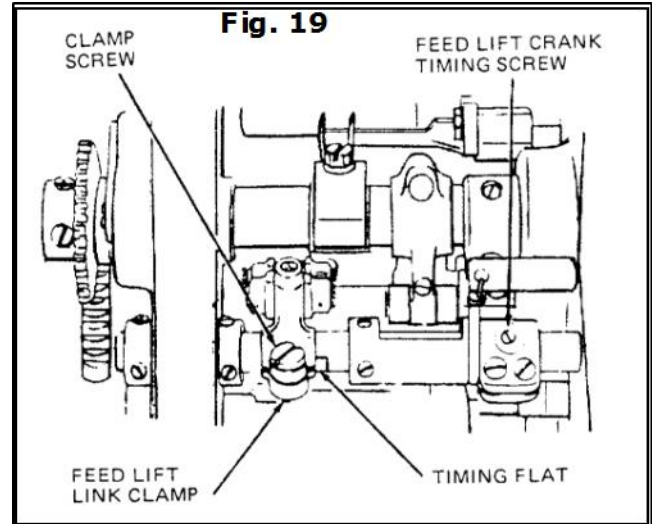


Fig. 20

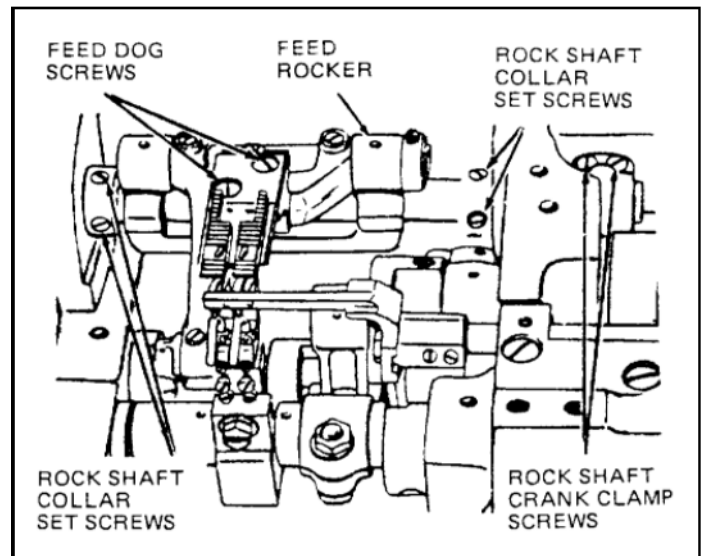
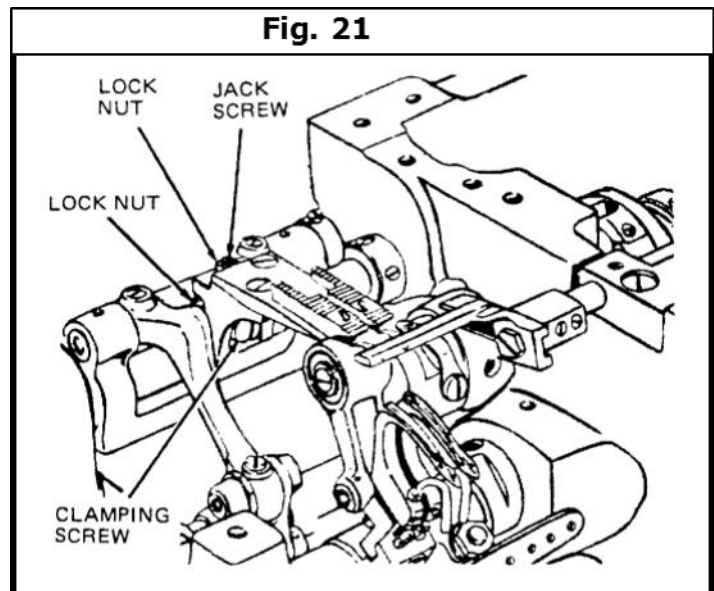
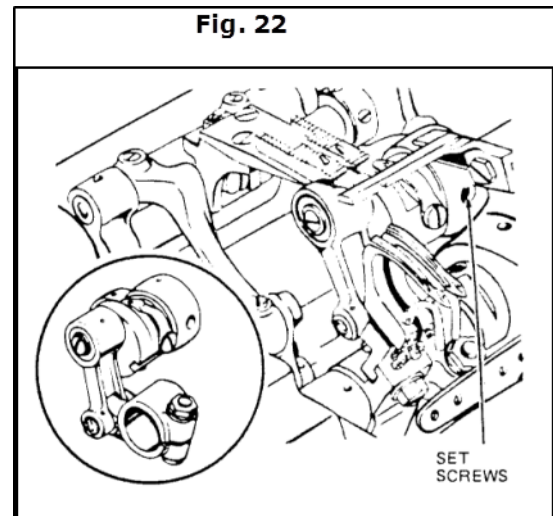


Fig. 21



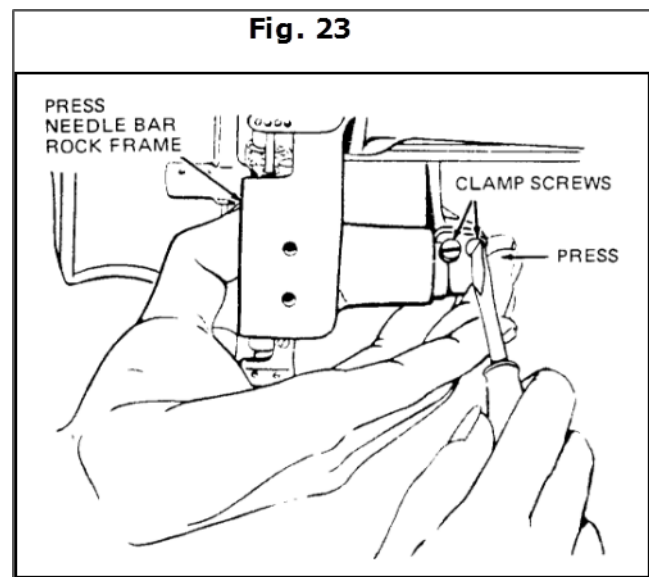
Timing the Feed Lift Eccentric

When the feed dog is at its highest position, the top of the teeth should be parallel with, and project full depth of the teeth above the upper surface of the throat plate. To adjust, insert screwdriver in the hole in the feed strap and loosen the two set screws, Fig. 22. Move the feed lift eccentric forward for earlier rise of the feed dog, or backwards for later rise. Then tighten the two set screws.



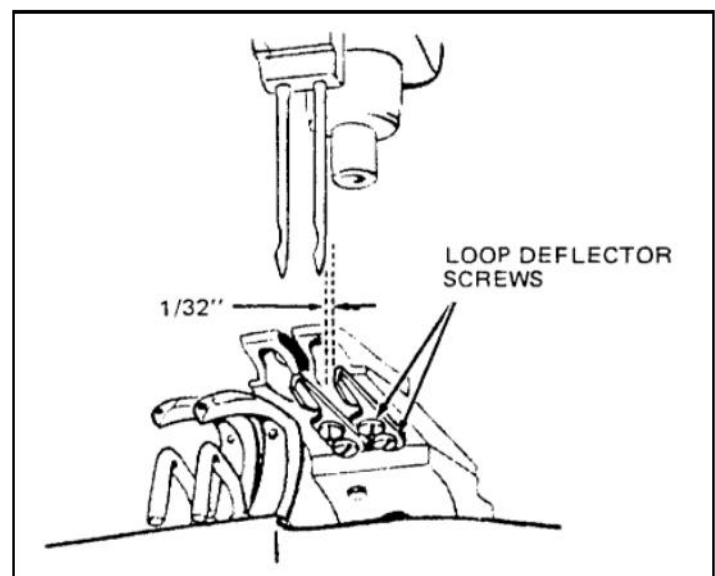
Needle Bar Positioning

The needles should enter the needle holes of the feed dog toward the front with approximately the same clearance between the front of the needles and the front of the needle holes, and the side of the needles to the side of needle holes. To adjust, press the needle bar rock frame, Fig. 23, against the drive arm clamp screws. Continue holding the rock frame against the drive arm, move the needle bar to correct the position and tighten the two clamp screws.

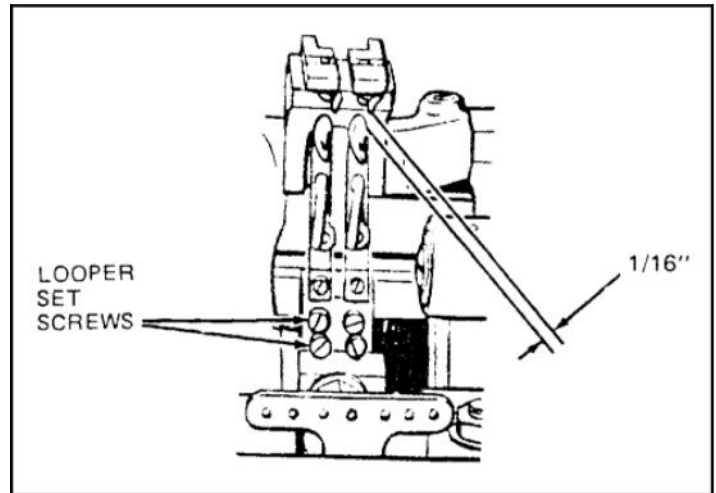
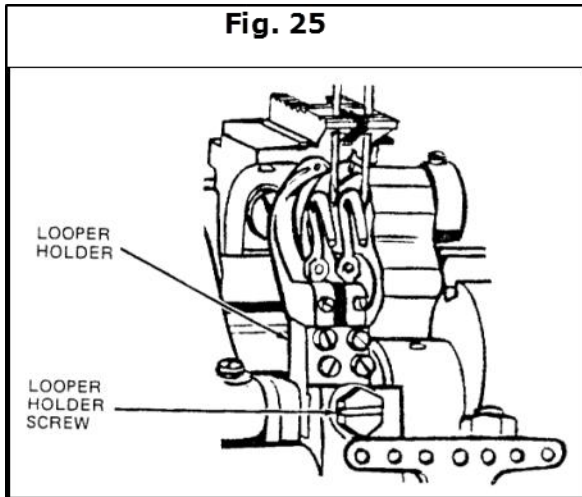


Positioning the Loop Deflectors

When the loop deflector, located on the underside of the feed dog, is positioned correctly, there should be a clearance of approximately 1/32" between the right side of the needle and loop deflector. To adjust, move the looper out of sewing position and tilt the machine back on its hinges. Loosen the loop deflector screws, Fig. 24. Move the deflectors toward the rear of the feed dog as far as the screw slots allow. Tighten slightly to allow for further adjustment. Return the looper to the sewing position and turn the machine pulley until the needle bar has descended to the bottom of the needle bar stroke. Tap the deflector to the left or right until the correct clearance is attained. Move the looper out of the sewing position and tighten the loop deflector screws.



Setting the Distance from the Loper to the Needle



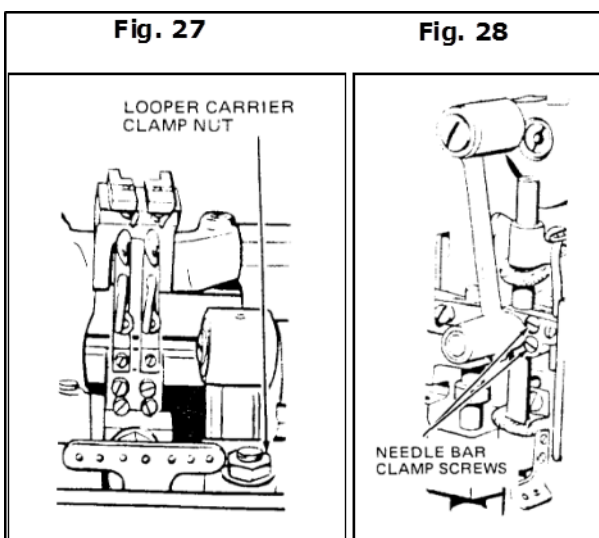
Sidewise Setting

When the looper is correctly positioned, the point of the looper just clears the scarf of the needle on the forward stroke of the looper. To adjust, turn the machine pulley until the looper point is directly opposite of the center of the needle. Loosen the looper holder screw, Fig. 25, and tap the holder to the left or right until the correct clearance is attained. Then securely tighten the looper holder screw.

Move the looper to the extreme forward position. Check the clearance between the heel of the looper and the loop deflector, Fig. 26, which should be approximately $1/16''$. To adjust, loosen the two looper set screws. Turn the looper to the left or right until the correct clearance is attained. Hold in position and securely tighten the two set screws.

Caution: On single and multi-needle machines, make certain that the point of each looper just clears the scarf of its respective needle. To adjust, with the looper point directly opposite the center of the needle, loosen the two set screw, Fig. 26, and turn the looper slightly to the left or right. Then tighten the set screws.

Lengthwise Setting & Setting the Height of the Needle Bar



When correctly set: the point of the looper should be directly opposite of the center of the needle, and at the center of the clearance above the eye of the needle when the looper timing mark LT on the machine pulley is opposite of the timing arrow on the arm.

To adjust the looper, loosen the looper carrier clamping nut, Fig. 27. Move the carrier forward or backward until the looper point is directly opposite of the center of the needle. Then tighten the clamping nut.

To adjust the needle bar, first make certain that the needle is inserted up into the needle bar or clamp as far as possible. Loosen the two needles bar clamping screws, Fig. 28, and raise or lower the needle bar to correct position. Then tighten the clamping screws

Timing Looper Driving Crank

When the looper driving crank is properly timed, the point of the looper will pass above the eye of the needle at the same distance on both the forward and backward strokes of the looper.

To adjust when the point of the looper passes higher on the forward stroke, loosen the looper driving crank set screw, Fig. 29. Loosen the looper crank timing screw (left) approximately 1/8 turn, and tighten the looper crank timing screw (right). Continue to adjust until the correct adjustment is made. Then securely tighten the set screw.

When the point of the looper passes higher on the backward stroke, reverse the adjustment by loosening the timing screw (right) and tightening the timing screw (left).

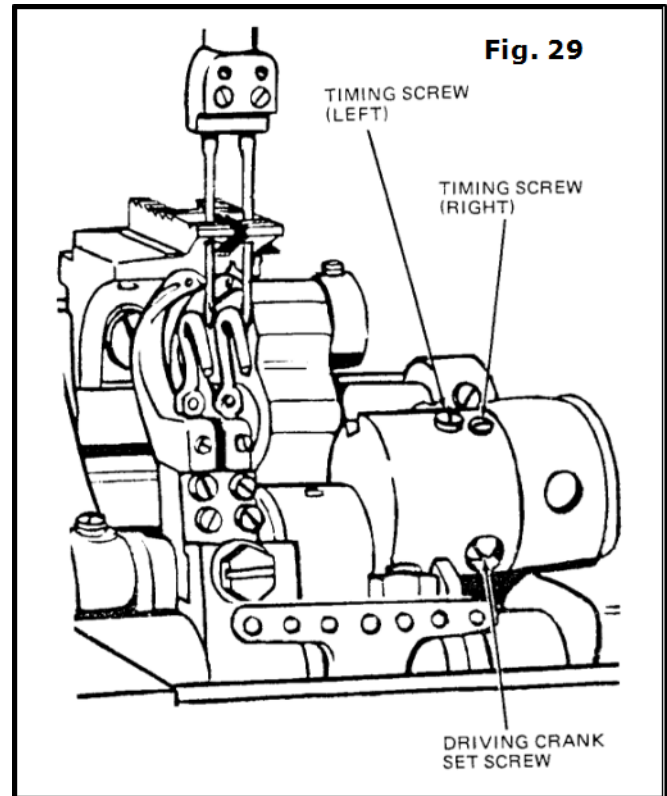
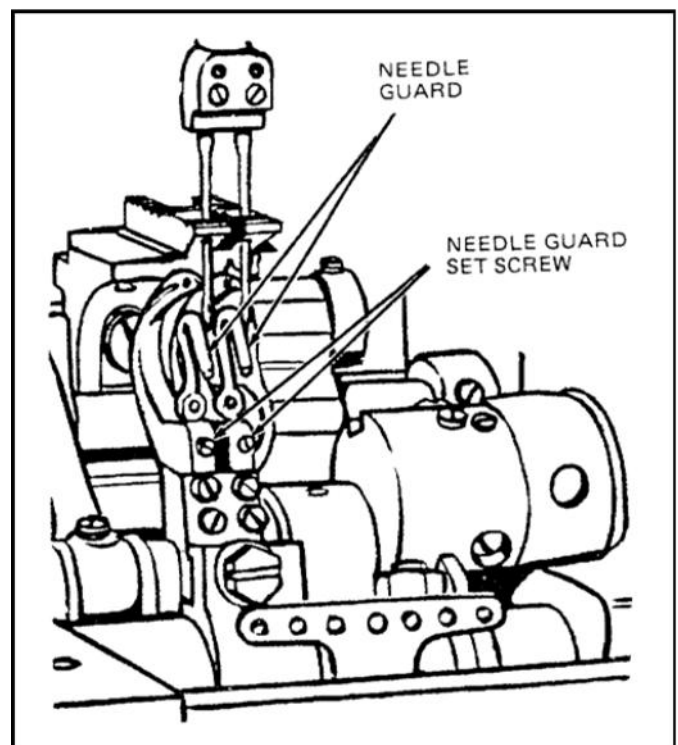


Fig. 30

Setting the Needle Guards

When the needle guards are properly set, they should pass as close as possible to the needles without touching. To adjust the guard turn the machine pulley over toward the operator until the points of the loopers are about to pass the needles on their forward strokes. At this point, the looper timing mark LT on the machine pulley should be approximately 1/8" above the arrow on the machine arm. Loosen the needle guard set screws, Fig. 30. Turn the needle guards as close to the needles as possible without touching. Tighten the set screws. Check by springing the needles to the left and turning the machine pulley to make certain that the looper points do not stroke the needles.



Positioning Spreader

Fig 31

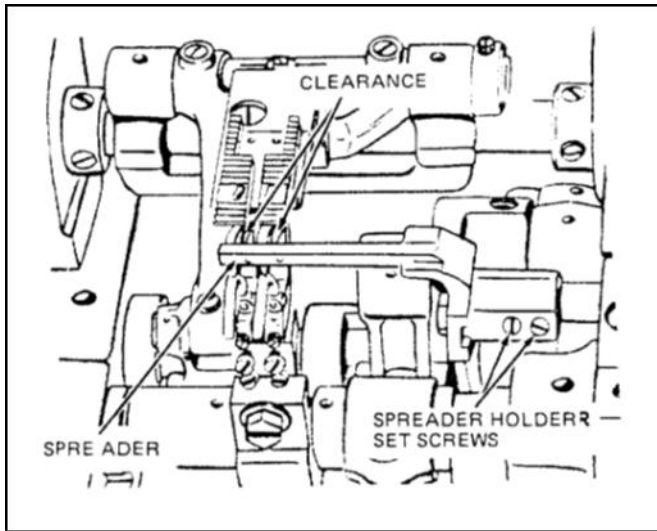
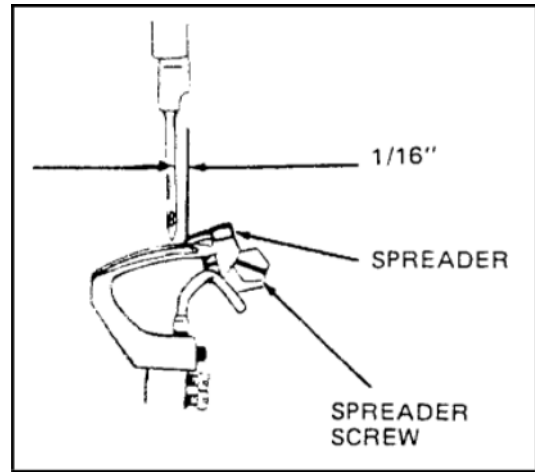


Fig 32



Sidewise and Height Setting

When the looper on its forward stroke is passing the spreader

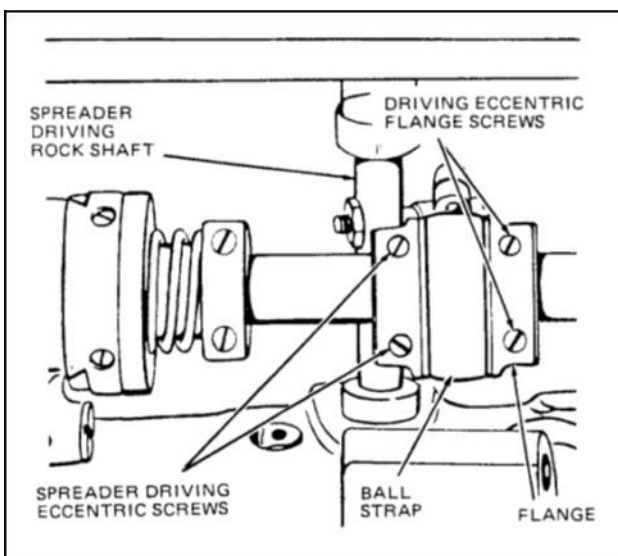
- a) The point of the spreader should be exactly opposite the top of the thread groove at the left side of the looper.
- b) The clearance between the spreader point and the looper should be approximately the double thickness of ordinary paper.

To adjust, loosen the two spreader holder set screw, Fig. 31. Move the spreader and holder to the correct position. Hold in position and tighten the set screws.

Lengthwise Setting

When the point of the needle on its downward stroke is even with the point of the spreader, the clearance between the two points should be approximately 1/16". To adjust, loosen the spreader screw, Fig. 32, and move the spreader forward or backward to correct position. Then tighten the spreader screw.

Fig 33



Changing Movement of Spreader

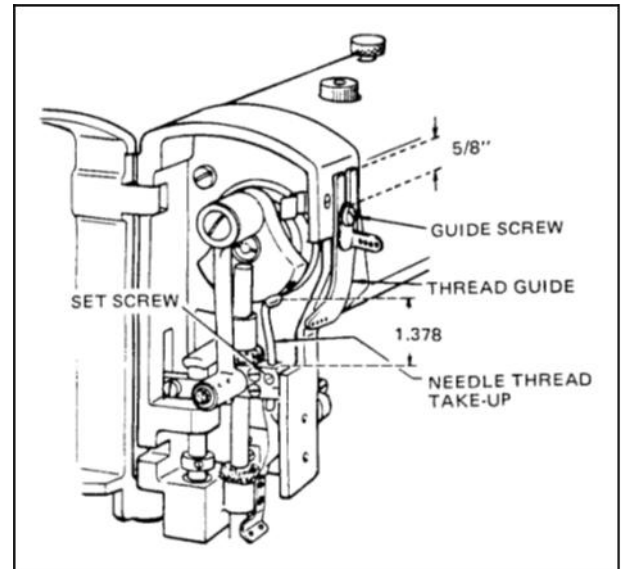
The sidewise movement of the spreader may be adjusted for sewing under abnormal conditions. Under normal conditions, maximum spreader movement is generally used. To adjust, tilt the machine back on its hinges, loosen the two spreader driving eccentric screws, Fig. 33, and the two spreader driving eccentric flange screws. Move eccentric to the left to increase movement, or to the right to decrease movement. When correctly positioned, tighten the two spreader driving eccentric screws first, hold flange against strap and tighten flange screws. Then refer to preceding information regarding positioning of spreader.

Adjusting Needle Thread Take-Up

The needle thread take-up and thread guide may be adjusted to increase or decrease the amount of thread drawn at the top of the needle bar stroke. To increase the amount, loosen the thread take-up screw, Fig. 34, and raise the take-up or loosen the guide screw and lower the guide. To decrease the amount, reverse the adjustment by lowering the take-up or raising the guide.

For average sewing conditions, the guide should be set with upper end 5/8" above the guide screw. The thread take-up should be set with the lower end 1.378" below the bottom of its holder.

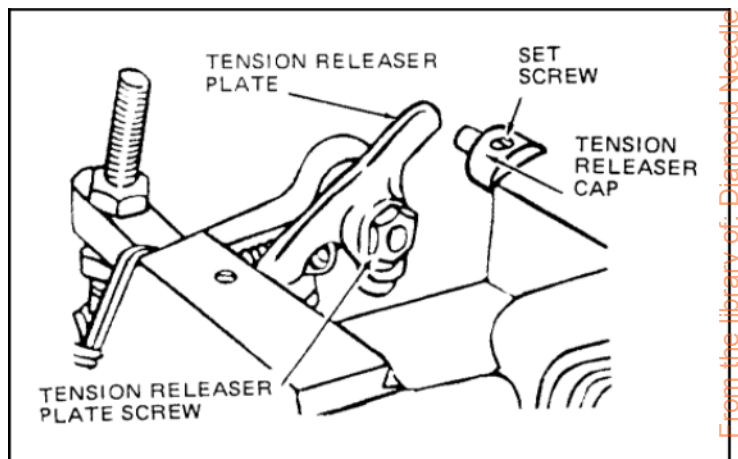
Fig 34



Adjusting Needle Thread Tension Releaser

When correctly adjusted, the tension releaser should release tension on the needle thread when the presser foot is raised and allows full adjusted tension when presser foot is down. To adjust, loosen the set screw, Fig. 35, and move tension releaser cap out for earlier release of tension or in for later release. Hold in position and tighten the set screw. Should the tension releaser not release tension at the correct time after making the above adjustments, loosen the tension releaser plate screw and move plate sidewise to correct position. Then tighten the screw.

Fig 35

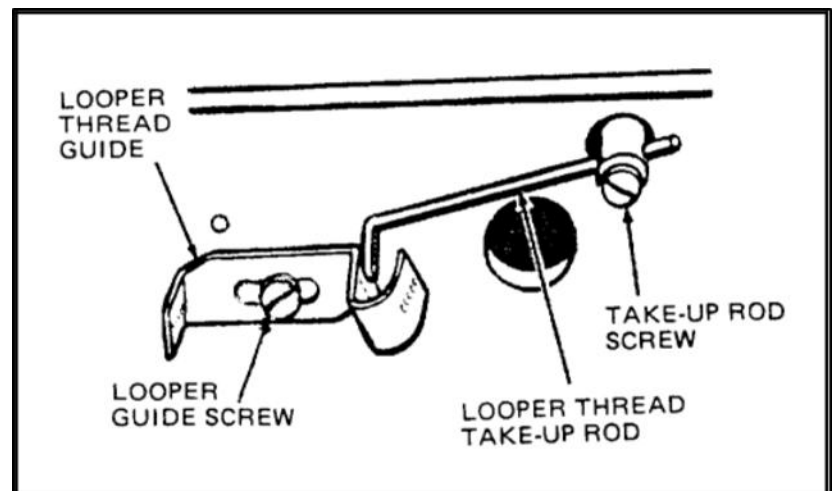


Adjusting Looper Thread Take-Up

The looper thread take-up and guide may be adjusted for handling more or less thread, according to the thickness of material and length of stitch, and to change the ratio of looper thread in the finished stitch.

To change the amount of thread handled, loosen the looper thread guide screw, Fig. 36, and looper thread take-up rod screw. Move the thread guide and take-up rod to the left for more thread or to the right for less thread. Tighten the two screws making certain that the take-up rod passes through the center of the guide yoke. To change the ratio of looper thread in finished stitch, loosen the thread guide screw, Fig. 36, and lower the yoke or right end of the thread guide for more thread. For less thread, raise the end of the guide. Hold in position and tighten the guide screw.

Fig 36



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Singer® 300UX5 Assembly Drawings & Parts Lists



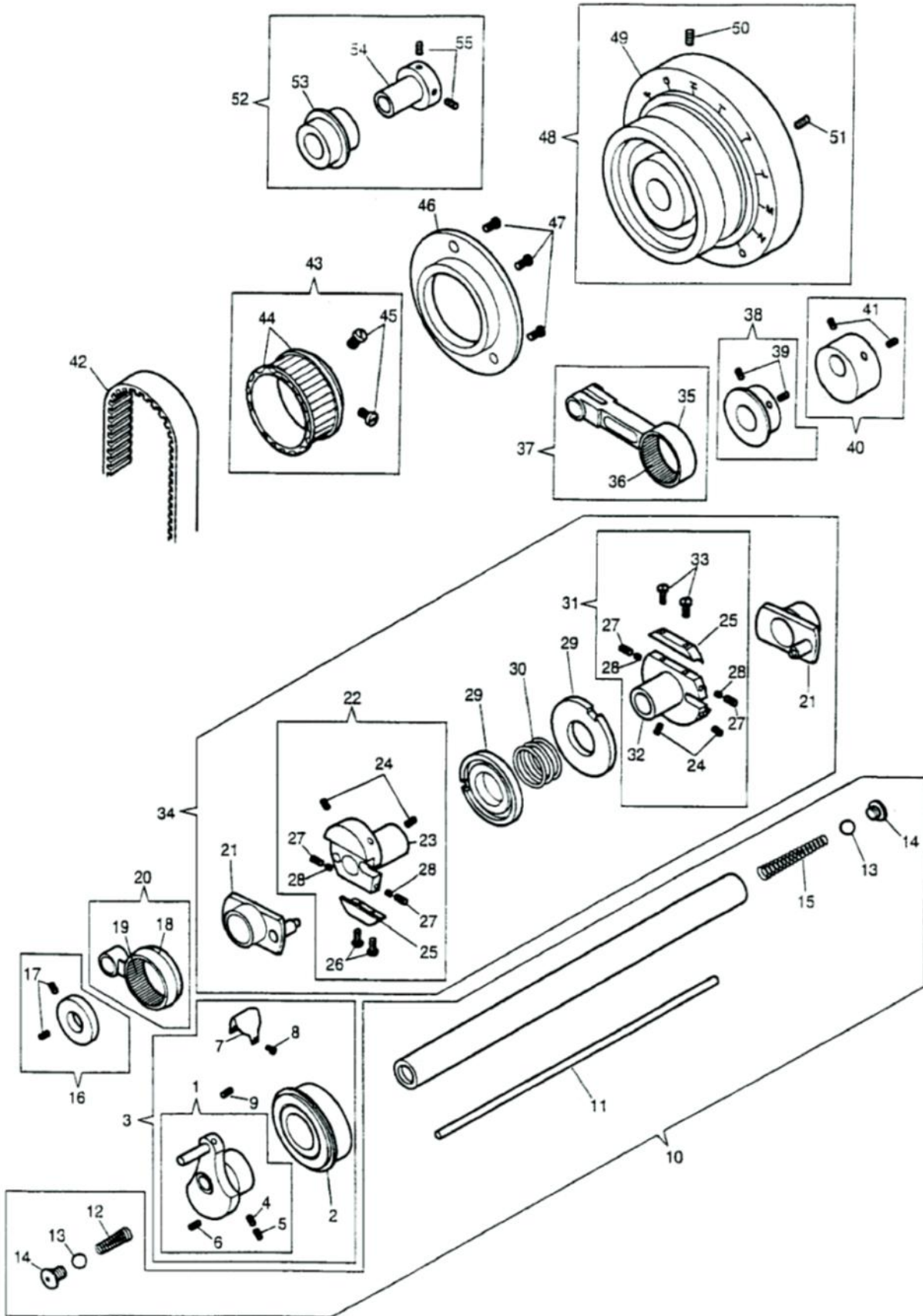
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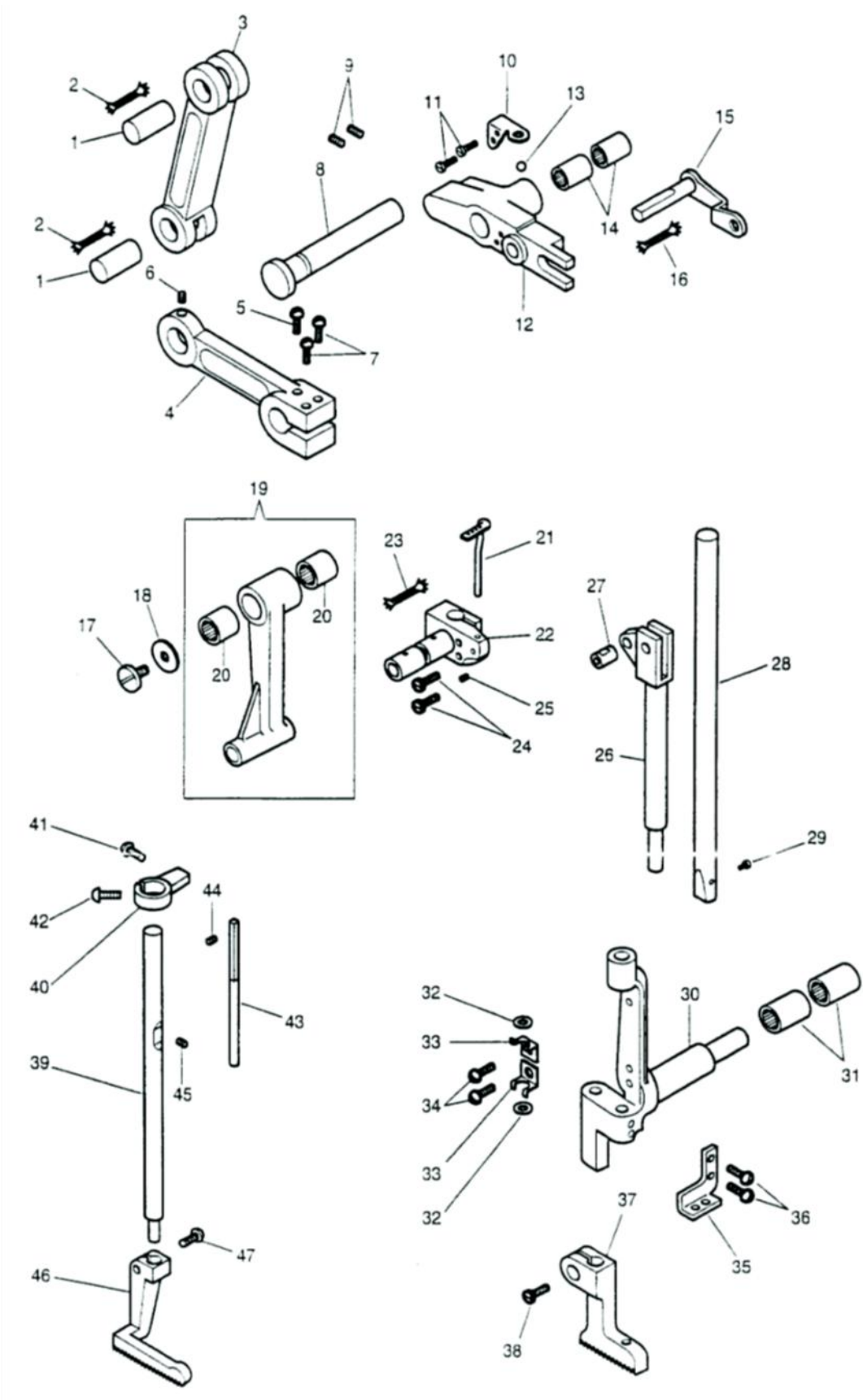
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Upper Shaft Assembly

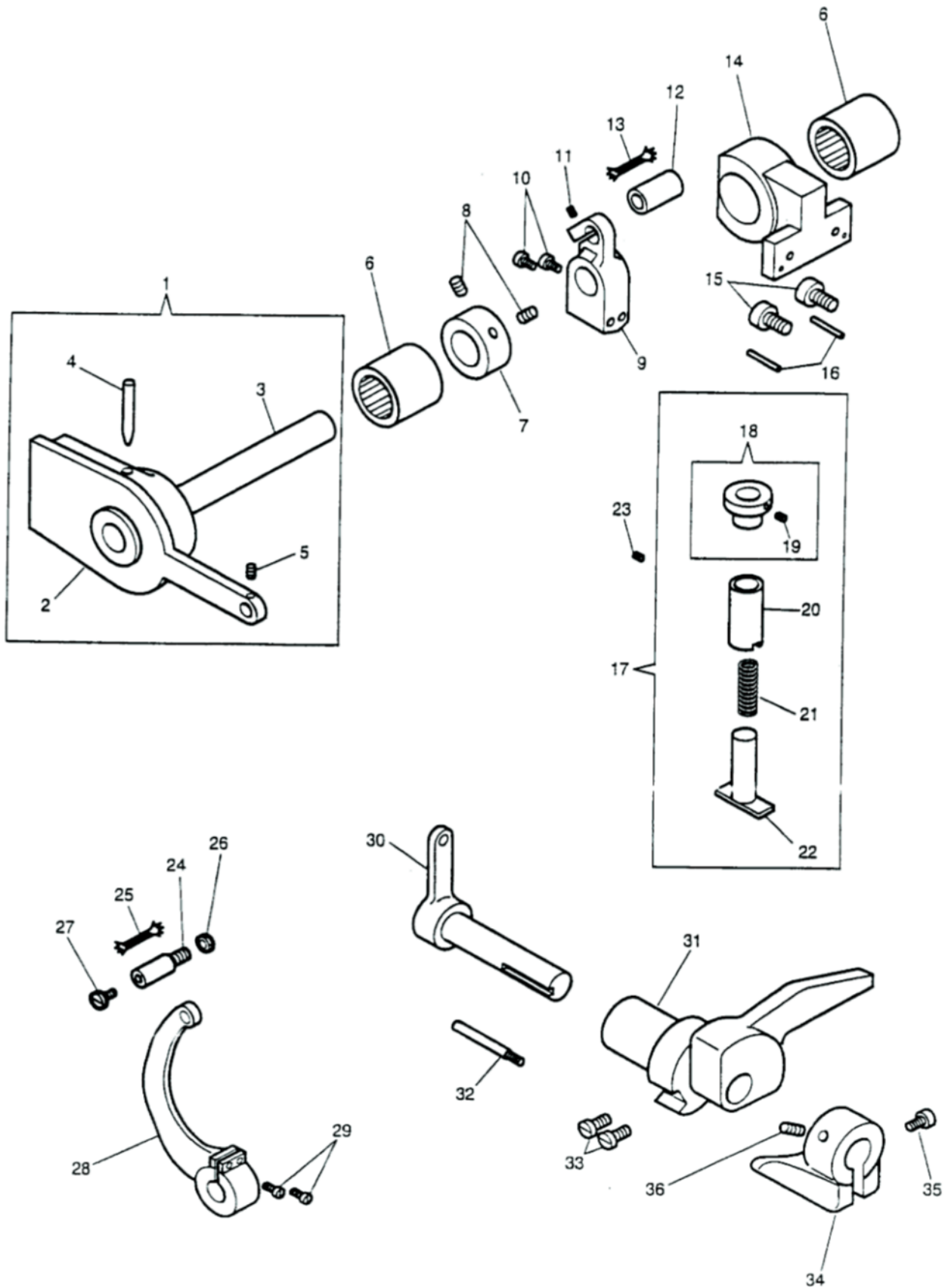
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	415138	Needle Bar Crank	29	2	268065	Eccentric Adjusting Disc
2	1	32848	Arm Shaft Ball Bearing	30	1	268618	Disc Spring
3	1	281239	Needle Bar Crank	31	1	415076	Eccentric Flange
4	1	549024	Crank Position Screw	32	1	415077	Eccentric Flange
5	1	544358	Check Screw	33	2	544286	Friction Plate Screw
6	1	500272-833	Set Screw	34	1	415081	Driving Eccentric
7	1	281206	Crank Cover	35	1	268490	Eccentric Connection
8	2	545205-451	Crank Cover Screw	36	1	271055	Needle Bearing
9	1	281258	Oil Wick	37	1	268491	Eccentric Connection
10	2	415128	Arm Shaft	38	1	415086	Spacing Collar
11	1	268264	Control Rod	39	2	414529	Set Screw
12	1	268009	Ball Spring	40	1	281256	Counter Balance
13	2	268214	Stop Ball	41	2	544208-005	Set Screw
14	2	414578	Ball Screw	42	1	268270	Connection Belt
15	1	268044	Ball Spring	43	1	281290	Belt Pulley
16	1	415308	Spacing Collar	44	2	202253	Pulley Spring Flange
17	2	414529	Set Screw	45	2	414546	Set Screw
18	1	268060	Driving Connection	46	1	268004-451	Bearing Housing
19	1	271055	Needle Bearing	47	3	544336	Housing Screw
20	1	267609	Driving Connection	48	1	415153-451	Machine Pulley
21	2	267610	Driving Eccentric	49	1	415154-451	Machine Pulley
22	1	415078	Eccentric Flange	50	1	414525	Set Screw
23	1	415079	Eccentric Flange	51	1	414526	Position Screw
24	4	414555	Set Screw	52	1	281294	Thrust Collar
25	2	267623	Friction Plate	53	1	272142	Ball Bearing Back
26	2	374098	Friction Plate Screw	54	1	281295-001	Thrust Collar
27	4	414557	Set Screw	55	1	544209-005	Set Screw
28	4	241763	Set Screw Packing				

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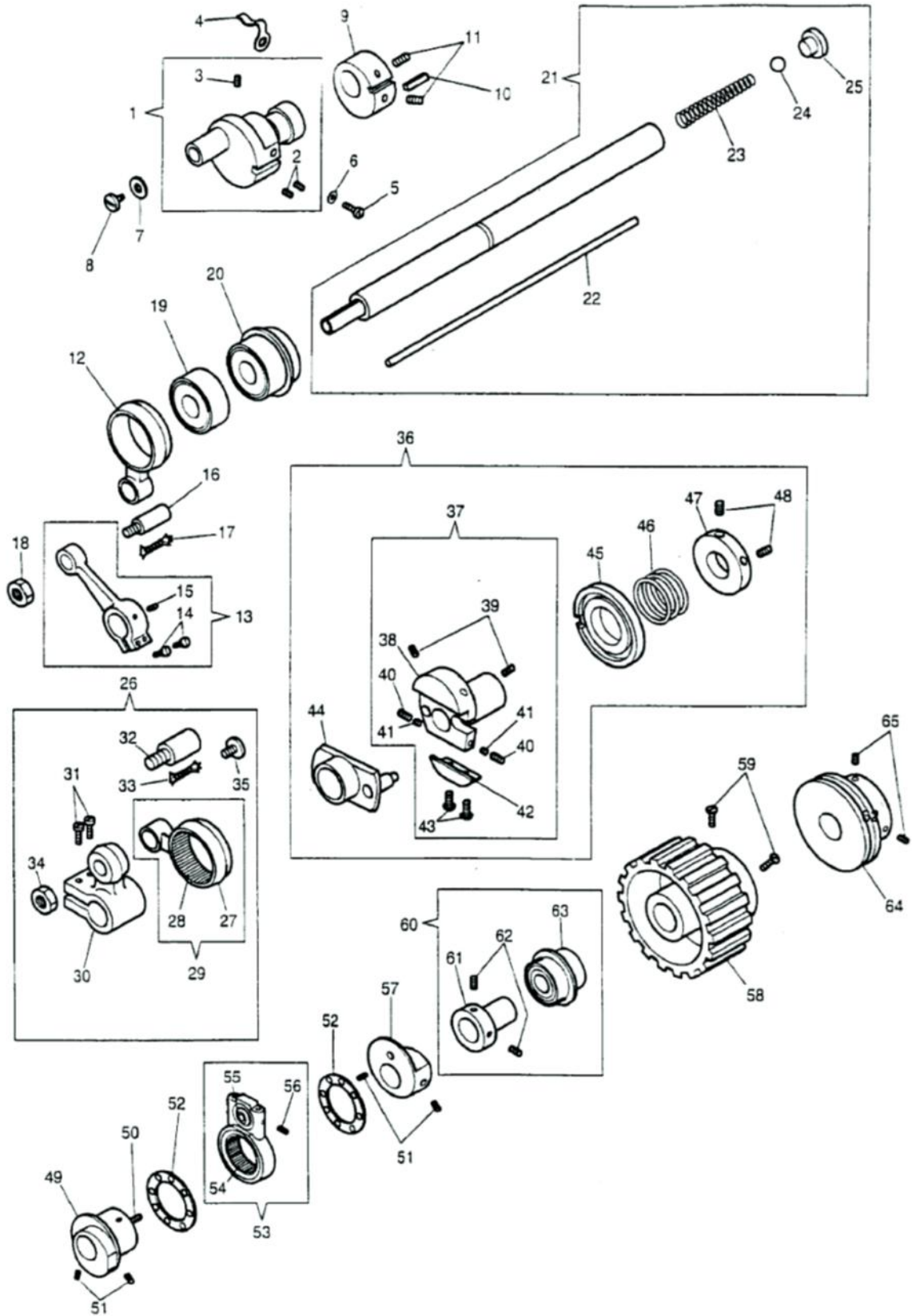
Front Assembly Sewing Arm

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	267617	Hinge Pin	25	1	414545	Thread Guide Set Screw
2	2	268258	Oil Wick	26	1	267657	Presser Bar
3	1	267627	Lifting Link	27	1	267658	Hinge Stud
4	1	415061	Lifting Crank	28	1	281912	Needle Bar
5	1	141338	Set Screw	29	1	414519	Set Screw
6	2	141424	Set Screw	30	1	415045	Rock Frame
7	2	414511	Pinch Screw	31	2	268029	Needle Bearing
8	1	267626	Hinge Stud	32	2	268144	Oiling Felt
9	2	544322	Set Screw	33	2	268278	Felt Holder
10	1	267718	Ball Retainer	34	2	414522	Felt Holder Screw
11	2	414548	Retainer Screw	35	1	268219	Thread Guide
12	1	415067	Lifting Lever	36	2	414539	Thread Guide Screw
13	1	276025	Spring Arm Ball	37	1	559057	Presser Foot
14	2	267093	Needle Bearing	38	1	414638	Pinch Screw
15	1	267631	Lifting Crank	39	1	267628	Presser Bar
16	1	268258	Oil Wick	40	1	415059	Guide Block
17	1	414517	Washer Screw	41	1	414516	Adjusting Screw
18	1	268139	Cap Washer	42	1	414512	Pinch Screw
19	1	285916	Connecting Link	43	1	267907	Guide Rod
20	2	270266	Needle Bearing	44	1	544301	Set Screw
21	1	268512	Thread Guide	45	1	414530	Set Screw
22	1	281914	Connecting Stud	46	1	559059	Presser Foot
23	1	202330	Oil Wick	47	1	414638	Pinch Screw
24	2	414511	Pinch Screw				



External Parts Sewing Arm

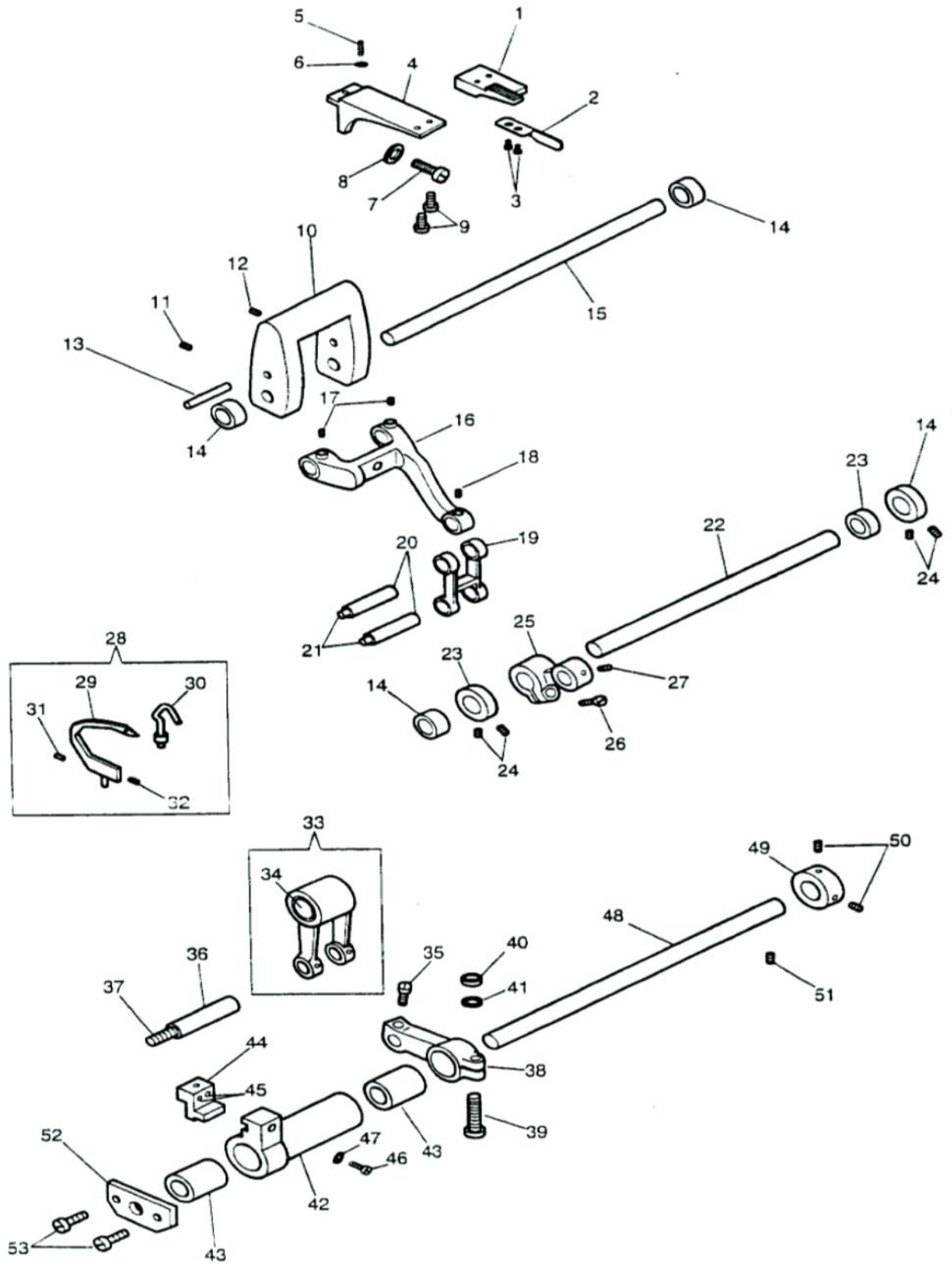
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	32789	Lifting Rock Shaft	19	1	414528	Set Screw
2	1	32788	Shaft Crank	20	1	268149	Stud Sleeve
3	1	267633	Lifting Rock Shaft	21	1	214529	Stud Spring
4	1	548035	Crank Pin	22	1	268148	Regulating Stud
5	1	141424	Set Screw	23	1	414527	Set Screw
6	2	267110	Needle Bearing	24	1	415092	Hinge Stud
7	1	415065	Shaft Collar	25	2	268258	Oil Wick
8	2	504020	Set Screw	26	1	541197	Hinge Stud Nut
9	1	415069	Connection Crank	27	1	545297	Cap Screw
10	2	414509	Pinch Screw	28	1	415094-451	Driving Arm
11	1	414543	Pinch Screw	29	2	414790	Pinch Screw
12	1	267617	Hinge Pin	30	1	267612	Foot Lifter Crank
13	1	268258	Oil Wick	31	1	267719-452	Spring Arm Fulcrum
14	1	415071-451	Shaft Bracket	32	1	414566	Stop Screw Stud
15	2	414504	Bracket Screw	33	2	350604	Set Screw
16	2	543841-001	Position Pin	34	1	415122	Foot Lifter Arm
17	1	415098	Regulating Stud	35	1	414509	Pinch Screw
18	1	415099	Stud Cap	36	1	545213	Set Screw



Lower Shaft Assembly

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	415176	Driving Crank	34	1	541197	Hinge Stud Nut
2	2	347099	Position Screw	35	1	545297	Cap Screw
3	1	500264-833	Set Screw	36	1	415082	Eccentric
4	1	268102	Hole Cover	37	1	415073	Eccentric Flange
5	1	414563	Screw	38	1	415074	Eccentric Flange
6	1	204925	Screw Washer	39	2	414555	Set Screw
7	1	418465	Connection Washer	40	2	414557	Set Screw
8	1	414518	Washer Screw	41	1	241763	Set Screw Packing
9	1	415210	Eccentric	42	1	267263	Friction Plate
10	1	268077	Lubricating Pad	43	2	374098	Friction Plate Screw
11	2	544208-005	Set Screw	44	1	267610	Eccentric
12	1	268074	Feed Lifting Connection	45	1	268065	Adjusting Disc
13	1	415206	Crank	46	1	268066	Adjusting Disc Spring
14	2	414511	Pinch Screw	47	1	412011	Spring Collar
15	1	414549	Position Screw	48	2	544325	Set Screw
16	1	415092	Hinge Stud	49	1	415187	Eccentric
17	1	268258	Oil Wick	50	1	543808-002	Eccentric Pin
18	1	541197	Hinge Stud Nut	51	4	414528	Set Screw
19	1	281216	Ball Bearing	52	2	268220	Thrust Washer
20	1	281224	Ball Bearing	53	1	281246	Driving Connection
21	1	559038	Bed Shaft	54	1	415368	Needle Bearing
22	1	268265	Control Rod	55	1	281248	Ball Roller
23	1	268044	Ball Spring	56	1	544203-001	Set Screw
24	1	268214	Stop Ball	57	1	415190	Counterbalance
25	1	414578	Ball Screw	58	1	281292	Belt Pulley
26	1	415212	Crank	59	2	414546	Set Screw
27	1	268608	Driving Connection	60	1	281294	Thrust Collar
28	1	271055	Needle Bearing	61	1	281295-001	Thrust Collar
29	1	267609	Driving Connection	62	2	544209-005	Set Screw
30	1	415213	Crank	63	1	272142	Thrust Collar Bearing
31	2	414511	Pinch Screw	64	1	559040	Bed Shaft Pulley
32	1	415092	Hinge Stud	65	2	544209-005	Set Screw
33	1	268258	Oil Wick				

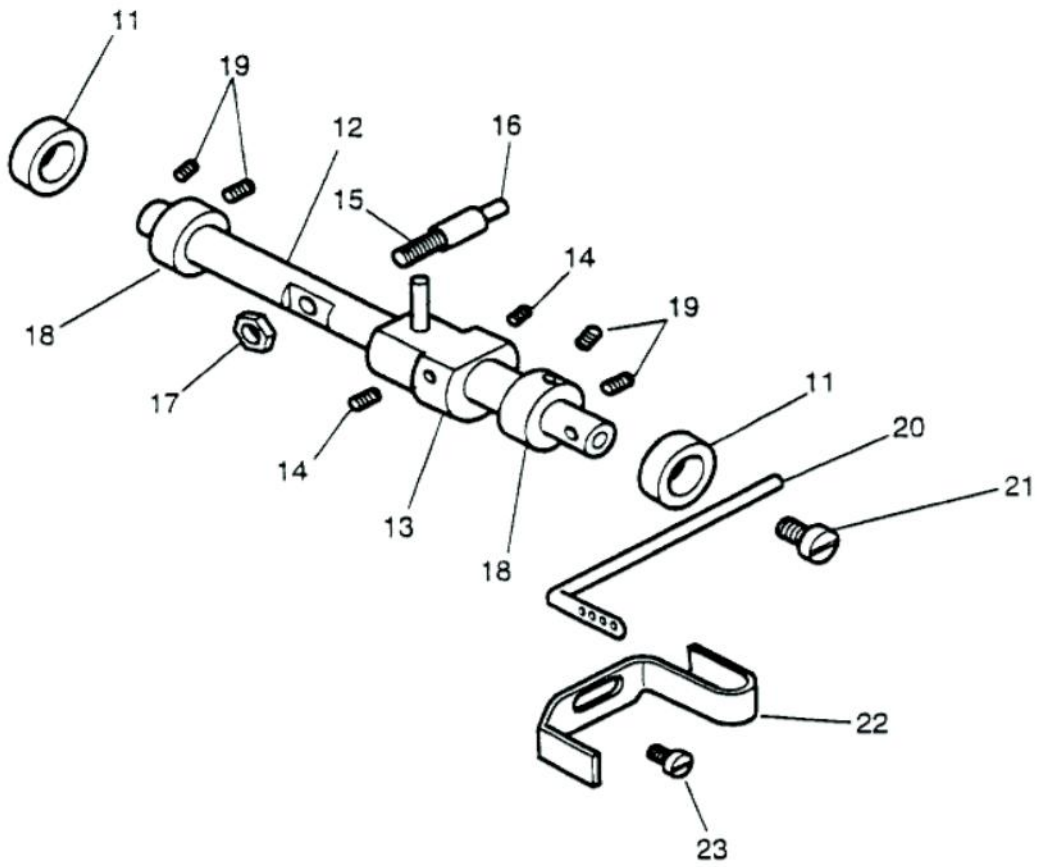
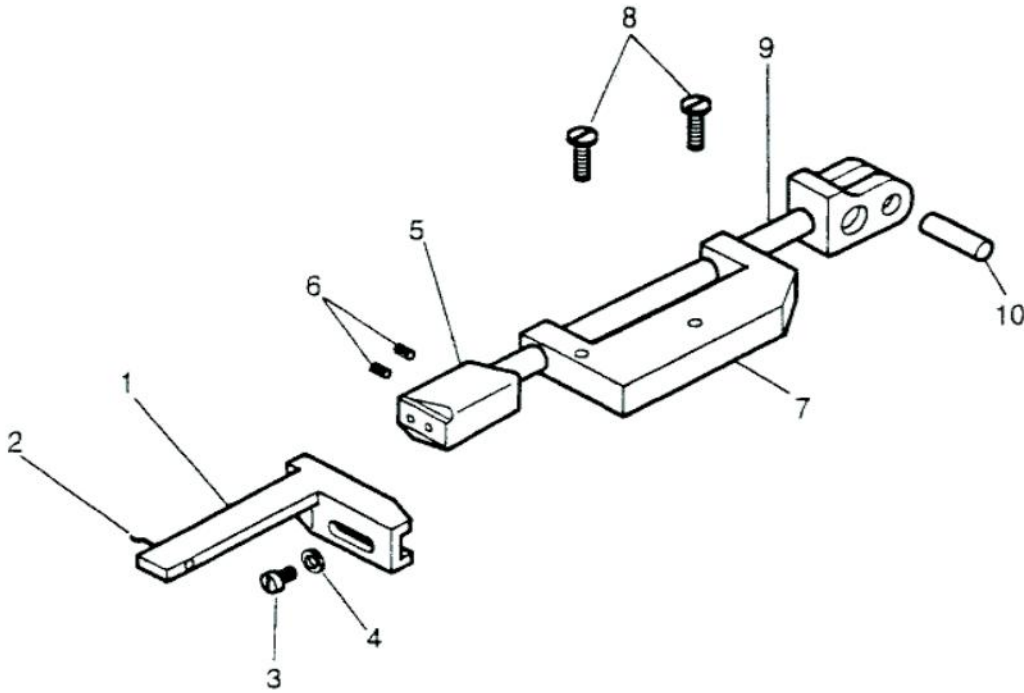
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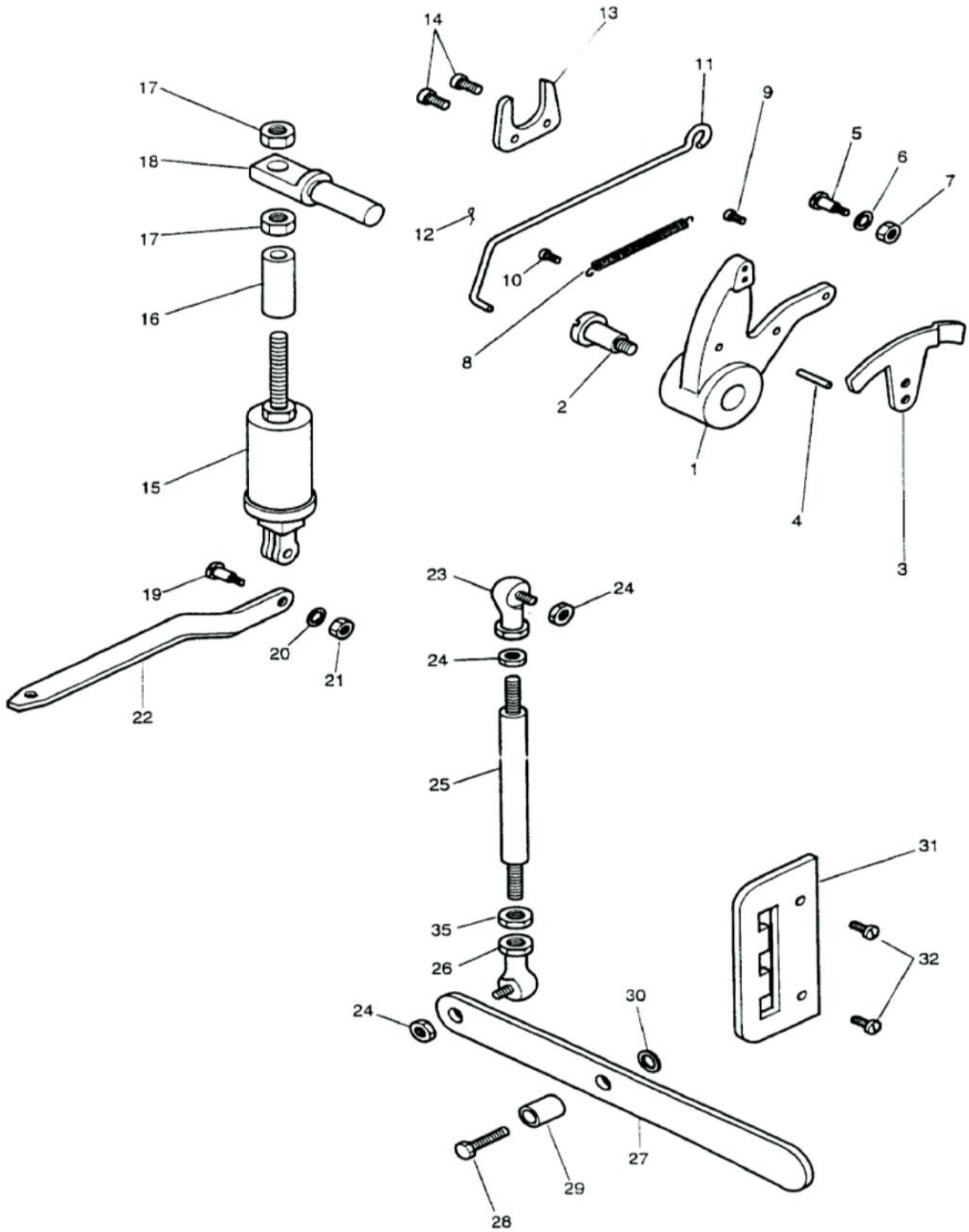
Front Assembly Sewing Bed

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	559061	Feed Dog	28	1	281208	Needle Guard
2	1	267665	Loop Deflector	29	1	268380	Looper
3	2	229	Deflector Screw	30	1	281207	Needle Guard
4	1	559064	Feed Dog Shank	31	1	141478	Set Screw
5	1	414559	Adjusting Screw	32	1	141494	Set Screw
6	1	541200	Lock Nut	33	1	281223	Driving Connection
7	1	414520	Shank Screw	34	1	415500	Connection Bushing
8	1	543804-004	Washer	35	1	414516	Pinch Screw
9	2	374107-003	Screw	36	1	268208	Hinge Pin
10	1	559049	Driving Rock Frame	37	1	268258	Oil Wick
11	1	549024	Position Screw	38	1	415174	Looper Carrier Crank
12	1	500264-833	Set Screw	39	1	415292	Clamping Stud
13	1	559051	Hinge Pin	40	1	541198	Clamping Stud Nut
14	4	415297	Bushing	41	1	548459	Clamping Stud Washer
15	1	268070	Driving Rock Shaft	42	1	559041	Looper Carrier
16	1	559045	Feed Bar	43	2	415500	Bushing
17	2	544204-001	Set Screw	44	1	559055	Looper Holder
18	1	545213	Set Screw	45	2	414558	Set Screw
19	1	268078	Feed Lifting Link	46	1	414750-002	Screw
20	2	268079	Hinge Pin	47	1	543804-004	Washer
21	2	268258	Oil Wick	48	1	269617	Looper Carrier Shaft
22	1	559052	Rock Shaft	49	1	415172	Shaft Collar
23	2	415065	Shaft Collar	50	2	544204-001	Set Screw
24	2	504020	Set Screw	51	1	544209-003	Set Screw
25	1	415204	Lifting Crank	52	1	559044	Supporting Plate
26	1	414501	Pinch Screw	53	2	414518	Screw
27	1	545213	Set Screw				



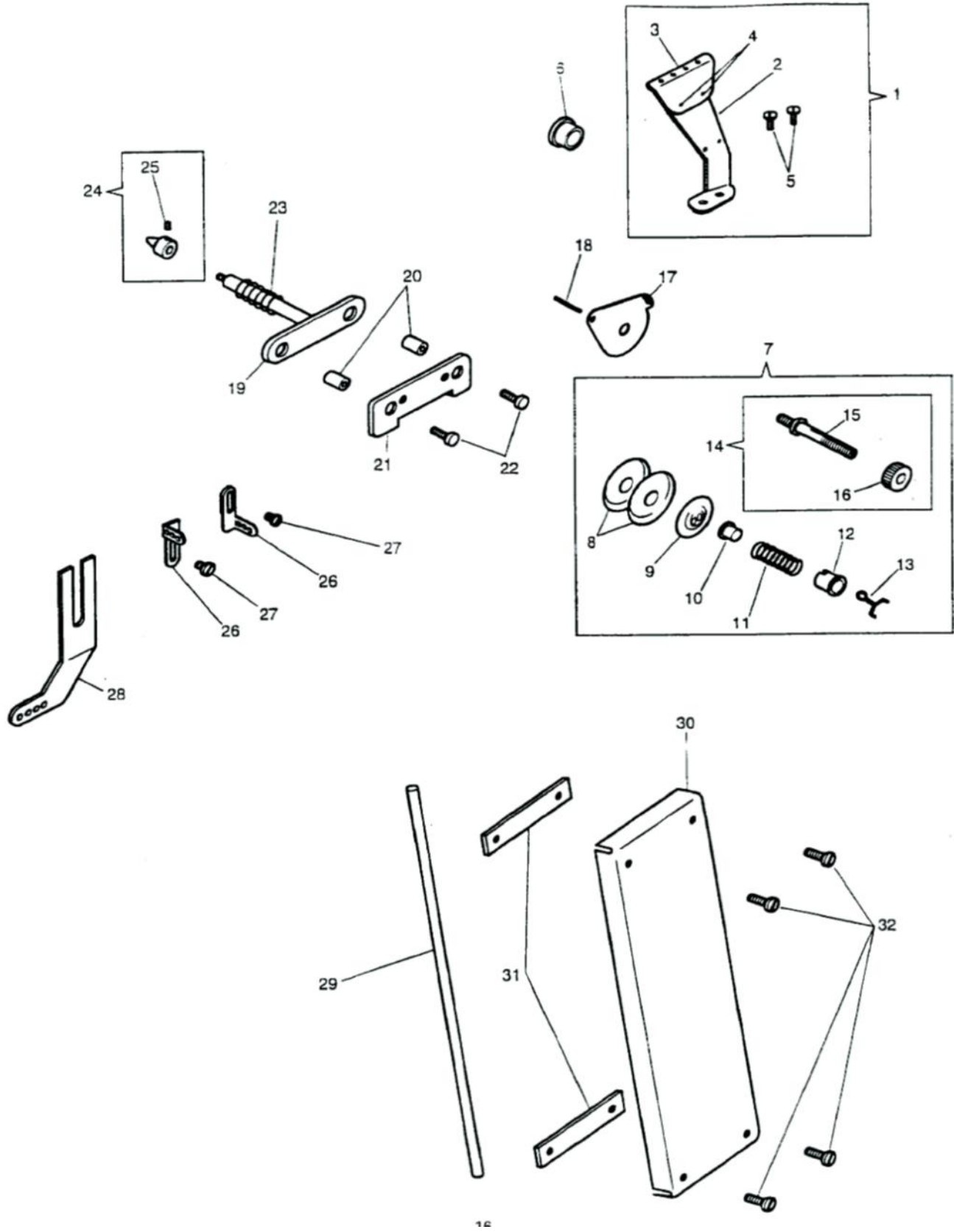
Cross Shaft in Sewing Bed

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	281975	Spreader	13	1	415194	Crank
2	1	268162	Spreader Point	14	2	544204-001	Set Screw
3	1	414552	Spreader Screw	15	1	414575	Screw Stud
4	1	547670	Washer	16	1	32825	Oil Wick
5	1	415196	Spreader Holder	17	1	545424	Screw Stud Nut
6	1	414529	Set Screw	18	2	415065	Shaft Collar
7	1	268184	Spreader Bar Bracket	19	4	504020	Set Screw
8	2	414524	Screw	20	1	268052	Thread Take-Up Rod
9	1	559065	Spreader Bar	21	1	504019	Set Screw
10	1	268190	Driving Pin	22	1	269619	Thread Guide
11	2	415297	Bushing	23	1	414510	Screw
12	1	415389	Driving Rock Shaft				



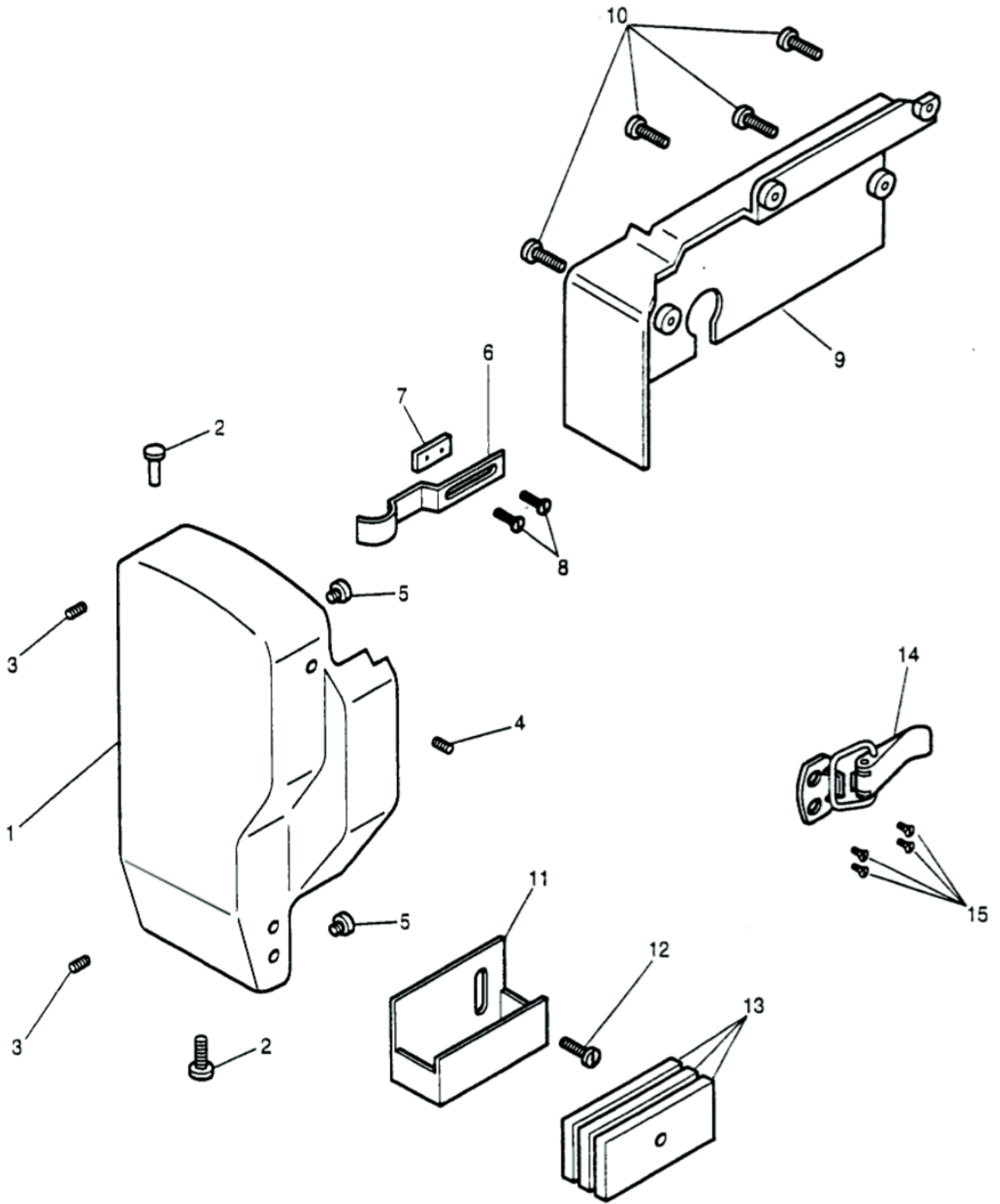
External Parts Sewing Arm

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	281929	Foot Lifter Lever	18	1	267714	Housing Support
2	1	201363	Hinge Screw	19	1	414567	Hinge screw
3	1	267707	Tension Releasing Plate	20	1	548154	Washer
4	1	543850-001	Releasing Plate Pin	21	1	545405	Nut
5	1	414577	Hinge Screw	22	1	267738	Spring Arm
6	1	543804-004	Washer	23	1	412373	Rod Connection
7	1	541166-003	Nut	24	3	541166-001	Connection Nut
8	1	204348	Lever Spring	25	1	559068	Lifting Rod
9	1	414570	Spring Screw Eye	26	1	559067	Rod Connection
10	1	544336	Spring Screw	27	1	559069	Lifting Lever
11	1	267704	Lever Rod	28	1	544499-072	Hinge Screw
12	1	248423	Cotter Pin	29	1	559070	Collar
13	1	267650	Housing Support Retainer	30	1	543874-005	Washer
14	2	545205-451	Retainer Screw	31	1	559071	Latch Plate
15	1	415106	Spring Housing	32	2	414508	Screw
16	1	559077	Collar	35	1	414774	Nut
17	2	541198	Nut				



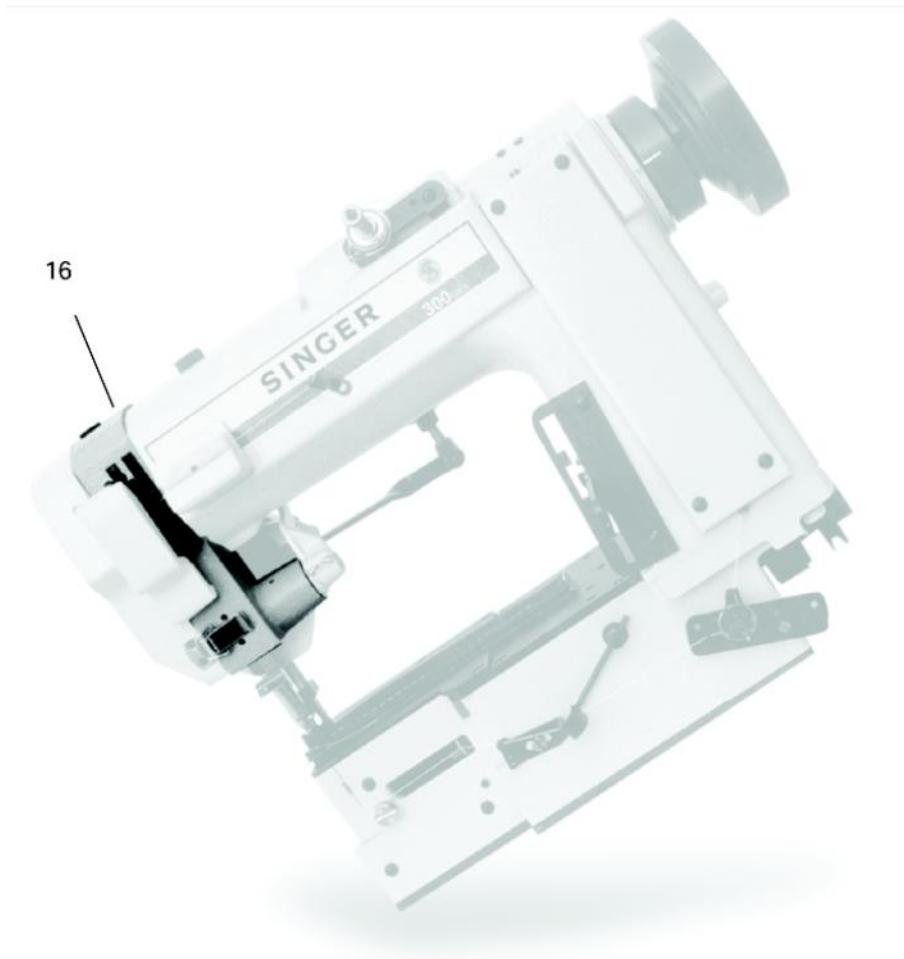
External Parts Sewing Arm

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	268506	Thread Guide Bracket	17	1	54279	Thread Guide
2	1	268111	Thread Guide Bracket	18	1	226206	Releasing Pin
3	1	268505	Thread Guide	19	1	415357	Tension Releaser
4	2	50169	Screw	20	2	543853-003	Spacing Collar
5	2	414537	Screw	21	1	268167	Tension Bracket
6	1	544875	Arm Plug	22	2	544336	Tension Bracket Screw
7	1	267971	Thread Tension	23	1	204365	Tension Releaser Spring
8	2	2102	Tension Disc	24	1	415252	Tension Releaser Cap
9	1	32572	Releasing Disc	25	1	504048	Set Screw
10	1	59538	Spring Bushing	26	2	268513	Thread Guide
11	1	131741	Tension Spring	27	3	414514	Screw
12	1	143657	Spring Bushing	28	1	268312	Thread Guide
13	1	143658	Locking Spring	29	1	268123	Thread Tube
14	1	59539	Tension Stud	30	1	415342-451	Thread Tube Cover
15	1	50326	Tension Stud	31	1	268500	Cover Cushion
16	1	51570	Thumb Nut	32	4	414639	Screw

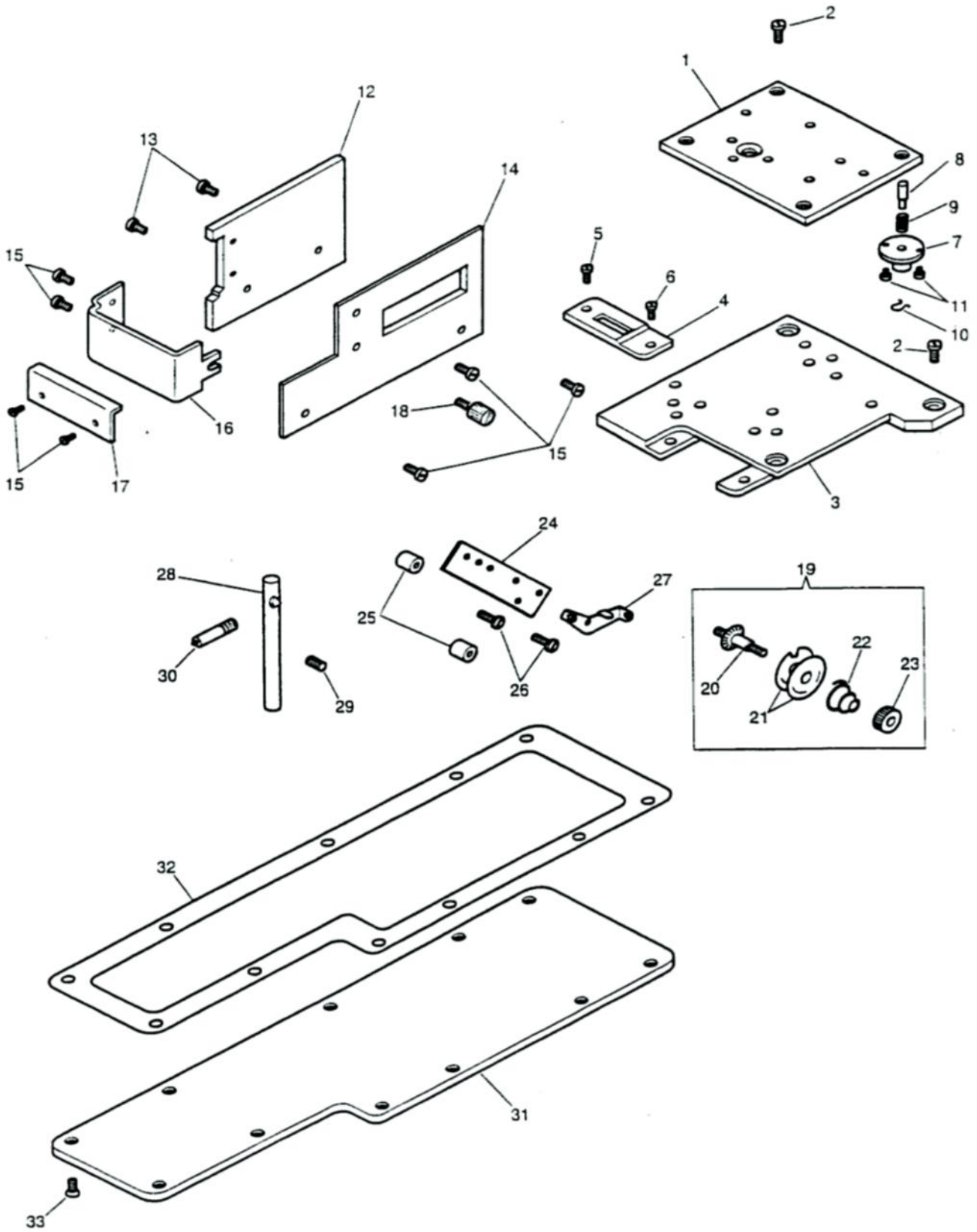


External Parts Sewing Arm

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	559029	Face Plate	9	1	267701-451	Arm Side Cover
2	2	268330	Hinge Stud	10	4	545295	Screw
3	2	545174-452	Set Screw	11	1	267656-452	Thread Lubricator
4	1	268033	Lock Stud	12	1	504019	Screw
5	1	228661	Face Plate Cushion	13	3	236957	Oil Pad (Felt)
6	1	268032	Lock Spring	14	1	559032	Face Plate Locker
7	1	415016	Spring Plate	15	4	374397-002	Screw
8	2	414534	Screw	16	1	415009	Needle Bar Crank Housing



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External Parts Sewing Arm

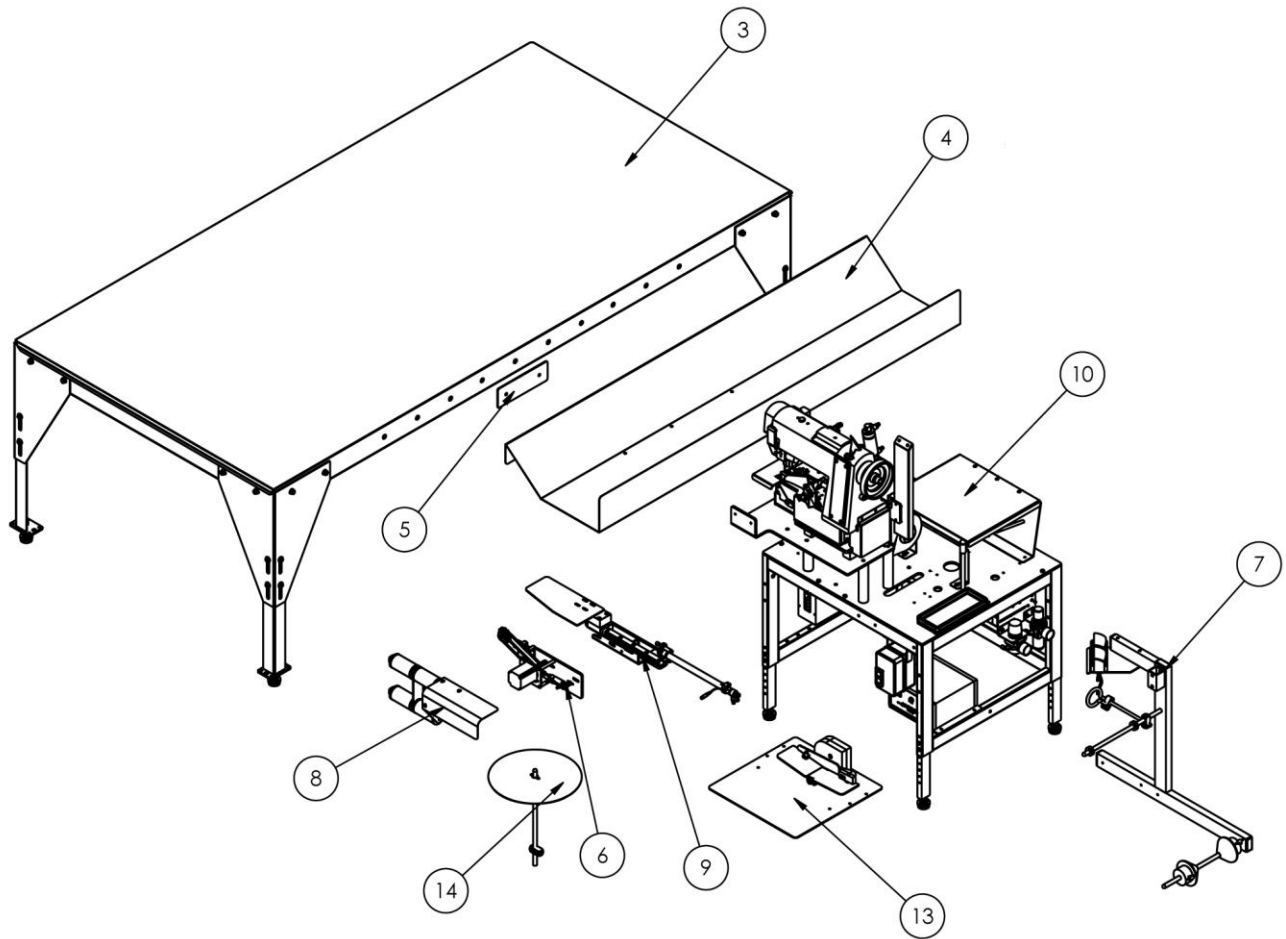
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	559037	Bed Plate (Right)	18	1	559073	Looper Cover Thumb Screw
2	8	414508	Screw	19	1	415294	Thread Tension
3	1	559035	Bed Plate (Left)	20	1	415291	Thread Tension Stud
4	1	559060	Throat Plate	21	2	412203	Thread Tension Disc
5	1	374107-001	Screw	22	1	10148	Thread Tension Spring
6	1	414518	Screw	23	1	541452	Thumb Nut
7	1	268082	Regulating Stud Socket	24	1	415255	Tension Bracket
8	1	268081	Feed Regulating Stud	25	2	543853-003	Spacing Collar
9	1	270026	Stud Spring	26	2	414532	Screw
10	1	240245	Retaining Spring	27	1	268333	Thread Guide
11	1	545249-452	Screw	28	1	52239	Looper Thread Guide
12	1	559075	Bed Cover	29	1	544211-052	Set Screw
13	2	414520	Screw	30	1	559078	Thread Guide
14	1	559076	Bed Cover	31	1	559033	Bottom Plate
15	7	544217-052	Screw	32	1	559034	Gasket
16	1	559072	Looper Cover	33	6	544381	Screw
17	1	559074	Bed Cover (Left)				

Assembly Drawings & Parts Lists

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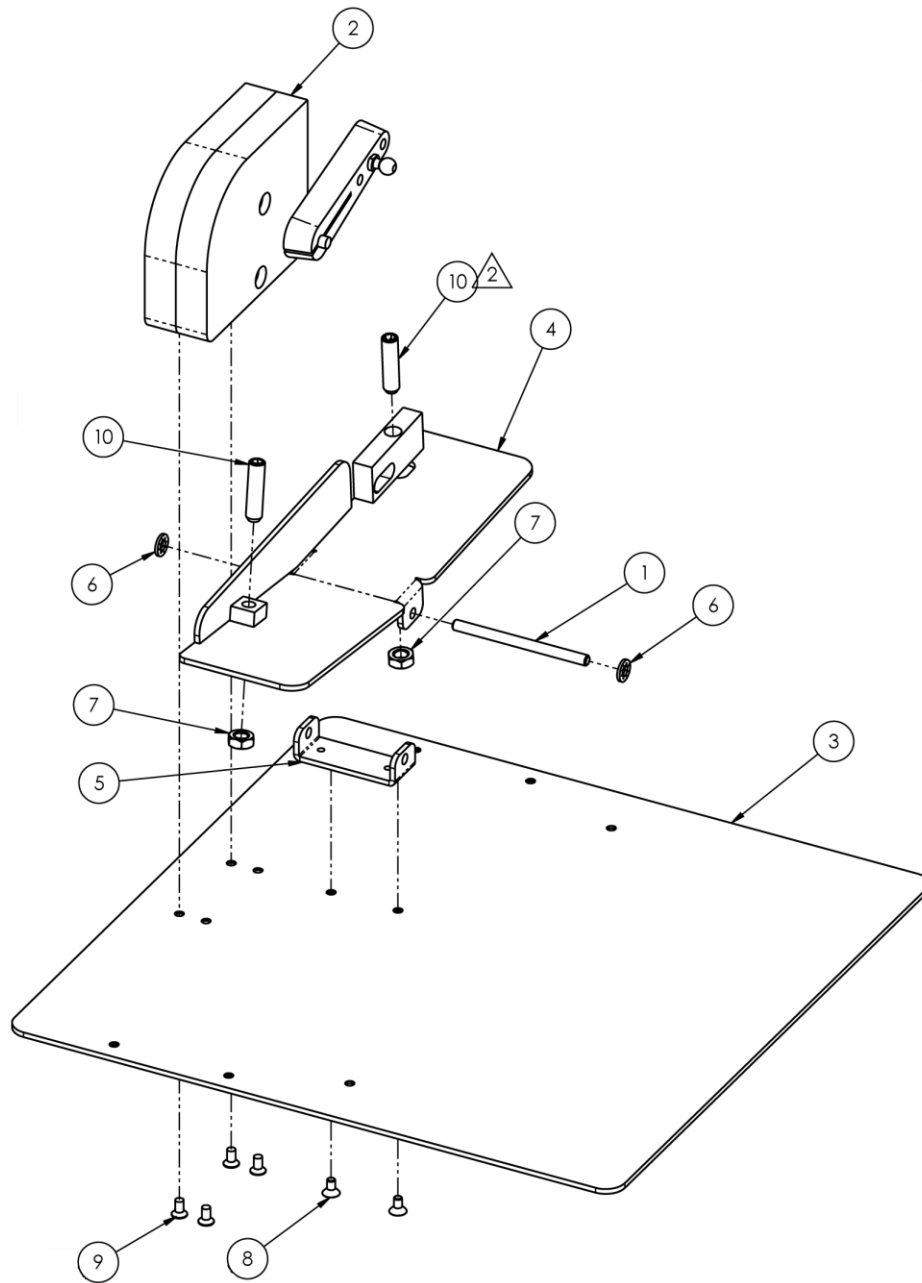
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11344S88UK Main Assembly

AAC Drawing Number 9001294 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	AR	11344S88PAR	PARAMETER DOCUMENT
2	1	1335-816	ROD,SS, 1/2 X 15.0 L
3	1	1337A-160	AIR TABLE ASSY,SINGLE TBL
4	1	1338-022	TRAY, BORDER
5	1	1338-023	SPACER, BORDER TRAY
6	1	1338-2000	EDGE GUIDE ASSEMBLY
7	1	1338-3000	TOUCH SWITCH ASBLY
8	1	1338041	FRONT ROLLER ASSEMBLY
9	1	1338042	GUIDE PLATE, RETRACTABLE
10	1	1344016	CONSOLE, 11344S88UK
11	AR	1344S88-PD	PNEUMATIC DIAGRAM
12	AR	1344S88-WD	WIRING DIAGRAM
13	1	4059-FP301D	FOOT PEDAL ASSY,EFKA
14	1	785-A95-12	DISC,STATIONARY,12"
15	1	A-U	ROD CROSS BLOCK
16	*10	SN62X8524	NEEDLE,SIZE 180/24

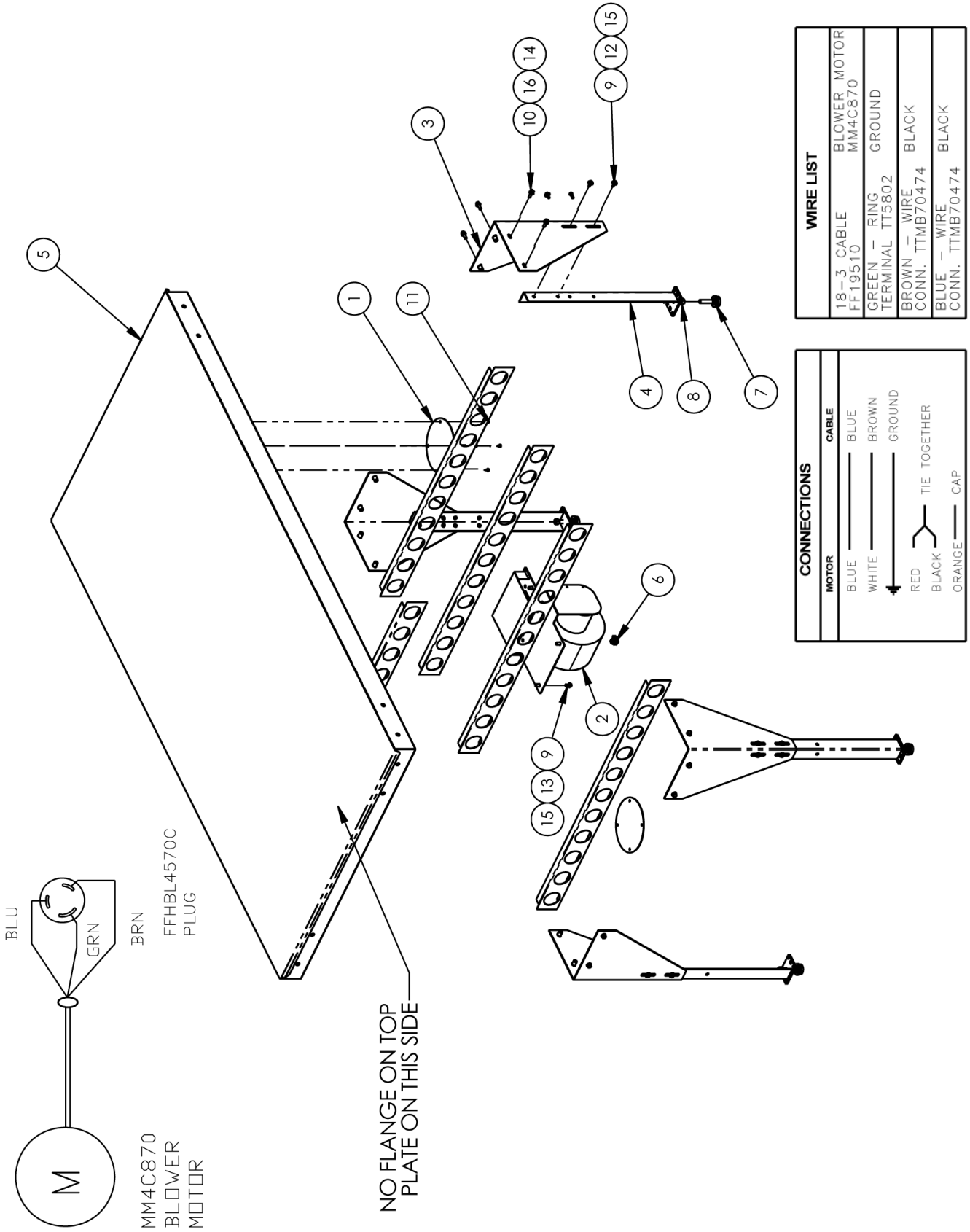


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4059-FP301D Foot Pedal Assembly

AAC Drawing Number 9000033 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	26058	ROD, STRAIGHT, 1018
2	1	4059030	BASE, FOOT PEDAL, 12X18
3	1	4059033	FOOT PEDAL WELDMENT
4	1	A3502-4	FOOT PEDAL, BRACKET
5	2	MM94807A029	PUSHNUT, ROUND, 1/4 DIA
6	1	4059-2-22A	EB-301 REMOTE ACTUATOR

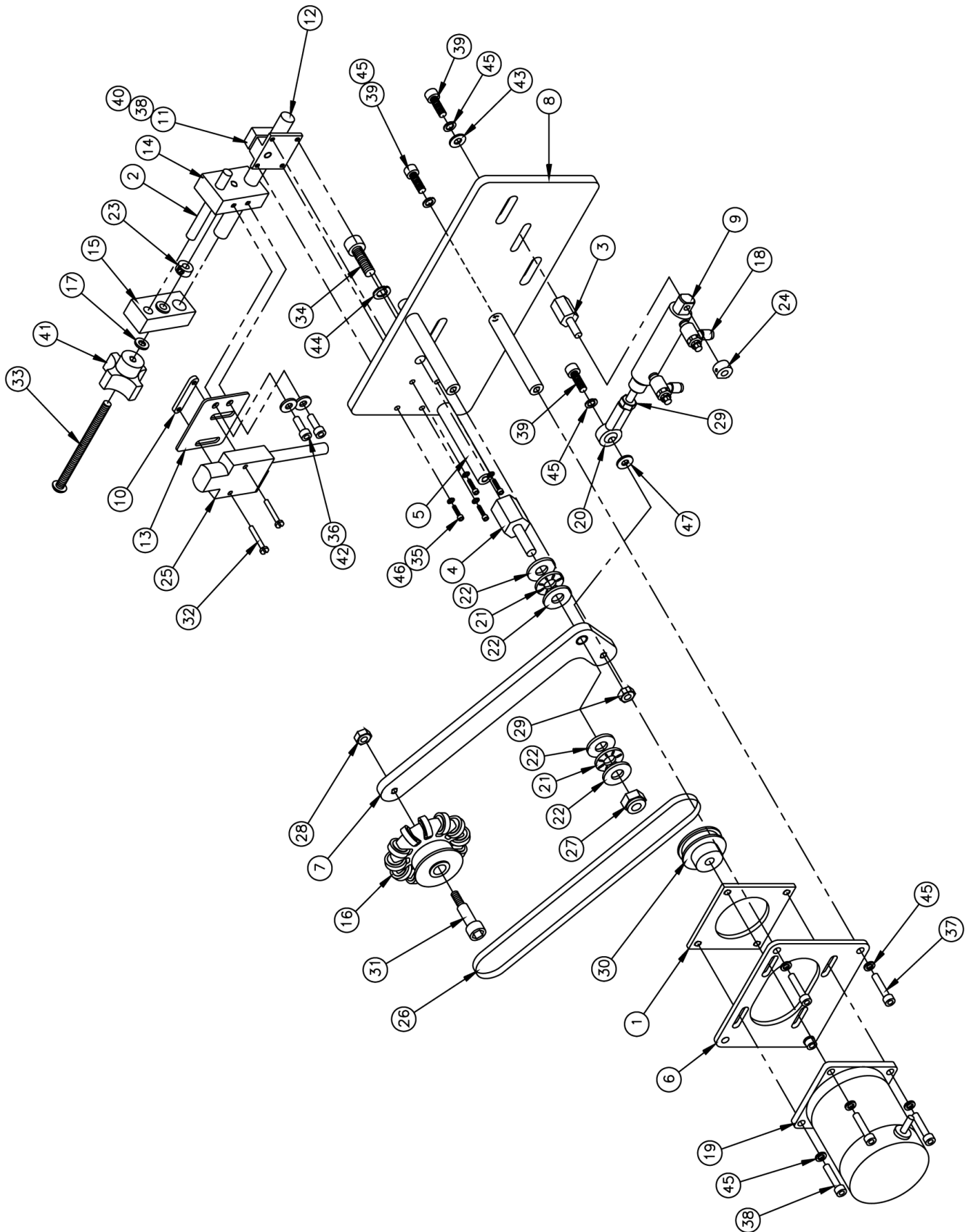


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1337A-160 Air Table Assembly

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

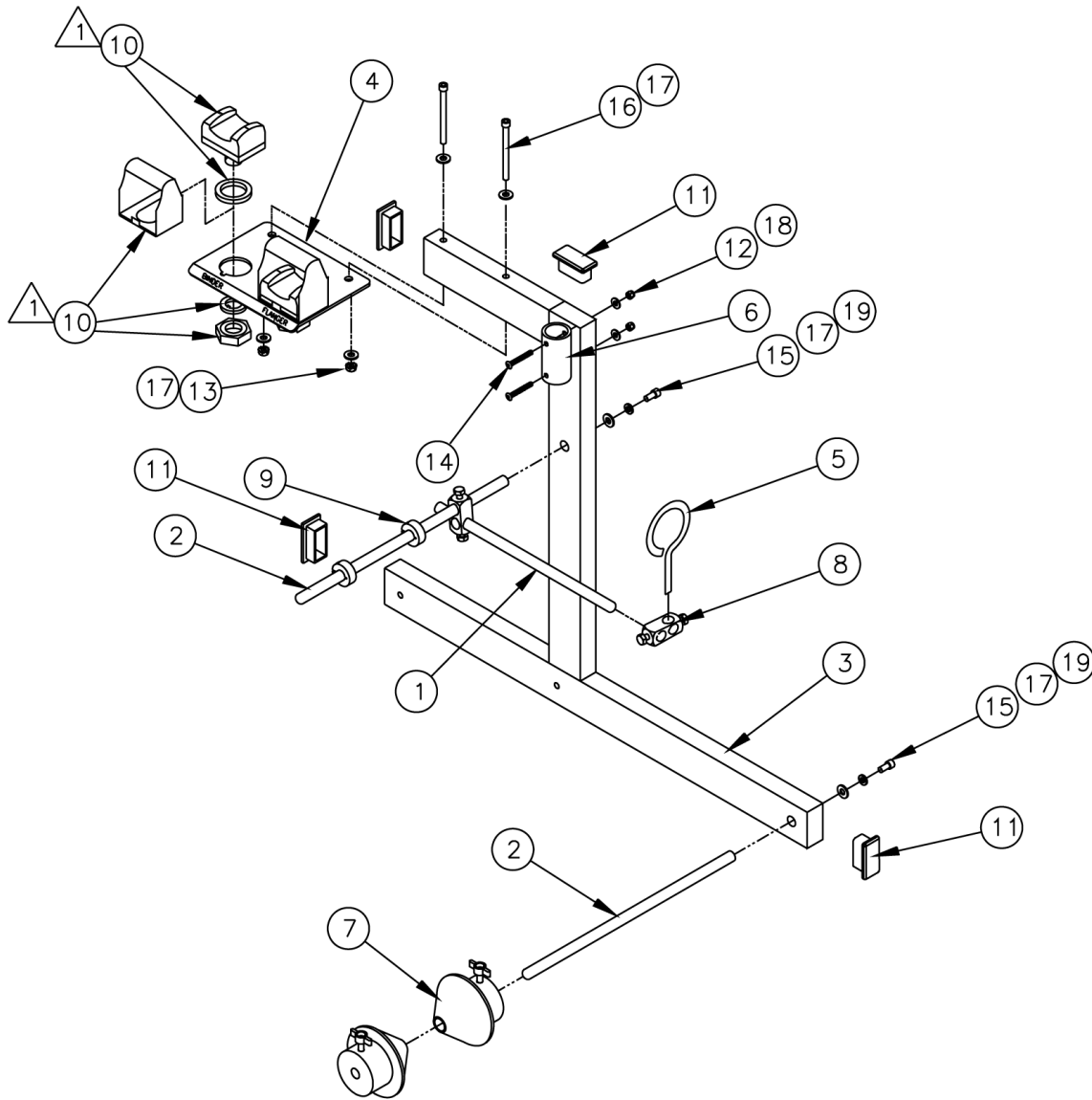


1338-2000 Edge Guide Assembly

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

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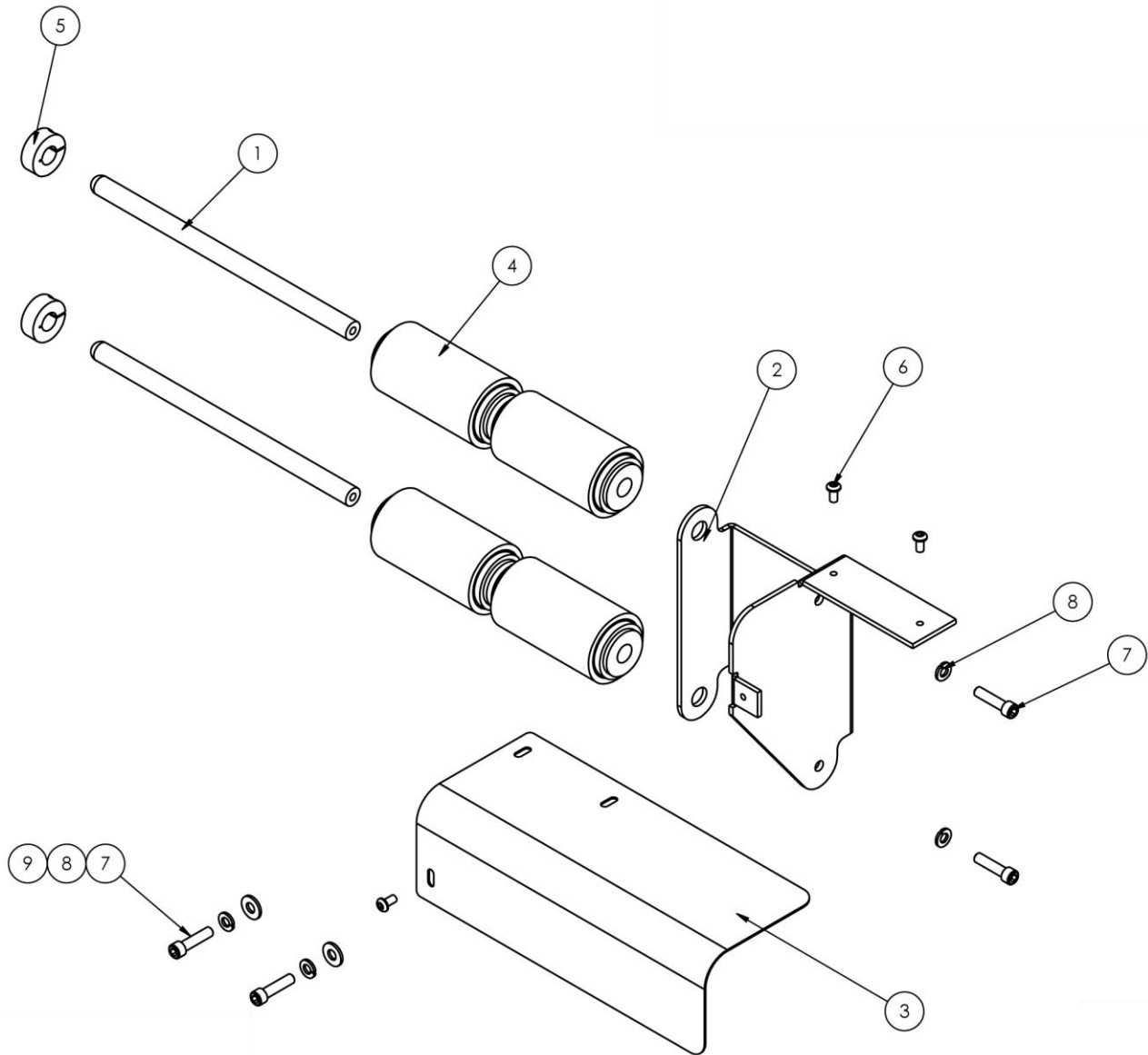


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1338-3000 Touch Switch Assembly

AAC Drawing Number 192043B Rev 0

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

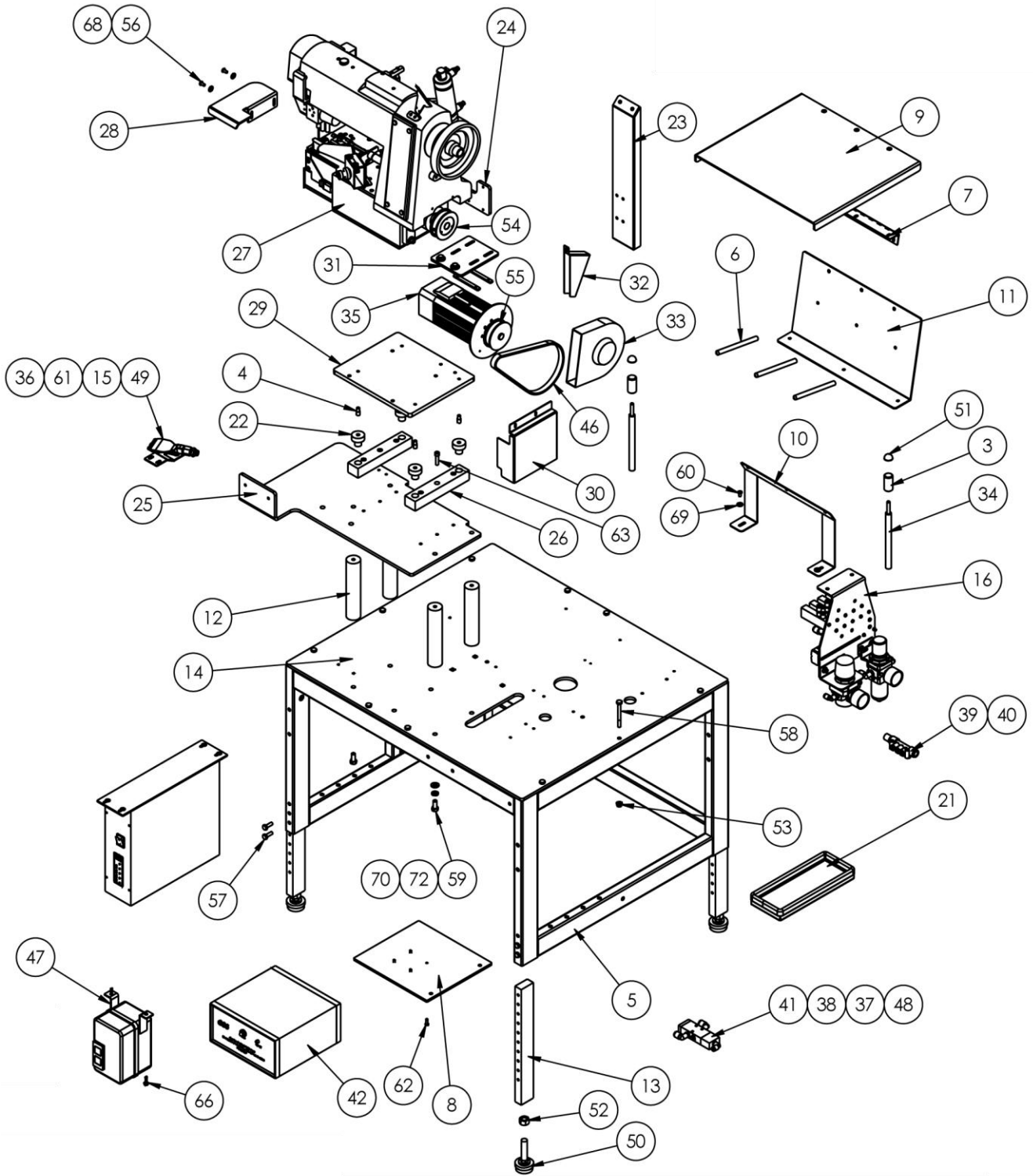


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1338041 Front Roller Assembly

AAC Drawing Number 1338041 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	2	1338-004	ROD,S/S,1/2X9.00
2	1	1338-005	PLATE,ROLLER MNTNG,FRONT
3	1	1338-030	COVER, MOTOR
4	4	33005671	ROLLER,1.90 OD, 1.59 ID
5	2	CCCL8F	CLAMP COLLAR- 1/2
6	3	SSBC98024	10-32 X 3/8 BUTTON CAP SC
7	4	SSSC01032	1/4-20X1/2 SOC CAP
8	4	WWL1/4	WASHER,LOCK,1/4
9	2	WWFS1/4	WASHER,FLAT,SAE,1/4



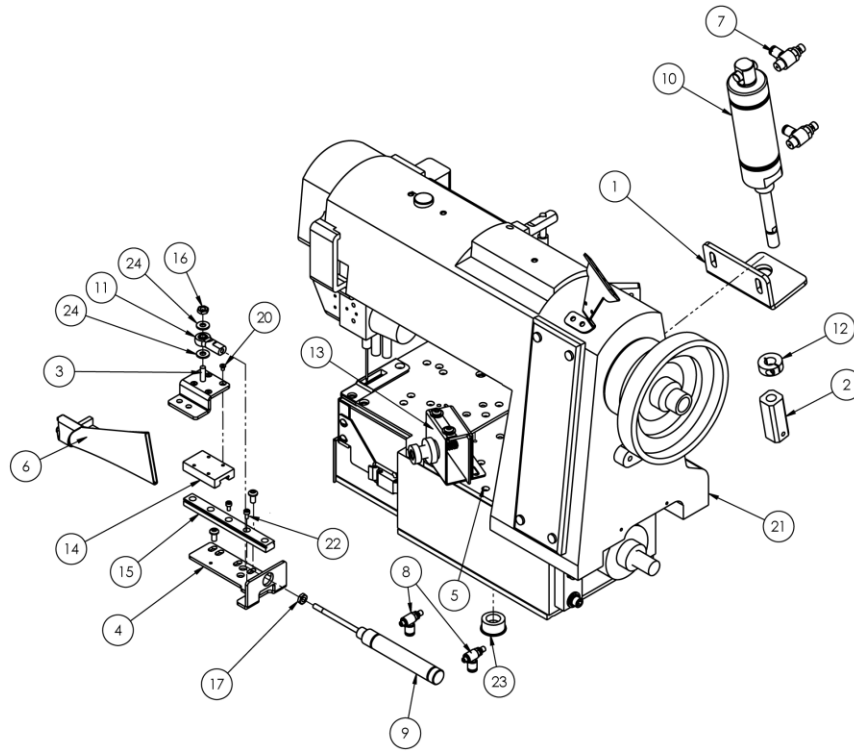
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1344016 Console Assembly

AAC Drawing Number 1344016 Rev 7

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	0211-209	PLATE,NUT,10-32@2.25 CTC	37	2	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8
2	1	0211-702C	CABLE,POS.SENSOR,3',EFKA	38	1	AAQME-5-8	QUICK MALE ELBOW
3	2	11200F	BUMPER,1/4-28 X1-1/2L	39	1	AAQMF-144	6-STATION AIR MANIFOLD
4	4	1335-408	STUD, THREADED, 1/4-20	40	1	AAQPP-11	PLUG, QUICK 3/8 TUBE
5	1	1337-4100B	FRAME WELDMENT, CONSOLE	41	1	AAV125B	PILOT VALVE
6	3	1337-4209	ROD, THREAD HOLDER	42	1	AP-28-640	CONTROL BOX,COMPLETE
7	1	1337-4217	PIANO HINGE 2W OPEN	43	10	FF19509	CABLE,3 COND,18 AWG,SJTOW
8	1	1338-009	PLATE, CONTROL BOX	44	20	FF19510	CABLE,3 COND,16 AWG,SJTOW
9	1	1338-011	COVER, THREAD	45	1	FFHBL4579C	RECEPTAL,2 POLE,3W,15A
10	1	1338-015	GUIDE, THREAD	46	1	GG225L050	BELT, 3/8P, 60T, 1/2W
11	1	1338-016	PLATE, THREAD STAND	47	1	K-CB600	MOTOR STARTER,ELEC
12	4	1338-018	SPACER, HEAD	48	1	MM4554K11	PLUG, 1/8" PIPE
13	4	1338-019	LEG,3/4X1-1/2X12.25L	49	1	MM5329K21	AIR NOZZLE
14	1	1338-021	TOP PLATE	50	4	MMFB4444	FOOT, RUBBER
15	1	1338-029	BRKT, AIR NOZZLE, MNT	51	2	MMSJ5017	BUMPER,3M SJ5017
16	1	1338-1500	PNEUMATIC PANEL ASSY 1338	52	4	NNH1/2-13	1/2-13 HEX NUT
17	1	1338-4000	ELECTRICAL COMPONENTS	53	10	NNK1/4-20	NUT,HEX,KEP,1/4-20,W/LOCK
18	1	1344S88-PD	DIAGRAM, PNEUMATIC	54	1	PP20LB050M2	PULLEY,GEAR,3/8P,.63B,20T
19	1	1344S88-WD	DIAGRAM, WIRING	55	1	PP20LB050M3	PULLEY,GEAR,3/8P,20T,14MM
20	1	1975-412A	PLATE,NUT,4-40,.95CTC	56	2	SSBC98024	10-32 X 3/8 BUTTON CAP SC
21	1	26151	TOOL TRAY, 1X3.5X9	57	10	SSHCO1048	1/4-20 X 3/4 HEX CAP
22	4	228444	MACHINE CUSHION	58	10	SSHCO1160	1/4-20 X 2-1/2 HHCS
23	1	1315574	GUIDE, THREAD	59	4	SSHCO10048	5/16-18 X 3/4 HHCS
24	1	1315585	BRKT, MOUNT, THREAD GUIDE	60	2	SSPP98024	10-32 X 3/8 PAN HD PHILIP
25	1	1338044	PLATE, MACHINE MOUNT	61	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
26	2	1338045	MOUNT, IOSLATOR,300UX5	62	4	SSPS90032	#8-32 X 1/2 LG PAN HD
27	1	1338046	ASSY, SEW HEAD	63	6	SSSC01064	1/4-20 X 1 SOC CAP
28	1	1338047	PLATE, CLOTH SUPPORT	64	2	SSSC90080	#8-32 X 1-1/4 SOC CAP SC
29	1	1338112	PLATE,ADAPTER,1338	65	4	SSZS93032	SCREW, SHT.METAL 10 ZIP
30	1	1338116	COVER,BELT,1344SS88UK	66	2	SSZS93048	SCREW, SHT.METAL 10 ZIP
31	1	1344023	BRKT, MOTOR MOUNT	67	2	WWF1/4	WASHER, FLAT, 1/4", COM
32	1	1344024	COVER,BELT,1344S88UK	68	2	WWF10	WASHER, FLAT, #10, COM
33	1	1344026	Cover, DC1500	69	2	WWFS10	WASHER, FLAT, #10, SAE
34	2	31101017	SUPPORT ROD	70	4	WWFS5/16	WASHER,FLAT,SAE,5/16
35	1	4059-DC50	MOTOR, LOW SPD, HIGH TORQ	71	2	WWL1/4	WASHER,LOCK,1/4
36	1	AAQBC-4-4	BULKHEAD CONN,1/4QUIC	72	4	WWL5/16	WASHER, LOCK, 5/16

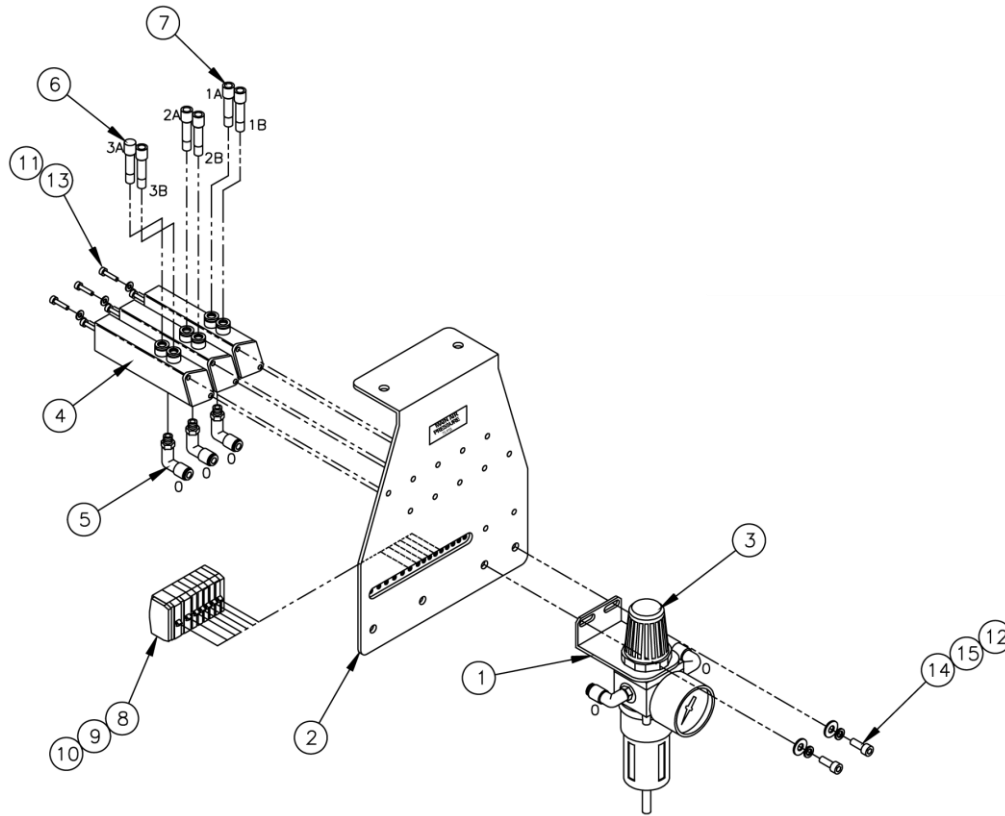
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1338046 Sewing Head Assembly

AAC Drawing Number 1338046 Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1	1315507	BRACKET, CYLINDER
2	1	1317307	CYLINDER END, FOOT LIFT
3	1	1344025	BRKT, GUIDE MOUNT
4	1	1344028	BRKT, CYLINDER MOUNT
5	1	1345230	PLATE, BED, RIGHT
6	AR	199-EC-13C	H/D MATTRESS BINDER W/CRD
7	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"
8	2	AA198RA510	FLOW CONTROL,5/32X10-32
9	1	AAC022DXPM	CYL,MOD, DA, 9/16B, 2S,
10	1	AAC5DP-2	AIR CYLINDER, SMC
11	1	BBAW-3Z	BRG,ROD END,F, 10-32
12	1	CCSCL7F	CLAMP COLLAR- 7/16
13	1	F221-T008	TENSIONER BOX ASSY,2" MAX
14	1	MMGN12HZOHN	LINEAR WAY
15	1	MMGNR12R0115HN	RAIL, LINEAR 12MM X 115MM
16	1	NNH10-32	HEX-NUT 10-32 REG.
17	1	NNJ10-32	NUT,JAM,THIN #10-32
18	2	SSBC98024	10-32 X 3/8 BUTTON CAP SC
19	6	SSFC01040	1/4-20 X 5/8 FLAT ALN CAP
20	4	SSFCM3X5	M3-0.50X5, SCEW FLAT ALL
21	1	SSIN-300UX6	SEWING HEAD, 300UX6
22	2	SSSCM3x6	M3-0.5X__SCREW,SOCKET CAP
23	1	TA2351004-R0	RUBBER PLUG
24	2	WWFS10	WASHER, FLAT, #10, SAE

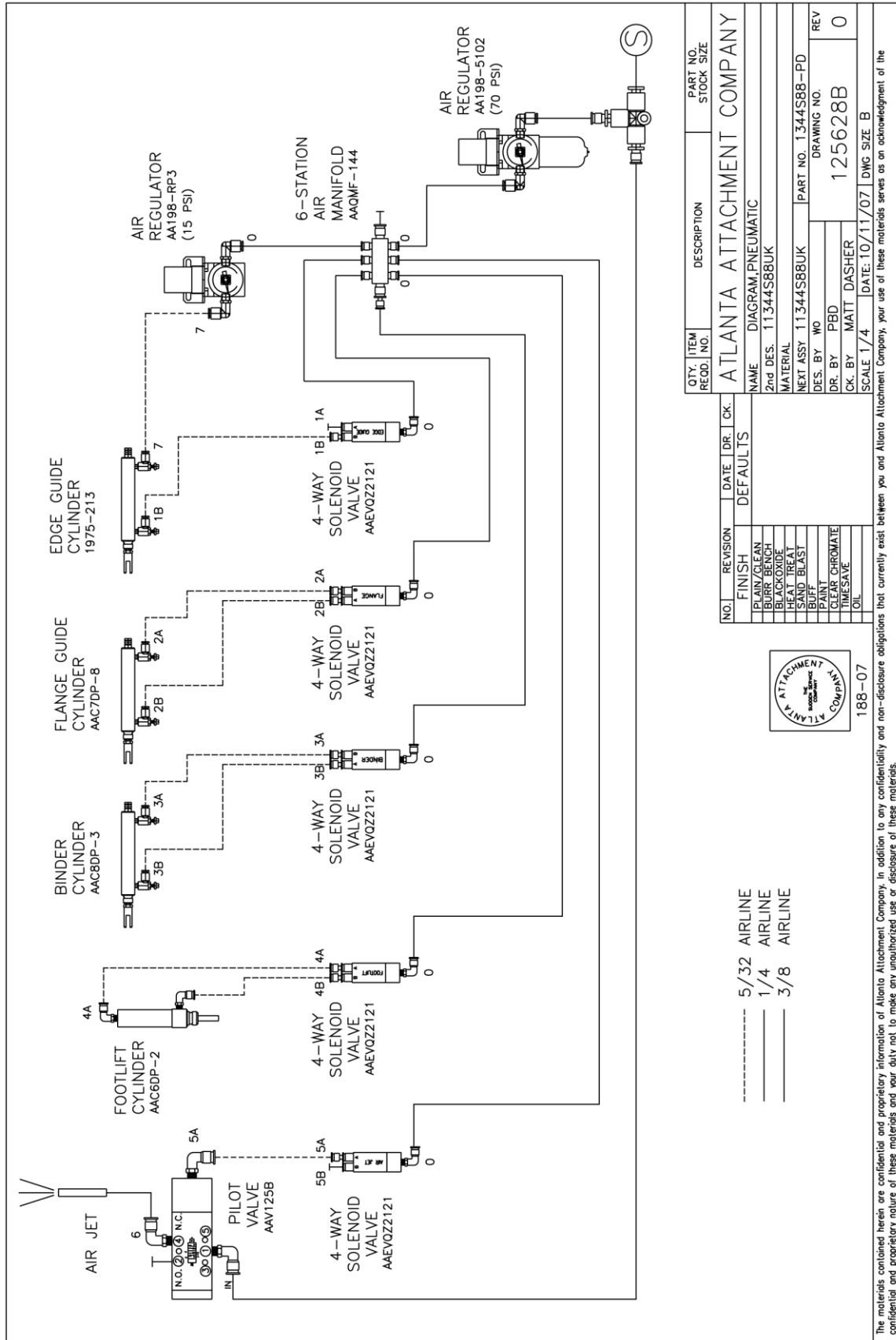


1339-1500 Pneumatic Panel Assembly

AAC Drawing Number 192944B Rev 0

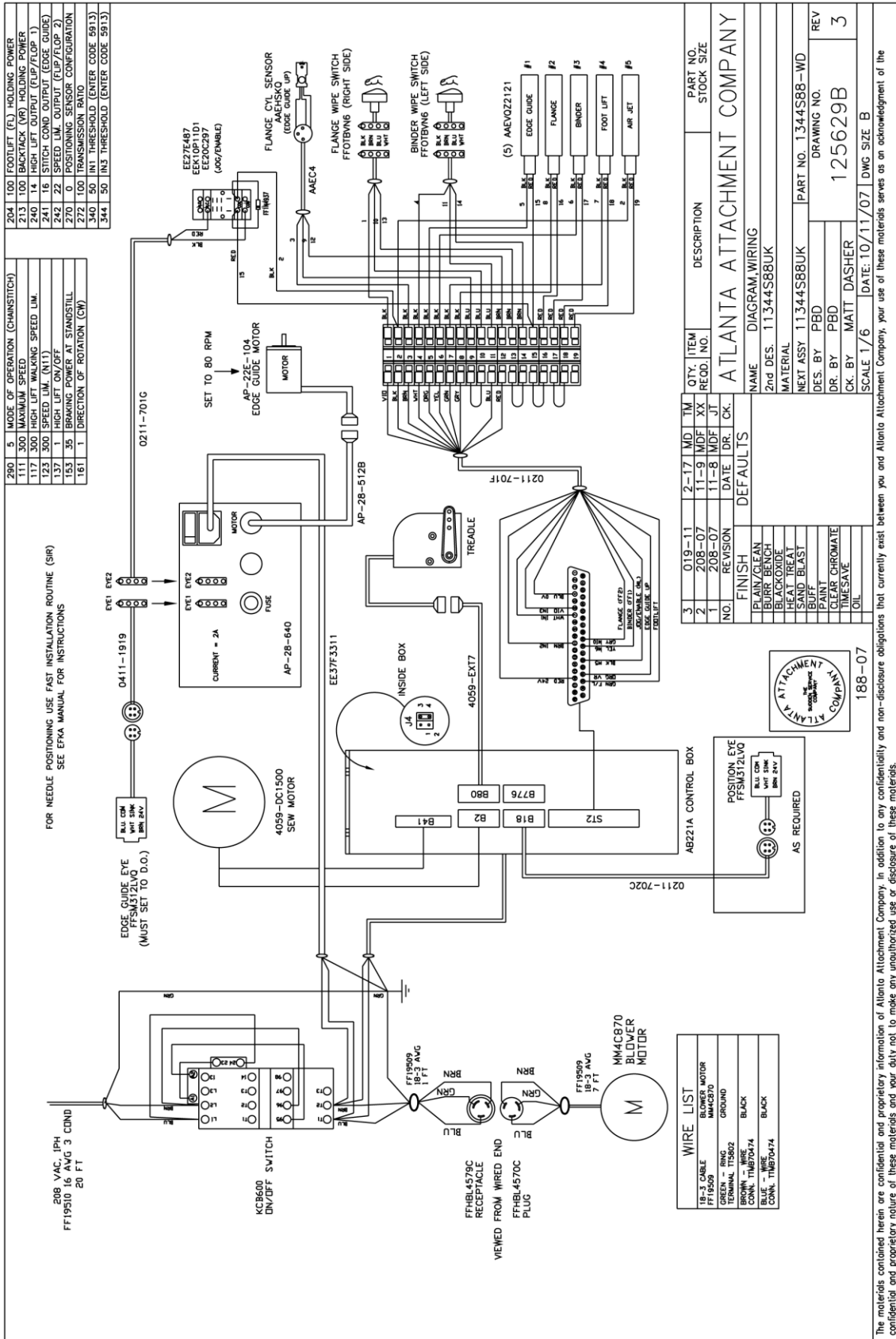
NO.	QTY	PART #	DESCRIPTION
1	1	0411-071	REGULATOR BRKT
2	1	1338-024	PANEL
3	1	AA198-5102	REGULATOR
4	3	AAEVQZ2121	VALVE
5	3	AAQME-4-8	QUICK MALE ELBOW
6	1	AAQPP-07	QUICK PLUG
7	5	AAQPR-5-4	QUICK REDUCER
8	5	FF264-311	WAGO, SINGLE
9	2	FF264-341	WAGO, DUAL
10	1	FF264-371	WAGO, END
11	6	SSSC70024	SCREW, SOCKET CAP
12	2	SSSC98032	SCREW, SOCKET CAP
13	6	WWF4	FLAT WASHER
14	2	WWFS10	FLAT WASHER
15	2	WWL10	LOCK WASHER

1344S88-PD Pneumatic Diagram



----- 5/32 AIRLINE
 _____ 1/4 AIRLINE
 _____ 3/8 AIRLINE

1344S88-WD Wiring Diagram



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Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

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

Términos y Condiciones:

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

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

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



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