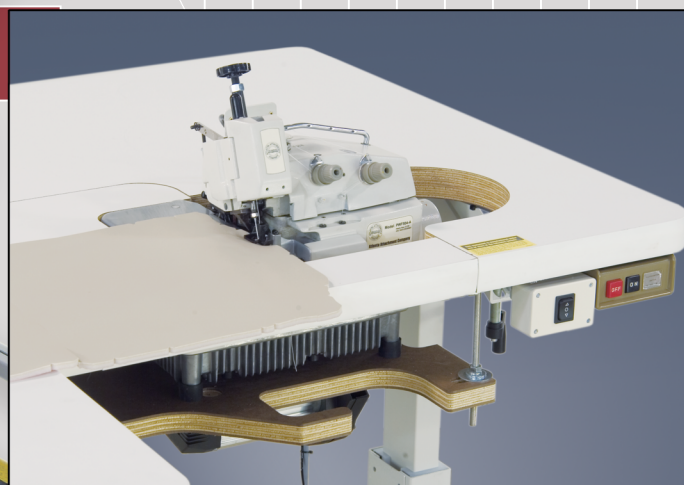


# model: 1381

Top Feed, Walking Foot, Overlock Workstation

Automated Manufacturing Equipment For The Sleep Products Industry

## Parts Lists For 1381-504A



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Revision 0  
Created: May 26, 2004

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# **Atlanta Attachment Company, Inc.**

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**Parts orders may be placed by:**

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**Fax: 770-963-7641**

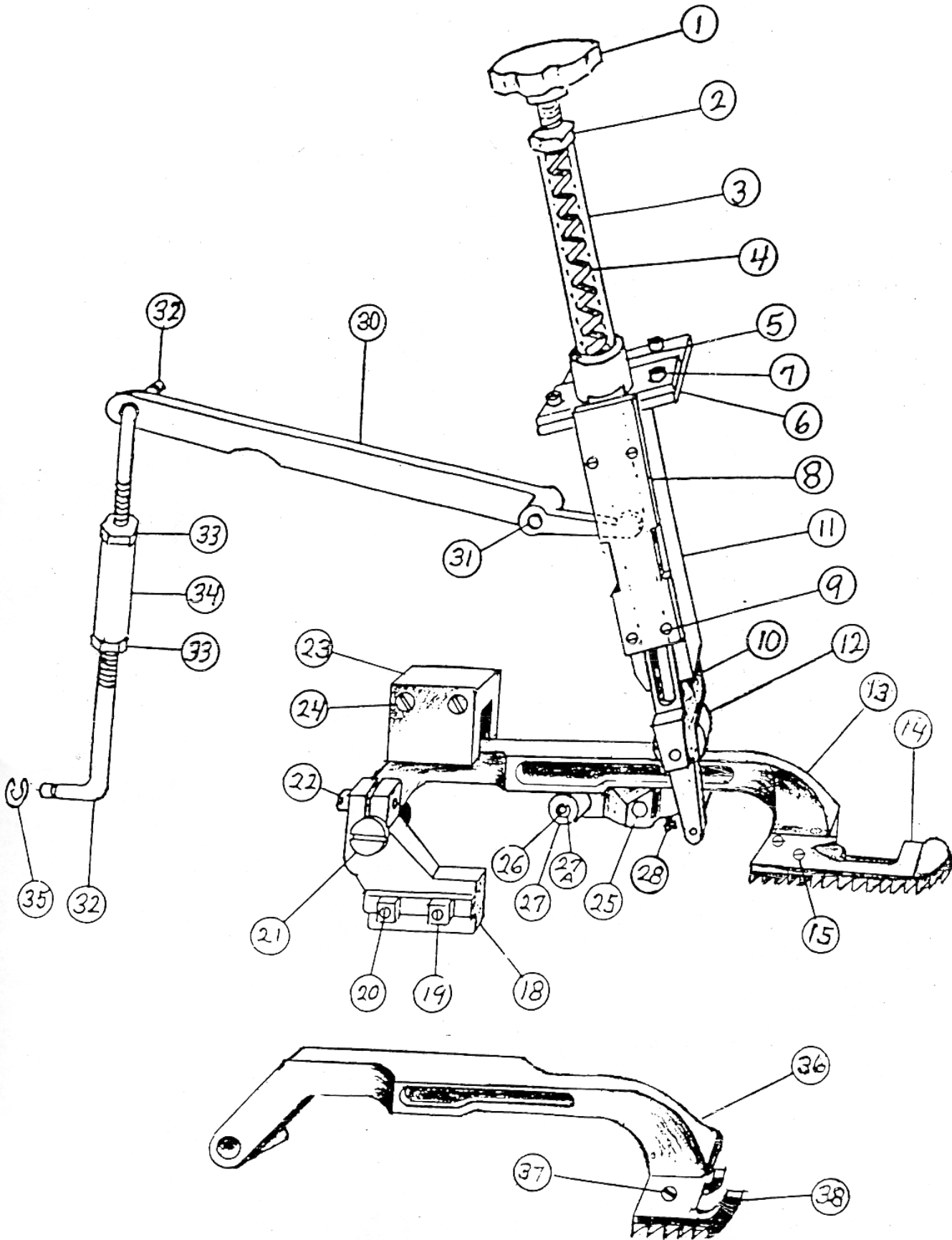
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We pledge to maintain inventories of the recommended spare parts for our automated workstations and to ship those replacement parts within 72 hours. If the replacement parts are not shipped within 72 hours they will be FREE! Contact Sales for the recommended spare parts list and the model workstations covered.





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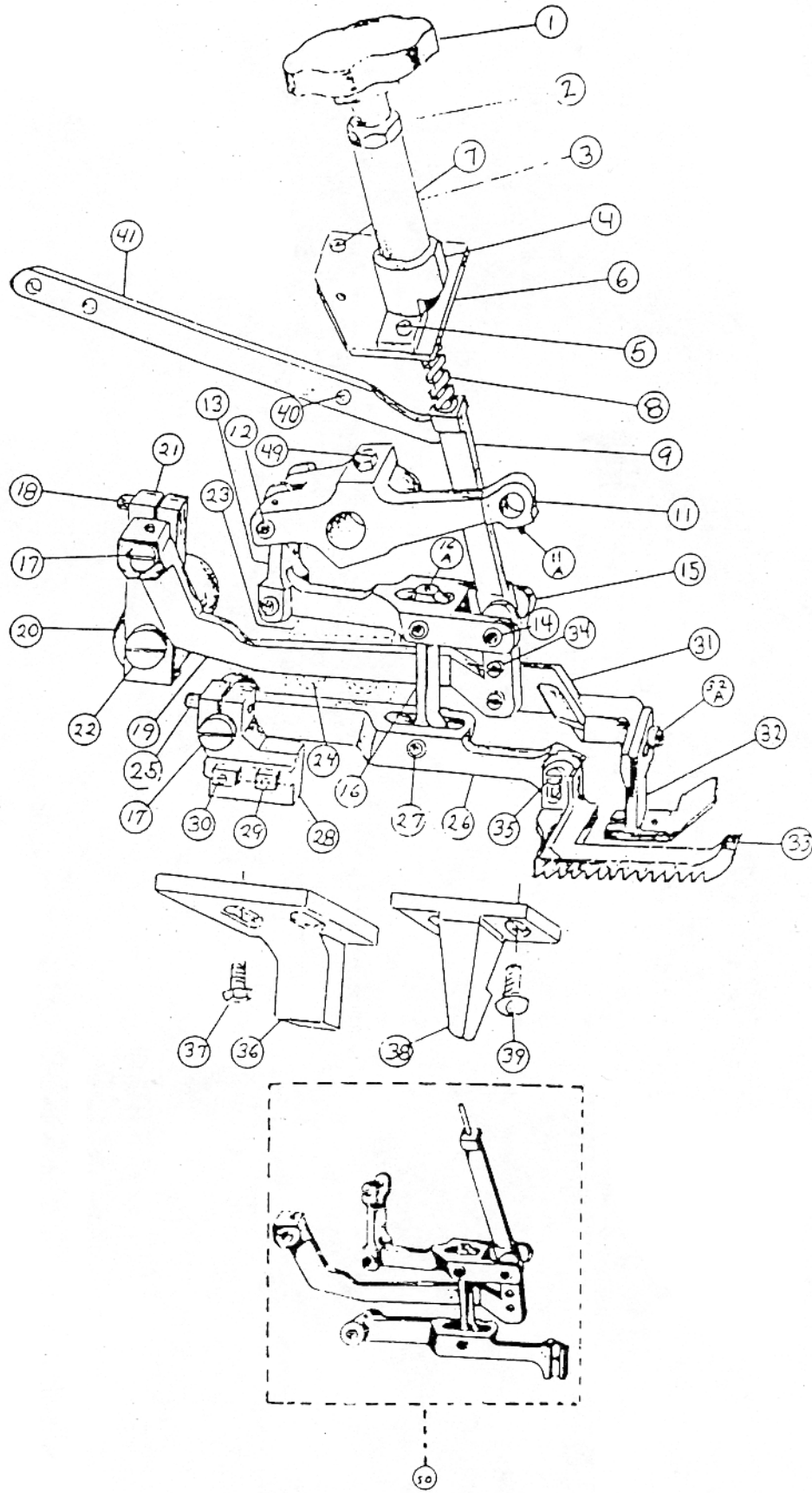


## Top Feed Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1185	Thumbscrew	1		20	619820	Screw	2	
2	1186	Nut	1		21	1271	Eccentric Stud	1	
3	1442	Spring Guide Sleeve	1		22	SHCS4-40X.375	Screw	1	
4	1184	Pressure Spring	1		23	1146	Guide Block	1	
5	1440	Flange	1		24	FHS	Screw	2	
5A	SHCS8-32X.500	Screw	2		25	1370	Lifter Assy	1	
6	1143	Flange Base	1		26	1206	Lifter Pin	1	
7	SHCS8-32X.250	Screw	2		27	1247	Lifter Roller	1	
8	1142	Pressure Bar Cover	1		27A	5560-18	Retainer	1	
9	610940	Screw	4		28	SCS6X32X7/8	Screw	1	
10	1256	Pressure Arm Assy	1		30	1166	Aux. Lifter Arm	1	
11	1140	Pressure Bar Guide Block	1		31	DP3/16X.874	Aux. Lifter Arm Pin	1	
12	1187	Pressure Roller	1		32	1214	Connector	2	
12A	5133-12	Retainer	1		33	HN8-32	Nut	2	
13	1233	Top Feed Arm	1		34	2219	Keystone Connector	1	
14	1234	Top Feed Foot	1		35	5133-15	Retainer	2	
15	FHS9/64X36	Screw	2		36	1212	Top Feed Arm	1	
18	1201	Top Feed Holder	1		37	FHS9/64X36	Screw	1	
19	1209	Top Feed Holder Nuts	2		38	1179	Ski	1	

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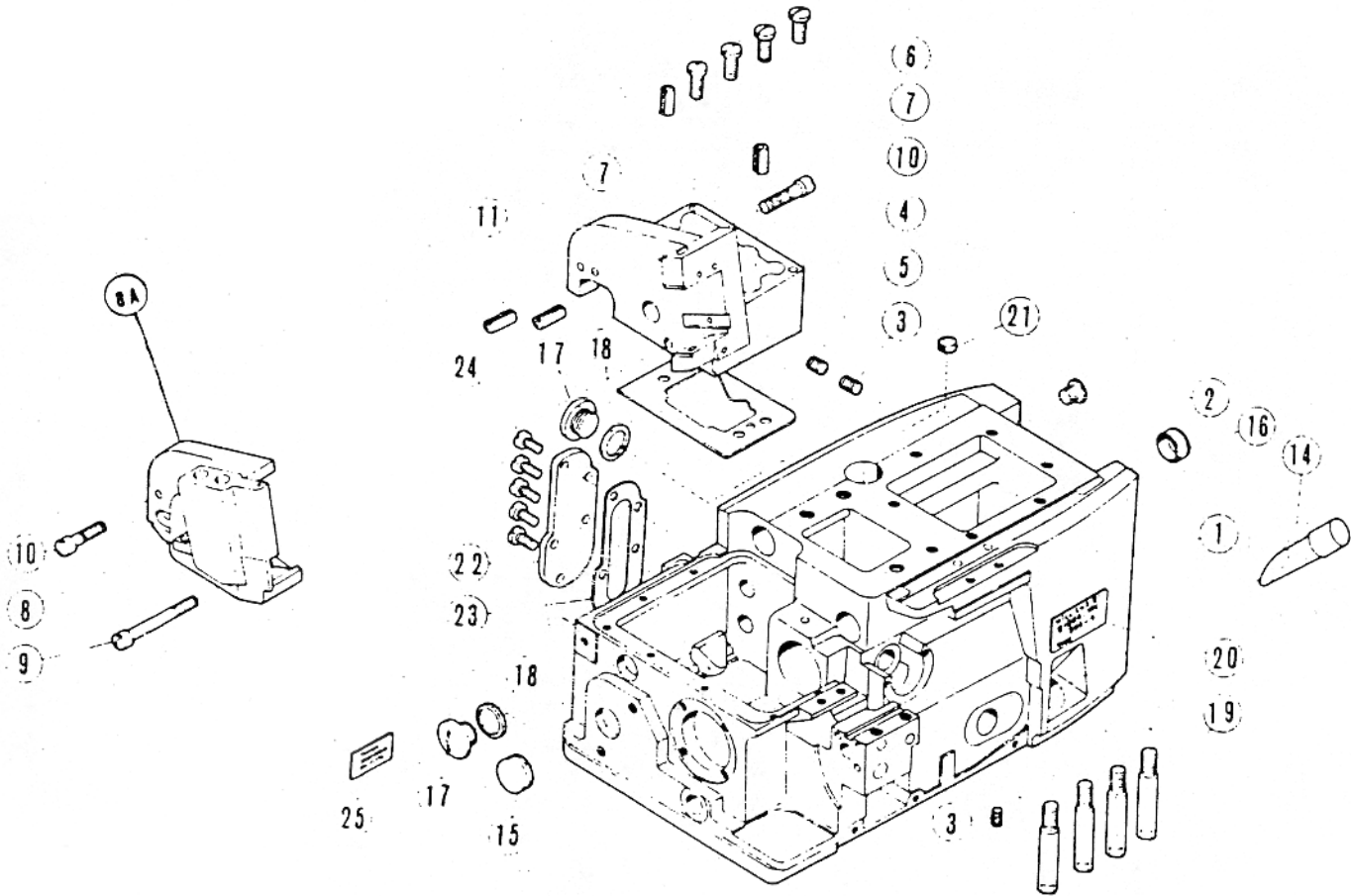


## Walking Foot Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1185	Thumbscrew	1		22	PHMS1/4-28X.750	Screw	1	
2	1186	Thumbscrew Nut	1		23	1712	Inside Rubbing Block	1	
3	1730	Pressure Spring Sleeve	1		24	SHCS8-32X.500	Screw	2	
4	1737	Pressure Spring Base	1		25	SHCS4-40X.375	Clamp Screw	1	
5	SHCS8-32X.125	Flange Screw	1		26	1708	Top Feed Main Beam	1	
6	1728	Pressure Spring Mount Block	1		27	1718	Pivot Pin (Short)	2	
7	SHCS8-32X.500	Screw	3		28	4841-1	Top Feed Holder	1	
8	1184	Pressure Spring	1		30	SHCS8-34X3/4	Top Feed Holder Screw	2	
9	1729	Presser Bar	1		31	1903	Presser Foot Extension	1	
11	1738	Needle Drive Arm	1		32	1887	Presser Foot	1	
11A	619400	Screw	1		32A	SHCS5-40X.250	Screw	1	
12	1719	Pivot Pin Conn. Link	1		33	1722	Walking Top Feed Foot	1	
13	1706	Link Beam Connector	1		34	SHCS5-40X.250	Screw	2	
14	1720	Pivot Pin (Long)	2		35	618420	Walking Foot Set Screw	1	
15	4513	Walking Foot Beam	1		36		Retaining Block Rear	1	
16	1912	Link Top Feed Connector	1		37	HB10-32X.500	Screw	2	
16A	HLSS4-40X.078	Screw	7		38		Retaining Block Front	1	
17	1271	Eccentric Stud	2		39	BHS10-32X.375	Screw	2	
18	SHCS6-32X.500	Clamp Screw	1		40	DP3/16X.750	Aux. Lifter Arm Dowel Pin	1	
19	1709	Presser Foot Beam	1		41	2368	Aux. Lifter Arm	1	
20	1724	Locating Stud	1		49	611620	Screw	1	
21	1725	Locating Bar	1		50	10001	Linkage Assy	1	

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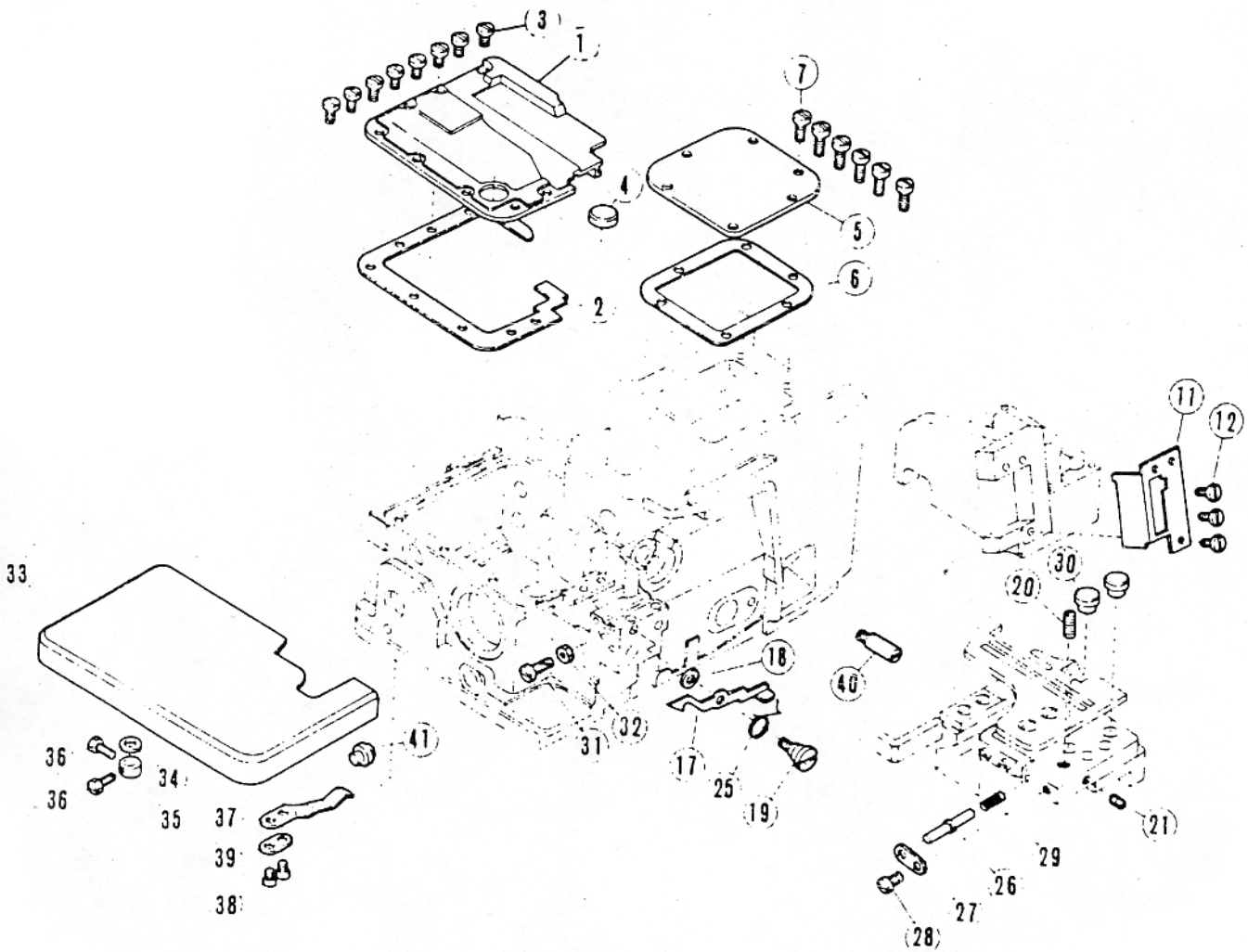


## Machine Bed Frame

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	617115	Machine Bed Frame	1		13	615210	Gasket	1	
2	619540	Oil Hole Plug Screw	1		14	612000	Oil Sight Gauge	1	
3	611618	Oil Hole Plug Screw	3		15	615220	Dead Hole Plug	1	
4	617140	Machine Arm (Right)	1		16	614330	Dead Hole Plug	1	
5	613580	Gasket	1		17	619040	Dead Hole Plug Screw	2	
6	618500	Screw	1		18	611000	Dead Hole Plug Screw	2	
7	610980	Dowel Pin	2		19	612020	Machine Bed Bottom Pin	4	
8	1935	Machine Arm (Left)	1		21	614280	Machine Bed Oil Filter	1	
8A	1734	PWF504-A Only	1		22	617380	Machine Bed Cover Plate	1	
9	619240	Screw	1		23	615755	Gasket	1	
10	619000	Screw	2		24	618740	Screw	5	
11	610980	Dowel Pin	2		25	616905	Manufacturer's Name Plate	1	
12	616650	Oil Shield	1						

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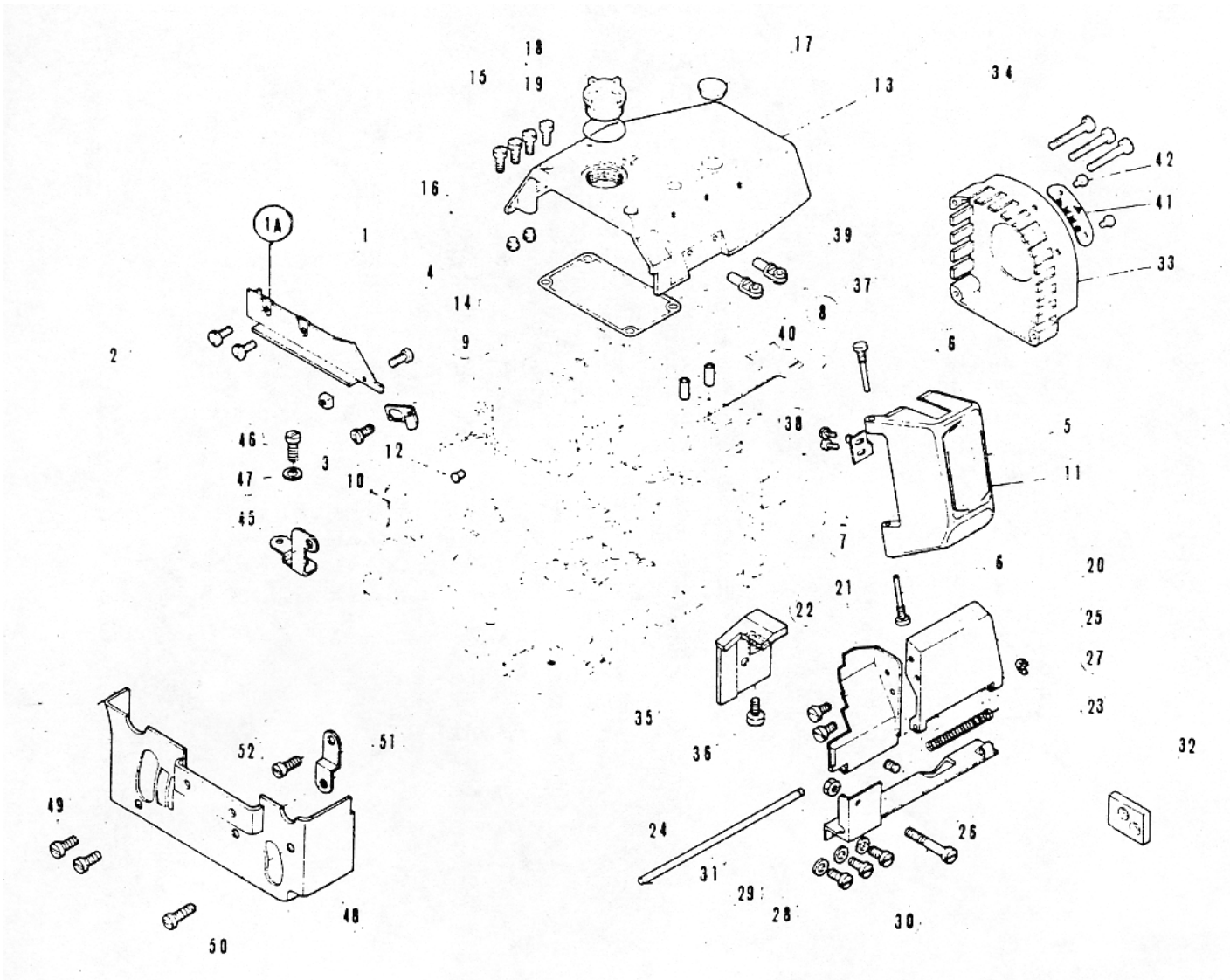


Miscellaneous Covers

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	615965	Bed Plate	1		27	614077	Push Pin Guide	1	
2	616540	Gasket	1		28	618420	Push Pin Guide Screw	1	
3	618340	Screw	8		29	614078	Push Pin Spring	1	
4	614340	Cloth Plate Cushion	1		30	614079	Rubber Plug	2	
5	616100	Bed Cover Plate (Right)	1		31	619800	Stop Screw	1	
6	616120	Gasket	1		32	618280	Stop Screw Nut	1	
7	618740	Screw	6		33	617165	Cloth Plate	1	
11	616640	Face Plate	1		34	611760	Hinge Stud Thrust Washer	1	
12	618340	Screw	3		35	611260	Hinge Stud Thrust Collar	1	
17	614065	Latch	1		36	618600	Hinge Stud Thrust Collar Screw	2	
18	612705	Latch Spacer	1		37	613520	Lock Spring	1	
19	619665	Latch Screw	1		38	610200	Lock Spring Screw	2	
20	1435	Latch Adjust Screw	1		39	610900	Lock Spring Screw Washer	1	
21	1459	Latch Adjust Lock Screw	1		40	619180	Lock Spring Pin	1	
25	614070	Spring	1		41	616820	Rubber Plug	1	
26	614075	Push Pin	1						

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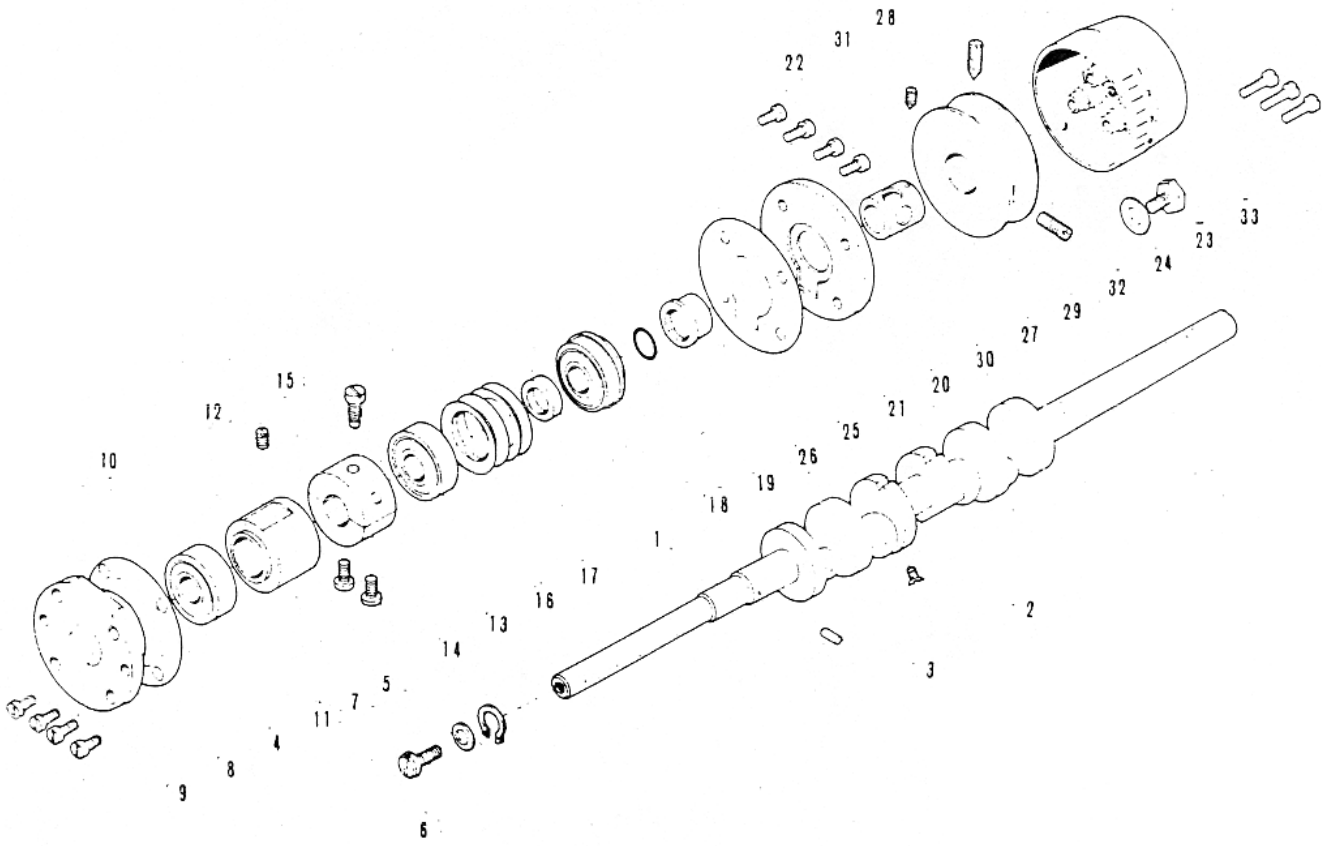


## Miscellaneous Covers (2)

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1A	1795	Cloth Plate Fabric Guard	1		26	618920	Hinge Screw	1	
2	618340	Screw	2		27	614920	Hinge Spring	1	
3	614010	Spacer	1		28	610200	Hinge Screw	3	
4	618220	Spacer Screw	1		29	610400	Hinge Screw Washer	3	
5	614940	Needle Bar Screw	1		30	618660	Hinge Screw	1	
6	611820	Hinge Pin	2		31	618800	Hinge Screw Nut	1	
7	611860	Lock Spring	1		32	613910	Spacer	1	
8	610220	Lock Spring Screw	2		33	613960	Oil Cooler Cover	1	
9	613530	Lock Spring Latch	1		34	618660	Screw	3	
10	618340	Lock Spring Latch Screw	1		35	617145	Right Looper Lever Oil Shield	1	
11	613785	Name Plate	1		36	618940	Screw	1	
12	610650	Cushion Rubber	1		37	611060	Right Looper Thread Eyelet	1	
13	615860	Top Cover	1		38	611140	Right Looper Thread Tube	1	
14	616800	Gasket	1		39	611060	Left Looper Thread Eyelet	1	
15	618980	Screw	4		40	611140	Left Looper Thread Tube	1	
16	616820	Cushion	2		41	613940	Stitch Indicator	1	
17	616060	Plug	1		42	614200	Rivet	2	
18	614820	Oil Splash Sight Window	1		45	614440	Spacer	1	
19	614840	O-Ring	1		46	618120	Spacer Screw	1	
20	614860	Front Cover (Right)	1		47	611640	Spacer Screw Washer	1	
21	614870	Front Cover (Left)	1		48	614420	Machine Cover (Left)	1	
22	610140	Screw	2		49	618640	Screw	2	
23	614880	Hinge	1		50	619060	Screw	1	
24	614900	Hinge Pin	1		51	614430	Spacer	1	
25	610920	Hinge Pin Retaining Ring	1		52	618720	Spacer Screw	1	

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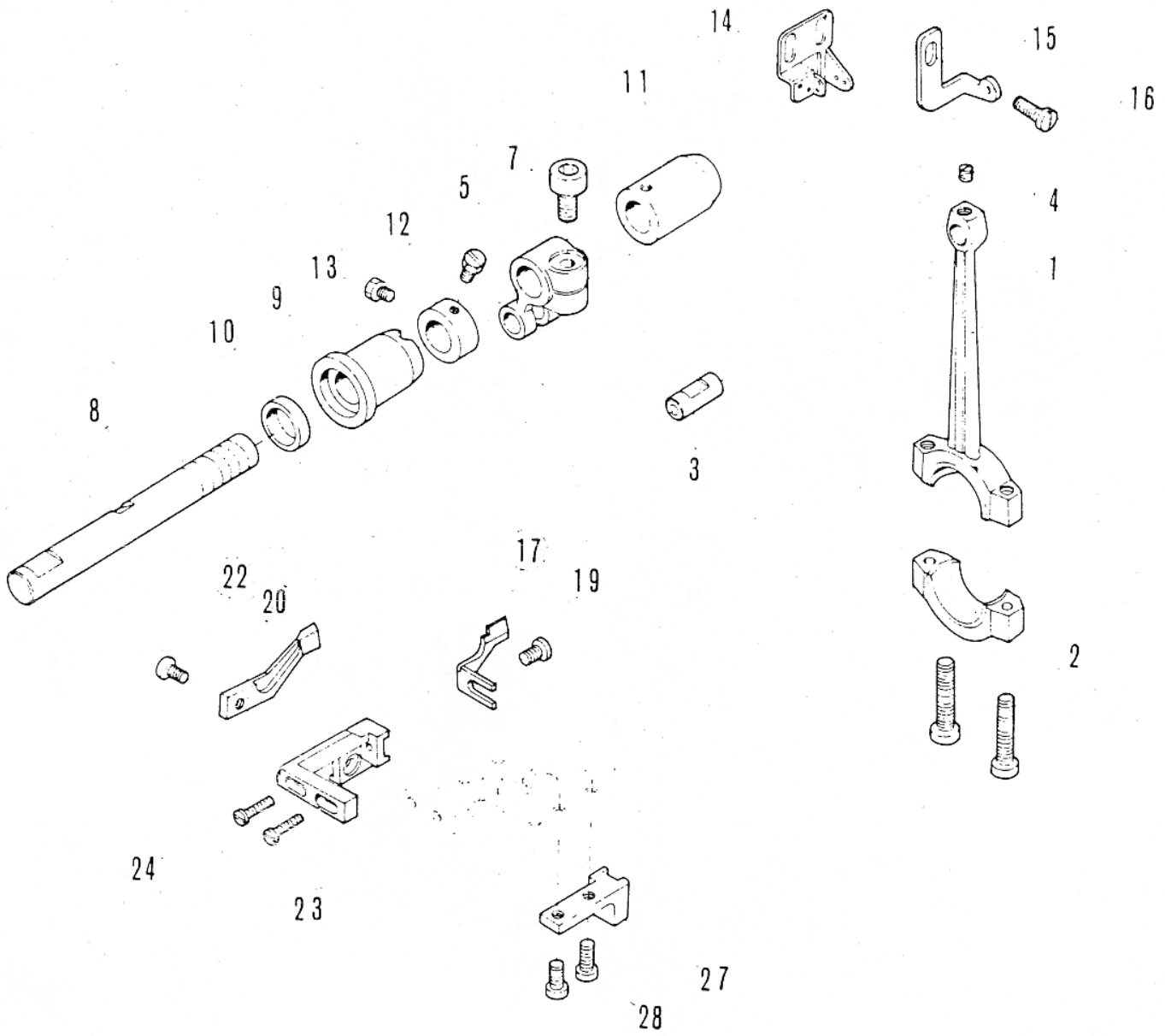


## Crankshaft Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	616140	Crankshaft	1		18	612120	Spacer	1	
2	619440	Oil Plug Screw	1		19	612140	Ball Bearing (Right)	1	
3	611580	Oil Felt	1		20	612160	Bearing Plate	1	
4	612040	Ball Bearing (Left)	1		21	612180	Bearing Plate Gasket	1	
5	614050	Ball Bearing Retaining Ring	1		22	618740	Bearing Plate Screw	4	
6	619660	Ball Bearing Screw	1		23	619260	Bearing Screw	1	
7	613840	Ball Bearing Screw Washer	1		24	612200	Bearing Screw Washer	1	
8	614055	Ball Bearing Housing	1		25	615520	Oil Seal Collar	1	
9	618780	Housing Screw	4		26	615540	Oil Seal Collar "O" Right	1	
10	613680	Housing Gasket	1		27	612300	Pulley	1	
11	612060	Bushing	1		28	618520	Position Screw	1	
12	611680	Bushing Screw	1		29	618540	Screw	1	
13	612080	Center Bushing	1		30	612240	Collar	1	
14	610080	Bushing Screw	2		31	619340	Collar Screw	1	
15	619300	Bushing Screw	1		32	616020	Cap	1	
16	611480	Ball Bearing (Center)	1		33	618360	Cap Screw	3	
17	612100	Washer	4						

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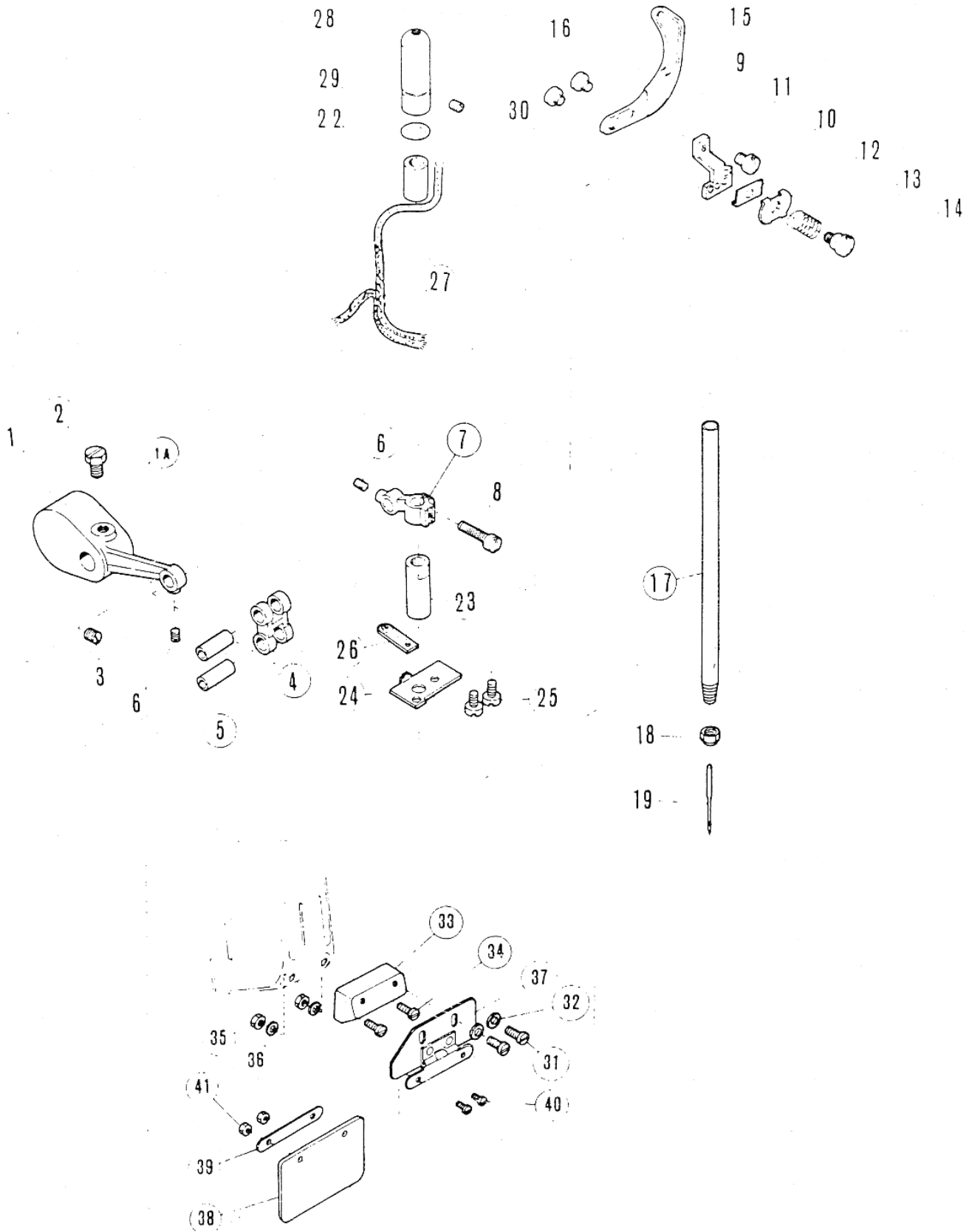


## Needle Drive Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	612260	Needle Bar Drive Connection	1		14	611885	Needle Thread Guide	1	
2	619100	Cap Screw	2		15	616222	Needle Thread Guide	1	
3	614760	Pin	1		16	618340	Screw	1	
4	619220	Pin Screw	1		17	613925	Front Needle Guard	1	
5	611440	Needle Bar Drive Crank	1		19	1206PEG	Screw	1	
7	619700	Clamp Screw	1		20	613926	Rear Needle Guard	1	
8	616600	Needle Bar Drive Shaft	1		22	1206PEG	Screw	1	
9	616610	Left Bushing	1		23	613927	Needle Guard Brkt	1	
10	616620	Left Bushing Oil Seal	1		24	610120	Screw	2	
11	615440	Right Bushing	1		27	614185	Edge Guide Holder Brkt Base	1	
12	611220	Thrust Collar	1		28	610100	Screw	2	
13	618600	Thrust Collar Screw	2						

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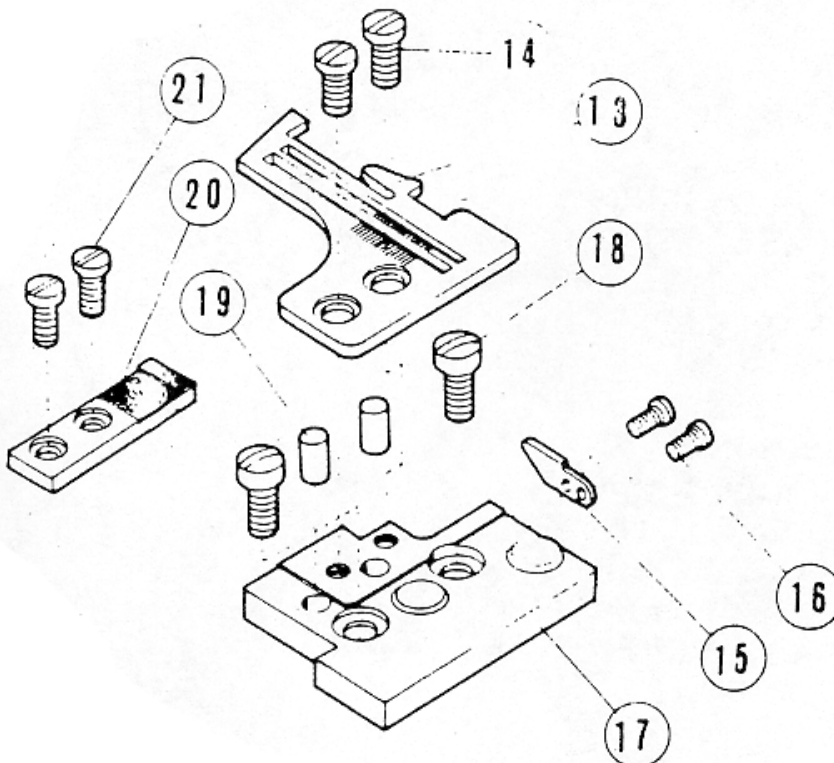
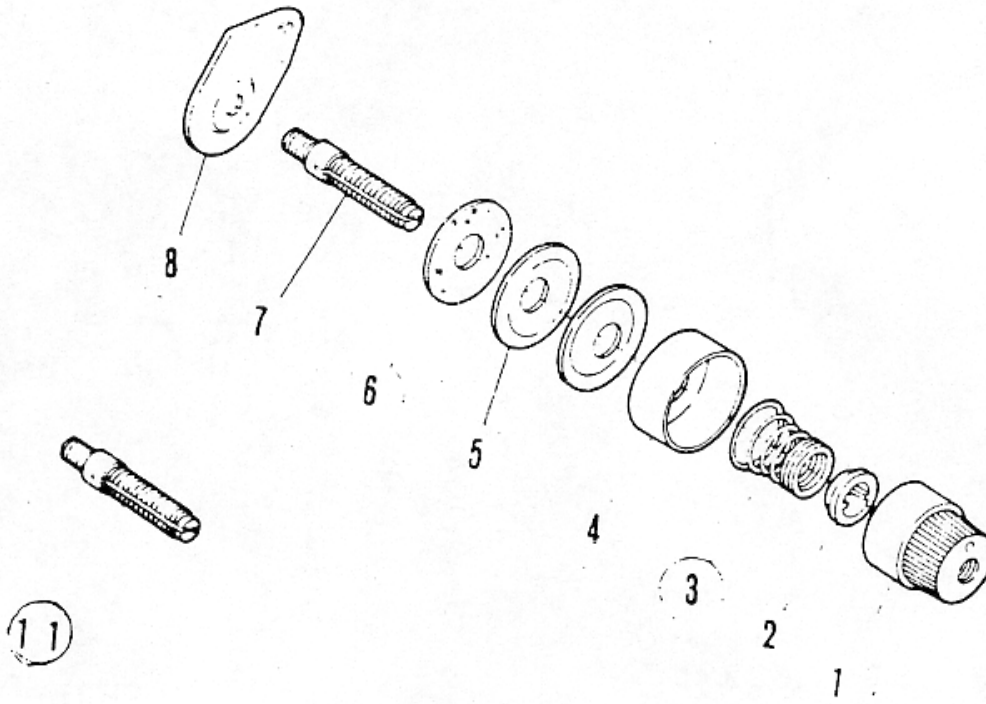


## Needle Drive Mechanism (2)

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1A	630136	Needle Bar Drive Crank (Left)	1		22	613900	Upper Needle Bar Bushing	1	
2	611620	Screw	1		23	613920	Lower Needle Bar Bushing	1	
3	611680	Screw	1		24	617200	Dust Shield	1	
4	616580	Needle Bar Connecting Link	1		25	618440	Dust Shield Screw	2	
5	610960	Pin	2		26	617220	Oil Release Felt	1	
6	619400	Pin Screw	2		27	611600	Oil Wick	1	
7	616600	Needle Bar Clamp	1		28	617240	Needle Bar Cap	1	
8	610060	Clamp Screw	1		29	610740	O-Ring	1	
9	611870	Needle Thread Retainer Brkt	1		30	610420	Screw	1	
10	611720	Guide Spacer	1		31	610060	Hinge Screw	2	
11	619640	Screw	1		32	610970	Hinge Screw Washer	2	
12	610760	Guide	1		33	614713	Hinge Base	1	
13	610905	Guide Spring	1		34	618355	Hinge Base Screw	2	
14	619850	Guide Screw	1		35	618665	Hinge Base Screw Nut	2	
15	611880	Needle Thread Take-up	1		36	610480	Hinge Base Nut	2	
16	619405	Screw	2		37	614667	Hinge	1	
17	613185	Needle Bar	1		38	614668	Guard	1	
18	618325	Needle Clamp Nut	1		39	614669	Guard Washer	1	
19	PSM-130	Needle PSM 130	1		40	618170	Guard Screw	2	

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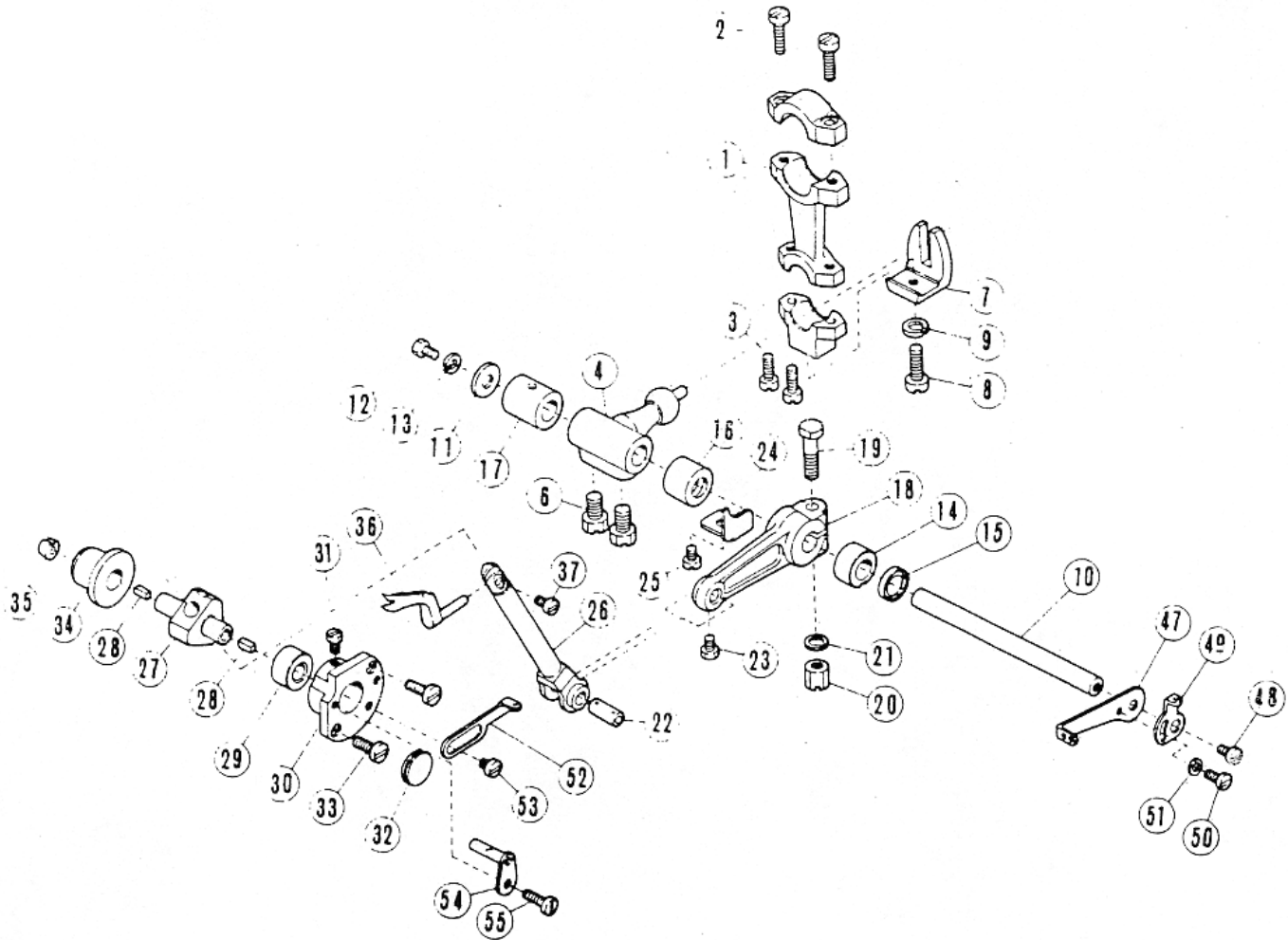


## Needle Drive Mechanism (3)

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
	616840	Needle Thread Tension	1		14	618340	Screw	2	
1	616680	Nut	1		15	613922	Key	1	
2	616700	Spring Bushing	1		16	619402	Key Screw	2	
3	611040	Spring	1		17	614081	Needle Plate Brkt	1	
4	616740	Spring Cup	1		18	619625	Screw	2	
5	611460	Disc	2		19	613921	Guide Pin	2	
6	616720	Cushion Felt	1		20	613923	Needle Plate Support	1	
7	618560	Post	1		21	618640	Screw	2	
8	611920	Guide	1			617045	Connecting Link Cover	1	
13	614045	Needle Plate	1						

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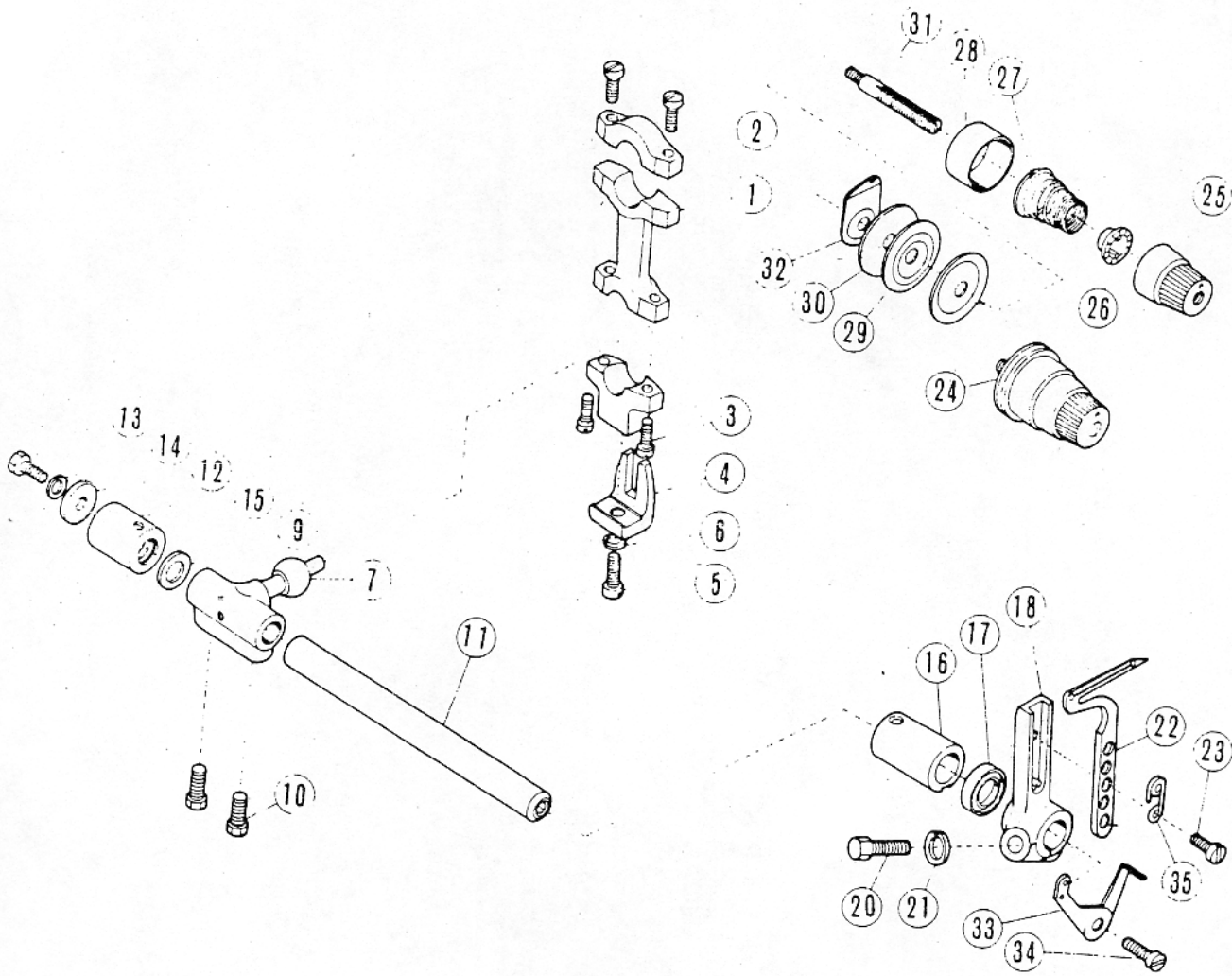


## Right Looper Drive Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	616160	Right Looper Drive Connection	1		25	618940	Set Plate Screw	1	
2	617600	Cap Screw	2		26	615985	Right Looper Lever	1	
3	610040	Cap Screw	2		27	615090	Guide	1	
4	614250	Drive Crank	1		28	613600	Oil Felt	2	
6	611620	Screw	2			614400	Bushing	1	
7	611160	Guide	1		29	612345	Front Bushing	1	
8	1156	Guide Screw	1		30	612346	Housing	1	
9	611640	Guide Screw Washer	1		31	618600	Bushing Screw	1	
10	612400	Right Looper Drive Shaft	1		32	615220	Housing Cap	1	
11	613660	Thrust Washer	1		33	610100	Housing Cap Screw	2	
12	617540	Thrust Washer Screw	1		34	617080	Bushing	1	
13	611640	Washer	1		35	617060	Cap	1	
14	615860	Front Bushing	1		36	620244	Spreader	1	
15	612300	Front Bushing Oil Seal	1		37	610700	Clamp Screw	1	
16	612440	Center Bushing	1		47	616660	Right Looper Thread Take-Up	1	
17	616620	Rear Bushing	1		48	611970	Screw	1	
18	612340	Right Looper Lever Crank	1		49	614640	Auxiliary	1	
19	619280	Clamp Screw	1		50	618200	Auxiliary Screw	1	
20	619380	Clamp Screw Nut	1		51	611960	Auxiliary Washer	1	
21	611560	Clamp Screw Washer	1		52	614660	Thread Guide Wire	1	
22	615480	Pin	1		53	618140	Screw	1	
23	618600	Pin Screw	1		54	613970	Thread Guide	1	
24	615840	Set Plate	1		55	618380	Screw	1	

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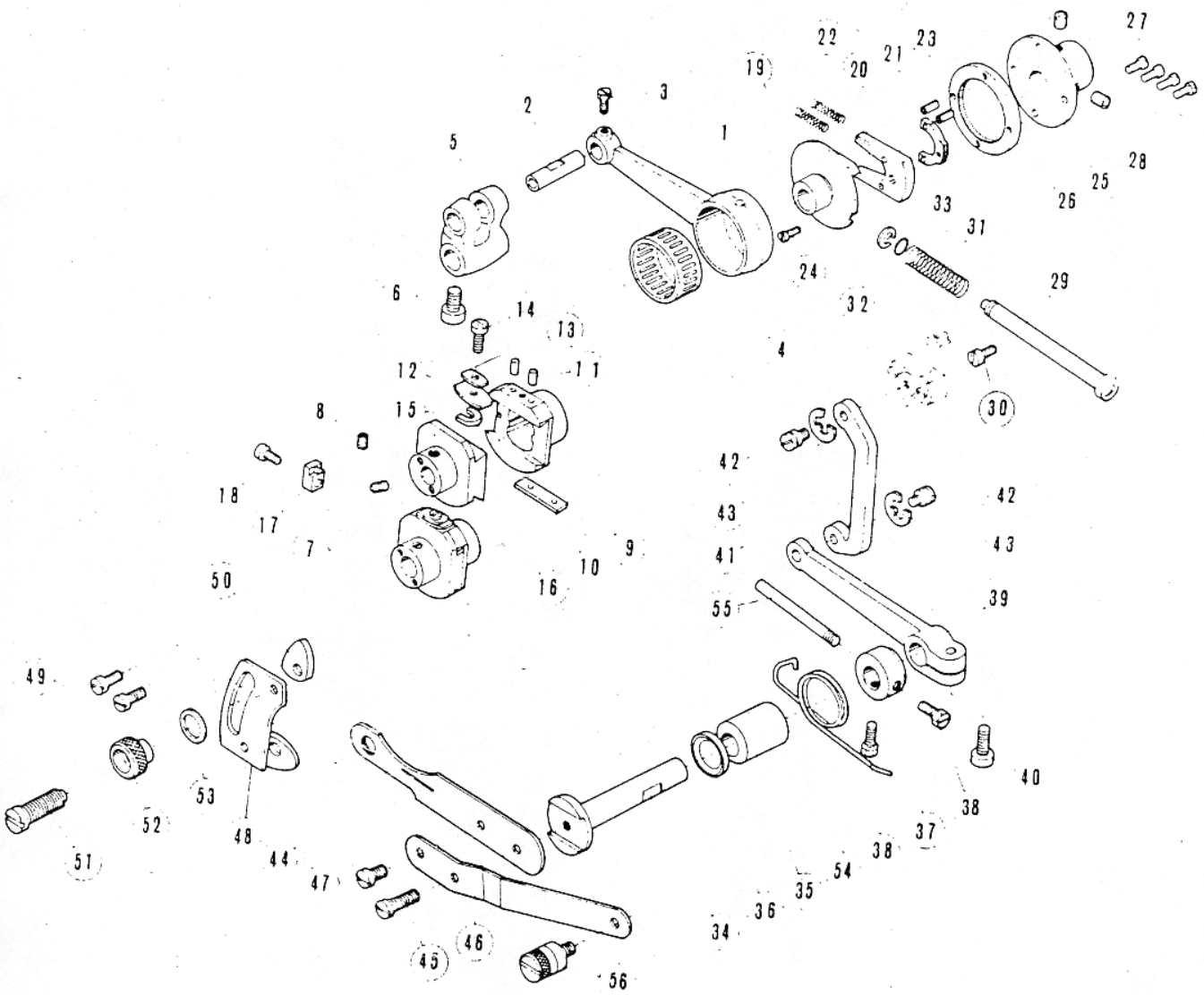


## Left Looper Drive Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	616160	Looper Drive Connection	1		20	619360	Clamp Screw	1	
2	617600	Cap Screw	2		21	613640	Clamp Screw Washer	1	
3	610040	Cap Screw	2		22	612420	Left Looper	1	
4	611160	Guide	1		23	610060	Screw	1	
5	1156	Guide Screw	1		24	616860	Thread Tension	1	
6	611640	Guide Washer	1		25	616680	Nut	1	
7	614250	Looper Drive Crank	1		26	616700	Spring Bushing	1	
9	614260	Thrust Washer	1		27	611180	Spring	1	
10	611620	Screw	2		28	616740	Spring Cup	1	
11	612400	Looper Lever Shaft	1		29	611460	Disc	2	
12	613650	Thrust Washer	1		30	616720	Cushion Felt	1	
13	617540	Thrust Washer Screw	1		31	618560	Post	1	
14	611640	Washer	1		32	611920	Guide	1	
15	612320	Rear Bushing	1		33	614248	Looper Thread Take-Up	1	
16	615780	Front Bushing	1		34	618120	Screw	1	
17	612300	Bushing Oil Seal	1		35	610660	Thread Guide Wire	1	
18	614000	Left Looper Lever	1						

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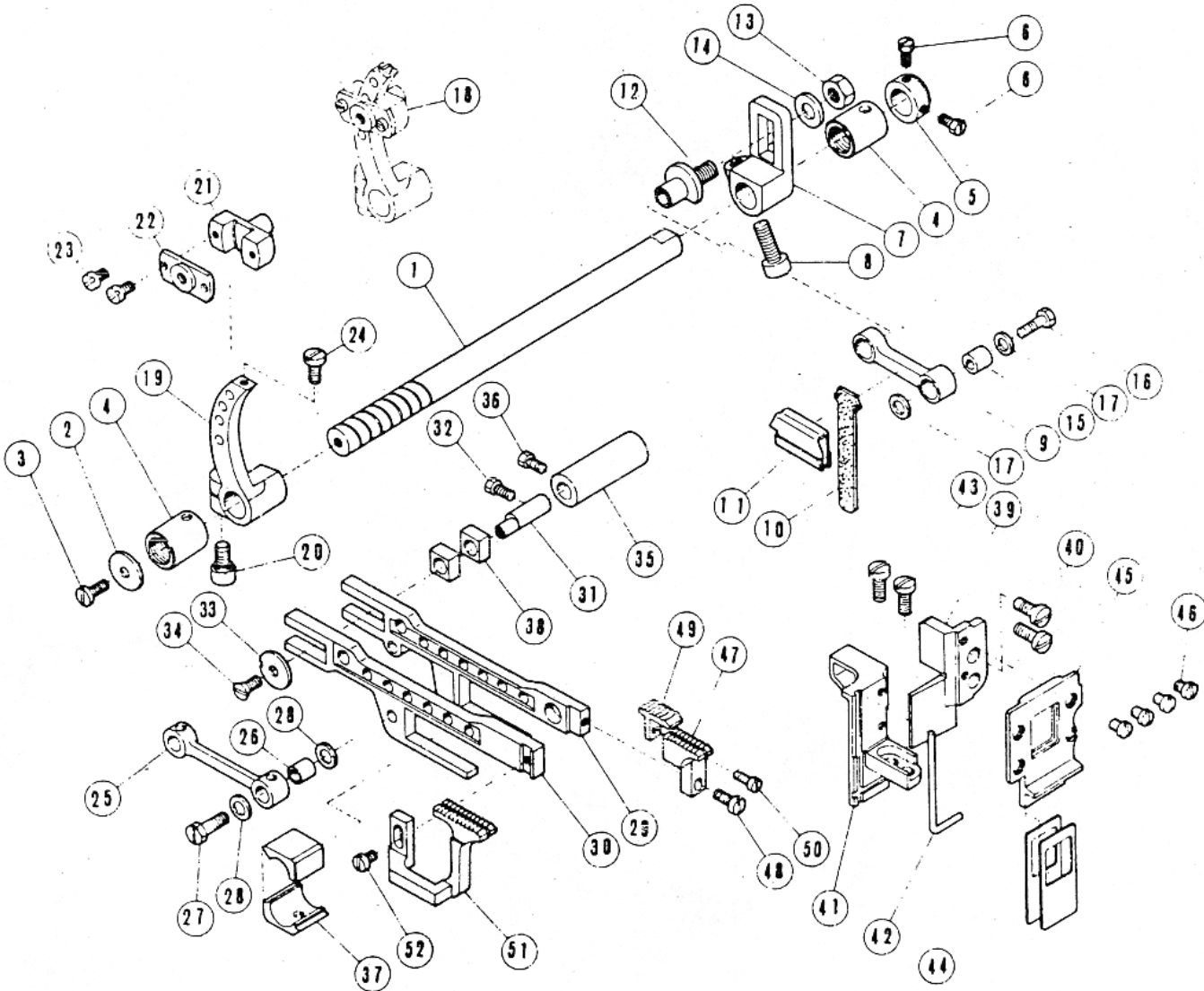


## Main & Differential Feed Drive Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	612620	Feed Drive Connection	1		28	619420	Screw	2	
2	614760	Pin	1		29	616500	Eccentric Push Rod	1	
3	618600	Pin Screw	1		30	619760	Screw	1	
4	612480	Needle Bearing	1		31	616520	Spring	1	
5	1231	Feed Drive Crank	1		32	616900	Retaining Ring	1	
6	619700	Clamp Screw	1		33	613320	O-Ring	1	
7	615680	Feed Eccentric	1		34	614100	Feed Shaft	1	
8	619420	Screw	2		35	615800	Bushing	1	
9	615680	Feed Eccentric	1		36	612300	Oil Seal	1	
10	615340	Eccentric Liner	1		37	614120	Thrust Collar	1	
11	613740	Eccentric Pin	2		38	618600	Thrust Collar Screw	2	
12	615360	Eccentric Spring Plate	1		39	612800	Feed Shaft Arm	1	
13	615380	Eccentric Spring Plate	1		40	619700	Clamp Screw	1	
14	1196	Spring Plate Screw	1		41	612820	Feed Link	1	
15	616300	Spring Plate Washer	1		42	619460	Screw	2	
16	615690	Eccentric Retainer	1		43	616900	Screw Retaining Ring	2	
17	616040	Eccentric Stopper	1		44	614140	Feed Regulator Lever	1	
18	610120	Screw	1		45	618760	Screw	1	
19	616320	Eccentric Regulator	1		46	614600	Front Lever	1	
	616340	Eccentric Gear	1		47	610200	Front Lever Screw	1	
20	616365	Gear Brkt	1		48	612840	Lever Guide	1	
21	616360	Position Gear	1		49	618760	Lever Guide Screw	2	
22	616400	Spring	2		50	612860	Lever Lift Guide	2	
23	614415	Pin	2		51	619500	Lever Adjust Screw	1	
24	619580	Screw	1		52	614480	Lever Adjust Nut	1	
	616420	Eccentric Gear	1		53	611940	Lever Adjust Washer	1	
25	616450	Gear Brkt	1		54	614160	Feed Regulating Spring	1	
26	616440	Internal Gear	1		55	614180	Latch Screw	1	
27	619680	Screw	4		56	614460	Hook Latch Screw	1	

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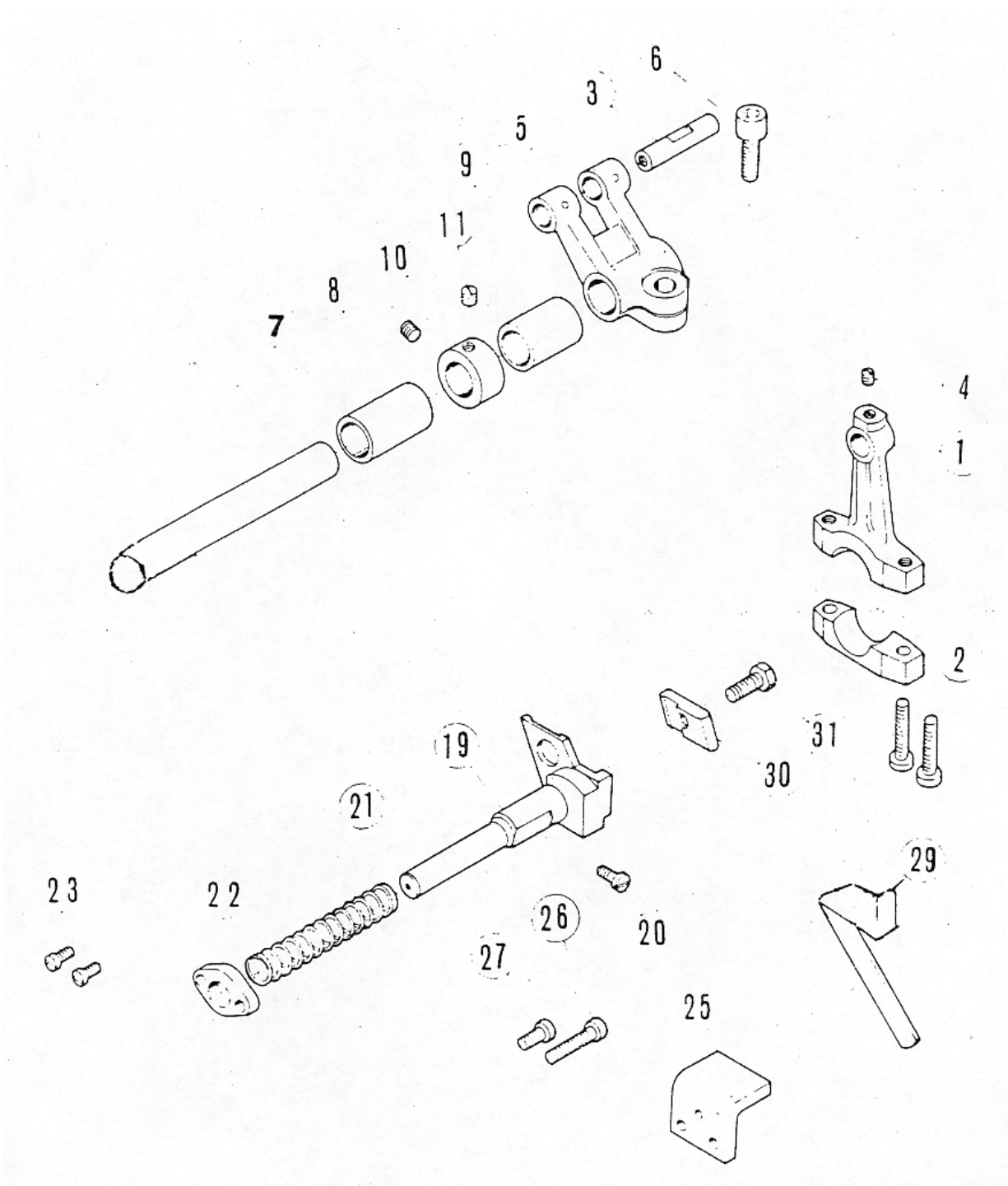


## Main & Differential Feed Drive Mechanism (2)

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	614080	Feed Bar Shaft	1		27	619140	Bushing Screw	1	
2	613660	Thrust Washer	1		28	612700	Bushing Washer	2	
3	618340	Thrust Washer Screw	1		29	612730	Main Feed Bar	1	
4	612320	Bushing	2		30	612740	Differential Feed Bar	1	
5	611100	Thrust Collar	1		31	612760	Hinge Pin	1	
6	618600	Thrust Collar Screw	2		32	618600	Screw	1	
7	615700	Feed Regulating Crank	1		33	613780	Washer	1	
8	619700	Clamp Screw	1		34	619480	Screw	1	
9	612660	Feed Connecting Link	1		35	612780	Feed Bar Guide Bushing	1	
10	613180	Oil Felt	1		36	617440	Screw	1	
11	613860	Oil Felt Retainer	1		37	614320	Feed Bar Lift Block	1	
12	615720	Pin	1		38	611200	Feed Bar Guide Block	2	
13	619710	Pin Nut	1		39	615140	Right Feed Bar Guide	1	
14	615740	Pin Washer	1		40	619080	Screw	2	
15	612680	Bushing	1		41	615120	Left Feed Bar Guide	1	
16	619140	Bushing Screw	1		42	615200	Gasket	1	
17	612700	Bushing Washer	2		43	619080	Screw	2	
18	615560	Feed Regulator	1		44	615160	Feed Bar Oil Splash Guard	2	
19	615580	Segment	1		45	615165	Insert Plate	1	
20	619700	Clamp Screw	1		46	619600	Screw	4	
21	615600	Block	1		47	613990	Main Feed Dog	1	
22	615610	Block Cover	1		48	610100	Screw	1	
23	618420	Cover Screw	2		49	614002	Auxiliary Feed Dog	1	
24	618860	Block Stop Screw	1		50	618220	Screw	1	
25	612720	Feed Connecting Link	1		51	613995	Differential Feed Dog	1	
26	612680	Bushing	1		52	610140	Screw	1	

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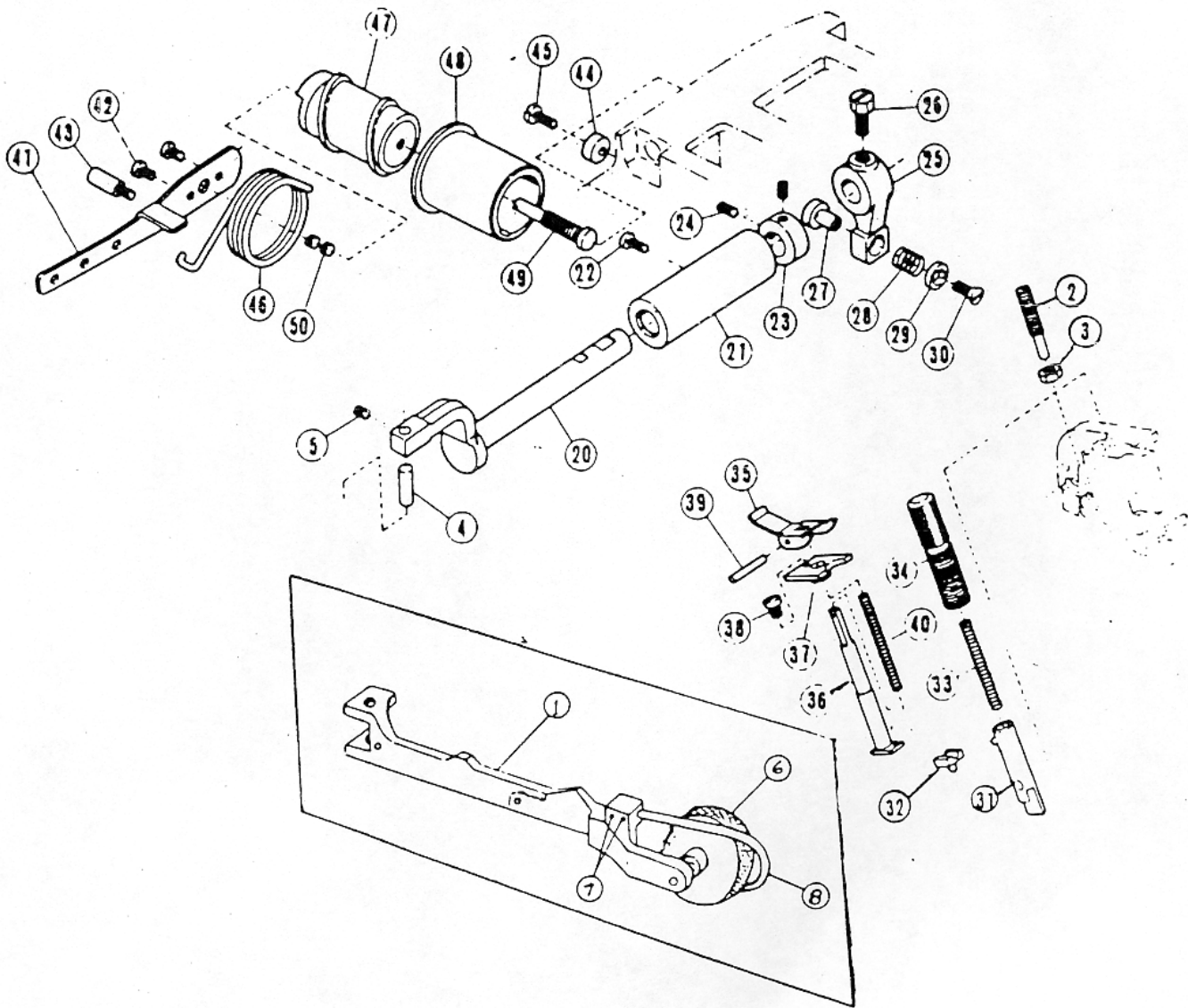


## Lifter & Guide Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	612880	Drive Connection	1		19	614186	Guide Holder	1	
2	619200	Cap Screw	2		20	618354	Screw	1	
3	612900	Pin	1		21	613080	Spring	1	
4	610440	Pin Screw	1		22	613100	Spring Seat	1	
5	613000	Drive Crank	1		23	618740	Spring Seat Screw	2	
6	619700	Clamp Screw	1		25	613120	Lower Holder Guide	1	
7	1374	Lifter Shaft	1		26	610100	Screw	1	
8	613020	Left Bushing	1		27	618360	Screw	1	
9	613040	Right Bushing	1		29	1950	Edge Guide	1	
10	611500	Thrust Collar	1		30	614187	Edge Guide Clamp	1	
11	618460	Thrust Collar Screw	2		31	617540	Screw	1	

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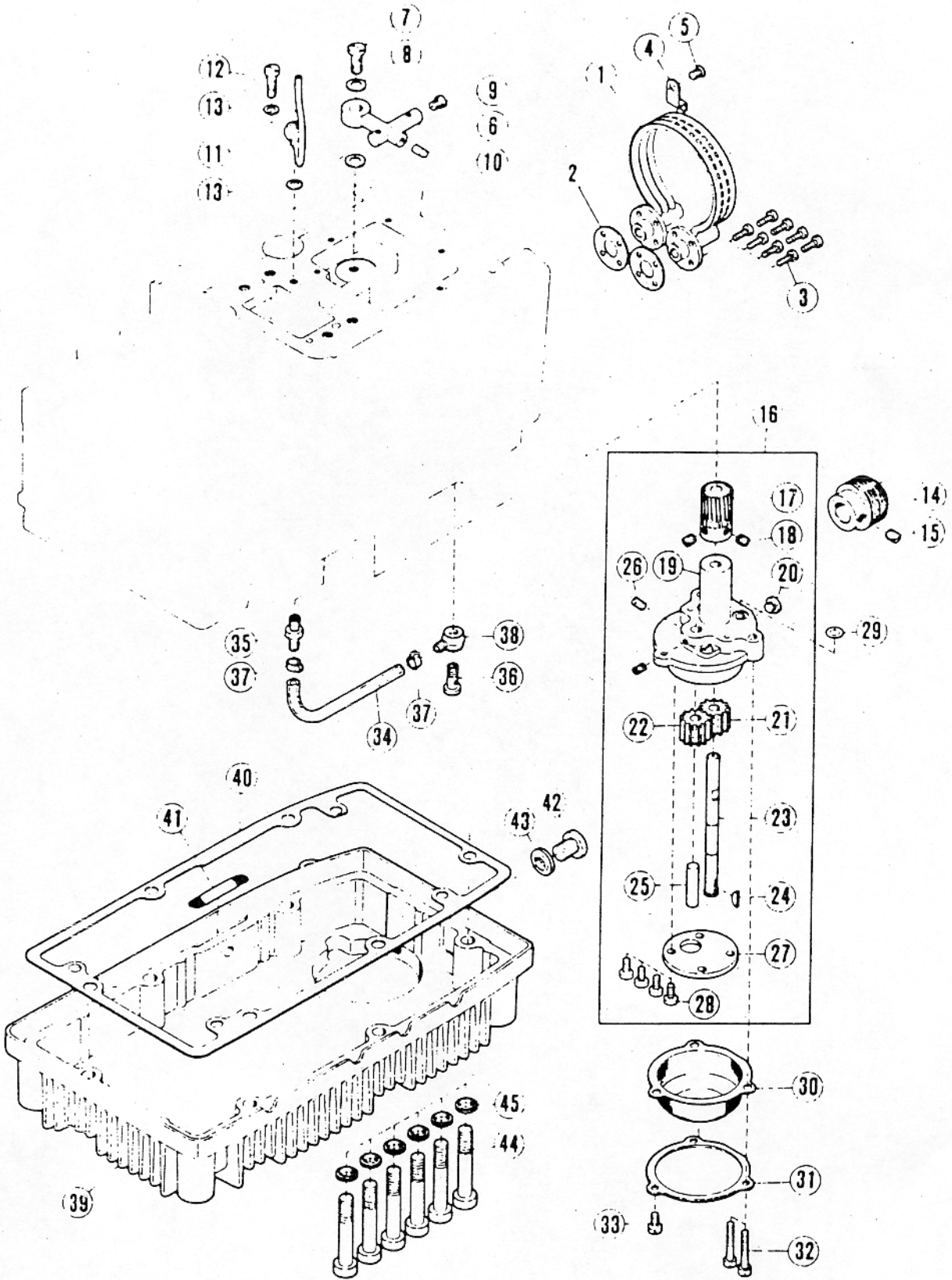


## Presser Foot & Lift Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1220	Presser Arm	1		32	616780	Guide	1	
2	619350	Lift Regulating Screw	1		33	617020	Spring	1	
3	618280	Lift Regulating Nut	1		34	617180	Regulating Thumb Screw	1	
4	617040	Hinge Pin	1		35	617100	Hand Lift Lever	1	
5	619020	Hinge Pin Screw	1		36	611780	Spring Plunger	1	
6	906	Roller Assy	1		37	617120	Spring Plunger Bushing	1	
7	SS2-56X.125	Set Screw	2		38	618420	Plunger Bushing Screw	1	
8	1178	Hold Down Wire	1		39	611800	Hinge Pin	1	
20	616960	Foot Lift Lever Shaft	1		40	611420	Spring	1	
21	616980	Bushing	1		41	613220	Foot Lift Lever	1	
22	617440	Bushing Screw	1		42	610180	Screw	2	
23	611100	Collar	1		43	619180	Stop Screw	1	
24	610420	Collar Screw	2		44	611840	Regulator	1	
25	615900	Intermediate Lever	1		45	618760	Regulator Screw	1	
26	611620	Screw	1		46	613240	Spring	1	
27	615920	Pin	1		47	614680	Foot Lift Cam	1	
28	615940	Pin Spring	1		48	614700	Bushing	1	
29	611900	Pin Washer	1		49	615960	Regulating Screw Stud	1	
30	619480	Pin Screw	1		50	618160	Stud Stop Screw	1	
31	617000	Presser Bar	1						

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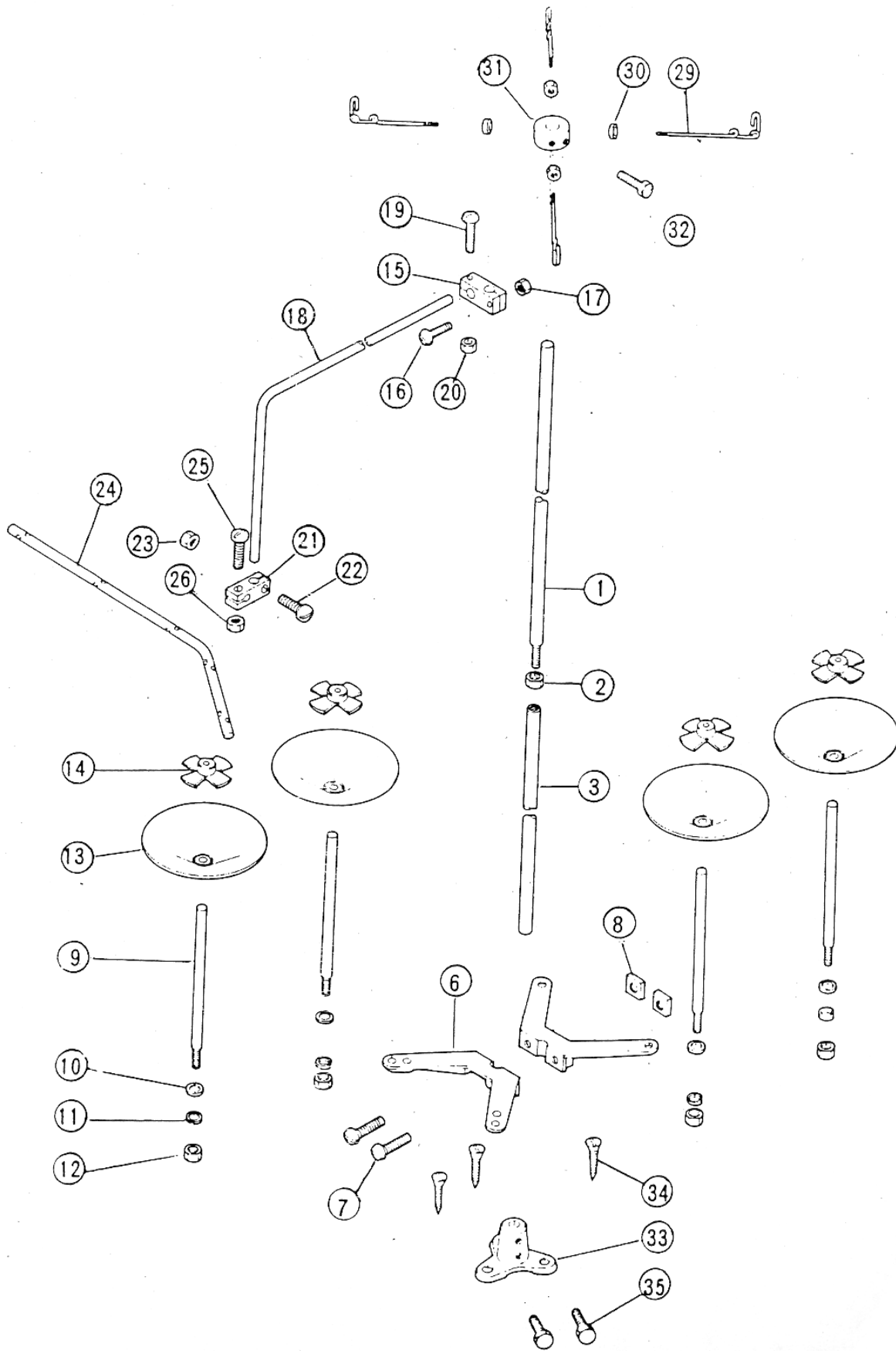


## Lubricating Mechanism

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	613380	Cooler Assy	1		24	611020	Key	1	
2	613420	Gasket	2		25	613300	Pump Gear Shaft	1	
3	610100	Screw	8		26	610440	Screw	2	
4	613400	Clamp	1		27	611280	Plate	1	
5	618260	Screw	1		28	618740	Screw	4	
6	613440	Distributor	1		29	613320	O-Ring	1	
7	610860	Oil Splash Screw	1		30	611380	Filter	1	
8	610820	Washer	2		31	611400	Frame/Filter	1	
9	611365	Screw	1		32	618660	Screw	2	
10	611980	Plug	1		33	618740	Screw	1	
11	613460	Oil Splash Pipe	1		34	610840	Oil Tube	1	
12	611520	Oil Splash Screw	1		35	610800	Oil Splash Joint	1	
13	611540	Washer	2		36	610860	Oil Splash Screw	1	
14	613340	Worm	1		37	611615	Tube Clamp	2	
15	611618	Screw	1		38	613480	Nipple	1	
16	613880	Gear Pump	1		39	615500	Oil Reservoir	1	
17	613360	Worm Wheel	1		40	615980	Gasket	1	
18	618460	Screw	2		41	611465	Oil Pan Screen	1	
19	613260	Casing	1		42	618840	Screw	1	
20	618900	Screw	1		43	611660	Washer	1	
21	611300	Right Pump Gear	1		44	618960	Bolt	6	
22	201308	Left Pump Gear	1		45	614300	Washer	6	
23	613290	Pump Gear Shaft	1						

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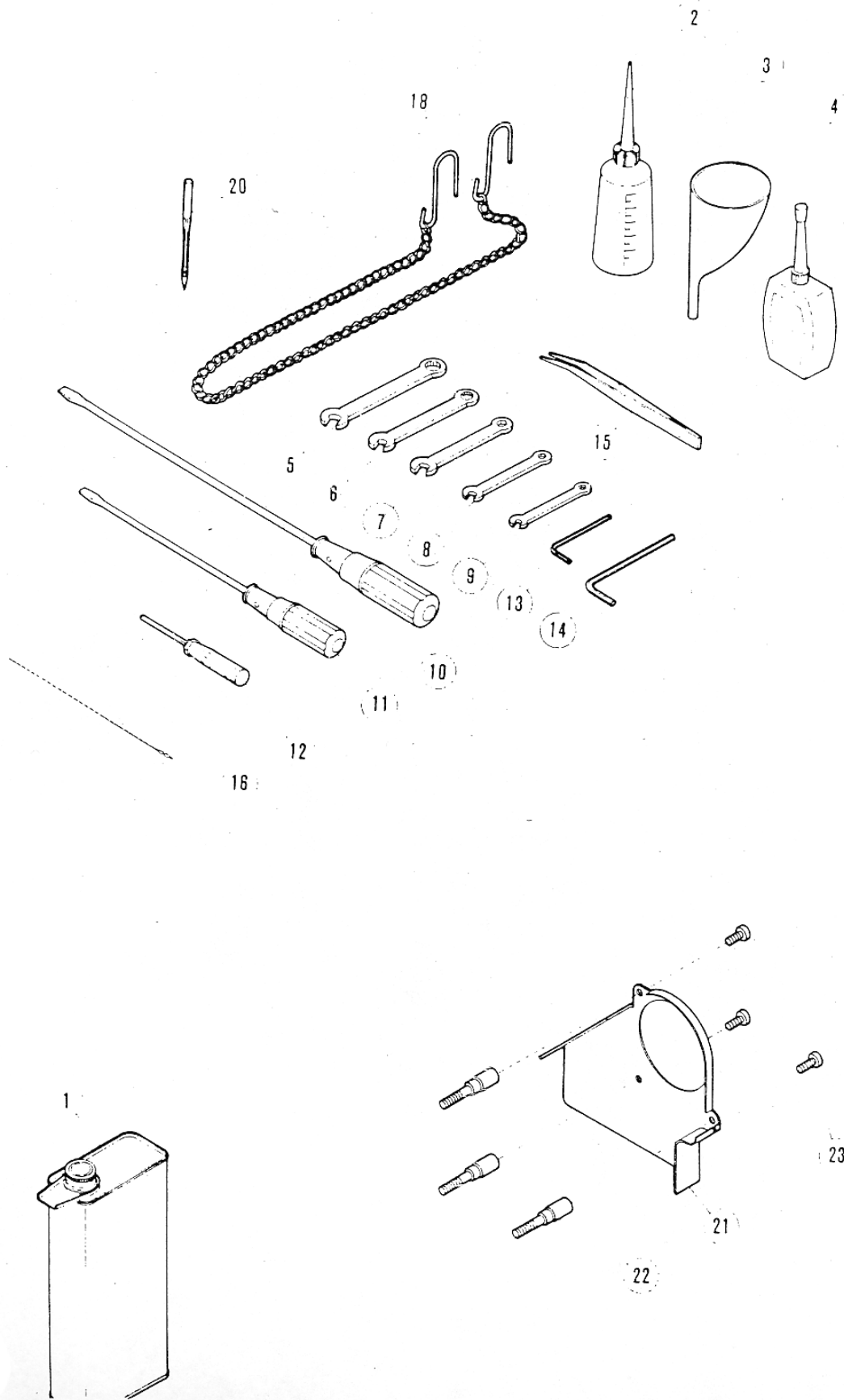


## Thread Stand

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
	618090	Thread Stand	1		19	617780	Screw	1	
1	617460	Upper Rod	1		20	617800	Screw Nut	1	
2	617480	Nut	1		21	617820	Guide Rod Retaining Block	1	
3	617500	Lower Rod	1		22	617780	Clamp Screw	1	
4	617520	Spool Pin Brkt	1		23	617800	Clamp Screw Nut	1	
5	617965	Clamp Plate	1		24	618240	Thread Guide Bar	1	
6	617560	Spool Pin Brkt	1		25	617780	Clamp Screw	1	
7	617580	Clamp Screw	2		26	617800	Clamp Screw Nut	1	
8	617620	Camp Screw Nut	2		27	617840	Thread Guide Wire	2	
9	617640	Spool Pin	3		28	617860	Lock Nut	2	
10	617660	Washer	3		29	617880	Thread Guide Wire	1	
11	617680	Nut Spring Washer	3		30	617860	Lock Nut	1	
12	617700	Nut	3		31	617970	Thread Guide Wire Holder	1	
13	617720	Spool Tray	3			617975	Thread Guide Wire Holder		
14	617740	Spool Retaining Fin	3		32	617900	Screw	1	
15	617760	Thread Guide Bar Rod Brkt	1		33	617920	Thread Stand Base	1	
16	617780	Clamp Screw	1		34	617940	Wood Screw	3	
17	617800	Clamp Screw Nut	1		35	617960	Lower Rod Screw	2	
18	618180	Thread Guide Bar Rod	1						

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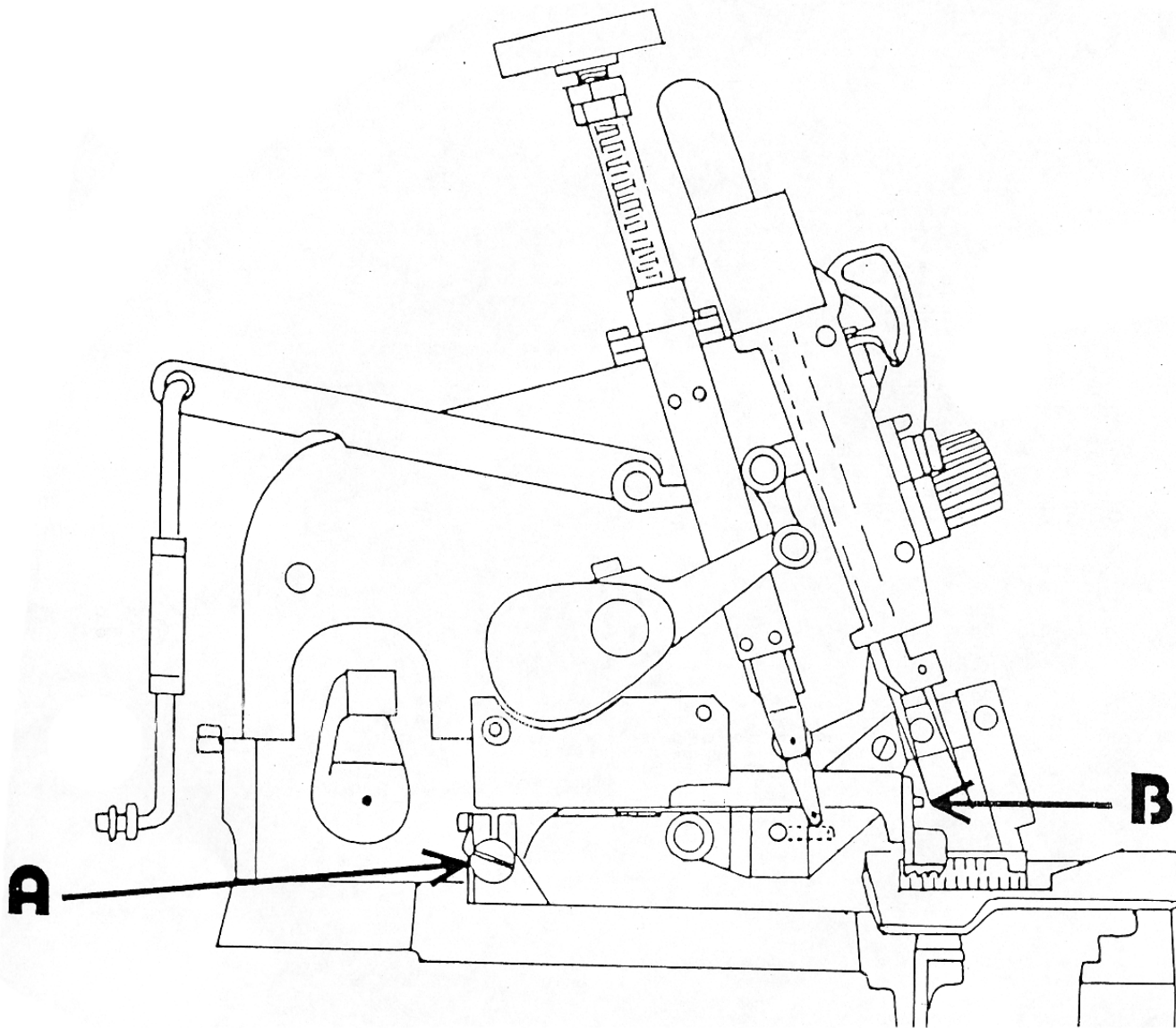


**Accessories**

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	610365	Oil Container (750cc)	1		12	610600	Allen Wrench (1.56mm)	1	
2	610385	Oiler	1		13	610640	Allen Key (3.17mm)	1	
3	610380	Oil Funnel	1		14	610720	Allen Key (4.76mm)	1	
4	610580	Silicone Container (50cc)	1		15	610300	Tweezers	1	
5	618080	Wrench (9.5mm)	1		16	610460	Threading Wire	1	
6	618060	Wrench (8mm)	1		18	610420	Treadle Chain	1	
7	618040	Wrench (7mm)	1		20	PSM130	Needle	1	
8	618020	Wrench (6mm)	1		21	614705	Belt Guard	1	
9	618000	Wrench (5mm)	1		22	614740	Fixing Screw	3	
10	610260	Screwdriver	1		23	618740	Screw	3	
11	610280	Screwdriver	1			617980	Allen Key (6.0mm) (Not Shown)	1	

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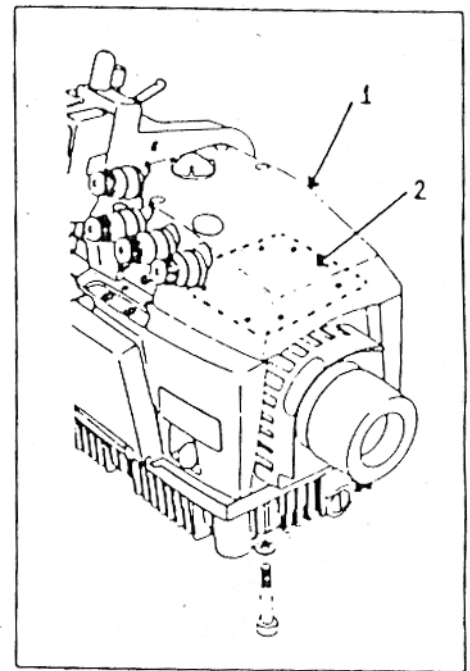




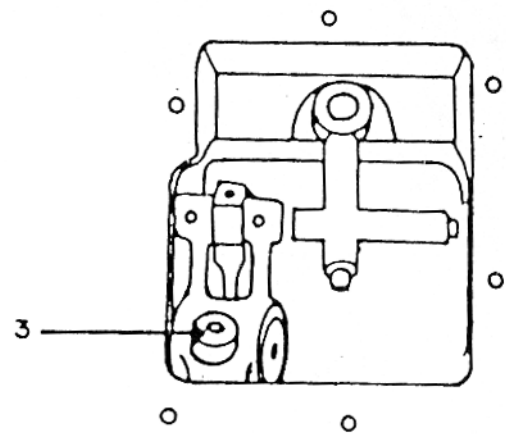
## Top Feed Adjustment

Refer to the diagrams on page 38 and on this page.

- A- This eccentric pin adjusts the position of the top feed front to rear. This enables you to align the top feed teeth with the lower feed dog teeth.
  - B- This screw adjusts the height of the top feed. If the height of the top feed can not be adjusted by changing "B", it will have to be adjusted internally by changing the upper knife shaft as illustrated in "Sub-Diagrams A & B".
- 1- Remove the top cover (four screws)
  - 2- Then, remove the right cover plate #208341 (six screws). This will expose the upper knife drive crank with a socket cap screw. (Sub-Diagram A)
  - 3- Use a 3/16" allen wrench to loosen this screw. Lowering the knife arm will raise the top feed. Raising the knife will lower the top feed. (Sub-Diagram B)
  - 4- After adjusting the above, the upper trim knife will have to be reset.



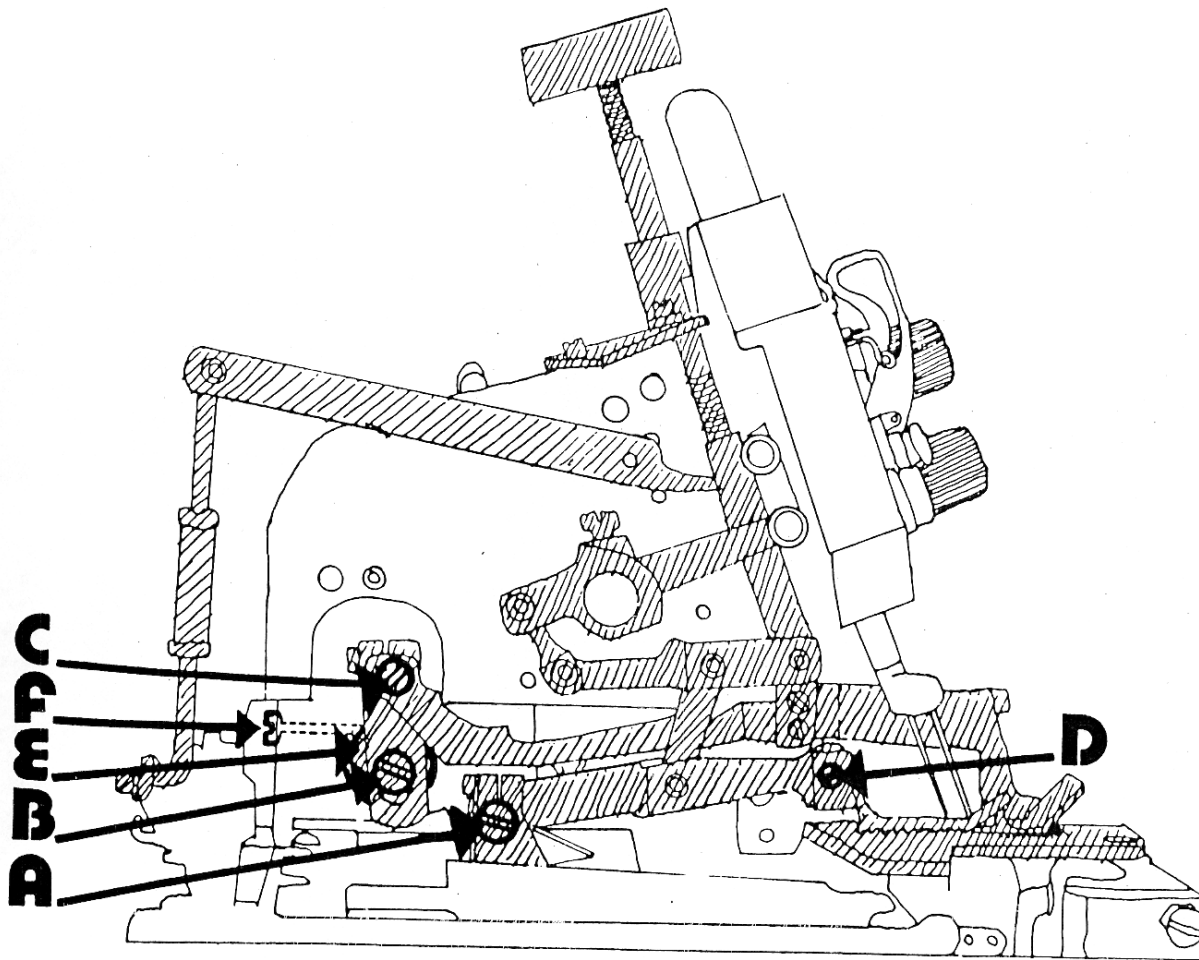
Sub-Diagram A



Sub-Diagram B

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## 1381-504A Walking Foot Adjustments



- A- This eccentric pin adjusts the position of the Walking Foot front to rear. This enables you to align the Walking Foot teeth with the lower feed dog teeth.
- B- This screw adjusts the Walking Foot movement in relation to the presser foot. The higher the bracket, the faster the presser foot will meet the needle plate, causing the Walking Foot to raise off of the work faster. Lowering the bracket will cause the Walking Foot to raise off the work slower.
- C- This eccentric pin primarily adjusts the position of the presser foot front to rear.
- D- This screw adjust the height of the lift of the Walking Foot.
- E- This shaft adjusts the position of the presser foot front to rear. It is used to adjust the clearance between the presser foot and the Walking Foot.
- F- This screw holds shaft "E". Loosen it to free the shaft.

### Important!

**Any one of the adjustments mentioned above will slightly change one or all of the other adjustments. Take this into consideration when making any one adjustment. Before running the machine, turn it over by hand to check all clearances**



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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 which ever 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 which ever 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 manufacturer's (OEM) warranty.
- AAC will assist in the procurement and handling of the manufacturer's (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.