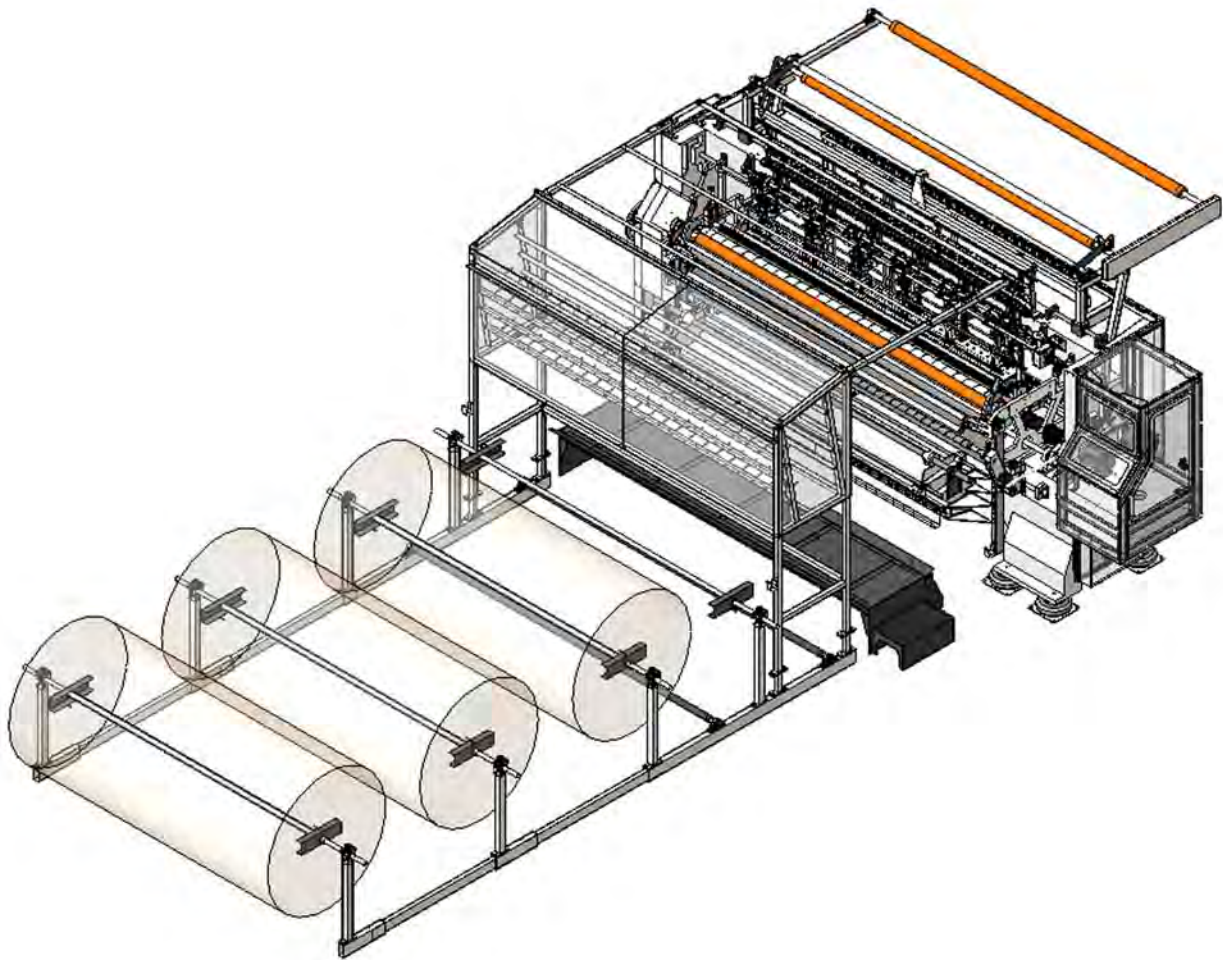


model: **1392C**
GoldenEagle IV



Technical Manual & Parts List

"Sudden Service"®



From the library of: Diamond Needle Corp

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IMPORTANT

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

Atlanta Attachment Company
362 Industrial Park Drive
Lawrenceville, Georgia 30045
Phone: (770) 963-7369
Fax: (770) 963-7641
Email: sales@atlatt.com

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Important Safety Instruction

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

Mandatory Information

All persons working on the machine should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only work on the machine 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,
- Serial Bus Control system Operator instructions,
- Instruction Manual(s) for components made by other manufacturers and
- 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.

Important Safety Instruction

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 pneumatic 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.



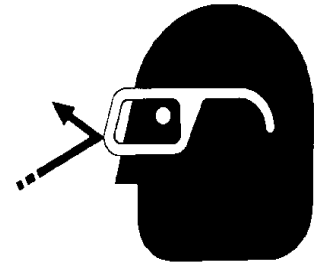
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Clothing, Jewelry, Protective Equipment

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

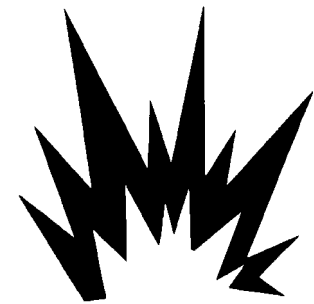
Always count the number of tools in your possession before starting work on the machine. This will allow you to check that no tools have been left behind inside the machine. Never leave a tool in the machine while working.

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 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).

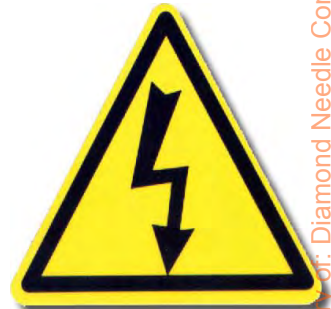
Isolate the machine from the power supply if a fire breaks out. Do not use water on burning electrical parts until it is absolutely certain that they have been completely disconnected from the power supply. Burning oils, lubricants, plastics and coatings on the machine can give off gases and vapors that 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 set-up and 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 us and/or your transport insurer without delay. 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.

Machine Installation

This equipment must be installed by an Atlanta Attachment Co. technician, or by a properly trained and authorized technician/mechanic. Atlanta Attachment Co. reserves the right to void any machine warranty if the machine is installed by anyone other than a qualified person as stated above

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.

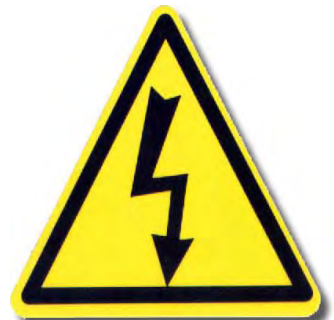


Connection, Reconnection

Energy feed and discharge lines must be routed so that they do not run through the operator's working area, are not compressed, crushed or buckled, are not subjected to tensile stresses and cannot rub against anything. This is particularly important in the case of pneumatic, hydraulic and electricity lines or hoses and always take the machine movements into account when routing such lines.

Electrical Connection

The machine shall only be connected to the factory power supply by a qualified electrician who is familiar with the local regulations. Before switching on the master switch, check that all fasteners are secure.



Pneumatic Connection

Only use dry filtered compressed air. Ensure that the air pressure always remains within the range specified, otherwise malfunctions may occur.

From the library of Diamond Needs Corp.



Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup. Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.

Retighten all screw connections that have to be loosened for the maintenance and repair work. Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

Waste products should be cleared from the machine as soon as possible as not to create a fire hazard.

Ensure that fuels and operating lubricants, as well as replacement parts are disposed of in a safe and ecologically acceptable manner. Note the local regulations on pollution control. When scrapping (disassembling) the machine and its assemblies, ensure that these materials are disposed of safely. Either commission a specialist company familiar with the local regulations or note the local regulations when disposing of these materials yourself. Materials should be sorted properly.

Repair

Replacement Parts

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

Repair, Electrical

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

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

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



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

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

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

Ventilation/Hazardous Gases

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

Hydraulic And Pneumatic Systems

Work on hydraulic or pneumatic equipment shall only be carried out by persons with training, knowledge and experience of hydraulic systems.

Pressure lines shall be depressurized before starting any repair work.

General Liability

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

Starting Machine Movements

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

A Word To The End User

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

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



From the library of: Diamond Needle Corp



Setup Specifications

2" Stroke

1. NEEDLE BAR DRIVE LEVER (SHOULDER TO SHAFT C/L)	35 MM
2. NEEDLE BAR PITMAN ROD...(18.1")	460MM
3. NEEDLE BAR TRAVEL (2.00")	51 MM
4. PRESSER FOOT PITTMAN ROD (22.2")	565MM
5. NEEDLE BAR (MODIFIED) HEIGHT ABOVE T/P @ BDC...180°	37 MM
6. POINT OF NEEDLE BELOW NEEDLE PLATE @ BDC...180°	28 MM
7. POINT OF NEEDLE BELOW NEEDLE PLATE @ TAKE TIME....232°	20 MM
8. TIMING	NEEDLE BAR DOWN = LOOPERS BACK
9. LOOPER PITMAN ROD LENGTH	85 MM
10. LOOPER DRIVE ARM SPACER OD TO AXIS CENTER	47 MM
11. RETAINERS REARWARD	64°
12. REAR RETAINER BAR BACK TO BACK OF NEEDLE PLATE @ 64°	89MM
13. POINT OF RETAINER TO NEEDLE @ 154°	1-2 MM
14. LOOP TAKE TIME (PT OF LPR @ FT OF NDL)	232°
15. LOOPER TRAVEL	29 MM
16. REAR BUTTERFLY ECCENTRIC FORWARD	148°
17. BUTTERFLY STROKE	RODEND CENTERED IN SLOT
18. BUTTERFLY PITMAN ROD LENGTH	265MM
19. REAR BUTTERFLY ROD TO FRAME @ LOWEST POSITION (148°)	38 MM
20. REAR BUTTERFLY ROD TO FRAME @ HIGHEST POSITION (328°)	58 MM
21. FRONT BUTTERFLY TIMING	LEVEL @ 90°
22. NEEDLE THREAD TAKE-UP ROD	DOWN 15° (LOWER ROD FOR THICKER MAT'L)
23. PRESSER FOOT HEIGHT, NDL DOWN @ LOWEST SETTING	3 MM
24. PRESSER FOOT CAMS	LEVEL @ 0 DEG
25. LOOPER TIMING ADJUSTMENT	LOW MOVING FORWARD? = ADV ECCENTRIC

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Power Requirements

Volts	208-240 VDC
Amps	40 Amps / 3 Phase Delta
Air Pressure	90 PSI

Physical Specifications

Overall Dimensions:	15' X 25'
Weight:	25000 lbs
Recommended Needle:	SN794FR-180
Stitch Length:	4-8 SPI

Pressure Gauge Settings

Main Pressure Regulator:	70 PSI
Pressure Roller Regulator:	50-80 PSI
Dancer Bar Regulator:	5-20 PSI

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Operation

Definitions

Machine Axis -The machine has three Servo motors. One for each Axis of movement.

X-Axis is the left and right movement of the carriage.

Y-Axis is the Roller movement or front to back.

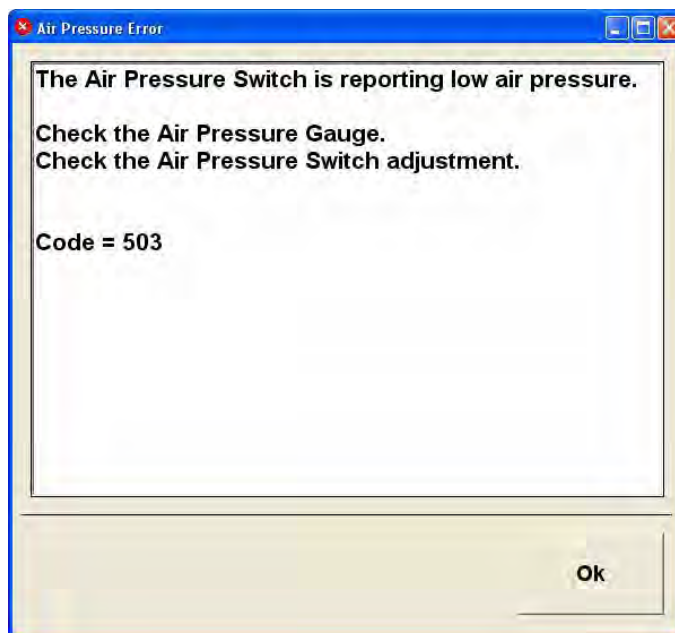
Z-Axis is the Needle up and down movement.

Machine Homing - Homing (or Home-Out) is the process of moving the X and Z axis to a known physical location in order to establish a zero point for these axes.

Machine Modes - Modes are used to control how the machine behaves under certain conditions. The modes are as follows:

1. *Stopped* - The machine is on but the servo motor controllers are off. No machine movement can occur in this mode.
2. *Running* - The machine is operating normally and is quilting.
3. *Paused* - The machine is operating normally and is NOT quilting.
4. *Manual* - The user has accessed the Manual Operations Screen and can move the machine manually. NOTE: When leaving the Manual Operations Screen the machine will automatically Home-Out.
5. *Pendant* - This mode occurs when the user moves the selector switch on the pendant to any setting other than Auto or the Pendant button on the Main Run Screen is clicked.

Message Boxes -These boxes (shown below) are used any time the machine needs to convey information to the user.



Power Off

The E-Z Quilter software accesses the hard drive of the PC during operation. It is highly recommended to close the software before turning the Main power off to the machine which also turns off the power to the PC. Do this by clicking the red "X" at the extreme top right of the E-Z Quilter software window.



For the purposes of this manual the terms *Click* and *Double-click* using a mouse also refers to "Pressing" a button using the touch screen.

Main Run Screen

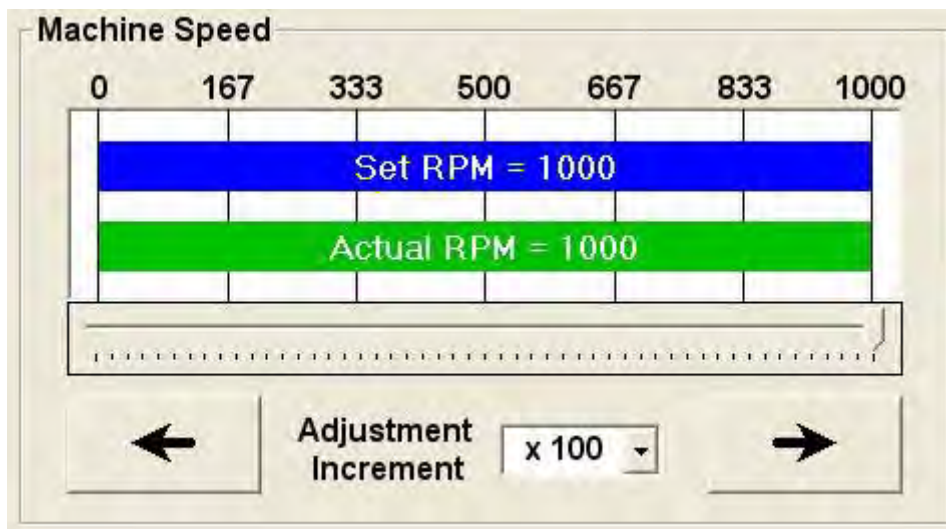
The Main Run Screen is displayed the entire time the E-Z Quilter software is active. It is divided into 5 areas Machine Speed, Miscellaneous Information, Pattern Selection, Run History, and a row of Command Buttons.



From the library of: Diamond Needle Corp



Machine Speed



The Machine Speed display shows the Set RPM, Actual RPM, and various ways to adjust the Set RPM.

Set RPM is the RPM the machine will run once it accelerates to full speed.

Actual RPM is the RPM the machine is currently running.

The Set RPM can be adjusted two different ways:

1. There is a slider bar adjustment just below the Actual RPM display. Click and hold the horizontal bar then slide back and forth to make changes.
2. The two arrow buttons adjust the RPM up or down based on the increment shown in the box between the 2 buttons. The increment can be set to 1, 10, or 100 (default is 10).

The maximum RPM the machine can be set to is controlled by the Foot Height sensors.

Miscellaneous Information



The screenshot shows a control panel interface for a sewing machine. It features several data fields and buttons. At the top, the title 'Miscellaneous Information' is displayed. Below it, the 'Yardage Counter' shows a value of 5.03, and 'Yards per Run Minute' shows 2.34. A 'Reset' button is located to the right of these two fields. A horizontal line separates this section from the next. The 'Current Mode' is set to 'Normal' via a dropdown menu, and a 'Batch Information' button is positioned to its right. The 'Yards To Go' field displays 'N/A'. Below this, a text box contains the message 'Currently set for Normal Mode'. Another horizontal line follows. At the bottom, the 'Foot Height' is set to 'Low' and the 'Current Status' is 'Running', both indicated by green buttons.

The Miscellaneous Information display shows current Yardage Information, Type of run mode, Foot Height, and Current Status.

1. Yardage Information: The Yardage Counter displays the current thru-put yards since the last time the Reset button was clicked. Yards per Run Minute displays current thru-put yards per minute. The machine needs to run for at least 1-2 minutes to get an accurate reading. Pausing the machine, changing patterns, and changing RPMs will temporarily affect this number.
2. Current Mode and Batch Information: For Future Use
3. Foot Height: Displays the current height of the foot.
4. Current Status: Refers to the mode the machine is currently operating in.

Foot Height

Miscellaneous Information

Yardage Counter	5.03	Reset
Yards per Run Minute	2.34	

Current Mode	Batch Information	Yards To Go
Normal ▾		N/A

Currently set for Normal Mode

Foot Height	Low	Current Status	Running
-------------	------------	----------------	----------------

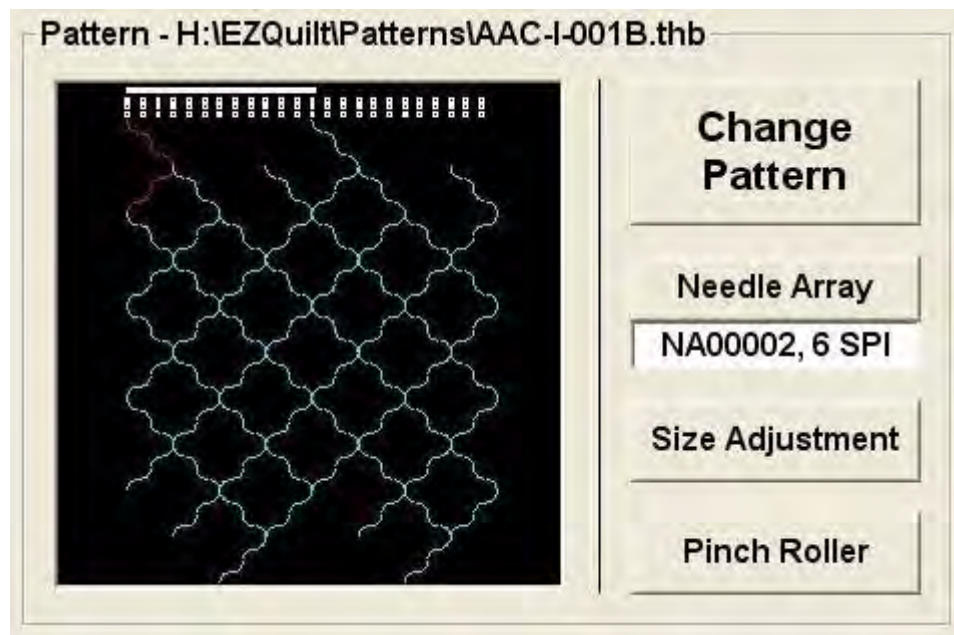
Foot Height is defined as the distance between the bottom of the presser foot to the top of the needle plate. This distance is physically set on the machine with the use of a manual crank. Sensors mounted to the mechanism tell the controller the current height of the foot. Foot Height adjustment is necessary based on the thickness of the materials being quilted. Maximum RPM of the machine is related to the Foot Height.

The importance of the Foot Height is the closer the bottom of the foot is to the needle plate the higher the maximum RPM can be.

There are three heights associated with the foot.

1. Low - Maximum RPM at this height is 1275.
2. Medium - Maximum RPM at this height is 800.
3. High - Maximum RPM at this height is 500.

Pattern Selection



The Pattern Selection area displays the currently selected pattern, Needle Array Information and Stitch Information.

The heading at the top of the frame displays the path and filename of the current pattern.

Clicking the Change Pattern button brings up the Pattern List screen to allow you to view and/or select a different pattern. The servos must be turned off before a pattern change is allowed.

The graphics area displays a visual representation of the current pattern. Double-clicking here will bring up the E-Z Pattern Design software with the current pattern loaded.

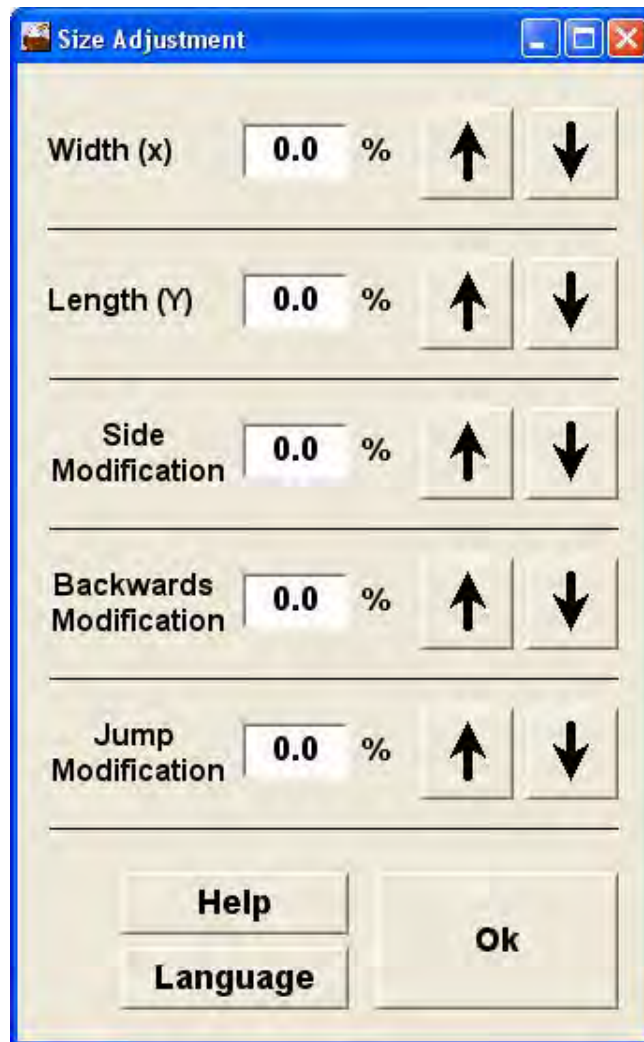
NOTE: If any changes are made, the pattern has to be re-loaded in the E-Z Quilter software.

Clicking the Needle Array button displays the needle arrangement needed in the machine to achieve the displayed pattern. The Needle Array Code and Stitches per Inch are displayed in the box below the Needle Array button.

The Pinch Roller button opens and closes the Front Pinch Roller. When a Sew & Jump pattern is loaded, the Pinch Roller closes automatically. When a continuous pattern is loaded, the roller automatically opens. The Pinch Roller assists in feeding the foam and/or fill backwards. Anytime a pattern sews in the reverse direction, the roller should be closed.

Size Adjustments

When the Change Adjustment button on the Main Run Screen is clicked the Size adjustment screen is activated.



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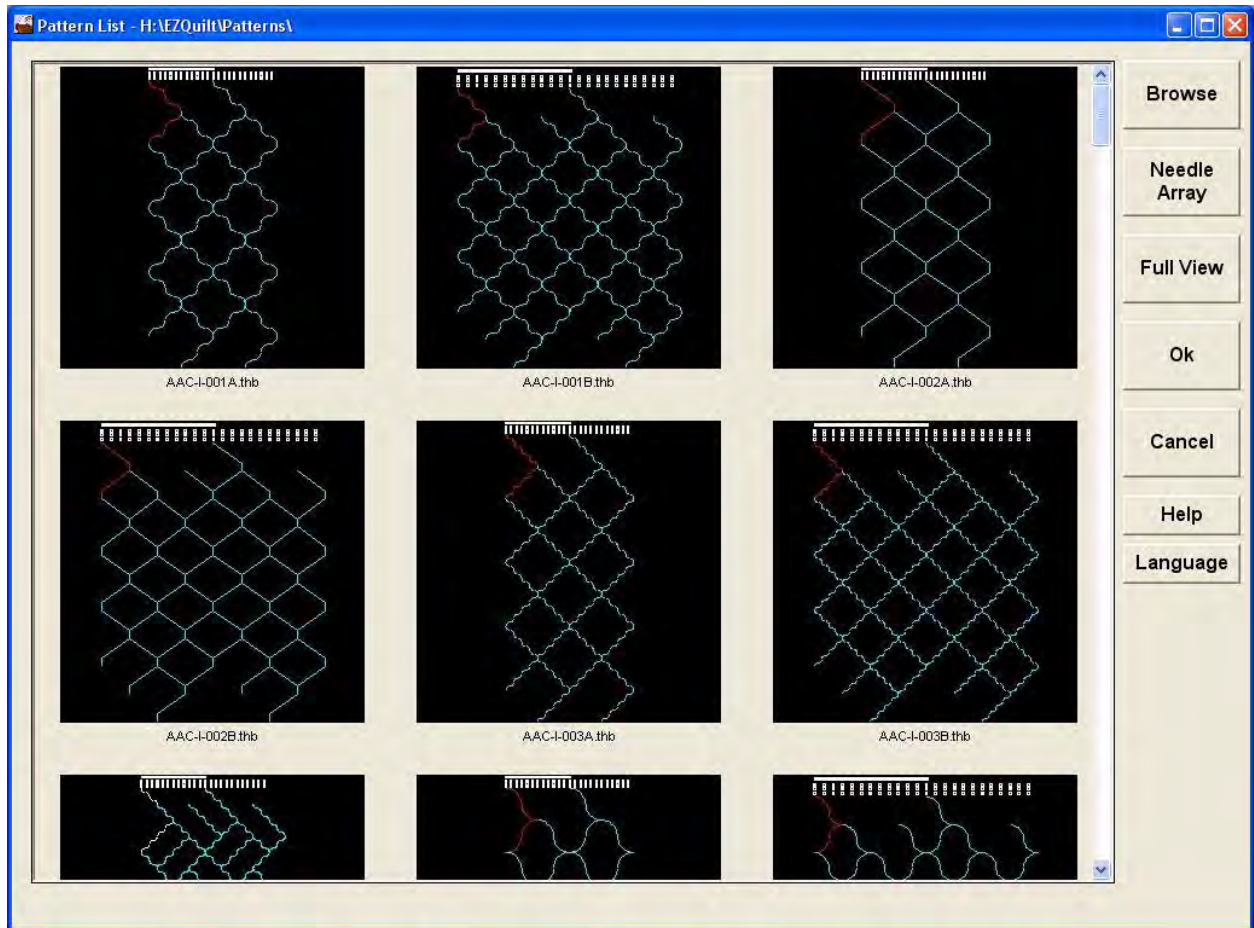
1. Width (X Axis) - Clicking the Arrow buttons increases or decreases the percentage in which the pattern will be stretched in that axis.
2. Length (Y Axis) - Clicking the Arrow buttons increases or decreases the percentage in which the pattern will be stretched in that axis.
3. Side Modification - Clicking the Arrow buttons increases or decreases the percentage in which the pattern is altered when the carriage (X Axis) moves toward Home. This is used to adjust the "roundness" of a circle.
4. Backwards Modification - Clicking the Arrow buttons increases or decreases the percentage in which the pattern is altered when the rollers (Y Axis) move in reverse. This is used to adjust the "roundness" of a circle.
5. Jump Modification - Clicking the Arrow buttons increases or decreases the percentage in which the Jump Move will be altered in the Y axis.

NOTE: Changes to these adjustments "on the fly" or when the machine is running is permissible but the changes will not take effect until the next repeat of the pattern.



Pattern List

The Pattern List Screen displays all the patterns in a particular directory or folder. Patterns may be viewed but not loaded while the machine is running.



In order to see more patterns in the selected directory use the vertical slide bar to the right of the graphics display area.

Single-clicking a pattern selects or highlights the pattern.

Clicking the Needle Array button displays the needle arrangement needed in the machine to achieve the selected pattern. If no pattern is selected it displays the Needle Array for the first pattern in the list.

Clicking the Full View button will bring up the Pattern (Full View) screen displaying a larger view of the pattern.

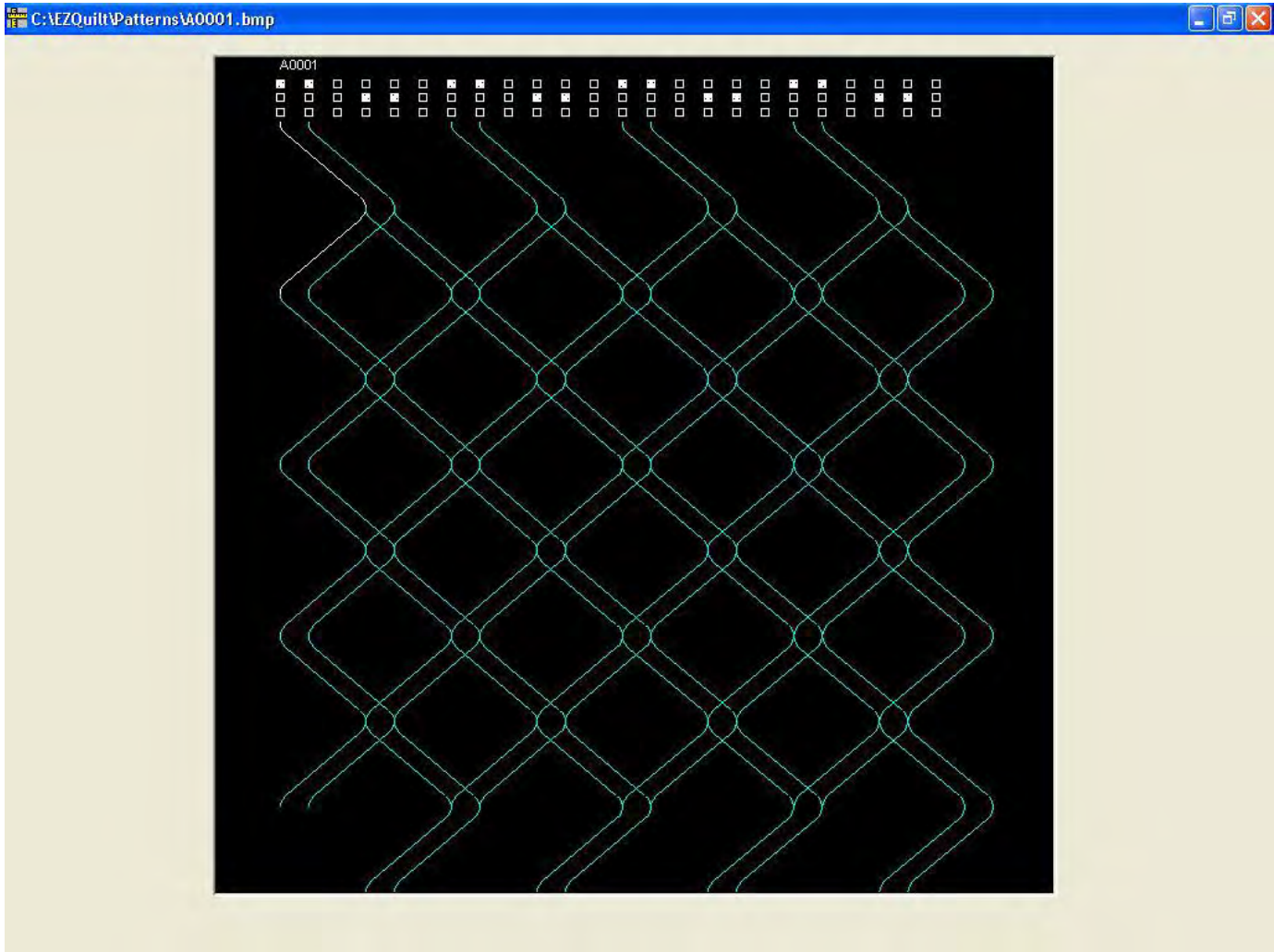
Clicking the OK button loads the selected pattern into the machine. If no pattern is selected it loads the first pattern in the list. If the servos were not turned off prior to selecting the Change Pattern button, a message will appear to allow you to turn them off. Then the new pattern must be reselected prior to pressing the Ok button.

Clicking the Cancel button returns you to the Main Run Screen.

Clicking the Browse button allows you to navigate to a different directory containing patterns.

Pattern (Full View)

The Pattern (Full View) Screen displays a larger more detailed view of the selected pattern. Clicking anywhere on the screen will return you to the previous screen.



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Needle Array

The Needle Array Screen displays the actual needle arrangement necessary to achieve the selected pattern. It only show 24 Out of the 97 needles in each row which is enough to display a recurring pattern. If the pattern is a "Sew & Jump", the Starting and Ending backtack is shown

Needle Array Codes are sequential numbers from NA00001 to NA99999. Each number represents a unique needle array. The needle array cannot be ascertained from the number only. Once a code is assigned that particular arrangement will always be associated with that code.

Stitches per Inch, Starting Backtack, and Ending Backtack values can be changed resulting in a permanent change to the pattern files and an automatic re-load of the pattern.

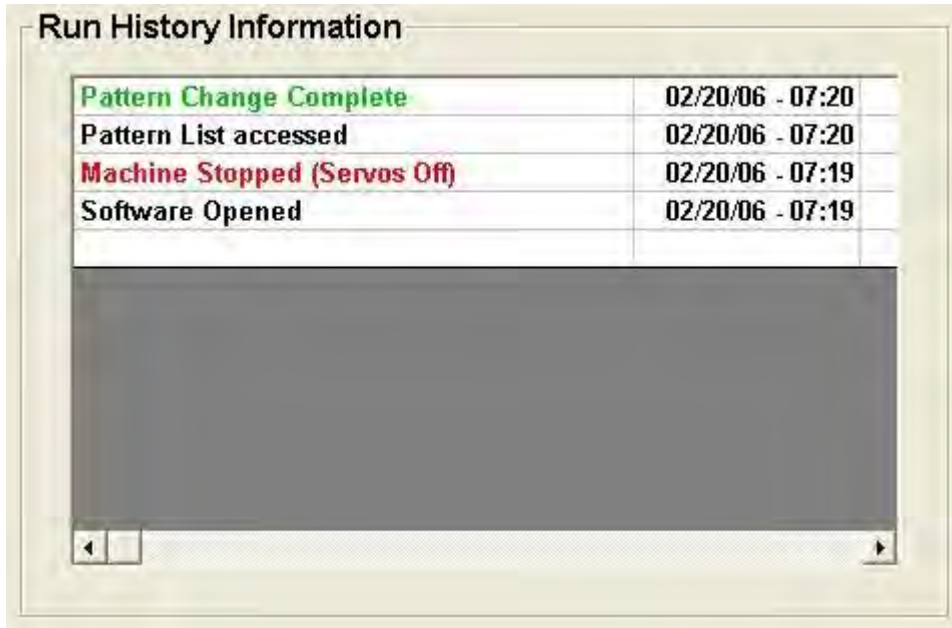


From the library of: Diamond Needle Corp

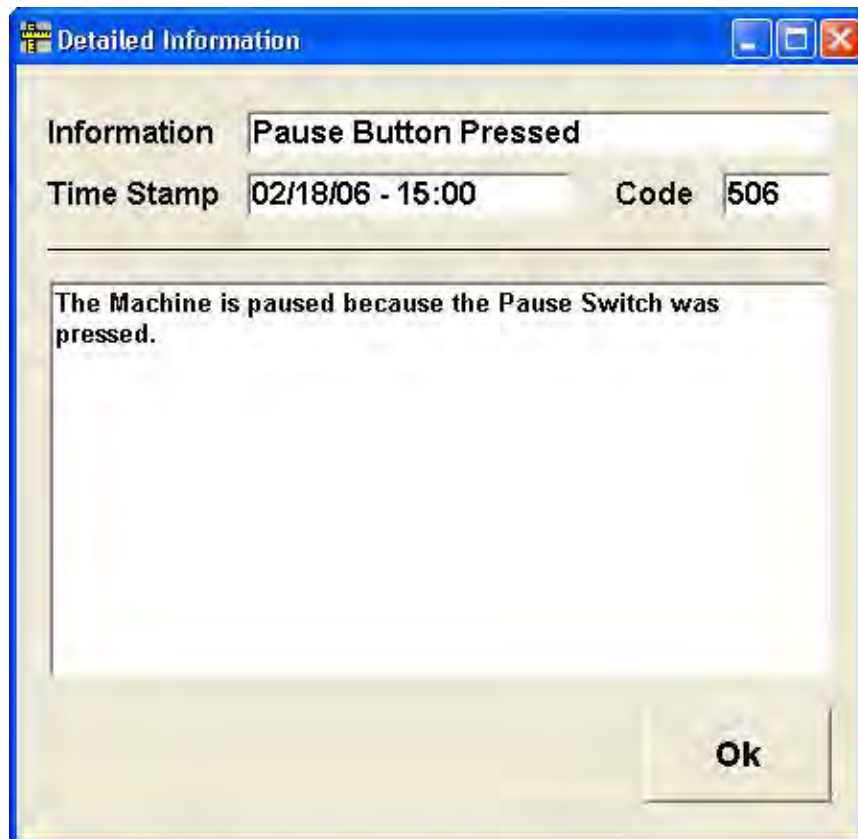


Run History

The Run History displays information, including a time stamp, concerning the operation of the machine. As shown above, this information consists of general information and/or errors. All the information displayed in this area is also written to a Log File which can be viewed on the Utilities Screen.

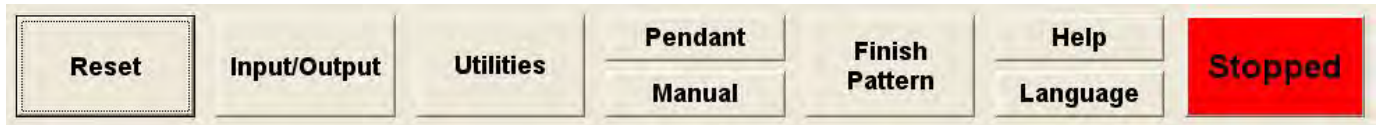


Clicking a particular line will display a message box containing more information concerning the selected line.



Command Buttons

The Command Buttons displayed along the bottom of the Main Run Screen provide user control of the machine and are as follows:



1. Reset / Servos On
2. Input / Output
3. Utilities
4. Pendant Mode
5. Manual
6. Finish Pattern - The Finish Pattern button pauses the machine at the end of a pattern. For "Sew & Jump" patterns the machine pauses at the end of a jump.
7. Help - Displays this Help file
8. Language
9. Start / Status

The Reset/Servos On button is located at the lower Left corner of the Main Run Screen.

When the Servos are Off this button displays the caption *Reset*. When the Servos are On this button displays the caption *Servos On*.

When the button's caption displays *Reset* the servos are OFF and the machine is inoperable. Clicking the button turns on power to the Servos and homes-out the machine.

CAUTION: the machine will move during the homing function.

When the button's caption displays *Turn Servos Off* the servos are ON and the machine is ready to run.

Clicking the button turns off power to the Servos.

NOTE: When the Servos are off none of the Machine Axes will move.

The *Input/Output* Screen allows you to see the current state of the Inputs and Outputs. It also allows you to activate/deactivate the Outputs.

NOTE: This screen is primarily used to test the Inputs and Outputs. If you manually change the state of an Input it will not have an affect on the machine. However, if you click on one of the Output buttons it will reverse its state (if it is on it will turn off or if it is off it will turn on).

Input Status

Air Pressure Sensor	Ok
Needle Up Sensor	On
Needle Thread Sensor	On
Looper Thread Sensor	On
Pause Switch	Off
Start Switch	Off
Material Sensor	Ok
Panel Cutter OK	Yes
Handwheel Guard	Closed
Fill / Backing Sensor	Ok
Front Door 1	Closed
Rear Door 1	Closed
Rear Door 2	Closed
Foot Height Range	Low
Right Limit Switch (X)	Ok
Left Limit Switch (X)	Ok
Pendant Selection	Auto
Pendant Buttons	Idle

Output Status

Servo Power	Off
Looper Thread Trim	Off
Needle Tension Release	Off
Looper Tension Release	Off
Bearing Lubrication	Off
Spiral Motor	Off
Front Pinch Roller	Off

Note for INPUT devices only
While on this screen activating the listed INPUT devices will not affect the machine.

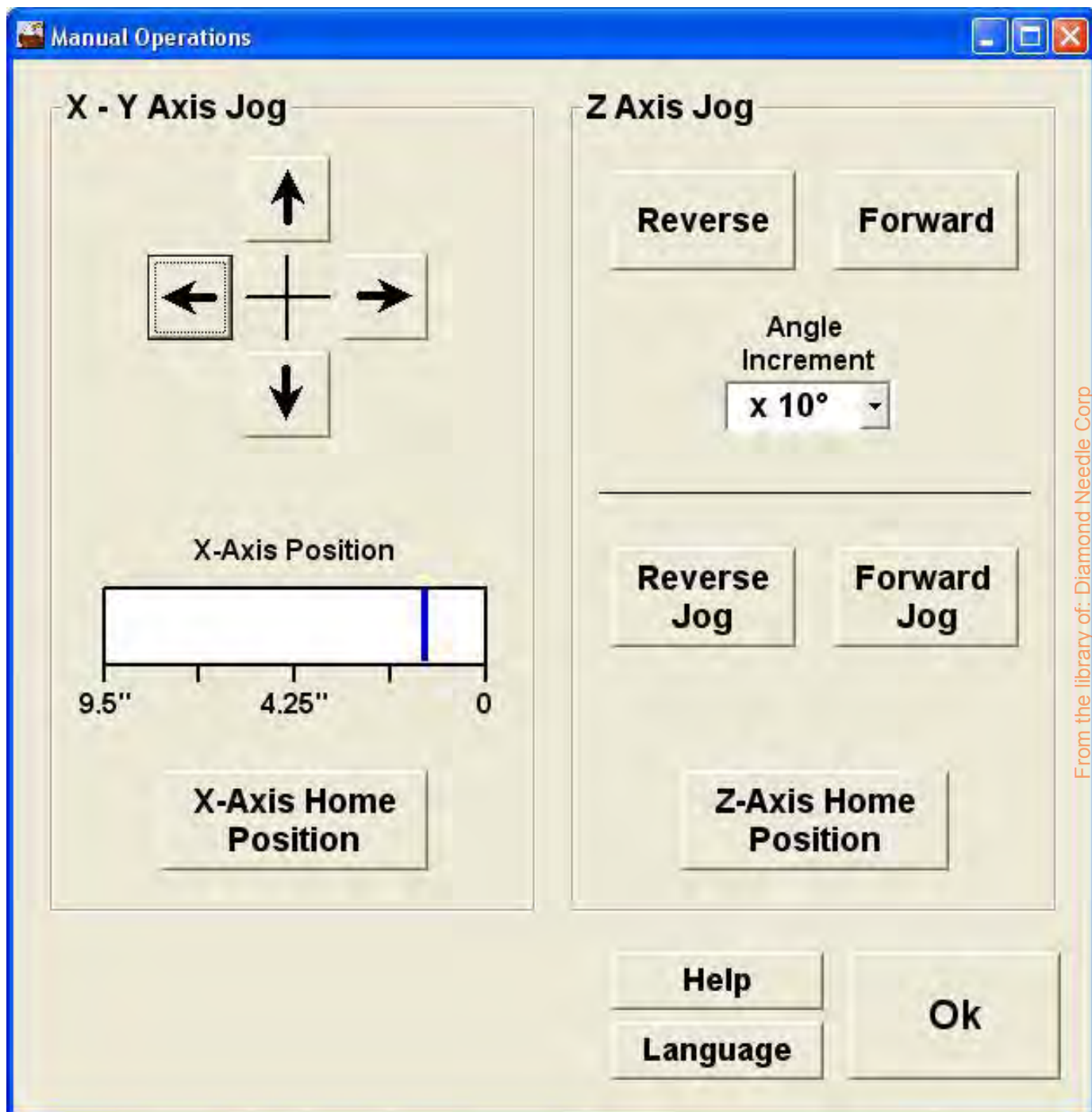
Help Language Ok

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The *Manual Operations* Screen allows you to move all three axes manually and independently.

NOTE: When moving the axes independently the synchronous relationship between them is lost. Therefore, when you exit this screen the machine will automatically Home-Out.

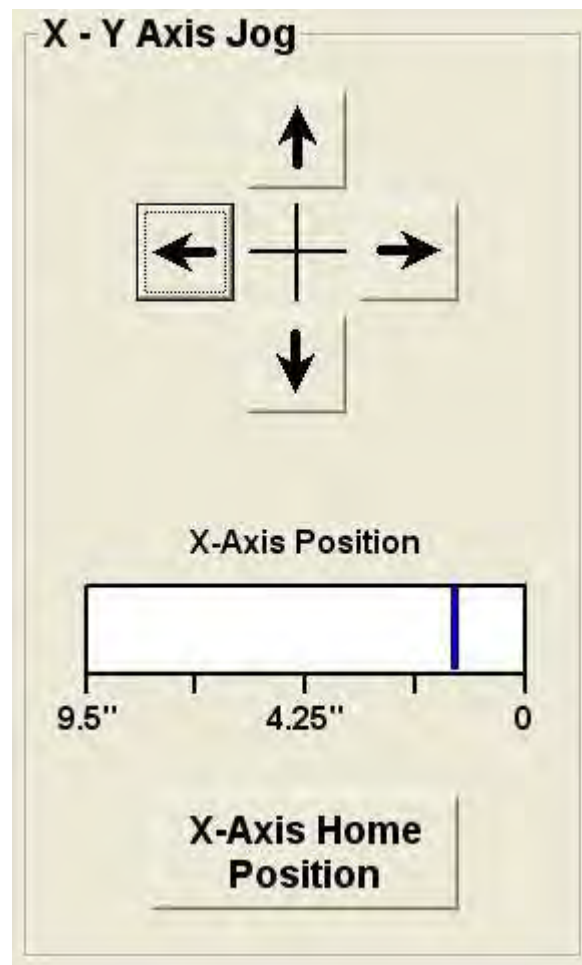


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1. X -Y Axis Jog - See "X-Y Axis Jog" on page 26.
2. Z Axis Jog - See "Z Axis Jog" on page 27.



X-Y Axis Jog

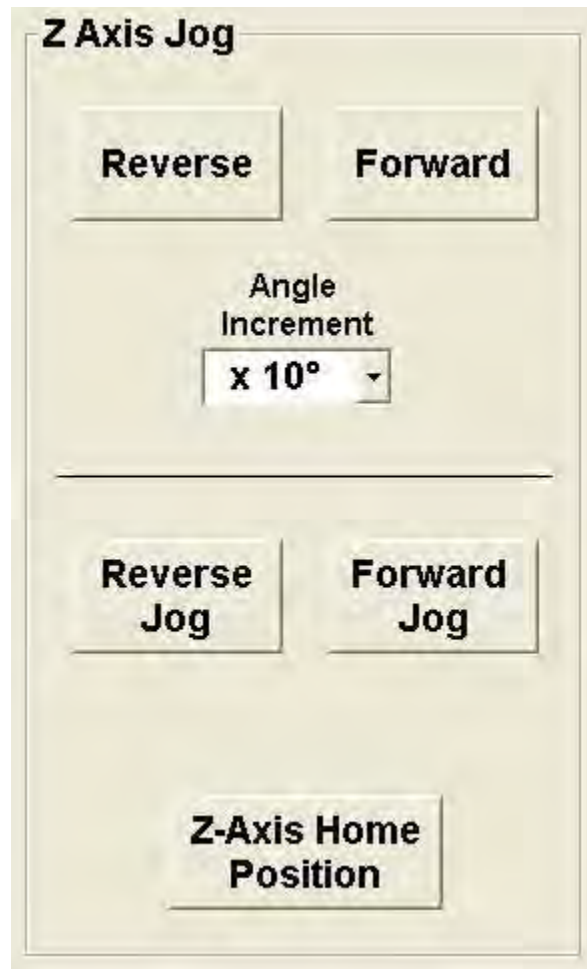


The Arrow buttons pointing left and right move the X-Axis (Carriage) in the Left and Right directions.

The Arrows buttons pointing up and down move the Y-Axis (Roller) in the Forward (Up) and Reverse (Down) directions.

The X-Axis Position then distance far the Carriage is from Home position (in inches).

Clicking the X-Axis Home Position button moves the X-Axis (Carriage) to its Home position. Only the X-Axis will move.

Z Axis Jog

The Reverse and Forward buttons move the Z-Axis (Needle) in the Reverse and Forward directions by the angular increment displayed above. Maximum reverse movement is 45 degrees.

The Reverse Jog and Forward Jog buttons move the Z-Axis (Needle) in the Forward and Reverse directions and will continue to move until the respective button is released.

Clicking the Z-Axis Home Position button move the Z-Axis (Needle) to its Home or needle-up position (zero degrees). Only the Z-Axis will move.

Pendant Operations

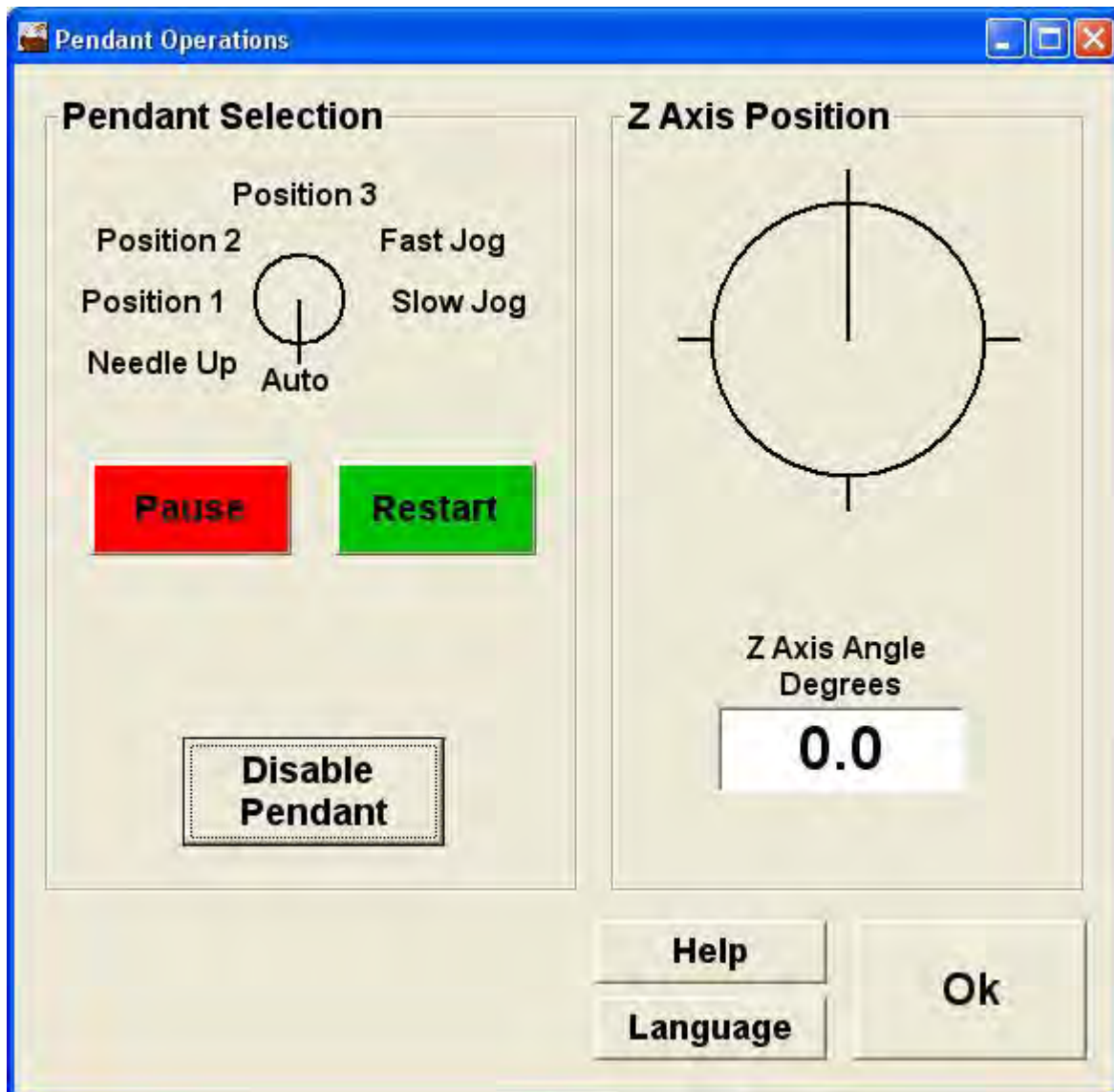
NOTE: For safety reasons, if the front door is open, the hand held pendant is disabled.

The Pendant Operations Screen duplicates the functionality of the physical Pendant attached to the machine. There are two ways to make this screen appear. One is to click the Command Button on the Main Run Screen. The second is to physically move the selector on the Pendant to any selection other than Auto.

NOTE: Regardless of what made this screen come up you have to click the Ok button to remove it (except in case of a Thread Break error).

Clicking the Disable Pendant button causes another button to appear labeled Index Pendant (see below). Clicking this button is the same as moving the selector on the physical Pendant. Clicking the red or green buttons above the Index Pendant button is the same as pressing buttons on the physical Pendant. Clicking the Pendant Disabled button re-enables the physical Pendant.

NOTE: If the Index Pendant button is visible, the physical Pendant is disabled.



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As you turn the selector the functions of the buttons change. See Table below.

Selector	Red Button	Green Button	Function
Auto	Pause	Restart	Start/Pauses machine
Needle Up	Pause	Execute	Moves machine to the Needle Up position
Position 1	Pause	Execute	Moves Z-Axis to user-defined position
Position 2	Pause	Execute	Moves Z-Axis to user-defined position
Position 3	Pause	Execute	Moves Z-Axis to user-defined position
Fast Jog	Reverse	Forward	Moves Z-Axis fast till button release. Max. 45° in reverse
Slow Jog	Reverse	Forward	Moves Z-Axis slow till button release. Max. 45° in reverse

The Z-Axis position area graphically and numerically displays the angular position of the Z-Axis as it moves.

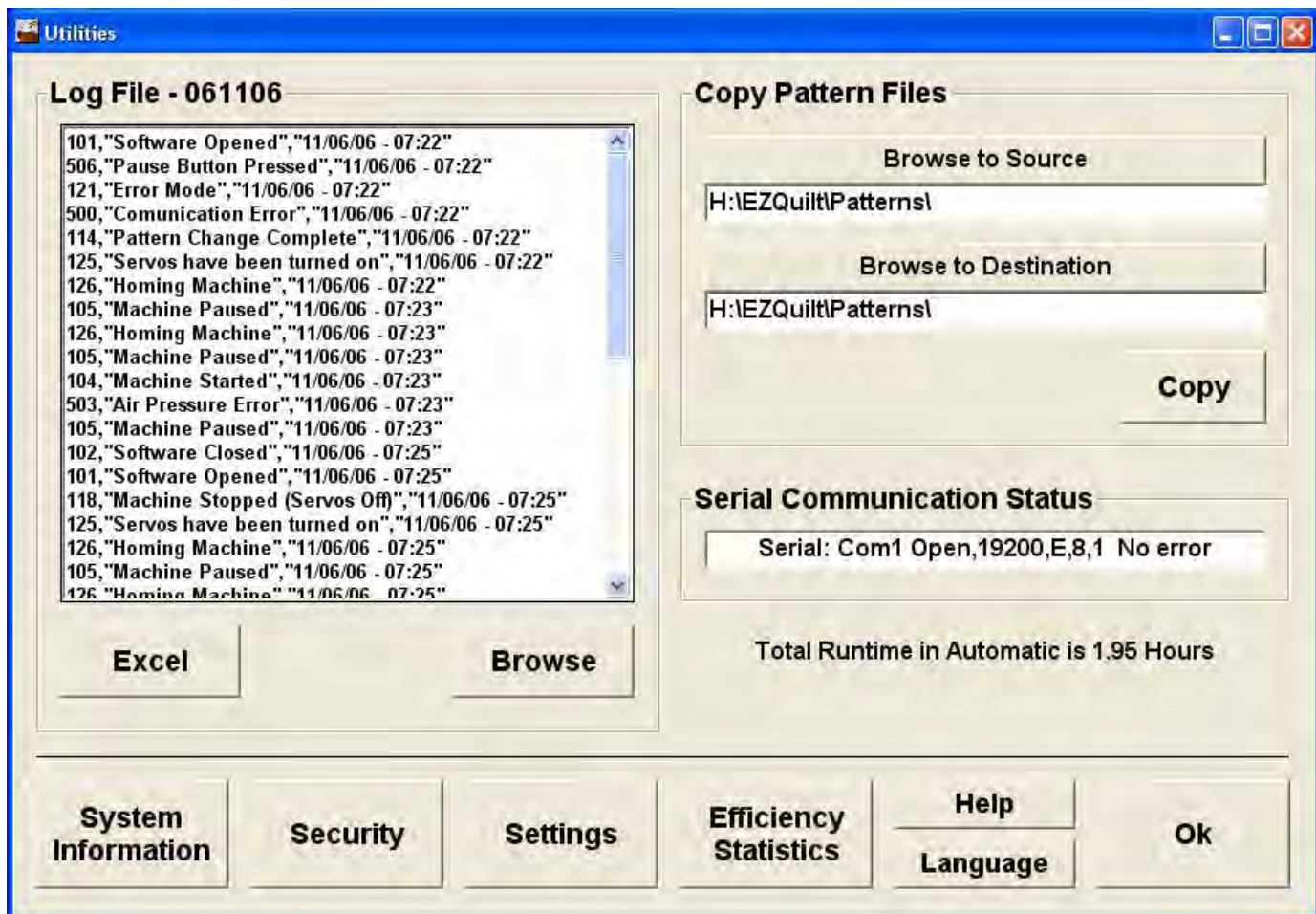
In case the Pendant becomes damaged or not functional for some reason this screen can perform the same functions as the physical Pendant.



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Utilities



As its name implies the Utilities Screen have several functions.

1. **Log Files** (See "Log Files" on page 31.)
2. **Copy Pattern Files** (See "Copy Pattern Files" on page 32.)
3. **Serial Communication Status** - Monitors communication between the PC and the Servo Controller.
4. **Total Runtime** - Total Runtime is only accumulated when the machine is actually running in Automatic mode.
5. **System Information** (See "System Information" on page 33.)
6. **Security** (See "Security" on page 34.)
7. **Settings** (See "Settings" on page 35.)
8. **Efficiency Statistics** (See "Efficiency Statistics" on page 40.)

The next few pages will provide more detail into each function.



Log Files



By default the Log File displayed is the file for the current day. Note the filename of the Log File is 060218.txt, this represents 02/18/06 or February 18th, 2006. 06 is the year, 02 is the month, and 18 is the day.

There is also a Error Log File which has the same filename except it is preceded with an E. Using the same example as above the Error Log filename would be E060218.txt. This file is mainly used for troubleshooting.

All Log Files are stored in a directory called C:\EZQuilt\Logs\.

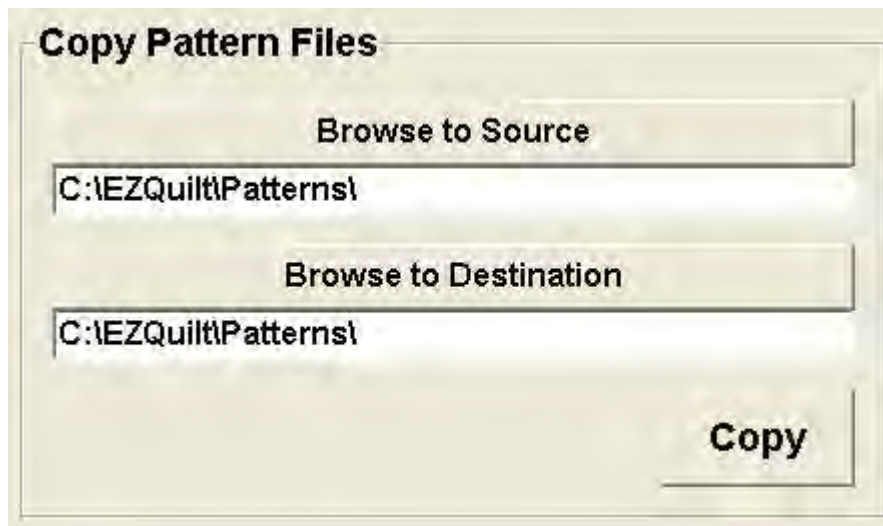
NOTE: Log Files are automatically deleted after a number of days defined by the "Keep Log Files for" Setting.

Clicking the Browse button allows you to navigate to a different Log file.

Clicking the Excel button allows you to open the current Log file in an Microsoft Excel spreadsheet.

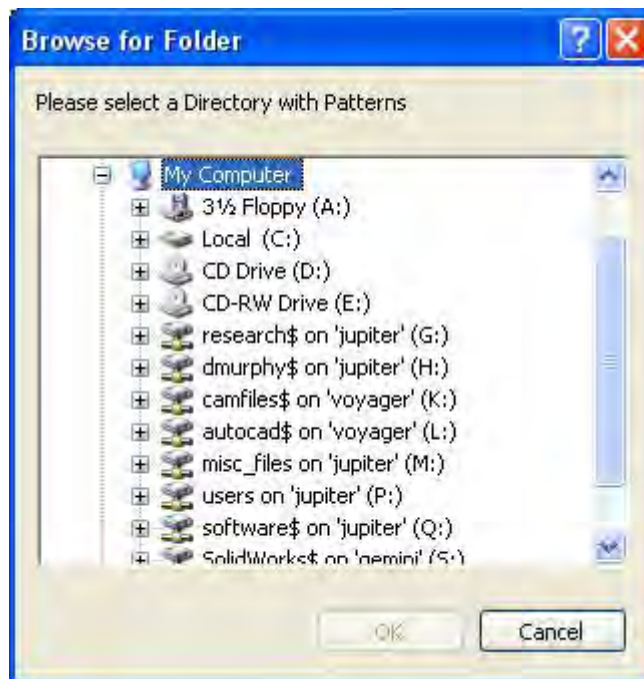
NOTE: For the Excel function to work Microsoft Excel has to be installed on this computer.

Copy Pattern Files



If new patterns are created on a different computer they have to be copied to the PC running the quilter. Since there are six separate files associated with each pattern this Copy function was developed to facilitate the process.

Browse to Source and *Browse to Destination* - Clicking either of these buttons will bring up the Browse screen which allows you to navigate to and select the appropriate directory.

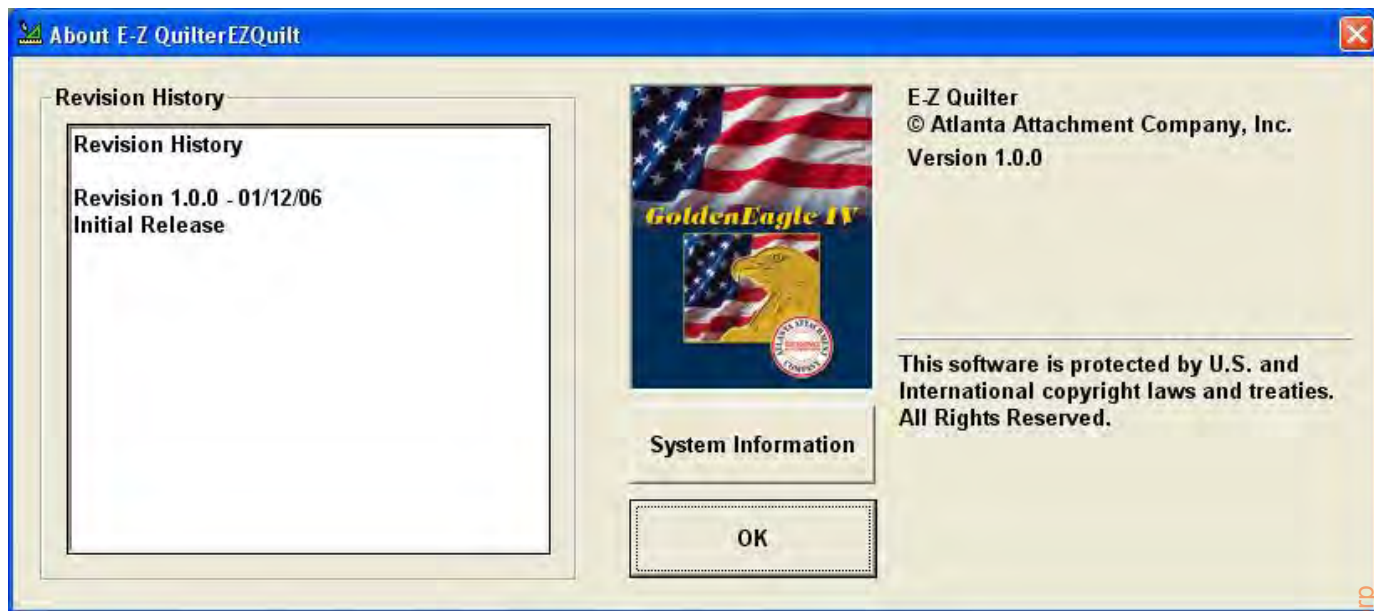


Source - The Source directory is the location where the files to be copied reside. Examples would be a memory stick, a floppy disk or a network drive.

Destination - The Destination directory is the location where the selected files will be copied to. Unless changed by the user this location should always be C:\EZQuilt\Patterns\

System Information

System Information shows Company Information and Revision History.



Clicking the System Information button displays configuration and hardware settings for the PC.

Note: In order to get to the Settings screen and various other functions an increased security level is required.

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Security



Security levels from lowest to highest are as follows:

1. Operator
2. Supervisor
3. Mechanic
4. Head Mechanic

Operator is the default level. There is no code for this level. When the machine is turned on it is always at this level.

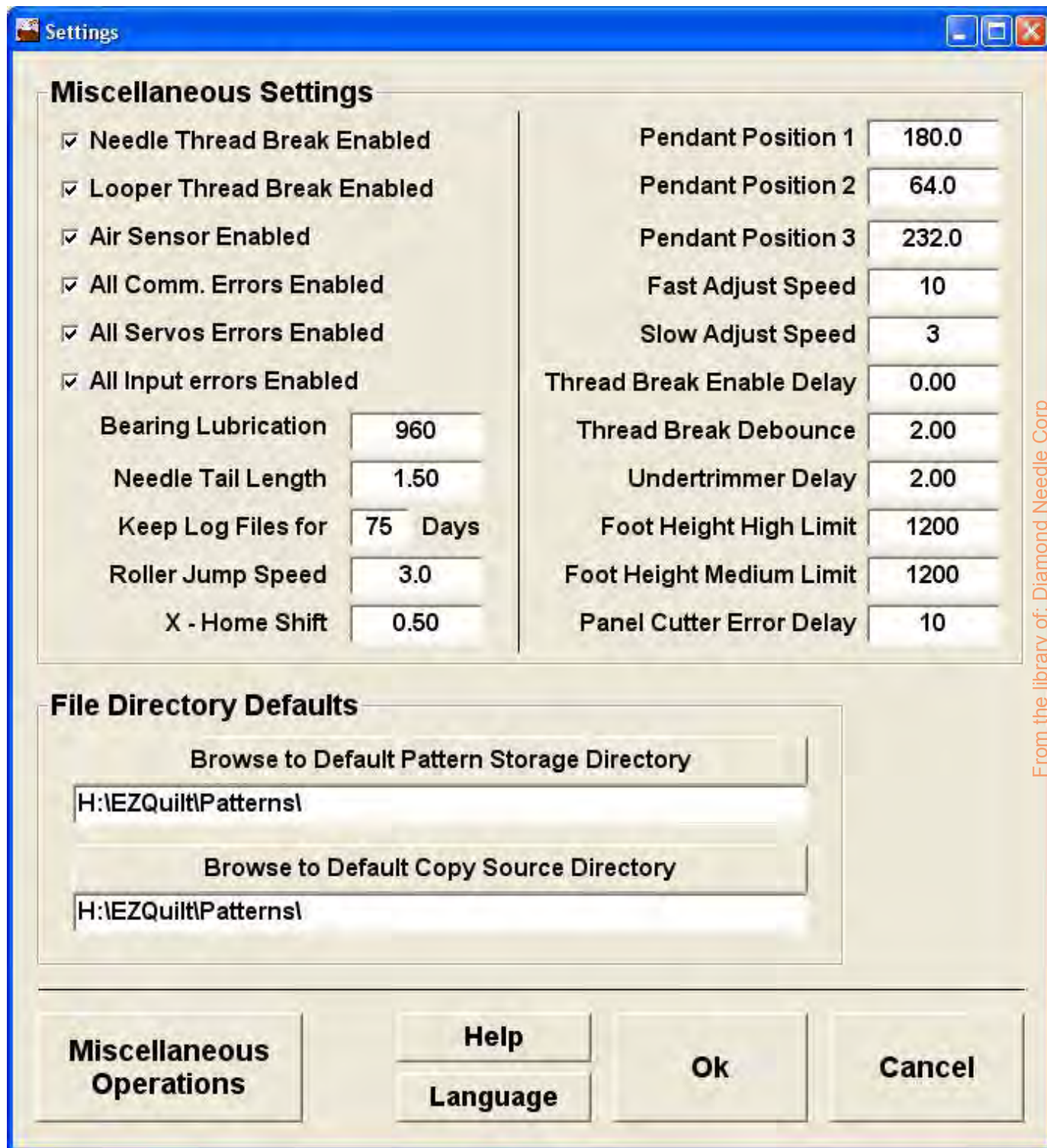
The codes can be changed for each level by following the instructions on the screen (see above).

NOTE: Once someone has raised the current security level to something other than Operator (for example to Mechanic) the machine will stay at this level until the machine is turned off or the Reset to Operator button is clicked.

Settings

The Settings screen allows you to make adjustments to various aspects of how the machine functions.

NOTE: A security level of Mechanic or higher is necessary to access this screen.



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The following pages provide more detailed information for each setting.



For the settings that have a check box a check in the box means the statement is true. For example, a check next to Air Sensor Enabled means that it is enabled and if air pressure drops below a certain point while the machine is running an error message box will be displayed.

The numeric settings have upper and lower limits. If you type in a number higher than the limit the entry will automatically change to the upper limit. The same happens with the lower limit, it will automatically change to the lower limit.

For the numeric settings clicking on the name of the setting displays a message box containing an explanation of that particular setting.

Needle Thread Break Enable

The machine is equipped with Needle Thread Break Detectors. Sometimes during setup or for troubleshooting it is convenient for the machine not to stop if a thread break occurs. Removing the check mark disables the Needle Thread Breaks.

Looper Thread Break Enable

The machine is equipped with Looper Thread Break Detectors. Sometimes during setup or for troubleshooting it is convenient for the machine not to stop if a thread break occurs. Removing the check mark disables the Looper Thread Breaks.

Air Sensor Enable

The machine is equipped with an Air Pressure Sensor. Sometimes during setup or for troubleshooting it is convenient for the machine not to stop if the air pressure is low or off. Removing the check mark disables the Air Sensor.

NOTE: All air activated devices such as the Undertrimmer will not function correctly without proper air pressure.

All Communication Errors Enable

There are two channels of communication in the machine. The PC communicates with the Servo Controller and the Servo Controller communicates with the Servo Motors. Removing the check mark disables all the communication errors. This is only used in initial setup or troubleshooting of the machine.

All Servo Errors Enable

There are three Servo Motors on the machine the X, Y and Z axis. If an error occurs at the motor level it can be ignored by removing the check mark thus disabling all servo errors. This is only used in initial setup or troubleshooting of the machine.

All Input Errors Enabled

Most error conditions need only be active while the machine is Running. For example if the machine is currently Paused you would not want an error message if a door were opened. Removing this check mark disables all errors pertaining to input devices that do not have an individual setting such as thread breaks. An example would be opening a door.

Bearing Lubrication Interval

The machine is equipped with a automatic lubrication device. This device sends lubricant to various points on the machine. This setting controls how often the device sends lubricant and is based on actual machine runtime.

Runtime is only accumulated when the machine is actually running in Automatic mode.



Needle Tail Length

When running a Sew & Jump pattern and the first repeat is finished the machine must move to the next pattern repeat. During this move a Needle Tail must be created in order to start sewing the next repeat properly. This is accomplished by moving this setting's distance, pausing the move just long enough for the Undertrimmer to activate, then continuing the move.

Limits: Minimum - 0.75 Maximum - 2.00 Default - 1.50
Unit of Measure - Inches

Log Files are automatically deleted after the number of days defined by this setting.

Roller Jump Speed

Roller Jump Speed is the feed rate that the Y-Axis (Roller) moves the material between pattern repeats when running a Sew and Jump pattern.

Limits: Minimum - 50 Maximum - 250 Default - 200
Unit of Measure - RPM

X - Home Shift

When using Size Adjustments to stretch a pattern sometimes the changes cause the machine to move to farther to the right possibly causing a Right Limit Switch error. When this amount of adjustment is necessary the X - Home Shift setting needs to be increased. A machine reset is required if the setting is changed.

Limits:
Minimum - 0
Maximum - 2.00
Default - .50

Unit of Measure - Inches

Pendant Positions 1, 2, and 3

Pendant Positions 1, 2, and 3 are user settable needle timing positions. These positions can be set to whatever angle you find convenient. These settings are used only in conjunction with Pendant Mode.

Limits: Minimum - 0 Maximum - 359 Default -Various
Unit of Measure - Angular Degrees

Fast Speed Adjust (Jog)

Fast Speed Adjust (Jog) is only used in Pendant and Manual Mode and is the faster of the two speeds the Z-Axis (Needle) moves when activated in either of these modes.

Limits: Minimum - 0 Maximum - 20 Default - 10
Unit of Measure - RPM

Slow Speed Adjust (Jog)

Slow Speed Adjust (Jog) is only used in Pendant and Manual Mode and is the slower of the two speeds the Z-Axis (Needle) moves when activated in either of these modes.

NOTE: If Slow Speed is set to a value higher than Fast Speed then Slow Speed is automatically changed to equal the Fast Speed. Therefore, Slow Speed can never exceed Fast Speed.

Limits: Minimum - 0 Maximum - 10 Default - 5
Unit of Measure - RPM

Thread Break Enable Delay

When the machine is not running the Thread Break eyes are dark as in an actual Thread Break condition. When the machine starts running, it takes a few seconds for the thread detection devices to report properly. This setting delays when the Needle and Looper Thread Breaks become active.

Limits: Minimum - 0 Maximum - 5.0 Default - 1.0
Unit of Measure - Seconds

Thread Break Debounce

When the machine is not running the Thread Break eyes are dark as in an actual Thread Break condition. Therefore, Needle and Looper Thread Breaks are not active until the machine has been running for the time set by the Thread Break Enable Delay setting. During the process of sewing the needle and looper thread may loosen or tighten causing the Thread Break Detect eyes to go dark. The Thread Break Debounce gives the thread time to "settle down" in order to report an actual thread break. If this number is set too low you may get false thread break errors. Conversely, if set to high, several stitches may pass before the operator is alerted.

Limits: Minimum - 0 Maximum - 5.0 Default - 1.0
Unit of Measure - Seconds

Undertrimmer Delay

The Undertrimmer is the knife mechanism under the needle plate that trims the needle thread when needed. The Undertrimmer activates during a jump move in a Sew and Jump pattern. During the jump portion of a Sew and Jump pattern, the machine stops after it has moved the Needle Tail Length distance. The machine then stops to allow for the Undertrimmer to activate. The Undertrimmer Delay is the amount of time the jump move is delayed to allow the Undertrimmer to cut the needle thread. Once undertrimming is complete the machine continues the jump move.

Limits: Minimum - 1.00 Maximum - 4.00 Default - 2.00
Unit of Measure - Seconds

Foot Height High Limit

The maximum RPM allowed with the foot in the High position.

Limits:
Minimum - 0
Maximum - 1275
Default - 500

Unit of Measure - RPM



Foot Height Medium Limit

The maximum RPM allowed with the foot in the Medium position.

Limits:

- Minimum - 0
- Maximum - 1275
- Default - 500

Unit of Measure - RPM

Panel Cutter Error Delay

The amount of time from when the Panel Cutter sensor is covered till an error is displayed.

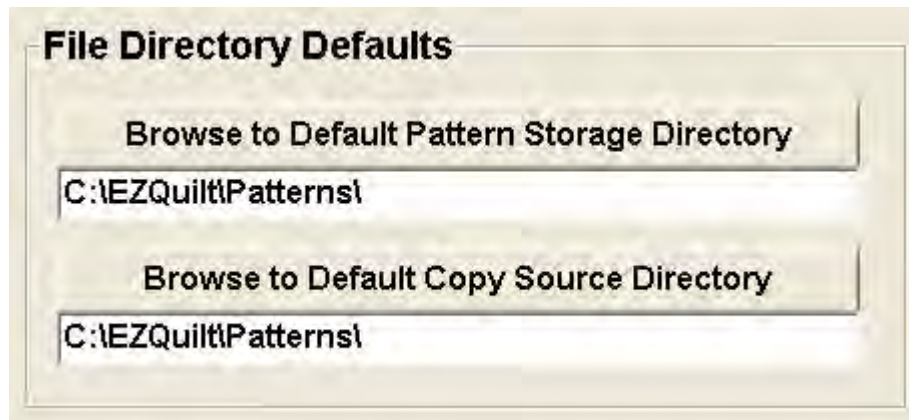
Limits:

- Minimum - 0
- Maximum - 60
- Default - 10

Unit of Measure - Seconds

File Directory Defaults

As seen in the Copy Pattern Files section, new patterns have to be copied to the PC running the quilter in order to be used. If you normally copy from (Source) and/or to (Destination) the same places you can set the defaults (shown above) so that any time the Copy Pattern Files section is accessed it will be pre-populated with the appropriate data and Browsing will not be necessary.



Miscellaneous Operations

Continuous Bearing Lubrication is used to prime or purge the lubrication lines. Clicking the Continuous Bearing Lubrication button continually pumps lubricant to the machine until the button is pressed again to turn it off.



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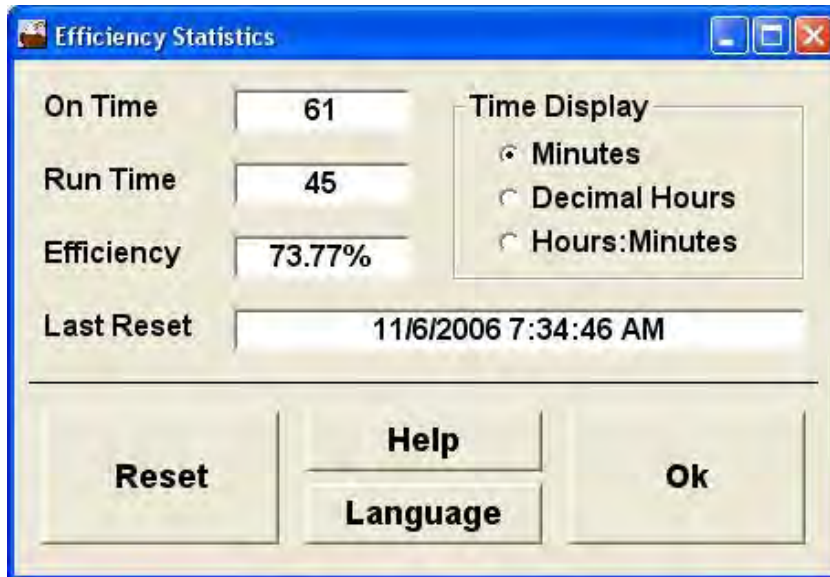


Efficiency Statistics

Efficiency Statistics are calculated based on the amount of time the machine is in Run Mode (sewing) divided by the amount of time the machine is turned on.

Time Display changes the format the On and Run times are displayed in.

The Last Reset box displays the last time the Reset button was pressed resetting the On and Run Times to 0 (zero).



Assembly Drawings & Parts Lists

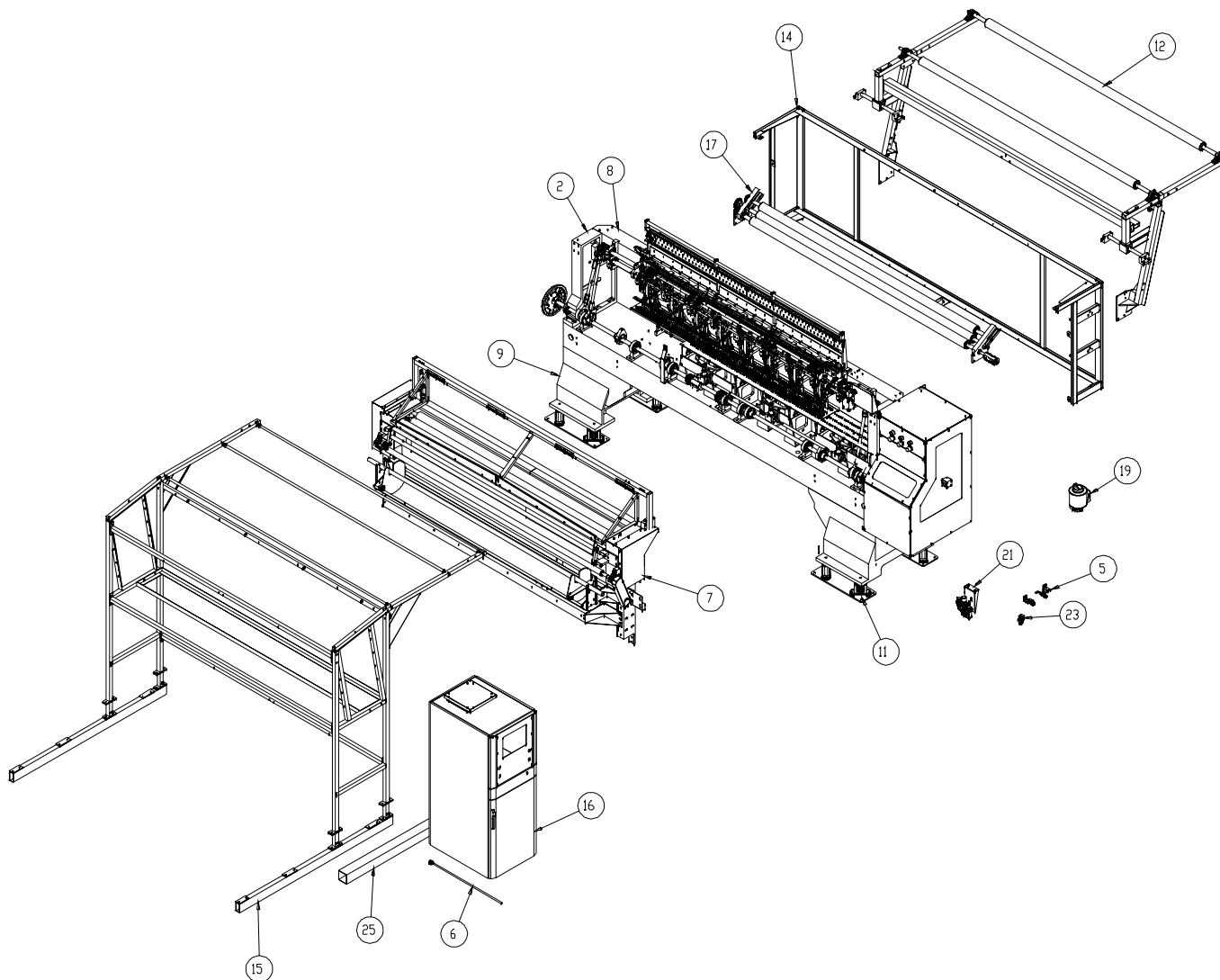
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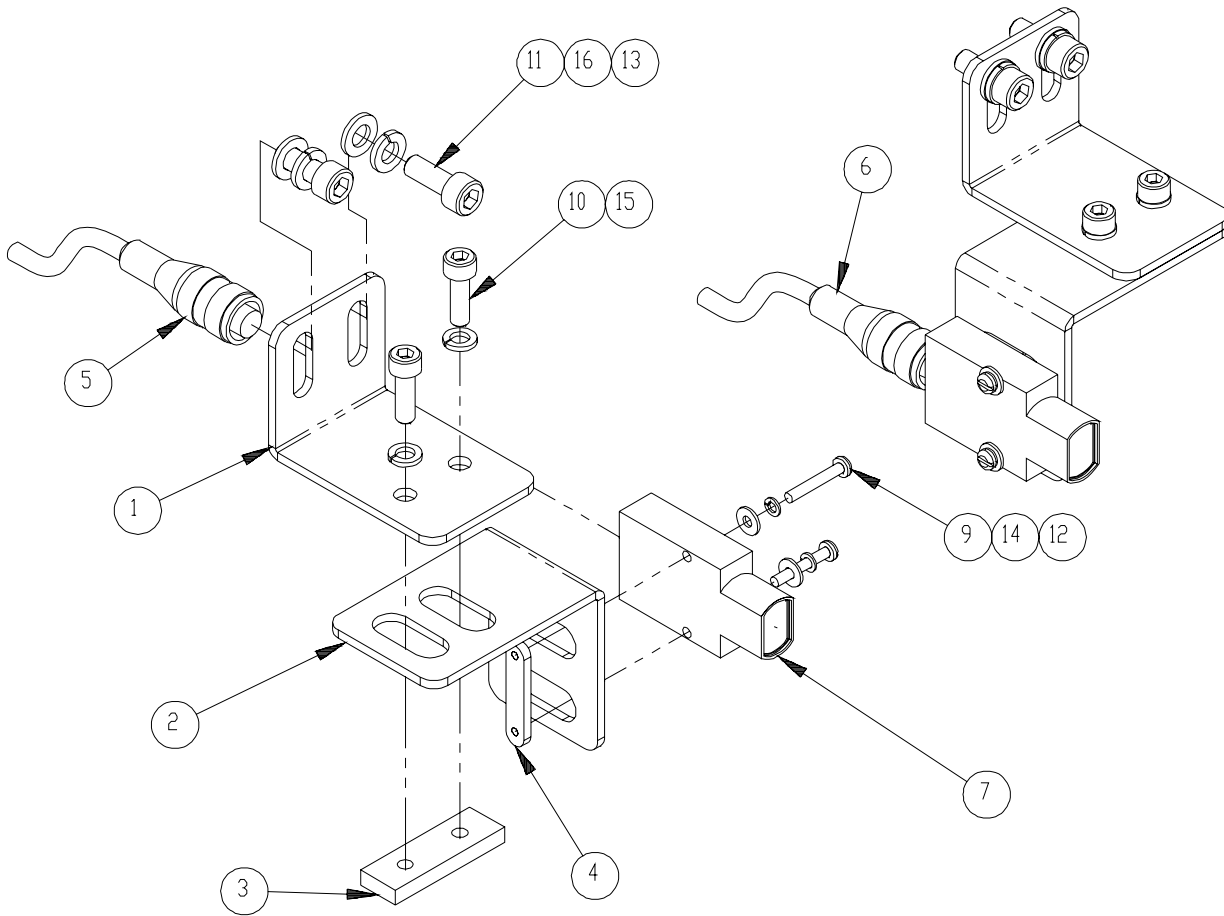


11392C Main Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389021	BASE, SUPPORT, RIGH SIDE	1		15	1392195	THREAD STAND ASM	1	52
2	1389022	BASE, SUPPORT, LEFT SIDE	1		16	1392364	CABINET, CONTROL, ASM	1	53
3	1389070	WLDMT,RR GUARD BRACE	1		17	1392392	LH ROLL DRIVE ASSY	1	54
4	1389072	BRKT,REAR GUARD BRACE	1		18	1392405	GUARD, MOTOR ASM	1	
5	1389234	PANEL CUTTER EYE ASSY	1	44	19	1392415	LUBRICATION ASSY	1	56
6	1389396	TENSION ADJUST ROD ASM	1		20	1392565	BRACKET,NDL UP SENSOR	1	
7	1389533	FRONT END ASSEMBLY	1	45	21	1393854	FRL ASSEMBLY, 1392	1	57
8	1389534	BRIDGE ASSEMBLY	1	46	22	1393940	VALVE/REGULATOR ASSY	1	58
9	1389556	BASE ASSEMBLY W MTRS	1	47	23	2-081	DRIVE ARM, REAR BTRFLY	1	
10	1389566	THROAT PLATE ASSY	1	48	24	5-033	SHAFT, RODEND	1	
11	1389740	ISOLATOR BASE ASSY	4	49	25	MM8130K152	RACEWAY,4 X 60	1	
12	1392028	TRANSFER CARR ASSY	1	50	26	1389183	REGULATOR ASSY	1	
13	1392074	BRACE, FRONT, OFFSET	1		AAC Drawing Number 9000772 Rev. 1				
14	1392185	REAR CLOSURE ASSY	1	51					

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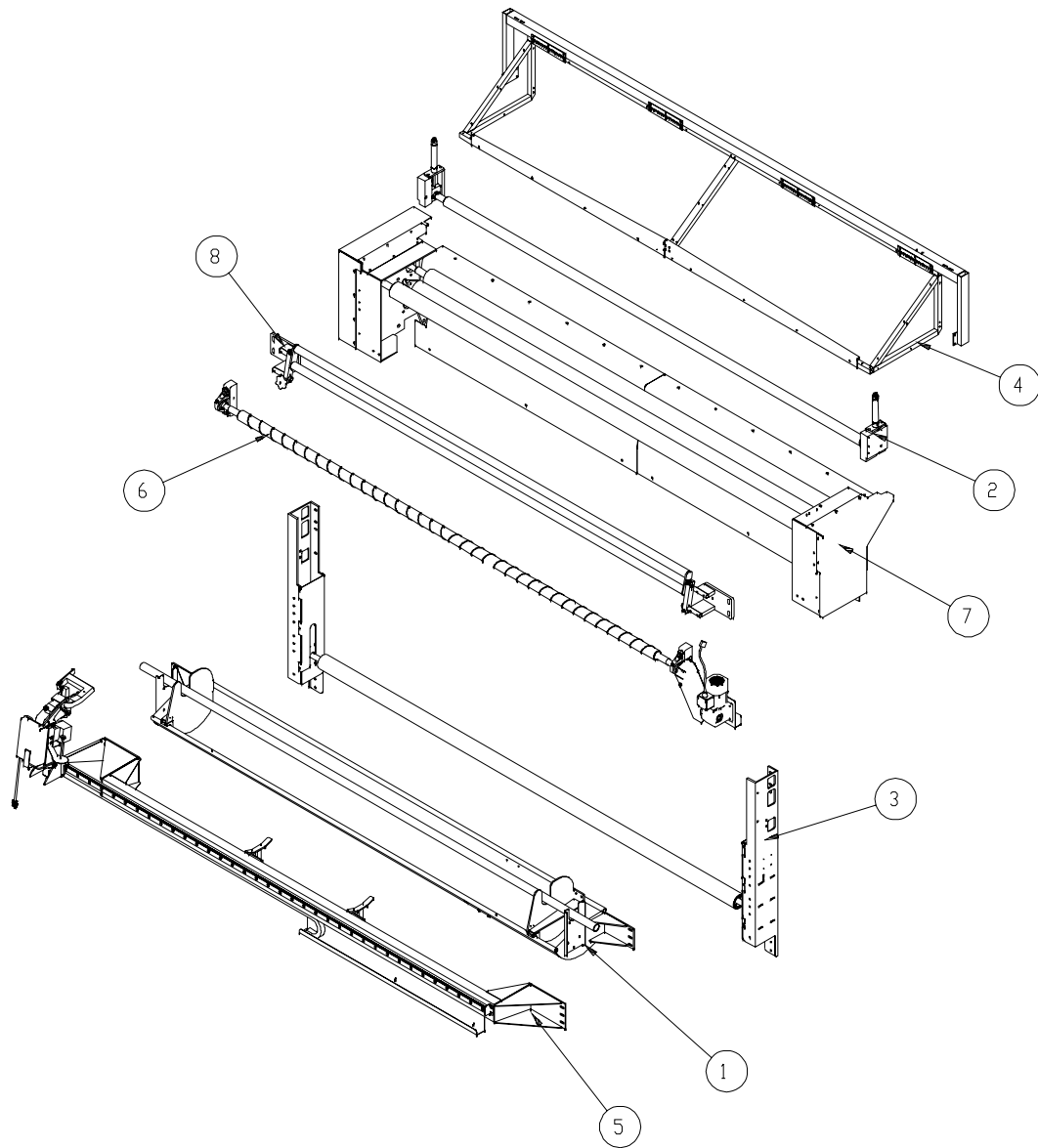
1389234 Panel Cutter Eye Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389231	BRKT,UPPER,PC OK EYE	2		10	SSSCM5X16	M5-0.8 X 16 SOC CAP	4	
2	1389232	BRKT,LOWER,PC OK EYE	2		11	SSSCM6X16	M6-1.0 X 16 SOC CAP	4	
3	1389233	PLATE,NUT,M5@2X20MM	2		12	WWF4	WASHER, FLAT #4	4	
4	1975-412A	PLATE,NUT,4-40@.96 CTC	2		13	WWFM6	6MM FLAT WASHER	4	
5	FFRK44T-4	CABLE,EYE,12',NO END	1		14	WWL4	#4 LW	4	
6	FFRK44T-6	CABLE,EYE,19',NO END	1		15	WWLM5	M5 LOCK WASHER	4	
7	FFSM312LVQ	BANNER MINI-BEAM	2		16	WWLM6	M6 LOCK WASHER	4	
8	MMT9945	TAPE,REFLECTIVE	12"						
9	SSPS70048	#4-40 X 3/4 PAN HD SLOT	4						

Rev. 0

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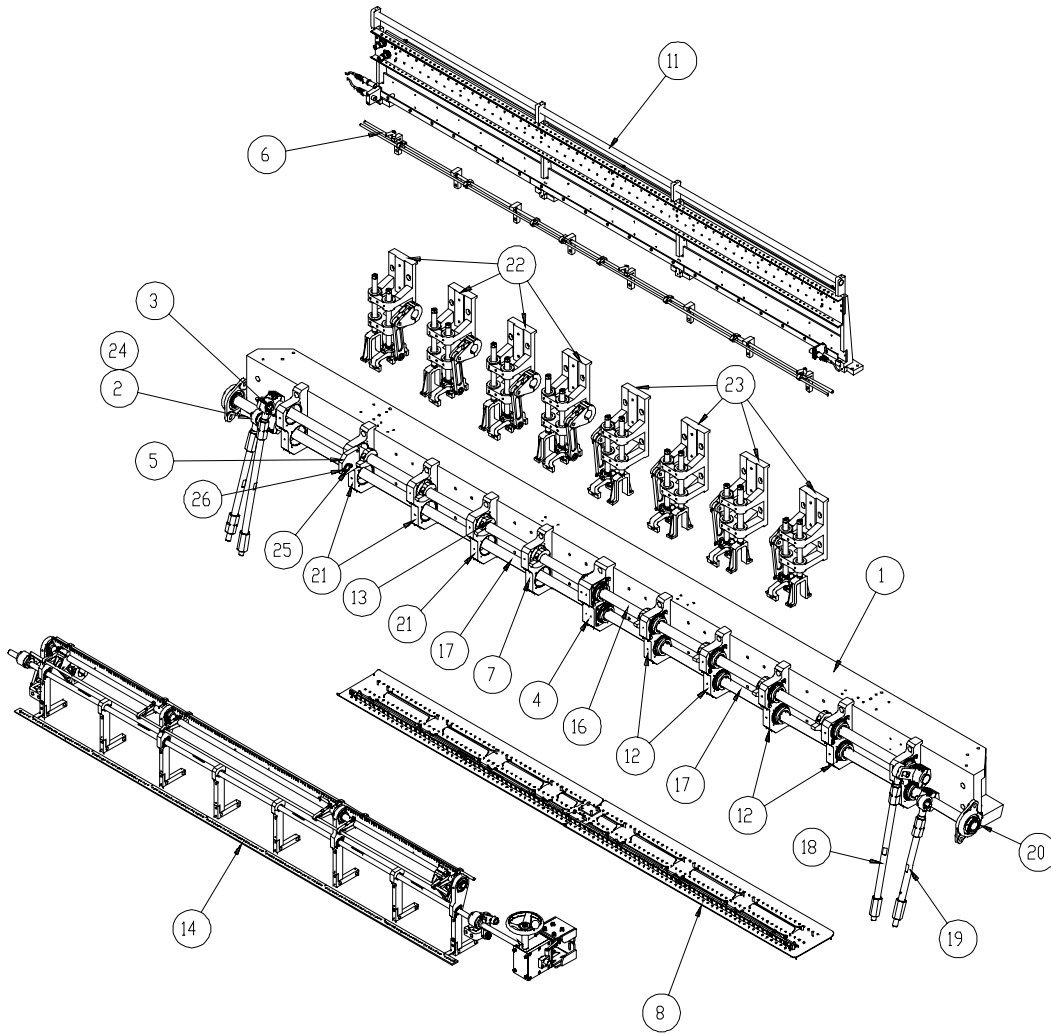


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1389533 Front End Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392087	TRAY ASSEMBLY, FRONT	1	59	6	1392897	PLEAT PREVENTION ASM	1	64
2	1392306	ROLLER LIFT ASSEMBLY	1	60	7	1392978	FRONT FEED ASSY.	1	65
3	1392448	TENSION ROLLER ASSY	1	61	8	1393922	TENSIONER ASSEMBLY	1	66
4	1392503	FRONT GUARD ASSY,1392B1		62					
5	1392580	BAG CLOSING MOUNT ASM1		63					
						Rev. 0			





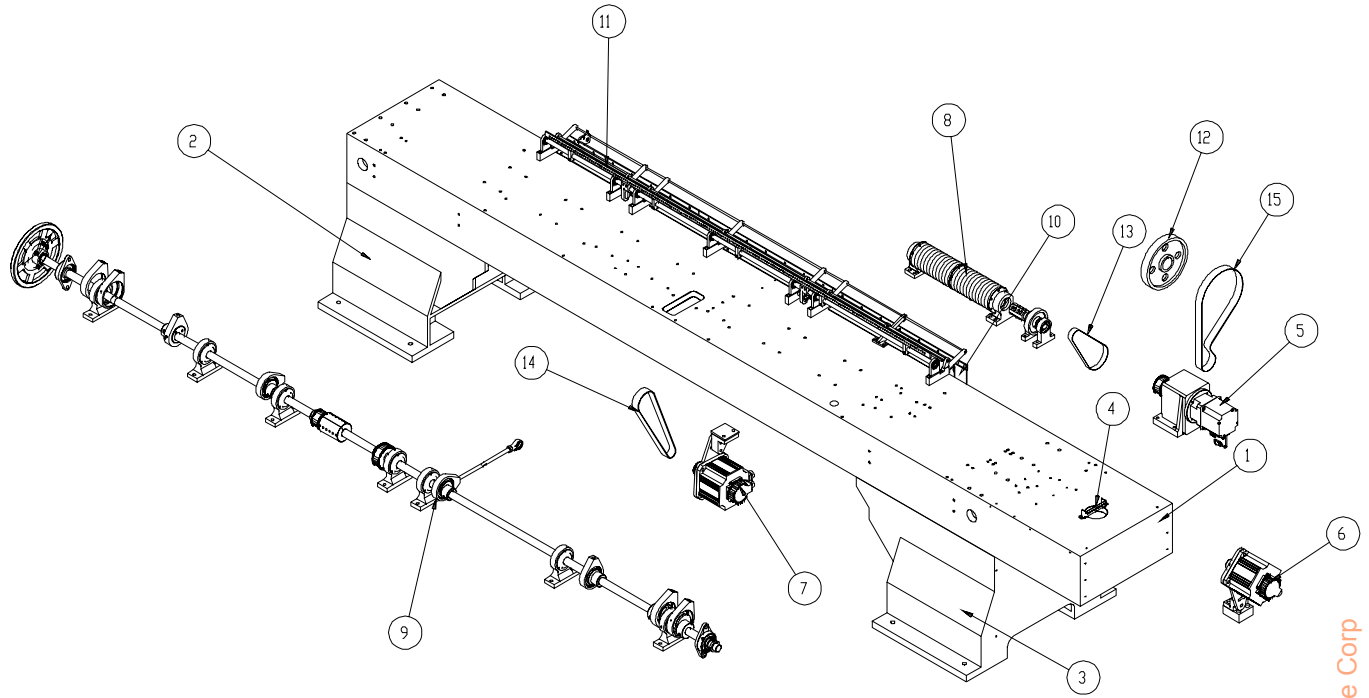
1389534 Bridge Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1-006C	TOP BRIDGE BEAM	1		15	1393867	P.FOOT SHAFT LEVER	2	
2	1-008	ROD END HOUSING	4		16	1393977	SHAFT, 40MM, PRESS FT	1	
3	1-009A	SHAFT, NEEDLE DRIVE	2		17	1393978	40MM SHAFT, NEEDLE BAR	2	
4	1389023	MOUNT,INSERT BRG	1		18	1393983	TIE ROD ASSEMBLY,PFOOT	2	71
5	1389026	SUPPORT,ADJ FOOT SHFT	1		19	1393986	TIE-ROD ASSEMBLY,NDL	2	72
6	1389073	ADJ NDL THD TAKEUP	1	67	20	1393987	BEARING,FLANGE,2BOLT	2	
7	1389246	MOUNT,INSERT BRG,LH	1		21	1393994	MOUNT,INSERT BRG,ASM	4	
8	1389509	PRESS FT AND NDL BARS	1	73	22	1393998	DRIVE,NDL & PS FT ASM	4	68
9	1389704	NDL SHAFT LEVER	2		23	1393999	DRIVE,NDL & PS FT ASM	4	69
10	1389705	PIN,PIVOT,NDL DR LEVER	2		24	BB63032RS	BEARING, RADIAL SEALED	4	
11	1392124	NEEDLE THREAD MNT ASM	1		25	BBGE20ES2RS	BEARING,SPHER PLAIN	1	
12	1393748	MOUNT,INSERT BRG	5		26	SSBCM5X8	M5 X 8MM BUT HEAD	2	
13	1393749	CAM, PRESS FOOT DRIVE	8						
14	1393864	FOOT ADJUSTMENT ASSY	1	74					

Rev. 1

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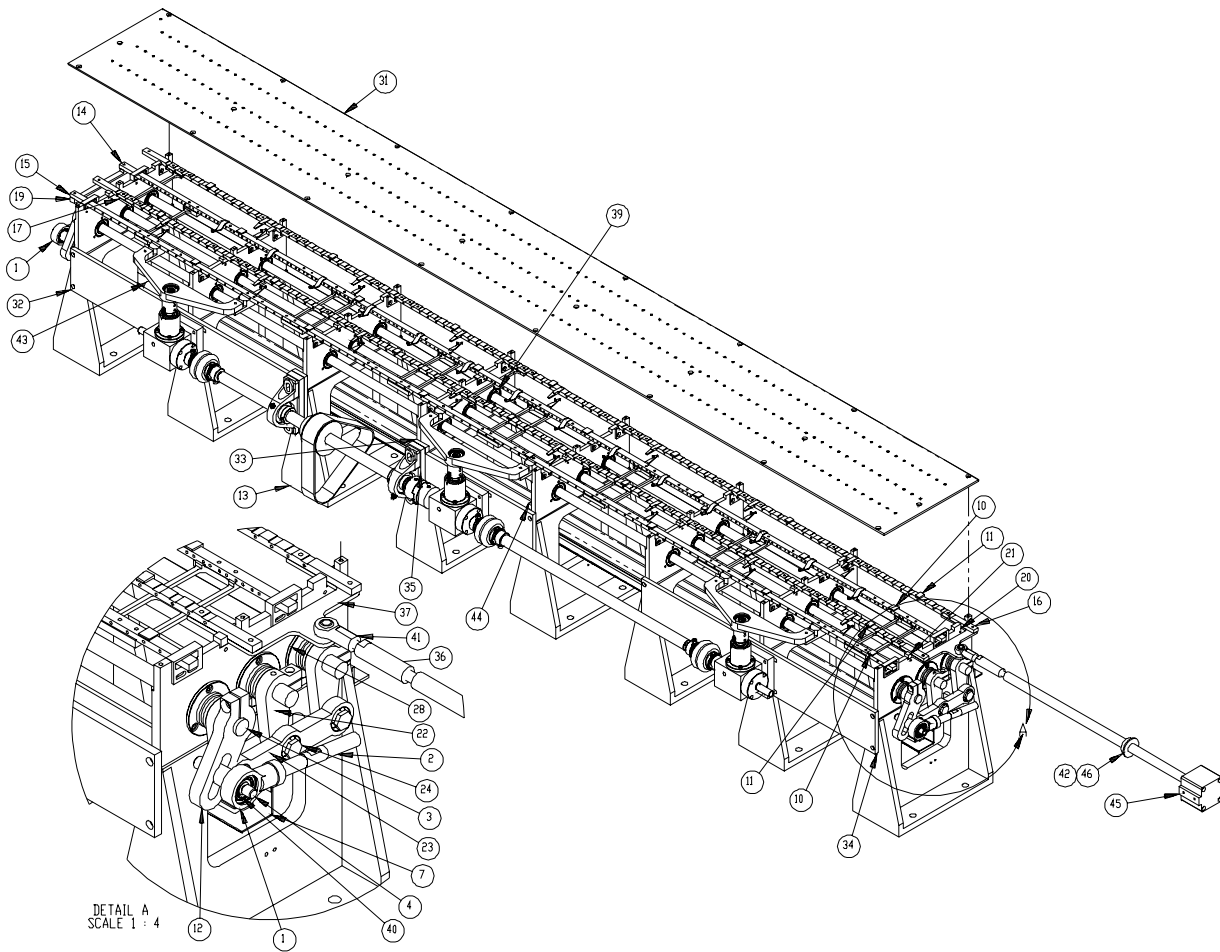


1389556 Base Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1-001	BASE, QUILTER	1		9	1392103	MAIN DRIVE SHAFT ASM	1	80
2	1-002	LEFT BASE	1		10	1392125	REAR THRD TENSION ASM	1	
3	1-003	RIGHT, BASE FOOT	1		11	1392196	TAKE-UP, LOOPER ASM	1	77
4	1389033	BRKT,STRAIN RELIEF	1		12	2-047	GEAR PULLEY, 84 TOOTH	1	
5	1392070	ROLL SERVO DRIVE ASM	1	76	13	GG300L100	BELT, TIMING, L-TYPE	1	
6	1392071	CARRIAGE SERVO DR ASM	1	78	14	GG405L150	BELT, TIMING, L-TYPE	1	
7	1392082	NEEDLE BAR DRIVE ASM	1	79	15	GG510L150	BELT, TIMING, L-TYPE	1	
8	1392096	DRIVE, WORM GEAR ASM	1	75					
						Rev. 0			

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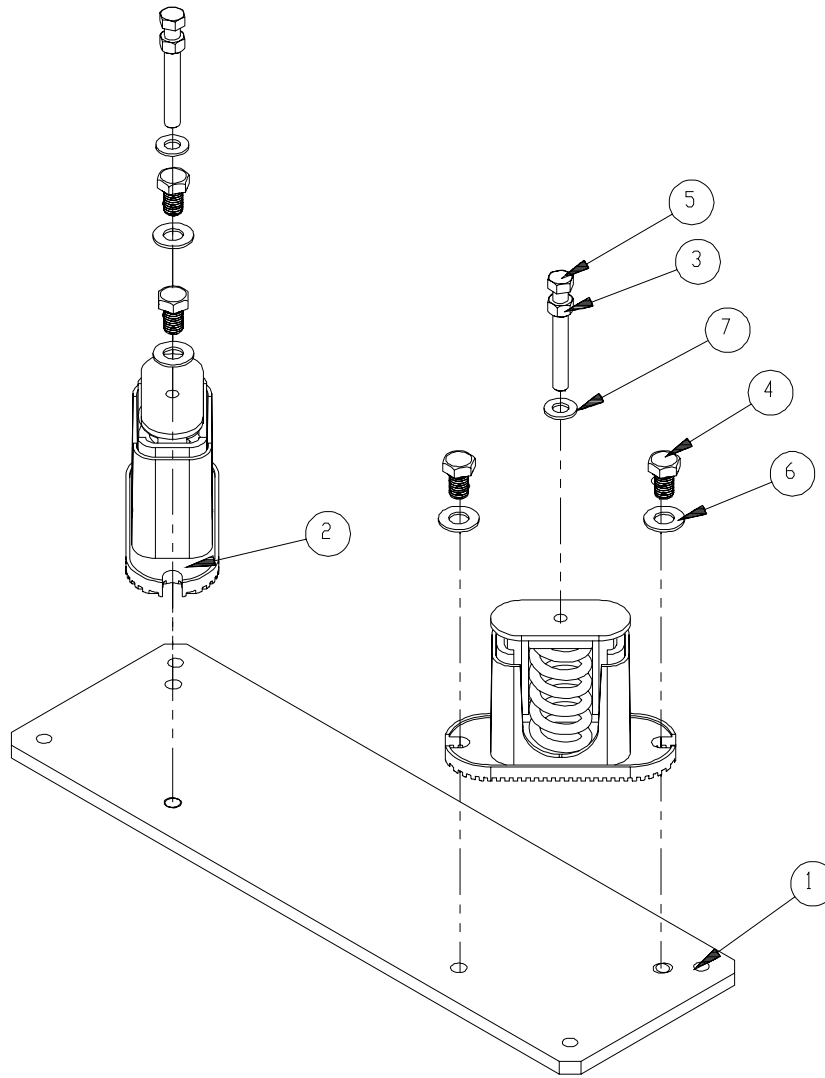
1389566 Throat Plate Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1-017	ROD END, PRESSER FOOT	2		25	2-037	PAD,WEAR, RETAINER	12	
2	1-028	LOOPER DR PITMAN ROD	2		26	2-039-1	GUIDE,KNIFE RAIL,CENTER	7	
3	1-029	SHAFT,LOOPER,20MM	3		27	2-040-1	GUIDE,KNIFE RAIL,REAR	7	
4	1-037	LOOPER DRIVE LINK	2		28	2-054A	COVER, BEARING, LOOPER	6	
5	1389495	RETAINER DRIVE ASSY	1		29	2-066	SLEEVE, RETAINER,LEFT	2	
6	1392170	GUIDE, LOOPER THRD ASM	1		30	2-066-3	SLEEVE, RETAINER,RIGHT	2	
7	1392576	REFLECTOR	2		31	2-19A	NEEDLE PLATE	1	
8	1392748	BRACKET,LIGHT	4		32	3-033	PLATE, GEARBOX MOUNT	1	
9	1392807	LINK, RETAINER,DOUBLE	6		33	3-034	PLATE, GEARBOX MOUNT	1	
10	1392810	GIB, RETAINER BAR	14		34	3-035	PLATE, GEARBOX MOUNT	1	
11	1392812	GIB, KNIFE BAR	14		35	3-036	BLOCK,BEARING	2	
12	1393874	ROCKER, LOOPER DRIVE	2		36	4-013ASLDPRT	ROD EXTENSION	1	
13	2-001A	SUPPORT, THROAT PLATE	8		37	4-014	FORK,KNIFE BAR	1	
14	2-003	BAR,RETAINER MTG,REAR	1		38	BB51204J	THRUST BEARING	6	
15	2-004	BAR,RETAINER MTG,FRONT	1		39	BB60042RS	BEARING,BALL,20 ID,42 OD	24	
16	2-005	BAR,KNIFE MTG	2		40	BB62022RS	BEARING, RADIAL, SEALED	2	
17	2-006	LINK,KNIFE BAR	2		41	BBAG-M10	ROD END, SPHER 10MM I	1	
18	2-007	LINK,RETAINER,SINGLE	1		42	CCCLM20F	CLAMP COLLAR- M20	1	
19	2-008	LINK,END,RETAINER BAR	1		43	HLES46BCCW	FLOURESCENT FIXTURE	482	
20	2-012	GUIDE,KNIFE RAIL,RIGHT	1		44	HLSDCHL	CONNECTOR	1	
21	2-013	GUIDE, KNIFE RAIL,RIGHT	1		45	QGY50X25	CYLINDER	1	
22	2-026	CRANK,LOOPER	6		46	WWU5/8	WASHER,URETHANE,20MM	1	
23	2-027	LINK,LOOPER CRANK	2						
24	2-028	PIN,THREADED,LPR CRANK	6						

Rev. 0

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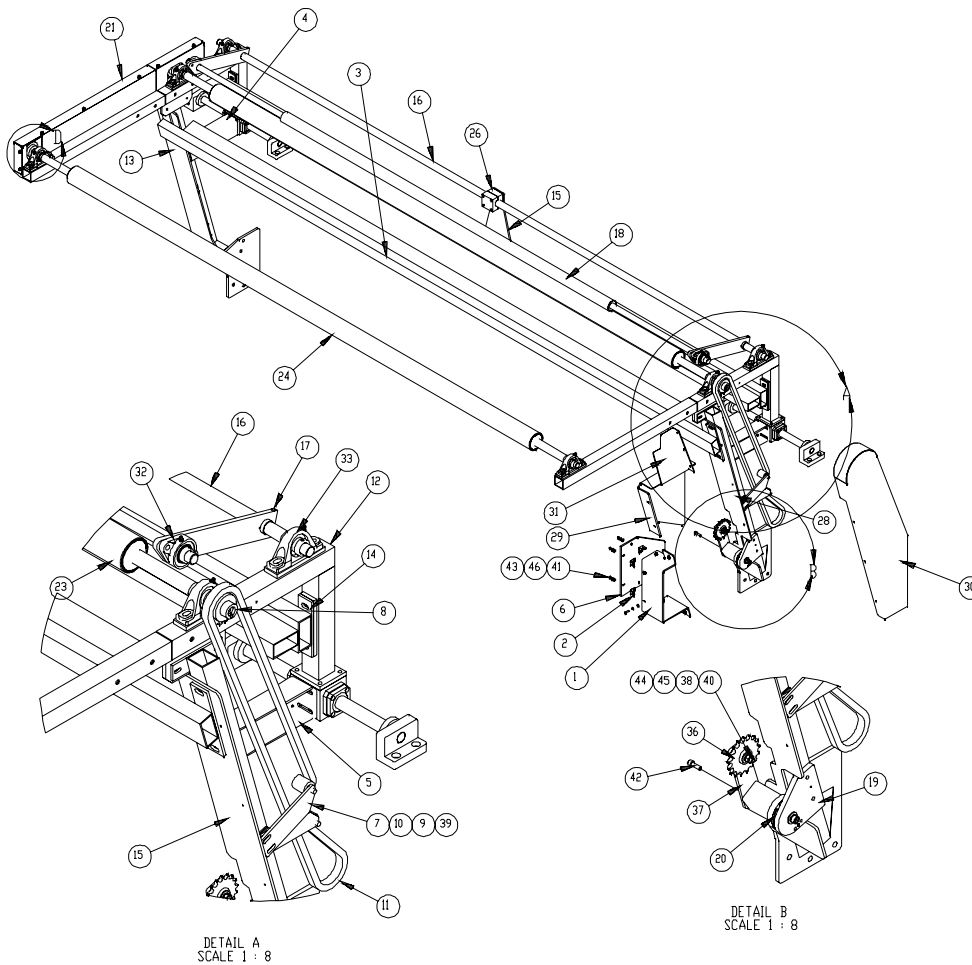


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1389740 Isolator Base Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389739	BASE, ISOLATOR	1		5	SSHC45256F	1/2-13 X 4 HEX HEAD	2	
2	MM6219K94	VIBRATION ISOLATOR	2		6	WWF5/8	WASHER, FLAT, 5/8	4	
3	NNH1/2-13	1/2-13 HEX NUT	2		7	WWFS1/2	WASHER, FLAT, 1/2	2	
4	SSHC41064	SCREW,HEX CAP	4						
						Rev. 0			





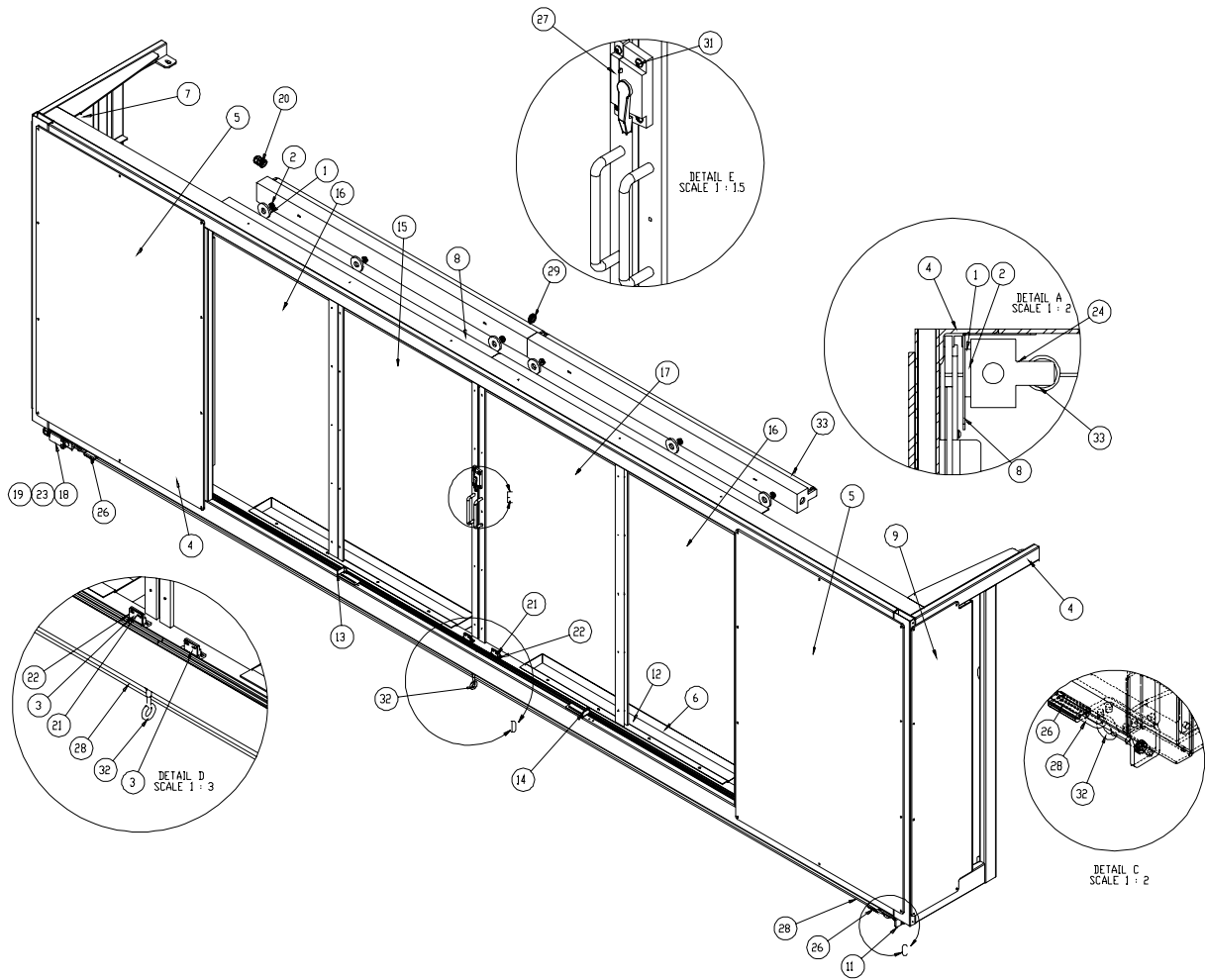
1392028 Transfer Carriage Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389047	GUARD,BELT,BOTTOM	1		25	1392533	PLATE,BRACE MTG	1	
2	1389053	CLIP, GUARD MTG	4		26	1392534	BLOCK, STABLIZER	1	
3	1389447	BRACE WELDMENT	1		27	1392672	KEY,7MMX8MMX.96 IN	1	
4	1389502	BRACE,RH	1		28	1393467	PLATE,NUT,M8	1	
5	1389503	BRACE,LH	1		29	1393660	GUARD,BELT,INSIDE	1	
6	1389523	GUARD,BELT,BOTTOM	1		30	1393887	BELT GUARD	1	
7	1389574	BAR,CHAIN TENSIONER	2		31	1393962	BELT GUARD	1	
8	1389575	TORQUE LIMIT ASSY,50A17	1	82	32	BBNANFL205-25	BEARING	2	
9	1389586	PLATE,WASHER	2		33	BBNAP205-25	BEARING, PILLOWBLOCK	6	
10	1389599	ROLLER,CHAIN TENSIONER2	2		34	BBTT604	BEARING,BRONZE,.385ID	2	
11	1389603	CHAIN,#50 X 83.125	1		35	GG767L050	BELT, GEAR, 3/8P,1/2W	1	
12	1392015	TRANSFER CARRIAGE RAIL2	2		36	MM50BB17	SPROCKET,17T,5/8P	1	
13	1392020	STRUT WELDMENT,RH	1		37	MMSE27	TENSIONER,DRIVE	1	
14	1392026	BRACE WELDMENT	1		38	NNHM10X1.0	M10 X 1.0 HEX NUT	1	
15	1392027	STRUT WELDMENT,LH	1		39	SSAS12X25X10	SHOULDER BOLT	2	
16	1392034	SHAFT ASSY	1		40	SSSCM10X50	M10-1.5 X 50 SOC CAP	2	
17	1392035	ARM,WEIGHTED ROLL	2		41	SSSCM5X16	M5-0.8 X 16 SOC CAP	11	
18	1392114	ROLLER,50 X 2900	1		42	SSSCM8X25	M8-1.25 X 25 SOC CAP	1	
19	1392146	PLATE,TENSIONER MTG	1		43	WWFM5	5MM FLAT WASHER	11	
20	1392147	SHIM,TENSIONER	2		44	WWFS1/2	WASHER, FLAT, 1/2	3	
21	1392230	GUARD ASSEMBLY	1		45	WWLM10	M10 LOCK WASHER	2	
22	1392262	PULLEY 3/8P, 24T, 22MM B	2		46	WWLM5	M5 LOCK WASHER	11	
23	1392343	WELDMENT,FWD CARR	1						
24	1392344	WELDMENT,AFT CARR	1						

Rev. 10

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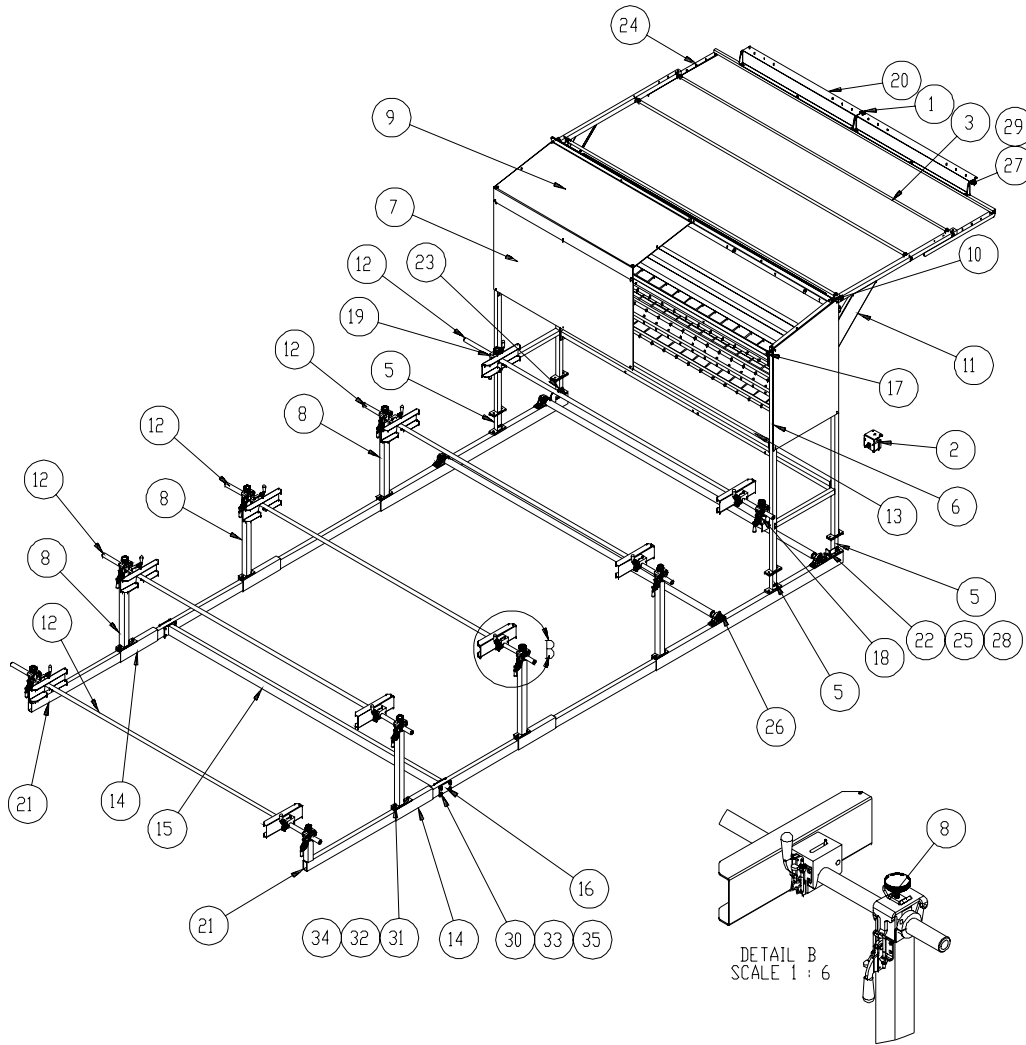
1392185 Rear Closure Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389207	CUSHION,RUBBER,2 OD	6		18	EEE10207TBI	SWITCH,SAFETYL	1	
2	1389208	SPACER,LIGHT MTG	6		19	FF3200	STRAIN RELIEF, 1/2 NPT	1	
3	1389213	SPACER, .09 THK	2		20	FF3216	STRAIN RELIEF, LIQ TIGHT	1	
4	1392180	REAR CLOSURE WLDMNT	1		21	FF57105000	REED SWITCH MAGNET	2	
5	1392186	FIXED FRONT WINDOW	2		22	FF59105010	REED SWITCH, FLANGE	2	
6	1392309	TOOL TRAY	2		23	FF8463	NUT,LOCK,1/2NPT,NYLON	1	
7	1392461	COVER,LEXAN,380X1106	1		24	FFM1414	FIXTURE,LIGHT,4	2	
8	1392464	REFLECTOR,4	2		25	MM1717A3	TRACK,DOOR,SET	2	
9	1392470	COVER,LEXAN,380X1106	1		26	MM3471T23	CLAMP,ROPE,WIRE,3/16"	2	
10	1392530	BRACKET,SAFETY SWITCH	1		27	MM819171	LOCK, SASH, NARROW	1	
11	1392532	BRKT,EYEBOLT MTG	1		28	MM8923T81	ROPE,WIRE,SS,3/16",RED	15'	
12	1392725	FOAM,NSLIP,3" X 36	2		29	MM9600K36	GROMMET,RUBBER,9/16 ID	1	
13	1392993	STOP,DOOR,LH	1		30	MMFELTSTRIP	FELT,STRIP,FIDEL	AR	
14	1392995	STOP,DOOR,RH	1		31	SSBC80032	#6-32 X 1/2 BUT HEAD	4	
15	1393819	ASSY, WINDOW LARGE LFT 1	1		32	SSBE10160	EYEBOLT, 5/16-18X2.5	2	
16	1393820	ASSY, WINDOW SMALL	2		33	ZZZMT-115	BULB,4' FLUORESCENT	2	
17	1393821	ASSY, WINDOW LARGE RT 1	1						

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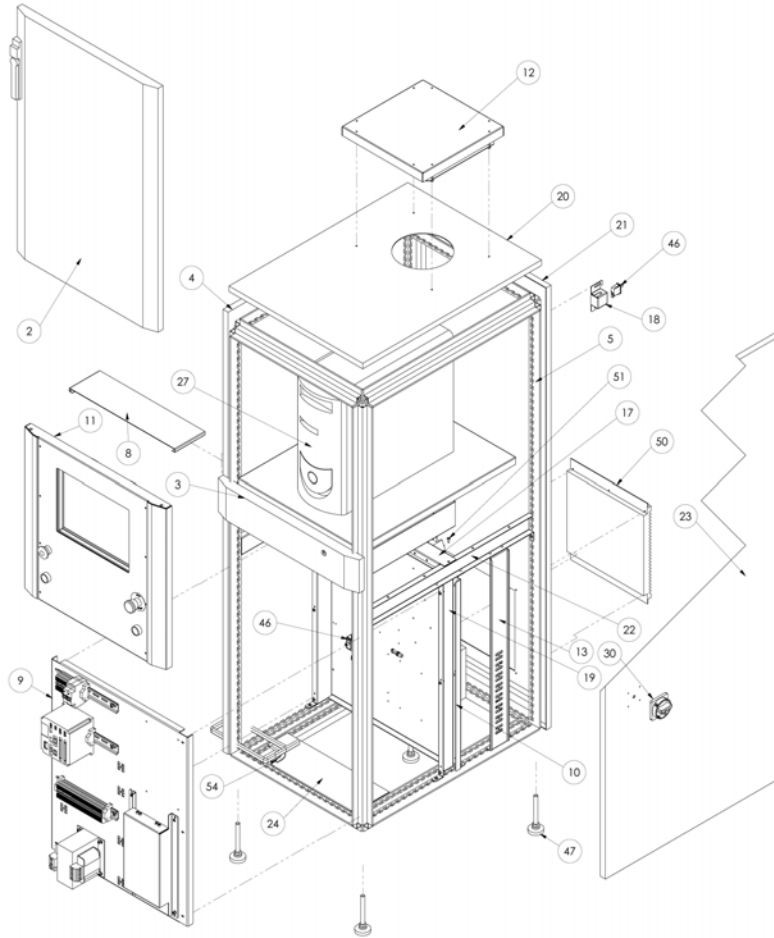
1392195 Thread Stand Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389179	MTG PLATE	1		19	1392973	TENSION CLAMP ASS, RH	1	
2	1389398	REMOTE PAUSE,RESTART	1		20	1393810	MOUNT, LIGHT, FRONT	2	
3	1392283	GUIDE, THREAD ASM	3		21	1393914	BACKING ROLL HOLDER	2	
4	1392308	SPACER, THREAD TENSION4	4		22	1393937	BRKT,EYE MTG	1	
5	1392439	EXTENSION,THREAD STND	4		23	1393938	PLATE,REFLECTOR	1	
6	1392488	SCREEN,WIND,SIDE	2		24	1393966	MOUNT, LIGHT	1	
7	1392493	SCREEN,WIND,BACK,R	2		25	1975-412A	PLATE,NUT,4-40@.96 CTC	1	
8	1392545	MAT. TENSION RACK ASSY	6	83	26	BBNAP205-25	BEARING, PILLOWBLOCK	AR	
9	1392553	SCREEN,WIND,TOP	2		27	FF3216	STRAIN RELIEF, LIQ TIGHT	1	
10	1392602	BRACE	1		28	FFSM312LVQ	BANNER MINI-BEAM	1	
11	1392637	BRACE, FRAME	2		29	MM9600K36	GROMMET,RUBBER,9/16 ID	1	
12	1392763	MATERIAL, ROD ASSEMBLY	5		30	SSHCM8X60	M8-1.25 X 60 HEX HEAD	8	
13	1392783	SUPPORT, WELDMENT	1		31	SSSCM10X25	M10-1.5 X 25 SOC CAP	6	
14	1392825	STAND, THREAD, FRAME	2		32	WWFS3/8	WASHER, FLAT, 3/8	4	
15	1392856	CROSS BAR WELDMENT	1		33	WWFS5/16	WASHER, FLAT, 5/16	8	
16	1392857	PLATE,WASHER,.359X4	2		34	WWL3/8	3/8 LW	4	
17	1392951	ANGLE,COVER ATTACH	1		35	WWL5/16	5/16 LW	8	
18	1392972	TENSION CLAMP ASS, LH	1						

Rev. 8

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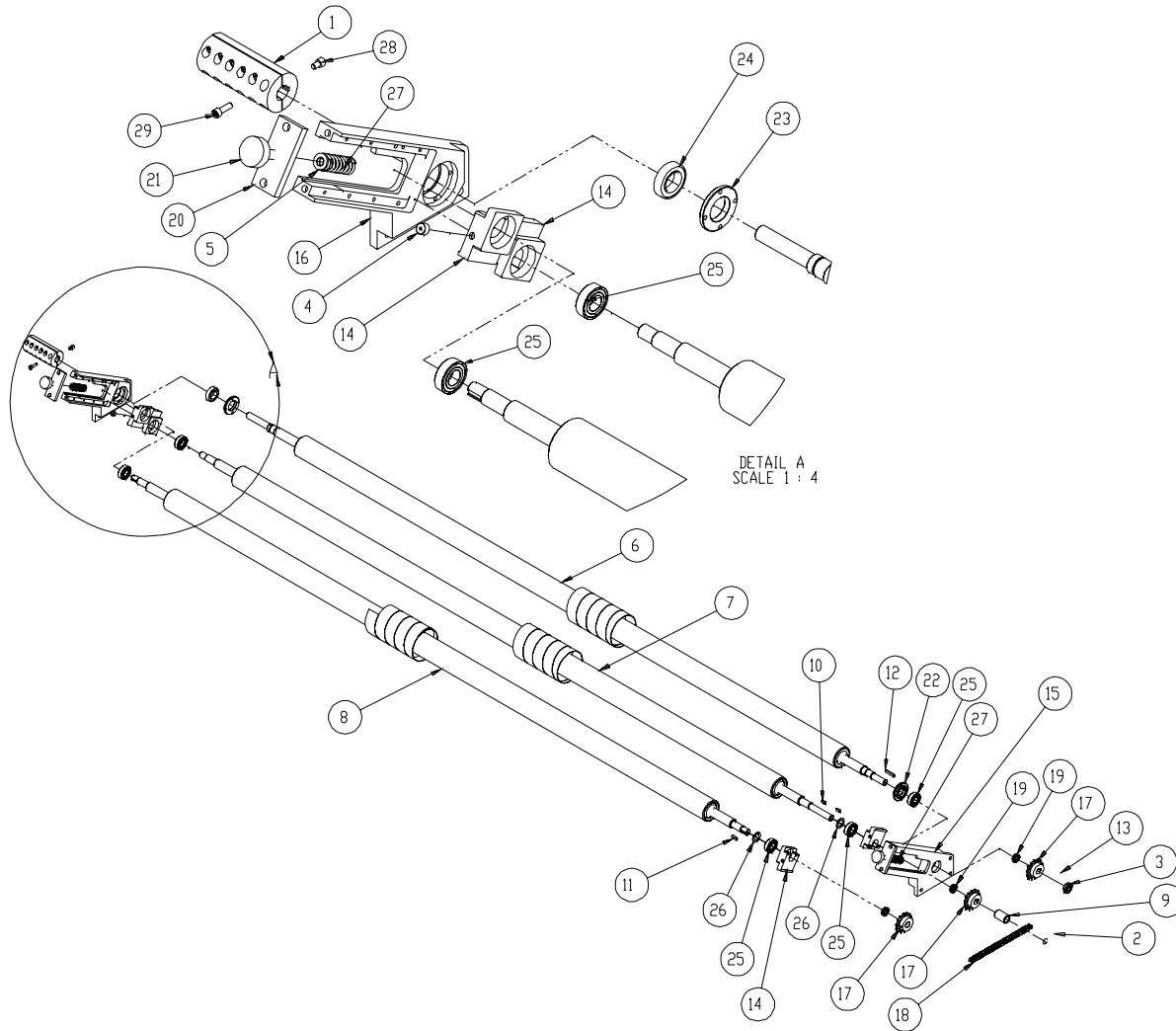
1392364 Control Cabinet Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	120280	PCI SERIAL ADAPTOR	1*		29	EE194EE63PE	DISCONNECT PE,40/63A	1	
2	1389733	DOOR, CONTROL PANEL	1		30	EE194LHE6N175	DISCONNECT HANDLE	1	
3	1389734	DRAWER, CONTROL PANEL	1		31	EEA11CE05A	CABLE,ENCODER,5M	1	
4	1389735	PANEL, LH SIDE CPANEL	1		32	EEB2E05A	CABLE,POWER,5M,SERVO	1	
5	PS4620210	CABINET, COMPUTER	1		33	EEB2E10A	CABLE,POWER,10M,SERVO	1	
6	1392-WD1	WD,BACK PANEL	AR	99	34	EEB51CE05A	CABLE,POWER,5M,SERVO	1	
7	1392-WD2	WD,QUILTER PANEL	AR	100	35	EEJEPMCW600301	CABLE,MCHTRINK M2	3	
8	1392036	SHELF, KEYBOARD	1		36	EEJEPMCW6022	TERMINATION,BLOCK	1	
9	1392366	BACKPLANE, FRONT SIDE	1	84	37	EEJZSPCMP0205BENC	CABLE ASSY,5M	1	
10	1392367	BACKPLANE, BACK SIDE	1	86	38	EEJZSPCMP0210BENC	CABLE ASSY,10M	1	
11	1392393	DOOR, ASSEMBLY, CPANEL	1	85	39	EEPMTS44	PUSH BUTTON,40MM	1	
12	1392399	FAN, ROOF, CPANEL ASM	1		40	FF31572787	WIRE,STR,#10,PVC	18	
13	1392544	BRACE,RELIEF,STRAIN	1		41	FF3234	STRAIN RELIEF,LIQ T	2	
14	1392660	CABLE, FLORES. LIGHT	1		42	FF8465	NUT,LOCK,3/4NPT,NYLON	2	
15	1392696	CABLE ASSY,MP2300,SER	1		43	FF8908-10	WIRE,STR,#8,PVC,BLK	3	
16	1392697	PENDANT ASSY,QUILTER	1		44	FF8908-13	WIRE,STR,#8,PVC,BLU	3	
17	1392701	CROSS BAR	1		45	FF8908-2	WIRE,STR,#8,PVC,RED	3	
18	1392702	BOX,SENSOR,DOOR	2		46	FFE6930A	SWITCH,INTEROCK,DOOR	2	
19	1392704	BRACE.CROSS	2		47	MM6301K82	SWIVEL LEVELING MNT	4	
20	1392706	PANEL, TOP SIDE, CPANEL	1		48	MM800E15YE112	E-STOP LEGEND PLATE,	1	
21	1392716	DOOR,BACK,BOX,CNTRL	1		49	MM800EPF1	PUSHBUTTON,WHITE	1	
22	1392729	BRACE.CROSS	2		50	SK3326200	FILTER, OUTLET	1	
23	1392745	PANEL, RH SIDE CPANEL	1		51	SSZP#12040	SCREW,PAN SHEET METAL	34	
24	1392994	PANEL, ACCESS	1		52	TT190020028	TERMINAL,FASTON,F.,187X	4	
25	4080-4215A	CABLE,3 PIN FM MOLEX	1		53	TT5828	TERMINAL,RING,#10 STUD	4	
26	51175B	MEMORY KEY,128MB	1		54	MM100-.125	DOOR TRIM - BLACK	1	
27	EE1392COMP	DELL COMP W/FLAT SCRNR	1						
28	EE194EE631753	DISCONNECT,3POLE,63A	1						

Rev. 9

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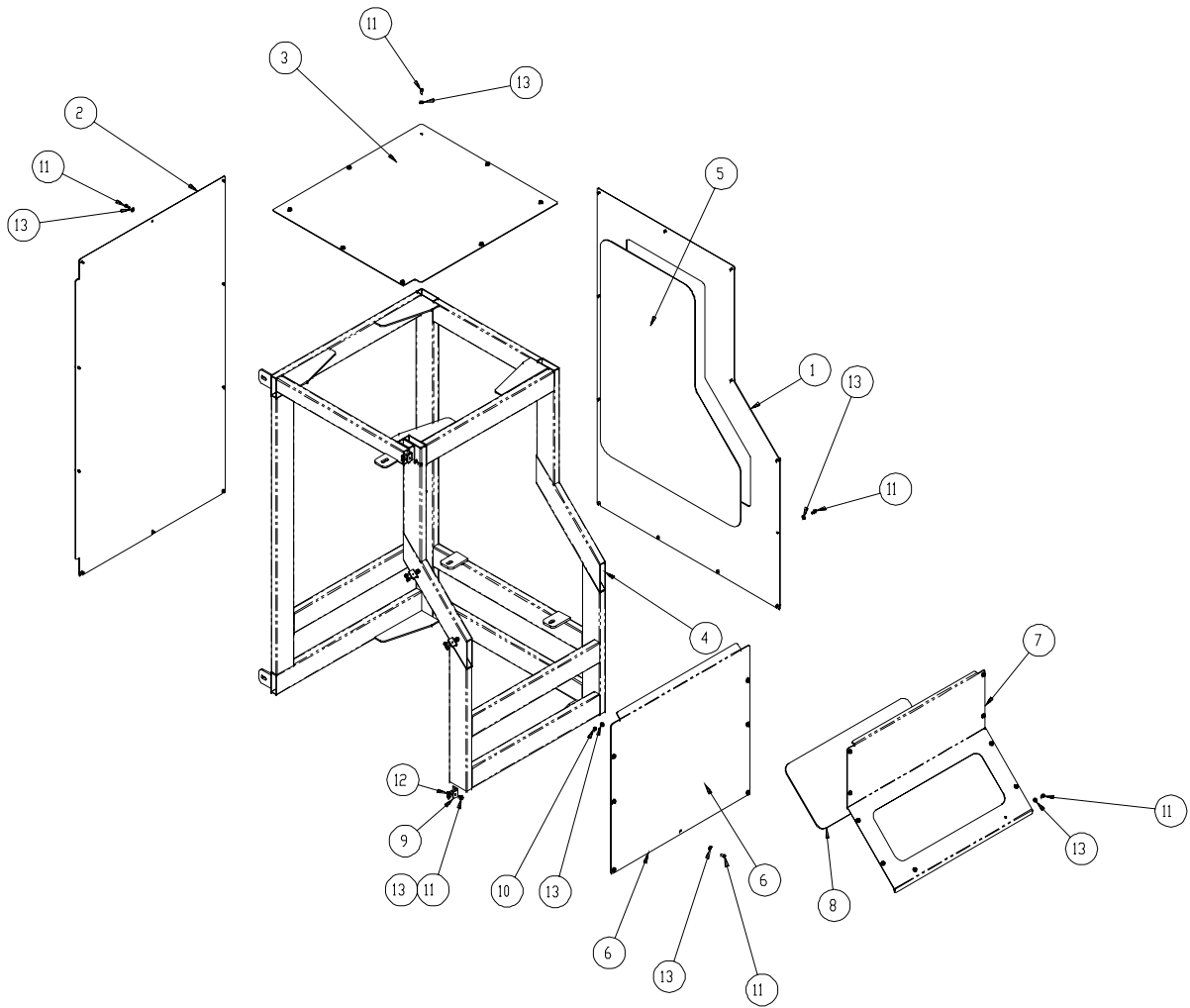
1392392 Roller Drive Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389236	COUPLING,Y-AXIS DRIVE	1		16	1392941	WELDMENT,RH REAR BRG	1	
2	1389555	SPROCKET,17T,5/8P,22MM	1		17	1393454	STEEL SPROCKET,14T,5/8P 3		
3	1389570	SPACER, ROLLER	1		18	1393463	CHAIN, INSIDE, 36.5 L	1	
4	1392127	LOCATOR,SPRING	2		19	1393464	SLEEVE,SPACER, .3 X.88ID 3		
5	1392128	ADAPTER,SPRING	2		20	3-027	BAR,ROLL ADJUSTMENT	2	
6	1392233	LOWER ROLLER	1		21	3-031	SCREW,ROLL ADJUST	2	
7	1392236	MIDDLE ROLLER	1		22	5-020	COLLAR, SHAFT, WIDE	1	
8	1392238	UPPER ROLLER	1		23	5-020-1	COLLAR, SHAFT,NARROW	1	
9	1392275	SLEEVE,SPACER	1		24	BB60062RS	BEARING,BALL,30MM B	1	
10	1392671	KEY,7MMX8MMX.71 IN	2		25	BB62052RS	BEARING,25mm ID, 52mm	5	
11	1392672	KEY,7MMX8MMX.96 IN	1		26	BBTRB1625	WASHER,THRUST,STEEL	2	
12	1392673	KEY,7MMX8MMX1.75 IN	1		27	RRLHC148J03	SPRING,1.1OD.,148WIRE,2.52		
13	1392851	STEEL SPROCKET,17T,5/8P	1		28	SSSCM8X12	SCREW,SOC CAP,M8X25	4	
14	1392923	BLOCK,BEARING,OFFSET	4		29	SSSCM8X25	M8-1.25 X 25 SOC CAP	12	
15	1392940	WELDMENT,LH REAR BRG	1						

Rev. 7

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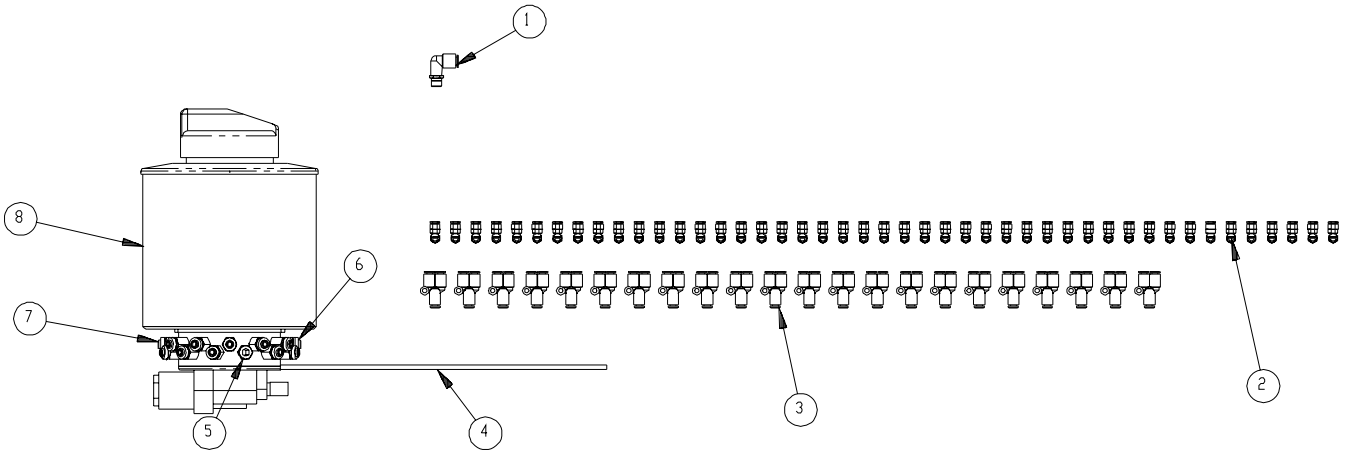


1392405 Motor Guard Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392404	PANEL, MOTOR GUARD	1		8	1392634	WINDOW, TOP	1	
2	1392419	PANEL, MOTOR GUARD	1		9	1392738	CLIP, PANEL	4	
3	1392420	PANEL, TOP, MOTOR GUARD	1		10	NNHM5X0.8	M5 X 0.8 HEX NUT	2	
4	1392455	WELDMENT, GUARD	1		11	SSSCM5X10	M5-0.8 X 10 SOC CAP	52	
5	1392551	LEXAN FOR 1392404	1		12	SSZH#10032	#10 X 1/2 HSMS	8	
6	1392631	PANEL, LOWER, GUARD	1		13	WWFS10	WASHER, FLAT #10	53	
7	1392632	PANEL, FRONT, CABINET	1						
						Rev. 4			

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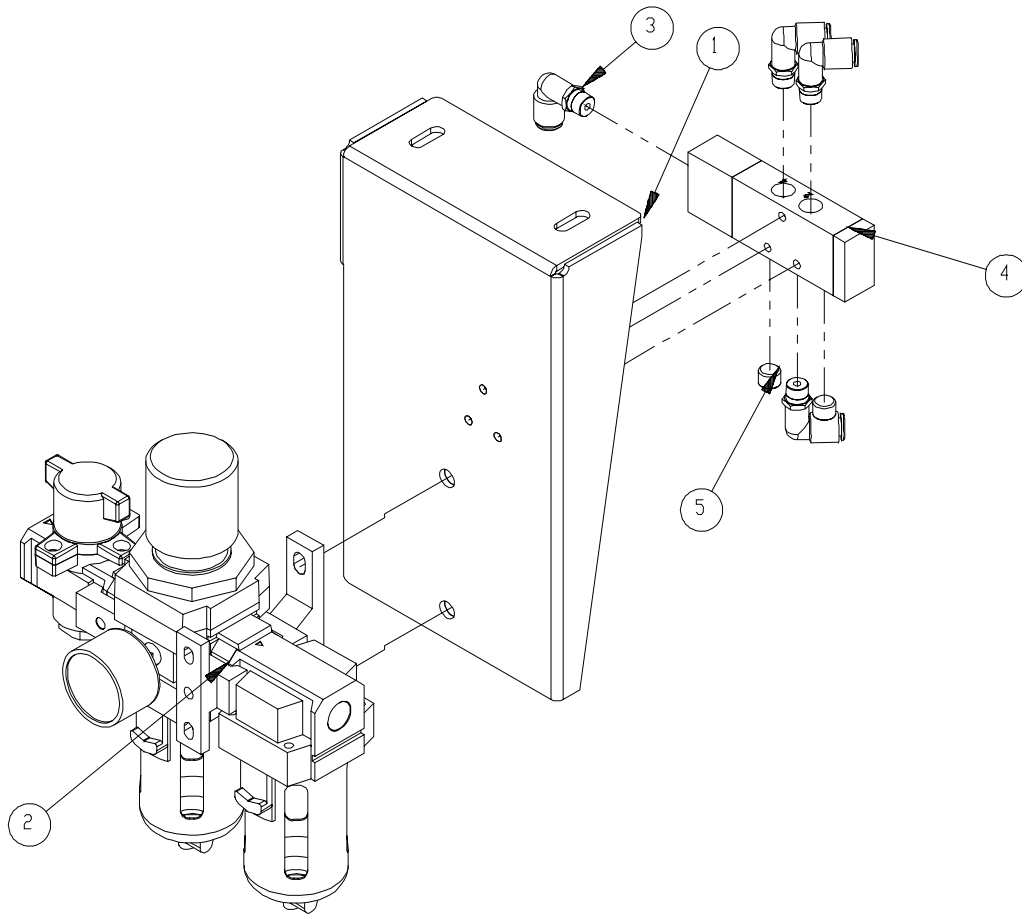
1392415 Lubrication Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	AAQME-4-8U	QUICK MALE ELBOW,1/4	1		6	MM78034PL	INJECTOR,GREEN.015CC	2	
2	AAQME-M4-M6	QUICK ELBOW CONN	45		7	MM78035PL	INJECTOR,YELLOW.025CC	21	
3	AAQUY-5-5	QUICK UNION Y, 5/32	22		8	MMXGS4024	PUMP,GREASE,24 STATION	1	
4	AATP4X2MW	TUBING,NYLON,5/32OD	250 FT						
5	MM34237-402	PLUG,PORT	1						

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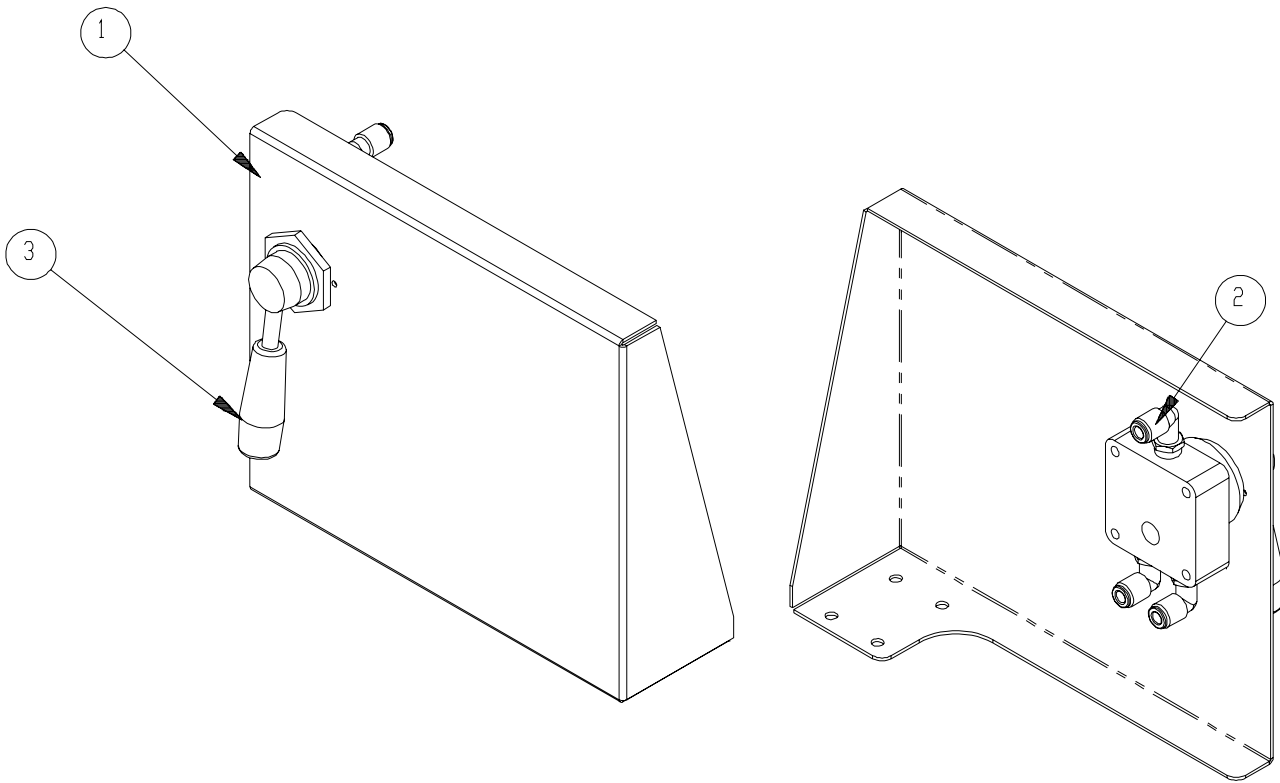


1393854 Regulator Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	32003033	BRKT,REGULATOR,DUAL	1		4	AAV125B	PILOT VALVE	1	
2	AA198-5110	FILTER/REGULATOR/LOCK	1		5	MM4554K11	PLUG, 1/8" PIPE	2	
3	AAQME-4-8	ELBOW,QUICK MALE,1/4	4						
						Rev. 0			

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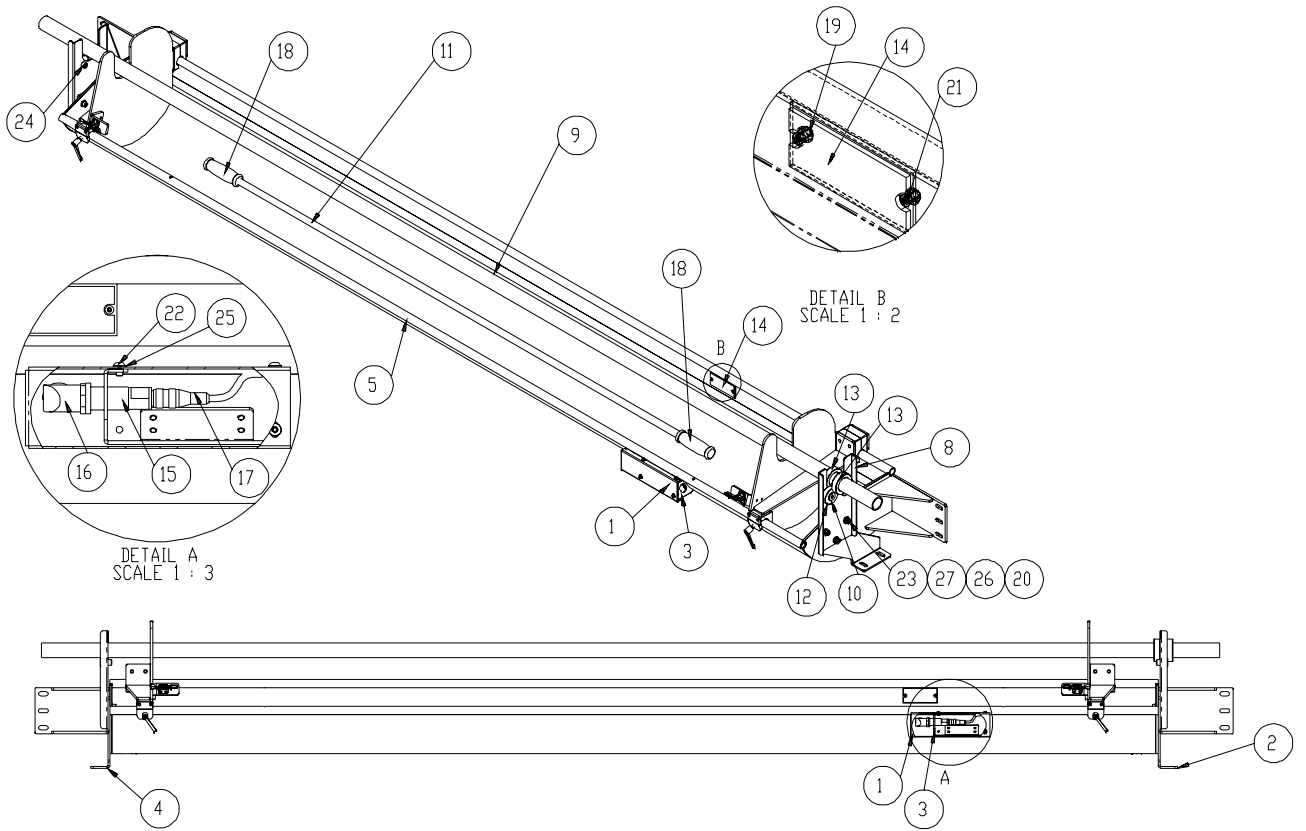


1393940 Valve Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1393939	PLATE, VALVE/REG MTG	1		3	AAVH202-N02	VALVE, HAND, 2 POSITION	1	
2	AAQME-4-4	ELBOW, MALE, 1/4X1/4NPT	3			Rev. 1			

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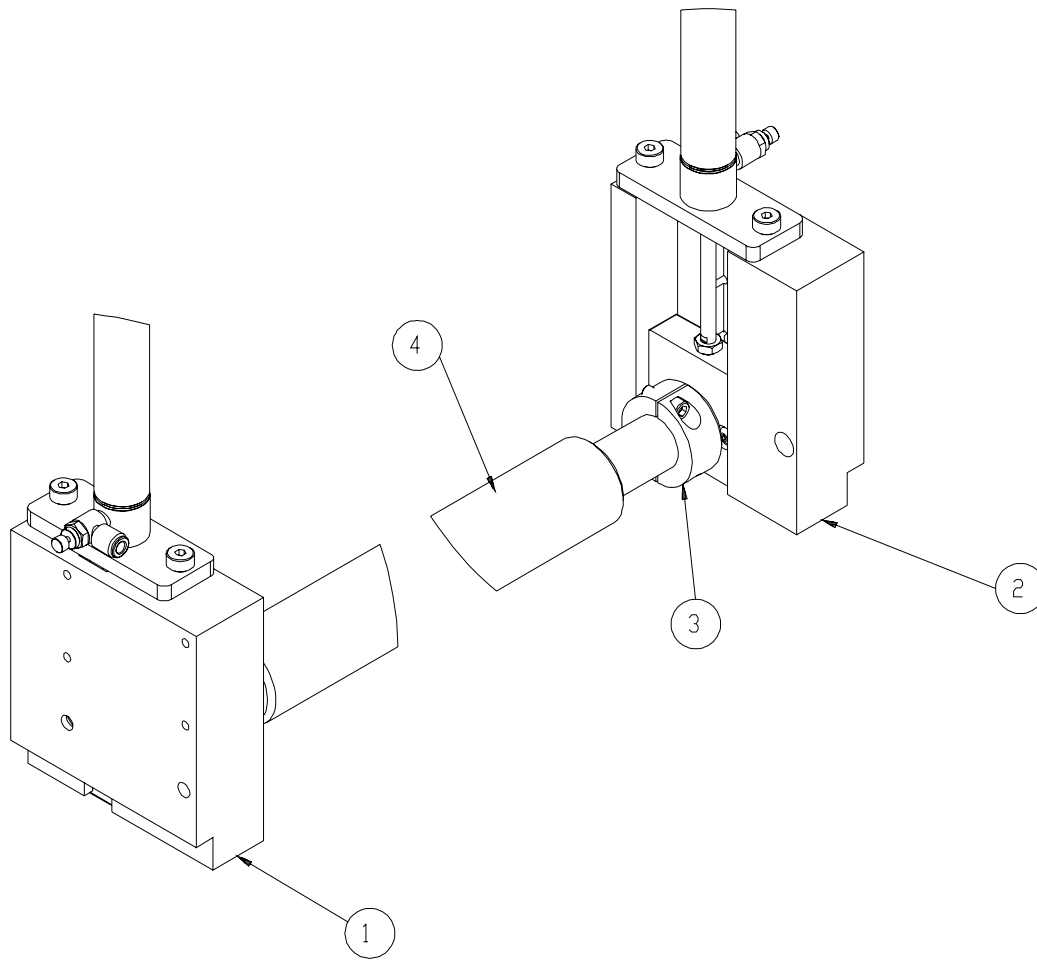
1392087 Front Tray Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389424	COVER, SENSOR BRACKET	1		15	EESP0N4E	SENSOR,PHOTOELECTRIC	1	
2	1389427	BRKT,RH	1		16	EEST03	ADAPTER, RIGHT ANGLE	1	
3	1389429	BRACKET, TICK SENSOR	1		17	FFRK44T-4	CABLE,EYE,12',NO END	1	
4	1389432	BRKT,LH	1		18	MMGP-105	GRIP HANDLE-FOAM 3/4 ID	2	
5	1392040	MATERIAL TRAY ASSEMBLY	1		19	NNE6-32	NUT,ELASTIC LOCK	2	
6	1392084	MATERIAL END, LEFT	1		20	NNH5/16-18	5/16-18 HEX NUT	6	
7	1392085	MATERIAL END, RIGHT	1		21	SSBC80024	#6-32 X 3/8 BUT HEAD	2	
8	1392452	BRACKET, ROLL HOLDER	2		22	SSBCM5X8	M5 X 8MM BUT HEAD	8	
9	1392457	TUBE, 1.5 "OD X 120" L	1		23	SSSC10064	5/16-18 X 1 SOC CAP	6	
10	1392476	BUSHING, BEARING MOUNT	4		24	SSSC25048	3/8-16 X 3/4 SOC CAP	4	
11	1393945	ROD, TICKING	1		25	WWFM5	5MM FLAT WASHER	4	
12	BB1L017	BEARING,BALL,.787B	4		26	WWFS5/16	WASHER, FLAT, 5/16	12	
13	CCCL24F	CLAMP COLLAR, 1.5" BORE	2		27	WWL5/16	5/16 LW	6	
14	EERL105	REFLECTOR, RECT	1						

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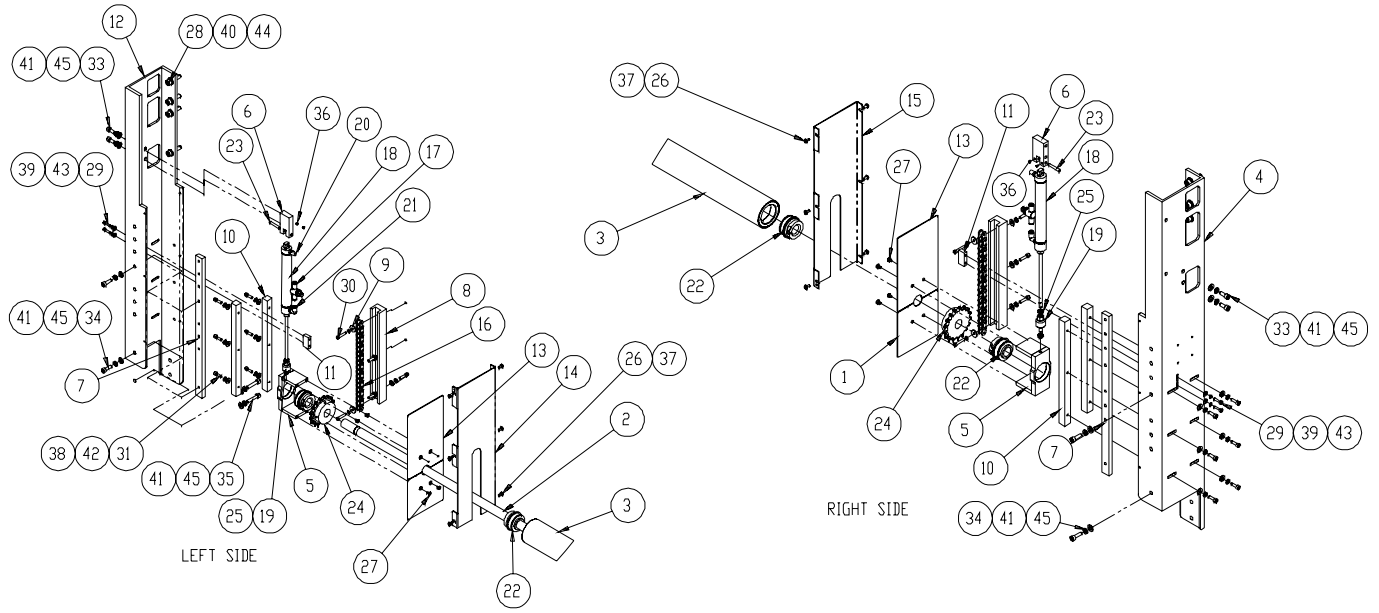


1392306 Roller Lift Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389085	ROLLER LIFT ASSEMBLY	1		3	1393895	COLLAR, END PLAY	2	
2	1392095	ROLLER LIFT ASSEMBLY	1		4	3-005	ROLLER	AR	
					Rev. 3				

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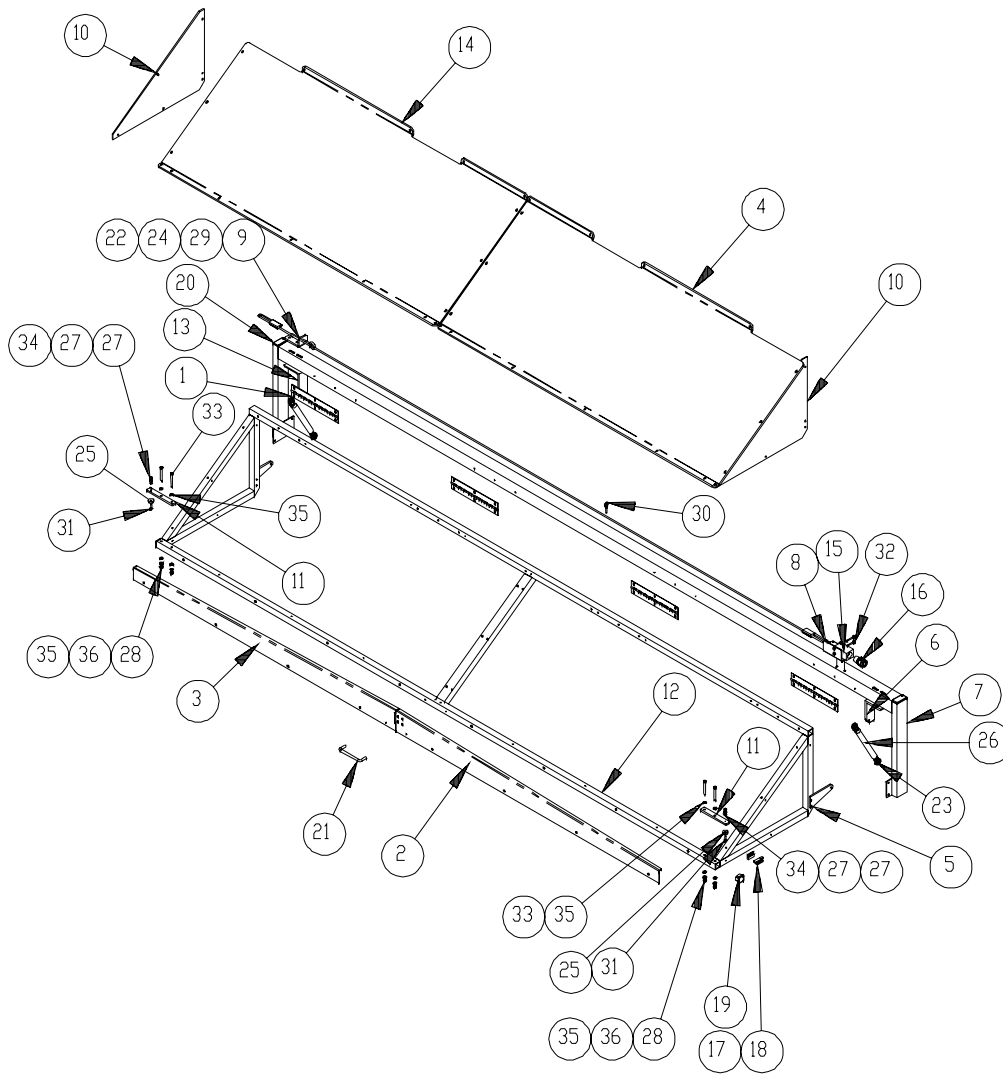


1392448 Tension Roller Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392724	COVER, TENSION RLR	2		24	MM50B17M	STEEL SPROCKET,17T,5/8P	2	
2	1392877	SHAFT, TENSION ROLLER	1		25	NNJ5/16-24	5/16-24 HEX JAM NUT	4	
3	1392878	ROLLER, TICK TENSION	1		26	SSBCM5X12S	M5 X 12MM BUT HEAD	12	
4	1392881	SUPPORT, TENSION RLR	1		27	SSFCM5X10	M5-0.8X10 FLAT ALLEN	8	
5	1392882	HOUSING, BEARING	2		28	SSSCM10X40	M10-1.5 X 40 SOC CAP	8	
6	1392895	MOUNT, CYLINDER	2		29	SSSCM5X20	M5-0.8 X 20 SOC CAP	4	
7	1392896	NUT PLATE, TENSION RLR	2		30	SSSCM5X30	M5-0.8 X 30 SOC CAP	4	
8	1392899	HOLDER, ROLLER CHAIN	2		31	SSSCM6X20	M6-1.0 X 20 SOC CAP	12	
9	1392900	WASHER, CHAIN HOLD	4		32	SSSCM6X25	M6-1.0 X 25 SOC CAP	6	
10	1392901	GUIDE, TENSION ROLLER	4		33	SSSCM8X20	M8-1.25 X 20 SOC CAP	4	
11	1392903	STOP, TENSION ROLLER	2		34	SSSCM8X25	M8-1.25 X 25 SOC CAP	4	
12	1392904	SUPPORT, TENSION RLR	1		35	SSSCM8X40	M8-1.25 X 40 SOC CAP	4	
13	1392908	COVER, TENSION RLR	2		36	SSSSM5X5C	M5-0.8X5 CUP PT. SS	4	
14	1392913	COVER, TOP LEFT	1		37	WWFM5	5MM FLAT WASHER	12	
15	1392914	COVER, TOP RIGHT	1		38	WWFS1/4	WASHER FLAT, 1/4	18	
16	1393466	CHAIN, SINGLE STRAND	2		39	WWFS10	WASHER, FLAT #10	4	
17	AA3001F-03	FLOW CONT,INLINE,1/4	2		40	WWFS3/8	WASHER, FLAT, 3/8	8	
18	AAC6DP-6	CYLINDER, AIR, DA	2		41	WWFS5/16	WASHER, FLAT, 5/16	12	
19	AAF312	ROD END ALIGNER	2		42	WWL1/4	1/4 LW	18	
20	AAFP18	MUFFLER,1/8 NPT, BRONZ	2		43	WWL10	#10 LW	8	
21	AAQME-4-8	ELBOW,QUICK MALE,1/4	2		44	WWL3/8	3/8 LW	8	
22	BBGER205-25	BEARING,BALL,25MMB	4		45	WWL5/16	5/16 LW	12	
23	IID016X096	DOWEL PIN,1/4 X 1-1/2	2						
						Rev. 4			

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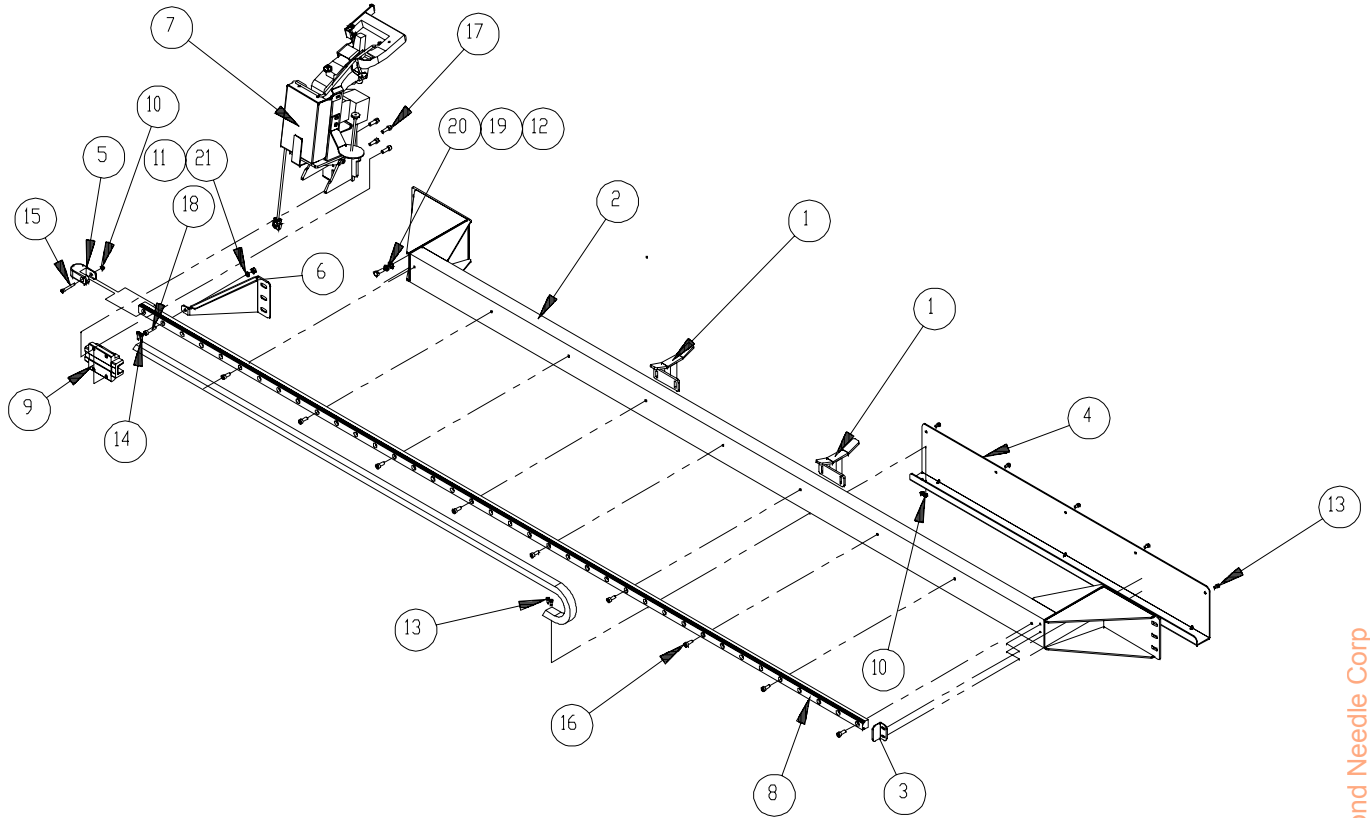
1392503 Front Guard Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1337-4217	PIANO HINGE 2W OPEN	4		20	MM132-1496	PLUG 1 X 2	2	
2	1389453	BRACKET, FRONT COVER	1		21	MM1568A45	HANDLE, DOOR, PULL	1	
3	1389454	BRACKET, FRONT COVER	1		22	MM3471T23	CLAMP, ROPE, WIRE, 3/16"	2	
4	1392356	COVER, FRONT, LEXAN, R	1		23	MM6465K26	EYELET, NYLON, M6 THRD	4	
5	1392357	TAB, GAS SPRING ATTACH	2		24	MM8923T81	ROPE, WIRE, SS, 3/16", RED	1	
6	1392427	BRKT, RH	1		25	MM9405K14	BUMPER, RECESSED	2	
7	1392502	WELDMNT, GUARD SUPP	1		26	MM9416K334	GAS SPRING, 70 LB	2	
8	1392530	BRACKET, SAFETY SWITCH	1		27	NNHM4X0.7	M4 X 0.7 HEX NUT	4	
9	1392532	BRKT, EYEBOLT MTG	1		28	NNHM6X1.0	M6 X 1.0 HEX NUT	4	
10	1392608	COVER, FRONT SIDE, LEXAN	2		29	SSBE10160	EYEBOLT, 5/6-18X2.5	1	
11	1392727	STOP, FRONT GUARD	2		30	SSBE95080	EYEBOLT, 10-24X1-1/4	1	
12	1392943	FRAME, FRONT COVER	1		31	SSPSM4X16	M4-0.7 X 16 PAN HD SLOT	2	
13	1392944	BRKT, LH	1		32	SSSC98080	#10-32 X 1-1/4 SOC CAP	2	
14	1392953	COVER, FRONT, LEXAN, L	1		33	SSSCM6X50	M6-1.0 X 50 SOC CAP	4	
15	EEE10207TBI	SWITCH, SAFETY, CABLE	1		34	WWFM4.3	WASHER, FLAT 4MM	2	
16	FF3200	STRAIN RELIEF, 1/2 NPT	1		35	WWFM6	6MM FLAT WASHER	8	
17	FF57105000	REED SWITCH MAGNET	1		36	WWLM6	M6 LOCK WASHER	4	
18	FF59105010	REED SWITCH, FLANGE	1						
19	MM132-1202	END CAP, SQUARE, BLACK	2						

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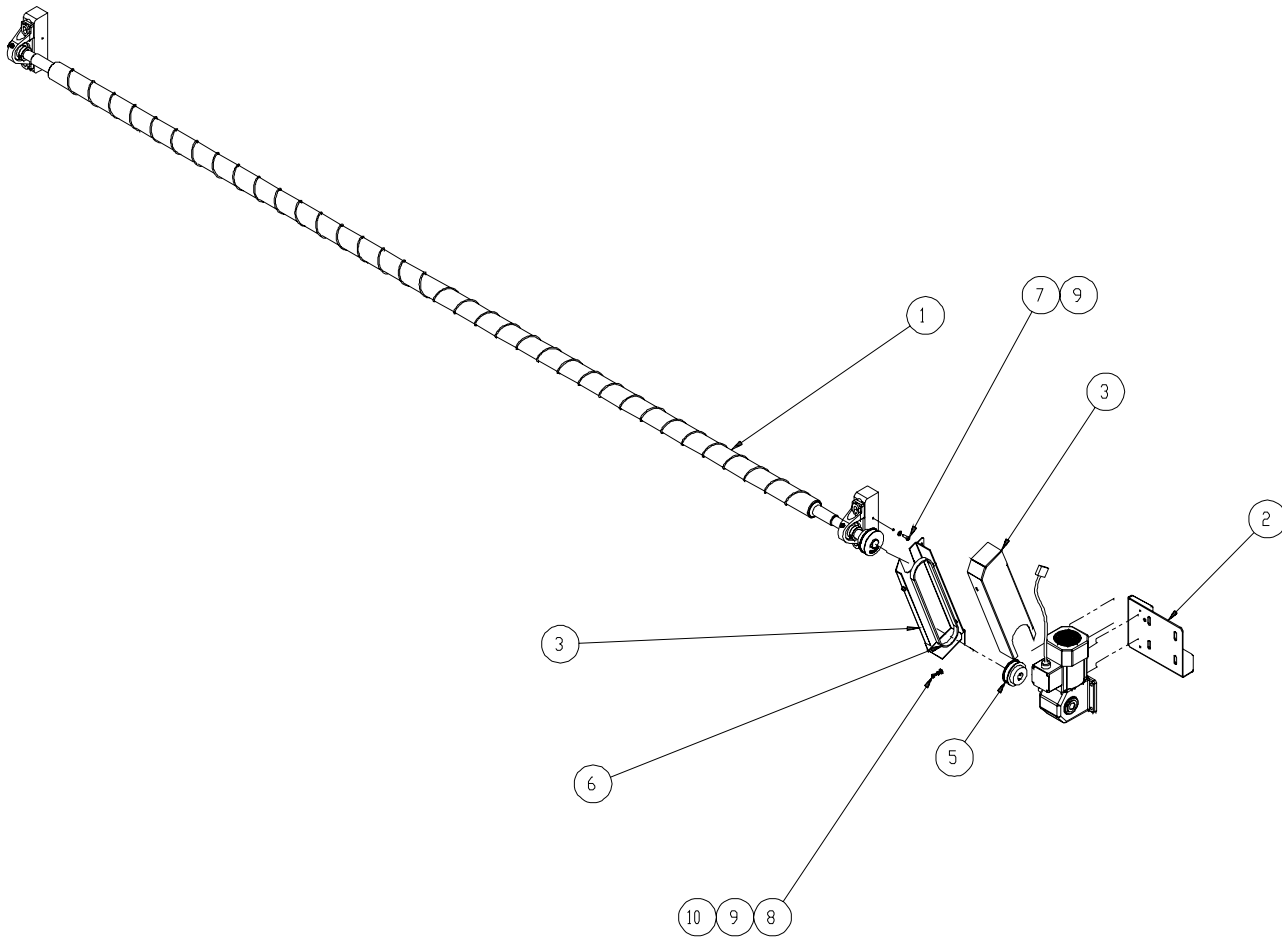
1392580 Bag Closing Mount Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389066	WLDMT,TICK TRAY SUP	2		12	SSHC25064	3/8-16 X 1 HEX HEAD	1	
2	1392168	SUPPORT, BAR, BAG CLSR	1		13	SSSCM6X10	M6-1.0 X 10 SOC CAP	7	
3	1392600	LIMITER	1		14	SSSCM6X16	M6-1.0 X 16 SOC CAP	2	
4	1392601	TRACK TRAY	1		15	SSSCM6X45	SCREW, SOCKET CAP	1	
5	1392605	END STOP-GUARD	1		16	SSSCM8X20	M8-1.25 X 20 SOC CAP	9	
6	1392638	BRACKET	1		17	SSSCM8X25	M8-1.25 X 25 SOC CAP	4	
7	1392959	CLOSER ASSM	1	89	18	SSSCM8X35	M8-1.25 X 35 SOC CAP	1	
8	MMHGR30R3000HNRAIL,LINEAR, HG 3000MM	1			19	WWFS3/8	WASHER, FLAT, 3/8	1	
9	MMHGW30HCZ0HNLINER BEARING	1			20	WWL3/8	3/8 LW	1	
10	NNHM6X1.0	M6 X 1.0 HEX NUT	3		21	WWLM8	M8 LOCK WASHER	1	
11	NNHM8X1.25	M8 X 1.25 HEX NUT	1						

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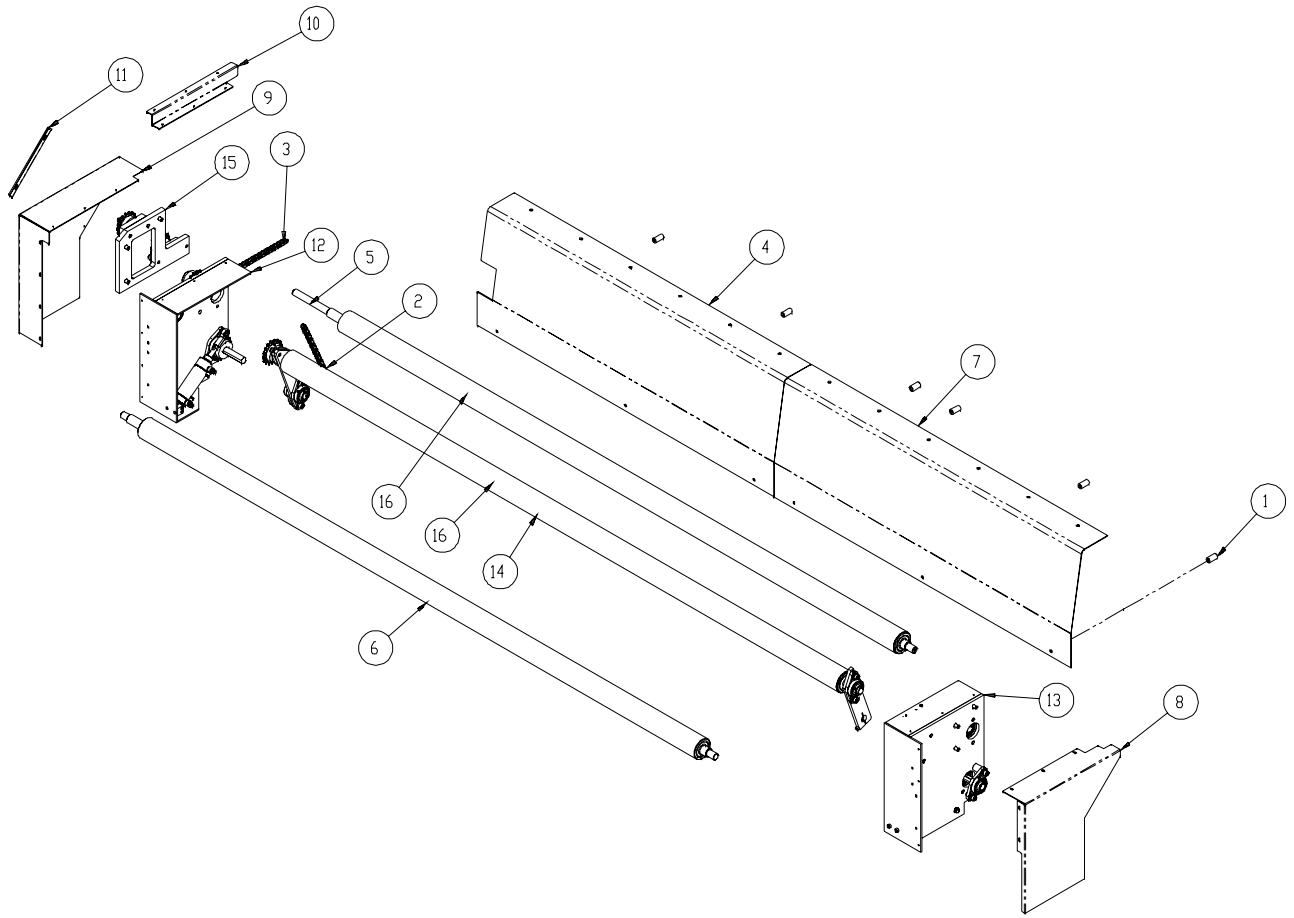


1392897 Pleat Prevention Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392151	B POLE ASSEMBLY	1		7	SSSCM5X16	M5-0.8 X 16 SOC CAP	1	
2	1392155	MOUNT, MOTOR	1		8	SSSCM5X8	M5-0.8 X 8 SOC CAP	1	
3	1392645	GUARD, MOTOR	1		9	WWFS10	WASHER, FLAT #10	2	
4	1392693	MOTOR ASSY, SPIRAL RLR	1		10	WWL10	#10 LW	1	
5	1961-369	PULLEY, CLUTCH, 20T, 3/8	1						
6	GG285L050	BELT, 3/8P, 76T, 1/2W	1						
							Rev. 0		

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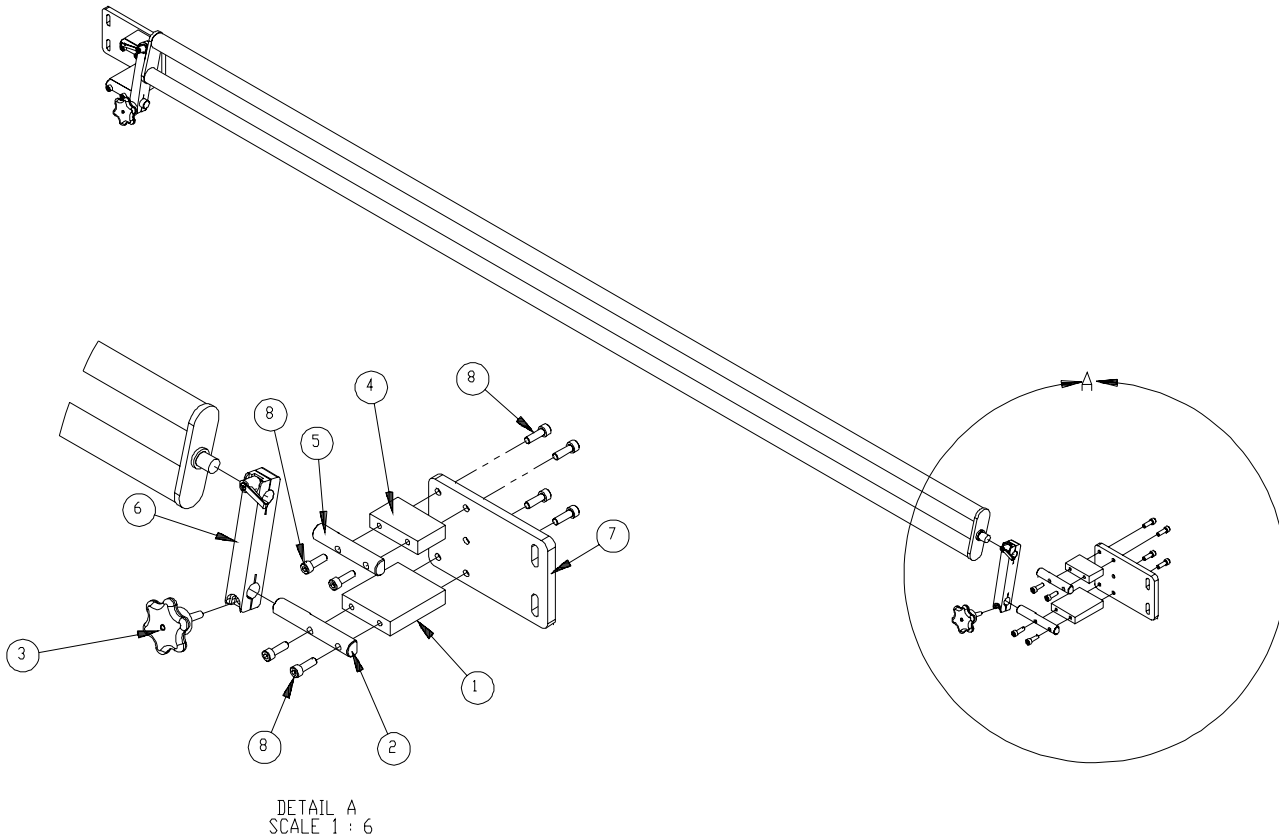
1392978 Front Feed Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389433	SPACER,3/4X1.5X.38ID	6		10	1392933	LEFT GUARD INSERT	1	
2	1392102	CHAIN, INSIDE, 24.375 L	1		11	1392934	LEFT GUARD BRACE	1	
3	1392144	CHAIN, OUTSIDE, 81.875 L	1		12	1392935	FRONT LEFT ROLLER ASY	1	91
4	1392172	GUIDE PLATE, INFEED, LT	1		13	1392936	FRONT RT ROLLER ASY	1	92
5	1392816	ROLLER, INPUT,MODIFIED	1		14	1392937	FRONT FEED ROLLER ASY	1	93
6	1392879	ROLLER, INPUT	1		15	1392938	LEFT SPROCKET SUB-ASY	1	94
7	1392909	GUIDE PLATE,INFEED,RT	1		16	MM050526	TAPE,SANDPAPER,240	2	
8	1392921	GUARD, FRONT ROLLER	1						
9	1392925	GUARD, FRONT ROLLER	1						

Rev. 5

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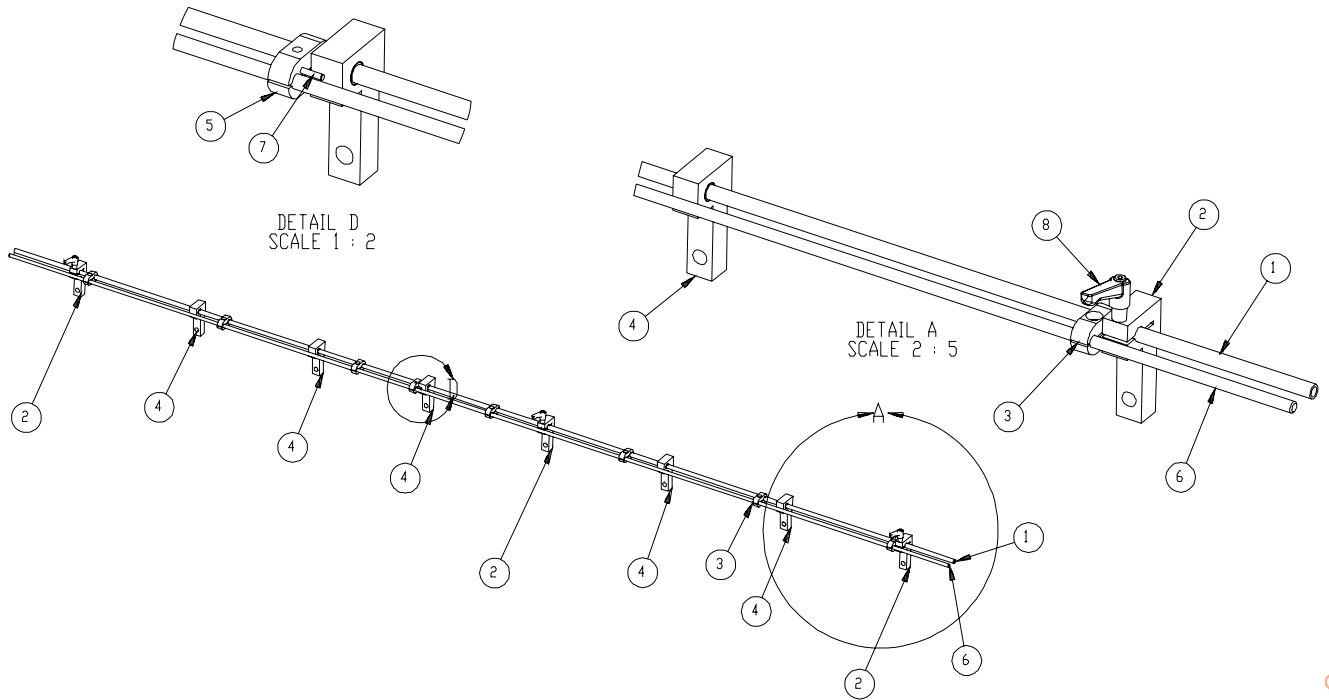
1393922 Tensioner Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389188	SPACER,3/4 X 3 X 3-1/2	2		6	1393927	ARM,PIVOT	2	
2	1389189	SHAFT,PIVOT,TENS BARS	2		7	1393928	PLATE,TENSION BAR MTG	2	
3	1389469	KNOB,THREADED,M8	2		8	SSCM8X25	M8-1.25 X 25 SOC CAP	16	
4	1389522	SPACER,3/4 X 3 X 1-3/4	2		9	TTH6324K63	M8 X 20mm	2	
5	1389617	ROD,STOP,TENSION BARS	2						

Rev. 3

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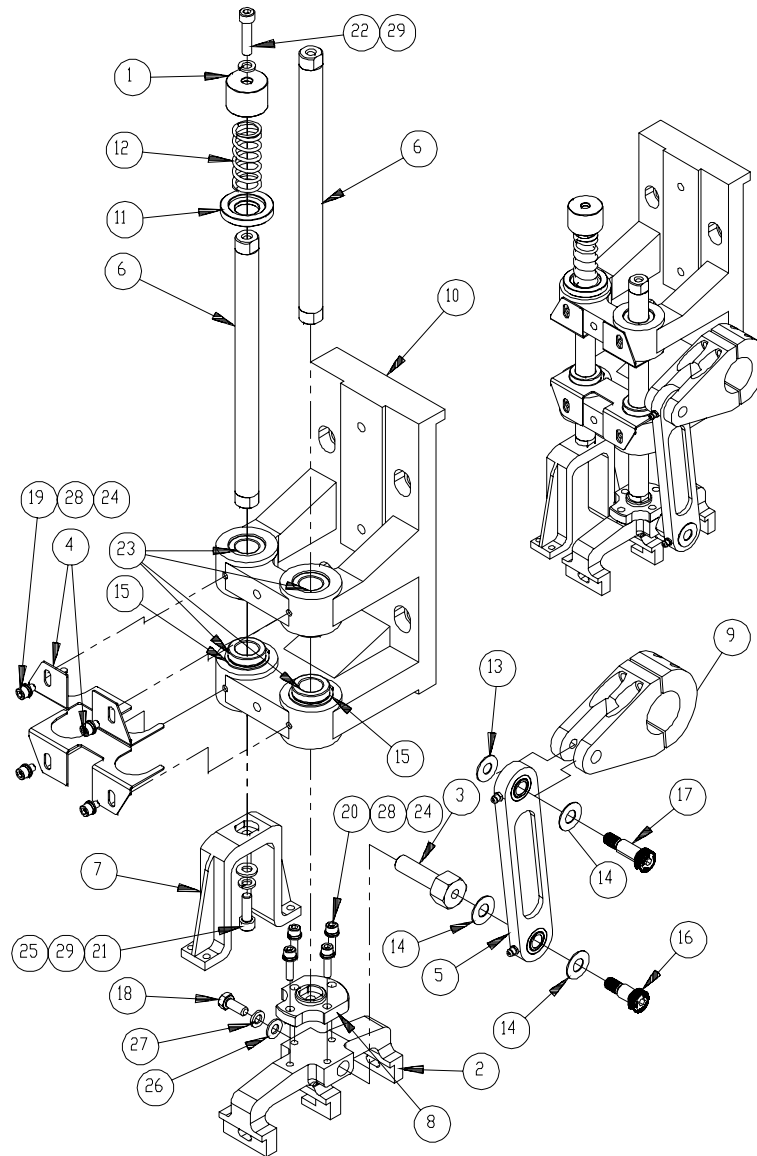


1389073 Needle Thread Take-Up Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389041	ROD,10MM DIA.	1		6	4-090	ROD, THREAD GUIDE	1	
2	1389043	CLAMP,THRD GUIDE ROD	3		7	IID008X064	DOWEL PIN,1/8 X 1	1	
3	1389044	LINK,ADJ NDL THD TAKE-UP	7		8	TTH32415	HANDLE,THREADED,1/4-20	3	
4	1389045	PIVOT, THREAD GUIDE ROD	5			Rev. 1			
5	1389198	LINK,ADJ NDL THD TAKE-UP	1						

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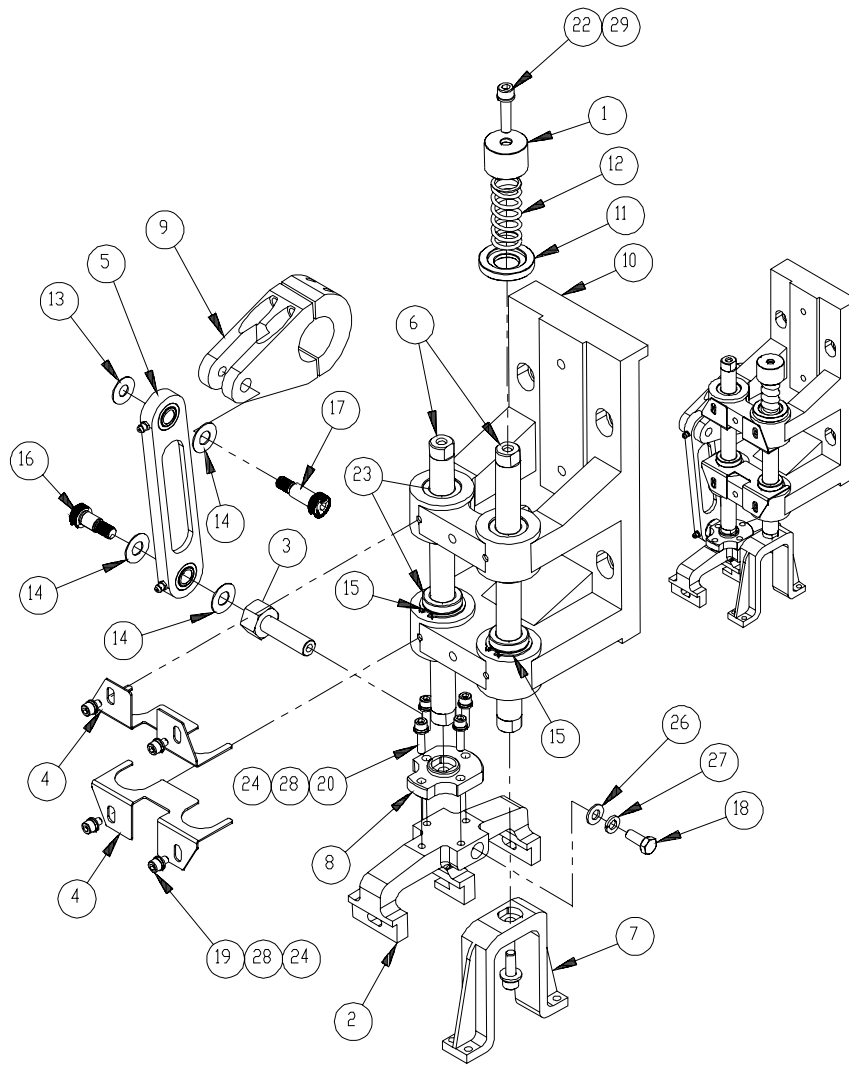
1393998 Needle Drive Assembly

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#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389016	GUIDE, SPRING, PRESS FT AR			16	SSASM12M16	SCREW,ALLEN SHOULDER 1		
2	1389539	NEEDLE BAR CONNECTOR 1			17	SSASM12M25	SCREW,ALLEN SHOULDER 1		
3	1389640	DRIVE PIN, NEEDLE BAR	1		18	SSHCM8X20	SCREW,HEX CAP	1	
4	1393870	RETAINER, LINEAR BRNG	2		19	SSSCM6X10	M6-1.0 X 10 SOC CAP	4	
5	1393908	DOG BONE, ASM	1		20	SSSCM6X25	M6-1.0 X 25 SOC CAP	4	
6	1393973	NDL/PRESS BAR ASSY	2		21	SSSCM8X25	M8-1.25 X 25 SOC CAP	1	
7	1393974	BRACKET,PRESSER FOOT	1		22	SSSCM8X35	M8-1.25 X 35 SOC CAP	1	
8	1393979	PLATE,NDL BAR ATTACH	1		23	UUFM20	BEARING,AL-FRELON 20MM4		
9	1393980	CRANK,NDL BAR DRIVE	1		24	WWFM6	6MM FLAT WASHER	8	
10	1393982	NEEDLE BAR BRG BLK	1		25	WWFM8	8MM FLAT WASHER	1	
11	5-007	GUIDE, SPRING, PRSR FT	1		26	WWFS5/16	WASHER, FLAT, 5/16	1	
12	7-019	SPRING, PRESSER FOOT	1		27	WWL5/16	5/16 LW	1	
13	MM5909K71	WASHER,THRUST,10MM ID	3		28	WWLM6	M6 LOCK WASHER	8	
14	MM5909K72	WASHER,THRUST,12MM ID	3		29	WWLM8	M8 LOCK WASHER	2	
15	MM98541A139	RETAINING RING,32MM EXT4							

Rev. 6





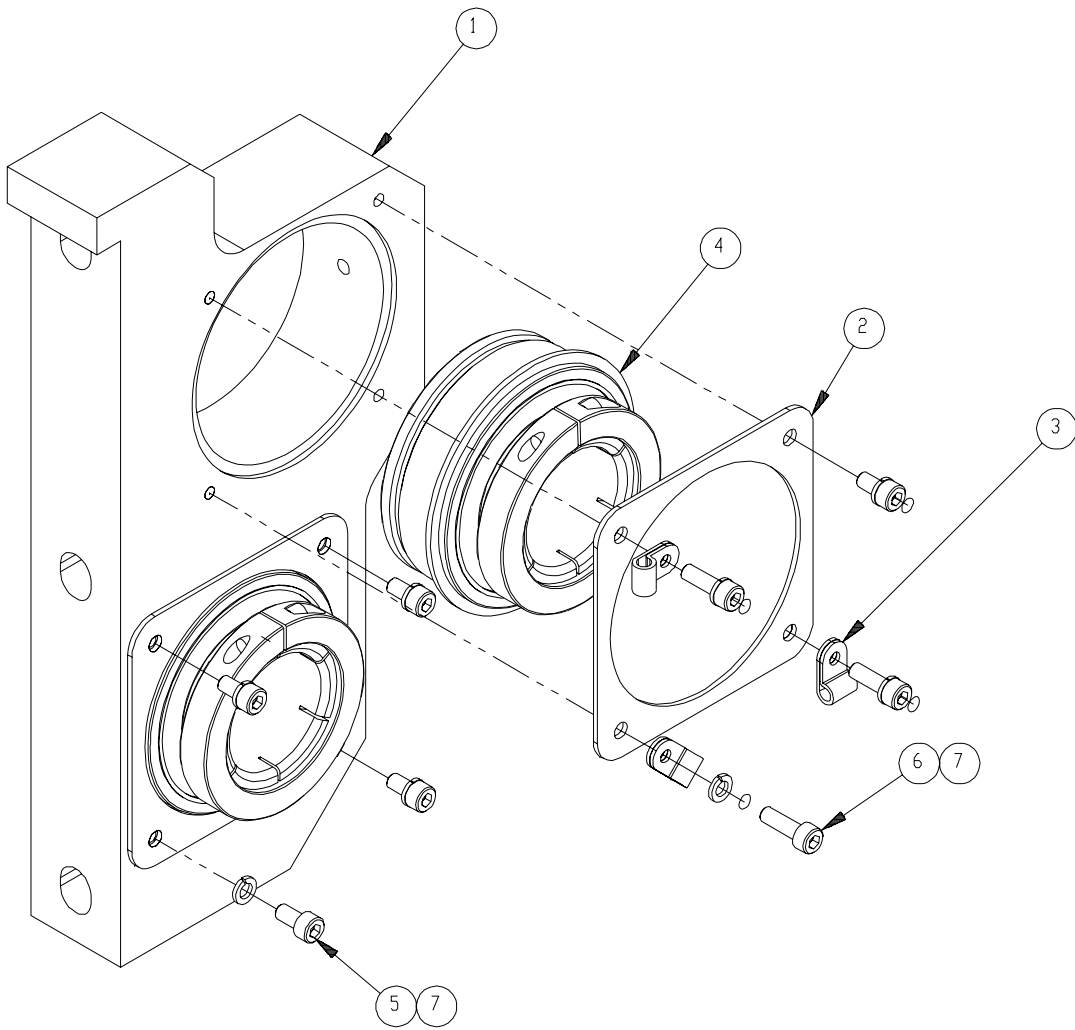
1393999 Needle Drive Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389016	GUIDE, SPRING, PRESS FT AR			16	SSASM12M16	SCREW,ALLEN SHOULDER	1	
2	1389539	NEEDLE BAR CONNECTOR 1			17	SSASM12M25	SCREW,ALLEN SHOULDER	1	
3	1389640	DRIVE PIN, NEEDLE BAR	1		18	SSHCM8X20	M8-1.25 X 20 HEX HEAD	1	
4	1393870	RETAINER, LINEAR BRNG	2		19	SSSCM6X10	M6-1.0 X 10 SOC CAP	4	
5	1393908	DOG BONE, ASM	1		20	SSSCM6X25	M6-1.0 X 25 SOC CAP	4	
6	1393973	NDL/PRESS BAR ASSY	2		21	SSSCM8X25	M8-1.25 X 25 SOC CAP	1	
7	1393974	BRACKET,PRESS FOOT	1		22	SSSCM8X35	M8-1.25 X 35 SOC CAP	1	
8	1393979	PLATE,NDL BAR ATTACH	1		23	UUFM20	BEARING,AL-FRELON 20MM4		
9	1393980	CRANK,NDL BAR DRIVE	1		24	WWFM6	6MM FLAT WASHER	8	
10	1393982	NEEDLE BAR BRG BLK	1		25	WWFM8	8MM FLAT WASHER	1	
11	5-007	GUIDE, SPRING, PRESS FT	1		26	WWFS5/16	WASHER, FLAT, 5/16	1	
12	7-019	SPRING, PRESSER FOOT	1		27	WWL5/16	5/16 LW	1	
13	MM5909K71	WASHER,THRUST,10MM ID	1		28	WWLM6	M6 LOCK WASHER	8	
14	MM5909K72	WASHER,THRUST,12MM ID	3		29	WWLM8	M8 LOCK WASHER	2	
15	MM98541A139	RETAINING RING,32MM EXT4							

Rev. 6

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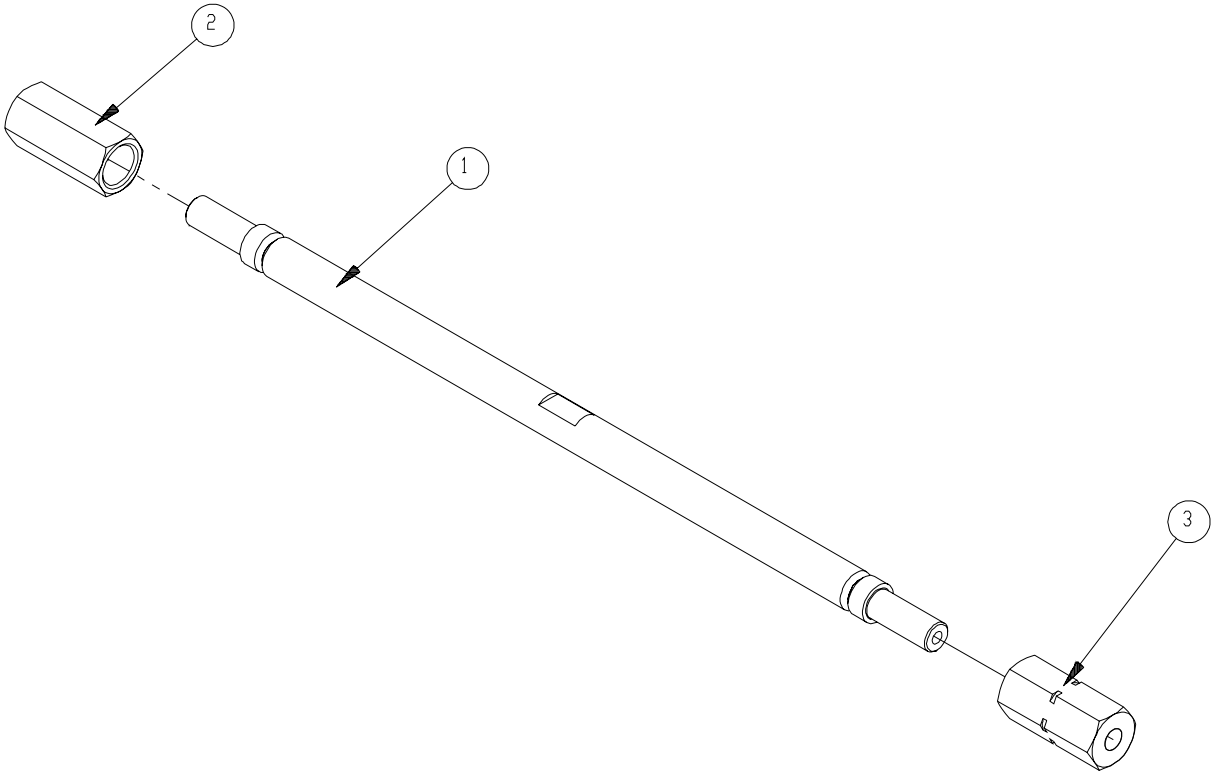


1393994 Bearing Mount Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1393992	MOUNT, INSERT BEARING	1		5	SSSCM5X10	M5-0.8 X 10 SOC CAP	5	
2	1393993	RETAINER, CART BRG	2		6	SSSCM5X16	M5-0.8 X 16 SOC CAP	3	
3	AAF3/16	CLAMP, BLACK PLASTIC	3		7	WWLM5	M5 LOCK WASHER	8	
4	BBER208TMC	BEARING,INSERT	2						
						Rev. 1			

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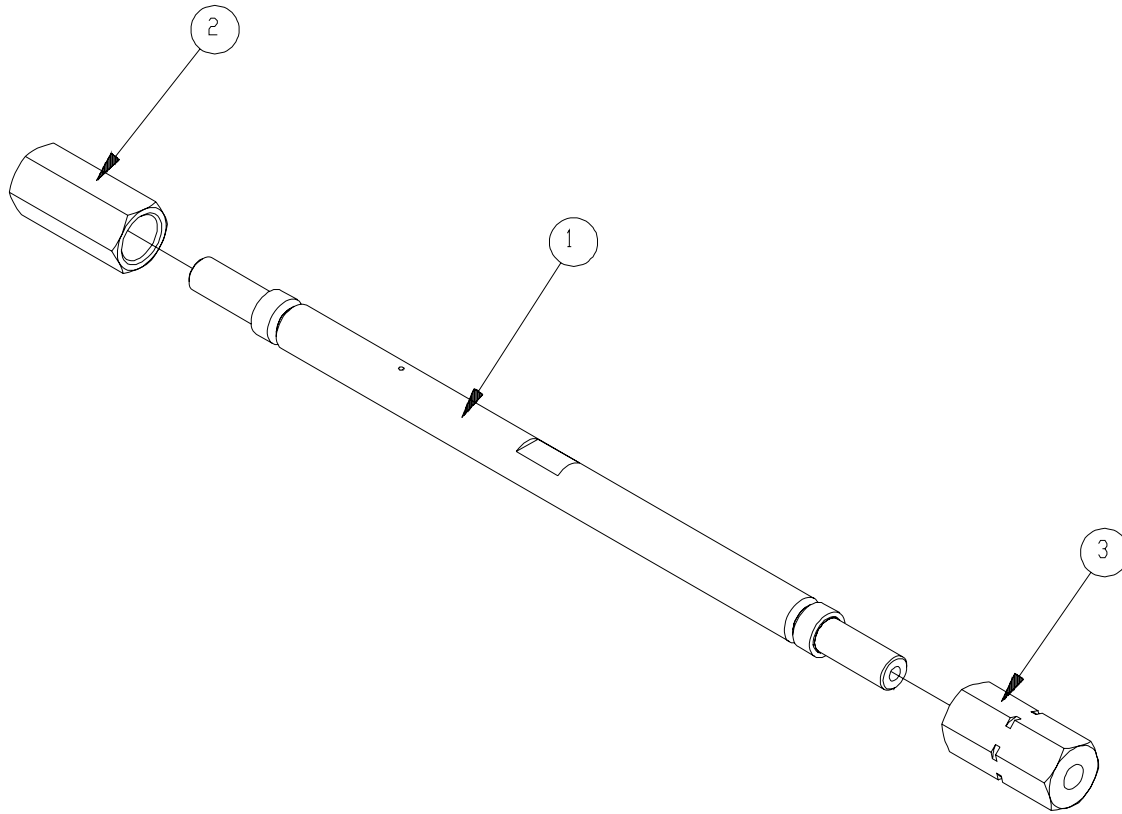


1393983 Tie Rod Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1393868	TIE ROD WELDMENT	1		3	1393985	NUT,TIE-ROD, LH THREAD	1	
2	1393984	NUT,TIE-ROD, RH THREAD	1			Rev. 0			

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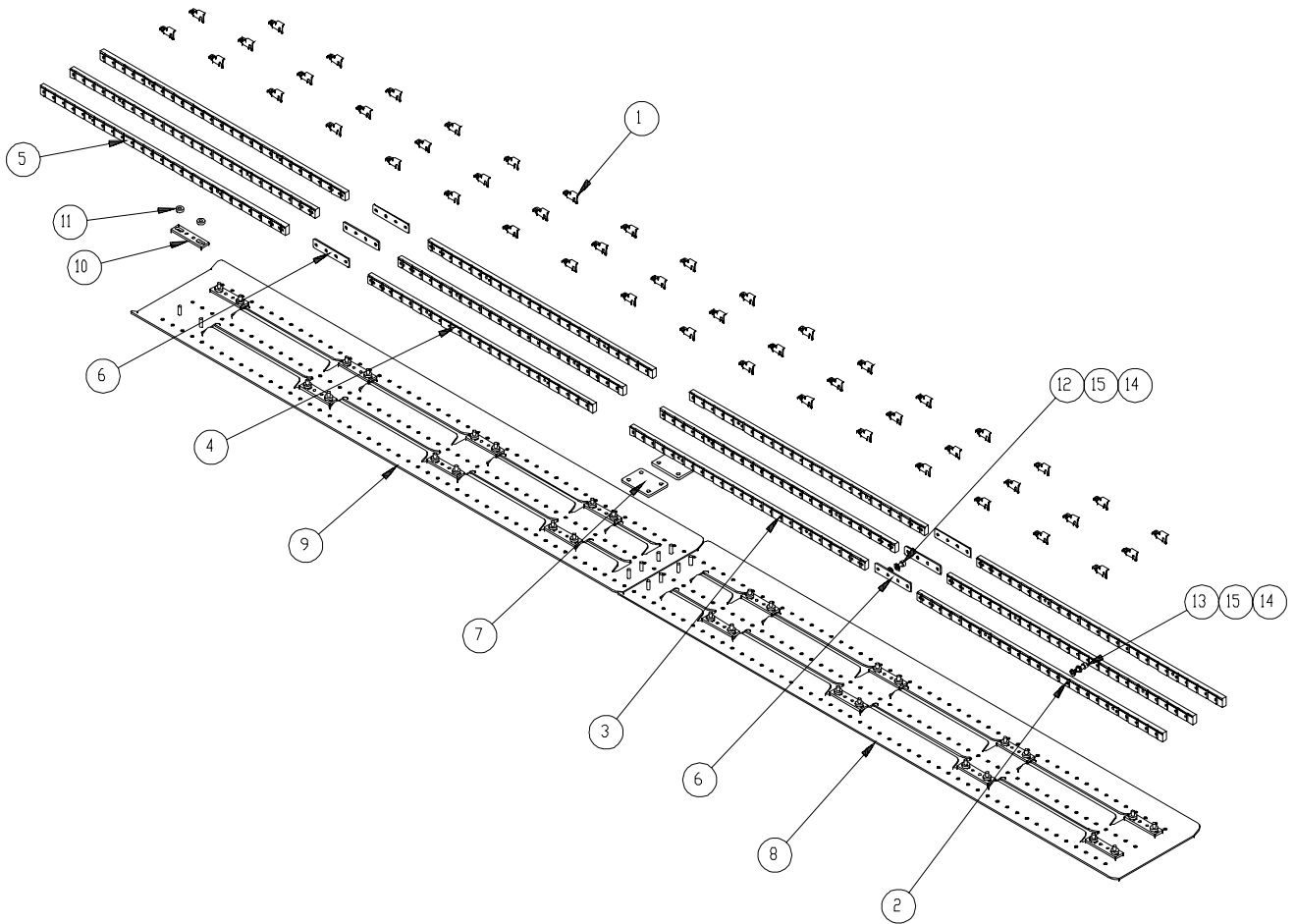


1393986 Tie Rod Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392719	TIE ROD WELDMENT,NDL	1		3	1393985	NUT,TIE-ROD, LH THREAD	1	
2	1393984	NUT,TIE-ROD, RH THREAD	1			Rev. 0			

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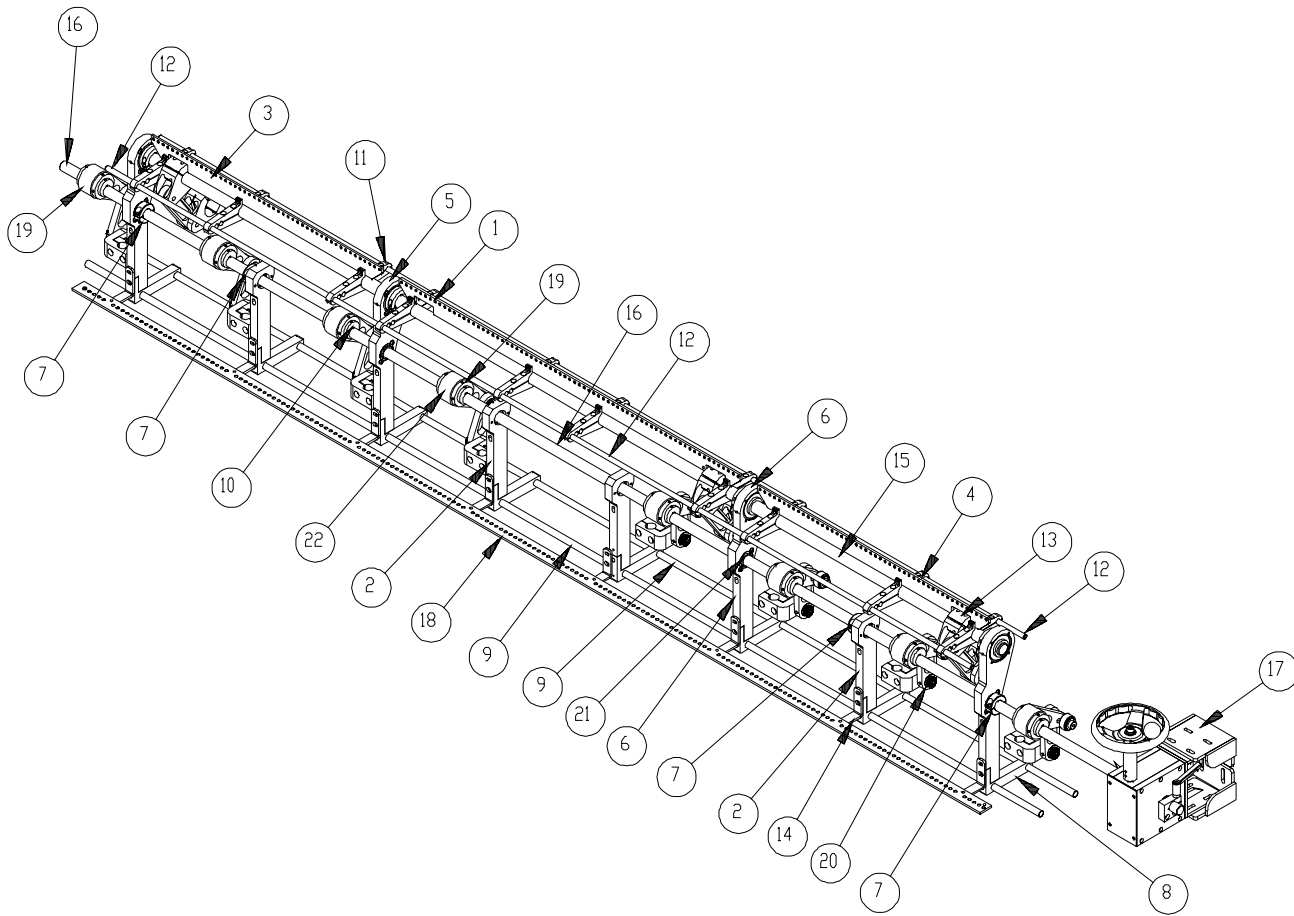


1389509 Presser Feet & Needle Bars

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389031	EYELET, NEEDLE THREAD	50		9	1393926	PRESSER FOOT, LH	1	
2	1393860	NEEDLE CLAMP, RT	3		10	1393952	PLATE, ADAPTER	16	
3	1393861	NEEDLE CLAMP, R. MIDDLE	3		11	1393953	WASHER, HEAVY	32	
4	1393900	NEEDLE CLAMP, L. MIDDLE	3		12	SSSCM6X12	SCREW, SOCKET CAP	24	
5	1393901	NEEDLE CLAMP, LEFT	3		13	SSSCM6X20	M6-1.0 X 20 SOC CAP	24	
6	1393902	PLATE, WASHER	6		14	WWFM6	6MM FLAT WASHER	48	
7	1393921	PLATE, SPLICE, FOOT	2		15	WWL1/4	1/4 LW	48	
8	1393925	PRESSER FOOT, RH	1			Rev. 0			

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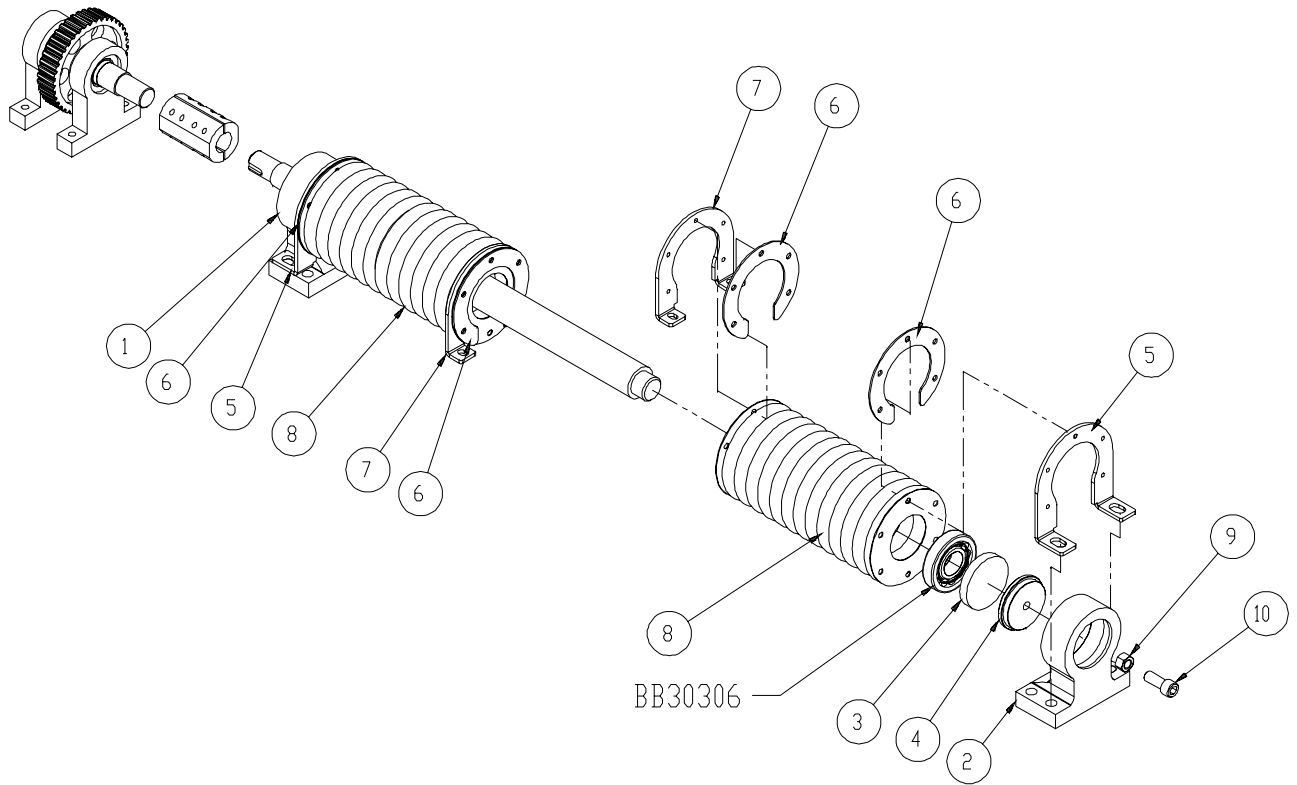
1393864 Foot Adjustment Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389003	BAR,EYELET	1		13	1392846	BUTTERFLY DRIVE ASSY	3	
2	1389004	BLOCK,BEARING,SHORT	4		14	1392847	BRKT,EYELET BAR MTG	8	
3	1389014	BAR,EYELET,SHORT,LEFT	1		15	1392849	SHAFT,BUTTERFLY,25MM	1	
4	1389015	BAR,EYELET,SHORT,RIGHT	1		16	1393865	SHAFT,FOOTLIFT ADJUST	1	
5	1389199	BEARING,RIGHT HAND	2		17	1393875	FOOTLIFT ADJUST KNOB	1	95
6	1389200	BEARING LEFT HAND	2		18	1393955	BAR,EYELET	1	
7	1389524	CLAMP COLLAR,M20	4		19	1393957	FOOTLIFT LINKAGE, RIGHT	4	
8	1392019	BLOCK,THREAD ROD	8		20	1393958	FOOTLIFT LINKAGE, LEFT	4	
9	1392066	THREAD GUIDE ROD, FRNT	2		21	BBGE20ES2RS	BEARING,SPHERICAL PL	5	
10	1392686	KEY, 6mm	8		22	SSBCM6X12	M6 X 12MM BUT HEAD	8	
11	1392811	BAR,CLAMP,BUTTERFLY	10						
12	1392844	TUBE,BUTTERFLY	2						

Rev. 6

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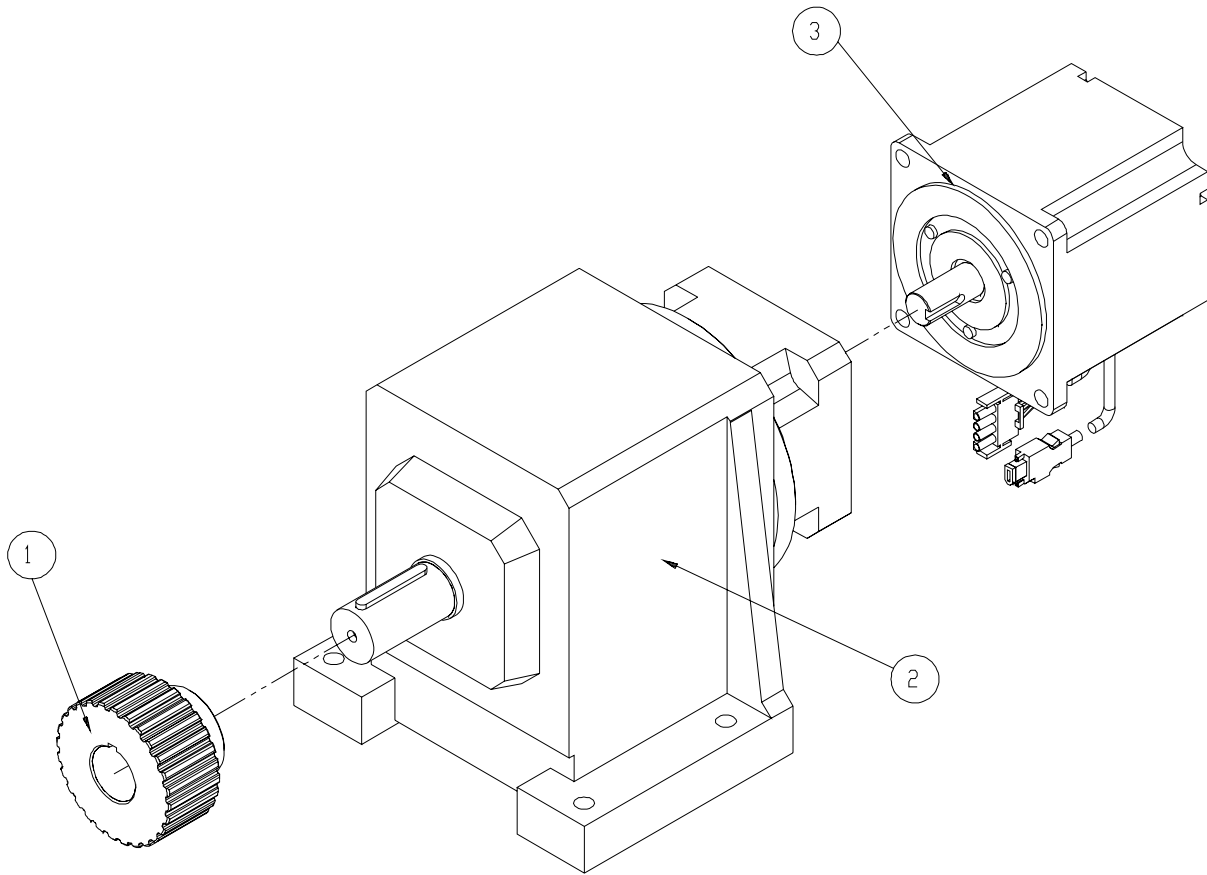


1392096 Worm Gear Drive Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389082	MOUNT, ROLLER BEARING	1		7	1392277	BRACKET, BELLOW	2	
2	1389083	MOUNT, ROLLER BEARING	1		8	MM9740K14	BELLOW, W/ ZIPPER	2	
3	1389297	BEARING THRUST DISC	1		9	NNHM12X1.75	M12 X 1.75 HEX NUT	1	
4	1389307	BEARING THRUST NUT PLT	1		10	SSSCM12X30	SCREW, SOC CAP, M12 X 30		
5	1392271	BRACKET, BELLOW	2						Rev. 2
6	1392276	BRACKET, BELLOW	4						

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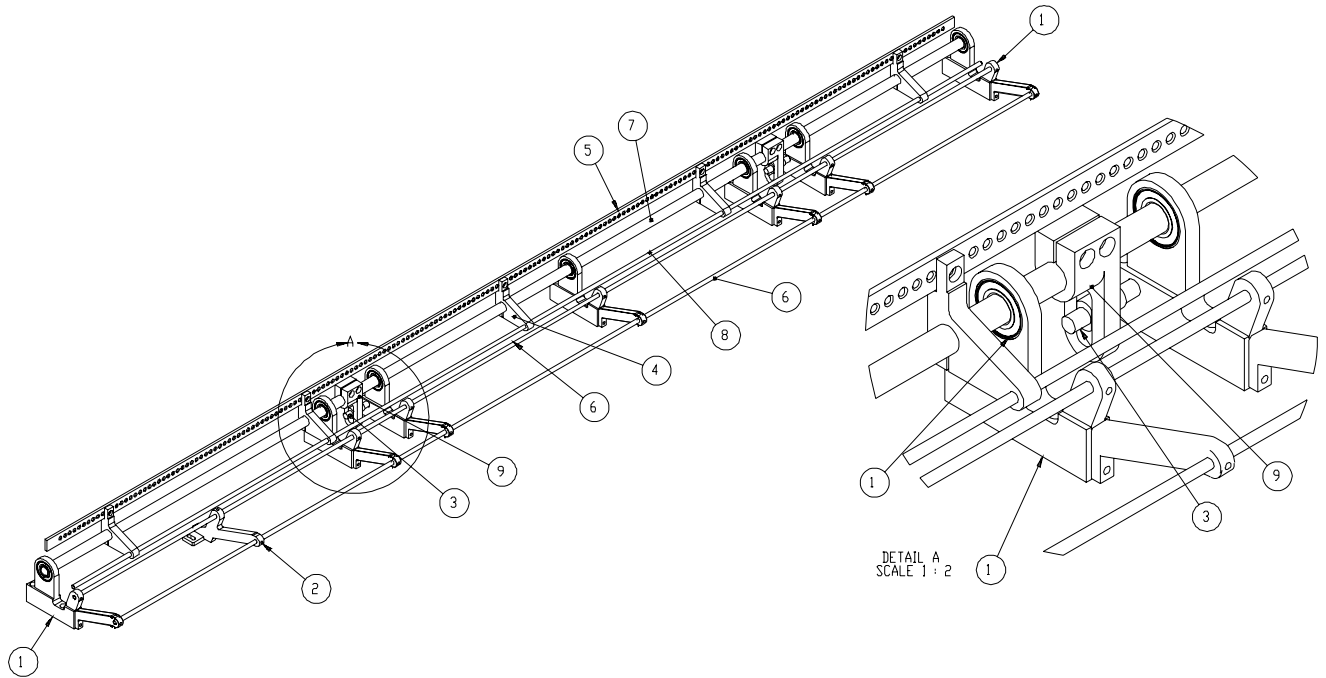


1392070 Servo Drive Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392809	PULLEY, GEAR, 38MM WIDE	1		3	SGMPH15AAE41DMOTOR, SERVO, 1.5KW		1	
2	C302N0410MT20	GEARBOX, CONC. HELICAL	1			Rev. 1			

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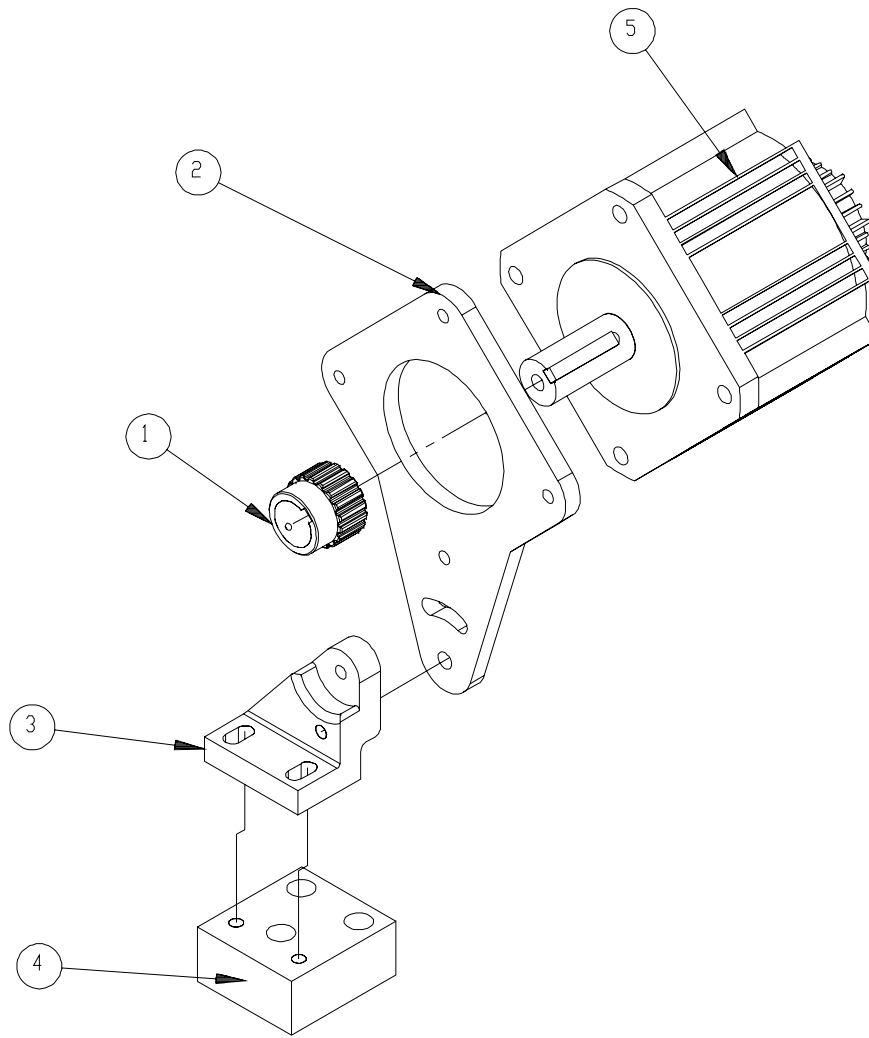


1392196 Looper, Take-Up Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392304	BUTTERFLY, BRNG ASSY	7		6	4-051	GUIDE, THREAD ROD	2	
2	1392983	ROD SUPPORT, THREAD	1		7	4-052	SHAFT, REAR TAKE-UP	1	
3	5-033	SHAFT, RODEND, BTRFLY	2		8	4-053	ROD, REAR TAKE-UP	1	
4	4-083	TAKE-UP, THREAD ROCKERS	5		9	2-081	DRIVE ARM, REAR BTRFLY	2	
5	4-084A	GUIDES, THREAD	1			Rev. 2			

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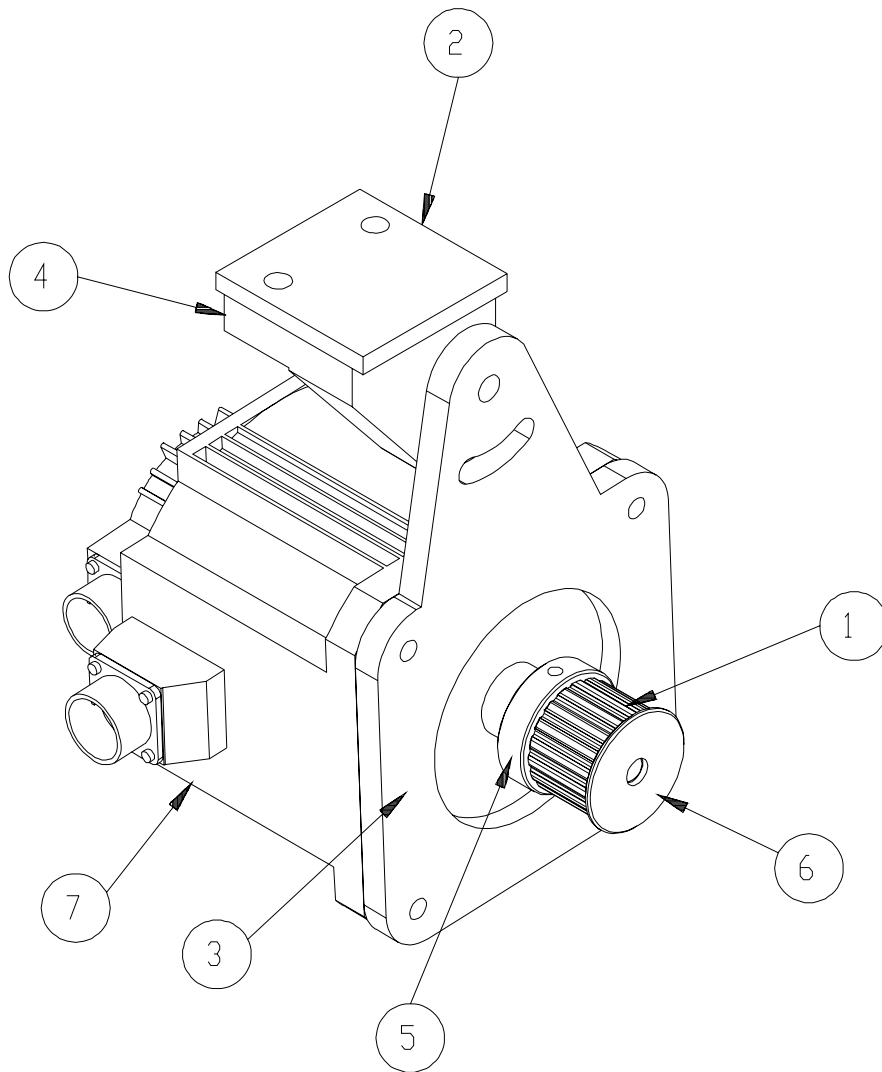


1392071 Servo Drive Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1-034	PULLEY, TIMING, 18T	1		4	6-010A	SPACER, MOTOR MOUNT	1	
2	2-033-M	MOUNT, MOTOR	1		5	SGMGH30ACA61	MOTOR, SERVO 3.0KW	1	
3	2-046	BRACKET, MOTOR	1						
						Rev. 0			

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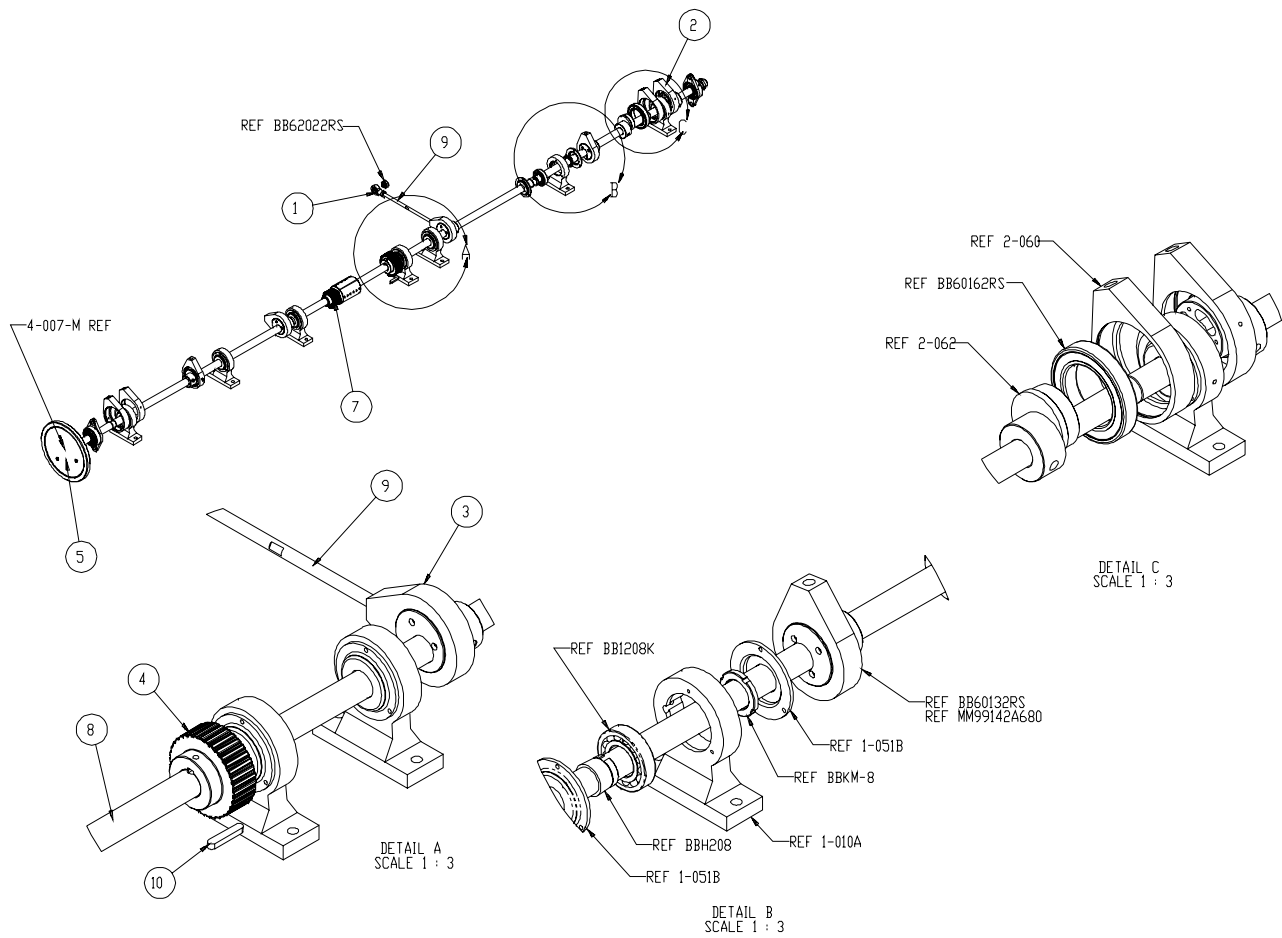


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1392082 Needle Bar Drive Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392101	PULLEY, GEAR, L 38MM	1		5	1392740	COLLAR,PULLEY	1	
2	1392261	SPACER, MOTOR, BASE	1		6	1392741	WASHER,PULLEY	1	
3	1392499	MOUNT, MOTOR, BOTTOM	1		7	SGMGH30ACA61	MOTOR, SERVO 3.0KW	1	
4	1392654	MOUNT, MOTOR, BASE	1						
						Rev. 3			





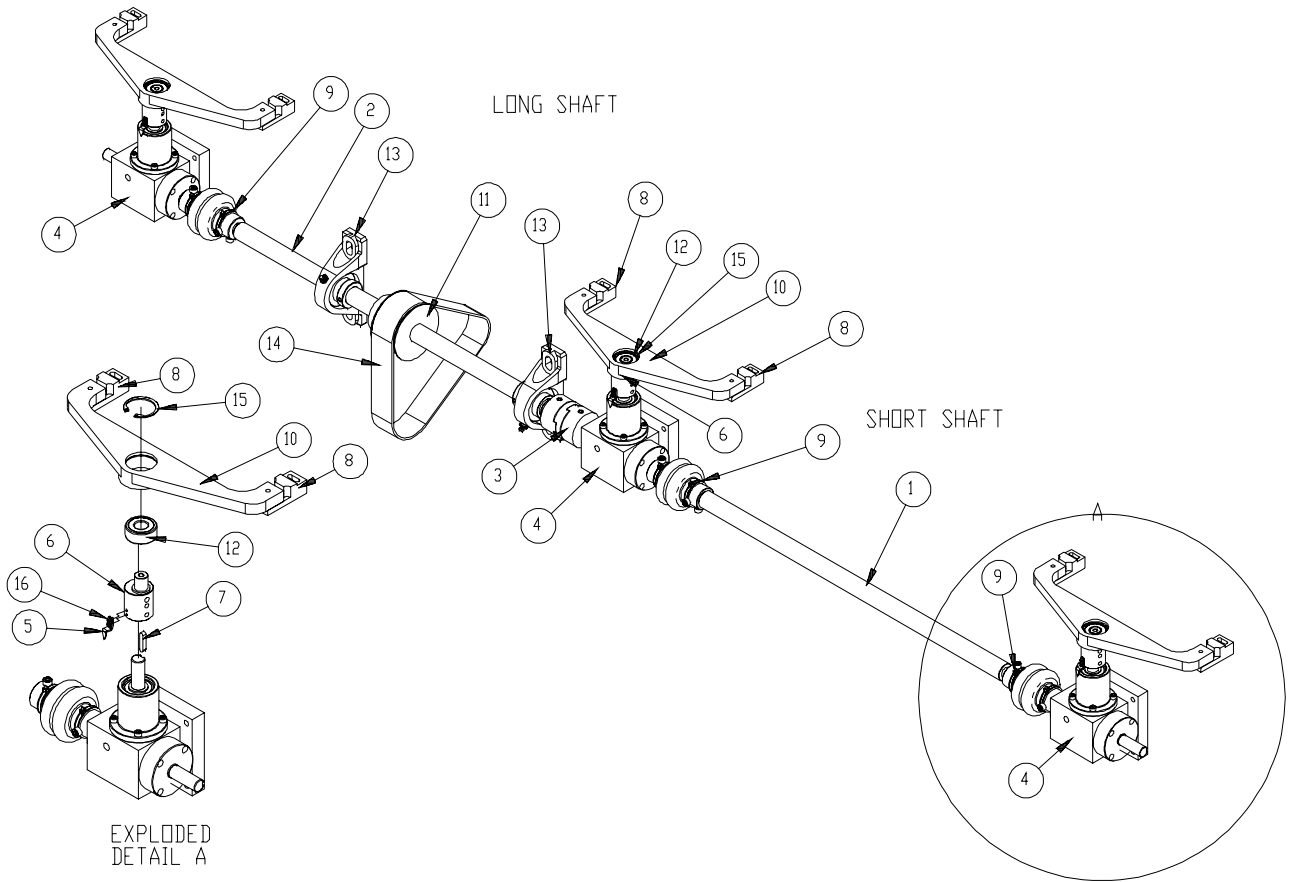
1392103 Main Drive Shaft Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1-017	ROD END, PRESSER FOOT	1		7	3-028A	PULLEY, GEAR, 40MM WIDE	1	
2	1389024	ECCENTRIC, LARGE, ASM	2		8	4-008-M	SHAFT, RIGHT NDL BAR DR	1	
3	1389025	ECCENTRIC, SMALL, ASM	2		9	5-032	PITMAN ROD, 16MM X 320	1	
4	1392509	PULLEY, GEAR, 38MM WIDE	1		10	A9C39M100856	KEY, SHAFT	1	
5	1392549	HANDWHEEL ASSY,	1		11	BBUKFL208	BEARING, FLANGE UKFL	2	
6	2-062	NDL BAR ECCENTRIC	1						

Rev. 2

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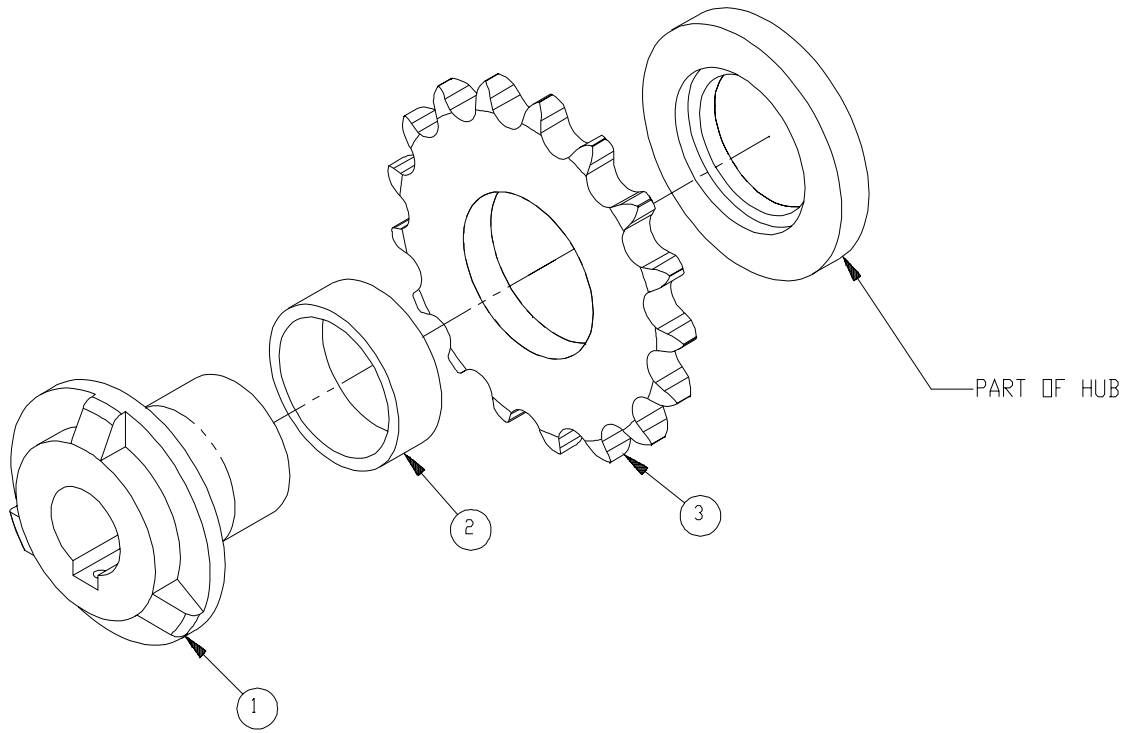


1389495 Retainer Drive Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389381	SHAFT,SPREADR DRIVE,RT	1		10	1393976	BOOMERANG, RETAINER	3	
2	1389382	SHAFT,SPREADR DRIVE,LT	1		11	3-021A	PULLEY,25MM B,26 TH	1	
3	1389383	COUPLING,OFFSET	1		12	BB22022RS	BEARING, BALL, 15ID, 35OD3		
4	1389662	RETAINER, GEARBOX, ASM3			13	BBNAP205-25	BEARING, PILLOWBLOCK	2	
5	1389711	POINTER, RETAINER	3		14	GG240L150	BELT,GEAR,3/8P,1-1/2W	1	
6	1389712	ECCENTRIC	3		15	MM98409A233	E-RING, INT, 1-3/8 X .051	3	
7	1389713	5MM X 5MM X 25MM KEY	3		16	SSPSM3X4	M3-0.5 X 4 PAN HD SLOT	6	
8	1392641	BLOCK, RETAINER	6						
9	1392991	U-JOINT, RETAINER, ASM	3						
							Rev. 2		

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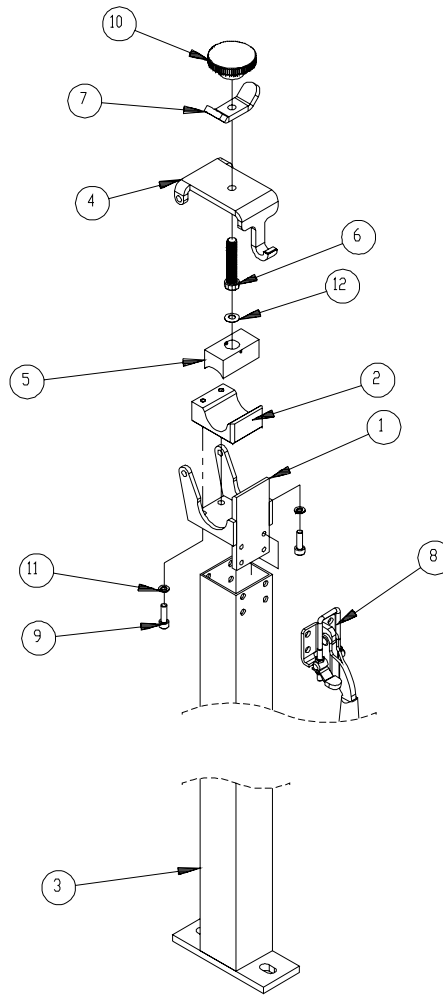


1389575 Torque Limit Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389569	HUB,MODIFIED,22MM B	1		3	MM250AG517	SPROCKET,TORQUE LIMITER1		
2	BB250AX_540	BUSHING,.54L	1			Rev. 0			

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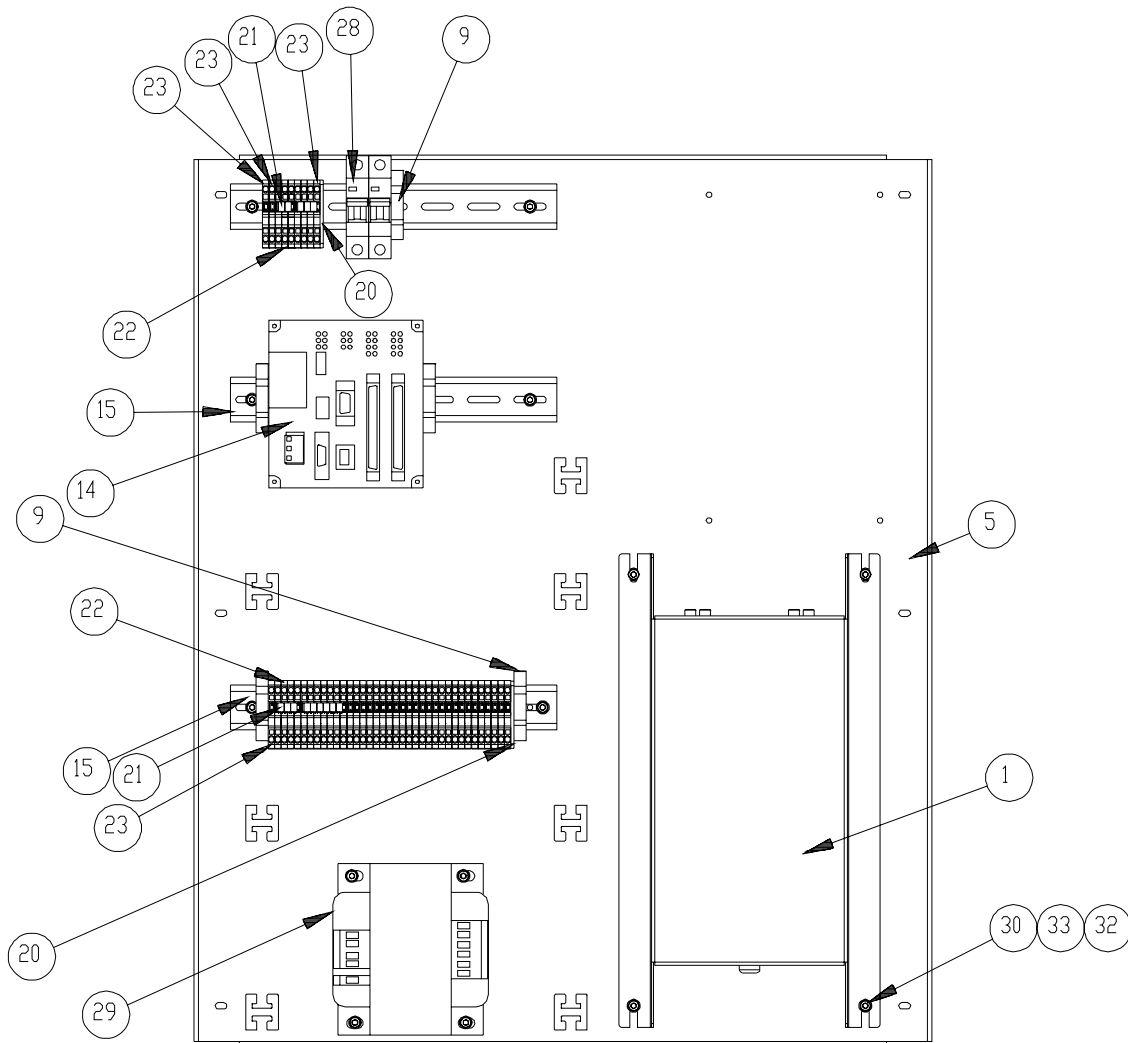


1392545 Tension Rack Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389408	ROD SUPPORT ASSY	1		8	MM331	CLAMP, PULL LATCH	1	
2	1389410	BLOCK,BRAKE,BOTTOM	1		9	SSSCM6X20	M6-1.0 X 20 SOC CAP	2	
3	1392453	LEG WELDMT,MATL RACK	1		10	TTK32315	KNOB,1-7/8OD,3/8B,BLACK	1	
4	1392542	PLATE,CAP,BRAKE,	1		11	WWLM6	M6 LOCK WASHER	2	
5	1392543	BLOCK,DELRIN,S	1		12	WWS307-1	WASHER,SPRING,BELVEL	1	
6	1393802	3/8-24 X 2 HEX HEAD	1						
7	1393803	NUT, WING, 3/8-24	1						
						Rev. 6			

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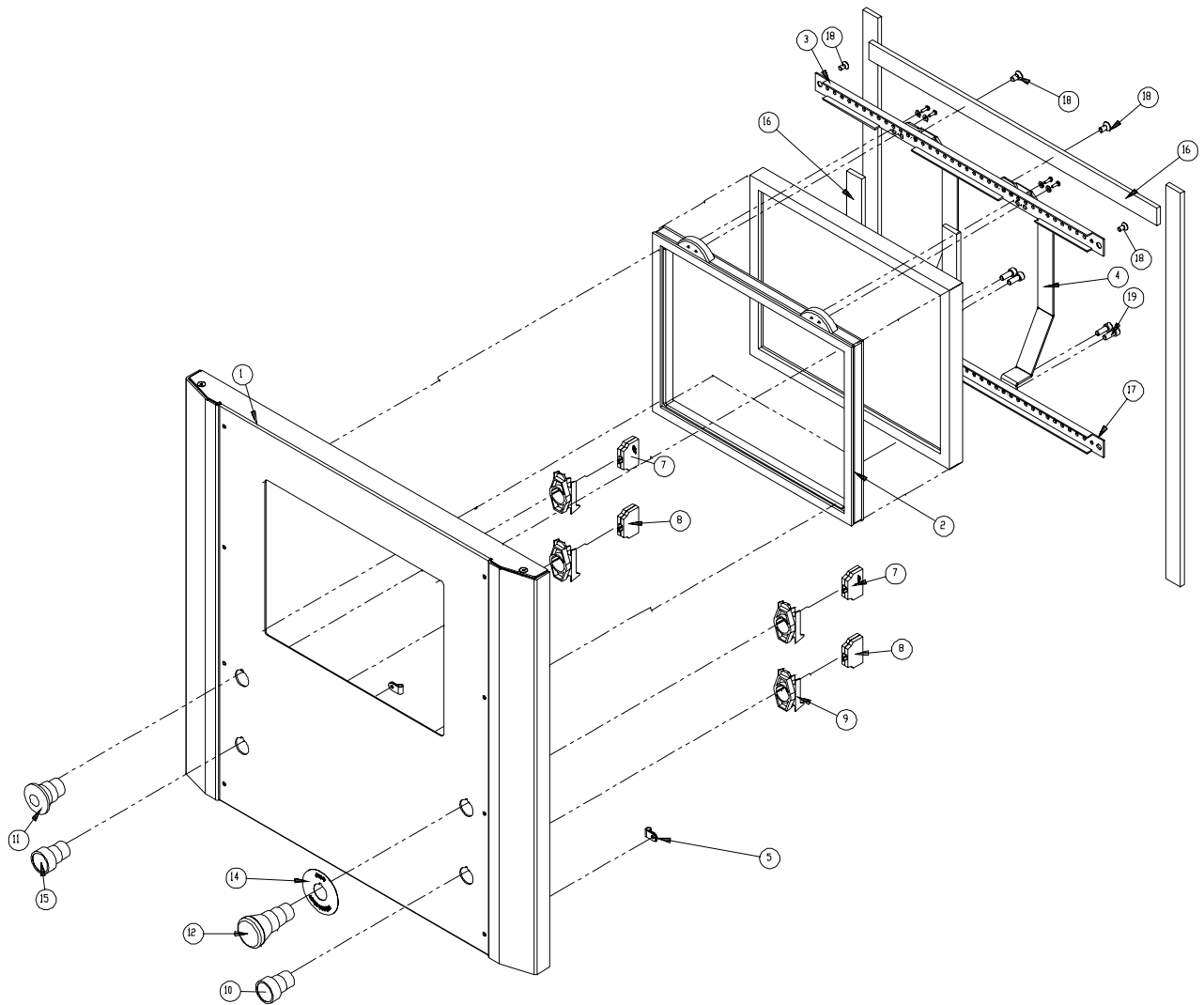
1392366 Back Panel Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392515	REGEN RESISTOR ASSY	1		18	FF209-504	TERMBLK,WAGO,TP,LG	AR	
2	1392663	CABLE ASSY,MP2300 I/O	1		19	FF209-505	TERMBLK,WAGO,TP,LG	AR	
3	1392664	CABLE ASSY,QUILTER I/O	1		20	FF280-308	TERMBLK ENDPLATE,WAGO2		
4	1392665	CABLE ASSY,FLOUR LIGHT	1		21	FF280-402	JUMPER,WAGO, TOP,SNGL	14	
5	1392684	PANEL,FRONT BACKPLANE	1		22	FF280-901	TERMBLK,WAGO, TOP,SNGL42		
6	1392688	CABLE ASSY,CARR LIMIT	1		23	FF280-907	TERMBLK,WAGO, TOP,SNGL4		
7	1392691	CABLE ASSY,SSR	1		24	FF3077-2	WIRE,STR,#16,PVC,BLK	1	
8	EE16-3C2406	CABLE,3 COND,16 AWG	11		25	FF3077-28	WIRE,STR,#16,PVC	1	
9	EECLIPFIX	ANCHOR,DIN RAIL	5		26	FF3077-3	WIRE,STR,#16,PVC,RED	1	
10	EEJAPMCIO2300	I/O CARD,16PT,SINK OUT	1		27	FF822326	CABLE,SOOW,3X16AWG	5	
11	EEJEMCOP2300	SLOT COVER	1		28	FFL762C	CIRCUIT BREAKER	1	
12	EEJEPMCCM2300	COMM MDL RS232	1		29	FFMPI-650-230	TRANSFORMER, 5.6A	1	
13	EEJEPMCOP300	RAIL CLIP,MP2300	1		30	SSSCM5X16	M5-0.8 X 16 SOC CAP	14	
14	EEJPMCMCP2300	CONTROLLER, MOTION	1		31	TTBB5263	TERMINAL,QUICK	4	
15	EETS35X7.5	DIN RAIL	3		32	WWFM5	5MM FLAT WASHER	14	
16	FF209-502	TERMBLK,WAGO,TP,LG	AR		33	WWL10	#10 LW	14	
17	FF209-503	TERMBLK,WAGO,TP,LG	AR						

Rev. 3

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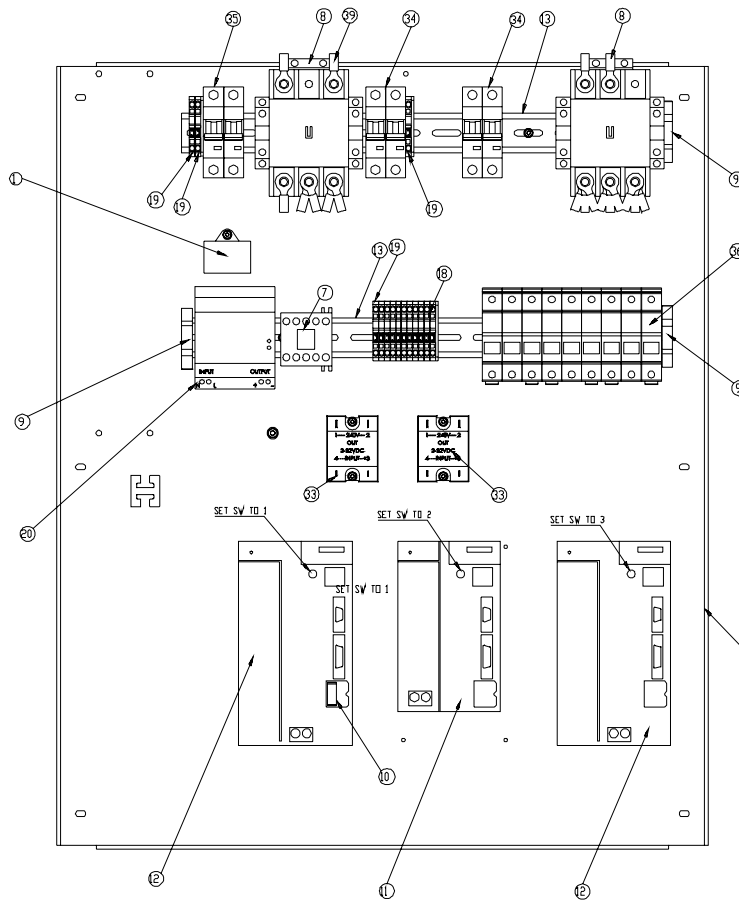
1392393 Control Panel Door Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392746	DOOR ASM, CPANEL	1		11	EEPLMP45	BUTTON,PUSH,22MM,YEL	1	
2	1392768	SCREEN, TOUCH ASSY	1		12	EEPMTS44	START/STOP BUTTON	1	
3	1392770	RAIL, MOUNTING, TSCREEN	1		13	FF19504	CABLE,3 COND,#16,INTL	6'	
4	1392778	STRAP, MOUNTING	2		14	MM800E15YE112	E-STOP LEGEND PLATE	1	
5	AAF3/16	CLAMP, BLACK PLASTIC	2		15	MM800EPF1	BUTTON, PUSH 22MM, WHI	1	
6	EE16-3C2406	CABLE,3 COND #16	10'		16	MM93745K75	TAPE, SOFT FOAM, 1/4"	7.5 FT	
7	EE3X01	BLOCK,P.B. CONTACT, N.C.	2		17	PS4596000	RITTAL MOUNTING RAIL	1	
8	EE3X10	BLOCK,P.B. CONTACT, N.O.	2		18	SSFCM5X10	M5-0.8X10 FLAT ALLEN	8	
9	EEA3L	LATCH,PUSH BUTTON	4		19	SSSCM6X16	M6-1.0 X 16 SOC CAP	4	
10	EEPF3	BUTTON, PUSH 22MM,GRN	1						

Rev. 3

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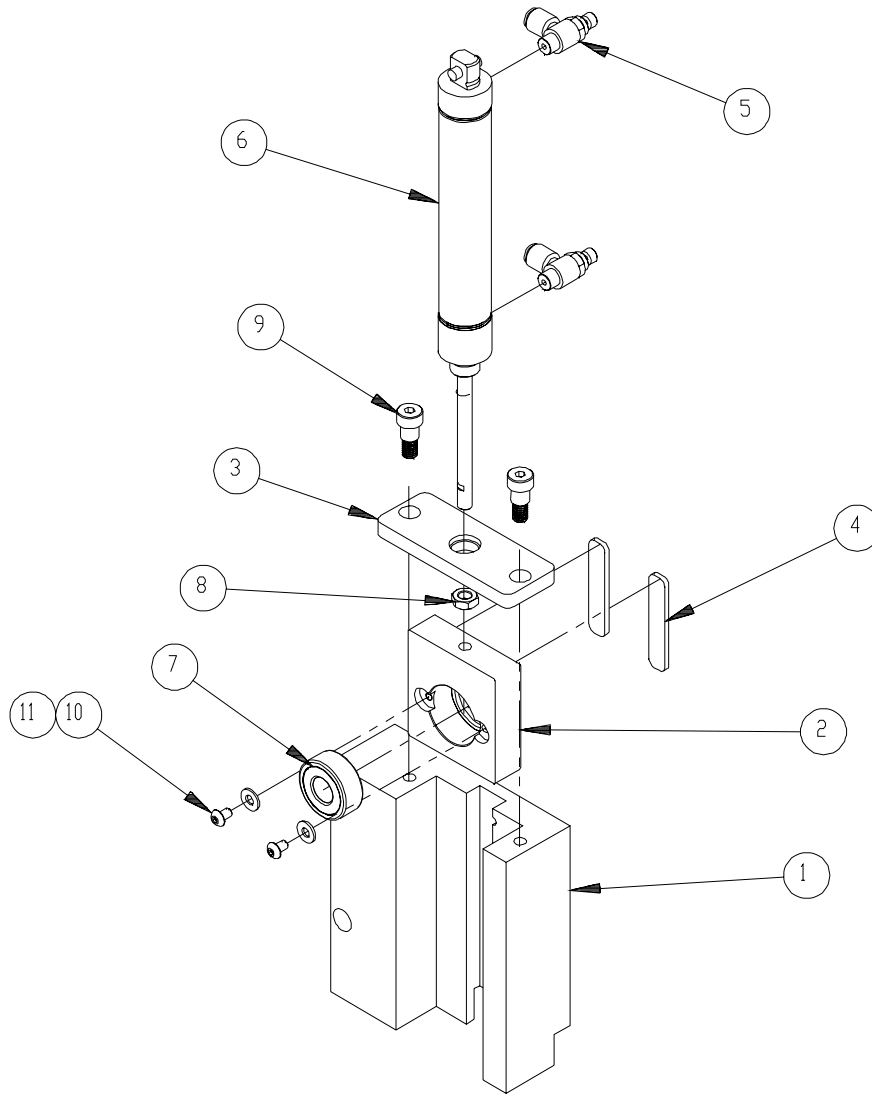
1392367 Back Side Panel Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392657	SURGE SUPPRESS ASSY	1		24	FF31572787	WIRE,STR,#10,PVC	10 FT	
2	1392658	CABLE ASSY,TRANS PRI	1		25	FF8908-10	WIRE,STR,#8,PVC,BLK	10 FT	
3	1392659	CABLE ASSY,E-STOP RCPT	1		26	FF8908-13	WIRE,STR,#8,PVC,BLU	10 FT	
4	1392661	CABLE ASSY,CLOSER RCPT1	1		27	FF8908-2	WIRE,STR,#8,PVC,RED	10 FT	
5	1392662	CABLE ASSY,SPIRAL RCPT	1		28	FF9740	CABLE,2 COND,18 AWG,300V4 FT		
6	1392685	PANEL, FRONT BACKPLANE1	1		29	FF9912-10	WIRE,STR,#12,PVC,BLACK	10 FT	
7	EECA491024	CONTACTOR, MINI, 240V	1		30	FF9912-13	WIRE,STR,#12,PVC,BLUE	10 FT	
8	EEGC85A220	CONTACTOR,85A,220VAC	2		31	FF9912-2	WIRE,STR,#12,PVC,RED	10 FT	
9	EECLIPFIX	ANCHOR,DIN RAIL	3		32	FFATMR20	FUSE,CC,20A,FAST,CURLIM9 FT		
10	EEJEPMCW6022	TERMINATION,BLOCK	1		33	FFD2425F	RELAY,SSR,24VAC,25A	2	
11	EESGDS15A12A	AMPLIFIER, SERVO DRIVER1	1		34	FFL762C	CIRCUIT BREAKER	2	
12	EESGDS30A12A	AMPLIFIER, SERVO DRIVER2	1		35	FFL782C	CIRCUIT BREAKER	1	
13	EETS35X7.5	DIN RAIL	36"		36	MM1492FB3C30	FUSE HOLDERS,3 POLE	3	
14	FF209-502	TERMBLK,WAGO,TP,LG	AR		37	SSSCM4X16	M4-0.7 X 16 SOC CAP	15	
15	FF209-503	TERMBLK,WAGO,TP,LG	AR		38	SSSCM5X10	M5-0.8 X 10 SOC CAP	12	
16	FF280-308	TERMBLK ENDPLATE	3		39	TT190730242	TERMINAL,RING,5/16"STD	18	
17	FF280-402	JUMPER,WAGO,280,SNGL	8		40	TTBB5263	TERMINAL,.25 FULLY INSUL4		
18	FF280-901	TERMBLK,WAGO,TOP,GRY	10		41	WWFM4.3	WASHER, FLAT 4MM	15	
19	FF280-907	TERMBLK,WAGO,TOP,GRN	4		42	WWFM5	5MM FLAT WASHER	12	
20	FF2938947	POWER SUP,SWITCHER	1		43	WWL10	#10 LW	12	
21	FF3077-1	WIRE,STR,#16,PVC,WHT	10 FT		44	WWL8	#8 LW	15	
22	FF3077-2	WIRE,STR,#16,PVC,BLK	10 FT						
23	FF3077-3	WIRE,STR,#16,PVC,RED	10 FT						

Rev. 1

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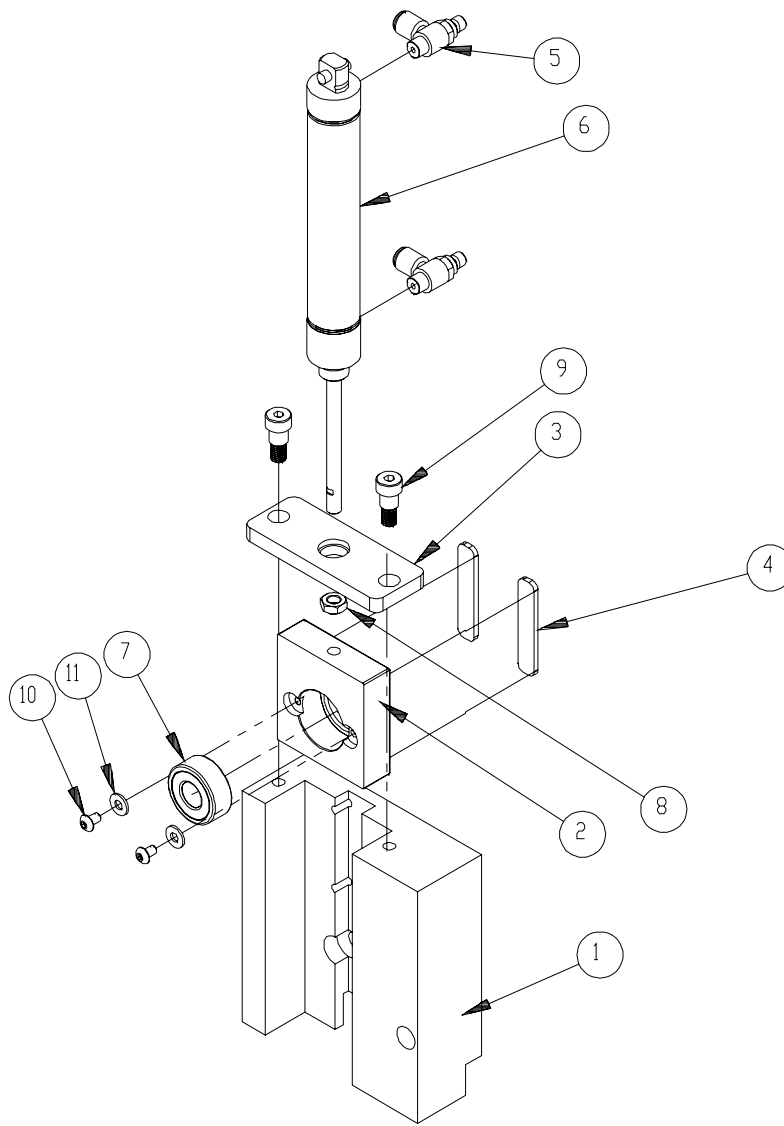


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1389085 Roller Lift Assembly, Left

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389039	BRKT,ROLLER SLIDE,LEFT	1		7	BB22022RS	BEARING, BALL, 15ID, 35OD	1	
2	1392093	BEARING SEAT, MOVING	1		8	NNJ5/16-24	5/16-24 HEX JAM NUT	1	
3	1392094	MOUNTING PLATE, AIR CYL	1		9	SSASM10M10	SHOULDER BOLT,10X10,M8	2	
4	1393889	WEAR STRIP, ROLLER LIFT	2		10	SSBCM5X8	M5 X 8MM BUT HEAD	2	
5	AA198RA408	FLOW CONTROL,1/4 X 1/8	2		11	WWFS10	WASHER, FLAT #10	2	
6	AAC6DP-4	CYLINDER,AIR,DA	1						
						Rev. 0			





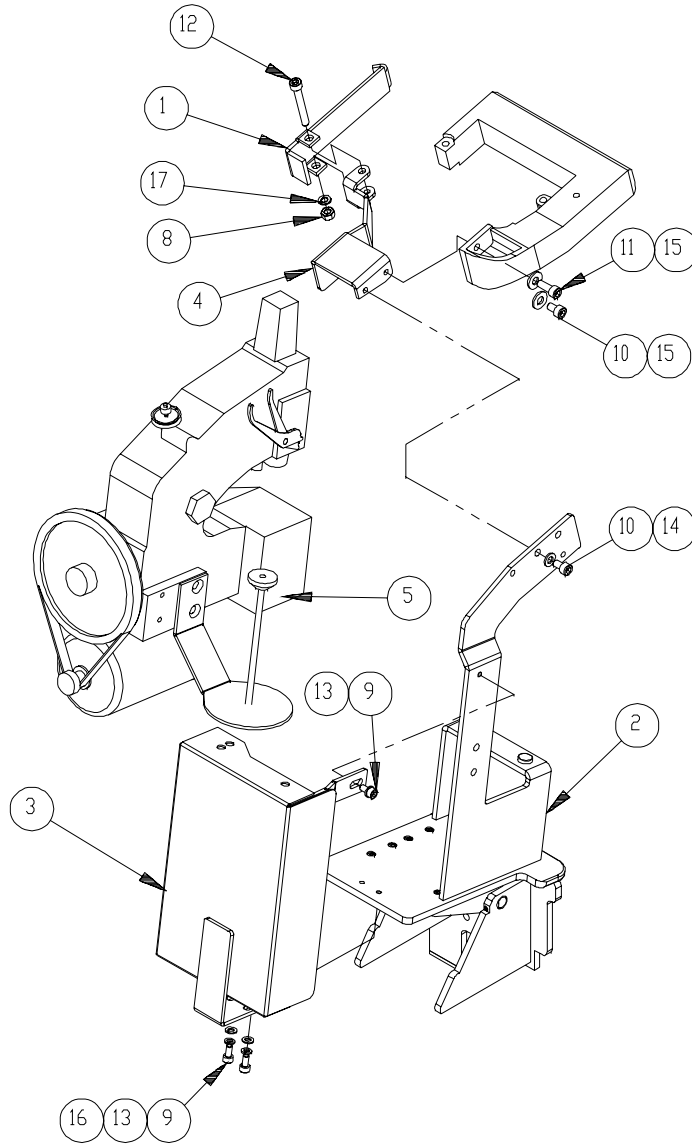
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1392095 Roller Lift Assembly, Right

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389038	BRKT,ROLLER SLIDE,RIGHT	1		7	BB22022RS	BEARING, BALL, 15ID, 35OD	1	
2	1392093	BEARING SEAT, MOVING	1		8	NNJ5/16-24	5/16-24 HEX JAM NUT	1	
3	1392094	MOUNTING PLATE, AIR CYL	1		9	SSASM10M10	SHOULDER BOLT,10X10,M8	2	
4	1393889	WEAR STRIP, ROLLER LIFT	2		10	SSBCM5X8	M5 X 8MM BUT HEAD	2	
5	AA198RA408	FLOW CONTROL,1/4 X 1/8	2		11	WWFS10	WASHER, FLAT #10	2	
6	AAC6DP-4	CYLINDER,AIR,DA	1						

Rev. 4





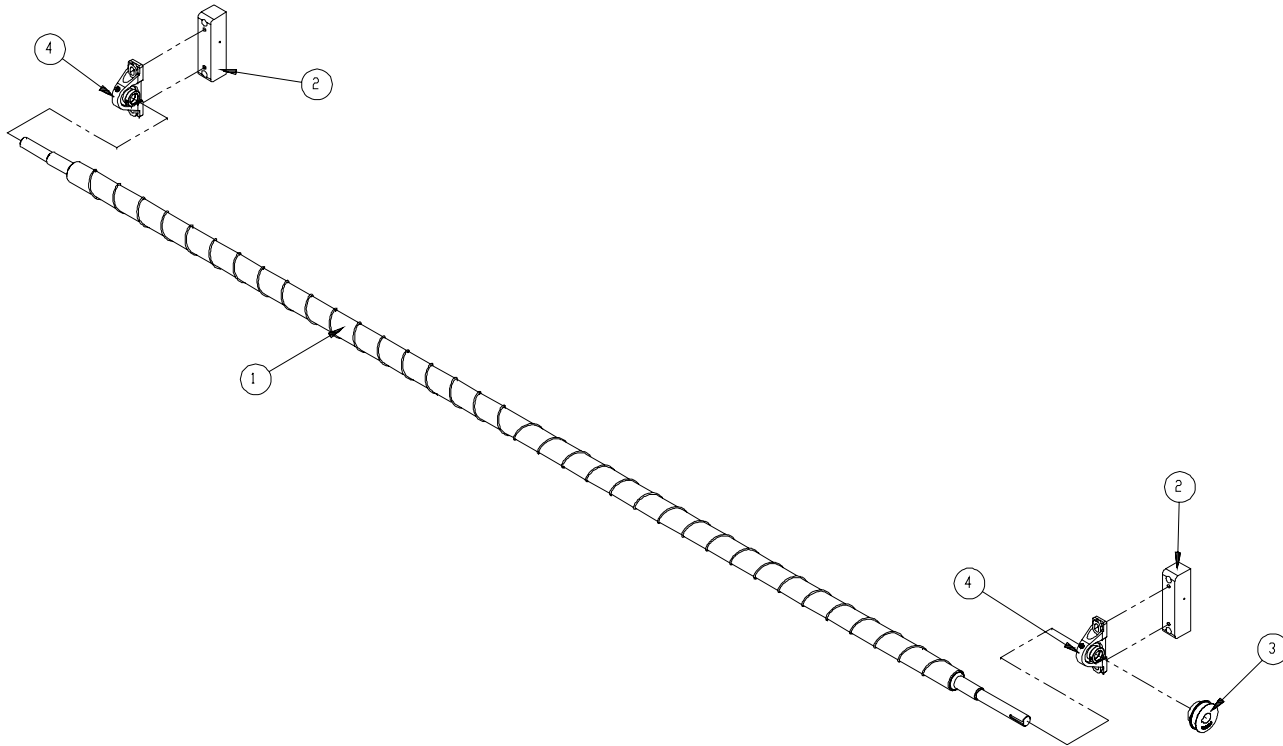
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1392959 Closer Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389228	LATCH, BAG CLOSER	1		11	SSSCM6X16	M6-1.0 X 16 SOC CAP	1	
2	1392163	SUPPORT, BASE	1		12	SSSCM6X45	SCREW, SOCKET CAP	1	
3	1392960	GUARD,BELT	1		13	WWFM5	5MM FLAT WASHER	3	
4	1393836	BRACKET,HANDLE	1		14	WWFM6	6MM FLAT WASHER	1	
5	BC-1	BORDER CLOSER	1		15	WWFS1/4	WASHER FLAT, 1/4	2	
6	FF770018-1	CONN,UML2,PLUG,3POS	1		16	WWLM5	M5 LOCK WASHER	2	
7	FF770251-3	CONN,UML2,PIN,F,14	3		17	WWLM6	M6 LOCK WASHER	1	
8	NNHM6X1.0	M6 X 1.0 HEX NUT	1		18	ZTH3/4B	HEAT SHRINK TUBING	.17 ft	
9	SSSCM5X10	M5-0.8 X 10 SOC CAP	3						
10	SSSCM6X10	M6-1.0 X 10 SOC CAP	2						

Rev. 3





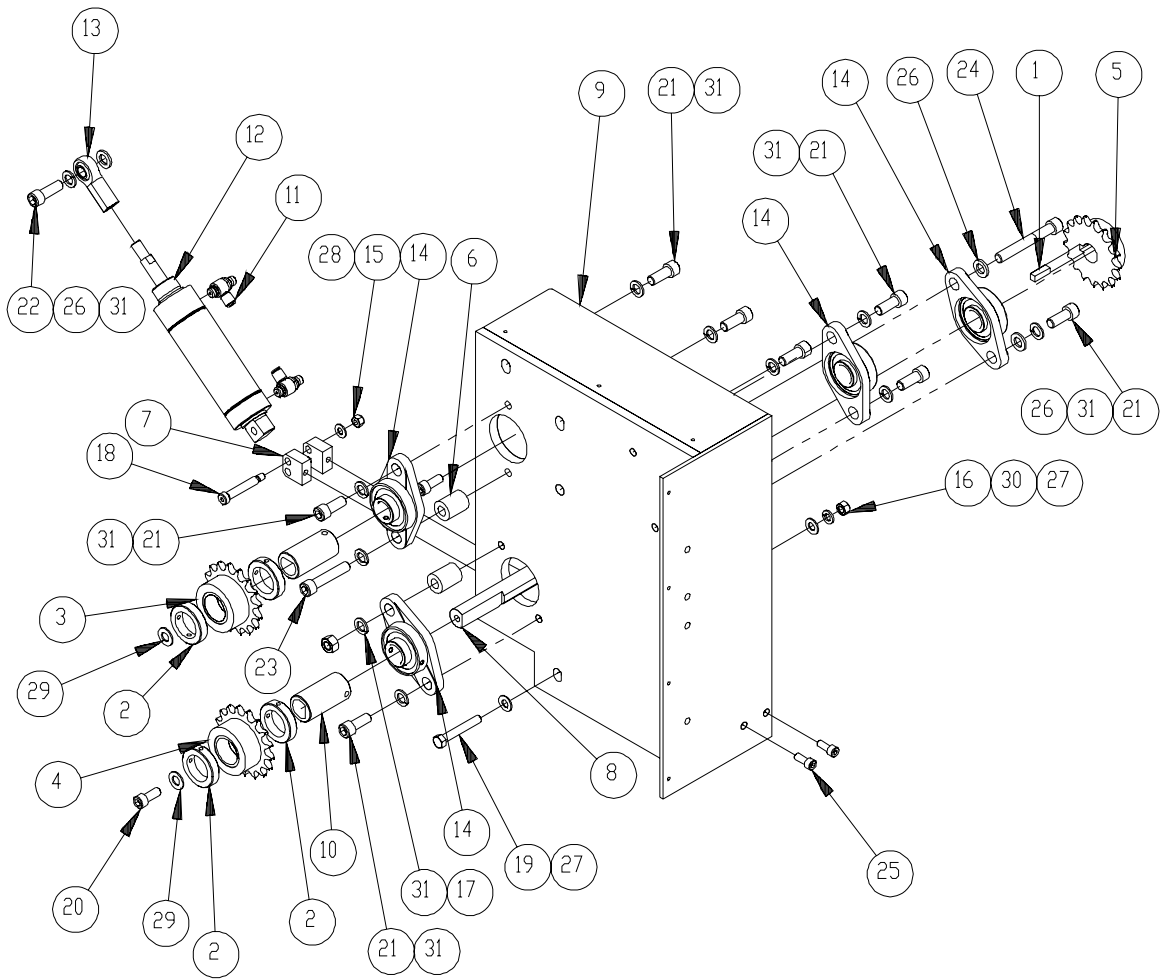
1392151 B Pole Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392110	ROLL, SPIRAL FLIGHTED	1		3	1392156	PULLEY, CLUTCH, 20T, 25mm1		
2	1392150	MOUNTING BLK, BEARING	2		4	BBNAP205-25	BEARING, PILLOWBLOCK AR		

Rev. 1

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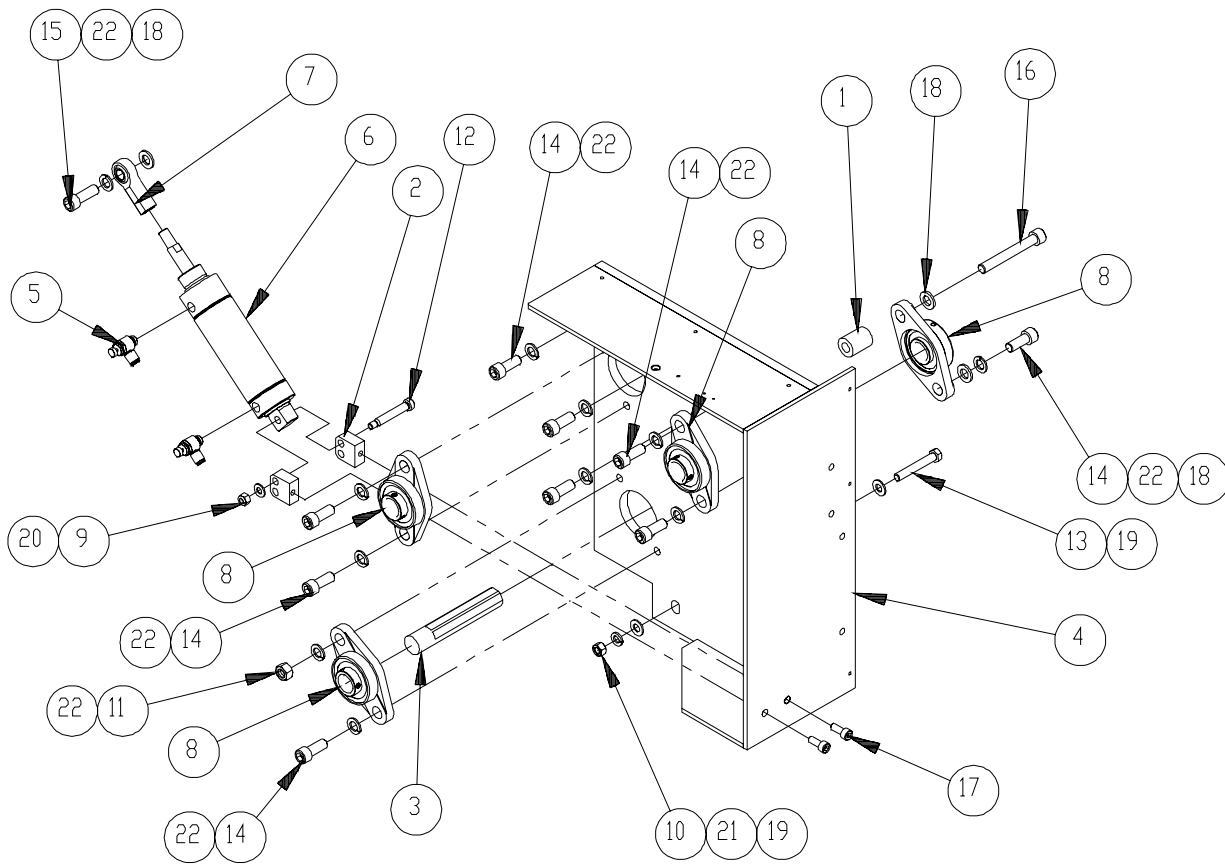
1392935 Front Left Roller Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392018	KEY, 8 MM X 25 MM	1		17	NNHM12X1.75	M12 X 1.75 HEX NUT	1	
2	1392278	COLLAR, CLUTCH BRNG	4		18	SSAS024128	3/8 X 2 X 5/16-18 SHLD	1	
3	1392826	DRIVE SPROCKET ASY, RH	1		19	SSHC25160	3/8-16 X 2-1/2 HEX HEAD	1	
4	1392865	DRIVE SPROCKET ASY,LH	1		20	SSSCM10X25	M10-1.5 X 25 SOC CAP	2	
5	1392871	STEEL SPROCKET,17T,5/8P	1		21	SSSCM12X30	M12-1.75 X 30 SOC CAP	8	
6	1392883	SPACER, FLANGE BEARING2	2		22	SSSCM12X35	M12-1.75 X 35 SOC CAP	1	
7	1392886	MOUNT, CYLINDER BASE	2		23	SSSCM12X60	M12-1.75 X 60 SOC CAP	1	
8	1392890	SHAFT, PIVOT,25MM	1		24	SSSCM12X90	SCREW, M12 X 90	1	
9	1392891	LEFT CARRIAGE FRAME	1		25	SSSCM8X20	M8-1.25 X 20 SOC CAP	2	
10	4-039	ADAPTER, CLUTCH BRNG	2		26	WWFM12	12MM FLAT WASHER	3	
11	AA198RA404U	FLOW CONTROL,1/4PTX1/4	2		27	WWFS3/8	WASHER, FLAT, 3/8	2	
12	AAC313DXP	CYLINDER,AIR,2"BORE	1		28	WWFS5/16	WASHER, FLAT, 5/16	1	
13	BBAW-8Z	BEARING,ROD END,FEM	1		29	WWFS7/16	7/16 FW	2	
14	BBUCFL205	BEARING, FLANGE UCFL	4		30	WWL3/8	3/8 LW	1	
15	NNE5/16-18	NUT,ELASTIC LOCK,5/16-18	1		31	WWLM12	M12 LOCK WASHER	11	
16	NNH3/8-16	3/8-16 HEX NUT	1						

Rev. 6

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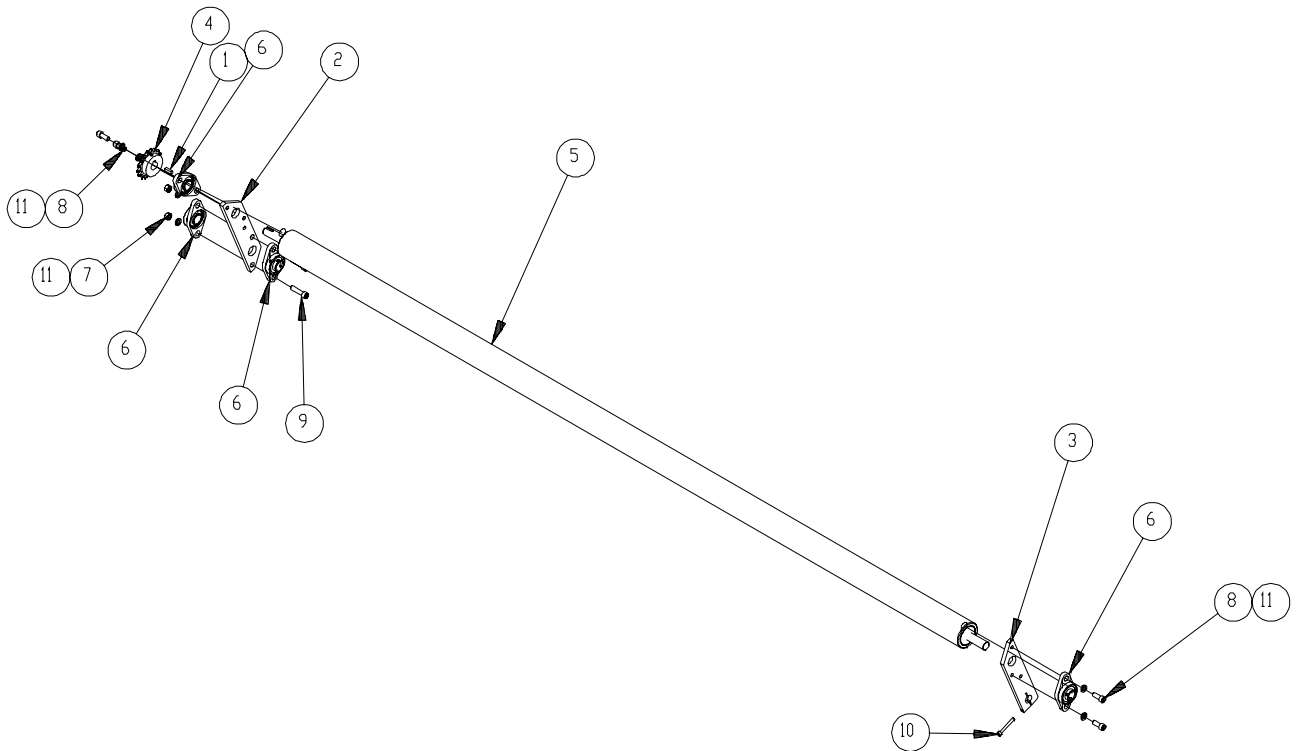
1392936 Front Right Roller Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392883	SPACER, FLANGE BEARING1			13	SSHC25160	3/8-16 X 2-1/2 HEX HEAD	1	
2	1392886	MOUNT, CYLINDER BASE 2	2		14	SSSCM12X30	M12-1.75 X 30 SOC CAP	9	
3	1392889	SHAFT, PIVOT,25MM	1		15	SSSCM12X35	M12-1.75 X 35 SOC CAP	1	
4	1392892	RIGHT CARIAGE FRAME 1	1		16	SSSCM12X90	SCREW, M12 X 90	1	
5	AA198RA404U	FLOW CONTROL,1/4PTX1/4 2	2		17	SSSCM8X20	M8-1.25 X 20 SOC CAP	2	
6	AAC313DXP	CYLINDER,AIR,2"BORE 1	1		18	WWFM12	12MM FLAT WASHER	3	
7	BBAW-8Z	BEARING,ROD END,FEM 1	1		19	WWFS3/8	WASHER, FLAT, 3/8	2	
8	BBUCFL205	BEARING, FLANGE UCFL 4	4		20	WWFS5/16	WASHER, FLAT, 5/16	1	
9	NNE5/16-18	NUT,ELASTIC LOCK,5/16-18 1	1		21	WWL3/8	3/8 LW	1	
10	NNH3/8-16	3/8-16 HEX NUT 1	1		22	WWLM12	M12 LOCK WASHER	11	
11	NNHM12X1.75	M12 X 1.75 HEX NUT 1	1						
12	SSAS024128	3/8 X 2 X 5/16-18 SHLD 1	1						

Rev. 4

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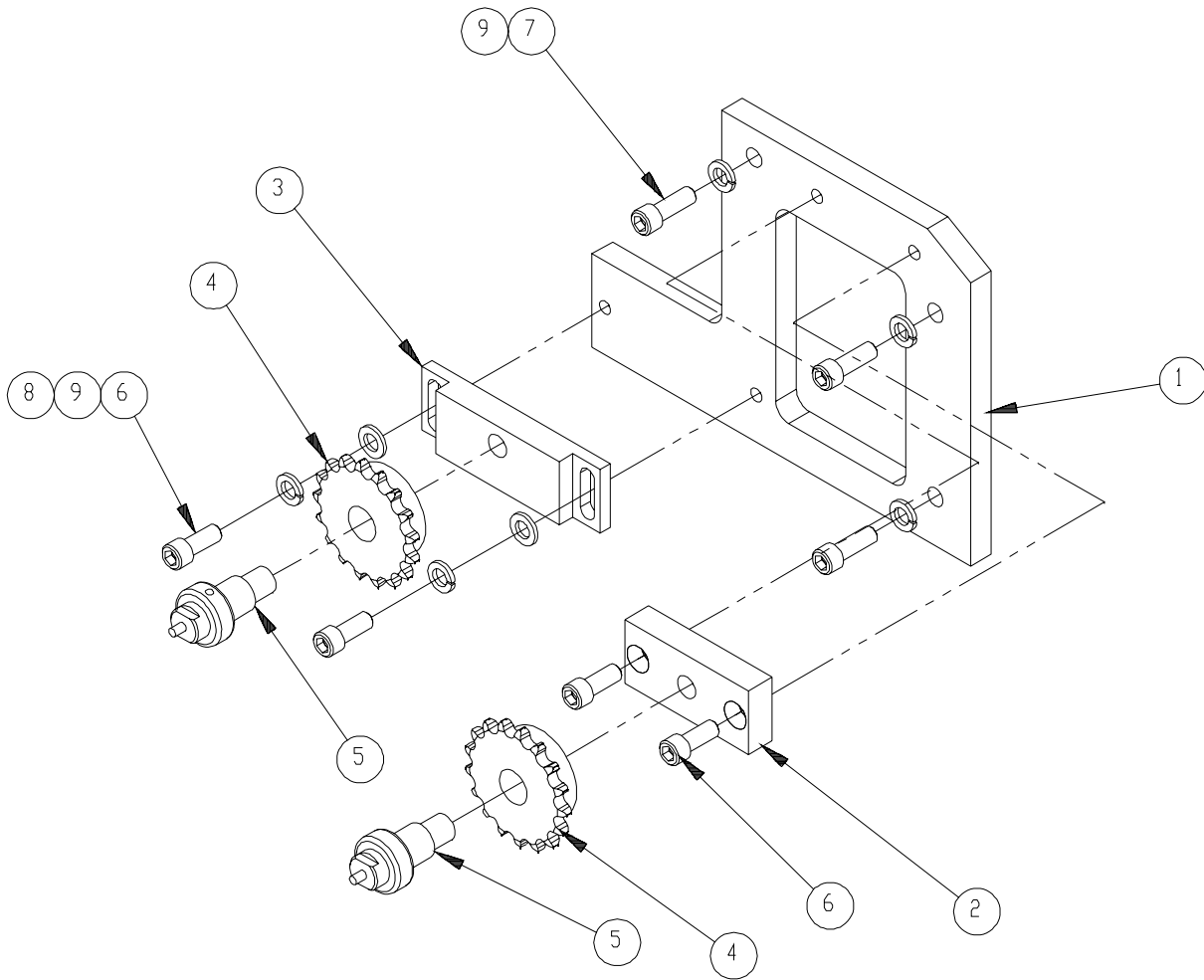


1392937 Front Feed Roller Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392018	KEY, 8 MM X 25 MM	1		7	NNHM12X1.75	M12 X 1.75 HEX NUT	2	
2	1392869	SUPPORT LINK, BEARING	1		8	SSSCM12X30	M12-1.75 X 30 SOC CAP	4	
3	1392870	SUPPORT LINK, BEARING	1		9	SSSCM12X50	M12-1.75 X 50 SOC CAP	2	
4	1392871	STEEL SPROCKET,17T,5/8P	1		10	SSSCM8X60	M8-1.25 X 60 SOC CAP	1	
5	1392872	ROLLER,DRIVEN,FRONT	1		11	WWL1/2	1/2 LW	6	
6	BBUCFL205	BEARING, FLANGE UCFL	4						
						Rev. 1			

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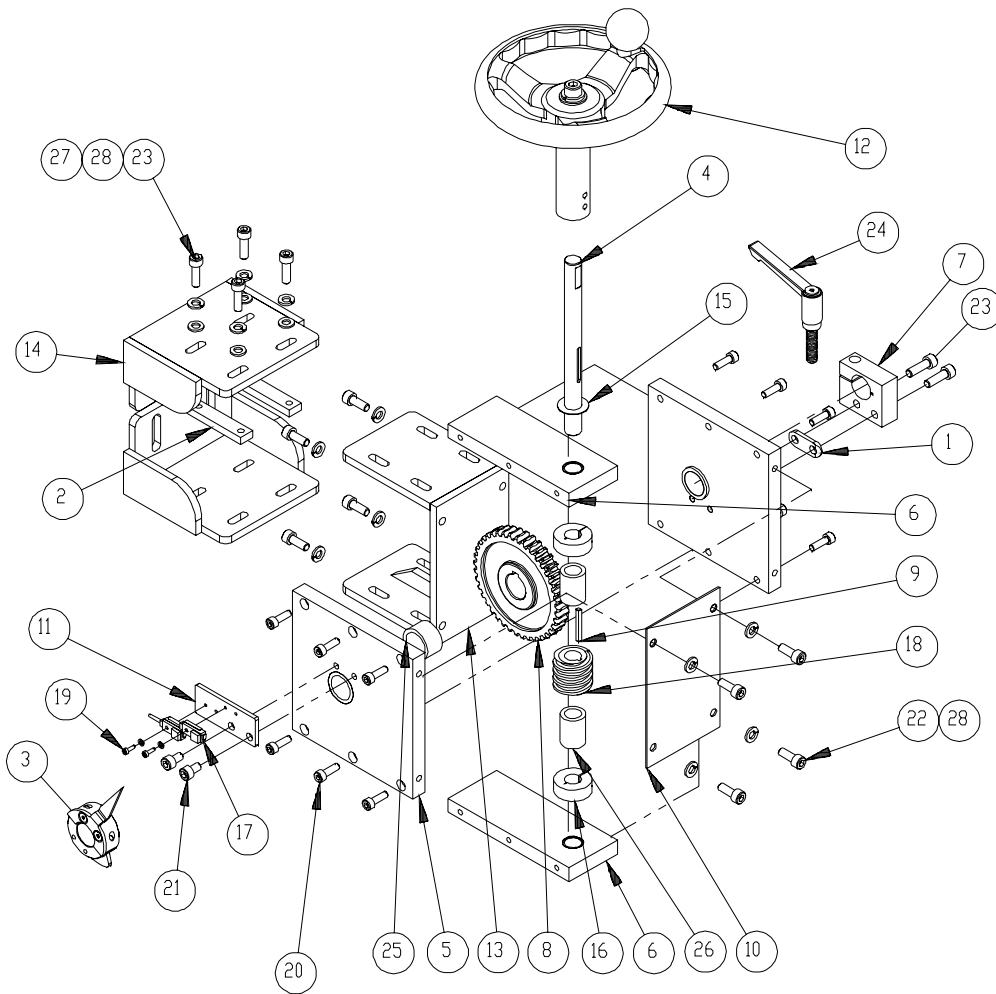
1392938 Left Sprocket Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392820	PLATE,ADAPTOR,BEARING	1		6	SSSCM12X30	M12-1.75 X 30 SOC CAP	4	
2	1392853	SHAFT MOUNT, 3/4-10	1		7	SSSCM12X35	M12-1.75 X 35 SOC CAP	3	
3	1392867	SHAFT MOUNT, 3/4-10	1		8	WWFM12	12MM FLAT WASHER	2	
4	MMHN50B17	IDLER SPROCKET,17T,5/8P	2		9	WWL1/2	1/2 LW	5	
5	MMN2	TIGHTENER SHAFT,1"DIA	2						

Rev. 0

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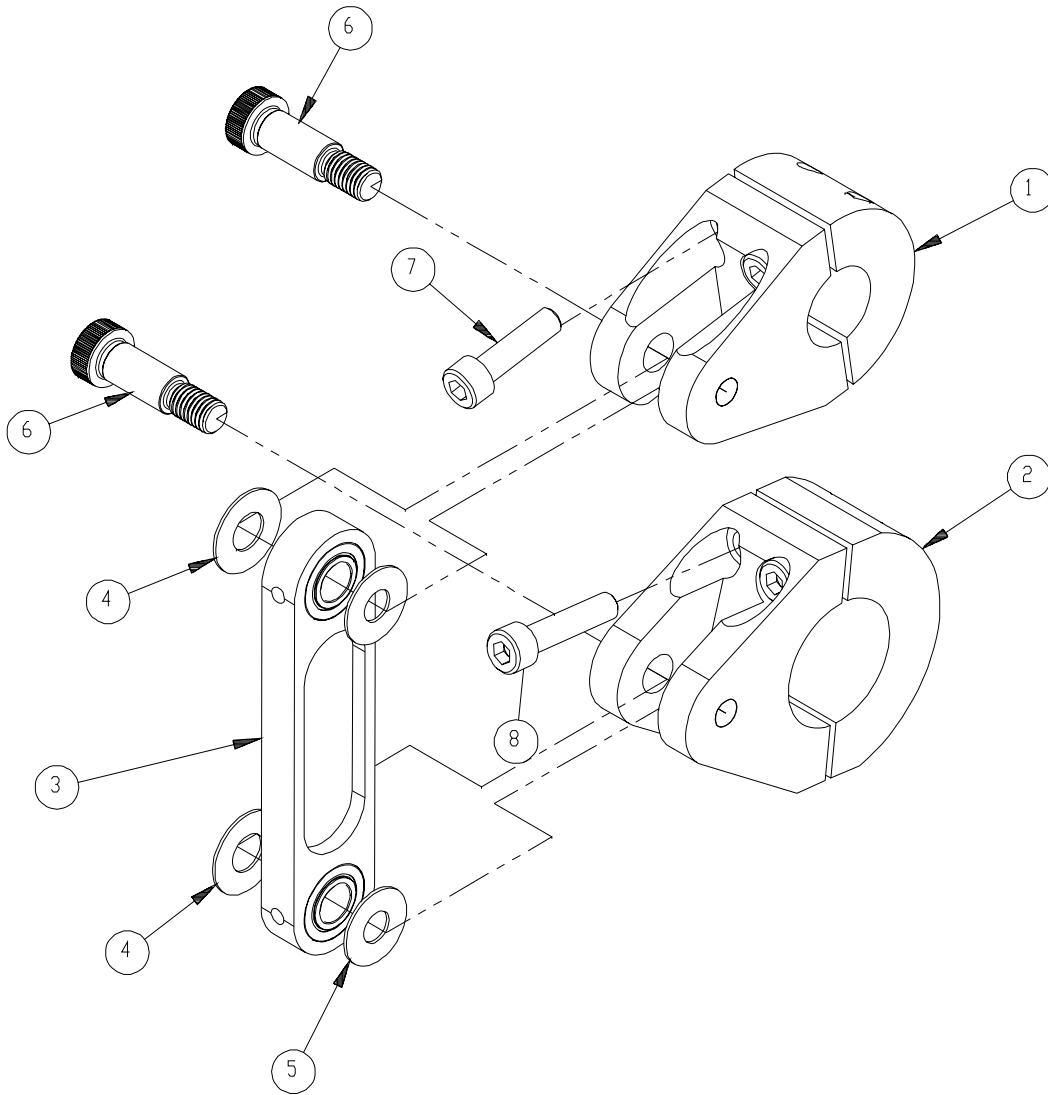
1393875 Footlift Adjust Knob Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1331725	PLATE,WASHER,,266@.75	1		16	CCCL8F	CLAMP COLLAR- 1/2	2	
2	1392004	PLATE,NUT,M6	2		17	FFGXL8FC5	PROX. SWITCH	2	
3	1392373	INDICATOR, FOOT HEIGHT	1		18	MM57545K527	WORM,12P,1.0 OD,0.5B	1	
4	1392482	SHAFT,ADJUSTING	1		19	SSSCM2.5X8	M2.5-0.45 X 8 SOC CAP	2	
5	1392484	PLATE,GEAR MTG	2		20	SSSCM5X16	M5-0.8 X 16 SOC CAP	12	
6	1392486	PLATE, WORM MTG	2		21	SSSCM6X10	M6-1.0 X 10 SOC CAP	2	
7	1392487	CLAMP	1		22	SSSCM6X16	M6-1.0 X 16 SOC CAP	8	
8	1392492	GEAR,WORM, 12P,14.5 DEG	1		23	SSSCM6X20	M6-1.0 X 20 SOC CAP	6	
9	1392521	KEY,1/8X1-1/8	1		24	TTH6324K650	M8X1.25X32MM STUD	1	
10	1392591	PLATE,COVER,FOOT ADJ	1		25	UU20-26X15	BEARING,BRONZE,20MM ID	1	
11	1392710	PLATE,SENSOR MTG	1		26	UUAA744-03	BEARING, .5 X.75X 1.00	2	
12	1392998	WHEEL,FOOT LIFT	1		27	WWFM6	6MM FLAT WASHER	4	
13	1393878	BRKT,FOOR ADJ MTG	1		28	WWL1/4	1/4 LW	12	
14	1393882	BRKT,REAR	2						
15	BBTRA815	WASHER,THRUST,STEEL	1						

Rev. 0

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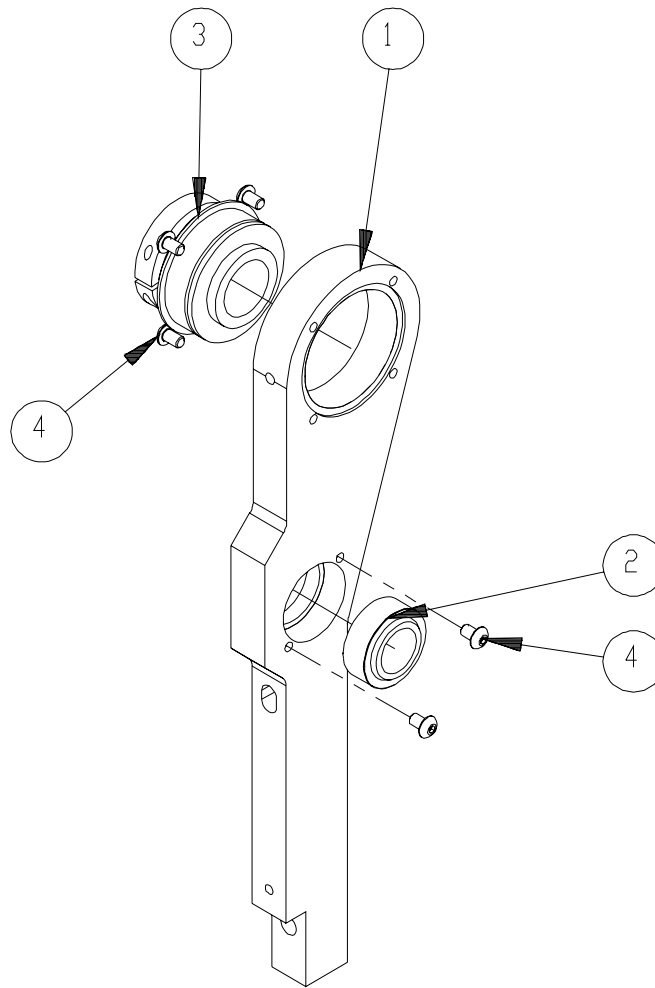
1392846 Butterfly Drive Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1389010	CRANK,FRONT BUTTERFLY	1		6	SSASM12M25	SCREW,ALLEN SHOULDER	2	
2	1392835	CRANK,FRONT BUTTERFLY	1		7	SSSCM8X30	M8-1.25 X 30 SOC CAP	4	
3	1392836	LINK,BUTTERFLY DRIVE	1		8	SSSCM8X35	M8-1.25 X 35 SOC CAP	4	
4	BBAS1226	WASHER,THRUST,12MM ID	2						
5	MM5909K71	WASHER,THRUST,10MM ID	2						

Rev. 2

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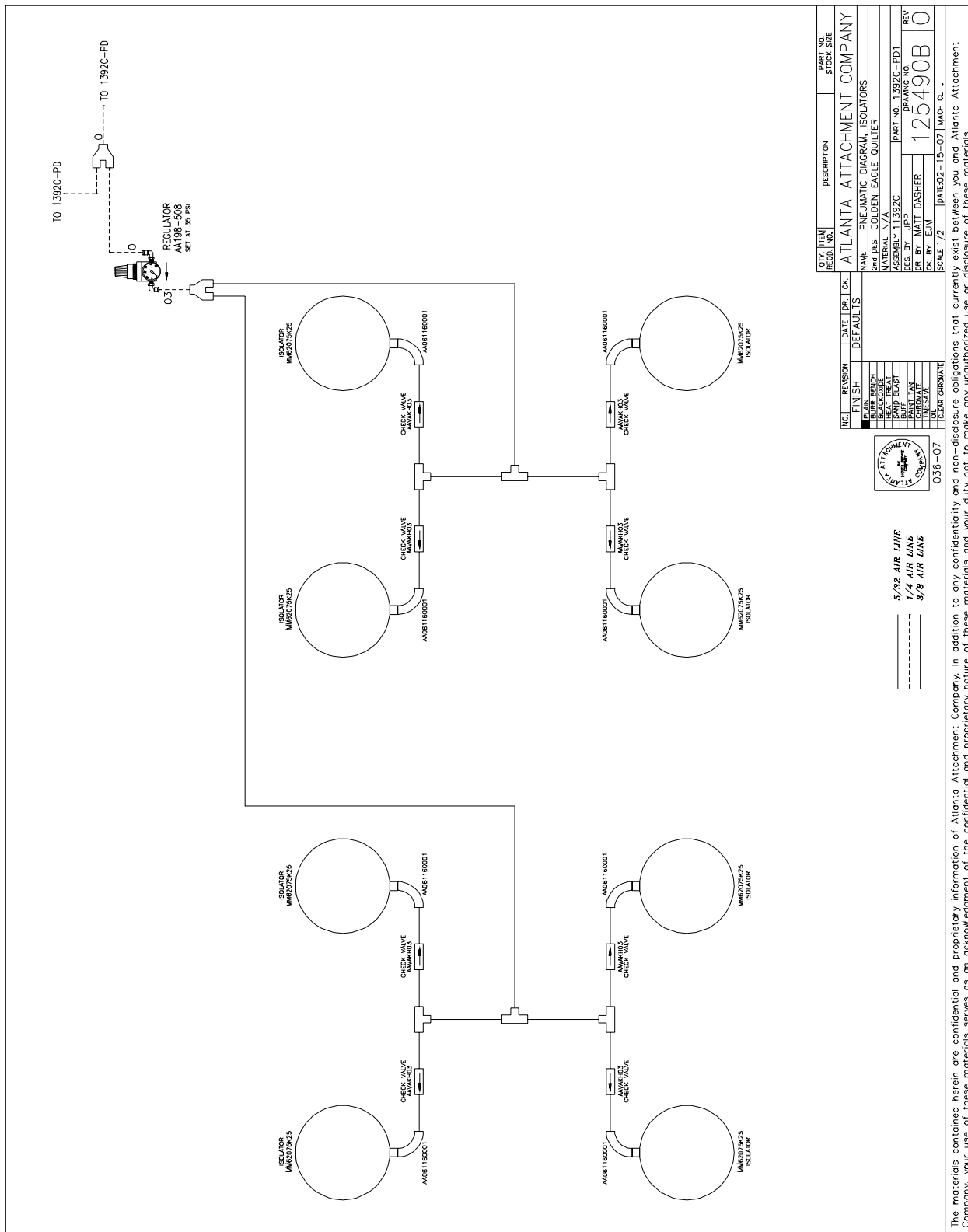
1389200 Bearing Assembly

#	Part #	Description	Qty	Pg	#	Part #	Description	Qty	Pg
1	1392815	BLOCK,BEARING	1		3	BBGER205-25	BEARING,BALL,25MMB,CLAMP1		
2	BBGE20ES2RS	BEARING,SPHERICAL PLAIN,21			4	SSBCM5X8	M5 X 8MM BUT HEAD	6	
						Rev. 0			

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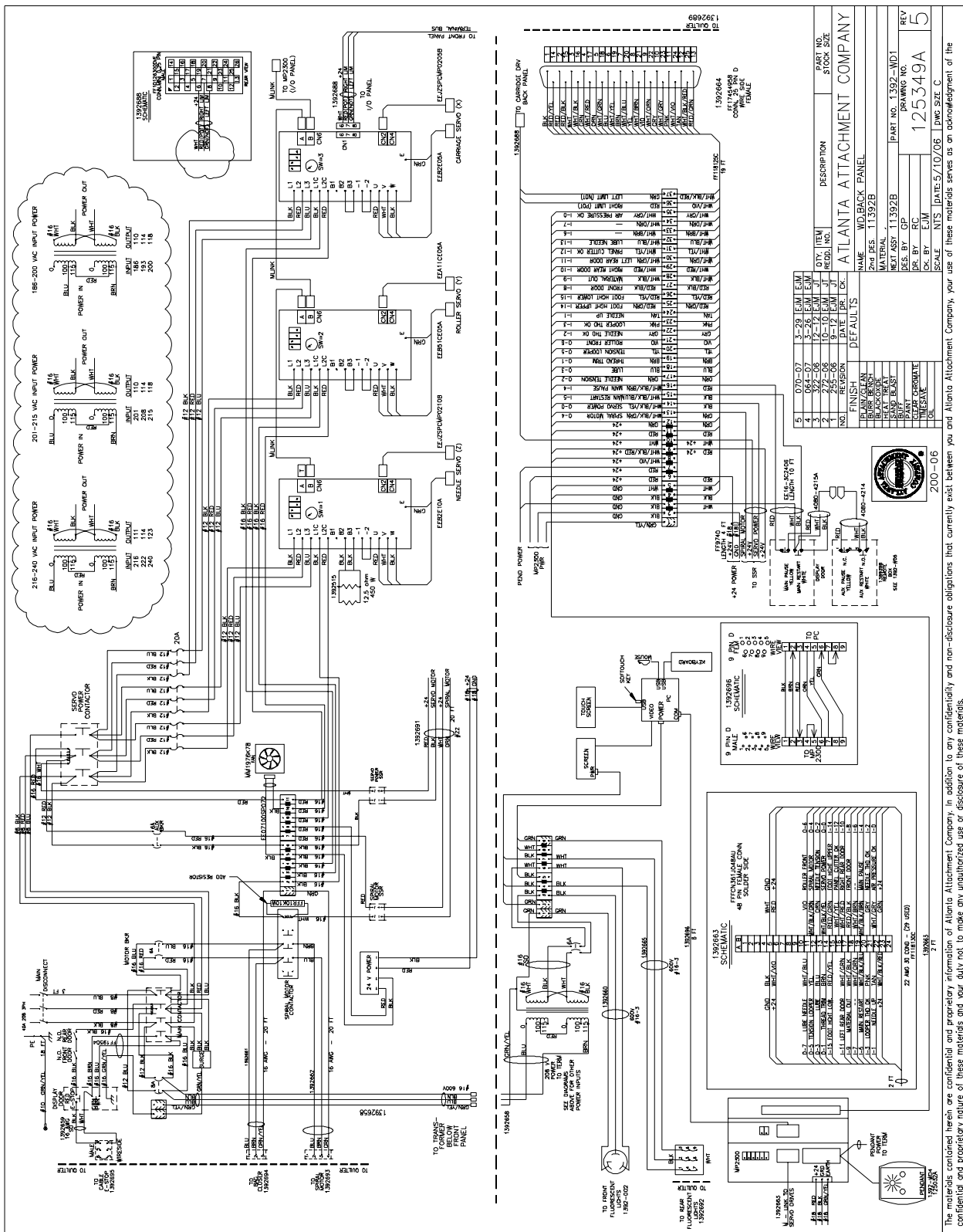


1392C-PD1 Pneumatic Diagram



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1392-WD1 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 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.

Atlanta Attachment Company (AAC) Declaración de Garantía

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libre de defectos de material y de mano de obra durante un periodo de ochocientos (800) horas de operación o cien (100) días cual llega primero. Atlanta Attachment Company garantiza que todos los componentes del bus serie son libre 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 via 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 la máquina o pieza defectuosa devuelto para AAC.
- AAC reserva el derecho para tomar la decisión final sobre toda cuestión de garantía.
- Las garantías de AAC tiene un validez de ochocientos (800) horas o cien (100) días cual llega primero.
- AAC garantiza operación satisfactoria de sus máquinas en base de las normas aceptadas de la industria contingente en la instalación y mantenimiento adecuada.
- 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 que sea autorizado por AAC antes de cualquier reclamo.

Lo Que Está Garantizado

- Componentes eléctricos que no está incluidos dentro del sistema Bus Serie que han sido manufacturados por AAC son garantizados por un periodo de ochocientos (800) horas.
- Mechanical parts or components that fail due to defects in material or workmanship, which are manufactured by AAC.
- 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 al raíz de mal transporte, accidentes, incendio o cualquier daño al resultado de servicio por personas no autorizados o instalaciones incorrectas de conexiones eléctricas o neumáticas.
- Desgaste normal de repuestos como correas, anillos de goma, cuchillos, 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 en el campo.
- Pérdida de tiempo, ingresos potenciales, y/o ganancias.
- Daños personales y/o daños al propiedad al resultado de la operación de este equipo.

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