



Model

1392

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Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

Atlanta Attachment Company

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ATLANTA ATTACHMENT COMPANY, INC.

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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.

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Important Safety Instruction



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

Mandatory Information

All persons operating and/or working on the 1392 Silver Eagle should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include;

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

Intended Use

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

Exclusion of Misuse



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

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

Liability

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

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

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

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

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

Choice and Qualification of Personnel

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

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

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines



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

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

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

Damage

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

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

Faults or Errors

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

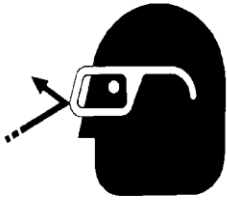
Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.

Clothing, Jewelry, Protective Equipment

Long loose hair, loose-fitting clothes, gloves and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

The following fire extinguishers may be used:

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

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

A qualified person should be consulted to repair the damage after a fire.

Electrical Power Supply



Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.

In practice, this may mean that the technician, electrician and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.

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

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

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.
- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

- Kinetic energy - Note that some motors or spindles, for example, may continue to run or coast run on after being switched off.
- Potential energy - Individual assemblies may need to be secured if necessary for repair work.

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.

All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.

Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.

Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.

Protect against unauthorized access.

Ensure that the machine and accessories are set up in a stable position.

Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Local Regulations

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

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.

Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.

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

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

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

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

Repair

Replacement Parts

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

Repair, Electrical

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

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

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

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

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

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

Ventilation/Hazardous Gases

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

Safety should be a constant concern for everyone. Always be careful when working with this equipment. While normal safety precautions were taken in the design and manufacture of this equipment, there are some potential safety hazards.

Everyone involved with the operation and maintenance of this equipment should read and follow the instructions in this manual.

Operate the equipment only as stated in this manual. Incorrect use could cause damage to the equipment or personal injury.

It is the owner's responsibility to make certain that the operator reads and understands this manual before operating this equipment. It is also the owner's responsibility to make certain that the operator is a qualified and physically able individual, properly trained in the operation of this equipment.

Specific safety warning decals are located on the equipment near the immediate areas of potential hazards. These decals should not be removed or obliterated. Replace them if they become non-readable.

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

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
Air Pressure	90 PSI

Physical Specifications

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

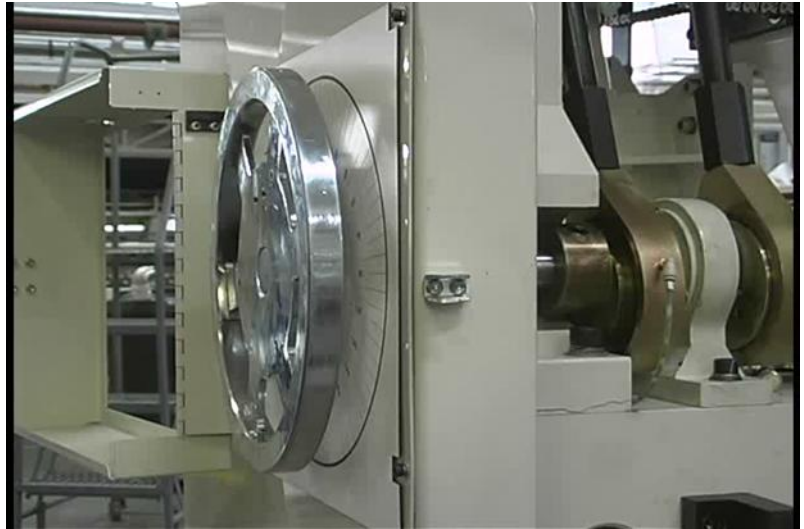
Pressure Gauge Settings

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

Quilter Setup & Training

Adjusting the Hand-Wheel

- Tighten hand-wheel bolt
- Move hand-wheel to Zero degrees
- Clamp Main Shaft, To Prevent Movement



Adjusting the Eccentrics

- Move presser foot eccentric to the highest position
- Tighten one bolt of eccentric



Setting Eccentric Top Center

Place dial indicator magnetic base on flat surface

Place dial indicator tip on top of presser foot rod end bearing

Rotate presser foot eccentric until the pointer of the dial indicator doesn't move anymore.

Tighten one bolt of the eccentric

To check turn hand-wheel between 345° and 15° . The dial indicator needs to point at the same number at 345° and 15°



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Fine tuning Eccentric Top Center

- To check turn hand-wheel between 345° and 15° . The dial indicator needs to point at the same number at 345° and 15°
- Change eccentric position
- Check the top center by moving hand wheel between 345° and 15°



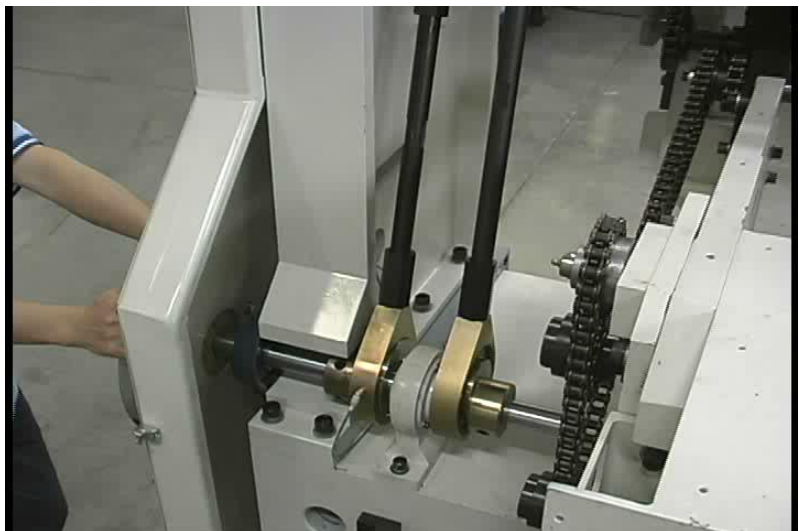
Adjust Pittman rod length.

- Loosen up the 2 nuts
- Turn the rod until you have the right length.
- Tighten the 2 nuts
- Check the final length (570mm)



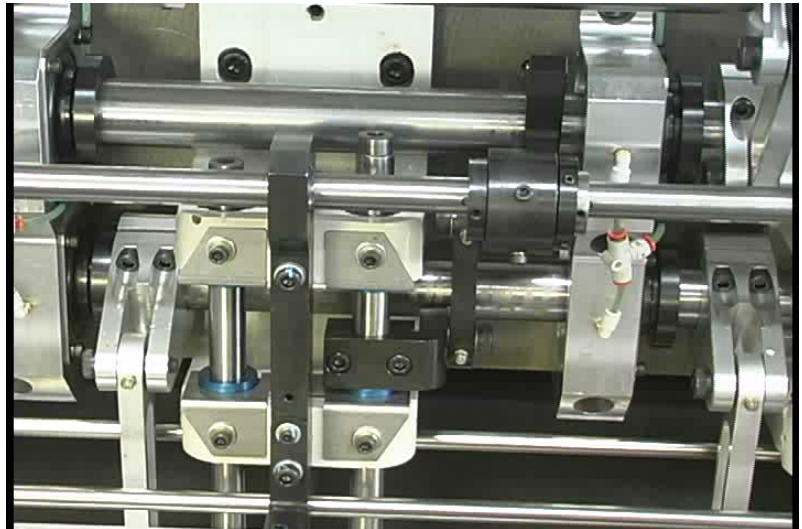
Adjust Pittman rod length (Needle bar).

- Do the same as the presser-foot Pittman-rod with the Pitman-rod for the needle bar
- Find “top dead center”
- Test “top dead center” with turning hand-wheel from 245° up to 15°
- Length of Pitman-rod need to be 460mm
- Repeat this step on the other side of the machine so the Pitman-rod for the presser-foot and the needle bar are the same on both side of the machine



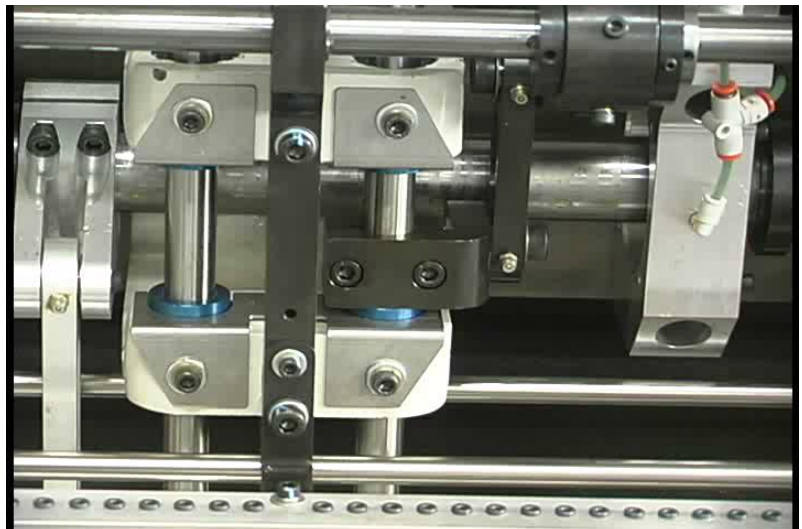
Adjusting cams for presser-foot.

- Turn the hand-wheel to 0°
- Push needle bar clamps down then tighten the bolts
- Bring all the cams down so they hit the cam-follower then tighten the bolts
- Turn the shaft up so all the cams are level then tighten the bolts
- Tighten the levers on both sides



Loosen up the needle-bar clamps.

- **After adjusting the** cams and followers loosen up the clamps of the needle bars.



Turn hand-wheel to 180°.



Tighten needle lever on shaft.

- Tighten the 2 needle lever on the shaft. (6 bolts every lever)



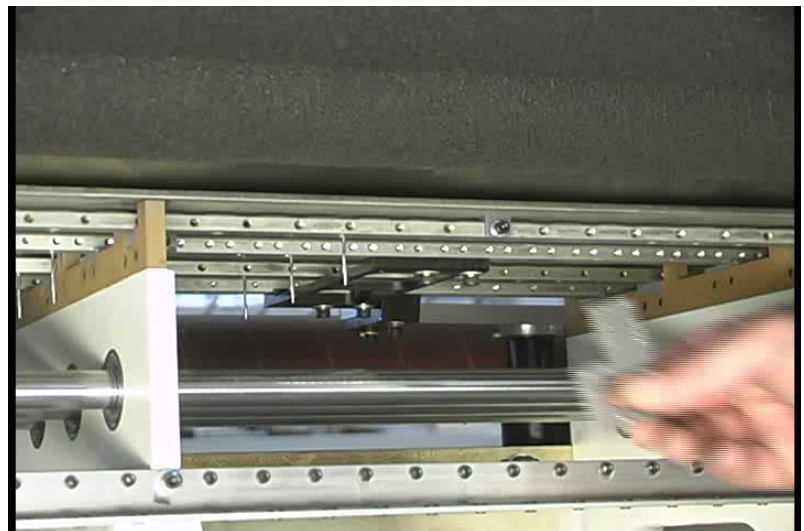
Set lowest needle position 1.

- If not already so, put the 3mm spacer under the presser-foot.
- Place the 14.3mm spacers between the presser-foot and the needle bars



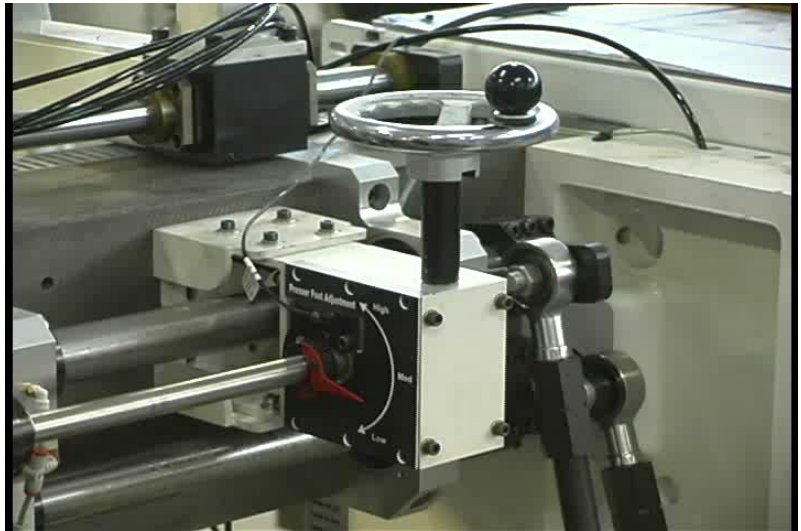
Set lowest needle position 2.

- The tip of the needle should be 28mm under the throat-plate when the machine is at 180°
- We can test this with the special gauge



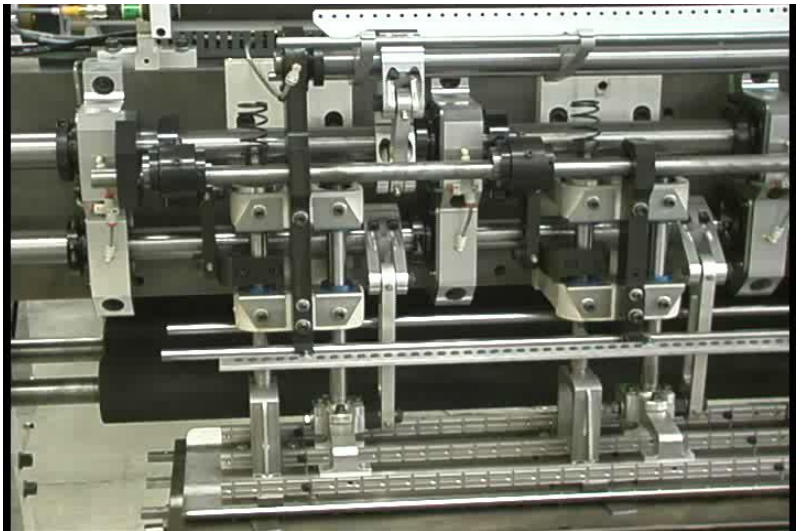
Set lowest needle position 3.

- Use the presser-foot adjustment to set the right needle height.
- Check the needle height after foot-lift adjustment.



Set lowest needle position 4.

- When the needle height is 28mm under the throat-plate tighten bolts of the link between needle-bar and shaft.



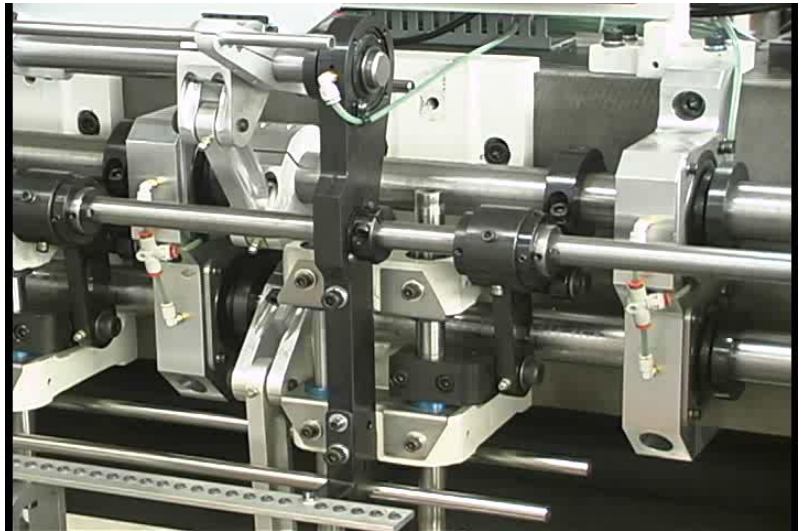
Set lowest presser-foot height.

- Raise the foot up with spacers of 3mm thick.
- Adjust the foot to its lowest position (use little hand wheel)
- The foot is at his lowest position when the key of the shaft is facing out.



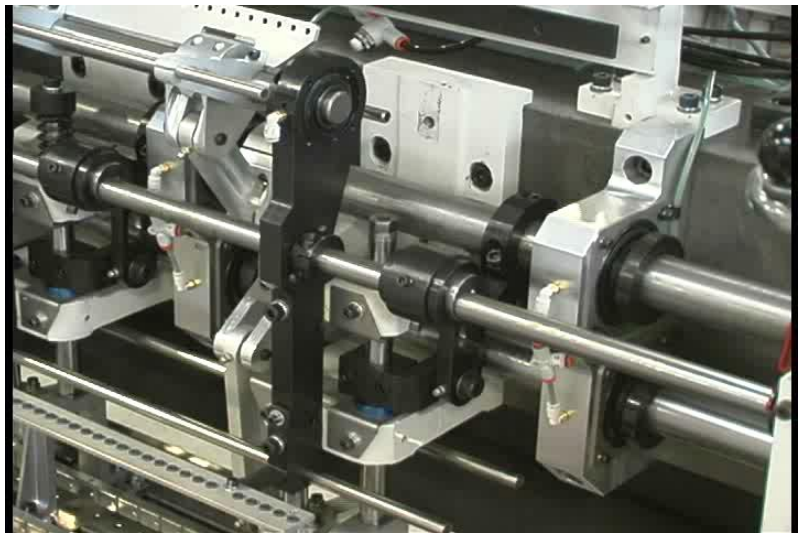
Lock down the presser-foot height.

- Use bolt to extent presser-foot bar
- Press the presser-foot down on the 3mm spacers
- Lift up clamp on presser-foot bar so the cam-followers or op against the cams
- Tighten bolts from clamp (make sure the clams are not twisted)



Assemble springs on presser-foot.

- Place spring disk
- Place spring
- Place spring cap
- Use special tool to compress the spring and tighten spring with bolt.
- Repeat this with all 8 presser bars



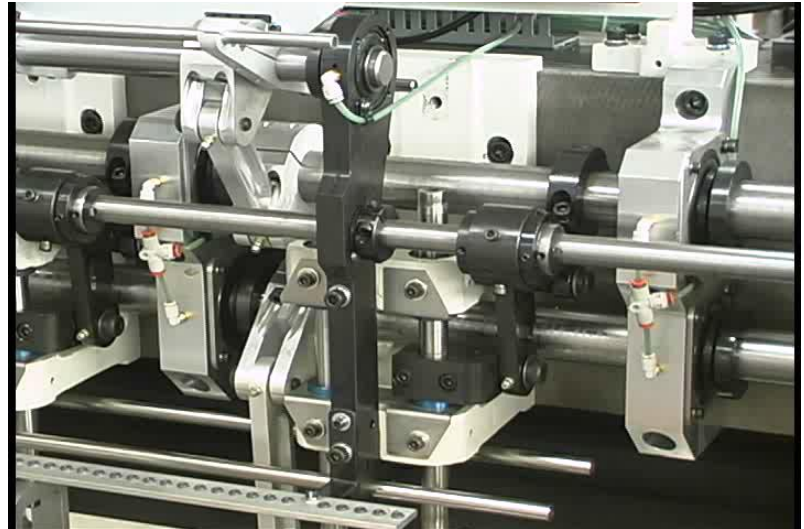
Set front butterfly.

- Turn hand-wheel to 90°
- Level the butterfly
- Tighten the 3 links from shaft to butterfly shaft
- Turn the machine with the hand-wheel. The machine should turn smoothly



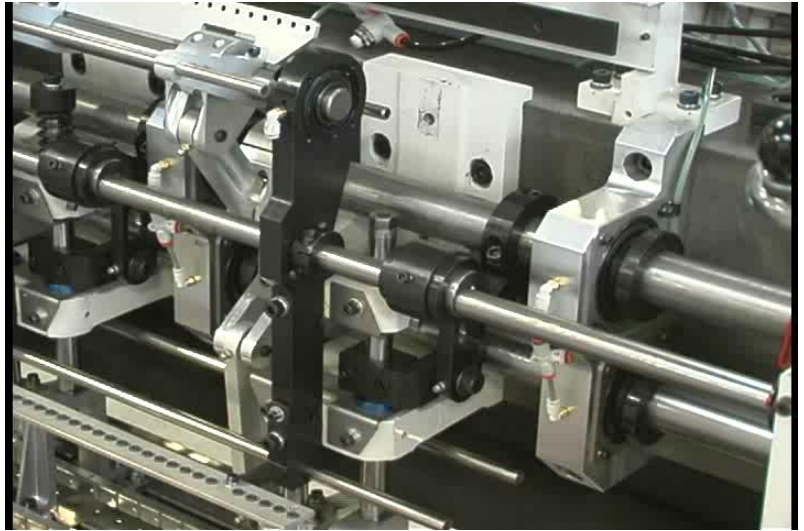
Lock down the presser-foot height.

- Use bolt to extent presser-foot bar
- Press the presser-foot down on the 3mm spacers
- Lift up clamp on presser-foot bar so the cam-followers or op against the cams
- Tighten bolts from clamp (make sure the clams are not twisted)



Assemble springs on presser-foot.

- Place spring disk
- Place spring
- Place spring cap
- Use special tool to compress the spring and tighten spring with bolt.
- Repeat this with all 8 presser bars



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.

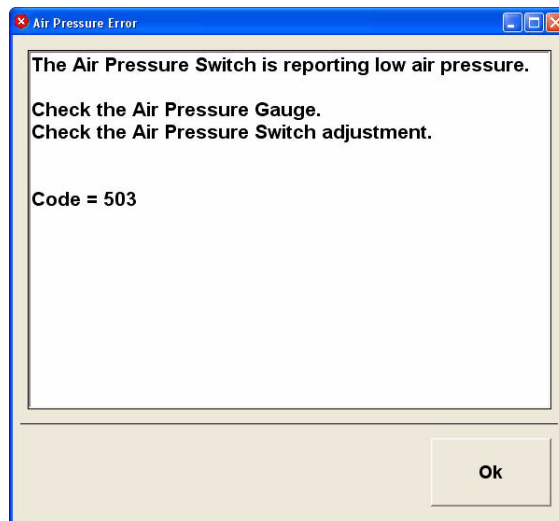
Z-Axis is the Needle up and down movement.

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.

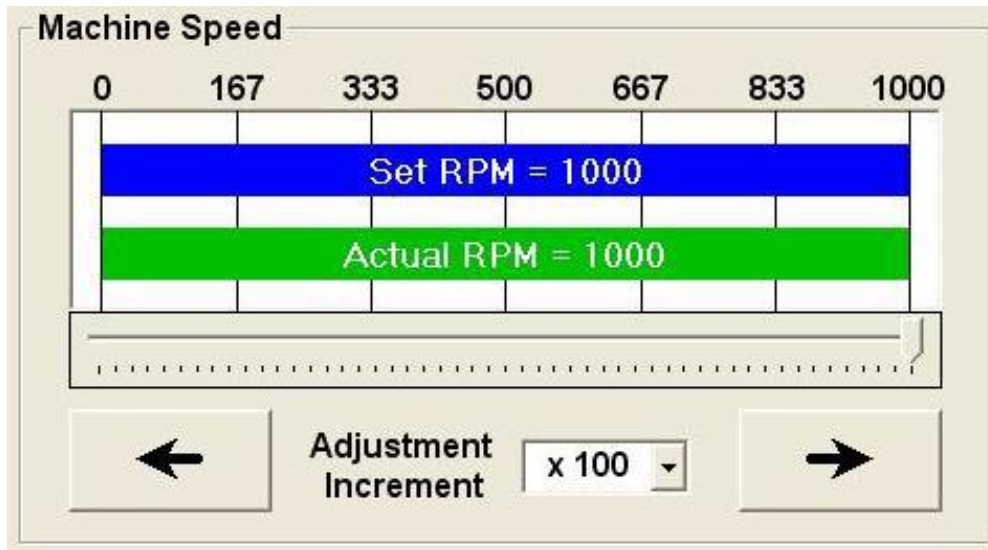
The screenshot shows the E-Z Quilter software interface for a quilt pattern named "1392C GOLDEN EAGLE". The interface is divided into several sections:

- Machine Speed:** A speedometer-style gauge with a scale from 0 to 1000. The "Set RPM" is 1000 and the "Actual RPM" is 1000. Below the gauge are left and right arrow buttons and an "Adjustment Increment" set to "x 100".
- Miscellaneous Information:** Displays "Yardage Counter" at 5.03 with a "Reset" button, and "Yards per Run Minute" at 2.34. It also shows "Current Mode" as "Normal" with a "Batch Information" button and "Yards To Go" as "N/A". A status bar at the bottom indicates "Foot Height" is "Low" and "Current Status" is "Running".
- Pattern Selection:** Shows the pattern name "H:\EZQuiltPatterns\AAC-II-001B.thb" and a preview of the "1392C GOLDEN EAGLE" pattern. Buttons include "Change Pattern", "Needle Array" (set to "NA00002, 6 SPI"), "Size Adjustment", and "Pinch Roller".
- Run History Information:** A table listing machine events and their timestamps.

Event	Time
Machine Started	03/19/07 - 08:12
Machine Paused	03/19/07 - 08:11
Machine Started	03/19/07 - 08:11
Machine Paused	03/19/07 - 08:11
Machine Started	03/19/07 - 08:11
Batch Material Change	03/19/07 - 08:11
Machine Paused	03/19/07 - 08:10
Homing Machine	03/19/07 - 08:10
Servos have been turned on	03/19/07 - 08:10
- Command Buttons:** A row of buttons at the bottom including "Turn Servos Off", "Input/Output", "Utilities", "Pendant Manual", "Finish Pattern", "Help Language", and a large yellow "Pause" button.

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 titled "Miscellaneous Information". It contains several fields and buttons:

- Yardage Counter:** A digital display showing "5.03".
- Yards per Run Minute:** A digital display showing "2.34".
- Reset:** A large rectangular button.
- Current Mode:** A dropdown menu currently set to "Normal".
- Batch Information:** A button.
- Yards To Go:** A digital display showing "N/A".
- Currently set for Normal Mode:** A text field.
- Foot Height:** A green button labeled "Low".
- Current Status:** A green button labeled "Running".

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. When 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.

Here is a step by step on how to adjust the presser foot on your Quilter. You can adjust the presser foot height easily without disturbing any other timing adjustments.

Presser Foot adjustment procedure for 1392

- Using the touch screen or pendant, place the quilter at 180 degrees.
 - Turn the presser foot adjustment wheel to lowest position.
 - Loosen the 8mm bolts on spring retaining cups at top of presser foot rods. Be cautious as these may be under a great deal of pressure. May require rod to be held by wrench.
 - Place 8 shims (typically half of desired material thickness) between throat plate and presser foot directly under presser foot rods. Shims should be same length as presser foot front to rear.
 - Loosen the 16 8mm bolts that hold the cam followers on the presser foot rods. Notice that the bearings on the cam followers will fall away from the cams.
 - Your presser foot is now sitting freely on the shims and that will become your lowest position upon completion.
 - From left to right begin re-tightening as follows.
 - With one hand pull the cam follower bearing up firmly against the cam and tighten the 8mm bolts so that the cam follower holds place on the presser foot rod. If done correctly you will not be able to spin the bearing with your fingers as they are snug against the lower surface of the cams. Do not apply excessive pressure or you will damage these bearings under a load. Repeat 8X
 - Again from left to right. Place the retaining cups on the springs and tighten 8mm bolt at top of presser foot rod. This may require you to hold the rod with a wrench as not to put lateral pressure on the cam followers. If you cannot collapse the spring enough by hand you can place the tip of a long screw driver on the head of the bolt directly behind the top of the rod and carefully pry down until the bolt is started.
 - Now you can turn the presser foot adjustment wheel to highest position. It should turn as easily as before, if not you have something in a bind., go back and double check that the spaces between the cam follower clamp and the bottom of the rod sleeve bearing (usually blue) are all identical. As well as vertical distance between the bottom of the needle bar and the top surface of the presser foot across the entire length of the presser foot. (This is a good reference point to assure you have properly aligned everything). If this varies just adjust as needed by loosening the 8mm bolt on the cam follower clamps.
 - Double check that the cam follower bearings are still all snug against the cams. And you are ready for operation again. I recommend starting the machine at a low rpm (200-300) and doing a final look over just to be certain everything is tight and adjusted properly as not to interrupt production once you start running material.

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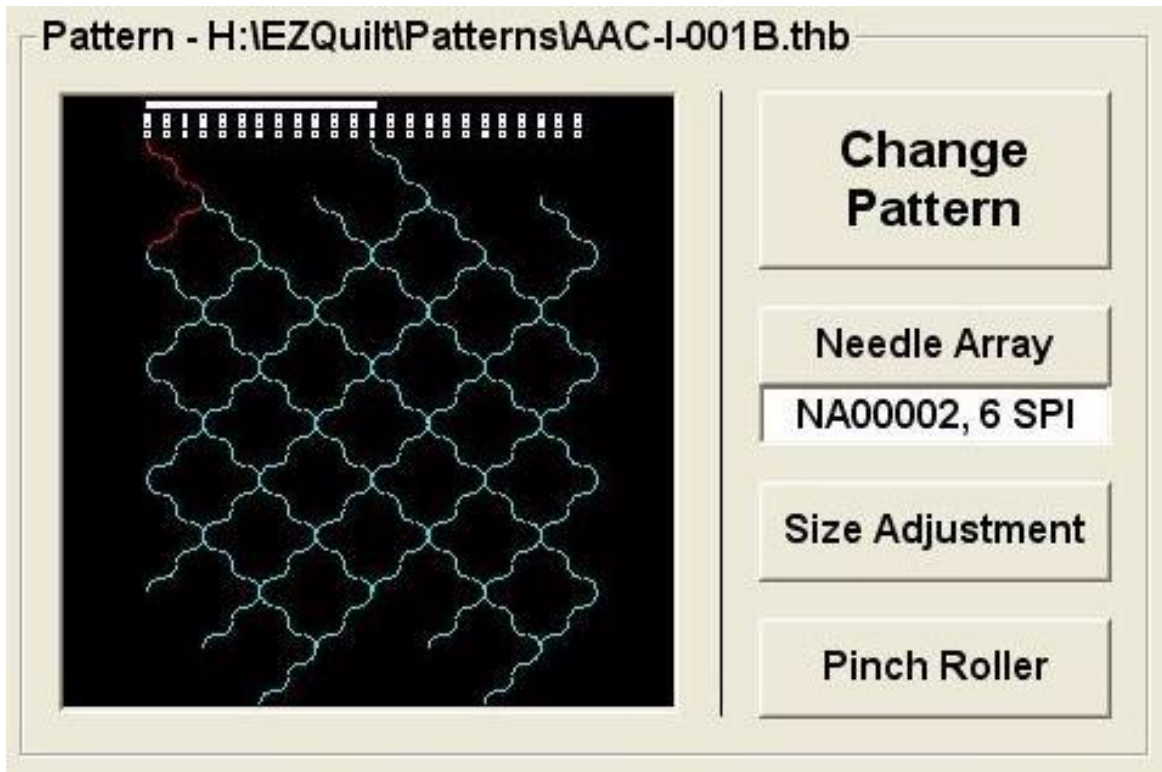
Foot Height is defined as the distance between the bottom of the presser foot to the top of the needle plate. This distance is physically set on the machine with the use of a manual crank. Sensors mounted to the mechanism tell the controller the current height of the foot. Foot Height adjustment is necessary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

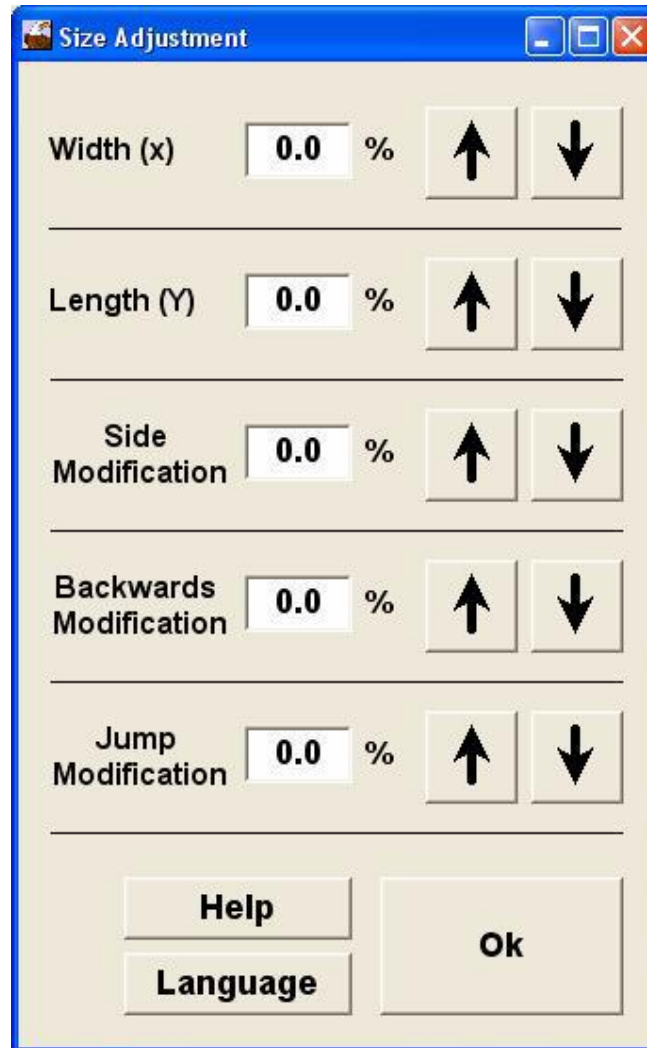
 **NOTE: If any changes are made, the pattern has to be re-loaded in the E-Z Quilter software.**

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.

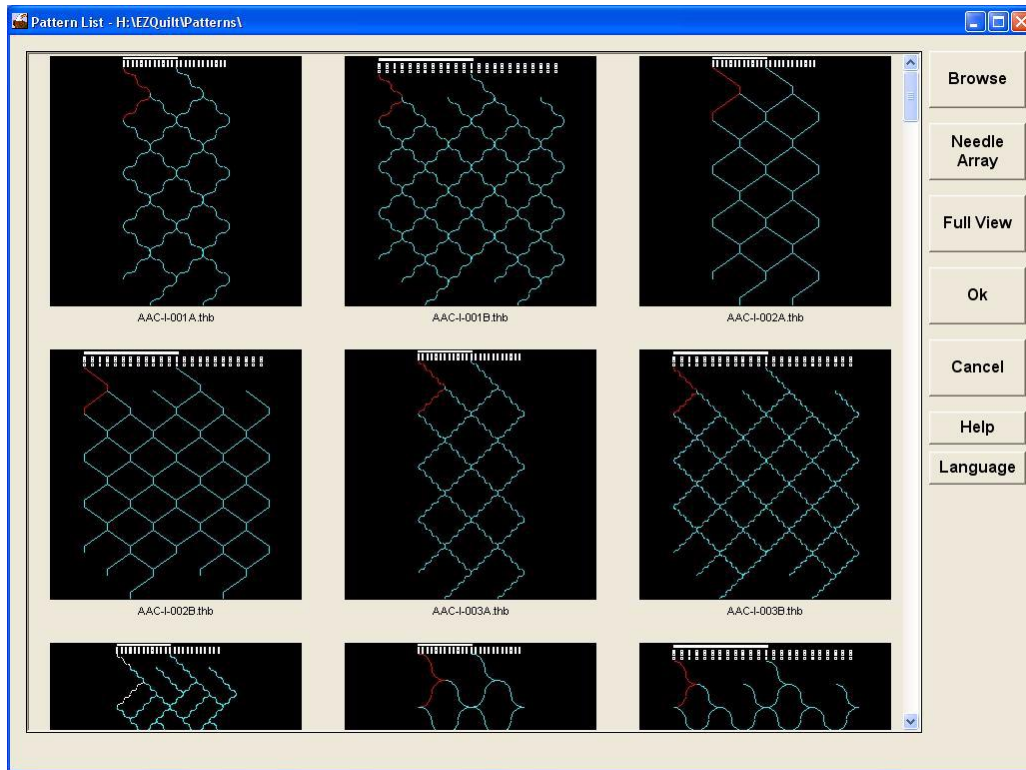


1. Width (X Axis) - Clicking the Arrow buttons increases or decreases the percentage in which the pattern will be stretched in that axis.
2. Length (Y Axis) - Clicking the Arrow buttons increases or decreases the percentage in which the pattern will be stretched in that axis.
3. Side Modification - Clicking 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.

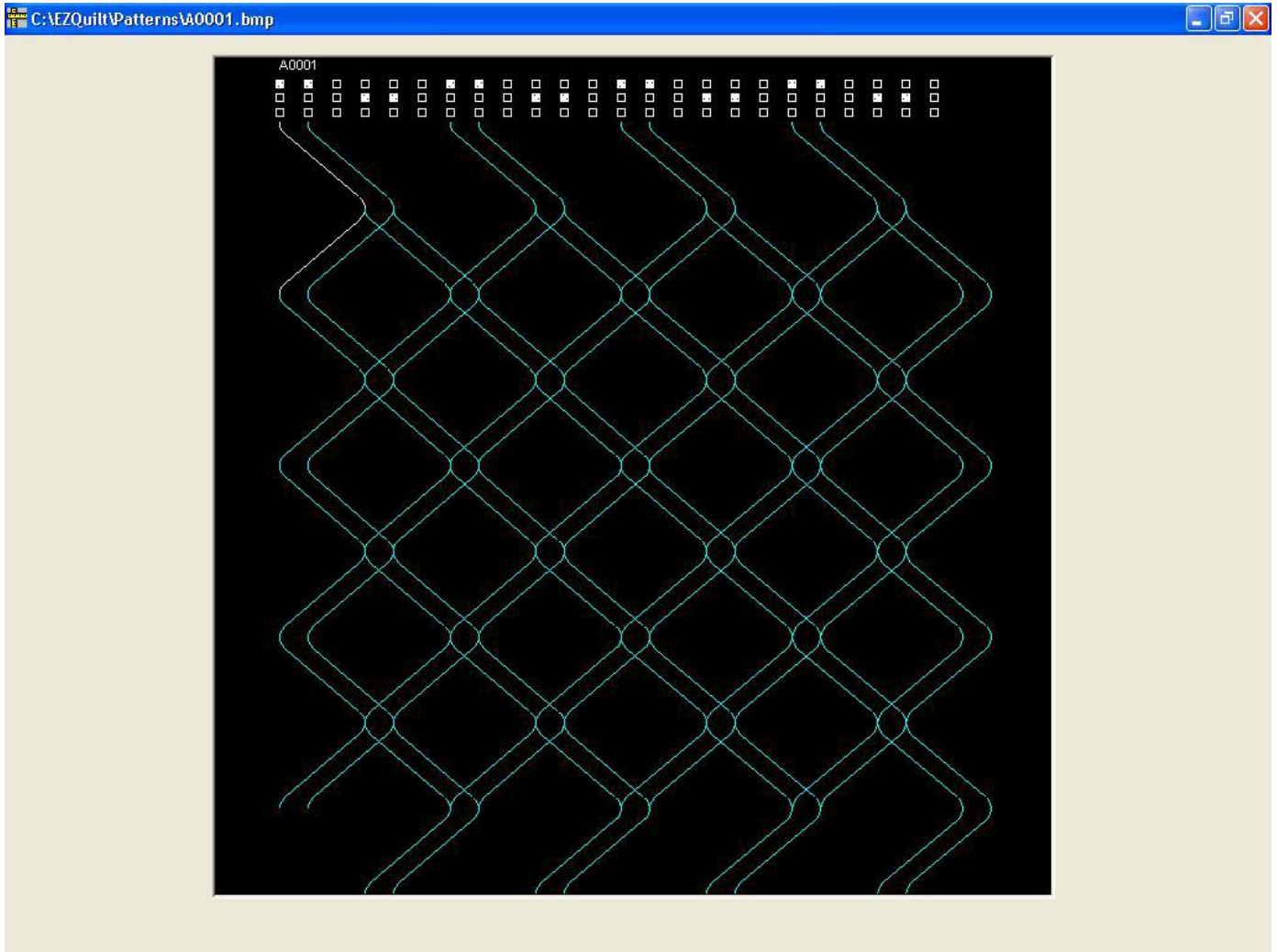
Clicking the OK button loads the selected pattern into the machine. If no pattern is selected it loads the first pattern in the list. If the servos were not turned off prior to selecting the Change Pattern button, a message will appear to allow you to turn them off. Then the new pattern must be reselected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



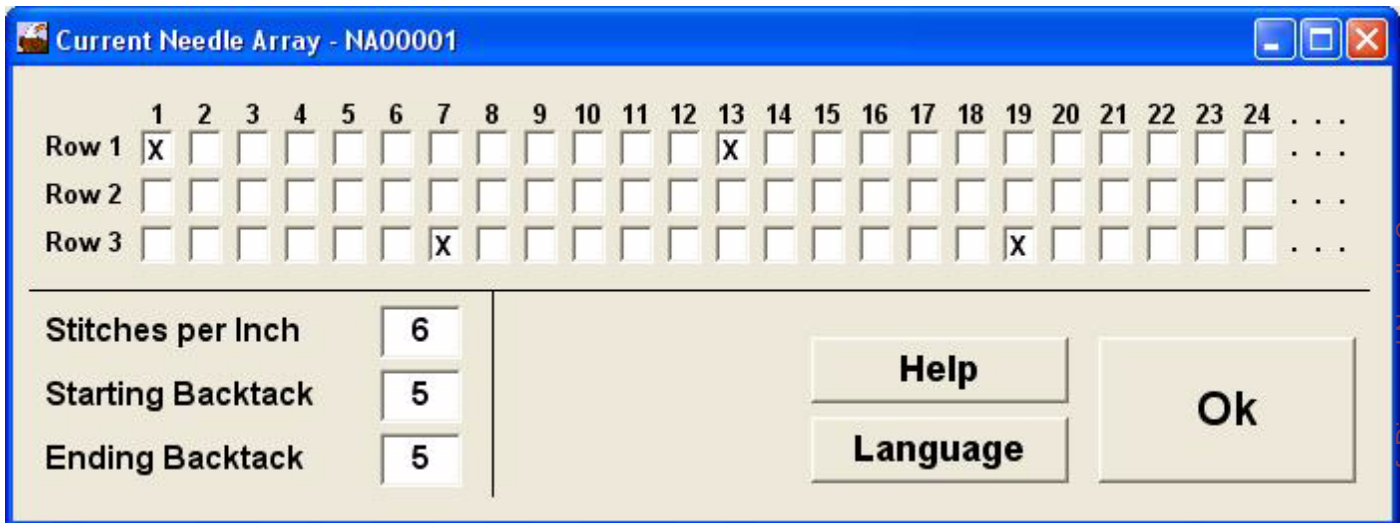
From the library of: Diamond Needle Corp

Needle Array

The Needle Array Screen displays the actual needle arrangement necessary to achieve the selected pattern. It only shows 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 back tack 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.

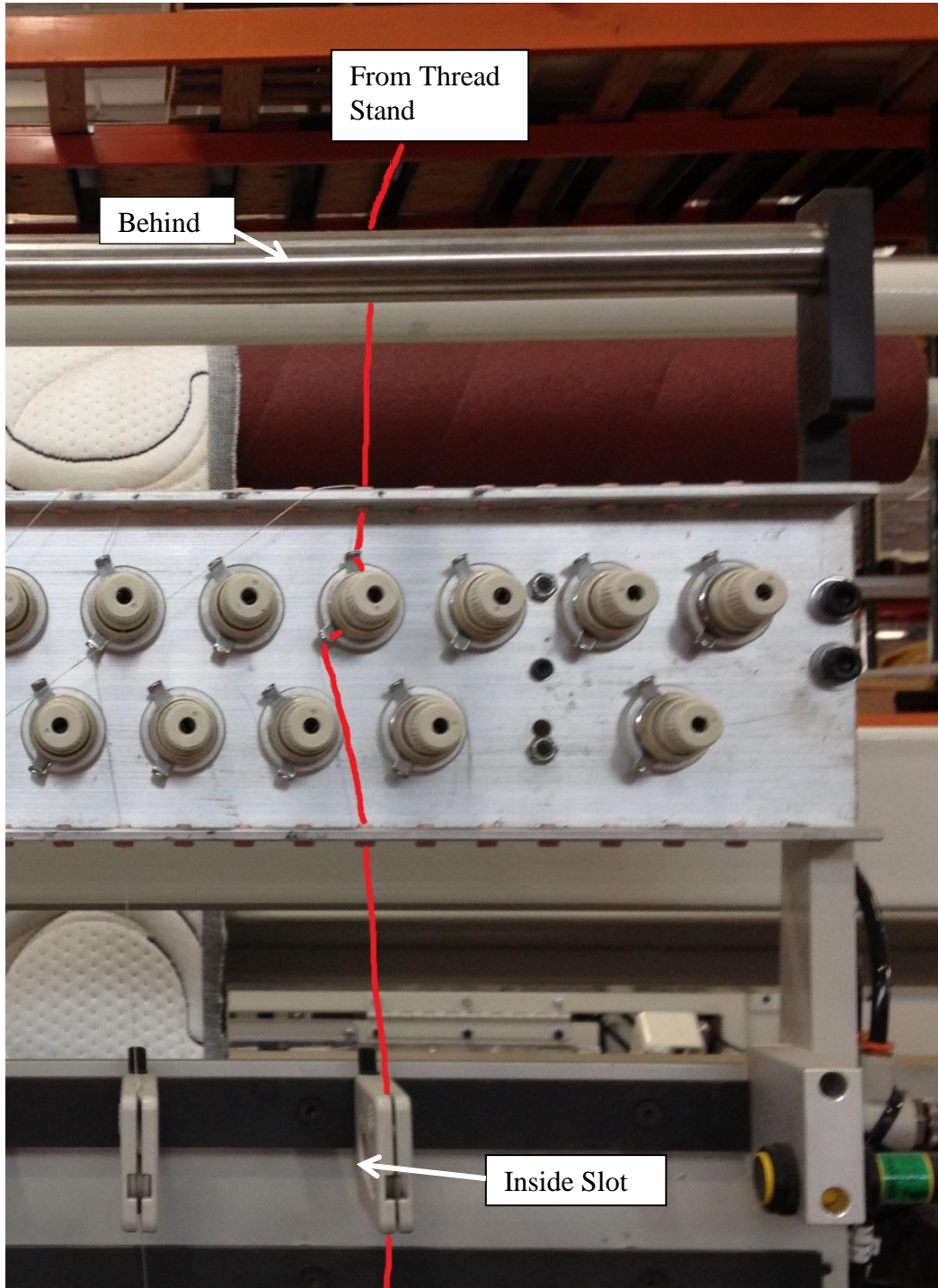
Stitches per Inch, Starting Back tack, and Ending Back tack values can be changed resulting in a permanent change to the pattern files and an automatic re-load of the pattern.



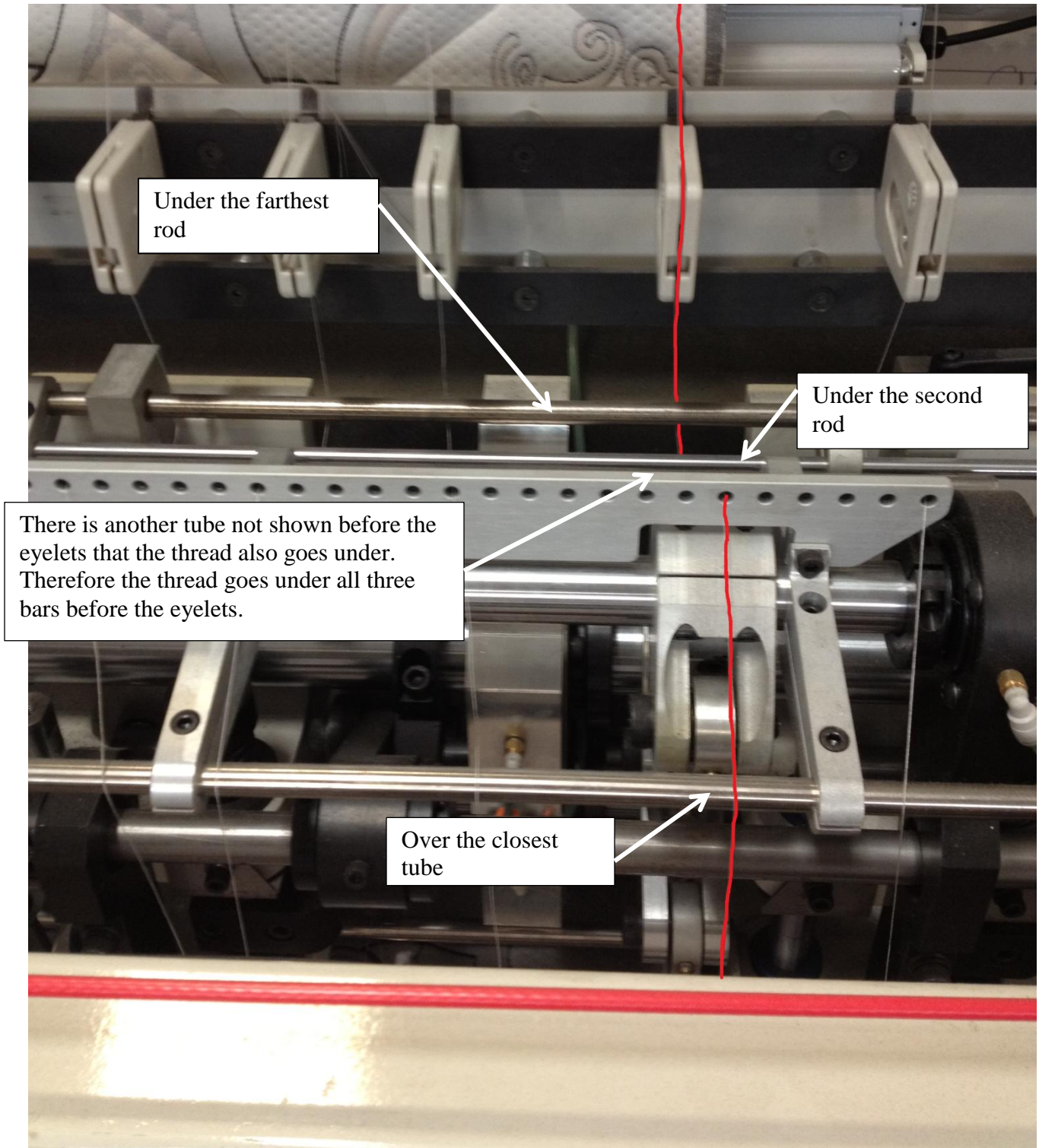
How-To Guide for Threading the 1392

From Thread Stand:

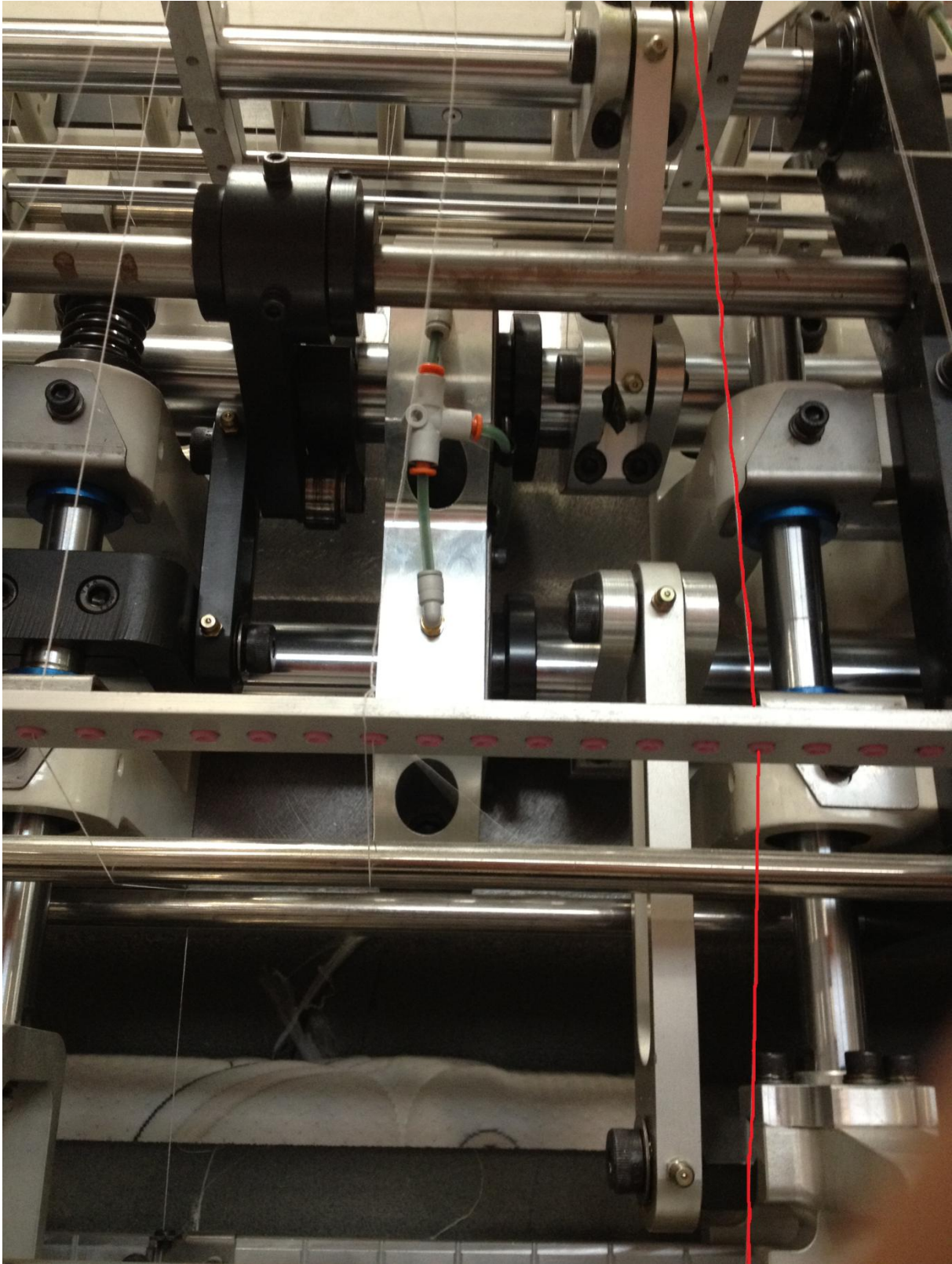
1. Take the thread behind the rod, through the eyelet, through the thread tensioner, through another eyelet, then inside the slotted thread break detector and pull down towards the needles.



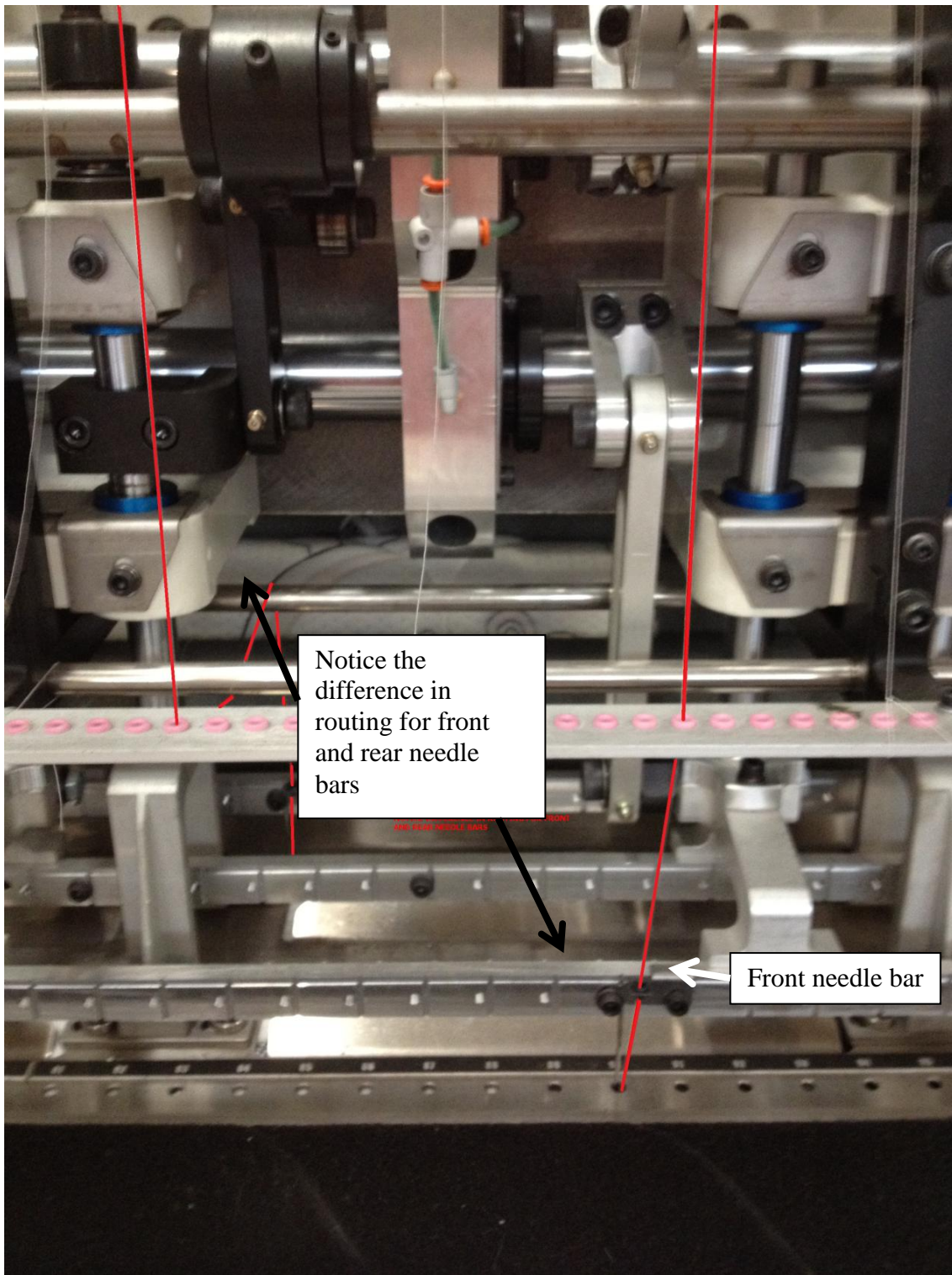
2. Route the thread under the furthest rod, under the second rod, under the butterfly tube, through the guides, then over another butterfly tube and then down through the guides and towards the needles.



3. Route the thread from the rod down to the eyelets below.

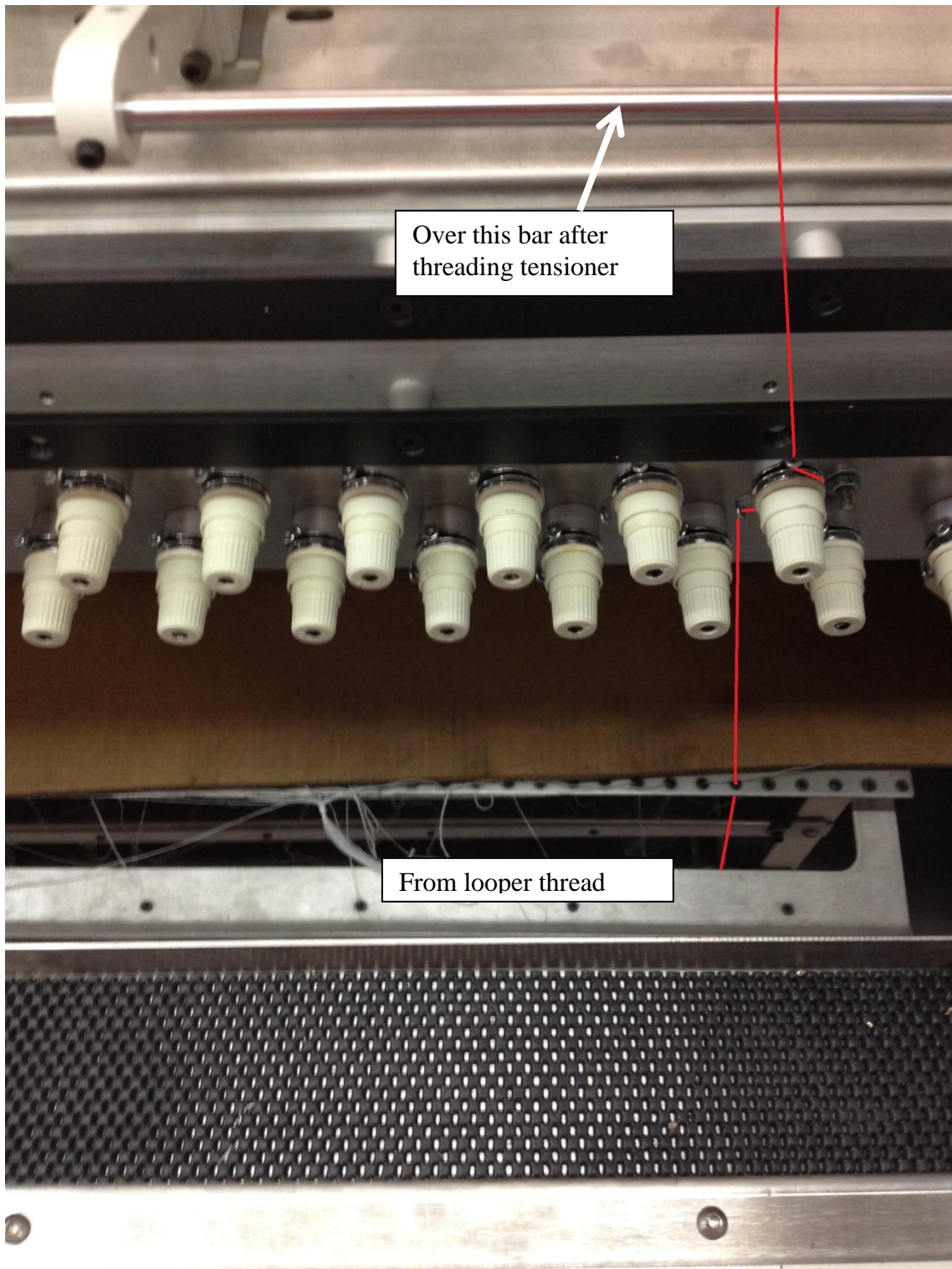


4. Thread the needles. The front needles are threaded straight down from the eyelets. The rear needles are threaded by routing the thread under the middle bar and over the rear bar and down to the needles. The middle needles are threaded similar to the rear needles but the thread only goes over the middle bar then down to the needles.

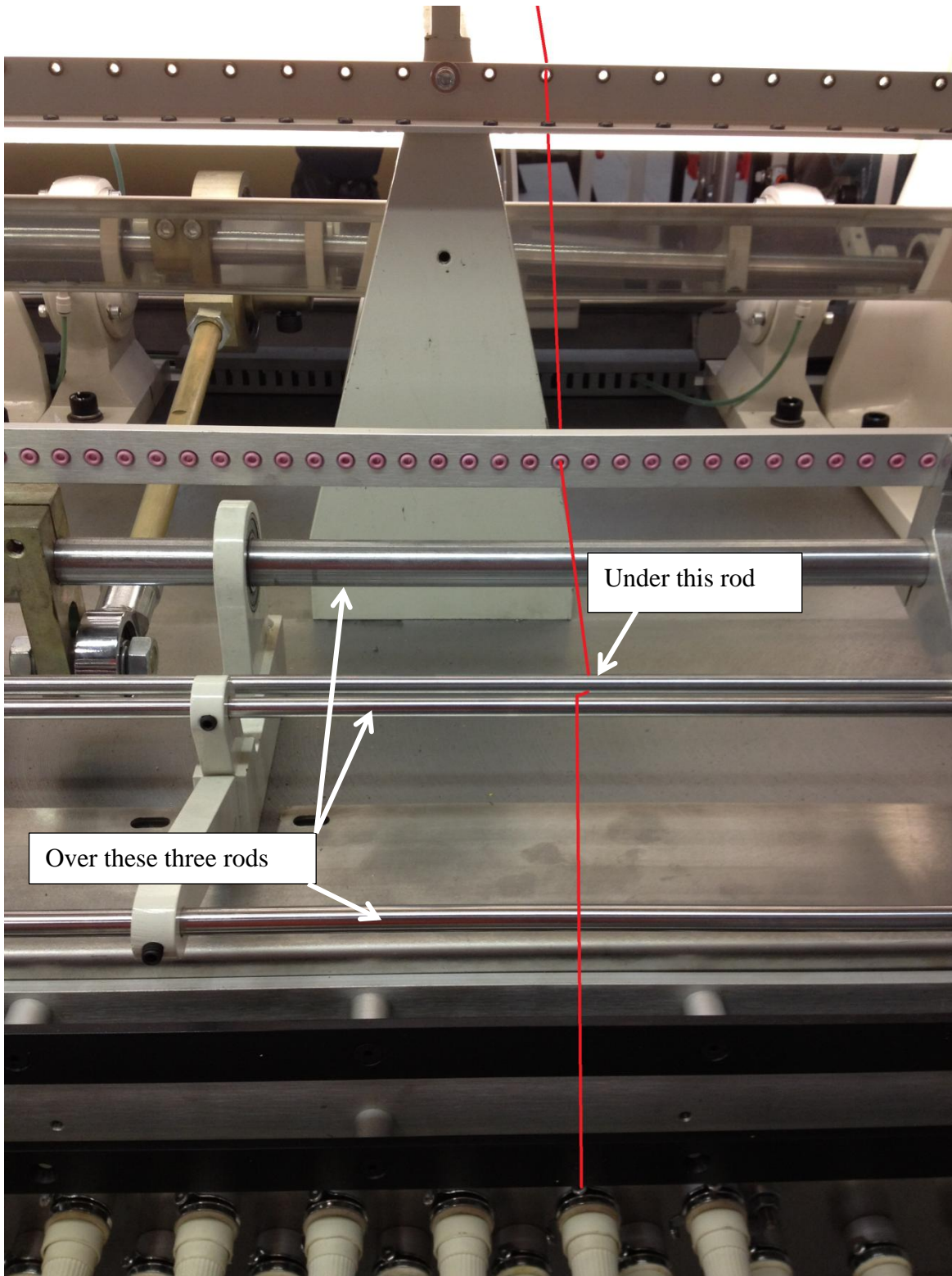


Looper Thread Routing:

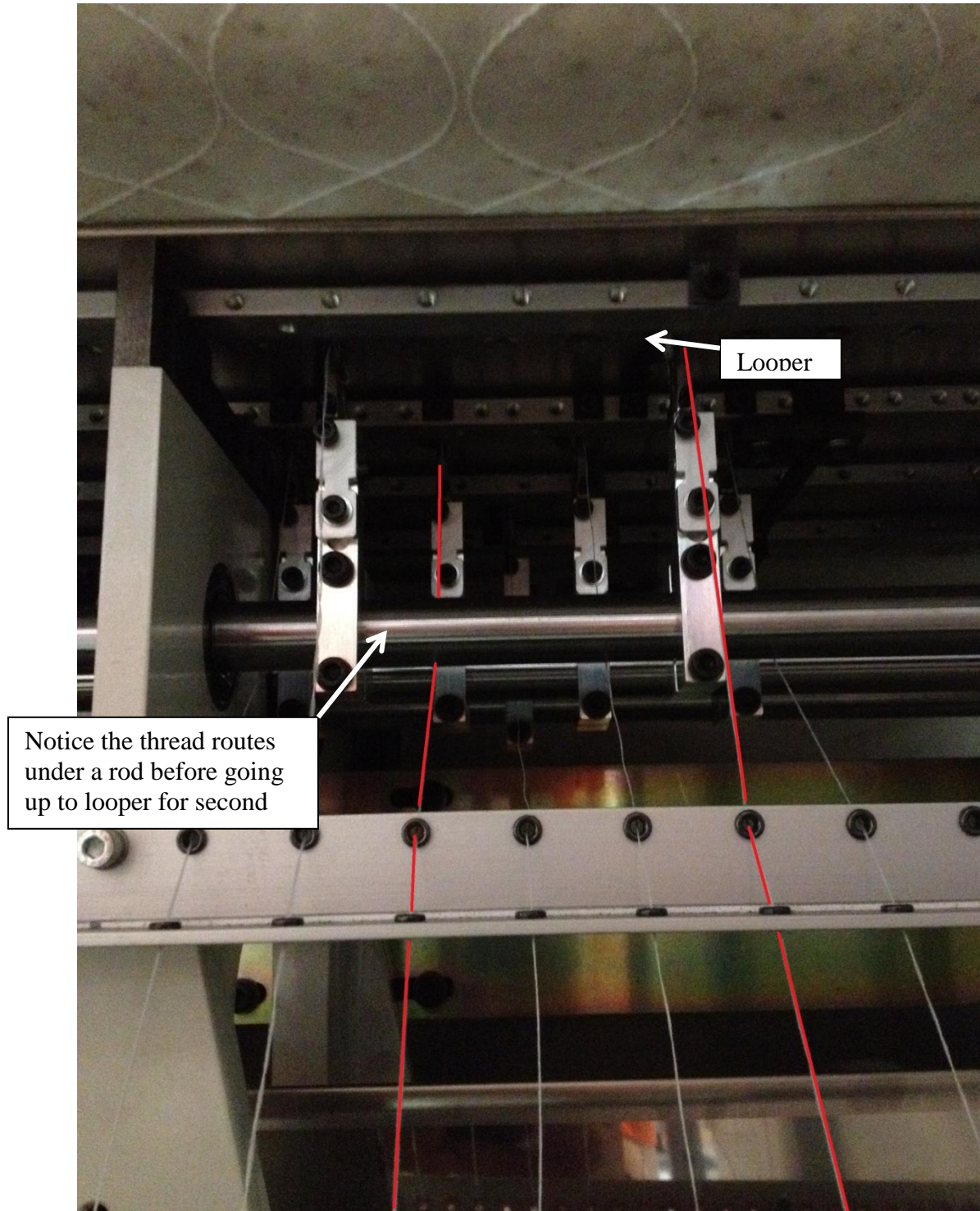
1. Run the thread through the eyelet and thread tensioner. Then take the thread over the first bar.



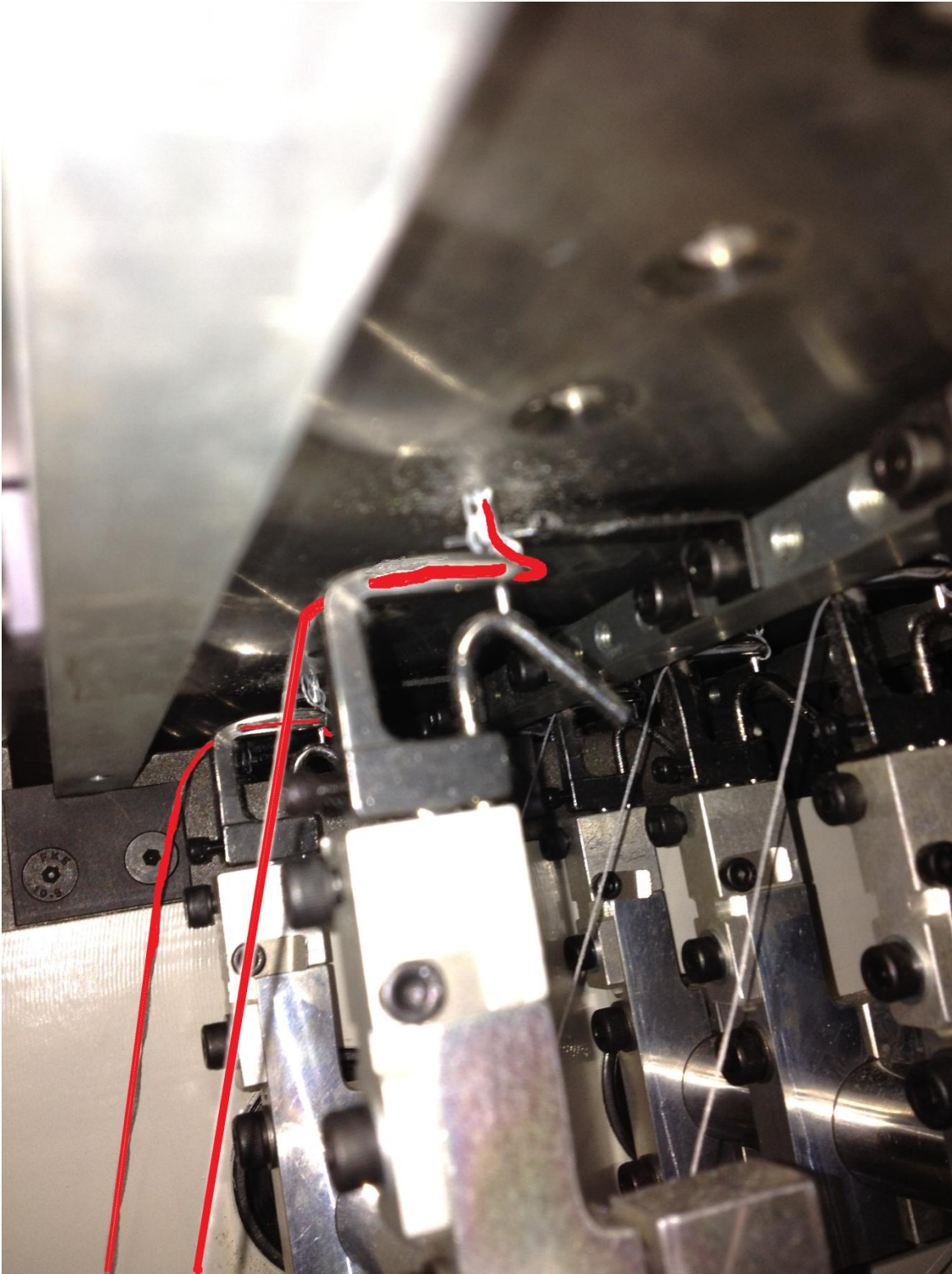
2. Route the thread over the first thread rod, under the second thread rod, then through the thread eyelets.



3. From the back looking at the loopers, route thread through the last set of eyelets and under the bar with the exception of the closest looper. Run thread straight from eyelet to looper.



4. Once at the looper, guide the thread through the back of the looper and bring it around the side then through the front of the looper.

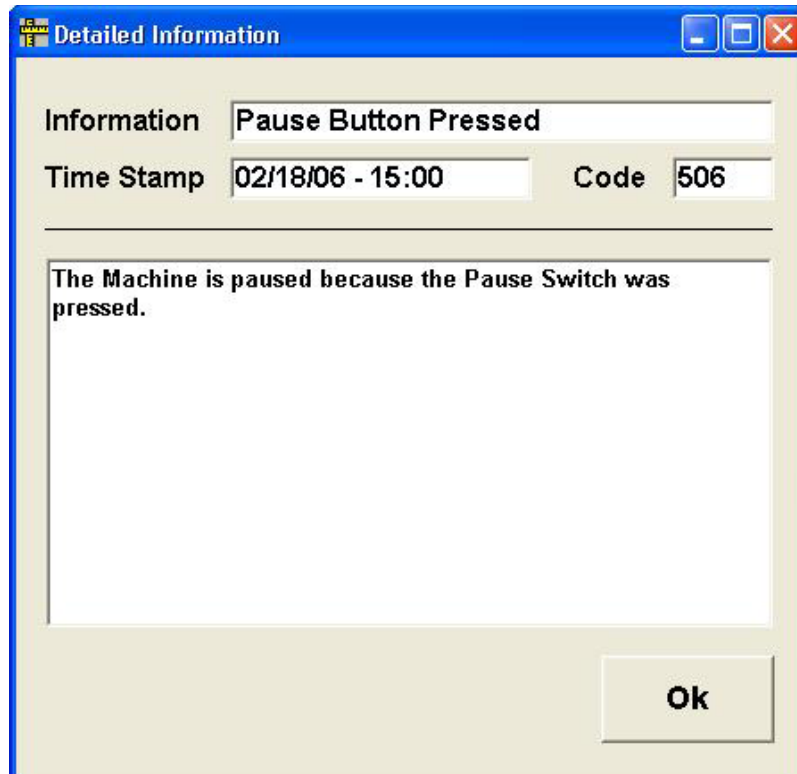


Run History

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 on page 46.

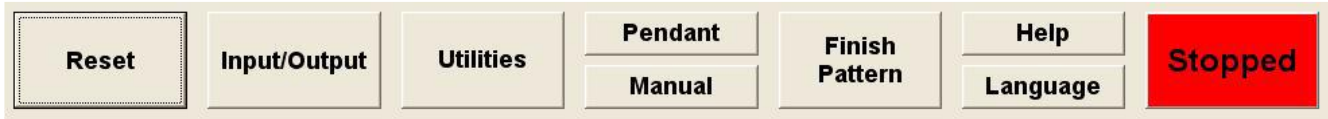
Pattern Change Complete	02/20/06 - 07:20
Pattern List accessed	02/20/06 - 07:20
Machine Stopped (Servos Off)	02/20/06 - 07:19
Software Opened	02/20/06 - 07:19

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.

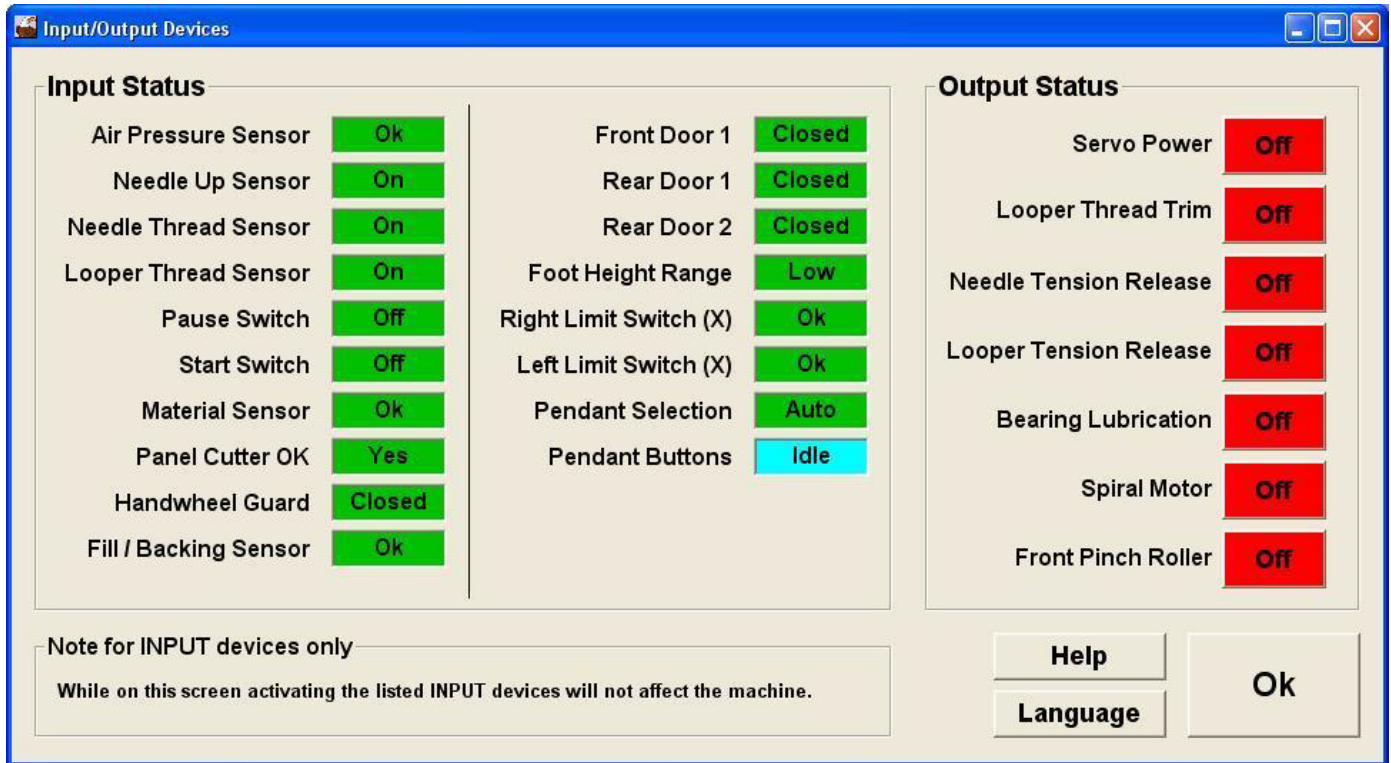
Clicking the button turns off power to the Servos.



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 effect 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).



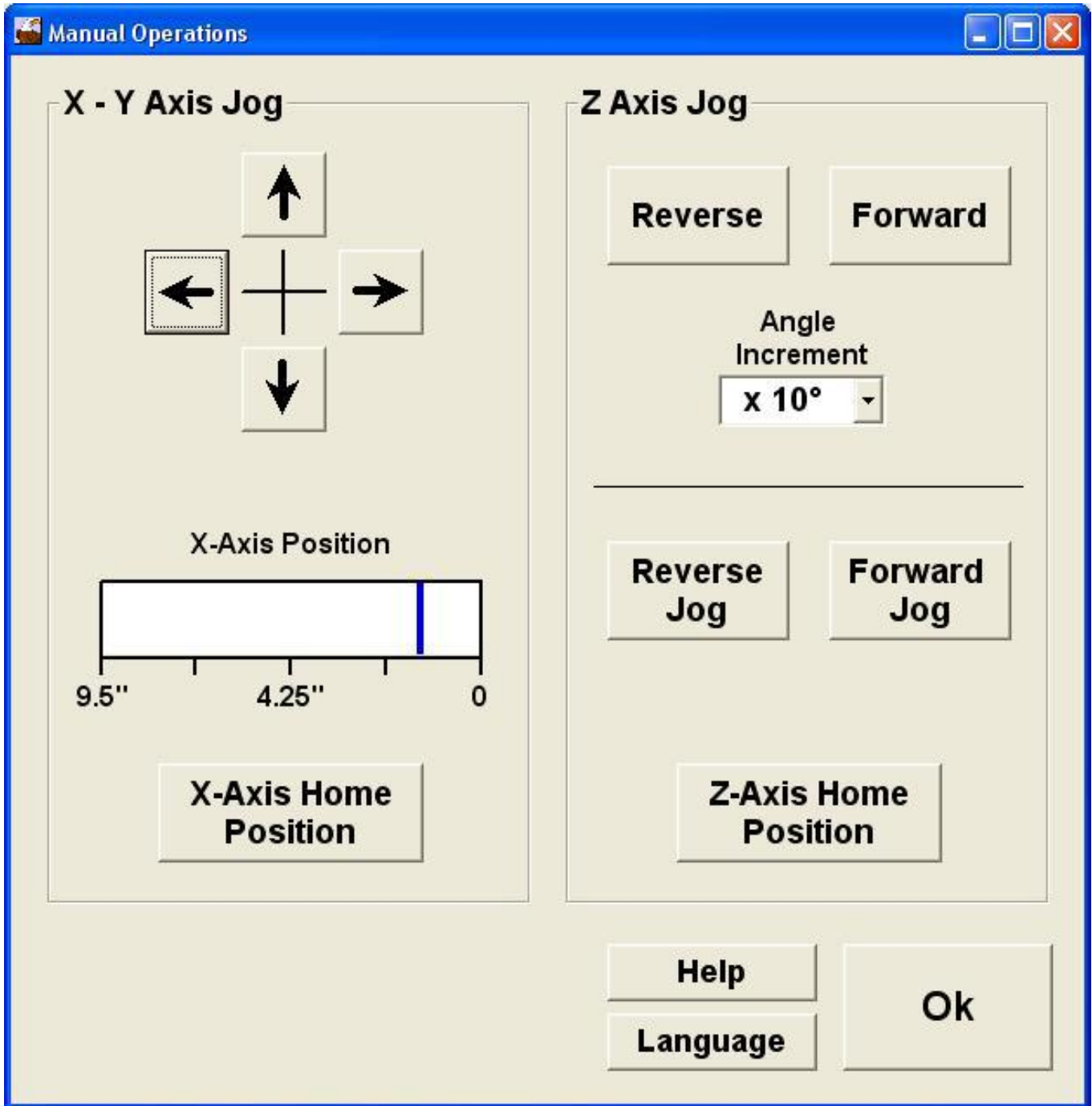
Input Status		Output Status	
Air Pressure Sensor	Ok	Servo Power	Off
Needle Up Sensor	On	Looper Thread Trim	Off
Needle Thread Sensor	On	Needle Tension Release	Off
Looper Thread Sensor	On	Looper Tension Release	Off
Pause Switch	Off	Bearing Lubrication	Off
Start Switch	Off	Spiral Motor	Off
Material Sensor	Ok	Front Pinch Roller	Off
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		

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

Buttons: Help, Language, Ok

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

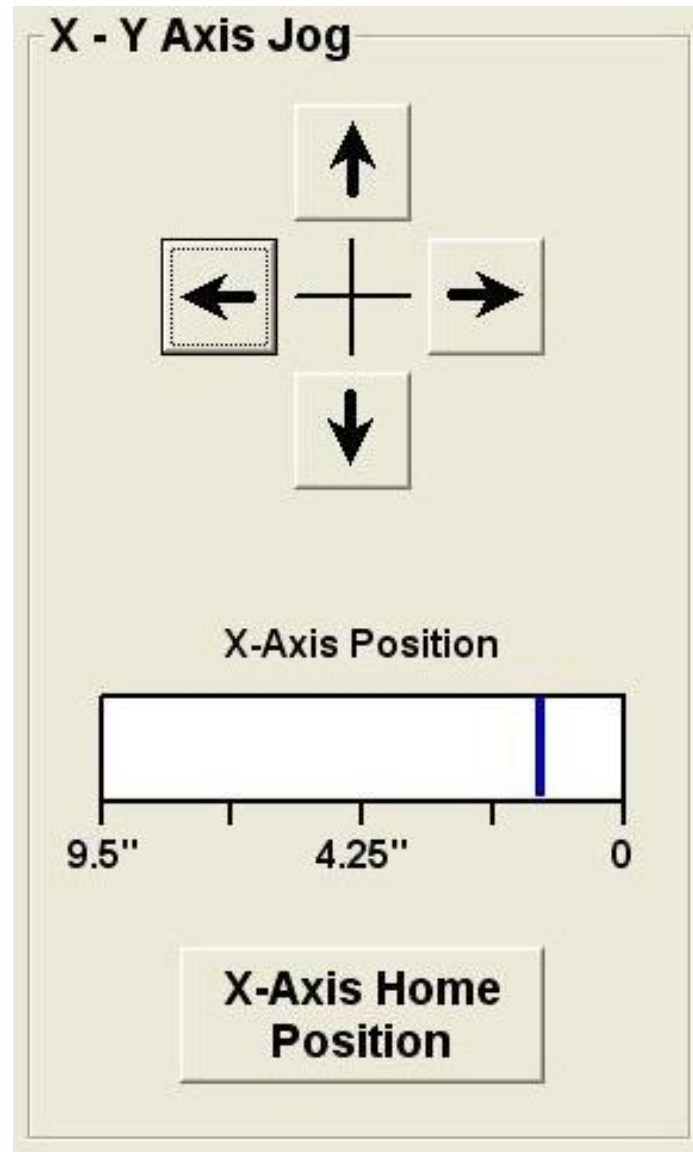
NOTE: When moving the axes independently the synchronous relationship between them is lost. Therefore, when you exit this screen the machine will automatically Home-Out.



From the library of: Diamond Needle Corp

1. X -Y Axis Jog - See “ X-Y Axis Jog” on page 42
2. Z Axis Jog - See “on page 43

X-Y Axis Jog



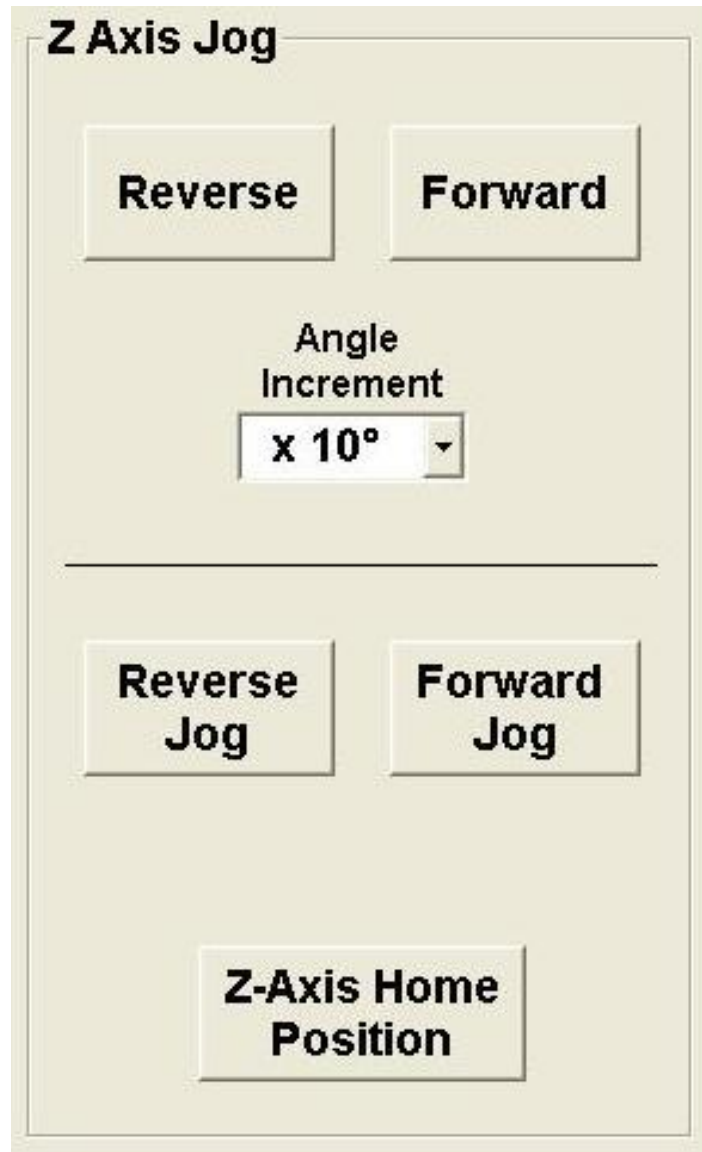
The Arrow buttons pointing left and right move the X-Axis (Carriage) in the Left and Right directions.

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

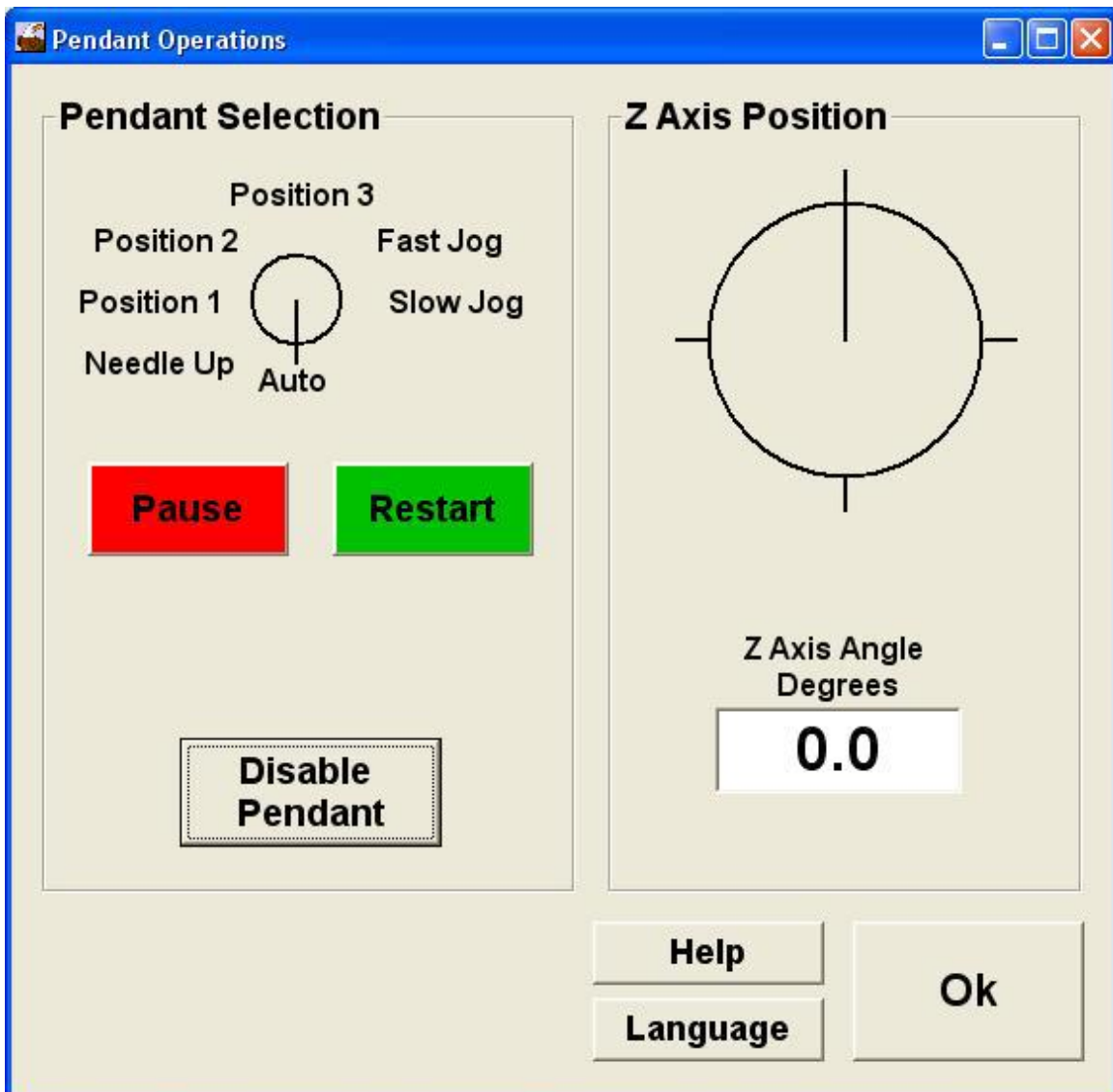
NOTE: For safety reasons, if the front door is open, the hand held pendant is disabled.

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.



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

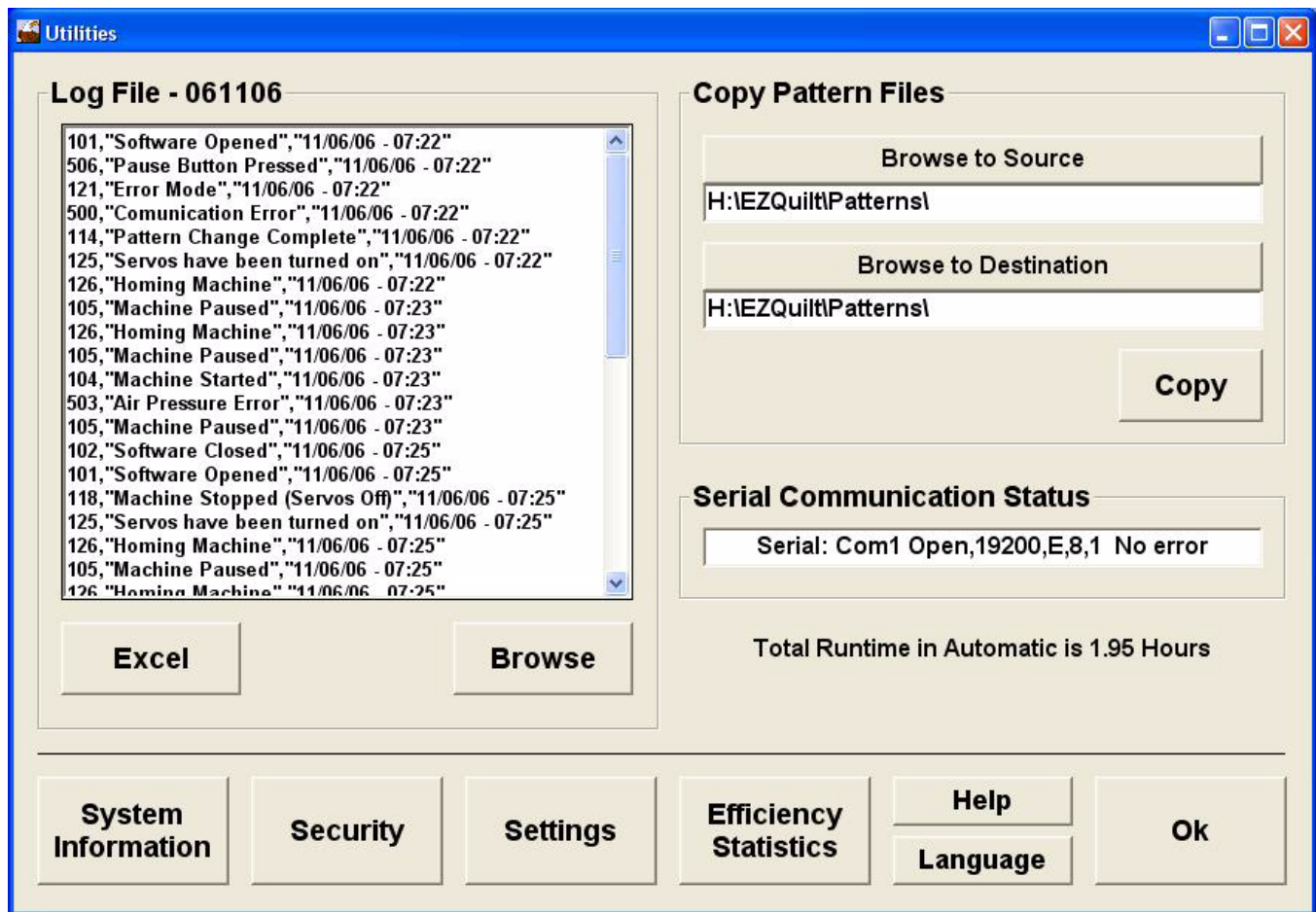
Selector	Red Button	Green Button	Function
Auto	Pause	Restart	Start/Pauses machine
Needle Up	Pause	Execute	Moves machine to the Needle Up position
Position 1	Pause	Execute	Moves Z-Axis to user-defined position
Position 2	Pause	Execute	Moves Z-Axis to user-defined position
Position 3	Pause	Execute	Moves 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.



Utilities



As its name implies the Utilities Screen have several functions.

1. Log Files (See “Log Files” on page 47.)
2. Copy Pattern Files (See “Copy Pattern Files” on page 48.)
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 49.)
6. Security (See “Security” on page 50.)
7. Settings (See “Settings” on page 51.)
8. Efficiency Statistics (See “Efficiency Statistics” on page 56.)

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

Log Files



From the library of: Diamond Needle Corp


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 an 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.

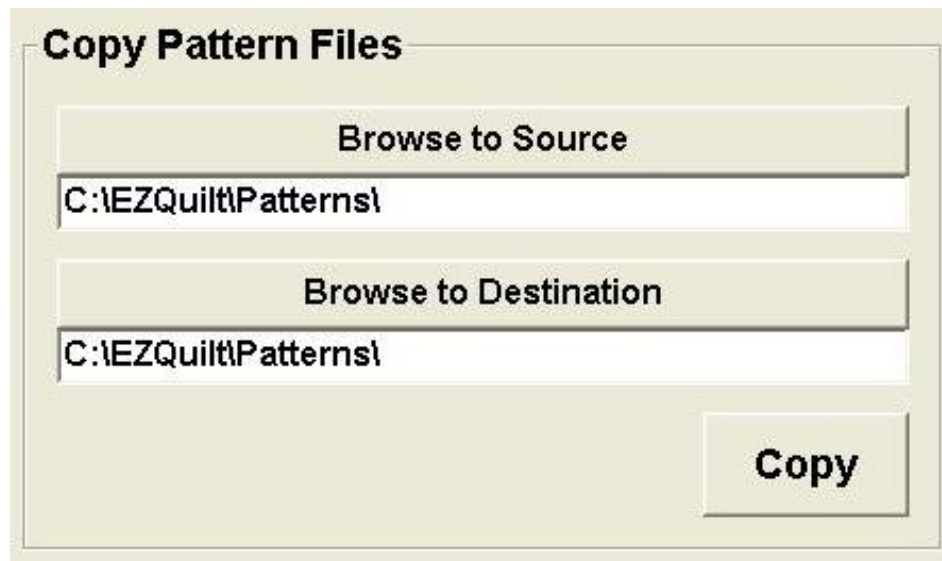
All Log Files are stored in a directory called C:\EZQuilt\Logs\.

 **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.

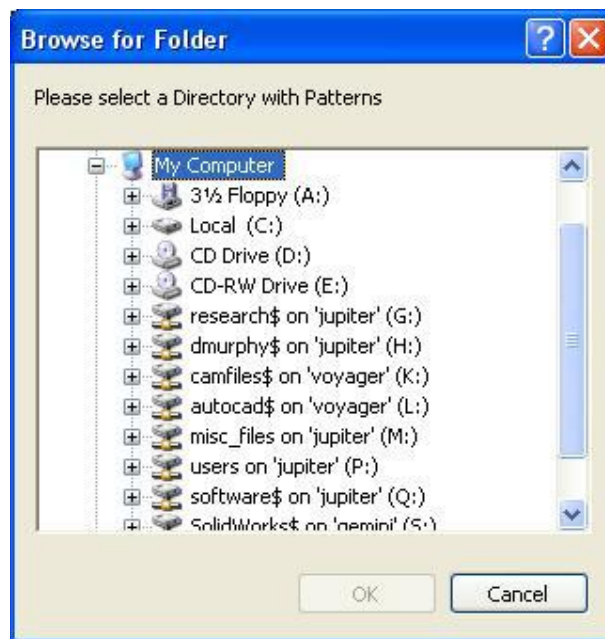
 **NOTE: For the Excel function to work Microsoft Excel has to be installed on this computer.**

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.

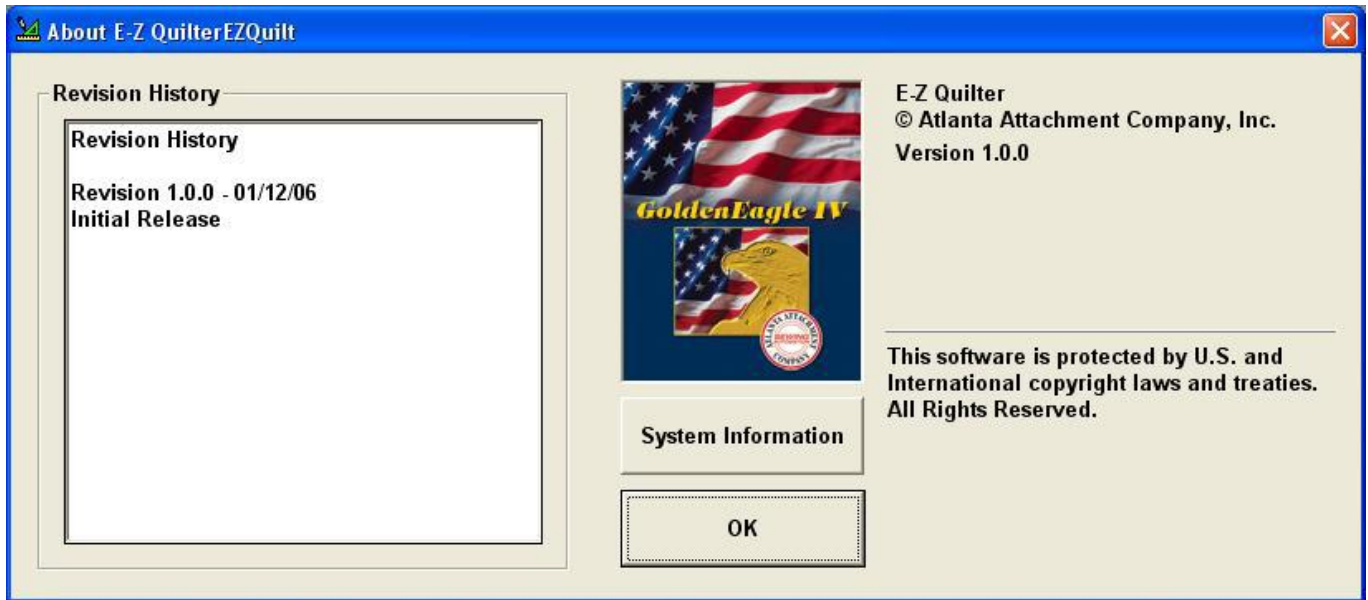


Source - The Source directory is the location where the files to be copied reside. Examples would be a memory stick, a floppy disk or a network drive.

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

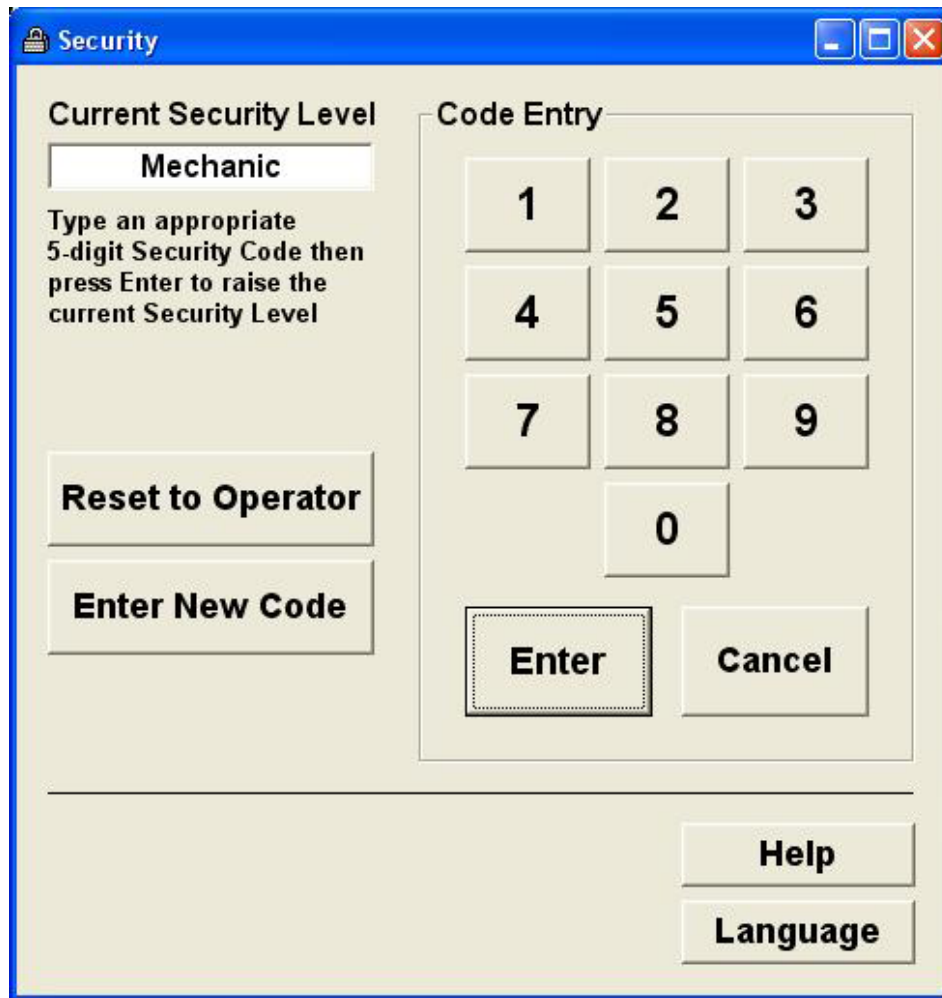
System Information shows Company Information and Revision History.



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.

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.

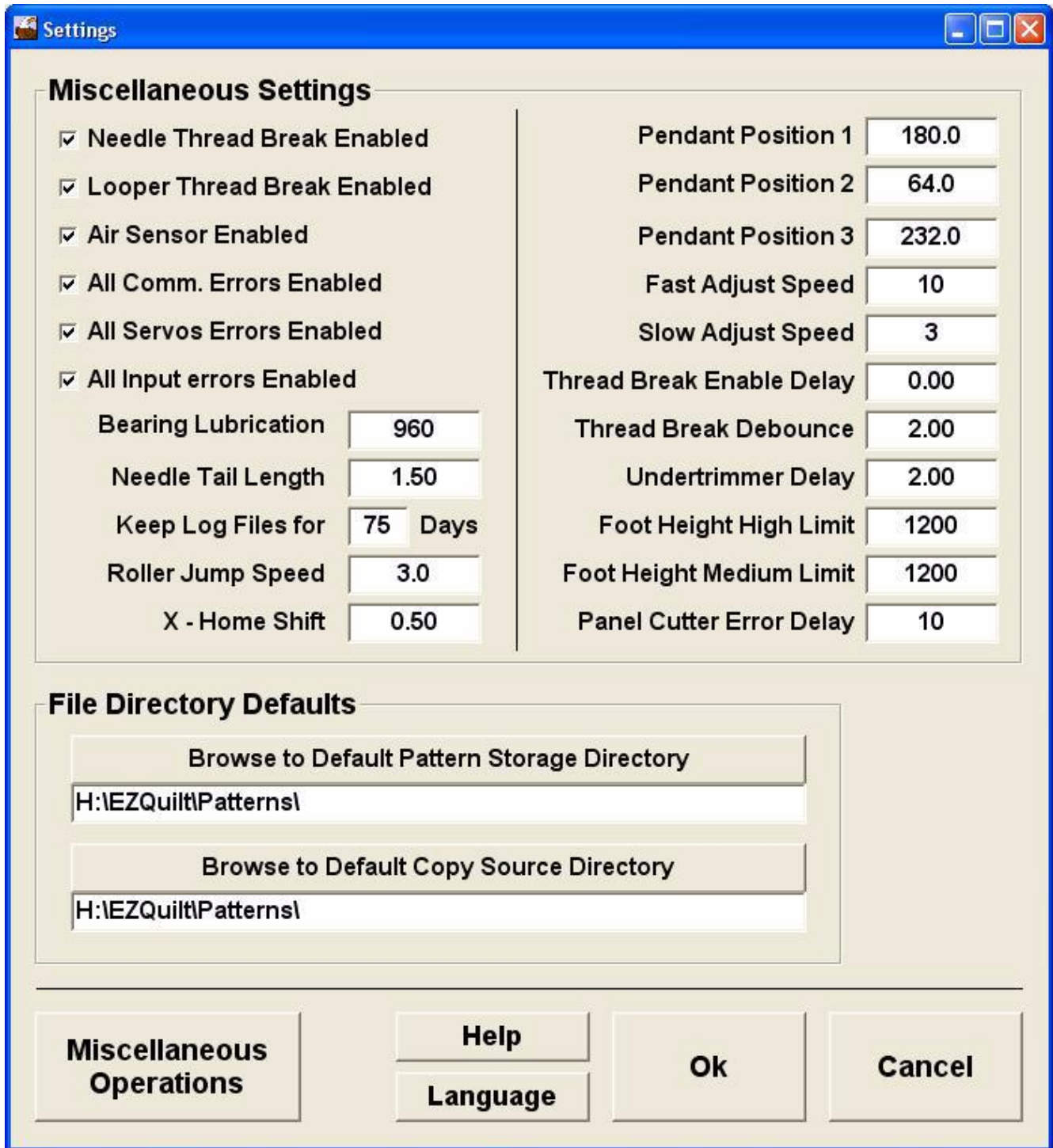
The codes can be changed for each level by following the instructions on the screen (see above).



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.**



The screenshot shows a 'Settings' window with two main sections: 'Miscellaneous Settings' and 'File Directory Defaults'.

Miscellaneous Settings

<input checked="" type="checkbox"/> Needle Thread Break Enabled	Pendant Position 1	180.0
<input checked="" type="checkbox"/> Looper Thread Break Enabled	Pendant Position 2	64.0
<input checked="" type="checkbox"/> Air Sensor Enabled	Pendant Position 3	232.0
<input checked="" type="checkbox"/> All Comm. Errors Enabled	Fast Adjust Speed	10
<input checked="" type="checkbox"/> All Servos Errors Enabled	Slow Adjust Speed	3
<input checked="" type="checkbox"/> All Input errors Enabled	Thread Break Enable Delay	0.00
Bearing Lubrication	Thread Break Debounce	2.00
Needle Tail Length	Undertrimmer Delay	2.00
Keep Log Files for	Foot Height High Limit	1200
75 Days	Foot Height Medium Limit	1200
Roller Jump Speed	Panel Cutter Error Delay	10
3.0		
X - Home Shift		
0.50		

File Directory Defaults

Browse to Default Pattern Storage Directory
H:\EZQuilt\Patterns\

Browse to Default Copy Source Directory
H:\EZQuilt\Patterns\

At the bottom of the window are buttons for 'Miscellaneous Operations', 'Help', 'Language', 'OK', and 'Cancel'.

From the library of: Diamond Needle Corp

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 an 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

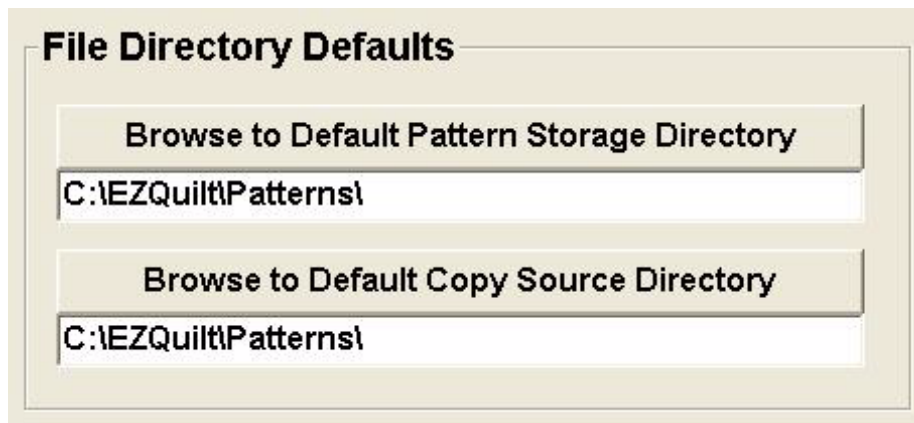
Maximum - 60

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.

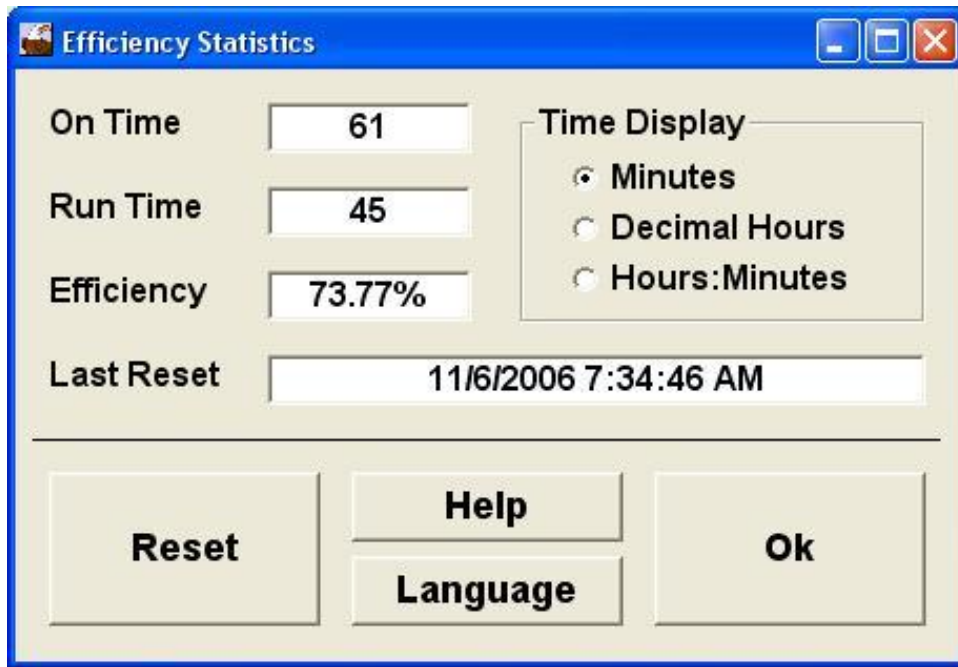


Efficiency Statistics

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).

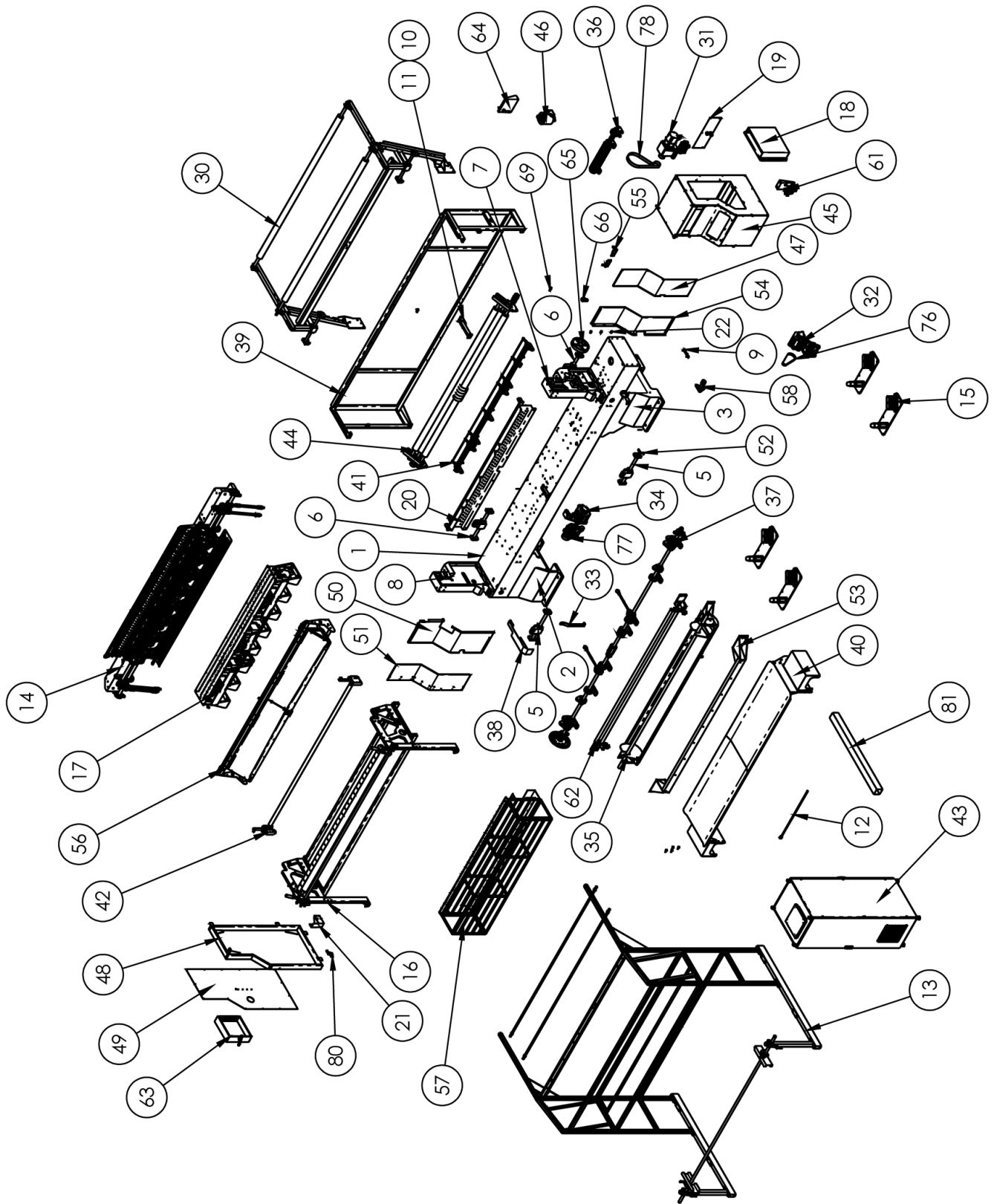


Assembly Drawings & Parts Lists

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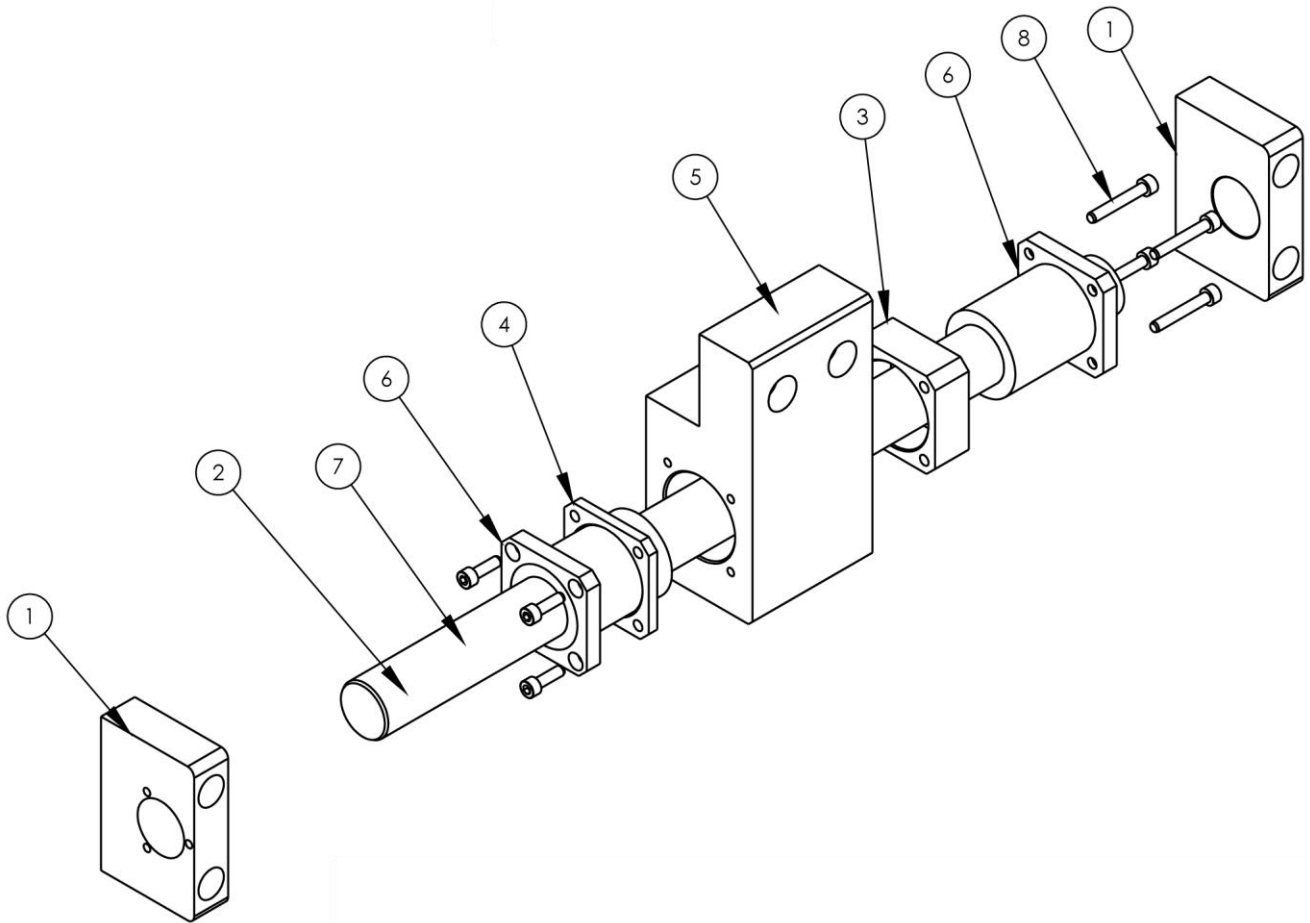


11392 Quilter Sliver Eagle

AAC Drawing Number 9001087 Rev 2

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1-001	BASE, QUILTER	43	1	1392364	CABINET, CONTROL, ASM
2	1	1-002	LEFT BASE	44	1	1392392	LH ROLL DRIVE ASSY
3	1	1-003	RIGHT, BASE FOOT	45	1	1392405	GUARD, MOTOR ASM
4	4*	1-007	MT,BEARING,ECCENTRIC	46	1	1392415	LUBRICATION ASSY
5	2	1388222	LINEAR SLIDE,FT,35MM	47	1	1392467	PANEL,BENT,R
6	2	1388227	LINEAR SLIDE,RR,35MM	48	1	1392525	WELDMENT,GUARD,LEFT
7	1	1389021	BASE, SUPPORT, RIGH SIDE	49	1	1392537	PANEL,GUARD,MOTOR,SIDE,L
8	1	1389022	BASE, SUPPORT, LEFT SIDE	50	1	1392558	GUARD,SE LEFT
9	1	1389033	BRKT,STRAIN RELIEF	51	1	1392559	PANEL,BENT,L
10	1	1389070	WLDMT,REAR GUARD BRACE	52	1	1392565	BRACKET,NDL UP SENSOR
11	1	1389072	BRKT,REAR GUARD BRACE	53	1	1392580	BAG CLOSING MOUNT ASM
12	1	1389396	TENSTION ADJUST ROD ASM	54	1	1392733	GUARD,PANEL,LEFT
13	1	1389653	THREAD STAND FRAME ASM	55	1	1392744	LIMIT SWITCH ASSEMBLY
14	1	1389655	BRIDGE ASSEMBLY	56	1	1392779	FRONT GUARD ASSY
15	4	1389740	ISOLATOR BASE ASSEMBLY	57	1	1392839	THREAD STAND,SILVER EAGLE
16	1	1389742	MAIN CARRIAGE, 1392	58	1	1392898	IDLER ASM, Y AXIS DRIVE
17	1	1389748	THROAT PLATE ASSY,1392	59	1*	1392A-LAB3	LABELS,AAC ROUND
18	1	1389760	PANEL,ELECTRICAL,REMOTE	60	1*	1392A-LAB5	LABELS,SCALE
19	1	1389762	REGULATOR ASSY	61	1	1393854	FRL ASSEMBLY, 1392
20	1	1389764	REAR THREAD TENSION ASM	62	1	1393922	TENSIONER ASSEMBLY
21	1	1389818	BRACKET, SEAMER LATCH	63	1	1393924	GUARD, HANDWHEEL ASM
22	3	1389819	SPACER, RIGHT GUARD PANEL	64	1	1393940	VALVE/REGULATOR ASSY
23	1	1389822	BRKT,BRACE,BTM	65	2	2-047	GEAR PULLEY, 84 TOOTH
24	1	1389823	BRKT,BRACE,TOP	66	1	2-081	DRIVE ARM, REAR BTRFLY
25	1	1389829	BRKT,GUARD	67	1*	2-50A	SHAFT,SPLINE,Y AXIS
26	8	1389831	STRIP,RUB,DELIN,10"	68	1*	4-045A	HOUSING, BEARING
27	2*	1392-001	CABLE ASSM, REAR DOOR	69	1	5-033	SHAFT, RODEND,REAR BTRFLY
28	1*	1392-CAB	CABLE PACKAGE	70	1	5-035	COLLAR
29	1*	1392-LAB2	LABLE,SILVER EAGLE	71	4*	AA3001F-03	1/4 INLINE FLOW CONTROL
30	1	1392028	TRANSFER CARRIAGE ASSY	72	1*	BB32052RS	BEARING,2 ROW,25MM X 52MM
31	1	1392070	ROLL SERVO DRIVE ASM	73	1*	BB69122RS	BEARING, RADIAL,SEALED
32	1	1392071	CARRIAGE SERVO DRIVE ASM	74	1*	BB69162RU	BEARING, RADIAL SEALED
33	1	1392074	BRACE, FRONT, OFFSET	75	1*	FFGXL8FC5	PROX SENSOR
34	1	1392082	NEEDLE BAR DRIVE ASM	76	1	GG300L100	BELT, TIMING, L-TYPE
35	1	1392087	TRAY ASSEMBLY, FRONT	77	1	GG405L150	BELT, TIMING, L-TYPE
36	1	1392096	DRIVE, WORM GEAR ASM	78	1	GG510L150	BELT, TIMING, L-TYPE
37	1	1392103	MAIN DRIVE SHAFT ASM	79	1*	HF-3	QUILTING MACHINE,STANDARD
38	1	1392161	COVER ASSM,SE	80	1	MM331	CLAMP, PULL LATCH
39	1	1392185	REAR CLOSURE ASSEMBLY	81	1	MM8130K152	RACEWAY,4 X 60
40	1	1392193	PLATFORM, OPERATOR, ASM	82	AR	Needle	SN794FR-180
41	1	1392196	TAKE-UP, LOOPER ASM	83	4*	SSHCM16X50	SCREW,HEX CAP
42	1	1392306	ROLLER LIFT ASSEMBLY				

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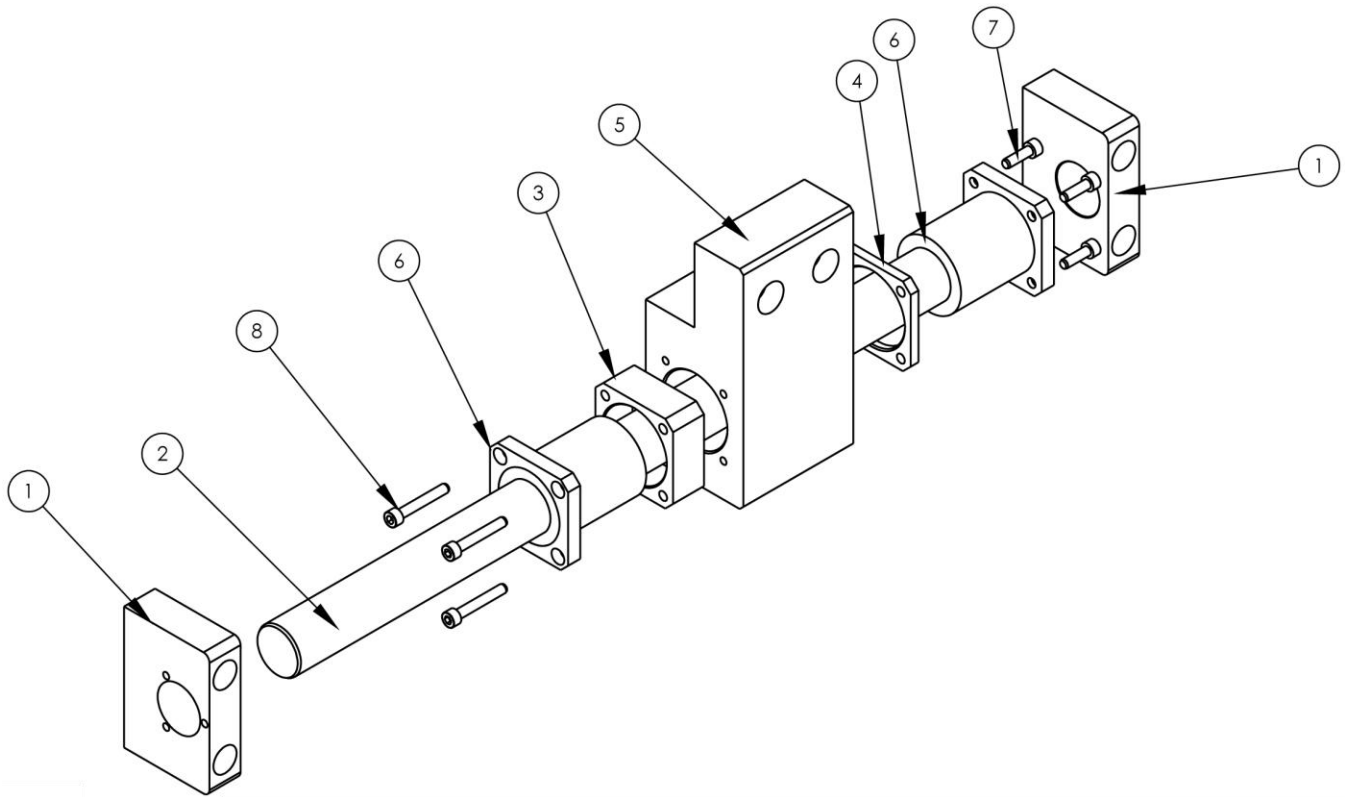


From the library of: Diamond Needle Corp

1388222 Linear slide, FT, 35MM

AAC Drawing Number 1388222 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	2	1388221	BRKT,SLIDE SUPPORT,35MM
2	1	1388223	SHAFT,SLIDE,35MM
3	1	1388224	SPACER, BEARING,35MMX1"
4	1	1388225	SPACER, BEARING,35MMX1/4"
5	1	4-001A	BLOCK,SLIDE,35MM SHAFT
6	2	BBSMK35GUU	BEARING,LIN,FLG,35MM
7	4	SSSCM6X20	SCREW, SOCKET CAP
8	4	SSSCM6X40	SCREW, SOCKET CAP, M6X40

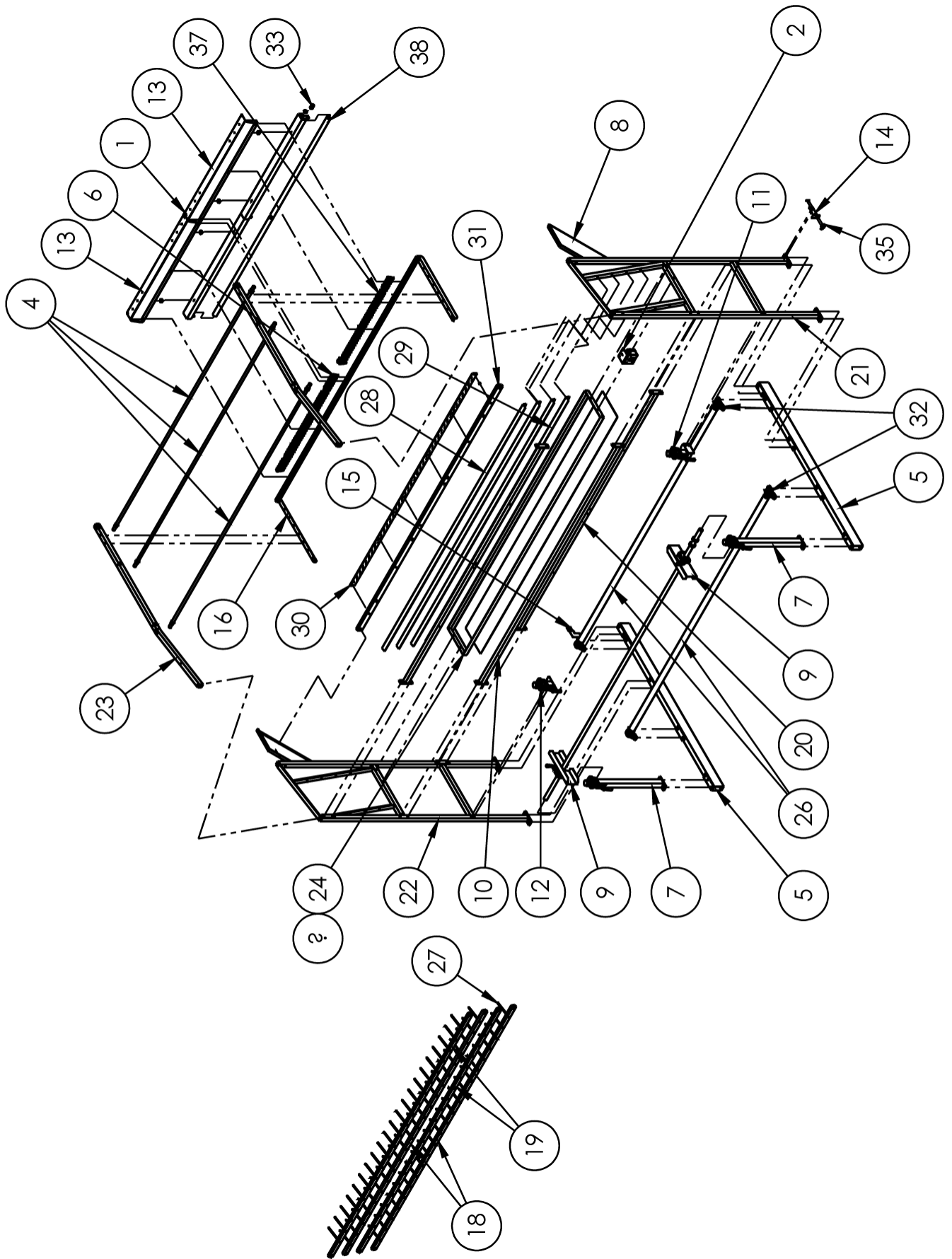


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1388227 Linear slide, RR, 35MM

AAC Drawing Number 1388227 Rev 1

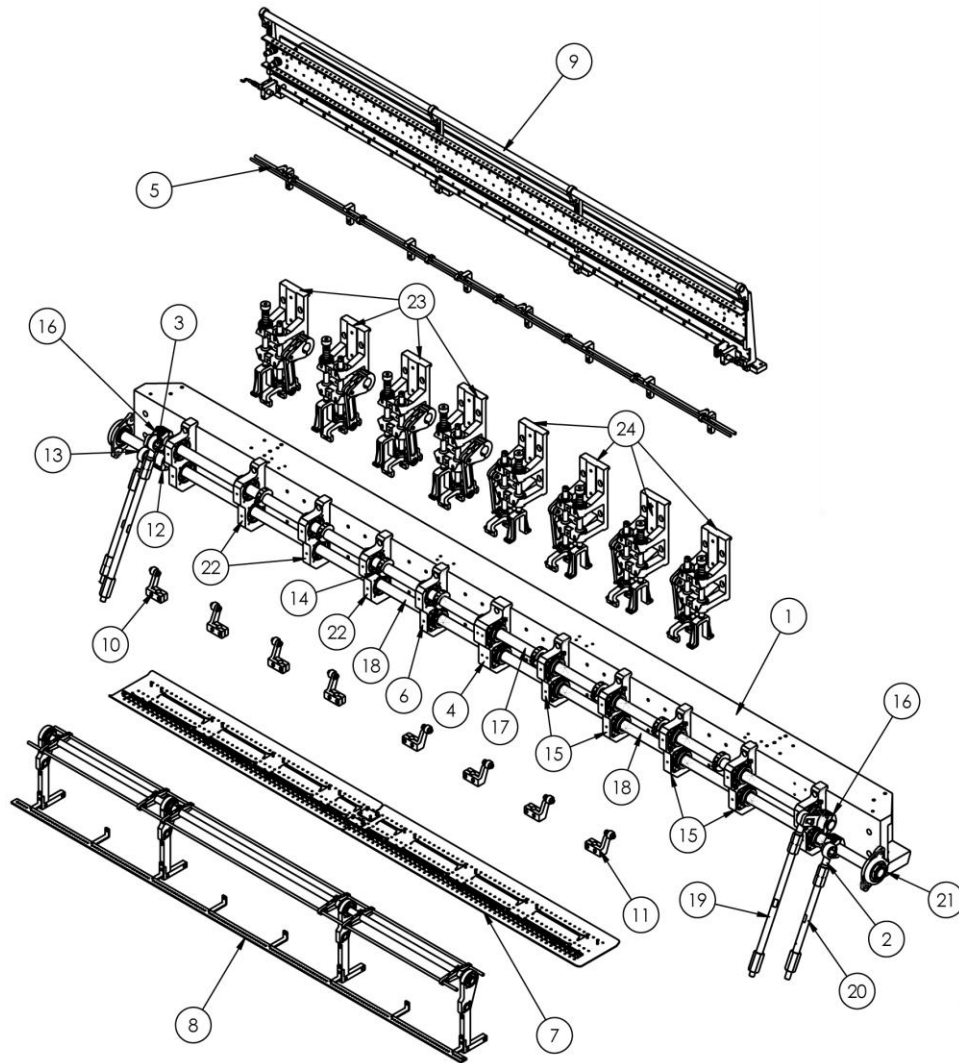
NO.	QTY	PART #	DESCRIPTION
1	2	1388221	BRKT,SLIDE SUPPORT,35MM
2	1	1388223	SHAFT,SLIDE,35MM
3	1	1388224	SPACER, BEARING,35MMX1"
4	1	1388225	SPACER, BEARING,35MMX1/4"
5	1	4-001A	BLOCK,SLIDE,35MM SHAFT
6	2	BBSMK35GUU	BEARING,LIN,FLG,35MM
7	4	SSSCM6X20	SCREW, SOCKET CAP
8	4	SSSCM6X40	SCREW, SOCKET CAP, M6X40



1389653 Thread Stand Frame Assembly

AAC Drawing Number 1389653 Rev 3

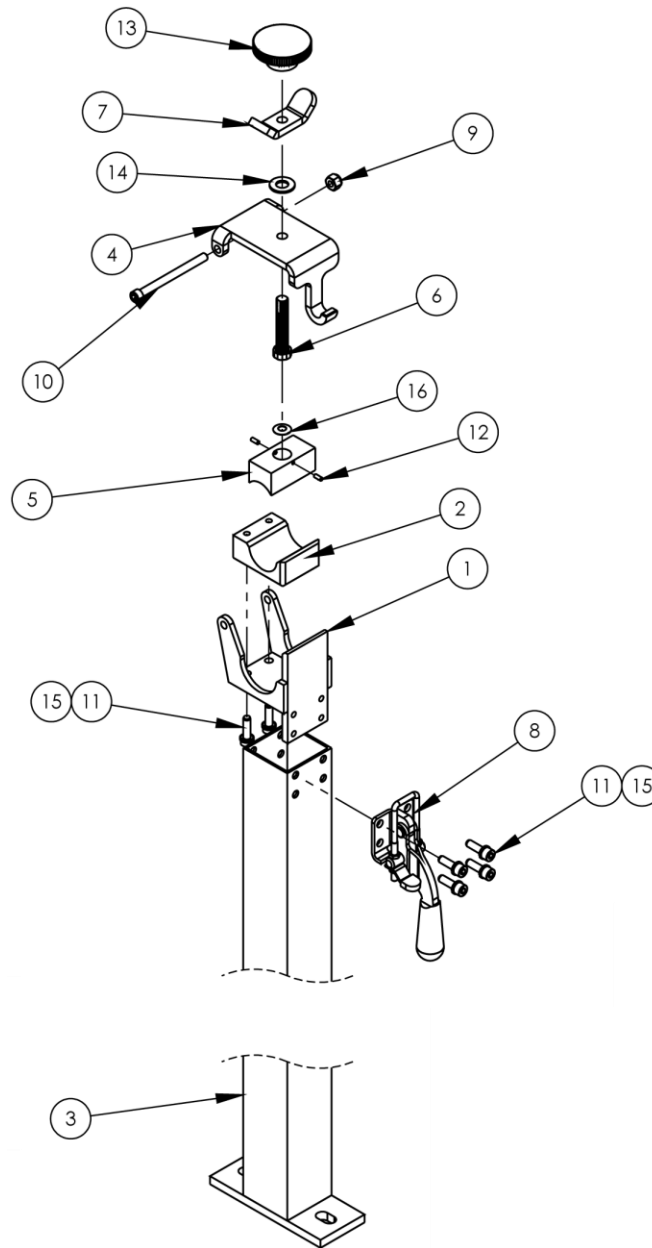
NO.	QTY	PART #	DESCRIPTION	
1	1	1389179	MTG PLATE	
2	1	1389398	REMOTE PAUSE,RESTART	
3	1	1392-002	CABLE,FLUORESCENT LIGHT	
4	3	1392283	GUIDE, THREAD ASM	
5	2	1392285	STAND, THREAD, FRAME	
6	79	1392308	SPACER, THREAD TENSION	
7	2	1392545	MAT. TENSION RACK ASSY	Page 66
8	2	1392637	BRACE, FRAME	
9	1	1392763	MATERIAL, ROD ASSEMBLY	Page 67
10	1	1392783	SUPPORT, WELDMENT	
11	1	1392972	TENSION CLAMP ASS, LH, SM	Page 68
12	1	1392973	TENSION CLAMP ASS, RH, SM	Page 69
13	2	1393810	MOUNT, LIGHT, FRONT	
14	1	1393937	BRKT,EYE MTG	
15	1	1393938	PLATE,REFLECTOR	
16	1	1393966	MOUNT, LIGHT	
17	1	1975-412A	PLATE,NUT,4-40,.95CTC	
18	2	5-001-12A	STAND, THREAD, FRAME	
19	2	5-001-13A	STAND, THREAD, FRAME	
20	2	5-001-14	SUPPORT, TOP THD STAND	
21	1	5-001-2-L	STAND, THREAD, FRAME ASM	
22	1	5-001-2-R	STAND, THREAD, FRAME ASM	
23	2	5-001-3B	STAND, THREAD, FRAME	
24	1	5-001-5	STAND, THREAD, FRAME, ASM	
25	1	5-001-5-3	SHELF,THREAD STAND	
26	2	5-001A	ROLLER, THREAD STAND	
27	86	5-022	SHAFT, THREAD STAND	
28	2	6-008	GUIDES, THREAD	
29	2	6-009	GUIDES, THREAD	
30	1	6-014A	EYELET BAR	
31	1	6-015A	TUBE, EYELET BAR MOUNTING	
32	4	BBNAP205-25	BEARING, PILLOWBLOCK	
33	1	FF3216	STRAIN RELIEF, LIQ TIGHT	
34	2	FFM1414	FIXTURE,LIGHT,4'	
35	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	
36	1	MM9600K36	GROMMET,RUBBER,9/16 ID	
37	79	SCT1392L	TENSION ASSY,1392 LOOPER	
38	2	ZZZMT-115	BULB,4' FLUORESCENT	



1389655 Bridge Assembly

AAC Drawing Number 1389655 Rev 1

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1-006C	TOP BRIDGE BEAM	13	2	1389705	PIN,PIVOT,NDL DRIVE LEVER
2	4	1-008	ROD END HOUSING	14	8	1389745	CAM, PRESSER FOOT DRIVE
3	2	1-009A	SHAFT, NEEDLE DRIVE ECC.	15	5	1393748	MOUNT,INSERT BRG, ASM, RH
4	1	1389023	MOUNT,INSERT BRG,ASM,CTR	16	2	1393867	P.FOOT SHAFT LEVER
5	1	1389073	ADJ NDL THD TAKEUP ASBLY	17	1	1393977	SHAFT, 40MM, PRESSER FOOT
6	1	1389246	MOUNT,INSERT BRG,LH,SPEC	18	2	1393978	40MM SHAFT, NEEDLE BAR
7	1	1389509	PRESSER FEET AND NDL BARS	19	2	1393983	TIE ROD ASSEMBLY,PFOOT
8	1	1389654	FRONT THD CONTROL ASSY	20	2	1393986	TIE-ROD ASSEMBLY,NDL
9	1	1389656	NEEDLE THREAD MOUNT ASM	21	2	1393987	BEARING,FLANGE,2BOLT
10	4	1389657	FOOT DRIVE ASBLY, LEFT	22	4	1393994	MOUNT,INSERT BRG,ASM, LH
11	4	1389658	FOOT DRIVE ASBLY, RIGHT	23	4	1393998	DRIVE,NDL & PS FT ASM RT
12	2	1389704	NDL SHAFT LEVER	24	4	1393999	DRIVE,NDL & PS FT ASM LT

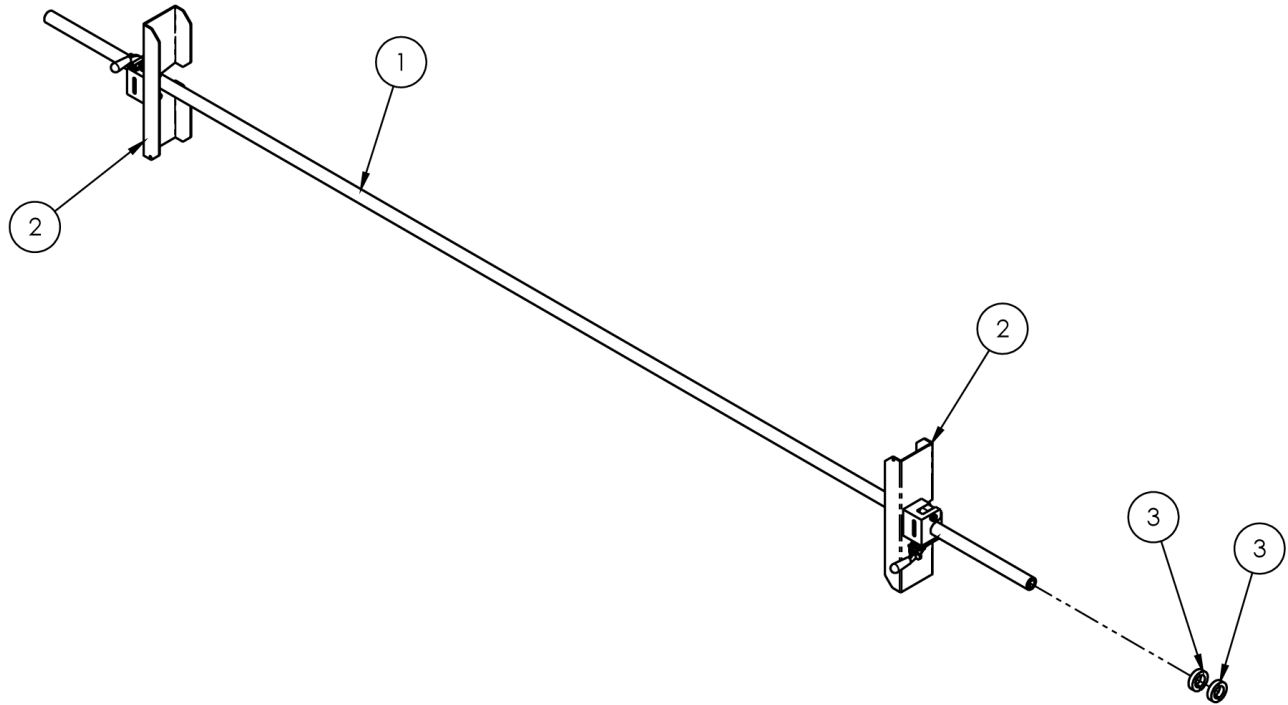


From the library of: Diamond Needle Corp

1392545 Mat. Tension Rack Assembly

AAC Drawing Number 1392545 Rev 7

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1389408	ROD SUPPORT/BRAKE ASSY	9	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
2	1	1389410	BLOCK,BRAKE,BOTTOM	10	1	SSSC01192	1/4-20 X 3 SOC CAP
3	1	1392453	LEG WELDMT,MATL RACK	11	6	SSSCM6X20	SCREW, SOCKET CAP
4	1	1392542	PLATE,CAP,FRICTION BRAKE,	12	2	SSSSM3X8	M3 SET SCREW, 8MM L
5	1	1392543	BLOCK,DELFIN,S	13	1	TTK32315	KNOB,1-7/8OD,3/8B,BLACK
6	1	1393802	3/8-24 X 2 HEX HEAD FULL THD	14	1	WWFS3/8	WASHER,FLAT,SAE,3/8
7	1	1393803	NUT, WING, 3/8-24	15	6	WWLM6	M6 LOCK WASHER
8	1	MM331	CLAMP, PULL LATCH	16	1	WWS307-1	WASHER,SPRING,BELVEL

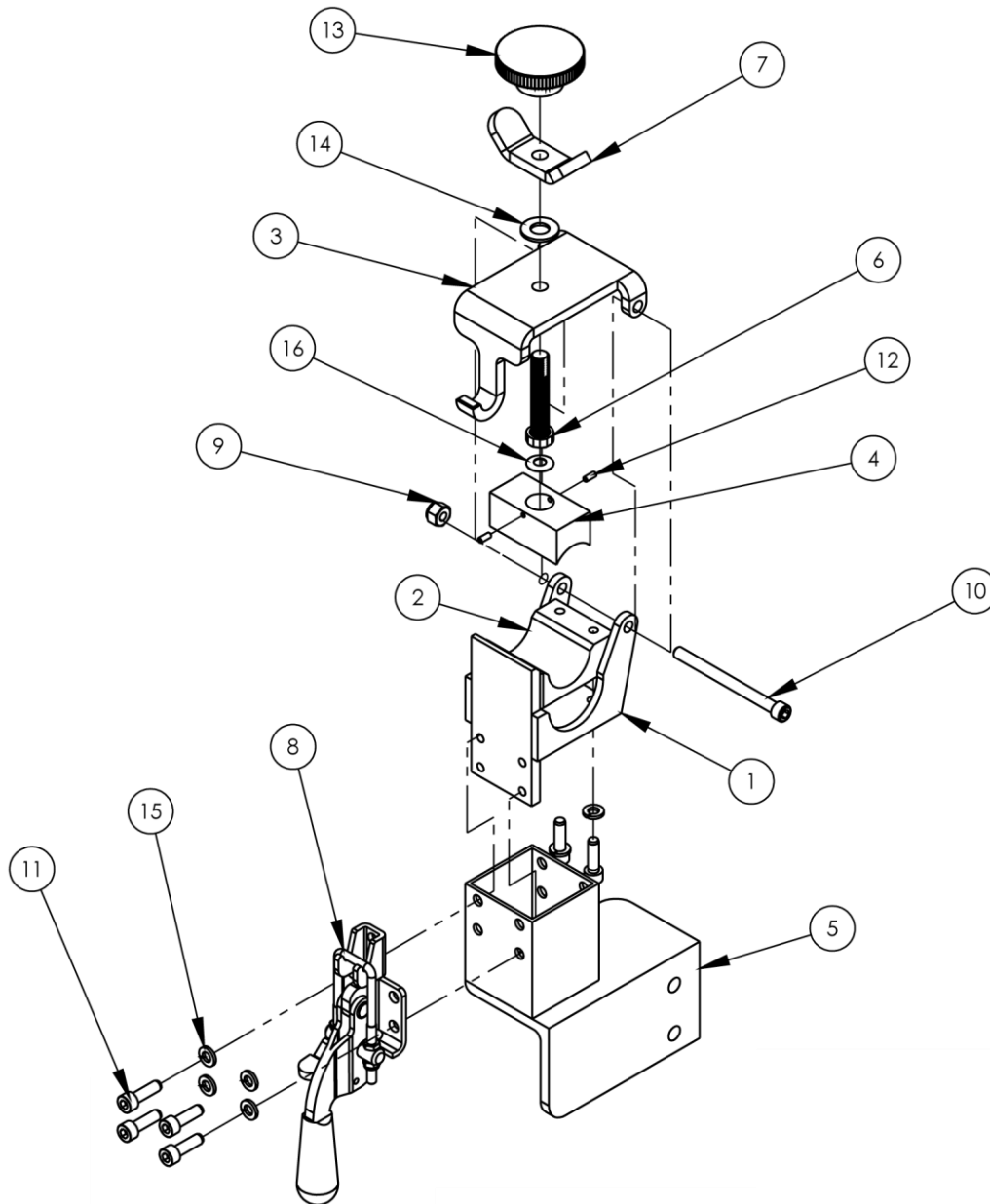


From the library of: Diamond Needle Corp

1392763 Material Rod Assembly

AAC Drawing Number 1392763 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	1392539	RODS, MATERIAL
2	2	1393904	CLAMP, ROLL
3	2	1392048	COLLAR, 32MM

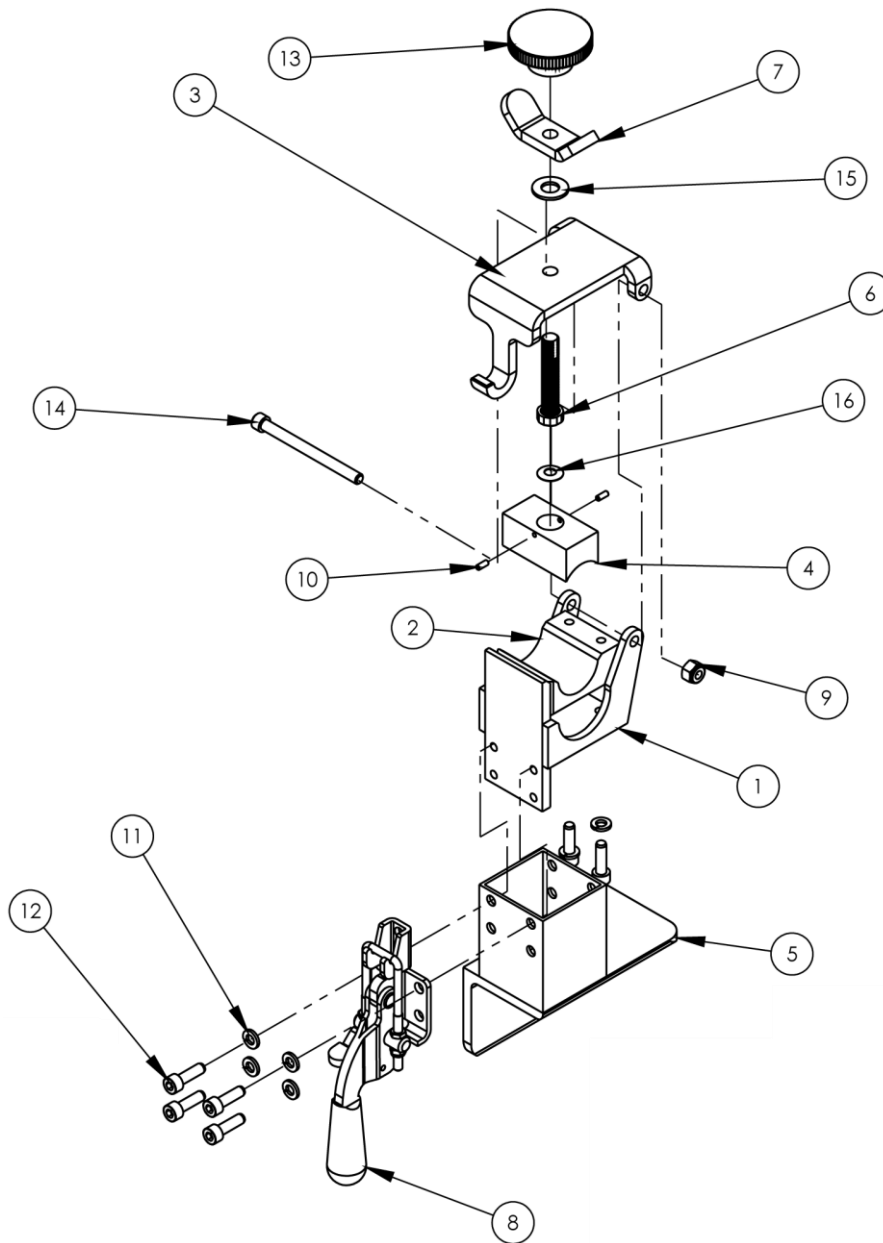


From the library of: Diamond Needle Corp

1392972 Tension Clamp Assembly, LH, SM

AAC Drawing Number 1392972 Rev 8

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1389408	ROD SUPPORT/BRAKE ASSY	9	1	NEE1/4-20	NUT,ELASTIC LOCK,1/4-20
2	1	1389410	BLOCK,BRAKE,BOTTOM	10	1	SSSC01192	1/4-20 X 3 SOC CAP
3	1	1392542	PLATE,CAP,FRICTION BRAKE,	11	6	SSSCM6X20	SCREW, SOCKET CAP
4	1	1392543	BLOCK,DELFIN,S	12	2	SSSSM3X8	M3 SET SCREW, 8MM L
5	1	1392964	MATERIAL BRKT	13	1	TTK32315	KNOB,1-7/8OD,3/8B,BLACK
6	1	1393802	3/8-24 X 2 HEX HEAD FULL THD	14	1	WWFS3/8	WASHER,FLAT,SAE,3/8
7	1	1393803	NUT, WING, 3/8-24	15	6	WWLM6	M6 LOCK WASHER
8	1	MM331	CLAMP, PULL LATCH	16	1	WWS307-1	WASHER,SPRING,BELVEL

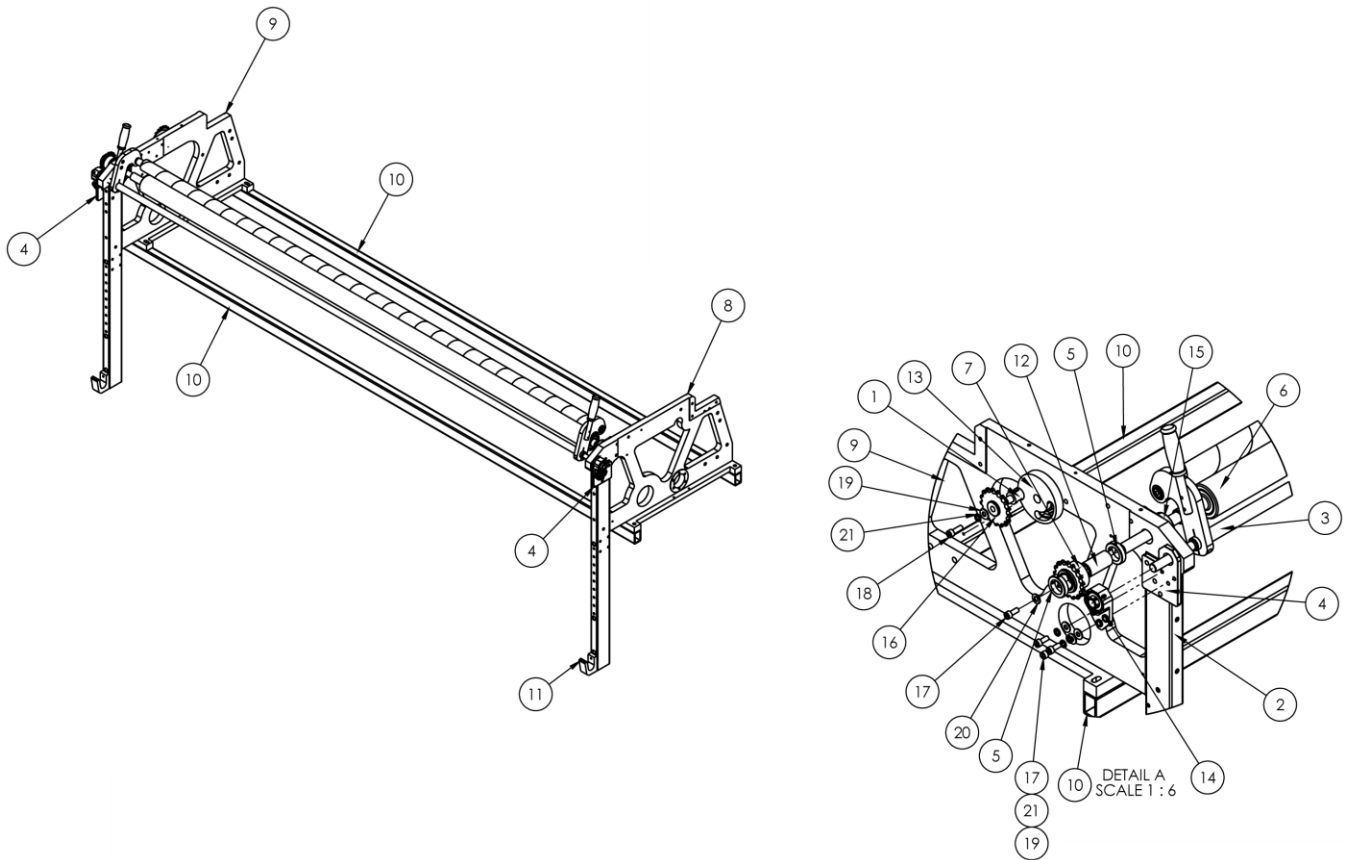


From the library of: Diamond Needle Corp

1392973 Tension Clamp Assembly, RH, SM

AAC Drawing Number 1392973 Rev 8

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1389408	ROD SUPPORT/BRAKE ASSY	9	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
2	1	1389410	BLOCK,BRAKE,BOTTOM	10	2	SSSSM3X8	M3 SET SCREW, 8MM L
3	1	1392542	PLATE,CAP,FRICTION BRAKE,	11	6	WWLM6	M6 LOCK WASHER
4	1	1392543	BLOCK,DELFIN,S	12	6	SSSCM6X20	SCREW, SOCKET CAP
5	1	1392966	MATERIAL BRKT	13	1	TTK32315	KNOB,1-7/8OD,3/8B,BLACK
6	1	1393802	3/8-24 X 2 HEX HEAD FULL THD	14	1	SSSC01192	1/4-20 X 3 SOC CAP
7	1	1393803	NUT, WING, 3/8-24	15	1	WWFS3/8	WASHER,FLAT,SAE,3/8
8	1	MM331	CLAMP, PULL LATCH	16	1	WWS307-1	WASHER,SPRING,BELVEL



From the library of: Diamond Needle Corp

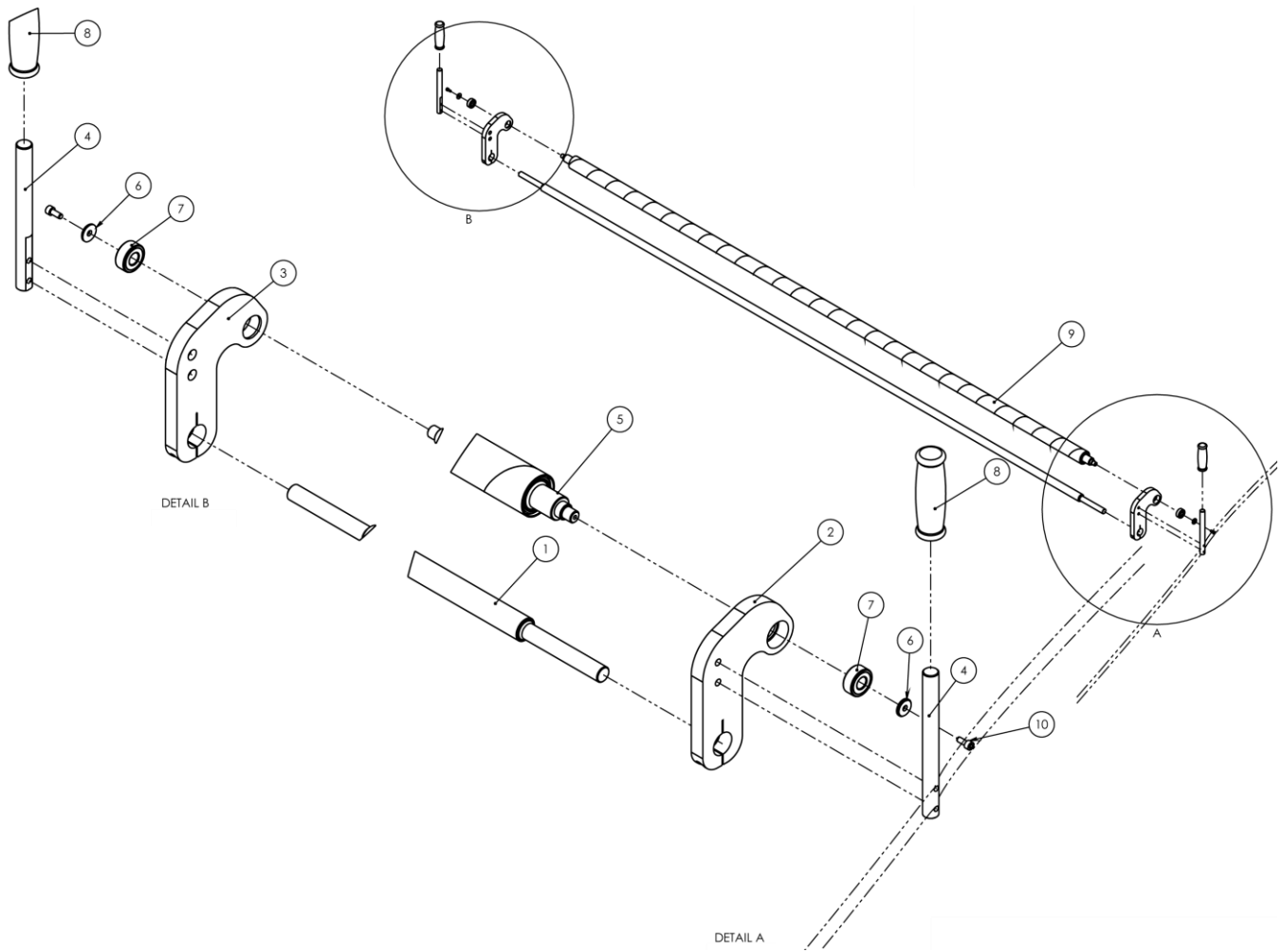
1389742 Main Carriage

AAC Drawing Number 1389742 Rev 3

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1389744	SHAFT,TENSIONER,SPROCKET	12	1	4-039	ADAPTER, CLUTCH BEARING
2	2	1392149	ATTACHMENT BRACKET, AAC	13	1	6-007	TENSIONER BASE
3	1	1392255	ROLLER, WEIGHTED, ASM	14	2	BB127570	BEARING,20MM,3 BOLT FLANG
4	2	1392268	BASE PLATE, BEARING MOUNT	15	2	BBUCFL205	BEARING, FLANGE UCFL
5	2	1392278	COLLAR, CLUTCH BEARING	16	1	MM50BB17	SPROCKET,17T,5/8P
6	1	1392816	ROLLER, INPUT,MODIFIED	17	7	SSSCM10X25	10M X 25MM, SOC CAP
7	1	1392865	DRIVE SPROCKET ASBLY,LH	18	1	SSSCM10X30	10M X 30MM, SOC CAP
8	1	2-017	FRAME, CARRIAGE, RIGHT	19	7	WWFM10	WASHER, FLAT, M10 I.D.
9	1	2-018A	FRAME, CARRAGE, LEFT	20	1	WWFS7/16	7/16 FW
10	2	2-031	BRACE,MAIN CARRIAGE,1392	21	7	WWLM10	M10 LOCK WASHER
11	2	2-059	BLOCK, ROLL HOLDER				

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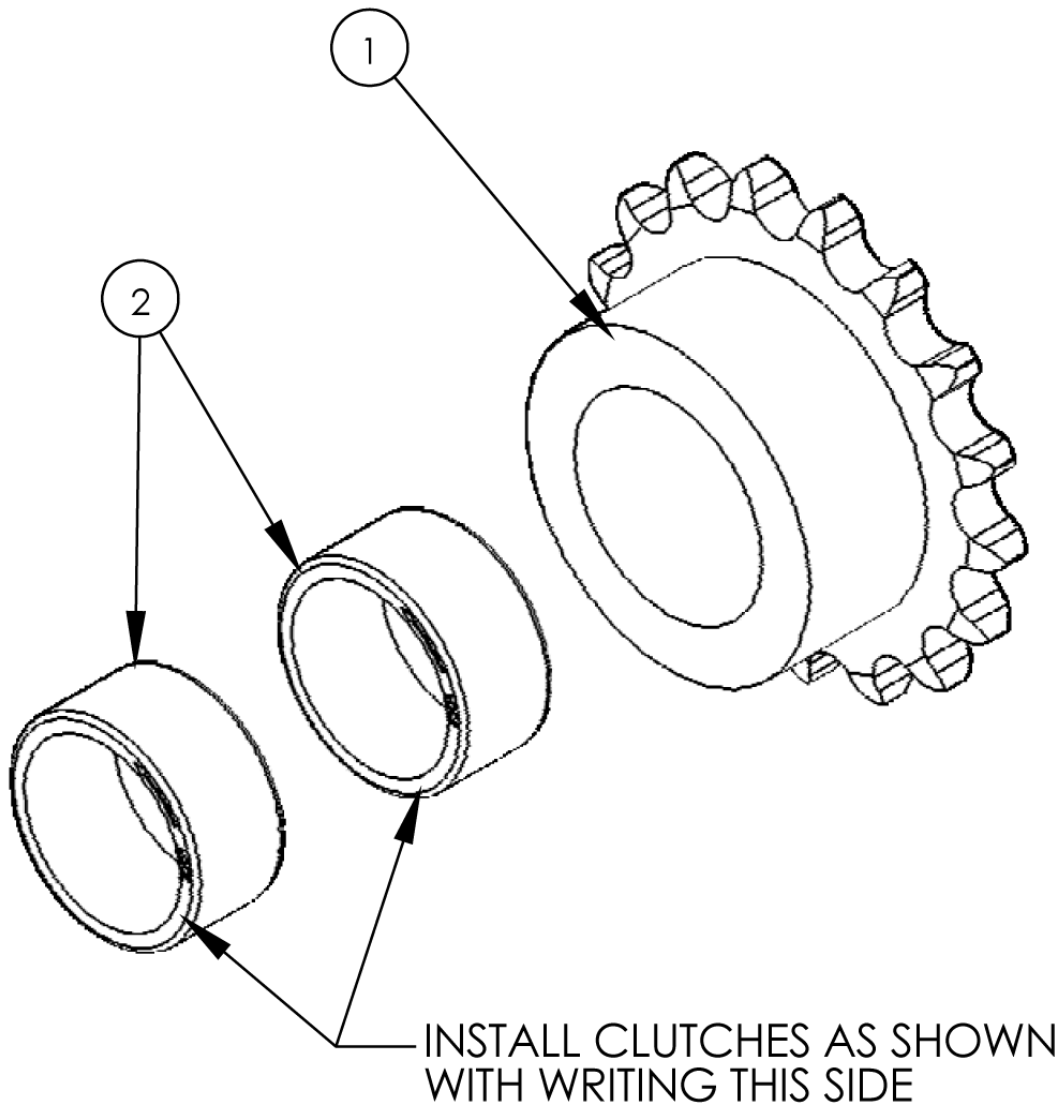


From the library of: Diamond Needle Corp

1392255 Weighted Roller Assembly

AAC Drawing Number 1392255 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1392253	SHAFT ASSY
2	1	1392254	ARM,WEIGHTED ROLL
3	1	1392256	ARM,WEIGHTED ROLL
4	2	1392257	HANDLE, ROLLER
5	1	1392272	SHAFT ASSY
6	2	5-034	END CAP, SHAFT
7	2	BB22022RS	BEARING, BALL, 15ID, 35OD
8	2	MMGP-105	GRIP HANDLE-FOAM 3/4 ID
9	227	MMV400PS	4.0" VELCRO TAPE BLACK
10	2	SSSCM6X15	M6X15 SOC CAP SCREW

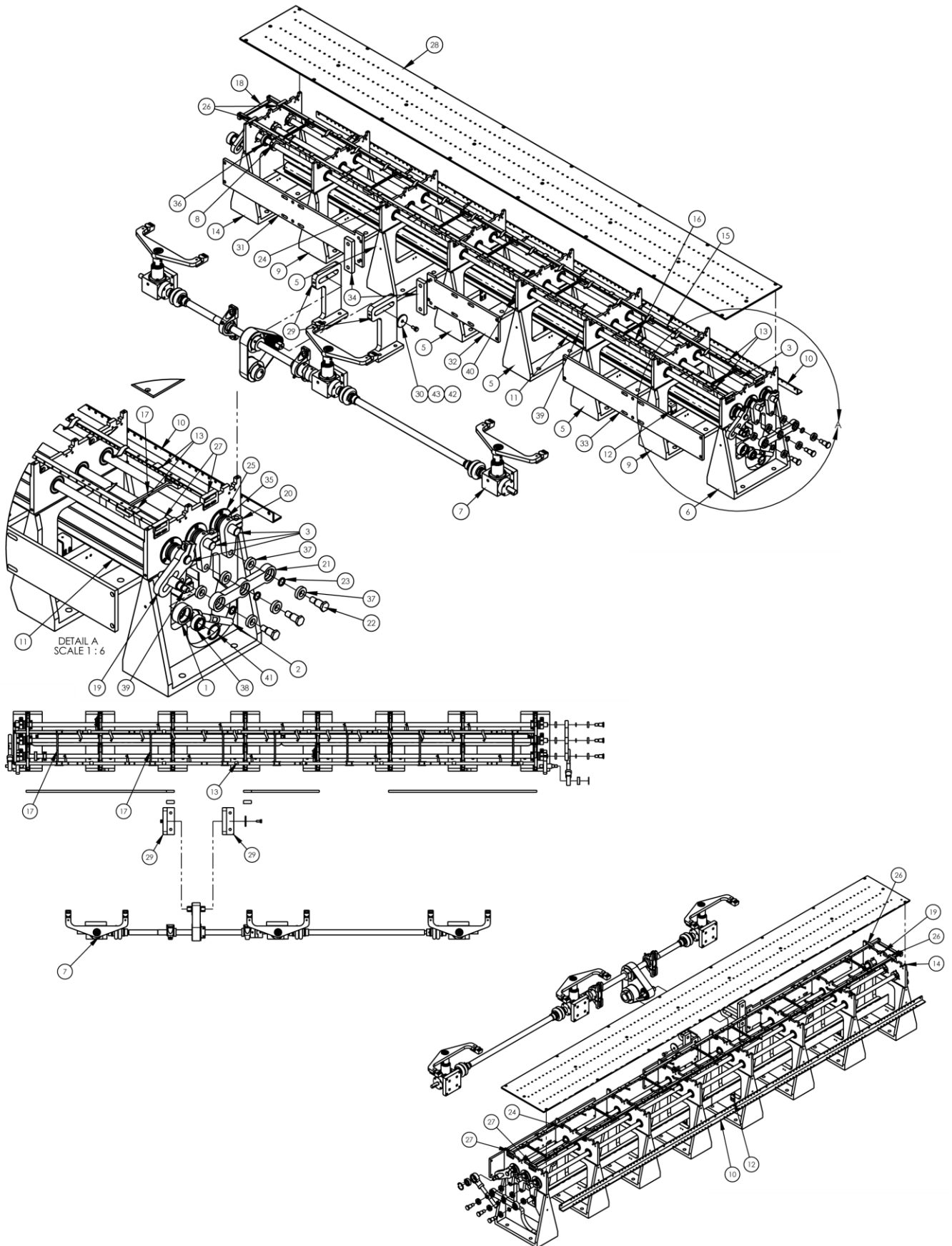


From the library of: Diamond Needle Corp

1392865 Drive Sprocket Assembly, LH

AAC Drawing Number 1392865 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1392842	SPROCKET ASSEMBLY
2	2	BBHF3520	ROLLER CLUTCH, 35MMX42MMX20MM

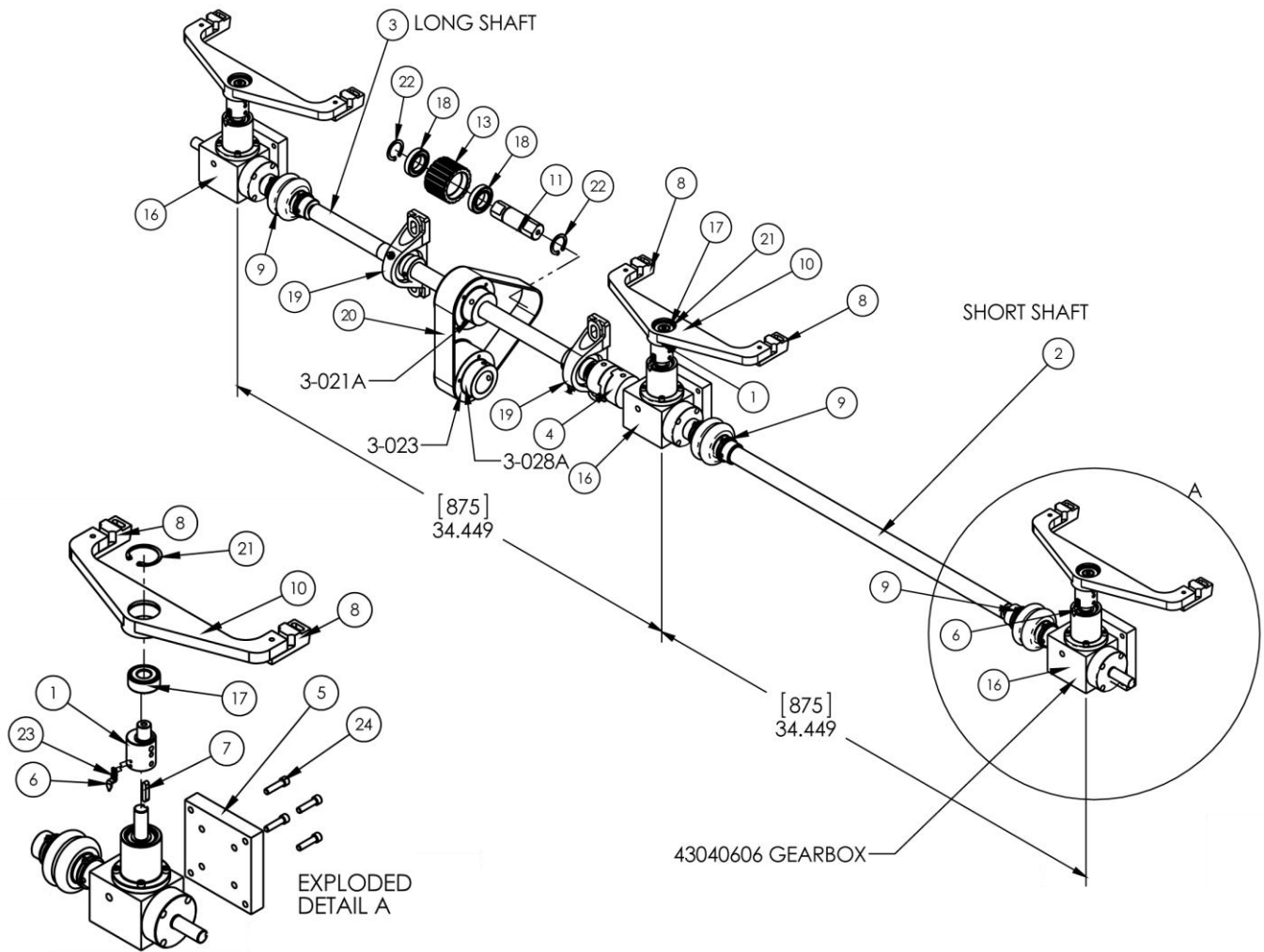


1389748 Throat Plate Assembly

AAC Drawing Number 1389748 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	2	1-017	ROD END, PRESSER FOOT
2	2	1-028	LOOPER DRIVE PITMAN ROD
3	3	1-029	SHAFT, LOOPER, 20MM
4	2	1-037	LOOPER DRIVE LINK, 83 MM
5	4	1388704	SUPPORT, THROAT PLATE
6	1	1389240	SUPPORT, THROAT PLATE, SPE
7	1	1389495	RETAINER DRIVE ASBLY
8	6	1389524	CLAMP COLLAR, M20, W/SHLDR
9	2	1389893	SUPPORT, THROAT PLATE, SPE
10	1	1392170	GUIDE, LOOPER THREAD ASM
11	2	1392576	REFLECTOR, GOLDEN EAGLE
12	4	1392748	BRACKET, LIGHT
13	14	1392810	GIB, RETAINER BAR, FRONT
14	1	2-001A	SUPPORT, THROAT PLATE
15	1	2-003	BAR, RETAINER MTG, REAR
16	1	2-004	BAR, RETAINER MTG, FRONT
17	7	2-007	LINK, RETAINER, SINGLE
18	1	2-008	LINK, END, RETAINER BAR
19	2	2-024	ROCKER, LOOPER DRIVE
20	6	2-026	CRANK, LOOPER
21	2	2-027	LINK, LOOPER CRANK
22	6	2-028	PIN, THREADED, LOOPER CRANK
23	6	2-029	SPACER, RING, 15MM ID, 2MMTK
24	12	2-037	PAD, WEAR, RETAINER
25	6	2-054A	COVER, BEARING, LOOPER
26	2	2-066	SLEEVE, RETAINER, LEFT
27	2	2-066-3	SLEEVE, RETAINER, RIGHT
28	1	2-19A	NEEDLE PLATE
29	2	3-025	BRACKET, PULLEY, RETAINER
30	2	3-026	WASHER, PULLEY
31	1	3-033	PLATE, GEARBOX MOUNT
32	1	3-034	PLATE, GEARBOX MOUNT
33	1	3-035	PLATE, GEARBOX MOUNT
34	2	3-036	BLOCK, BEARING
35	6	BB51204J	THRUST BEARING
36	24	BB60042RS	BEARING, BALL, 20 ID, 42 OD
37	12	BB61902	BEARING, BALL, 15MM BORE
38	2	BB62022RS	BEARING, RADIAL, SEALED
39	2	HLES46BCCW	FLOURESCENT FIXTURE 48"
40	1	HLSDCHL	CONNECTOR FOR HLES46BCCW
41	2	MMH0137	SNAP RING, INTERNAL
42	2	SSHCM8X20	SCREW, HEX CAP
43	2	WWLM8	M8 LOCK WASHER

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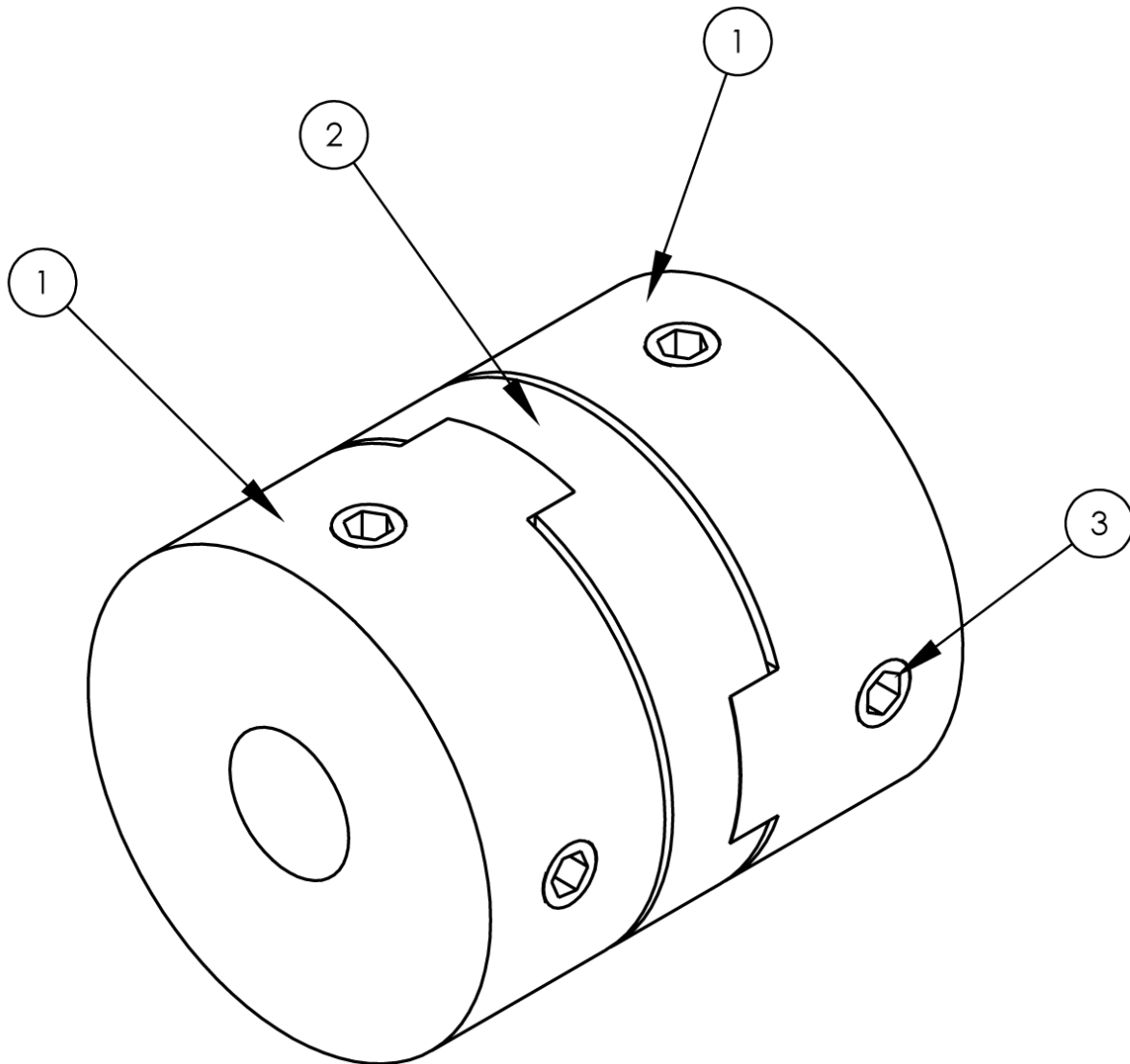
1389495 Retainer Drive Assembly

AAC Drawing Number 1389495 Rev 4

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	3	1-093	ECCENTRIC, RETAINER DRIVE	13	1	3-022	PULLEY, GEAR, 40MM WIDE
2	1	1389381	SHAFT, SPREADER DRIVE, RT	14	4	3-023	PLATE, SIDE, PULLEY
3	1	1389382	SHAFT, SPREADR DRIVE, LEFT	15	1	3-028A	PULLEY, GEAR, 40MM WIDE
4	1	1389383	COUPLING, OFFSET, OLDHAM	16	3	43040606	GEARBOX, SPIRAL BEVEL
5	3	1389488	MOUNT, GEARBOX, RETAINER	17	3	BB22022RS	BEARING, BALL, 15ID, 35OD
6	3	1389711	POINTER, RETAINER	18	2	BB69052RS	BEARING, RADIAL, SEALED
7	3	1389713	5MM X 5MM X 25MM KEY	19	2	BBNAP205-25	BEARING, PILLOWBLOCK
8	6	1392641	BLOCK, RETAINER BOOMERANG	20	1	GG240L150	BELT, GEAR, 3/8P, 1-1/2W
9	3	1392991	U-JOINT, RETAINER, ASM	21	3	MM98409A233	E-RING, INT, 1-3/8 X .051
10	3	1393976	BOOMERANG, RETAINER	22	2	MM98541A440	RETAINING RING, 25MM EXT
11	1	3-020	SHAFT, TAKE-UP, PULLEY	23	6	SSPSM3X4	SCREW, PAN HD SLOTTED
12	1	3-021A	PULLEY, GEAR, 40MM WIDE	24	12	SSSC05064	1/4-28 X 7/8

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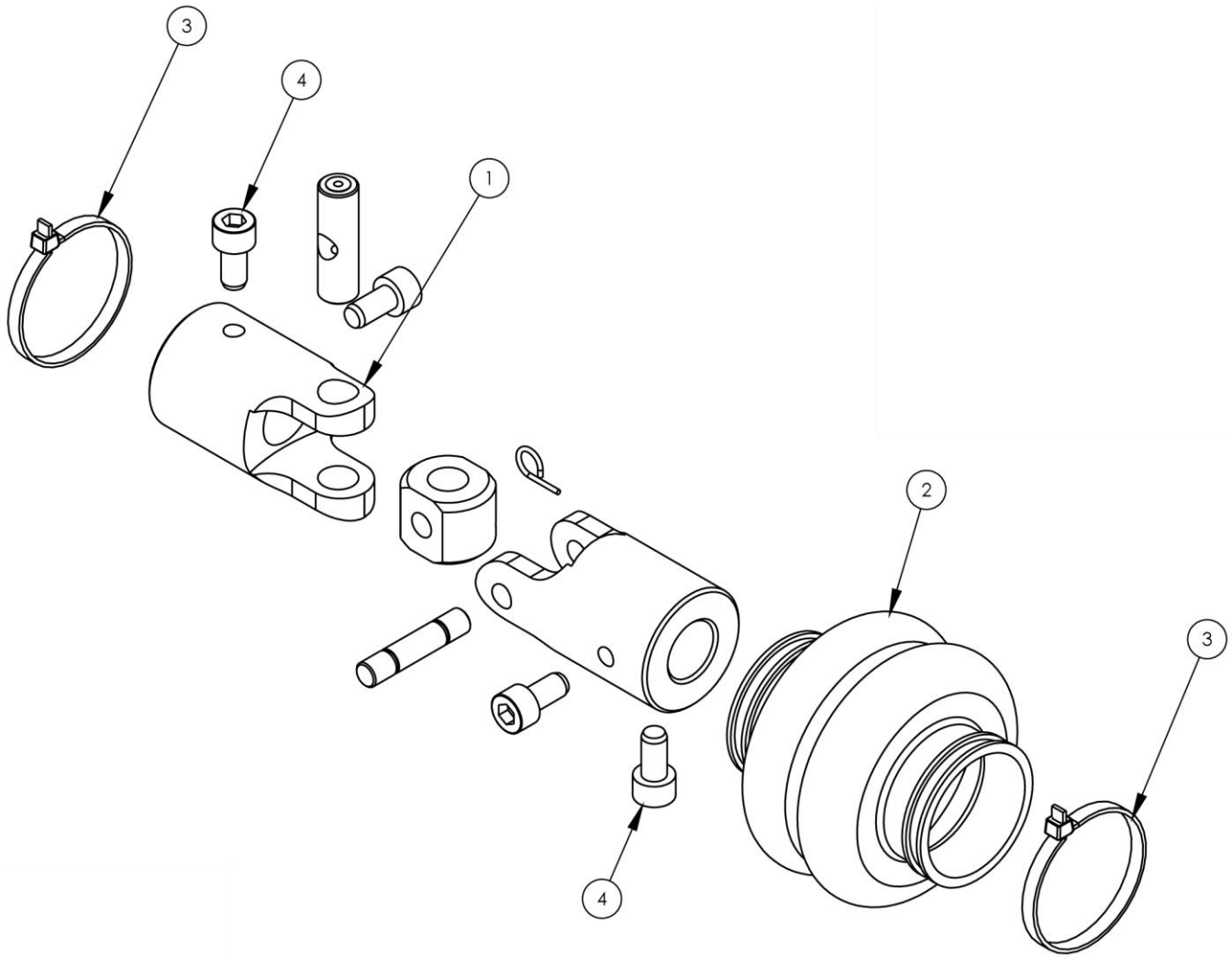


From the library of: Diamond Needle Corp

1389383 Oldham Offset Coupling

AAC Drawing Number 1389383 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	2	1389402	COUPLING HALF
2	1	1389403	SPIDER FOR COUPLING
3	4	SSSSM8X10	M8X10 SOC SET SCRW

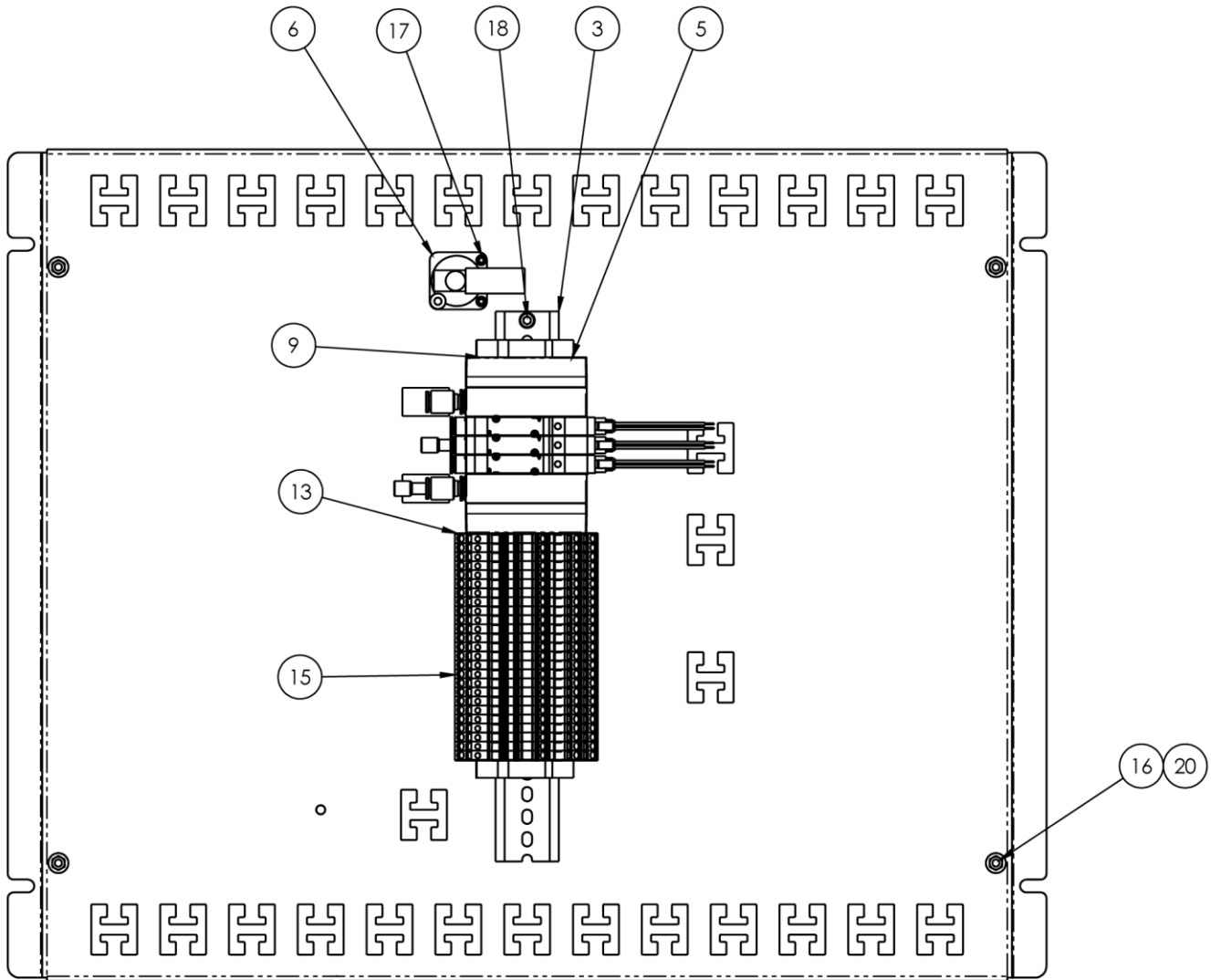


From the library of: Diamond Needle Corp

1392991 U-Joint, Retainer Assembly

AAC Drawing Number 1392991 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1392990	U-JOINT MOD
2	1	UJCJ6489K	BOOT, UNIVERSAL JOINT
3	2	EE6X750	TIE WRAP - Small.
4	4	SSSCM6X12	M6X12 SOC CAP SCREW

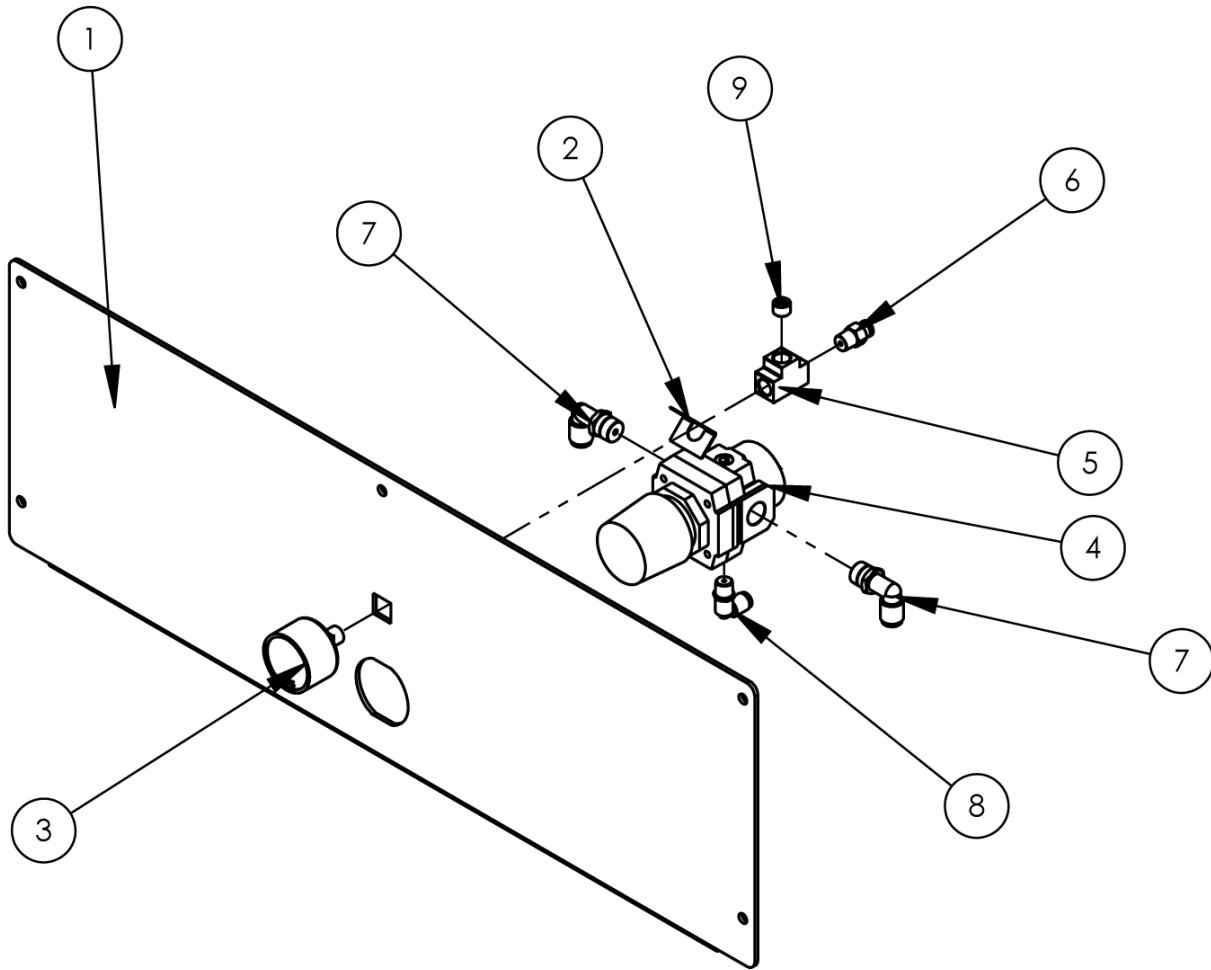


From the library of: Diamond Needle Corp

1389760 Remote Electric Panel

AAC Drawing Number 1389760 Rev 4

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1392506	PANEL, BACK, ELECTRICAL	11	*AR	FF209-503	TERMBLK, WAGO (11-20)
2	1	1392507	COVER, PANEL	12	*AR	FF209-504	TERMBLK, WAGO (21-30)
3	1	1392508	DIN RAIL, 35MM, 12" LONG	13	2	FF280-319	TERMBLK, WAGO, SENSOR, DIN
4	*1	1392689	CABLE ASSY, F, QUILTER I/O	14	*45	FF280-402	JUMPERS
5	1	AAE1392-3	3 SOLENOID ASSEMBLY	15	25	FF280-560	TERMBLK, WAGO, SENSOR, DIN
6	1	AAVF51FM1B	AIR/ELEC PRESSURE SW	16	4	NNHM4X0.7	M4 X 0.7 HEX NUT
7	*AR	EE6X753	CABLE TIE	17	2	SSSCM3X10	M3-0.5 X 10 SOC CAP
8	*2	EE8442	CABLE, 2 COND, 22 AWG	18	2	SSSCM5X10	M5-0.8 X 10 SOC CAP
9	2	EECLIPFIX	ANCHOR, DIN RAIL	19	*2	TTAA5267	TERMINAL, FE, FUL INS, 18-22AWG
10	*AR	FF209-502	TERMBLK, WAGO (1-10)	20	4	WWF8	WASHER, FLAT #8

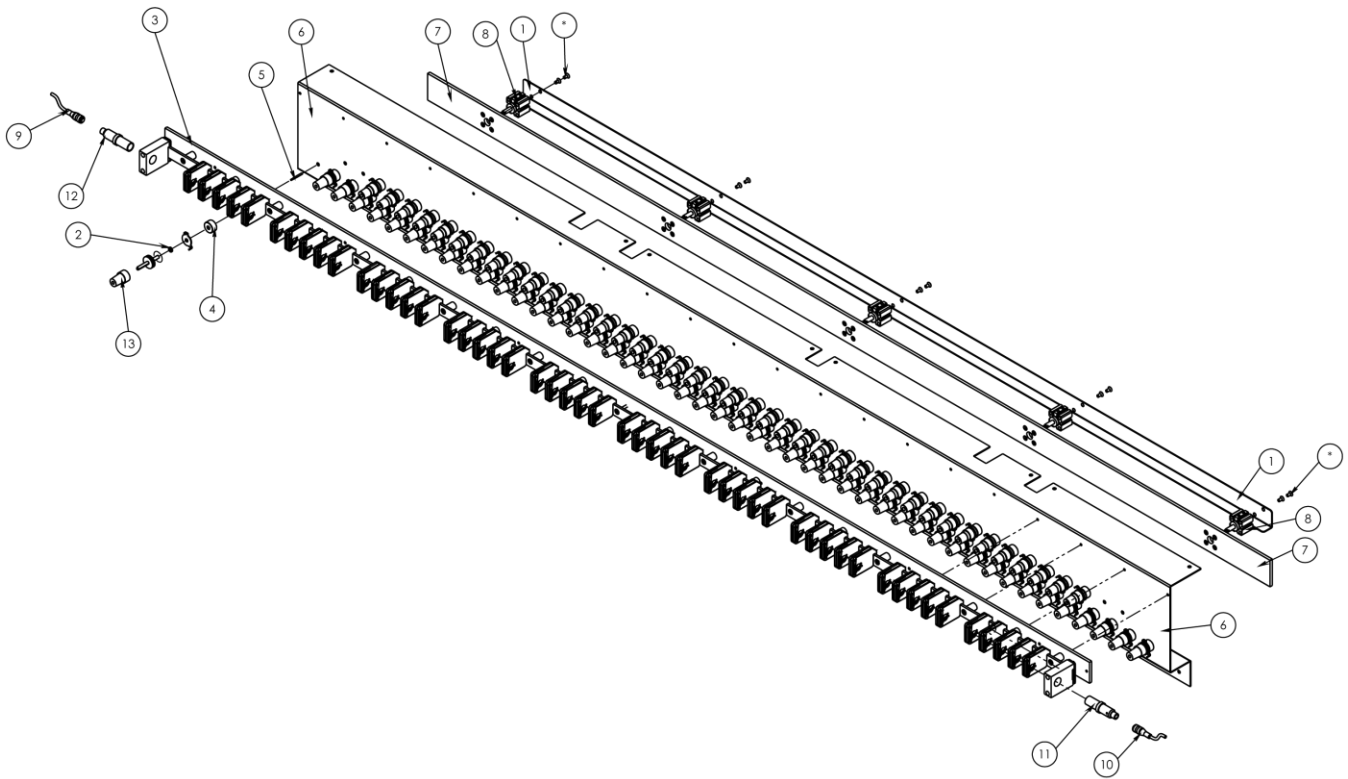


From the library of: Diamond Needle Corp

1389762 Regulator Assembly

AAC Drawing Number 1389762 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1389710	PLATE,REG MTG,1392
2	1	31103701	BRKT,PRESSURE GAUGE
3	1	AA198-5032	0-60PSI AIR GAGE 1/8NPT
4	1	AA198-RP3	REGULATOR,PRECISION AIR
5	1	AAF10289	T-FITTING 1/4" NPT
6	1	AAQMC-5-8	QU. MALE CONN 5/32X1/8
7	2	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT
8	1	AAQME-5-8	QUICK MALE ELBOW
9	1	MM4554K11	PLUG, 1/8" PIPE

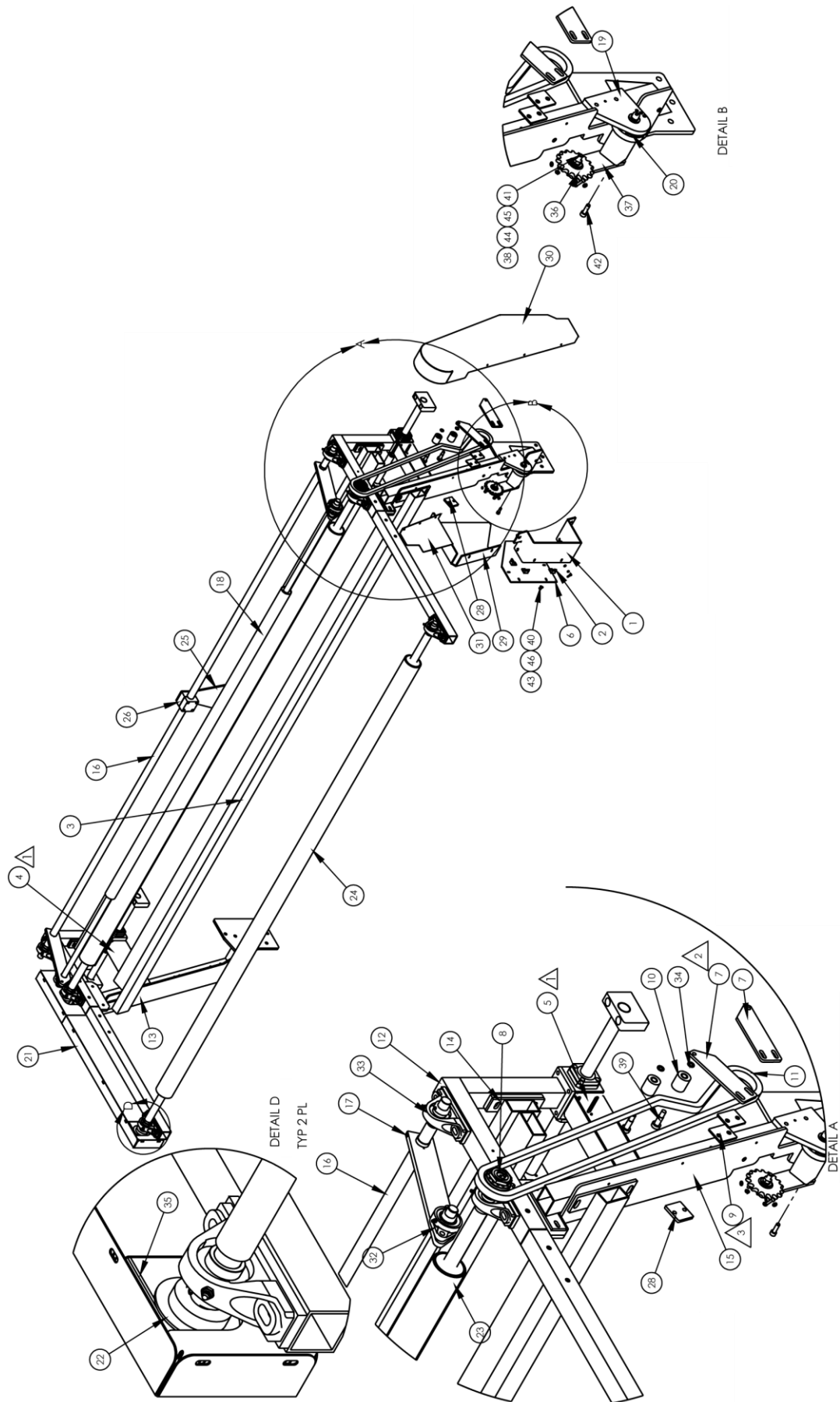


From the library of: Diamond Needle Corp

1389764 Rear Thread Tension Assembly

AAC Drawing Number 1389764 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	1389455	PLATE, TENSION RELEASE
2	87	1389915	WASHER, THREAD TENS. OPEN
3	1	1392118	THREAD BREAK DETECTOR ASM
4	87	1392126	SPACER, THREAD TENSION
5	87	1392988	PIN, TENSION OPENER, SHORT
6	1	5-047C-M	MOUNT, MOD. REAR THRD GD
7	1	5-059	PLATE, TENSION RELEASE
8	5	AACSDA20X10B	COMPACT, CYLINDER, 20MM BOR
9	1	FFRK44T-4	CABLE, EYE, 12', NO END

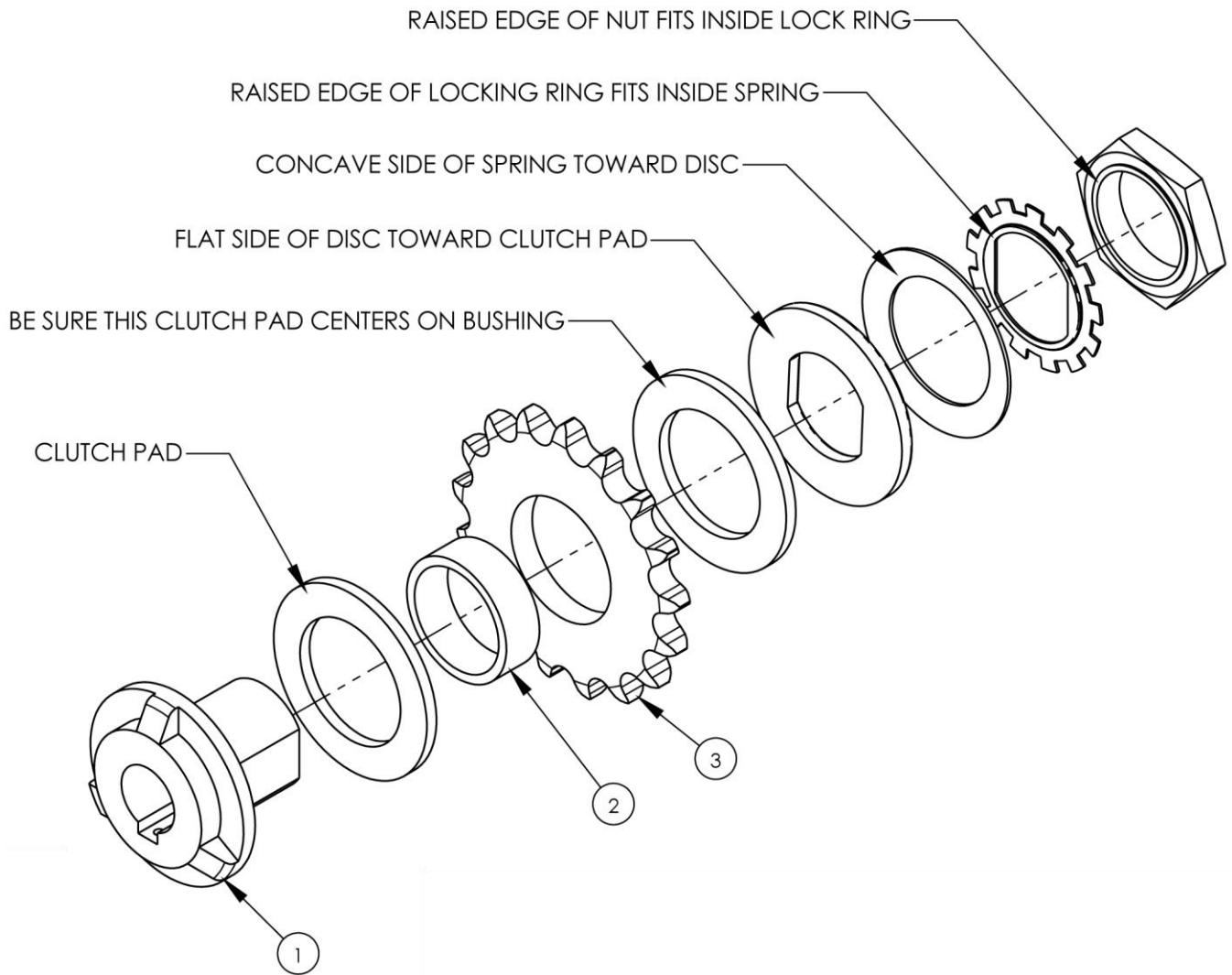


1392028 Transfer Carriage Assembly

AAC Drawing Number 1392028 Rev 11

NO.	QTY	PART #	DESCRIPTION
1	1	1389047	GUARD,BELT,BOTTOM
2	4	1389053	CLIP, GUARD MTG
3	1	1389447	BRACE WELDMENT,CARRIAGE
4	1	1389502	BRACE,RH
5	1	1389503	BRACE,LH
6	1	1389523	GUARD,BELT,BOTTOM
7	2	1389574	BAR,CHAIN TENSIONER
8	1	1389575	TORQUE LIMIT ASSY,50A17
9	2	1389586	PLATE,WASHER
10	2	1389599	ROLLER,CHAIN TENSIONER
11	1	1389603	CHAIN,#50 X 83.125"
12	2	1392015	TRANSFER CARRIAGE RAIL
13	1	1392020	STRUT WELDMENT,RH
14	1	1392026	BRACE WELDMENT
15	1	1392027	STRUT WELDMENT,LH
16	1	1392034	SHAFT ASSY
17	2	1392035	ARM,WEIGHTED ROLL
18	1	1392114	ROLLER,50 X 2900
19	1	1392146	PLATE,TENSIONER MTG
20	2	1392147	SHIM,TENSIONER
21	1	1392230	GUARD ASSEMBLY
22	2	1392262	PULLEY 3/8P, 24T, 22MM B
23	1	1392343	WELDMENT,FWD CARRIAGE ROL
24	1	1392344	WELDMENT,AFT CARRIAGE ROL
25	1	1392533	PLATE,BRACE MTG
26	1	1392534	BLOCK, STABILIZER
27	1	1392672	KEY,7MMX8MMX.96 IN
28	1	1393467	PLATE,NUT,M8
29	1	1393660	GUARD,BELT,INSIDE
30	1	1393887	BELT GUARD
31	1	1393962	BELT GUARD
32	2	BBNANFL205-25	BEARING,2-BOLT FLG,25MM
33	6	BBNAP205-25	BEARING, PILLOWBLOCK
34	2	BBTT604	BEARING,BRONZE,.385ID
35	1	GG767L050	BELT, GEAR, 3/8P,1/2W,76.7L
36	1	MM50X17BB	SPROCKET,BALL BEARING
37	1	MMSE27	TENSIONER,DRIVE
38	1	NNHM10X1.5	NUT,HEX,M10X1.5
39	2	SSAS12X25X10	SHOULDER BOLT M10-1.5x12
40	2	SSSCM10X50	CAP SCREW 10MM X 50MM
41	1	SSSCM8X25	SCREW,SOC CAP,M8X25
42	12	WWFM5	WASHER, FLAT, M5 I.D.
43	3	WWFS1/2	WASHER,FLAT,SAE,1/2
44	2	WWLM10	M10 LOCK WASHER
45	11	WWLM5	M5 LOCK WASHER

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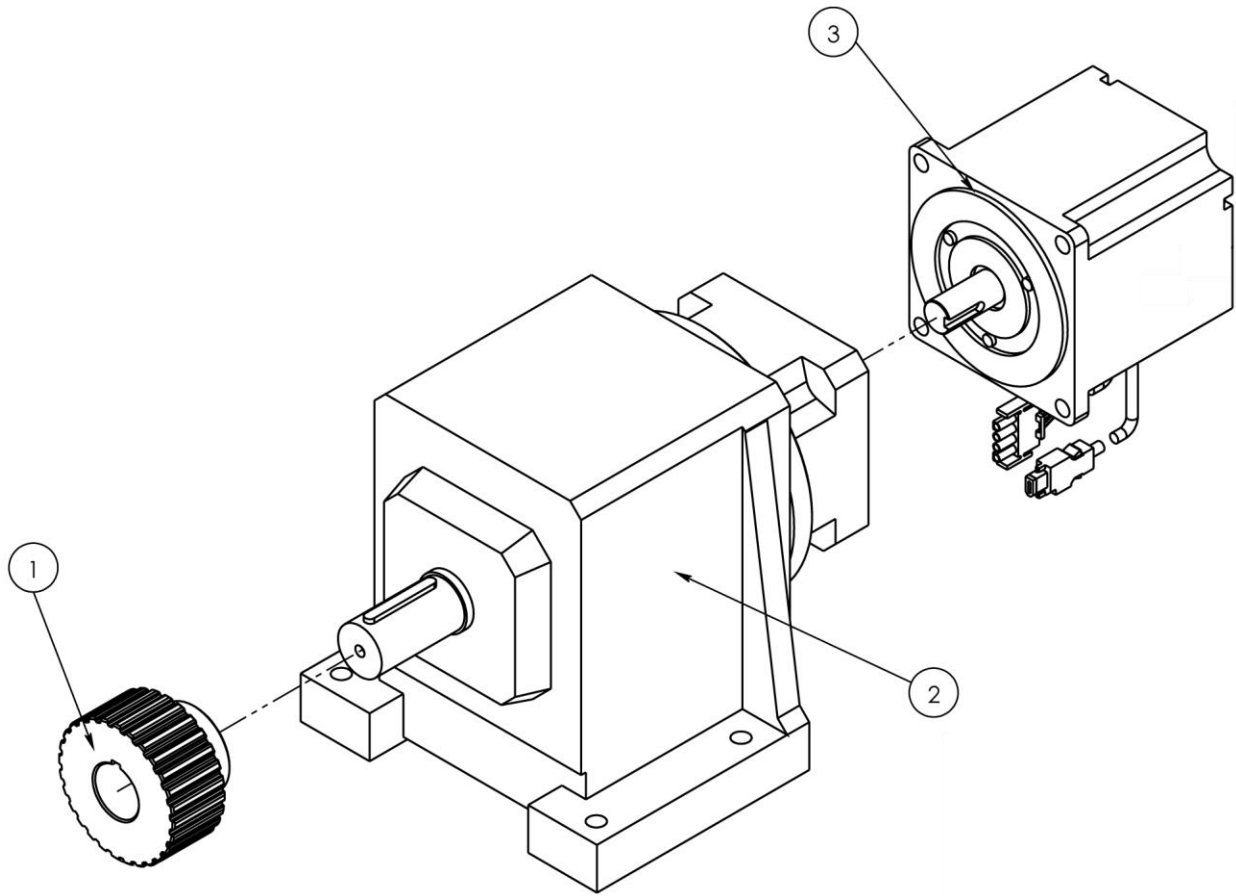


From the library of: Diamond Needle Corp

1389575 Torque Limit Assembly

AAC Drawing Number 1389575 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1389569	HUB,MODIFIED,22MM B
2	1	BB250AX_540	BUSHING,.54L,FOR TORQUE L
3	1	MM250AG517	SPROCKET,TORQUE LIMITER

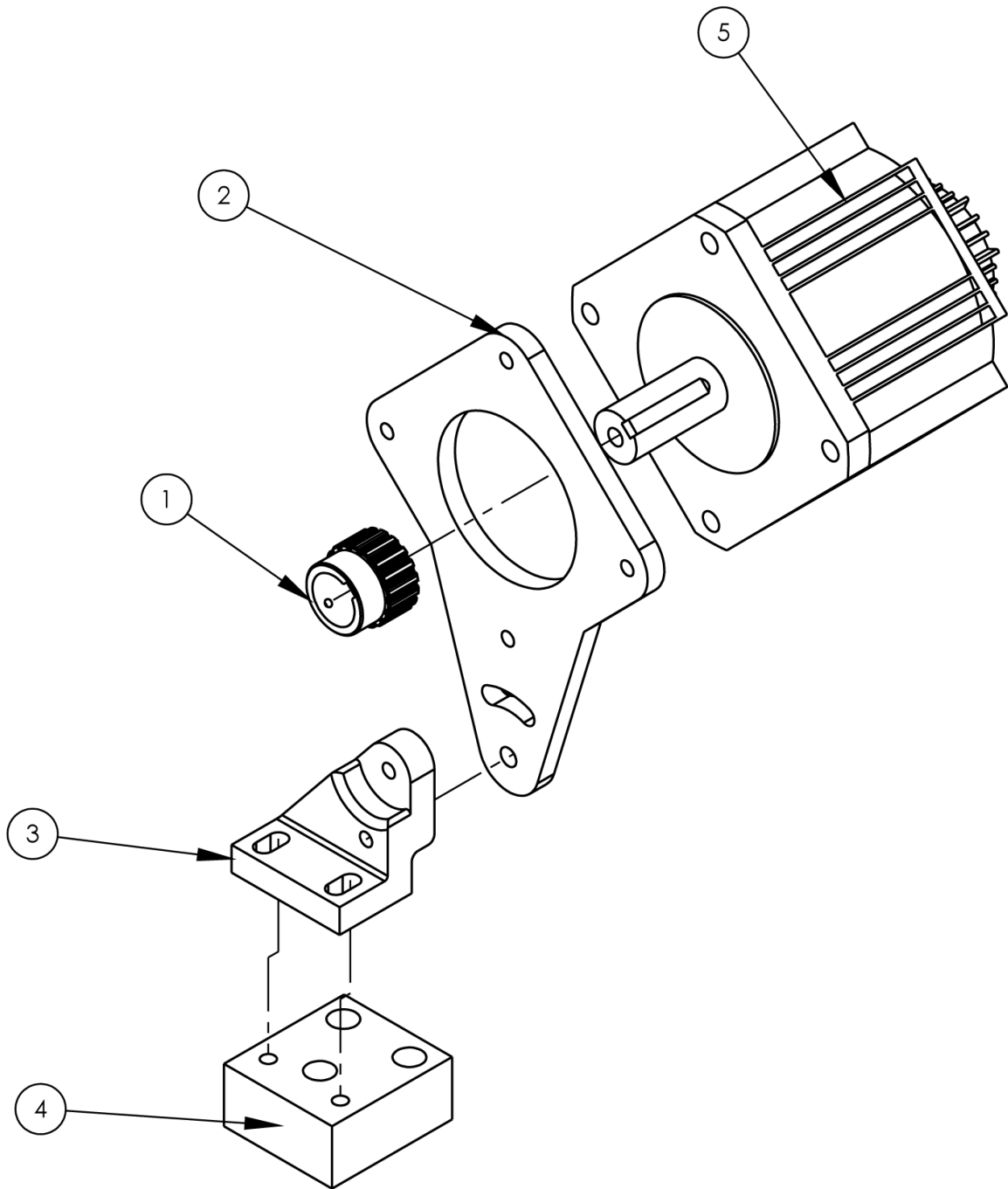


From the library of: Diamond Needle Corp

1392070 Roll Servo Drive Assembly

AAC Drawing Number 1392070 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1392809	PULLEY, GEAR, 38MM WIDE
2	1	C302N0410MT20	GEARBOX, CONC. HELICAL
3	1	SGMPH15AAE41D	MOTOR, SERVO, 1.5KW

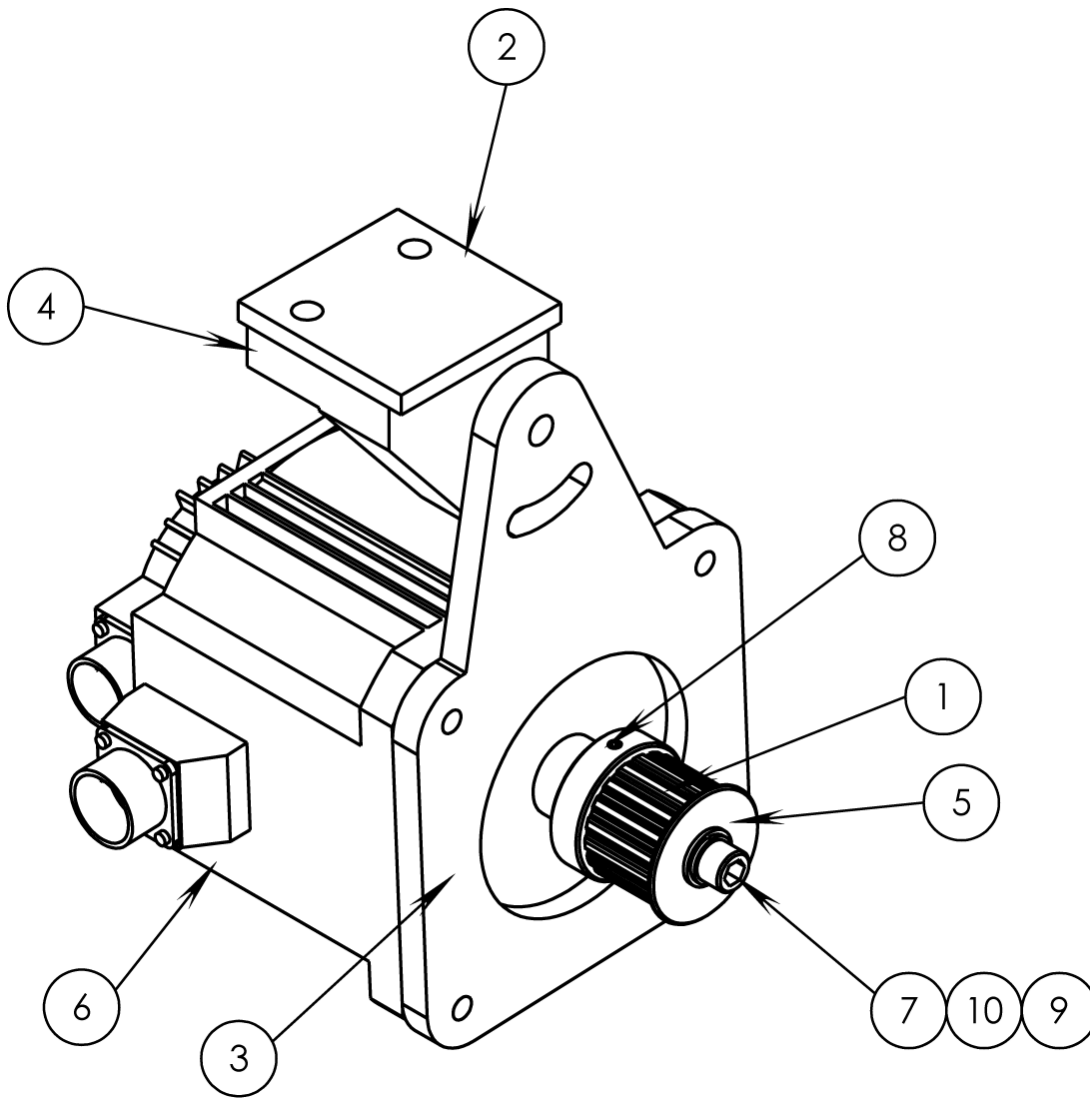


From the library of: Diamond Needle Corp

1392071 Carriage Servo Drive Assembly

AAC Drawing Number 1392071 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1-034	PULLEY, TIMING, 18T
2	1	2-033-M	MOUNT, MOTOR
3	1	2-046	BRACKET, MOTOR
4	1	6-010A	SPACER, MOTOR MOUNT
5	1	SGMGH30ACA61	MOTOR, SERVO 3.0KW

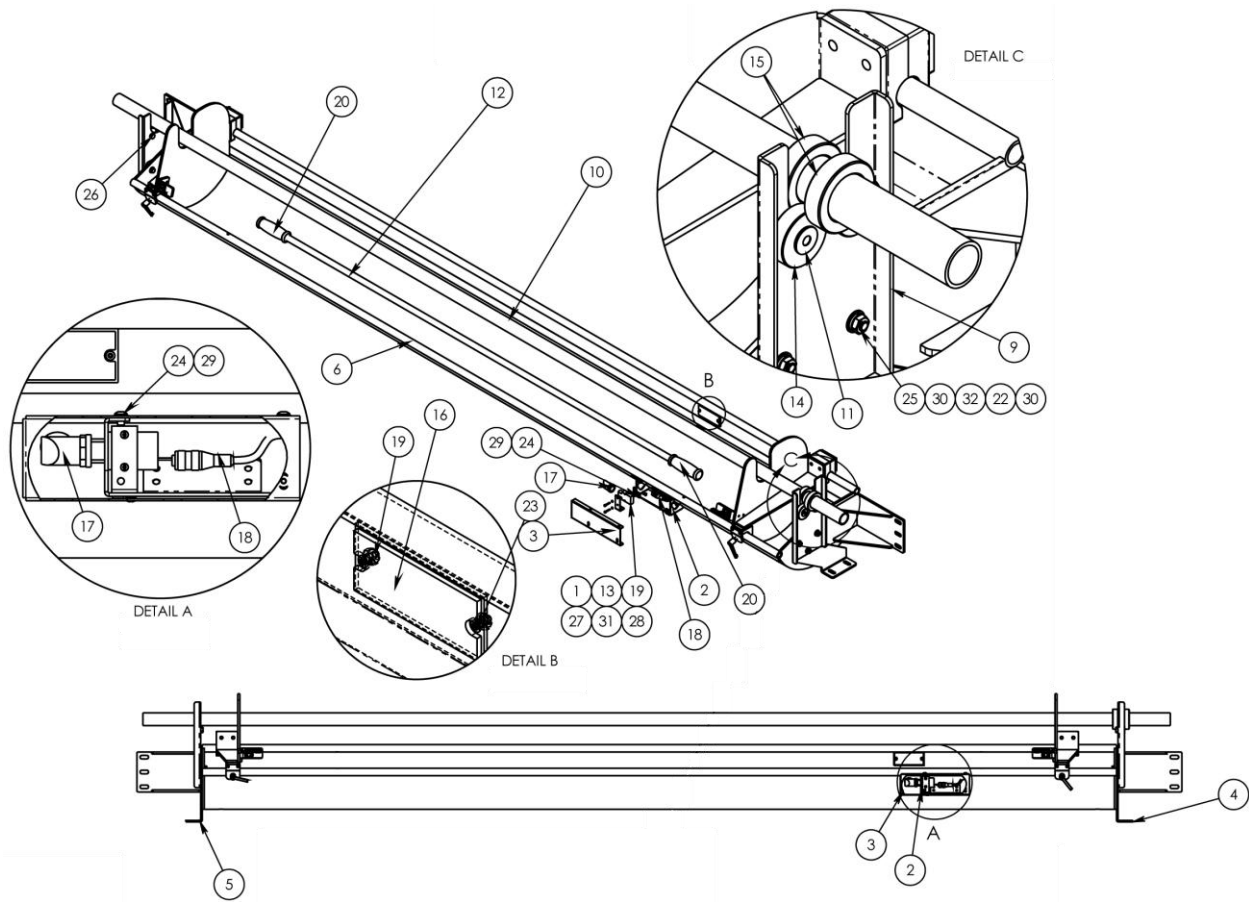


From the library of: Diamond Needle Corp

1392082 Needle Bar Drive Assembly

AAC Drawing Number 1392082 Rev 4

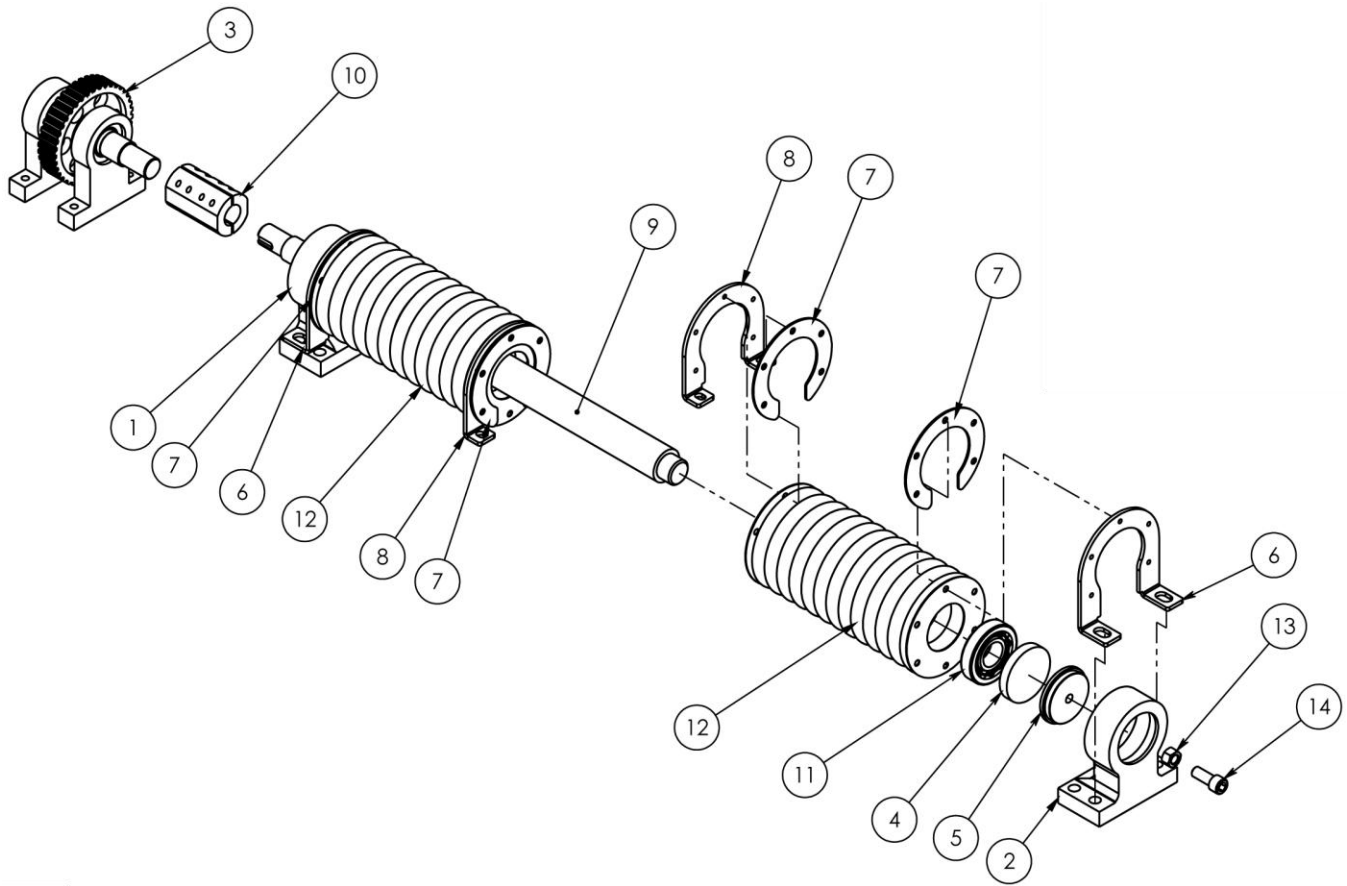
NO.	QTY	PART #	DESCRIPTION
1	1	1389827	PULLEY, GEAR, L 38MM WIDE
2	1	1392261	SPACER, MOTOR, BASE
3	1	1392499	MOUNT, MOTOR, BOTTOM
4	1	1392654	MOUNT, MOTOR, BASE
5	1	1392741	WASHER,PULLEY
6	1	SGMGH30ACA61	MOTOR, SERVO 3.0KW
7	1	SSSCM12X30	SCREW, SOC CAP, M12 X 30
8	2	SSSM6X10	M6 SET SCREW, 10MM L
9	1	WWFM12	WASHER, FLAT, M12 I.D.
10	1	WWLM12	M12 LOCK WASHER



1392087 Front Tray Assembly

AAC Drawing Number 1392087 Rev 7

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1387004	BRACKET, SENSOR MOUNT	18	1	FFRK44T-4	CABLE,EYE,12',NO END
2	1	1387005	BRACKET, TICKING SENSOR	19	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
3	1	1389424	COVER, SENSOR BRACKET	20	2	MMGP-105	GRIP HANDLE-FOAM 3/4 ID
4	1	1389427	BRKT,RH	21	2	NNE6-32	NUT,ELASTIC LOCK,6-32
5	1	1389432	BRKT,LH	22	6	NNH5/16-18	5/16-18 HEX NUT
6	1	1392040	MATERIAL TRAY ASSEMBLY	23	2	SSBC80024	6-32 X 3/16 BUT HEAD
7	1	1392084	MATERIAL END, LEFT	24	8	SSBCM5X8	SCREW,BUTTON CAP
8	1	1392085	MATERIAL END, RIGHT	25	6	SSHC10064	5/16-18 X 1 HHCS
9	2	1392452	BRACKET, ROLL HOLDER	26	4	SSHC25048	3/8-16X3/4,HEX CAP
10	1	1392457	TUBE, 1.5 "OD X 120" L	27	2	SSPP90024	8-32X3/8 PAN PHLPS
11	4	1392476	BUSHING, BEARING MOUNT	28	2	SSPS70048	4-40 X 3/4 PAN HD SLOTTED
12	1	1393945	ROD, TICKING	29	4	WWFM5	WASHER, FLAT, M5 I.D.
13	1	1975-412A	PLATE,NUT,4-40,.95CTC	30	12	WWFS5/16	WASHER,FLAT,SAE,5/16
14	4	BB1L017	BEARING,BALL,.787B	31	2	WWL4	WASHER,LOCK,#4
15	2	CCCL24F	CLAMP COLLAR, 1.5" BORE	32	6	WWL5/16	WASHER, LOCK, 5/16
16	1	EERL105	REFLECTOR, RECTANGULAR	33	2	WWL8	WASHER,LOCK,#8
17	1	EEST03	ADAPTER, RIGHT ANGLE				

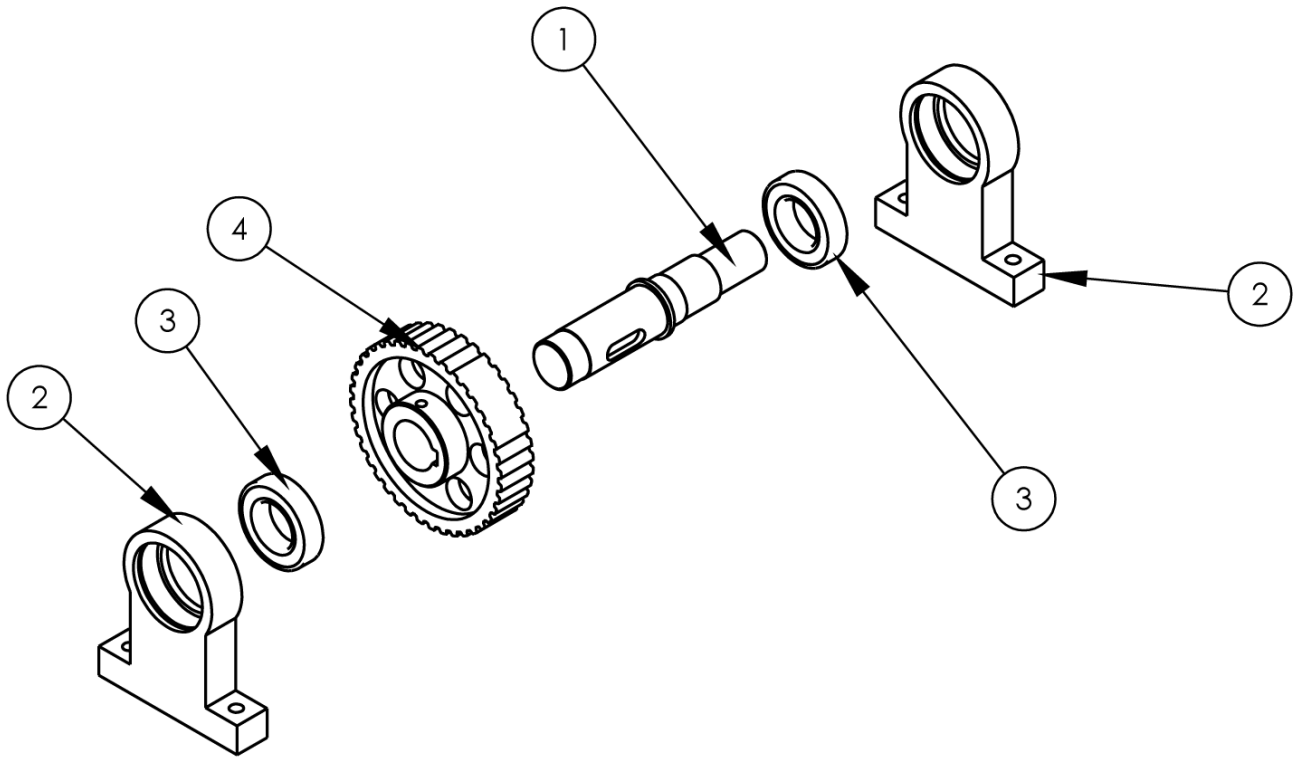


1392096 Worm Gear Drive Assembly

AAC Drawing Number 1392096 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	1	1389082	MOUNT, ROLLER BEARING
2	1	1389083	MOUNT, ROLLER BEARING
3	1	1389180	X-DRIVE PULLEY ASBLY
4	1	1389297	BEARING THRUST DISC
5	1	1389307	BEARING THRUST NUT PLATE
6	2	1392271	BRACKET, BELLOW
7	4	1392276	BRACKET, BELLOW
8	2	1392277	BRACKET, BELLOW
9	1	4-086	BALL SCREW, DRIVE
10	1	4-087	COUPLING, WORM GEAR
11	2	BB30306	BEARING, TAPPED
12	2	MM9740K14	BELLOW, W/ ZIPPER
13	1	NNHM12X1.75	M12 X 1.75 HEX NUT
14	1	SSSCM12X30	SCREW, SOC CAP, M12 X 30

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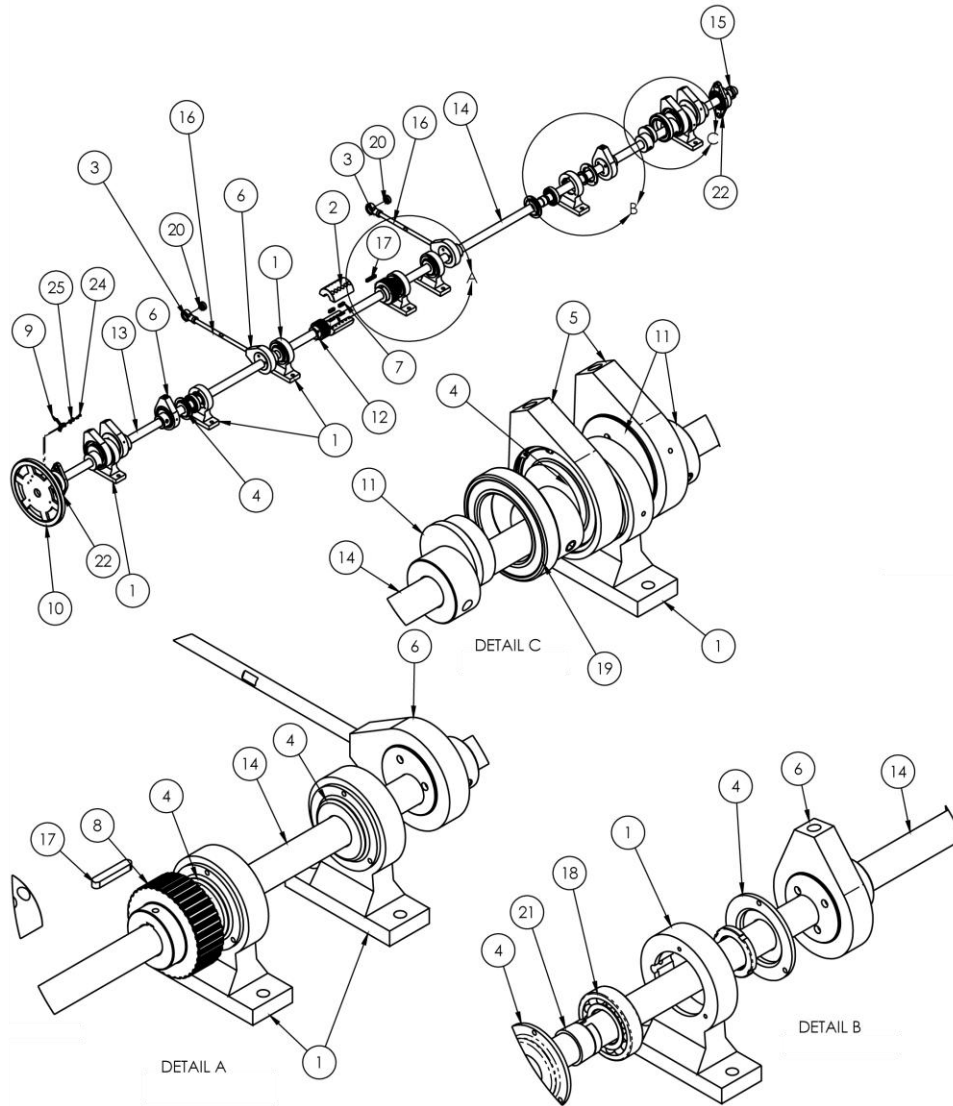


From the library of: Diamond Needle Corp

1389180 X-Drive Pulley Assembly

AAC Drawing Number 1389180 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	4-089	SHAFT, DRIVE
2	2	4-088	MOUNT, ROLLER BEARING
3	2	BB60062RS	BEARING, BALL, 30MM B, 2 SL
4	1	1-033	PULLEY, TIMING, 40T

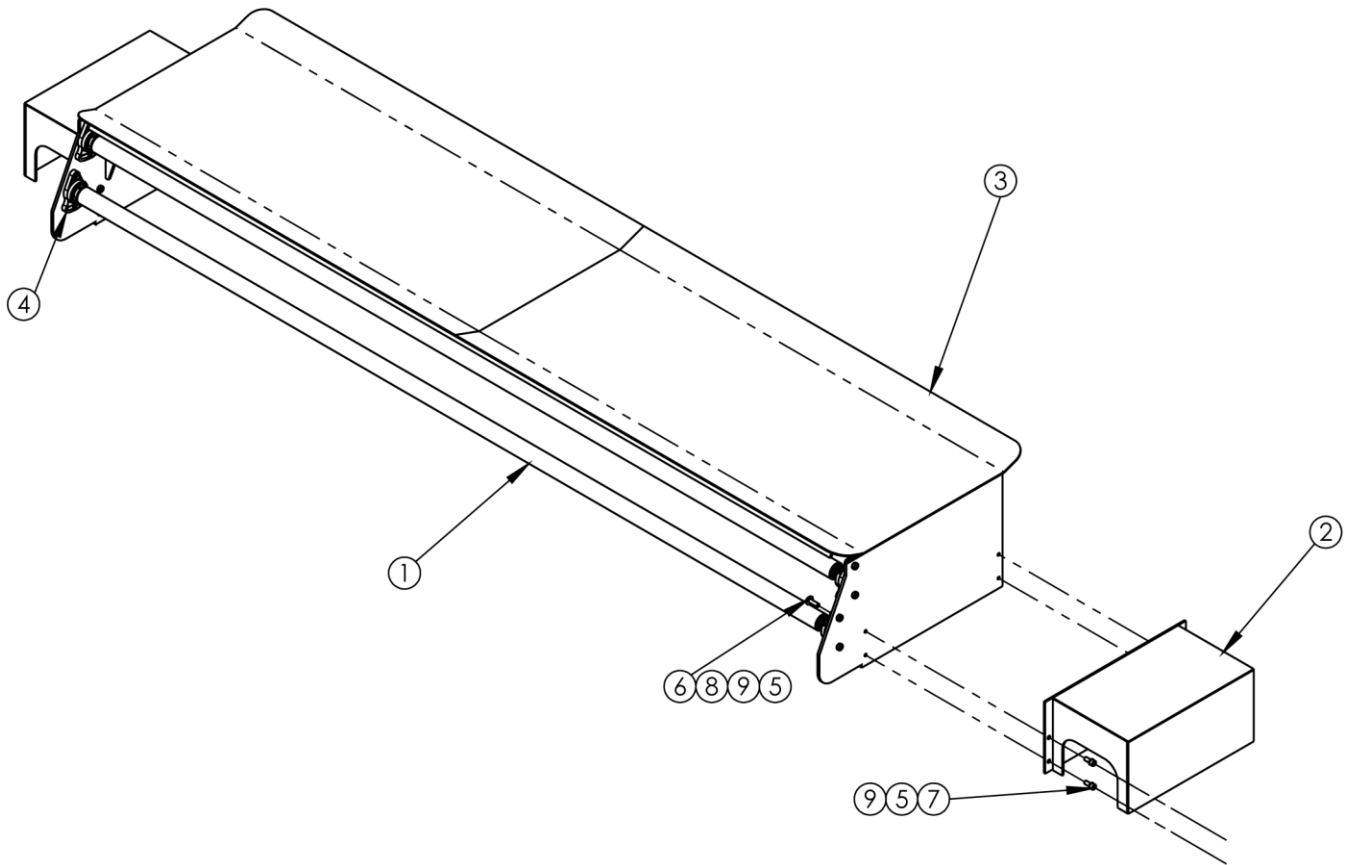


From the library of: Diamond Needle Corp

1392103 Main Drive Shaft Assembly

AAC Drawing Number 1392103 Rev 3

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	7	1-010A	SHAFT SUPPORT, BEARING BL	14	1	4-008-M	SHAFT,RIGHT NDL BAR DRIVE
2	1	1-012A	MAIN SHAFT COUPLING	15	1	5-025	TARGET, PROX
3	2	1-017	ROD END, PRESSER FOOT	16	2	5-032	PITMAN ROD, 16MM X 320MM
4	14	1-051B	COVER, BEARING	17	1	A9C39M100856	KEY, SHAFT
5	4	1389024	ECCENTRIC, LARGE, ASM	18	7	BB1208K	BEARING, TAPERED BORE
6	4	1389025	ECCENTRIC,SMALL, ASM	19	1	BB60162RS	BEARING, RADIAL, SEALED
7	2	1389973	SHAFT KEY	20	2	BB62022RS	BEARING, RADIAL, SEALED
8	1	1392509	PULLEY, GEAR, 38MM WIDE	21	7	BBH208	SLEEVE, ADAPTER
9	1	1392548	INDICATOR	22	2	BBUKFL20835	BEARING, FLANGE UKFL
10	1	1392549	HANDWHEEL ASSY,	23	2	MMH0137	SNAP RING,INTERNAL
11	2	2-062	ECCENTRIC INSERT,LARGE	24	2	SSBCM5X8	SCREW,BUTTON CAP
12	1	3-028A	PULLEY, GEAR, 40MM WIDE	25	2	WWL5/16	WASHER, LOCK, 5/16
13	1	4-007-M	SHAFT, LEFT NDL BAR DRIVE				

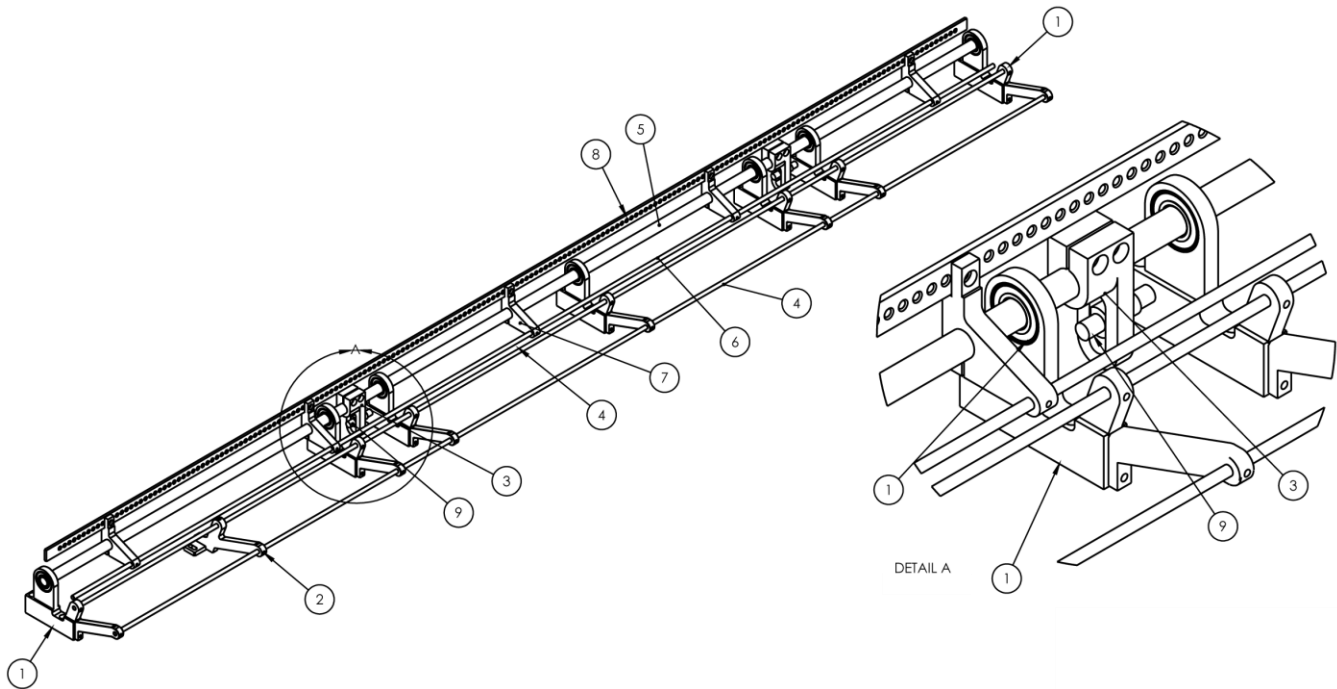


From the library of: Diamond Needle Corp

1392193 Operator Platform Assembly

AAC Drawing Number 1392193 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	2	5-016	ROLLER, PLATFORM
2	2	5-018	STEP, WELDMENT, PLATFORM
3	1	5-019	PLATFORM, OPERATOR, ASM
4	4	BBUCFA205	BEARING, FLANGE UCFA
5	16	NNHM10X1.5	NUT, HEX, M10X1.5
6	8	SSHCM10X35	SCREW, HEX CAP M10X35
7	8	SSSCM10X25	10M X 25MM, SOC CAP
8	8	WWFM10	WASHER, FLAT, M10 I.D.
9	16	WWLM10	M10 LOCK WASHER



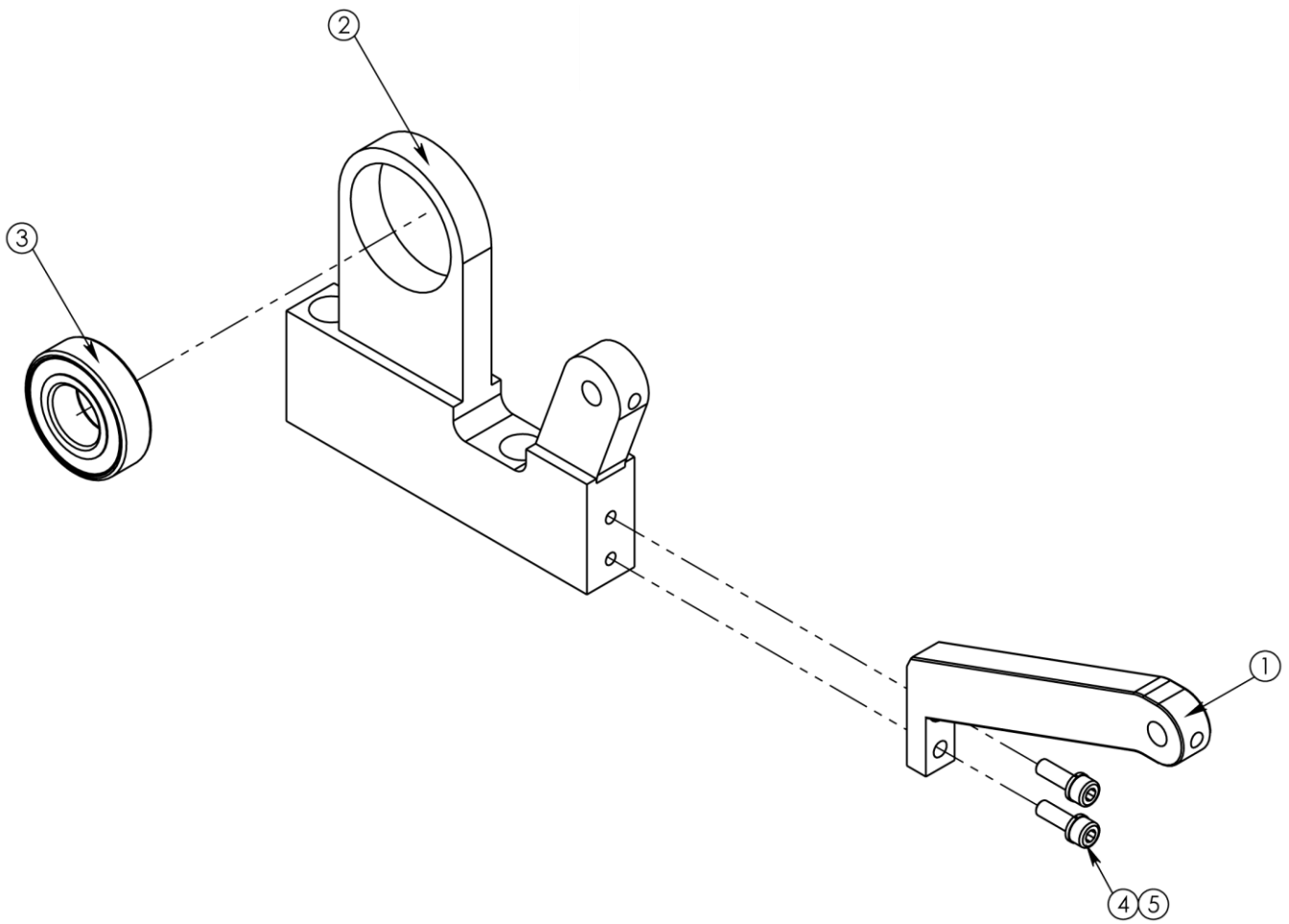
From the library of: Diamond Needle Corp

1392196 Looper Take-up Assembly

AAC Drawing Number 1392196 Rev 2

NO.	QTY	PART #	DESCRIPTION
1	7	1392304	BUTTERFLY, BEARING ASSY
2	1	1392983	ROD SUPPORT, REAR THREAD
3	2	2-081	DRIVE ARM, REAR BTRFLY
4	2	4-051	GUIDE, THREAD ROD
5	1	4-052	SHAFT, REAR TAKE-UP
6	1	4-053	ROD, REAR TAKE-UP
7	5	4-083	TAKE-UP, THREAD ROCKER
8	1	4-084A	GUIDES, THREAD
9	2	5-033	SHAFT, RODEND, REAR BTRFLY

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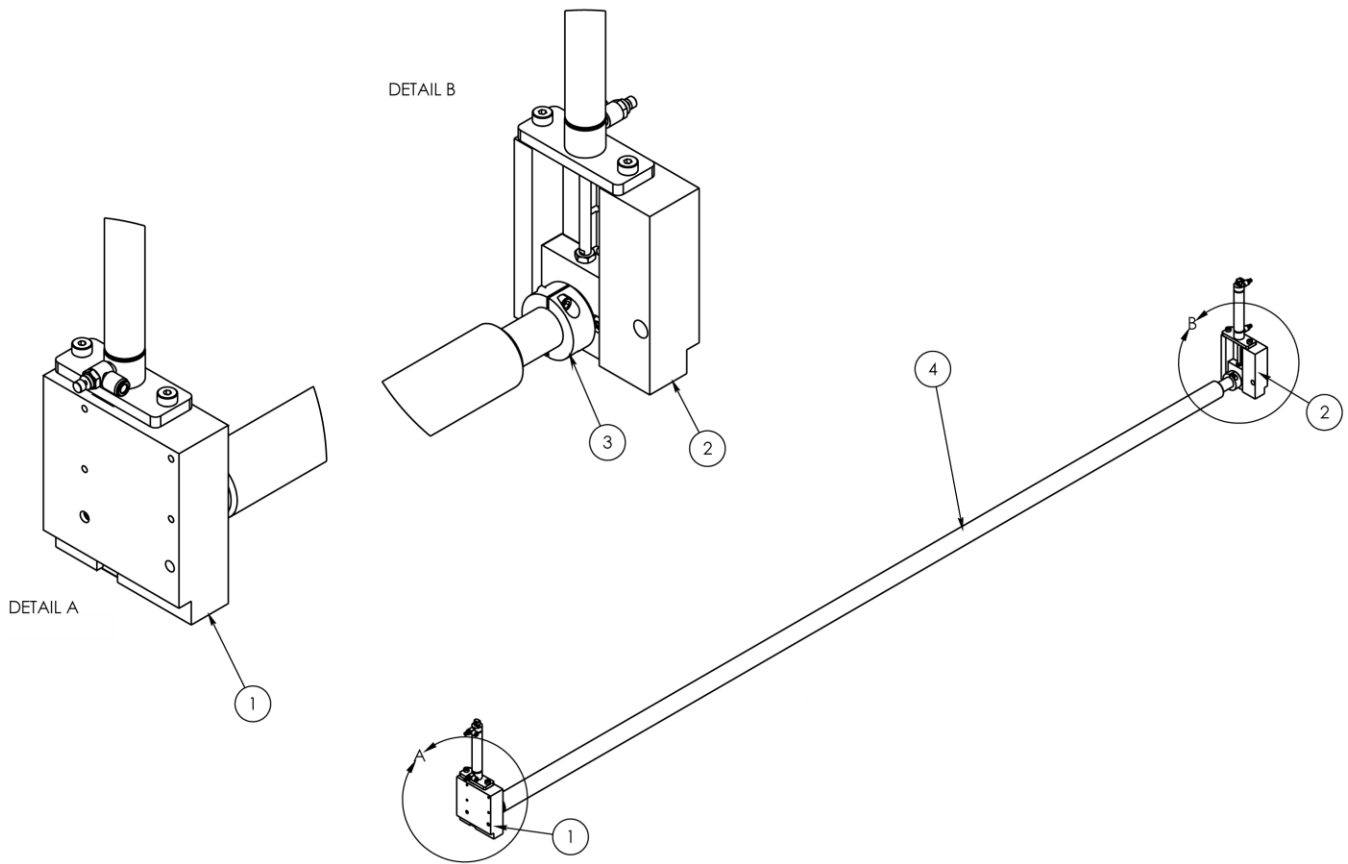


From the library of: Diamond Needle Corp

1392304 Bearing Butterfly Assembly

AAC Drawing Number 1392304 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1392221	GUIDE, LOOPER THREAD(4-082A-2)
2	1	1392491	MOUNT, ROLLER BEARING
3	1	BB60042RS	BEARING,BALL,20 ID,42 OD
4	2	SSSCM5X16	SCREW,SOC CAP,M5-0.8 X 16
5	2	WWLM5	M5 LOCK WASHER

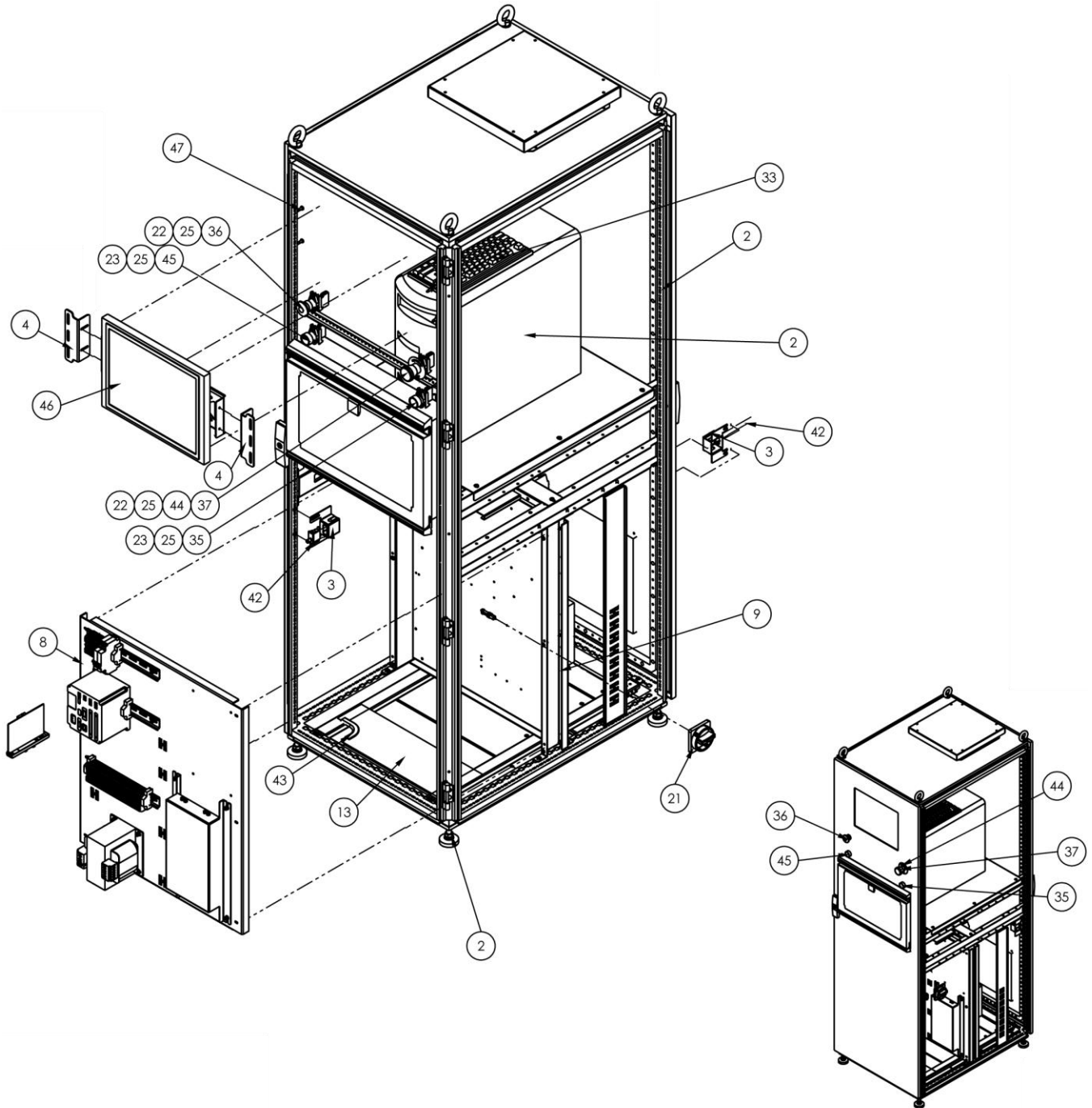


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1392306 Roller Lift Assembly

AAC Drawing Number 1392306 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	1389085	ROLLER LIFT ASSEMBLY, LT
2	1	1392095	ROLLER LIFT ASSEMBLY
3	2	1393895	COLLAR, END PLAY
4	1	3-005	ROLLER



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1392364 Control Cabinet Assembly

AAC Drawing Number 1392364 Rev 15

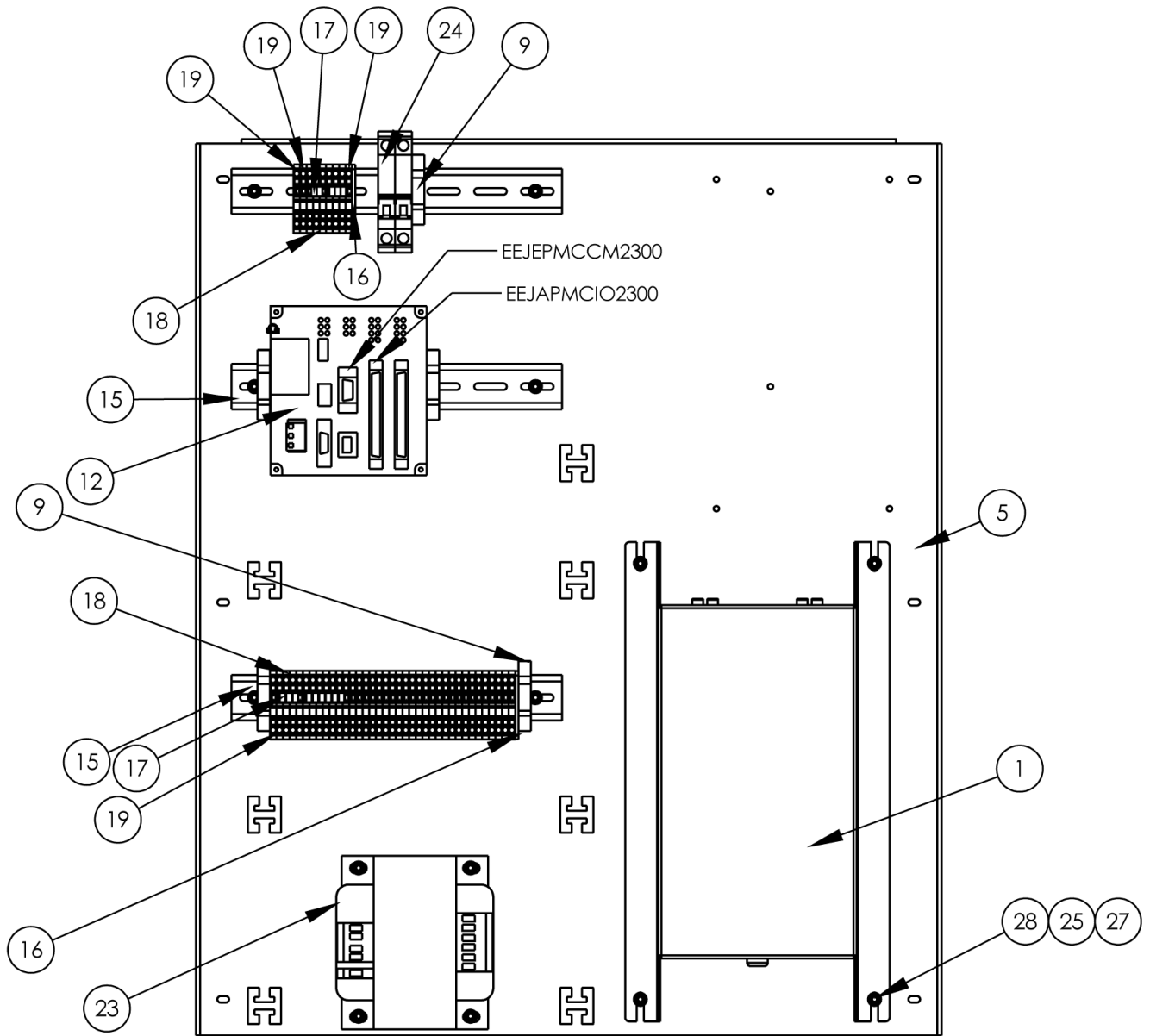
NO.	QTY	PART #	DESCRIPTION
1	AR	120280	PCI SERIAL ADAPTOR
2	1	1388431	ENCLOSURE, COMPUTER 1392
3	2	1388437	ENCLOSURE ,SENSOR,DOOR
4	2	1388708	BRACKET, TOUCHSCREEN
5	AR	1392-WD1	WD,BACK PANEL
6	AR	1392-WD2	WD,QUILTER PANEL
7	1	1392036	SHELF, KEYBOARD
8	1	1392366	BACKPLANE, FRONT SIDE ASM
9	1	1392367	BACKPLANE, BACK SIDE ASM
10	1*	1392660	CABLE, FLORES. LIGHT
11	1*	1392696	CABLE ASSY,MP2300,SERIAL
12	1*	1392697	PENDANT ASSY,QUILTER
13	1	1392994	PANEL, ACCESS
14	1	4080-4215A	CABLE,3 PIN FM MOLEX
15	1*	51175B	MEMORY KEY,128MB
16	1*	DONGLE1	E-Z PATTERN DESIGN SECURITY DONGLE
17	1*	DONGLE2	E-Z QUILTER SECURITY DONGLE
18	1	EE1392COMP	DELL COMP W/FLAT SCREEN
19	1*	EE194EE631753	DISCONNECT,3POLE,63A,IEC,
20	1*	EE194EE63PE	DISCONNECT PE,40/63A,IEC
21	1	EE194LHE6N175	DISCONNECT HANDLE,RED/YEL
22	2	EE3X01	BLOCK,P.B. CONTACT, N.C.
23	2	EE3X10	BLOCK,P.B. CONTACT, N.O.
24	1*	EEA11CE05A	CABLE,ENCODER,5M
25	4	EEA3L	LATCH,PUSH BUTTON
26	1*	EEB2E05A	CABLE,POWER,5M,SERVO
27	1*	EEB2E10A	CABLE,POWER,10M,SERVO
28	1*	EEB51CE05A	CABLE,POWER,5M,SERVO
29	3*	EEJEPMCW600301	CABLE,MCHTRINK M2 W/CORE
30	1*	EEJEPMCW6022	TERMINATION,BLOCK
31	1*	EEJZSPCMP0205B	ENC,CABLE ASSY,5M
32	1*	EEJZSPCMP0210B	ENC,CABLE ASSY,10M
33	1	EEL237228	KEYBOARD, USB
34	1	EELA1500RTR	LCD,TOUCHSCREEN,15"
35	1	EEPF3	BUTTON, PUSH 22MM, GREEN MO
36	1	EEPLMP45	BUTTON,PUSH,22MM,YELLOW
37	1	EEPMTS44	E-STOP BUTTON, TWIST REL.
38	18*	FF31572787	WIRE,STR,#10,PVC,GRN/YEL
39	3*	FF8908-10	WIRE,STR,#8,PVC,BLK
40	3*	FF8908-13	WIRE,STR,#8,PVC,BLU
41	3*	FF8908-2	WIRE,STR,#8,PVC,RED
42	2	FFE6930A	SWITCH,INTEROCK,DOOR,SPDT
43	5**	MM100-1/8	DOOR TRIM - BLACK
44	1	MM800E15YE112	E-STOP LEGEND PLATE
45	1	MM800EPF1	BUTTON, PUSH 22MM, WHI, MO
46	50**	MMLSSBB01210	FOAM, URETHANE, 1/8X1
47	50*	SSZP#12040	SCREW,PAN SHEET METAL
48	4*	TT190020028	TERMINAL,FASTON,F,.187X
49	4*	TT5828	TERMINAL,RING,#10 STUD

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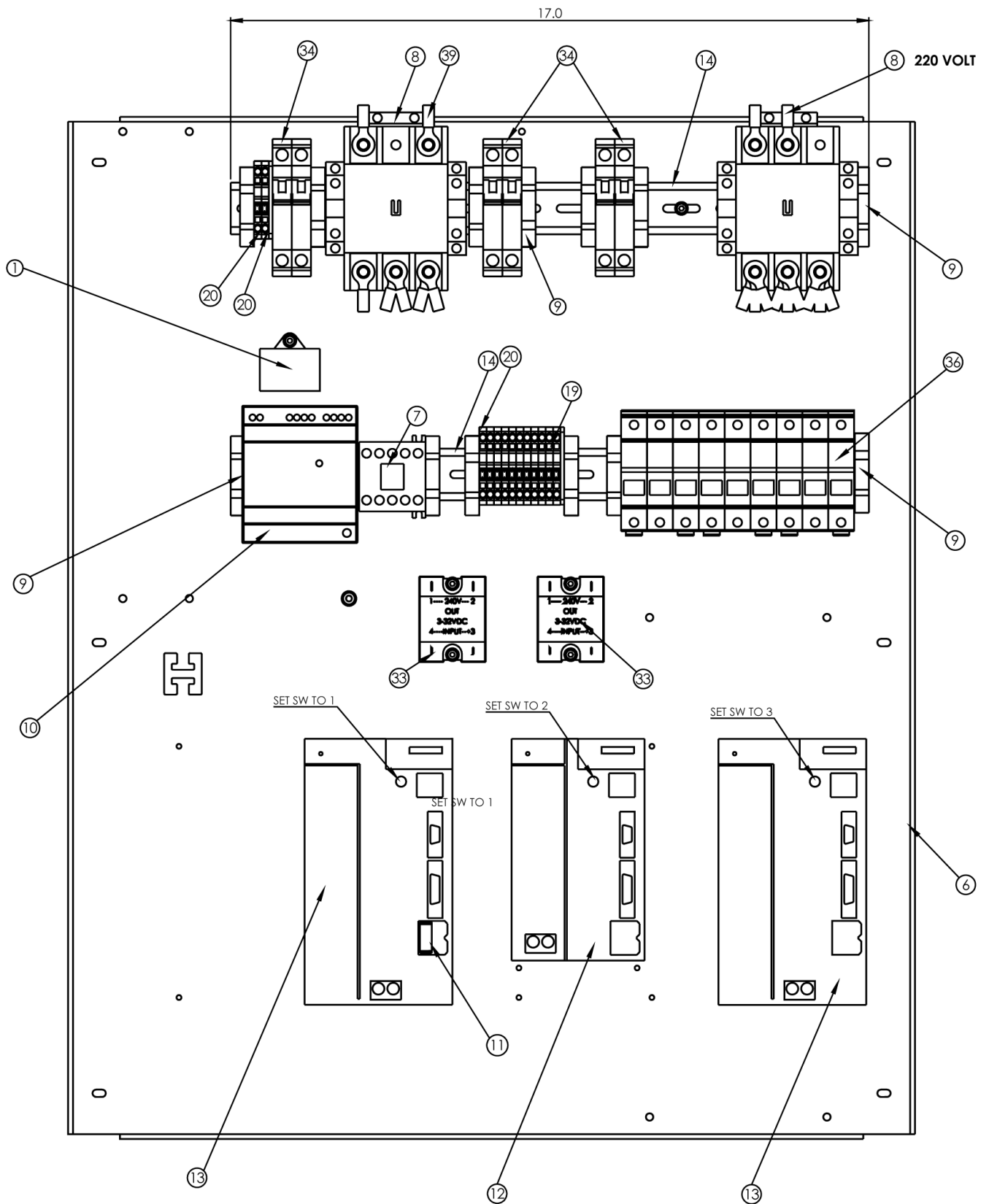


1392366 Front Side Backplane Assembly

AAC Drawing Number 1392366 Rev 5

NO.	QTY	PART #	DESCRIPTION
1	1	1392515	REGEN RESISTOR ASSY
2	1	1392663	CABLE ASSY,MP2300 I/O
3	1	1392664	CABLE ASSY,QUILTER I/O
4	1	1392665	CABLE ASSY,FLUOR LIGHT
5	1	1392684	PANEL,FRONT BACKPLANE
6	1	1392688	CABLE ASSY,CARR LIMIT
7	1	1392691	CABLE ASSY,SSR
8	11'	EE16-3C2406	CABLE,3 COND,16AWG,300V
9	5	EECLIPFIX	ANCHOR,DIN RAIL
10	1	EEJAPMCIO2300	I/O CARD,16PT,SINK OUT
11	1	EEJEPMCCM2300	COMM CARD,RS232/ETHERNET
12	1	EEJEPMCMP2300	CONTROLLER, MOTION
13	1	EEJEPMCOP300	RAIL CLIP,MP2300
14	1	EEJEPMCOP2300	SLOT COVER
15	30"	EETS35X7.5A	DIN RAIL-AMERICAN
16	2	FF280-308	TERMBLK ENDPLATE,WAGO,280
17	14	FF280-402	JUMPER,WAGO,TOP,SNGL
18	42	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY
19	4	FF280-907	TERMBLK,WAGO,TOP,SNGL,GRN
20	1	FF3077-2	WIRE, 16 AWG BLACK
21	1	FF3077-3	WIRE,STR,#16,PVC,RED
22	1	FF3077-28	WIRE, 16 AWG GRN/YEL
23	1	FFMPI-650-230	TRANSFORMER, 5.6A
24	1	FFQL213DMKM10	CIRCUIT BREAKER,10A,2P
25	14	SSSCM5X16	SCREW,SOC CAP,M5-0.8 X 16
26	1	TTBB5263	TERMINAL,.25 FULLY INSUL
27	14	WWFM5	WASHER, FLAT, M5 I.D.
28	14	WWL10	WASHER,LOCK,#10

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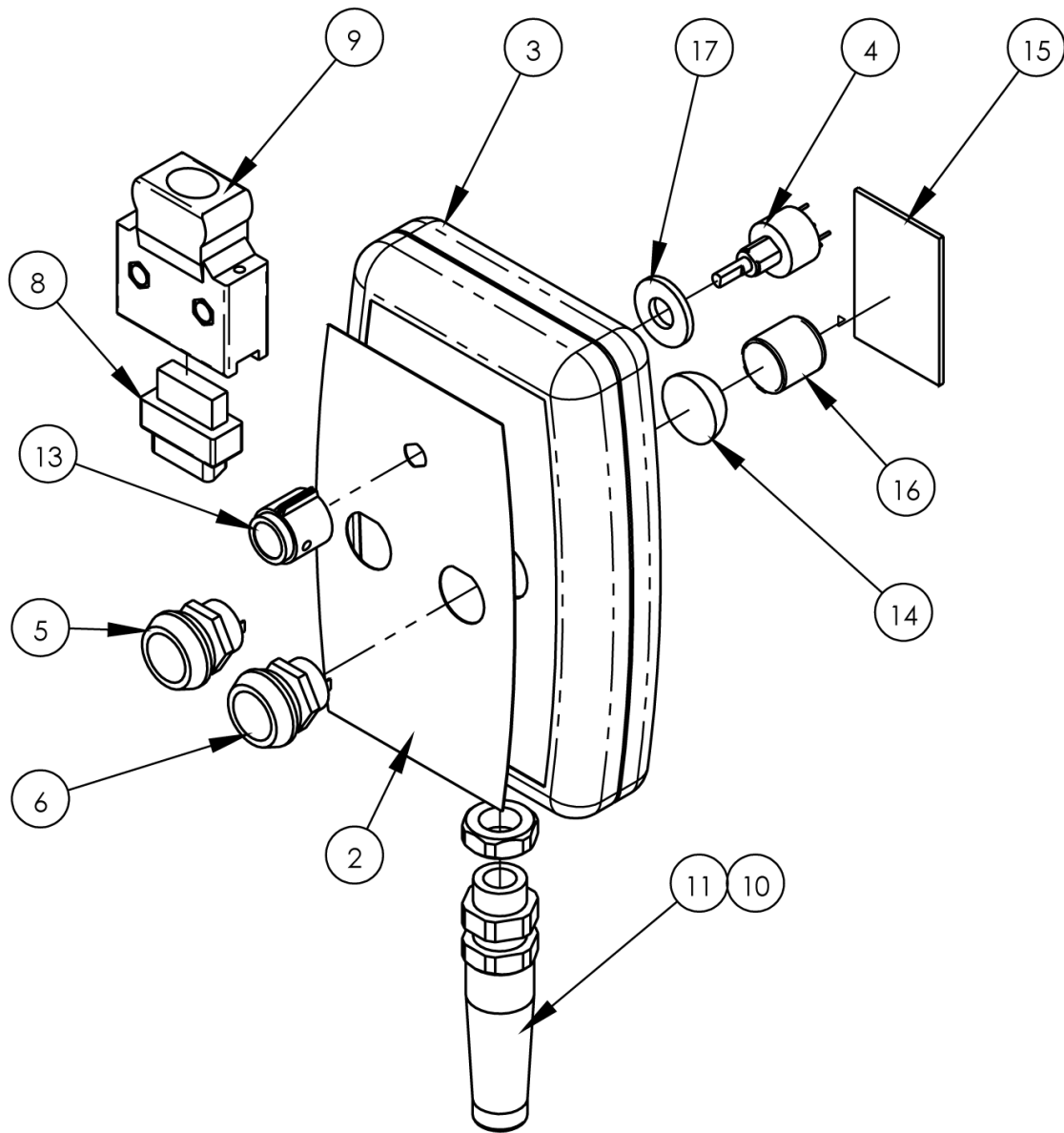
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1392367 Back Side Backplane Assembly

AAC Drawing Number 1392367 Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1*	1392657	SURGE SUPPRESSOR ASSY
2	1*	1392658	CABLE ASSY,TRANS PRI
3	1*	1392659	CABLE ASSY,E-STOP RCPT
4	1*	1392661	CABLE ASSY,CLOSER RCPT
5	1*	1392662	CABLE ASSY,SPIRAL RCPT
6	1	1392685	PANEL, FRONT BACKPLANE
7	1	EECA491024	CONTACTOR, MINI, 240V
8	2	EECGC85A220	CONTACTOR,85A,220VAC
9	16	EECLIPFIX	ANCHOR,DIN RAIL
10	1	EEDR3024	POWER SUP,SWITCHER,24V
11	1	EEJEMCW6022	TERMINATION,BLOCK
12	1	EESGDS15A12A	AMPLIFIER, SERVO DRIVER
13	2	EESGDS30A12A	AMPLIFIER, SERVO DRIVER
14	36**	EETS35X7.5A	DIN RAIL
15	AR	FF209-502	TERMBLK,WAGO,TP,LG,MARK,1-10
16	AR	FF209-503	TERMBLK,WAGO,TP,LG,MARK,11-20
17	2	FF280-308	TERMBLK ENDPLATE,WAGO,280
18	8*	FF280-402	JUMPER,WAGO,280,SINGLE
19	10	FF280-901	TERMBLK,WAGO,TOP,SNGL,GRY
20	3	FF280-907	TERMBLK,WAGO,TOP,SNGL,GRN
21	10 FT*	FF3077-1	WIRE,STR,#16,PVC,WHT
22	10 FT*	FF3077-2	WIRE,STR,#16,PVC,BLK
23	10 FT*	FF3077-3	WIRE,STR,#16,PVC,RED
24	10 FT*	FF31572787	WIRE,STR,#10,PVC,GRN/YEL
25	10 FT*	FF8908-10	WIRE,STR,#8,PVC,BLK
26	10 FT*	FF8908-13	WIRE,STR,#8,PVC,BLU
27	10 FT*	FF8908-2	WIRE,STR,#8,PVC,RED
28	4 FT*	FF9740	CABLE,2 COND,18 AWG,300V
29	10 FT*	FF9912-10	WIRE,STR,#12,PVC,BLACK
30	10 FT*	FF9912-2	WIRE,STR,#12,PVC,RED
31	10 FT*	FF9912-6	WIRE,STR,#12,PVC,BLUE
32	9 FT*	FFATMR20	FUSE,CC,20A,FAST,CURLIM
33	2	FFD2425F	RELAY,SSR,24VAC,25A
34	3	FFQL213DMKM10	CIRCUIT BREAKER,10A,2P
35	1	FFR10K10W	RESISTOR,10K,10W,5%
36	3	MM1492FB3C30	FUSE HOLDERS,3 POLE
37	15	SSSCM4X16	SCREW,SOCKET CAP
38	12	SSSCM5X10	SCREW,SOC CAP,M5-0.8 X 10
39	18	TT190730242	TERMINAL,RING,5/16"STD
40	4*	TTBB5263	TERMINAL,.25 FULLY INSUL
41	15	WWFM4.3	WASHER, FLAT, M4
42	12	WWFM5	WASHER, FLAT, M5 I.D.
43	12	WWL10	WASHER,LOCK,#10
44	15	WWL8	WASHER,LOCK,#8

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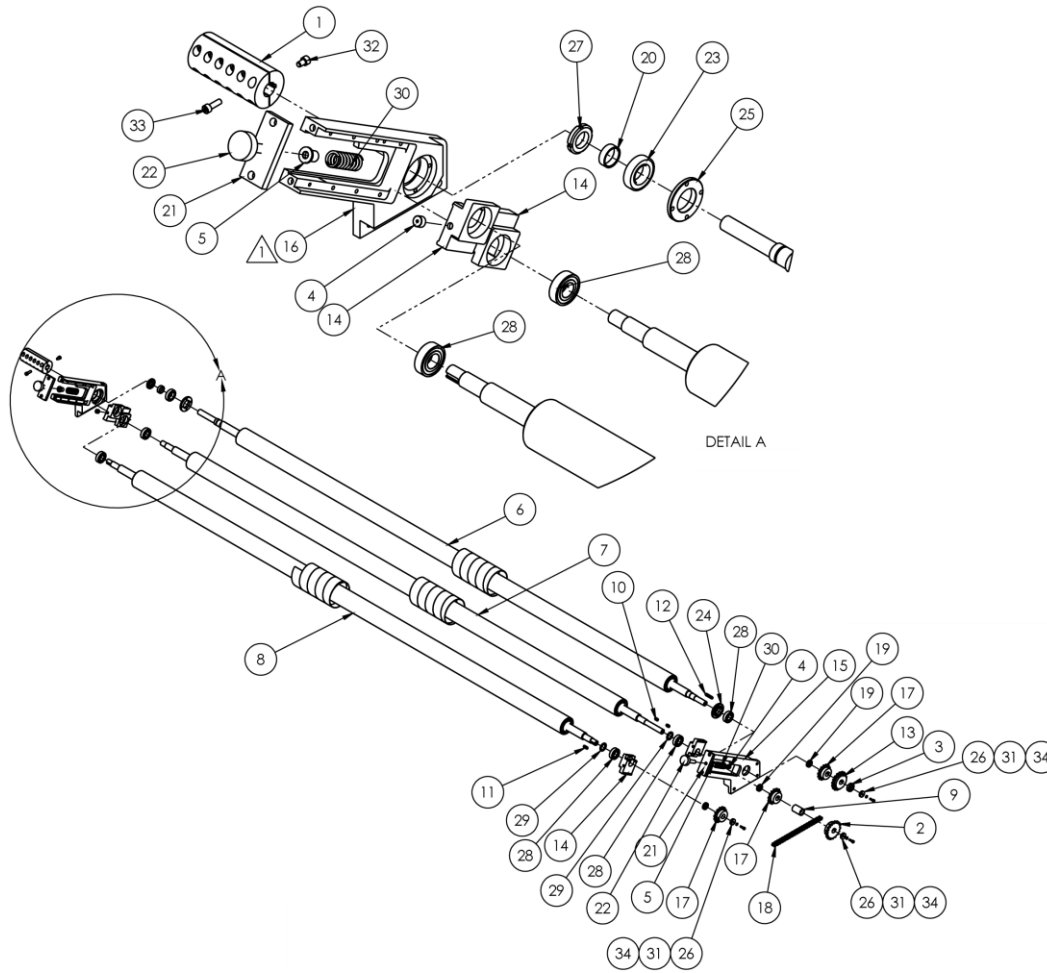


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1392697 Quilter Pendant Assembly

AAC Drawing Number 1392697 Rev 1

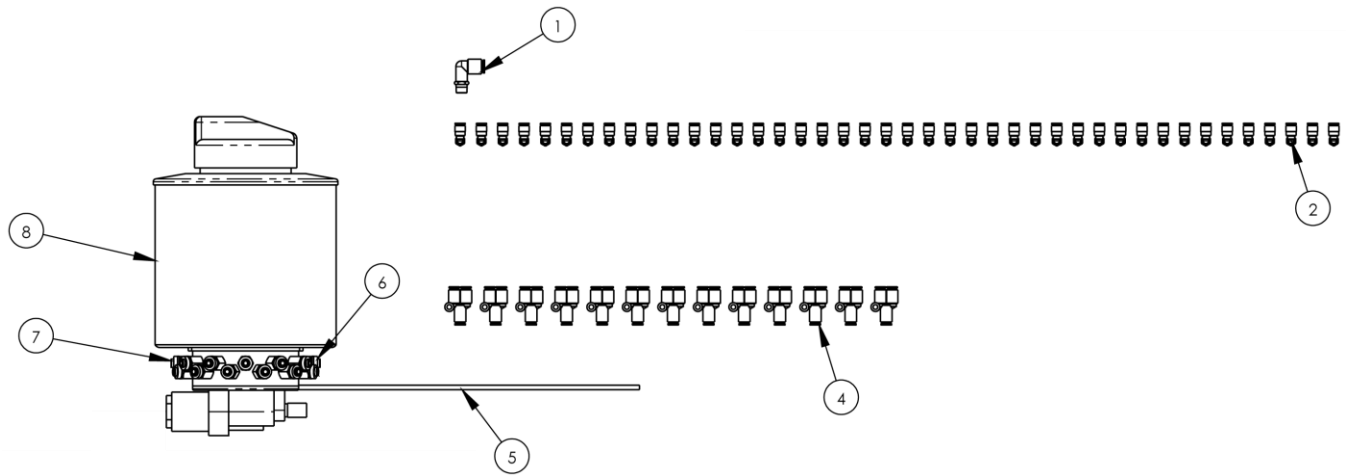
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	*AR	1392-WD4	WIRING DIAG. PENDANT	10	1	FF2257	LOCKNUT,PG7 METAL
2	1	1392554	LABEL	11	1	FF3237	STRAIN RELIEF,LIQ. TIGHT
3	1	1392555	PENDANT,REMOTE	12	*34 FT	FF36F056WA	CABLE, 8 COND, 22 AWG
4	1	EE26ASD45011	SWITCH, ROTARY,BCD 8 POS	13	1	FF8567	KNOB, .5" DIA, .125"SHAFT
5	1	EE49112	SWITCH, PUSH BUTTON, MOM.	14	1	FFSJ5027	BUMPER, HEMI, .31"
6	1	EE49113	SWITCH, PUSH BUTTON, MOM.	15	*1.5 IN	MM6243T41	TAPE,ANTISLIP,NONABRASIVE
7	*1.5 FT	EE8442	CABLE, 2 COND. 22 AWG	16	1	MMD88N42	MAGNET, .5DIA X .5 THK
8	1	FF101203000VE	CONN,MINI D,M,20PIN	17	1	WWFS1/4	WASHER FLAT, 1/4
9	1	FF1032052F008	CONN,MINI D,BACK,26PIN				



1392392 LH Roll Drive Assembly

AAC Drawing Number 1392392 Rev 8

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1389236	COUPLING, Y-AXIS DRIVE	18	1	1393463	CHAIN, INSIDE, 36.5 L
2	1	1389555	SPROCKET, 17T, 5/8P, 22MM B	19	3	1393464	SLEEVE, SPACER, .17 X .88ID
3	1	1389570	SPACER, ROLLER	20	1	3-024A	SPACER, LOWER REAR ROLL
4	2	1392127	LOCATOR, SPRING	21	2	3-027	BAR, ROLL ADJUSTMENT
5	2	1392128	ADAPTER, COMPRESSION SPRING	22	2	3-031	SCREW, ROLL ADJUSTMENT
6	1	1392233	LOWER ROLLER	23	1	BB60062RS	BEARING, BALL, 30MM B, 2 SL
7	1	1392236	MIDDLE ROLLER	24	1	5-020	COLLAR, SHAFT, WIDE
8	1	1392238	UPPER ROLLER	25	1	5-020-1	COLLAR, SHAFT, NARROW
9	1	1392275	SLEEVE, SPACER	26	3	5-058A	SPACER, THREAD TENSION
10	2	1392671	KEY, 7MMX8MMX.71 IN	27	1	6-039	SPANNER NUT, M30 X 1.5
11	1	1392672	KEY, 7MMX8MMX.96 IN	28	5	BB62052RS	BEARING, 25mm ID, 52mm OD
12	1	1392673	KEY, 7MMX8MMX1.75 IN	29	2	BBTRB1625	WASHER, THRUST, STEEL
13	1	1392851	STEEL SPROCKET, 17T, 5/8P	30	2	RRLHC148J03	SPRING, 1.1OD, .148WIRE, 2.5
14	4	1392923	BLOCK, BEARING, OFFSET	31	3	SSSCM6X20	SCREW, SOCKET CAP
15	1	1392940	WELDMENT, LH REAR BRG MT	32	4	SSSCM8X12	SCREW, SOC CAP, M8X25
16	1	1392941	WELDMENT, RH REAR BRG MT	33	12	SSSCM8X25	M8-1.25 X 25 SOC CAP
17	3	1393454	STEEL SPROCKET, 14T, 5/8P	34	3	WWLM6	M6 LOCK WASHER

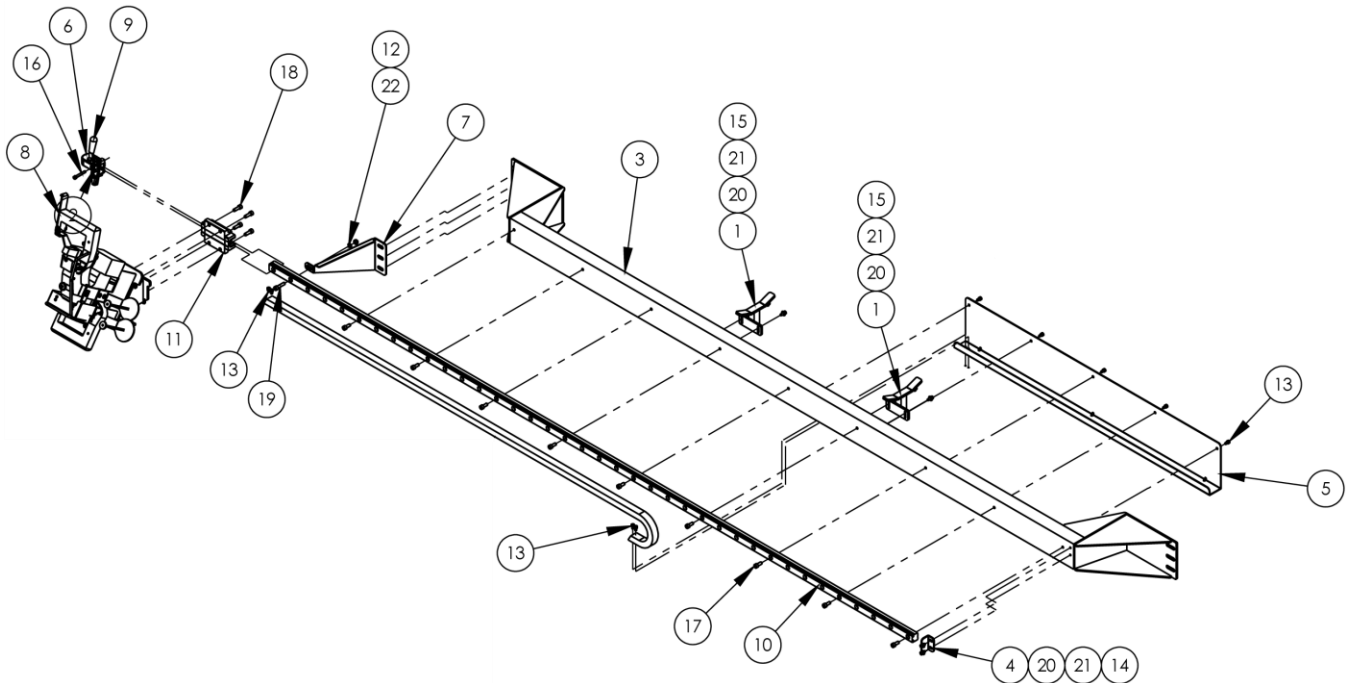


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1392415 Lubrication Assembly

AAC Drawing Number 1392415 Rev 7

NO.	QTY	PART #	DESCRIPTION
1	1	AAQME-4-8U	QUICK MALE ELBOW,1/4X1/8
2	45	AAQME-M4-M6	QUICK ELBOW CONNECTOR
3	9	AAQUT-5-5	UNION TEE 5/32
4	13	AAQUY-5-5	QUICK UNION Y, 5/32
5	250 FT	AATP4X2MW	TUBING,NYLON,5/32OD
6	2	MM78034PL	INJECTOR,GREEN.015CC
7	22	MM78035PL	INJECTOR,YELLOW.025CC
8	1	MMXGS4024	PUMP,GREASE,24 STATION

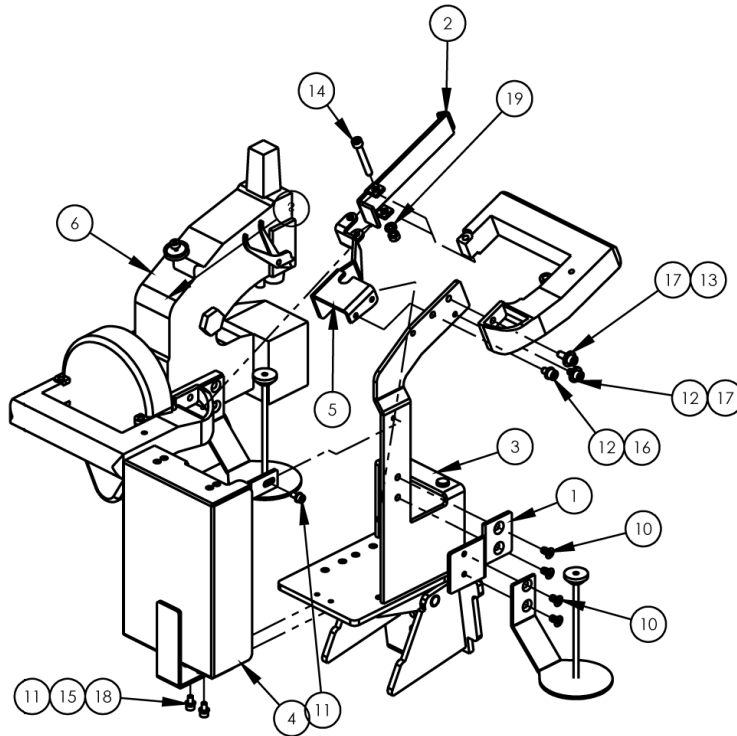


1392580 Bag Closing Mount Assembly

AAC Drawing Number 1392580 Rev 9

NO.	QTY	PART #	DESCRIPTION
1	2	1389066	WLDMT,TICK TRAY SUPPORT
2	1	1389970	STOP BLOCK,30MM RAIL
3	1	1392168	SUPPORT, BAR, BAG CLOSER
4	1	1392600	LIMITER
5	1	1392601	TRACK TRAY
6	1	1392605	END STOP-GUARD
7	1	1392638	BRACKET
8	1	1392959	CLOSER ASSM
9	1	MM331	CLAMP, PULL LATCH
10	1	MMHGR30R3000HN	RAIL,LINEAR, HG 3000MM
11	1	MMHGW30HCZ0HN	LINEAR BEARING
12	1	NNHM8X1.25	M8 X 1.25 HEX NUT
13	9	SSSCM6X10	M6X10 SOC CAP SCREW
14	2	SSSCM6X12	M6X12 SOC CAP SCREW
15	4	SSSCM6X15	M6X15 SOC CAP SCREW
16	1	SSSCM6X45	M6X45 SOC CAP SCREW
17	9	SSSCM8X20	M8X20 SOC CAP
18	4	SSSCM8X25	SCREW,SOC CAP,M8X25
19	1	SSSCM8X35	SCREW,SOC CAP,M8X35
20	6	WWFM6.1	WASHER, FLAT, M6, SAE
21	6	WWLM6	M6 LOCK WASHER
22	1	WWLM8	M8 LOCK WASHER

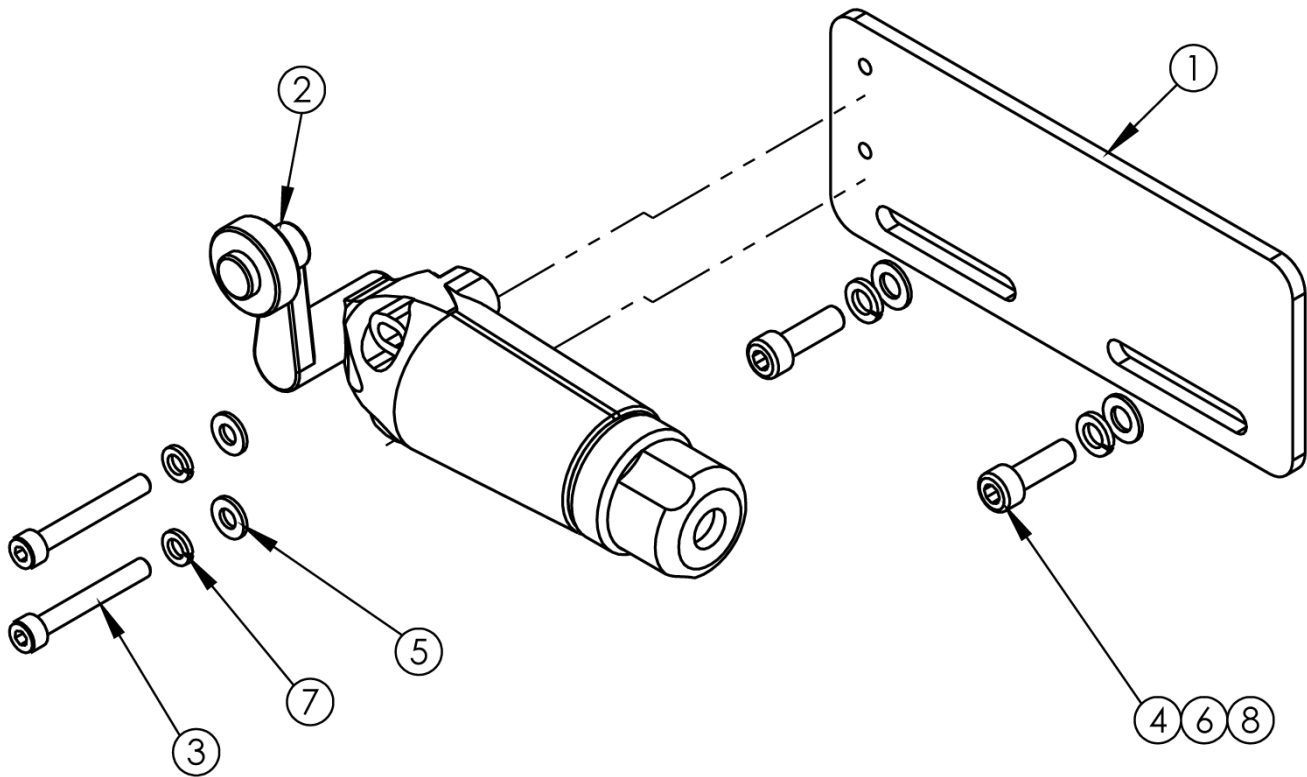
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1392959 Closer Assembly

AAC Drawing Number 1392959 Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1	1388177	POST, THREAD STAND,BC1
2	1	1389228	LATCH, BAG CLOSER
3	1	1392163	SUPPORT, BASE BAG CLOSER
4	1	1392960	GUARD,BELT
5	1	1393836	BRACKET,HANDLE
6	1	BC-1	BORDER CLOSER MACHINE
7	1	FF770018-1	CONN,UML2,PLUG,3POS
8	3	FF770251-3	CONN,UML2,PIN,F,14
9	1	NNHM6X1.0	M6 X 1.0 HEX NUT
10	4	SSFPM6X10	SCREW,FLAT PHILLIPS
11	3	SSSCM5X10	SCREW,SOC CAP,M5-0.8 X 10
12	2	SSSCM6X10	M6X10 SOC CAP SCREW
13	1	SSSCM6X16	M6X16 SOC CAP SCREW
14	1	SSSCM6X45	M6X45 SOC CAP SCREW
15	3	WWFM5	WASHER, FLAT, M5 I.D.
16	1	WWFM6	WASHER, FLAT, M6, SAE
17	2	WWFS1/4	WASHER,FLAT,SAE,1/4
18	2	WWLM5	M5 LOCK WASHER
19	1	WWLM6	M6 LOCK WASHER
20	.17 ft	ZTH3/4B	HEAT SHRINK TUBING

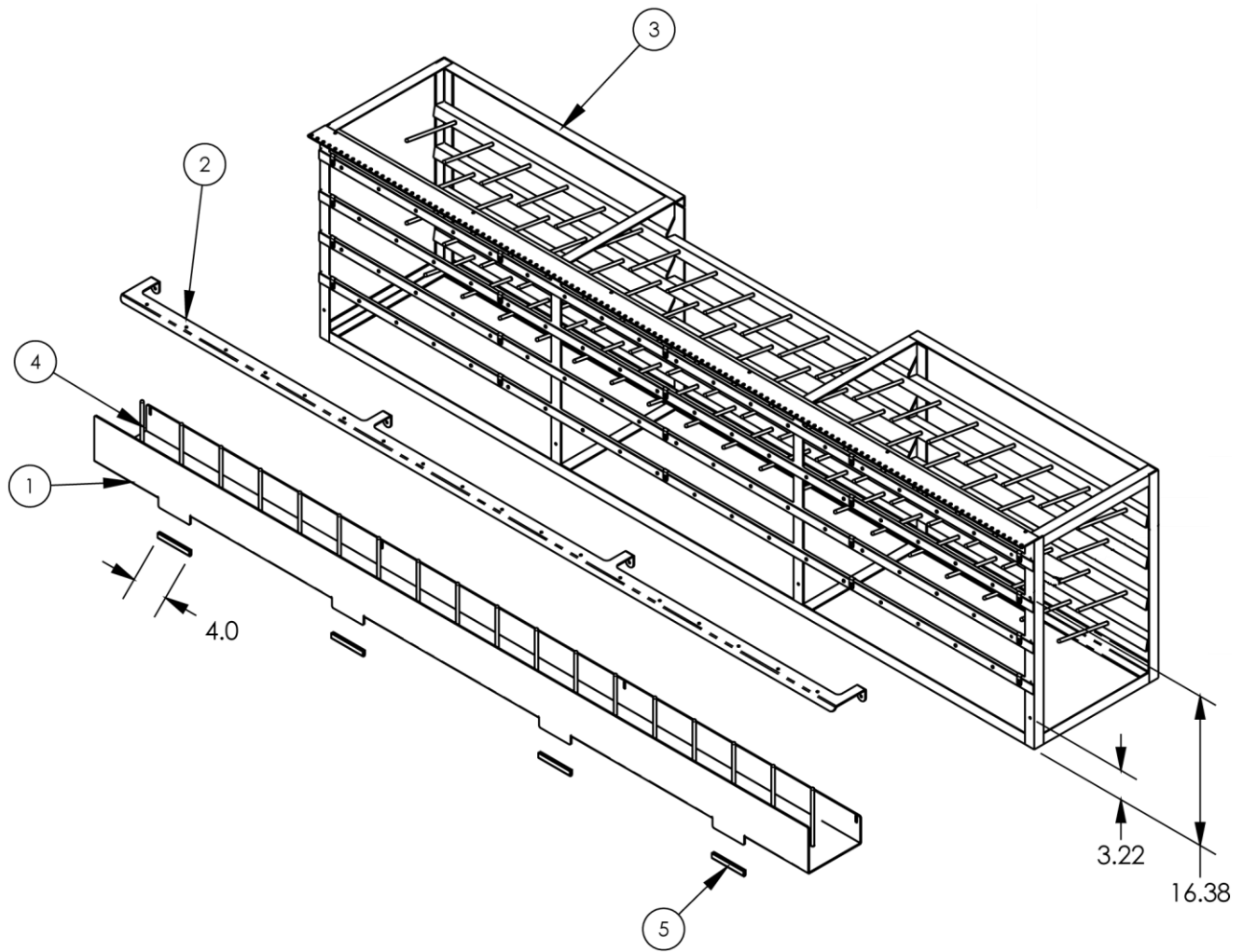


From the library of: Diamond Needle Corp

1392744 Limit Switch Assembly

AAC Drawing Number 1392744 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	2	1392497	BRACKET,LIMIT SWITCH
2	2	FFEVN2000A	LIMIT SWITCH
3	4	SSSCM4X30	SCREW,SOC CAP,M4-0.7X30
4	4	SSSCM5X16	SCREW,SOC CAP,M5-0.8 X 16
5	4	WWFM4.3	WASHER, FLAT, M4
6	4	WWFM5	WASHER, FLAT, M5 I.D.
7	4	WWL8	WASHER,LOCK,#8
8	4	WWLM5	M5 LOCK WASHER

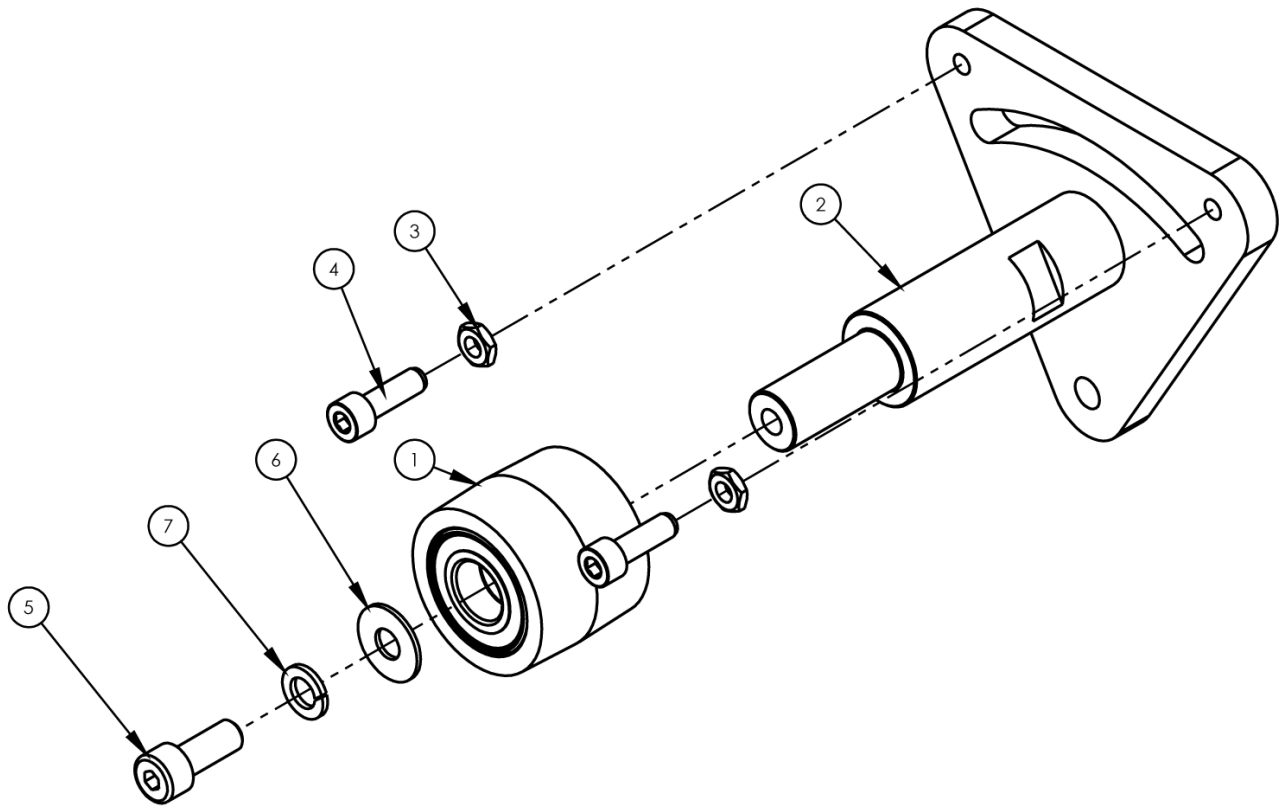


From the library of: Diamond Needle Corp

1392839 Thread Stand (silver eagle)

AAC Drawing Number 1392839 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	1392804	SUPPORT, THREAD
2	1	1392806	GUIDE, THREAD
3	1	1392861	LOWER THREAD RACK
4	18	5-008	SHAFT, THREAD STAND
5	*1.4 ft	MM100-1/8	DOOR TRIM - BLACK

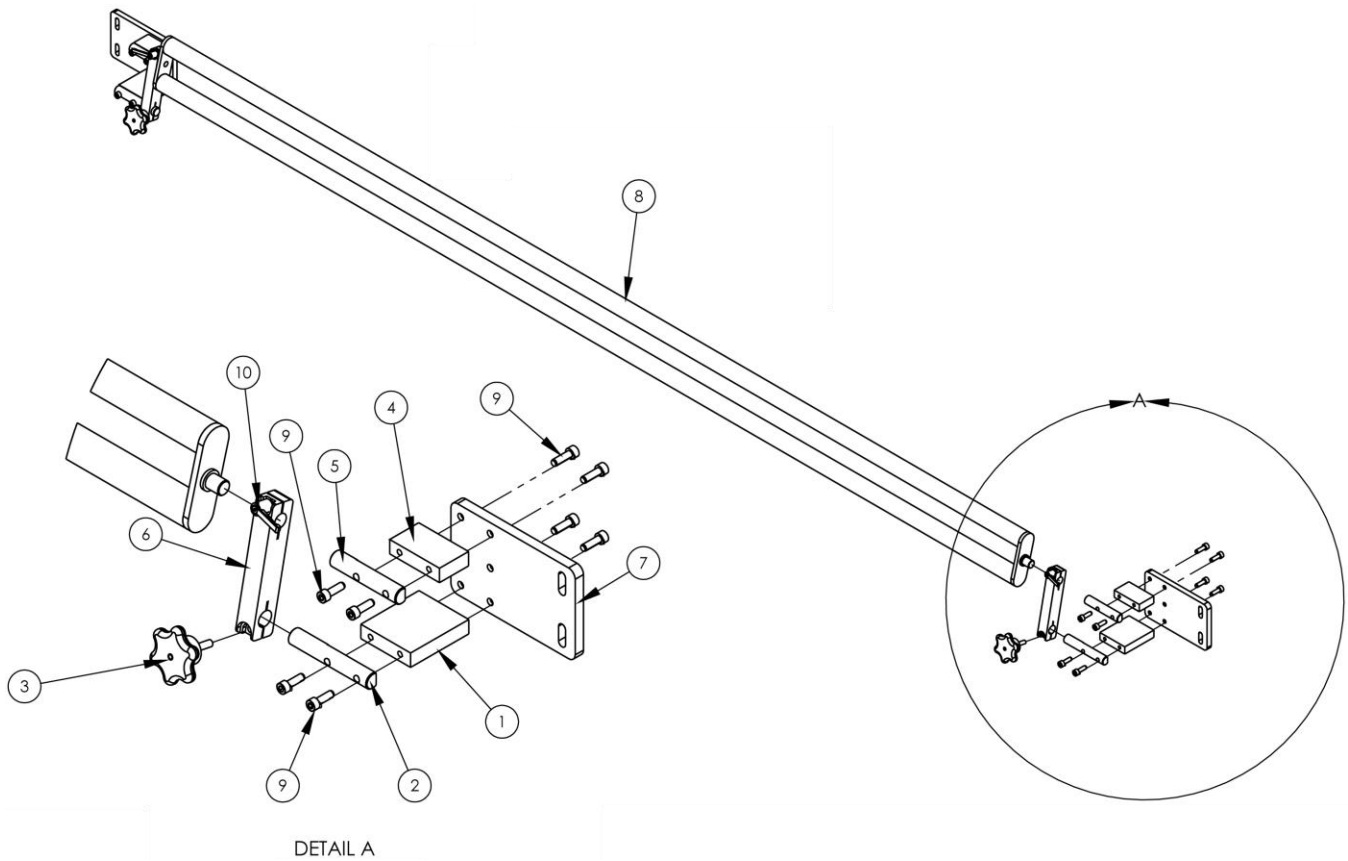


From the library of: Diamond Needle Corp

1392898 Y Axis Drive Idler Assembly

AAC Drawing Number 1392898 Rev 4

NO.	QTY	PART #	DESCRIPTION
1	1	1392501	IDLER, BEARING ASSEMBLY
2	1	1393968	DRIVE, IDLER, WELDMENT
3	2	NNJM8	NUT, JAM, M8, ZINC PLATED
4	2	SSSCM8X25	SCREW, SOC CAP, M8X25
5	1	SSSCM10X25	10M X 25MM, SOC CAP
6	1	WWF3/8	WASHER, FLAT, 3/8 OR 10MM
7	1	WWLM10	M10 LOCK WASHER

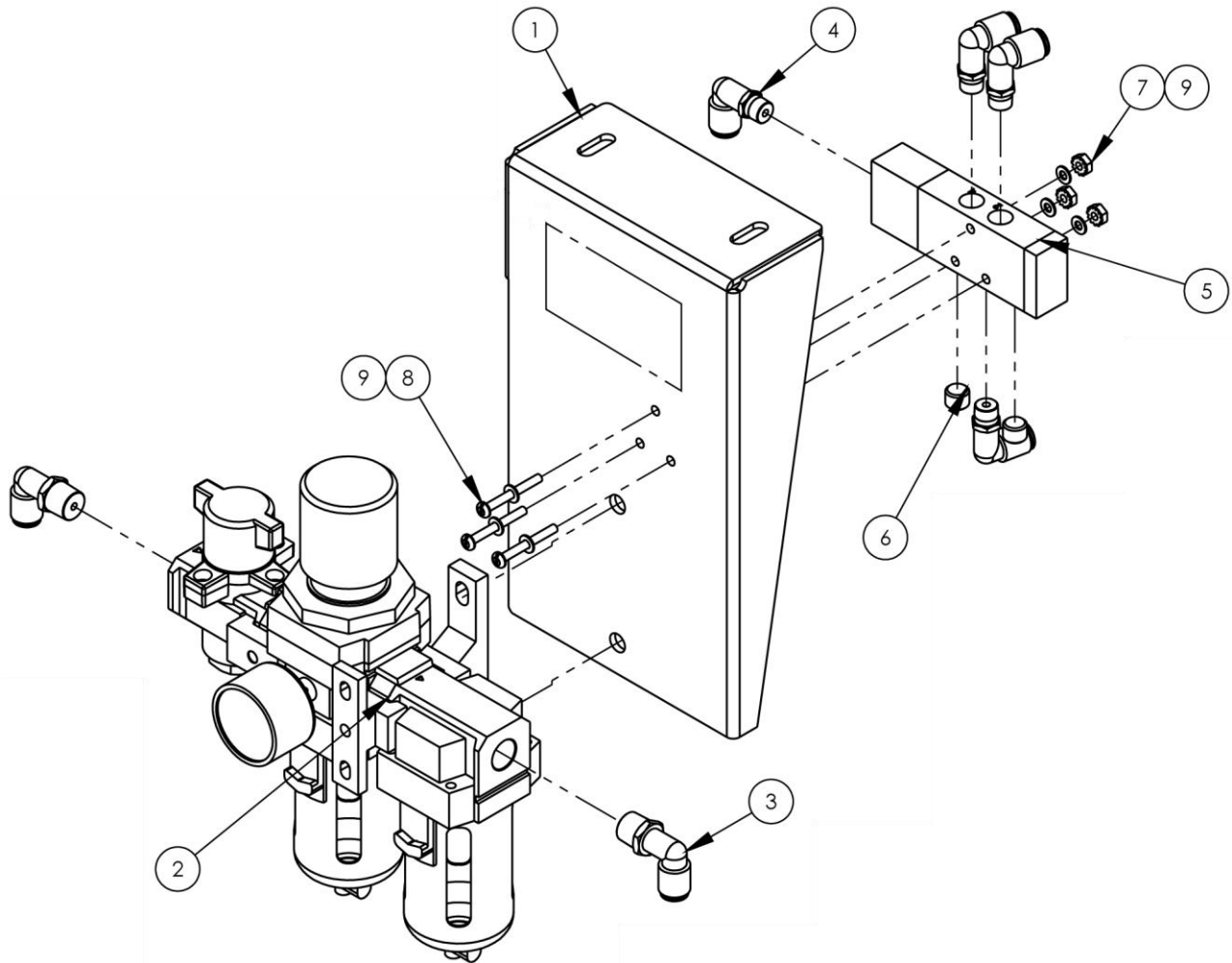


From the library of: Diamond Needle Corp

1393922 Tensioner Assembly

AAC Drawing Number 1393922 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	2	1389188	SPACER,3/4 X 3 X 3-1/2
2	2	1389189	SHAFT,PIVOT,TENSION BARS
3	2	1389469	KNOB,THREADED,M8
4	2	1389522	SPACER,3/4 X 3 X 1-3/4
5	2	1389617	ROD,STOP,TENSION BARS
6	2	1393927	ARM,PIVOT
7	2	1393928	PLATE,TENSION BAR MTG
8	1	3-017	FRONT TENSIONER MOD
9	16	SSSCM8X25	SCREW,SOC CAP,M8X25
10	2	TTH6324K63	HANDLE,THREADED,M8 X 20MM



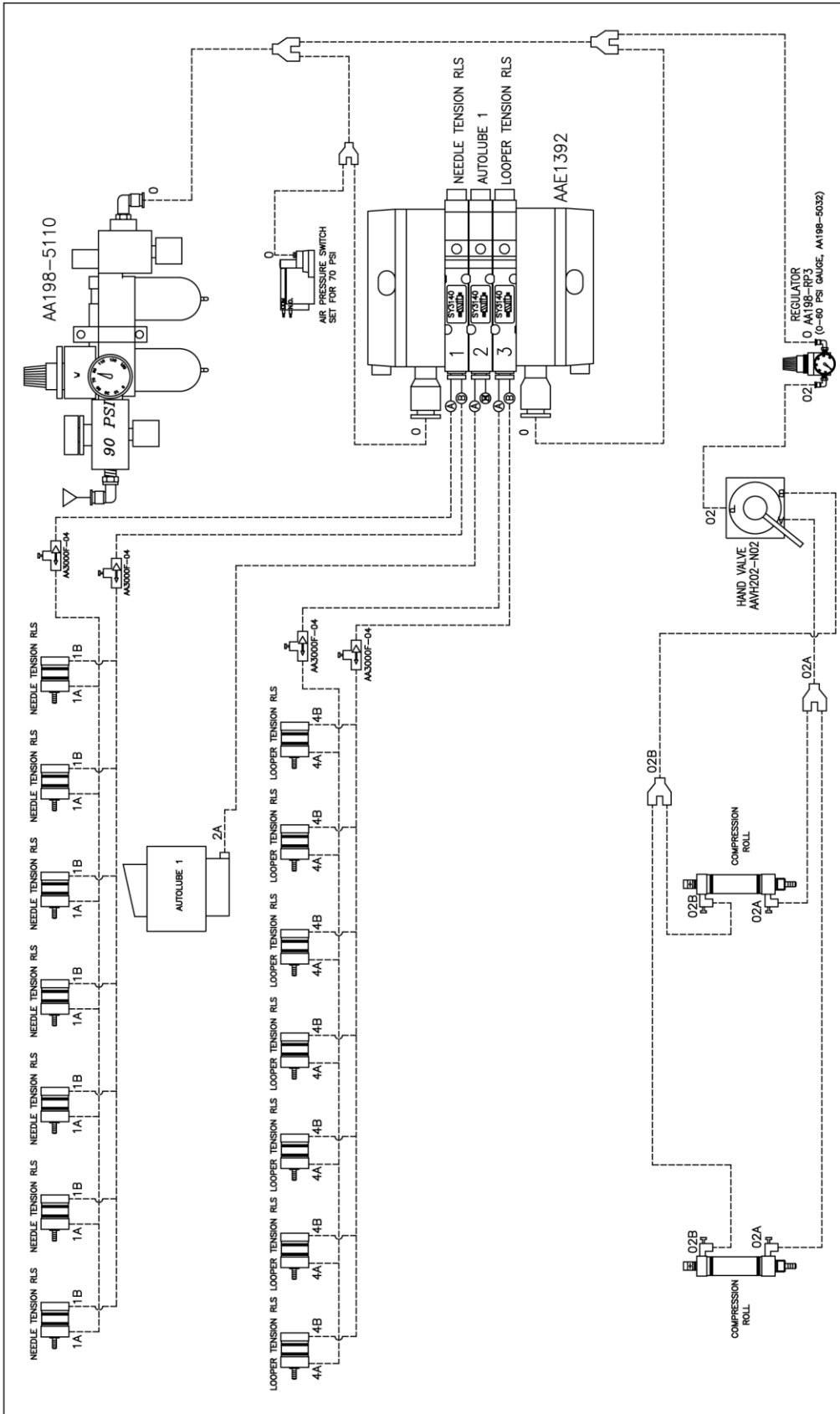
From the library of: Diamond Needle Corp

1393854 Filter/ Air Assembly

AAC Drawing Number 1393854 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	32003033	BRKT,REGULATOR,DUAL
2	1	AA198-5110	FILTER/REGULATOR/LOCKOUT
3	2	AAQME-4-4	ELBOW, MALE,1/4X1/4NPT
4	4	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8
5	1	AAV125B	PILOT VALVE
6	2	MM4554K11	PLUG, 1/8" PIPE
7	3	NNK6-32	KEP NUT, 6-32
8	3	SSPS80080	#6-32 X 3/8 LG PAN HD
9	6	WWFS6	WASHER, FLAT, #6

1392-PD Pneumatic Diagram



QTY.	ITEM RECD. NO.	DESCRIPTION	PART NO.	STOCK SIZE
		ATLANTA ATTACHMENT COMPANY		
		NAME	PNEUMATIC DIAGRAM	
		DR. DES.	SILVER EAGLE	
		MATERIAL	N/A	
		ASSEMBLY	N/A	
		DES. BY	JPP	PART NO. 1392-PD
		DR. BY	JPP	DRAWING NO.
		CK. BY	MATT DASHER	125776C
		SCALE	1/2	DATE 02-07-07 MACH. G.

NO.	REVISION	DATE	DR.	CHK.	DESCRIPTION
					DEFAULTS
					FINISH
					BLACK BENCH
					BLACK OXIDE
					BLACK PHOSPHATE
					BLU
					BLU/CR
					CHROME
					CHROME
					INUSAVE
					CLEAR CHROME

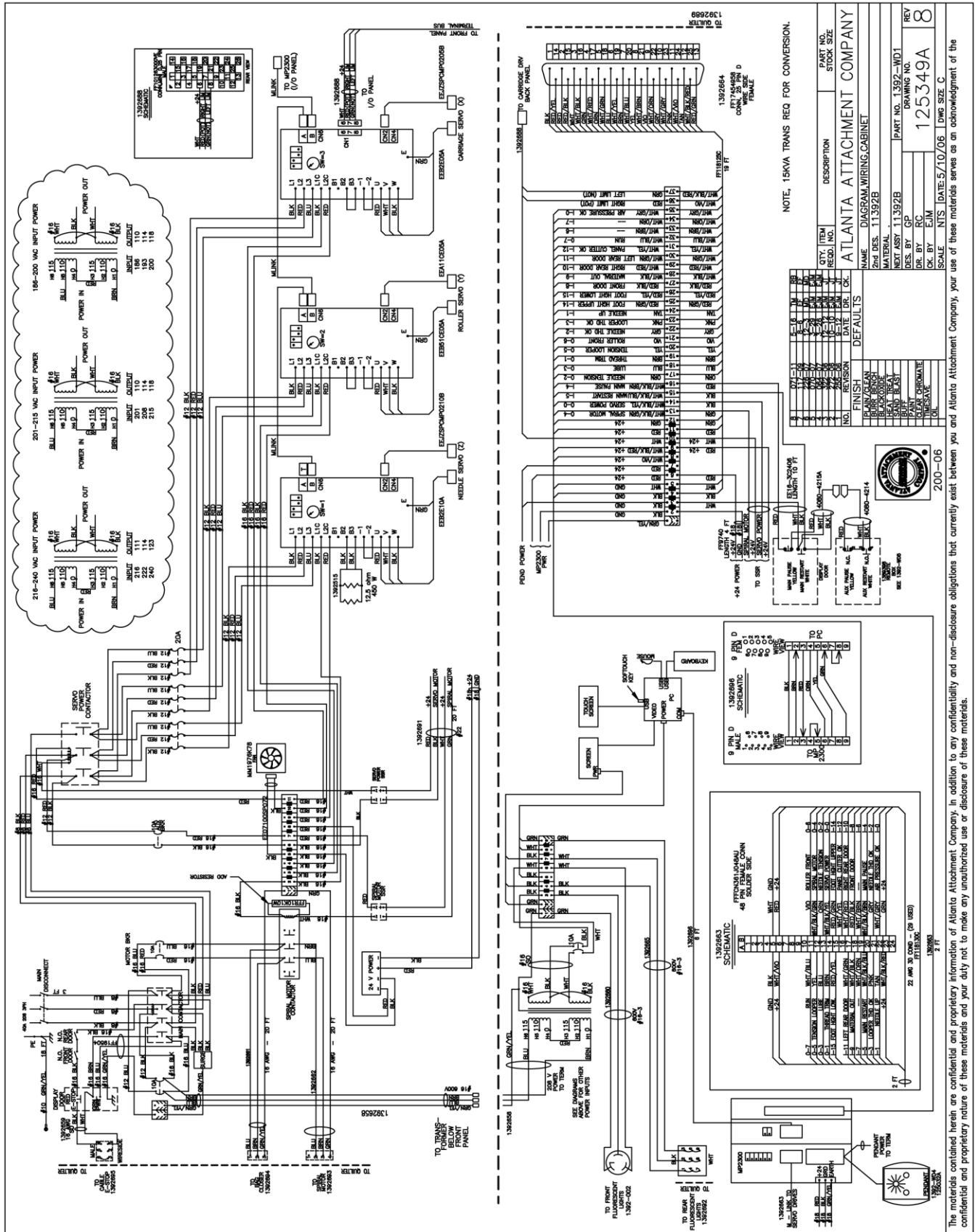


_____ 5/8" AIR LINE
 _____ 1/4" AIR LINE
 _____ 3/8" AIR LINE

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1392-WD1 Wiring Diagram, Cabinet

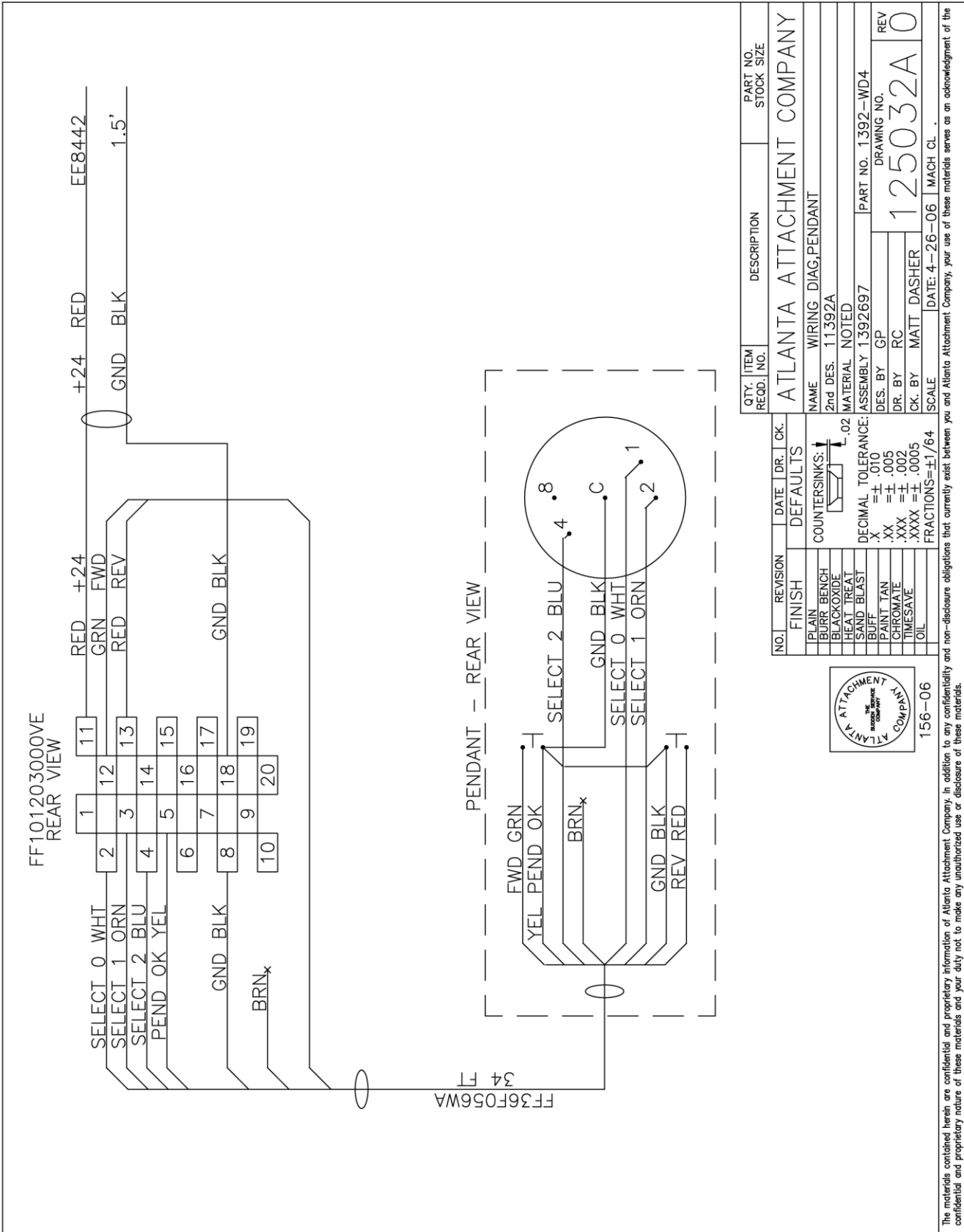


NOTE: 15KVA TRANS REQ FOR CONVERSION.

QTY.	ITEM	DESCRIPTION	PART NO.	STOCK SIZE
1	1392000	DIAGRAM WIRING CABINET		
ATLANTA ATTACHMENT COMPANY				
2nd DES. 11/39/2B				
MATERIAL: 1392000				
REV/ISSY: 1392000				
DES. BY: PC				
CHK BY: EJM				
SCALE: NTS DATE: 5/10/06 DWG SIZE: C				
PART NO. 1392-WD1				
DRAWING NO. 125349A				
REV 8				

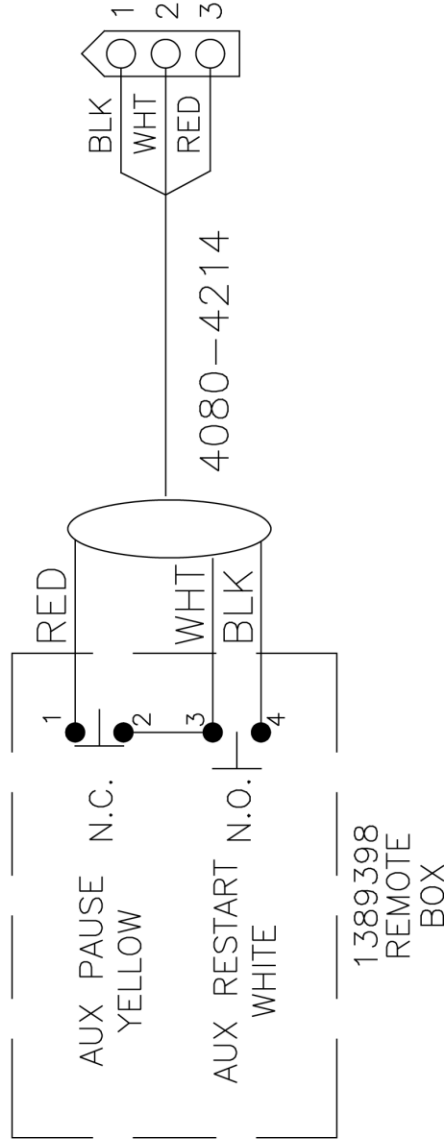
From the library of: Diamond Needle Corp

1392-WD4 Wiring Diagram, Pendant



From the library of: Diamond Needle Corp

1392-WD5 Wiring Diagram, Remote Start/Stop



NO.	REVISION	DATE	DR.	CK.	DESCRIPTION	PART NO.	STOCK SIZE
					ATLANTA ATTACHMENT COMPANY		
					NAME WIRING DIAG.1389398		
					2nd DES. REMOTE START/STOP		
					MATERIAL NOTED		
					ASSEMBLY 1389398	PART NO. 1392-WD5	
					DES. BY PBD	DRAWING NO.	REV
					DR. BY PBD	125491B	0
					CK. BY EJM		
					SCALE	DATE: 2/22/07	MACH CL.
					FRACTIONS=±/64		

NO.	REVISION	DATE	DR.	CK.	DESCRIPTION
					FINISH
					PLAIN
					BURR BENCH
					BLACKOXIDE
					HEAT TREAT
					SAND BLAST
					BUFF
					PAINT TAN
					CHROMATE
					TIMESAVE
					OIL

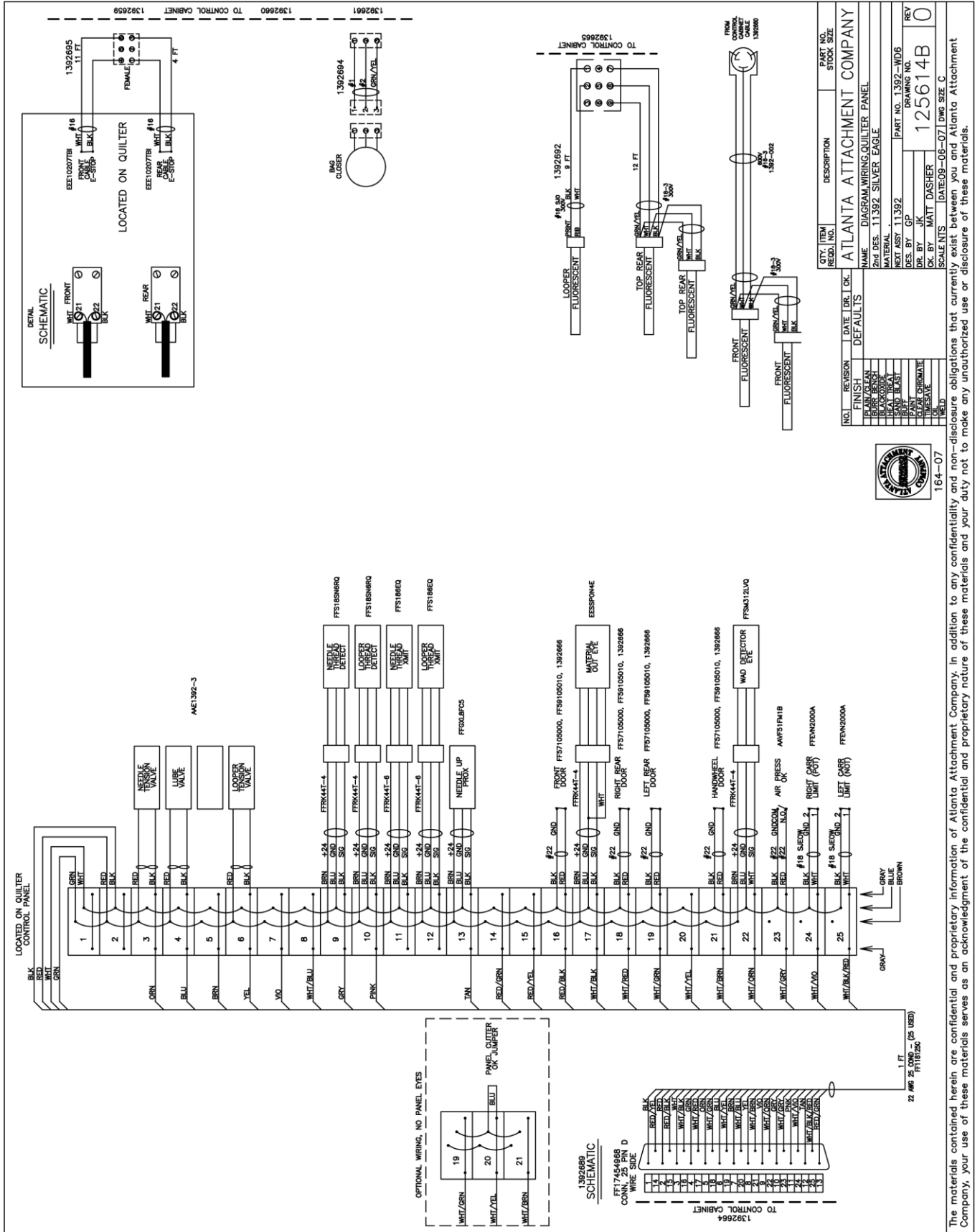
NO.	REVISION	DATE	DR.	CK.	DESCRIPTION
					DEFAULTS
					COUNTERSINKS: ↓
					.02
					DECIMAL TOLERANCE:
					.X =± .010
					.XX =± .005
					.XXX =± .002
					.XXXX =± .0005
					FRACTIONS=±/64

NO.	REVISION	DATE	DR.	CK.	DESCRIPTION
					049-07

ATLANTA ATTACHMENT COMPANY
1389398

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1392-WD6 Wiring Diagram, Quilter Panel



From the library of: Diamond Needle Corp

Atlanta Attachment Company (AAC) Statement of Warranty

Manufactured Products

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

Terms and Conditions:

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

What Is Covered

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

What Is Not Covered

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

Declaración de Garantía

Productos Manufacturados

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

Términos y Condiciones:

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

Lo Que Está Garantizado

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

Lo Que No Está Garantizado

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



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