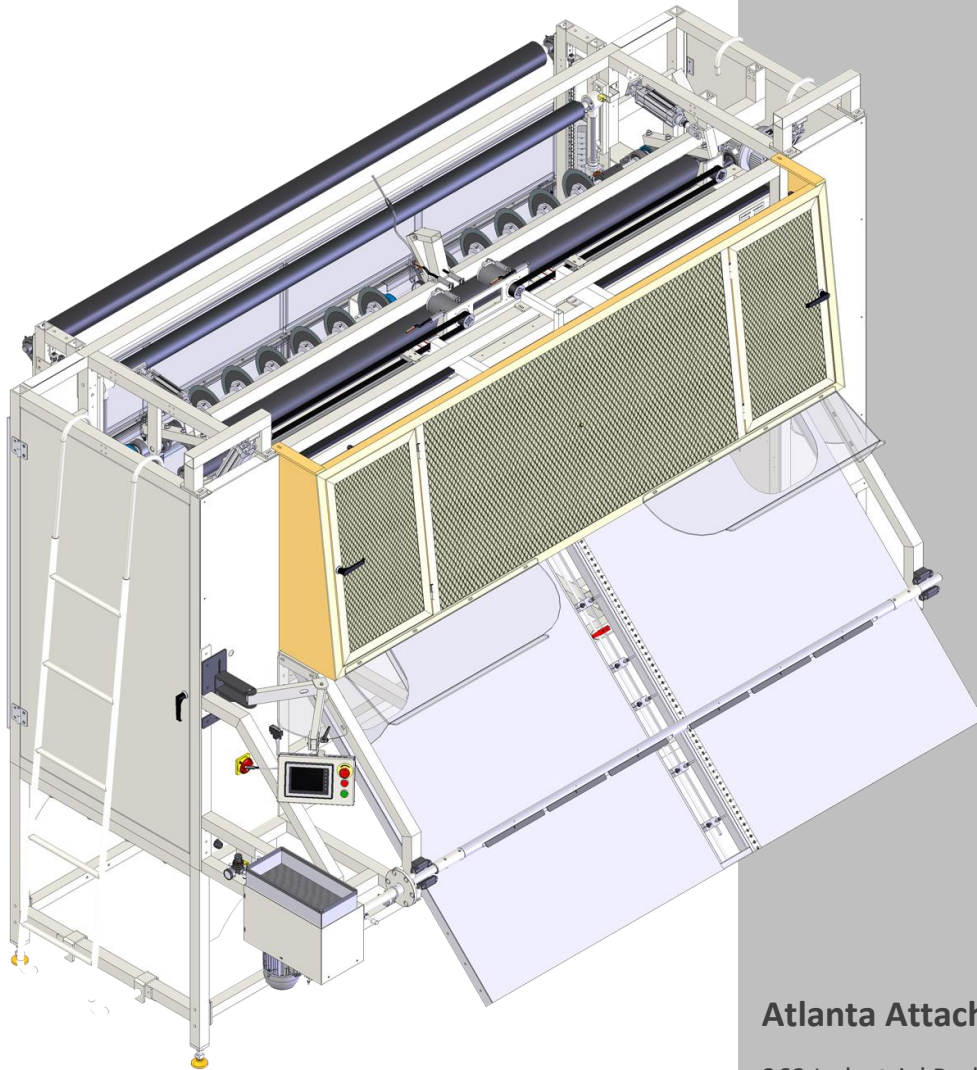




model **1393E**

Revision 2 Updated Oct.8, 2015

# Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

**Atlanta Attachment Company**

362 Industrial Park Drive

Lawrenceville, GA 30046

770-963-7369 • [www.atlatt.com](http://www.atlatt.com)



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## IMPORTANT

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

# Contents

Important Safety Instruction .....	1
Liability .....	2
Safety Equipment on the Machines .....	3
Protective Eyewear .....	4
Important Notices.....	5
Maintenance .....	7
Repair .....	8
A Word to the End User.....	9
Safety Precautions.....	9
1.- INSTALLATION MANUAL.....	10
1.1.- Parts and Components .....	10
1.2.- Technical Data .....	11
1.3.- Installation & Set Up .....	12
2.- OPERATION MANUAL .....	13
2.1 Individual components.....	13
a.- Main Power .....	13
b.- Emergency Stop.....	13
c.- Touch Screen / Control .....	13
d.- Table Lift Operation. ....	14
e.- Panel Width Sensors .....	14
2.2.- Touch Screen .....	15
Main Menu.....	15
2.2.1 Edge Blade Setup & Adjustment Procedure .....	16
a.- Panel Cut Mode .....	18
b.- Border Cut Mode .....	23
c.- Position Trim Blades .....	27
d.- Maintenance Menu .....	30
e.- Panel Cut Batch .....	34
g.- Select Cut length.....	38
h.- Sharpen Blades .....	39
i.- Timer settings menu .....	40
j.- Control Power Start .....	41
k.- POWER OFF / POWER ON.....	41
l.- Control power off .....	41
m.- Load Material in feed roller.....	41
2.3.- Operating .....	42

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c.- Panel Cutting.....	43
d.- Border Cutting .....	43
2.4.- Maintenance.....	44
a.- Daily.....	44
b.- Weekly.....	44
c.- Monthly.....	44
3.- SERVICE MANUAL .....	45
1.- Pneumatic .....	45
1393E Panel Cutter Spare Parts Kit .....	46
XCut Drive Motor Parameters Menu (INV1).....	48
Infeed Drive Motor Parameters Menu (INV2) .....	51
Assembly Drawings & Parts Lists .....	55

# 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 1393E Autopack 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

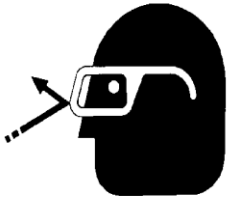
Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.

### 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.

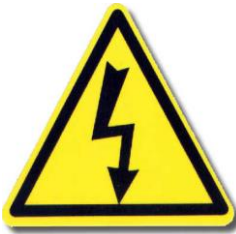
The following fire extinguishers may be used:

- 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.

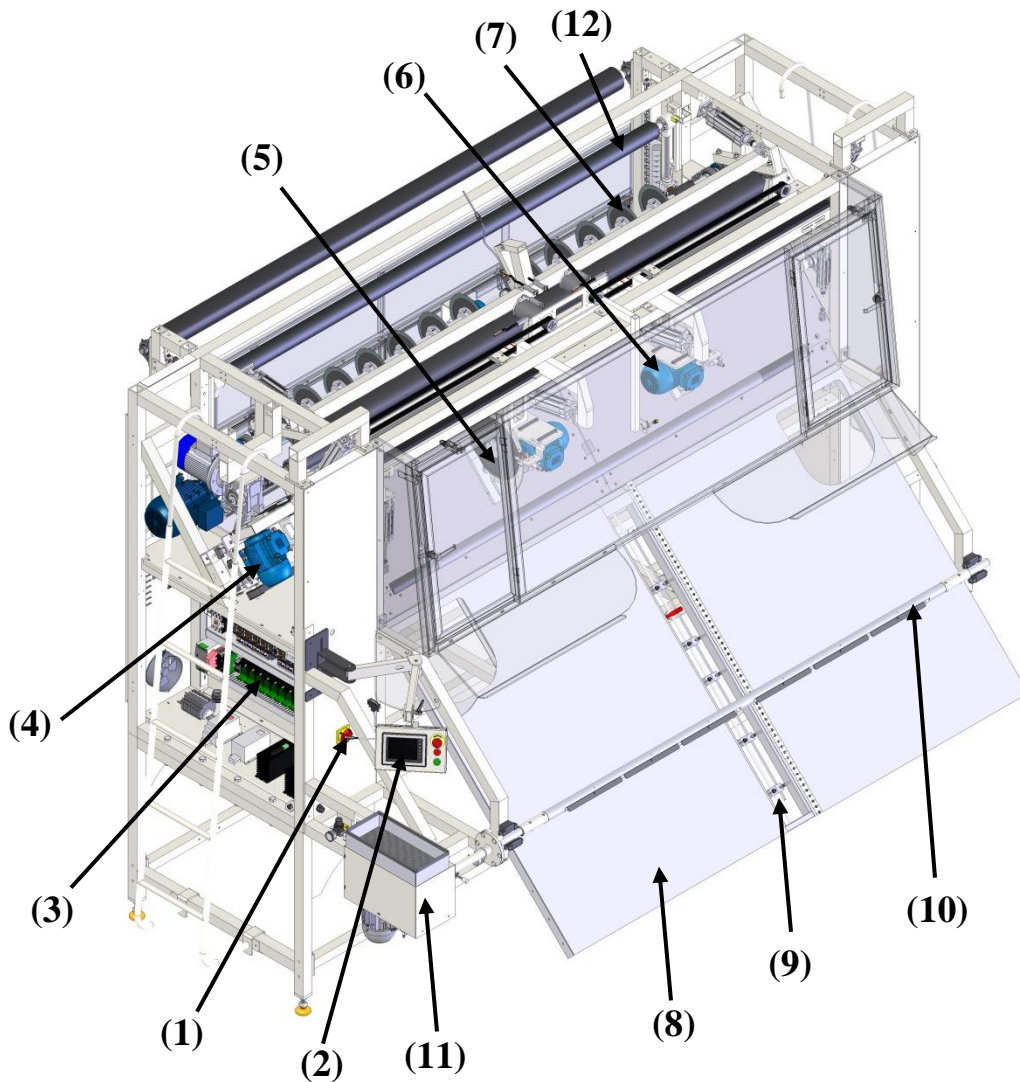


# 1.- INSTALLATION MANUAL



It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating.

## 1.1.- Parts and Components



- 1.- Main Power
- 2.- Touch Screen
- 3.- Control Panel
- 4.- Cross cut

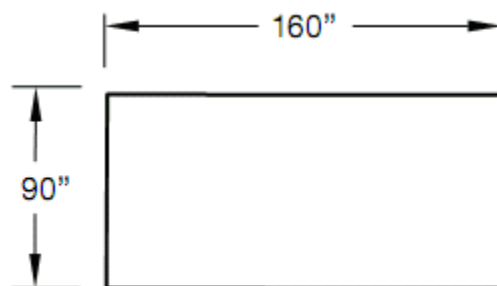
- 5.- Right Edge cut
- 6.- Left Edge cut
- 7.- Slitter knife
- 8.- Panel Table

- 9.- Width Sensors
- 10.- Drive Rod
- 11.- Winder
- 12.- Border Roll

## 1.2.- Technical Data

SPECIFICATIONS	
Max cutting thickness (inch)	1 1/2" (Compressed)
Min cutting thickness (inch)	1/4"
Max cutting width (inch)	102
Min cutting width (inch)	47 3/4
Max length (inch)	84
Min length (inch)	28 1/2
Voltage (v/ph/hz)	220V 3PH 50/60HZ
Current (amps)	20
Air pressure (psi)	80
Air consumption (cfm)	3
Shipping Weight (lbs)	5200
Shipping Dimensions (w/l/h, Inch)	144 x 65 x 78

PRODUCTION	
Output speed (Ft/Min.)	45



Foot Print



## 1.3.- Installation & Set Up



**It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating**

- 1.- Unpack the machine frame and install it with help of crane and forklift.
- 2.- Remove any shipping straps from machine.
- 3.- Inspect the machine for any damage that may have occurred during shipping. If damage is found, report this immediately to your supervisor. Document the damage and provide details and photographs.
- 4.- Install the rollers onto the frame and be sure they can rotate freely.
- 5.- Install the back safety guard onto the frame.
- 6.- Adjoin the inner and outer board and install onto the frame, adjust them to in one plane.
- 7.- Install the front safety guard shield onto the frame.
- 8.- Install the left and right protective shield onto the frame.
- 9.- Adjust all rollers to be sure the midlines of them are parallel.
- 10.- Connect power source and compressed air.



11.- Provide a 220VAC, Three phase, 20 Amp



12.- Provide 3/8" air supply line (90 PSI).

## 2.- OPERATION MANUAL

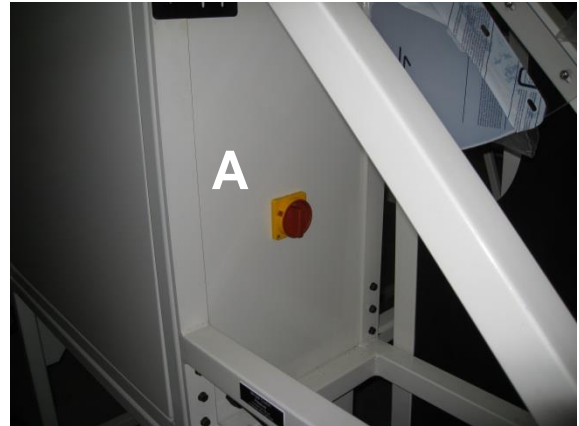


It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating

### 2.1 Individual components

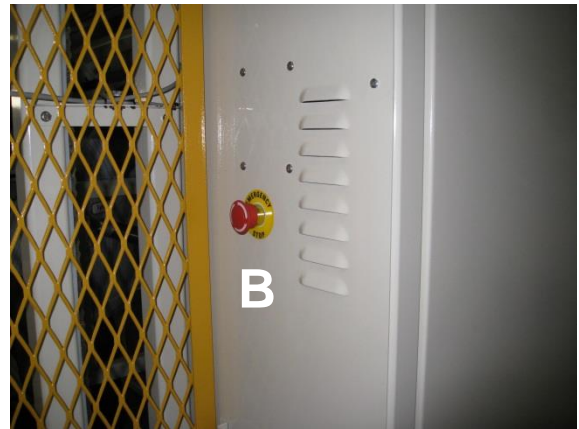
#### a.- Main Power

It is located below the touch screen panel. Is the main power switch ¼ turn to the right will supply power to the machine. This switch has provision to lockout the power when performing maintenance.



#### b.- Emergency Stop

There are red push buttons located in 4 places around the machine. After pushing it the machine will be disconnected from the energy source. You will need to turn the knob 1/8 revolution before reactivating the power



#### c.- Touch Screen / Control

1.- Emergency Stop - This button serves the same function as the other 3 red “E-Stop” push buttons located on each of the four corners of the machine.

2.- Power Off – Push off button for turning off power to the control panel and the machine.

3.- Power On – Activates main power to the control panel and machine (not control power)



### d.- Table Lift Operation.

This allows the operator to select the position of the out-feed table. If “Table Lift Up” is selected, the table will lift and lock in place for cutting panels. If “Table Lift Down” is selected, the table will lower to allow the windup roller to be used to wind up material. This option is available on 3 different menu screens. (Panel Mode, Border Mode, & Maint. Menus)



### e.- Panel Width Sensors

These sensors are what determine the width of the panel being cut. The top sensor is for Twins, the 2<sup>nd</sup> for Fulls, The 3<sup>rd</sup> for Queens, The 4<sup>th</sup> for Cal Kings, and the bottom for Kings. These sensors are only active when in the Panel mode with the table in the UP position. The scale next to the sensors is the actual width of the panel being cut. When switching to a different thickness of panel the widths can be adjusted by moving the lever at the right of the table.

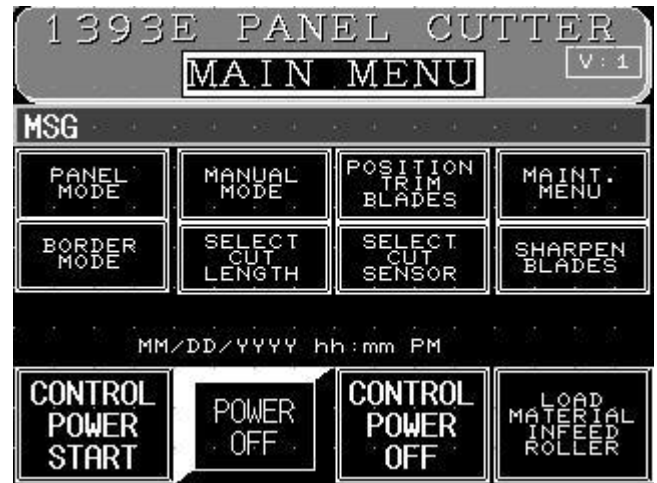


## 2.2.- Touch Screen

### Main Menu

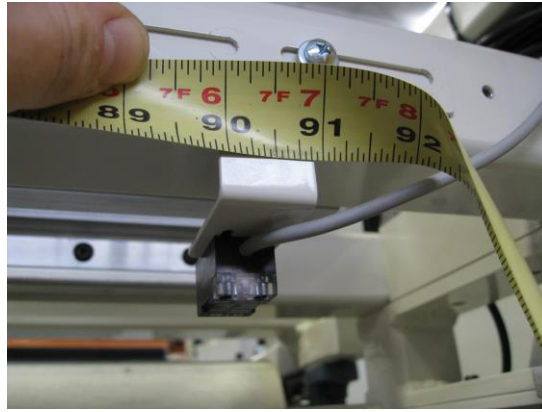
This menu is displayed at the startup of the machine. Press any of the frames in the screen and you will be transfer to the following sub-menu

- PANEL MODE
- BORDER MODE
- MANUAL MODE
- SELECT CUT LENGTH
- POSITION TRIM BLADES
- SELECT CUT SENSOR
- MAINTENANCE MENU
- SHARPEN BLADES
- CONTROL POWER START
- POWER ON/OFF INDICATOR
- CONTROL POWER OFF
- LOAD MATERIAL IN FEED ROLLER

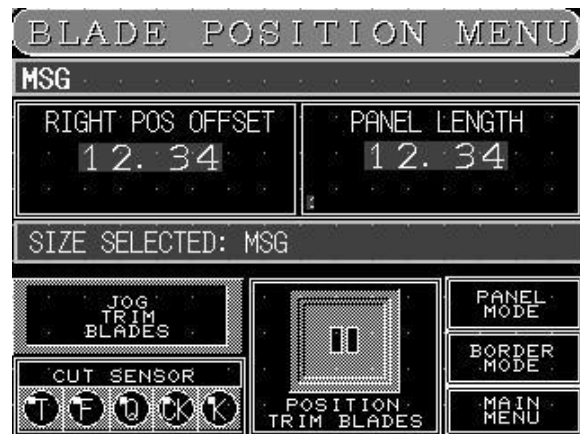
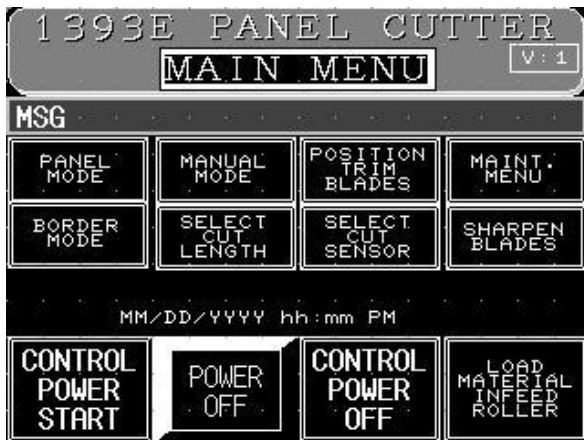


## 2.2.1 Edge Blade Setup & Adjustment Procedure

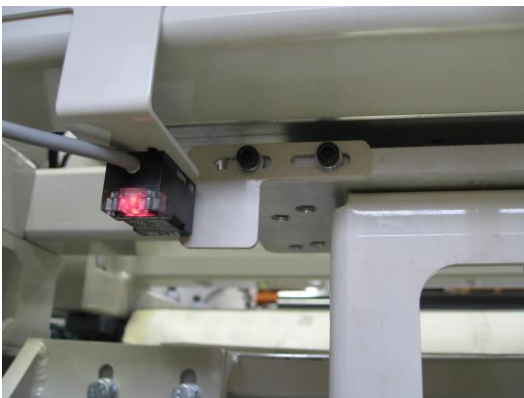
- 1) Set the center distance between the LEFT and RIGHT edge trim blade home position proximity switches to 90.5" (2300mm)



- 2) On the touchscreen menu.....Select Blade Position. Set a Left Offset value to 5.00" (127mm) and Cut Length value to 85.00" (2159mm).

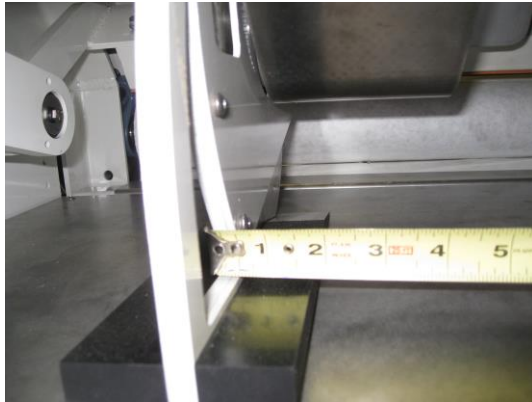


- 3) Press the Blade Position button. As soon as the edge trim blades are at the LEFT and RIGHT home position proximity switches press the E-Stop button. YOU WILL HAVE ONLY A FEW SECONDS TO HIT THE E-STOP. If the trim blades come off the proximity switches, then retry again.





- 4) Assuming Step 3 was completed correctly, measure the center distance (blade to blade) between the blades. It should measure 90.5" (2300mm).



- 5) If the distance between the blades is not 90.5" (2300mm) recheck the center distance between the home left and right home position proximity switches. Move the proximity target / flag on each edge trim blade in the direction needed to get 90.5" (2300mm) and repeat Steps 3 & 5 until the distance between the blades measure 90.5" (2300mm).




- 6) Once Step 5 is completed, return to the Blade Position menu and confirm your settings from Step 2 are still 5.00" (127mm) and 85.0" (2159mm). If these values have changed please reset to 5.00" (127mm) and 85.0" (2300mm).
- 7) Press the Blade Position button and measure the distance between the blades to confirm a cut length of 85.0" (2159mm). If they are off, adjust the edge trim proximity target / flag and repeat Step 7 again.

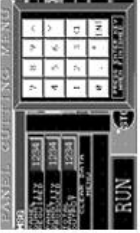
# a.- Panel Cut Mode

## Only on machine with Batch Mode Function

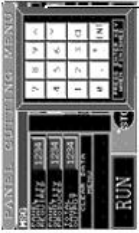
1.- [PANEL QUANTITY REQUIRED] For the selection of the amount of panel you will need




2.- [PANEL QUANTITY PRODUCE] Number panels ALREADY produce




3.- [TOTAL PANELS OUTPUT]




4.- [CLEAR DATA MENU] To erase the data on the 3 top screens.



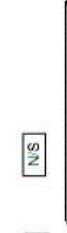
5.- [ACTIVE CUT SENSOR] Refer to the sensors locale on the cutting table. The highlight field is the active one. [T]:Twin [F]:Furi [Q]:Queen [K]:California King [K] King



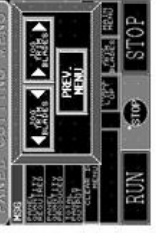
6.- [PANEL CUT LENGTH]




7.- [FINISH PANEL]



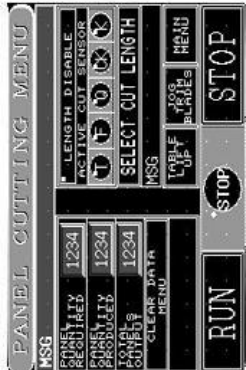
8.- [JOG BLADES]




9.- [MAIN MENU] Return to main menu



a.- [PANEL CUTTING MENU].



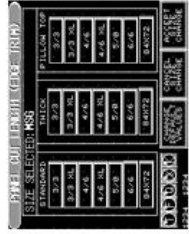
After pressing any of the number fields you will get a key board where you can set the value required. Press enter key when finish with the value.



[CLEAR PANEL QTY PRODUCE]

[CLEAR TOTAL PANEL OUTPUT].

[PREV MENU]




This screen is divide in 3 main columns.  
STANDARD for xxxx  
PILLOW TOP for xxxx  
The highlighted fields are the ones active at this time.

6.1 [CHANGE CUT SIZE SETTINGS] after pressing this field the screen STANDARD PANEL CUT SIZES is show. You will get all the actual dimensions the panels' sizes

STANDARD PANEL CUT SIZE SETTINGS		MIN	TWIN XL	FUR	PULL &
LENGTH		12.34	12.34	12.34	12.34
WIDTH		12.34	12.34	12.34	12.34
DOWN		12.34	12.34	12.34	12.34
DOWN		12.34	12.34	12.34	12.34
DOWN		12.34	12.34	12.34	12.34
DOWN		12.34	12.34	12.34	12.34

6.1.1.- To change dimensions, press on top of the number and modify the values.



6.1.2.- [EDIT PUSH SETTINGS] to change the rest of the sizes.


6.1.3.- [EDIT PILLOW TOP SETTINGS] to change the rest of the sizes.

6.1.4.- [RETURN TO CUT LENGTH MENU] to exit the

6.2 [CANCEL SIZE CHANGE]. return to the original values

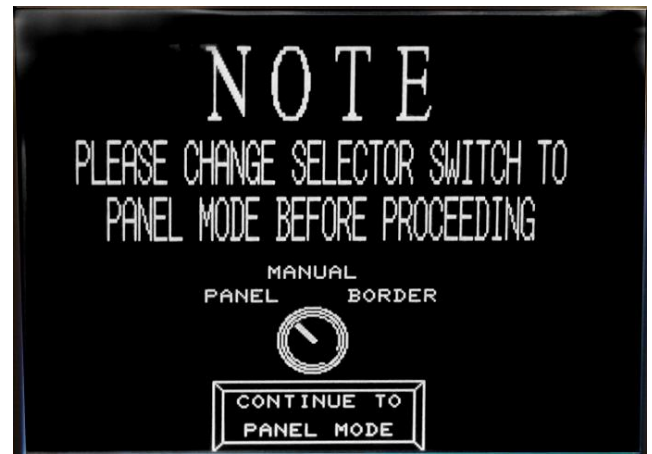
6.3 [ACCEPT SIZE CHANGE] record any change made on dimensions

**NOTE**  
TO MAKE THE CUT LIGHTER OR DARKER, YOU MUST PLACE THE BLADE POSITION SELECTOR SWITCH FROM 'OFF' TO 'POSITION OFF'



Starting at Main Menu

- Select **PANEL CUT MODE** from the Main Menu screen
- You will get a NOTE Screen
- Manually change the position of the Selector to PANEL
- Press **CONTINUE TO PANEL MODE**



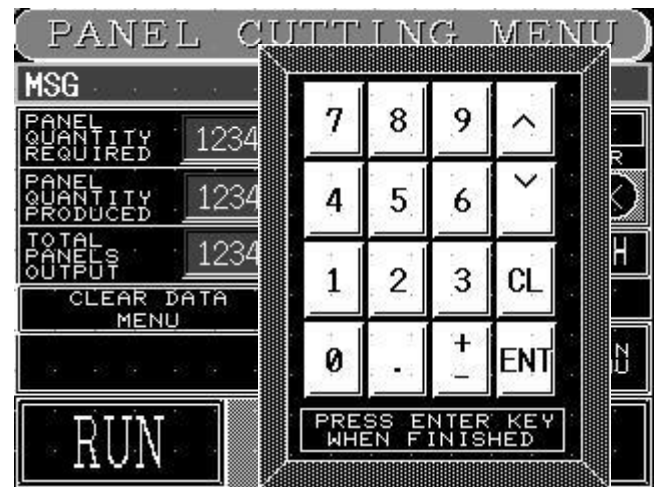
PANEL CUTTING MENU:

**1.- PANEL QUANTITY REQUIRED**

Enter the number of panels to cut. Machine will stop automatically when that number is reached.



After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.

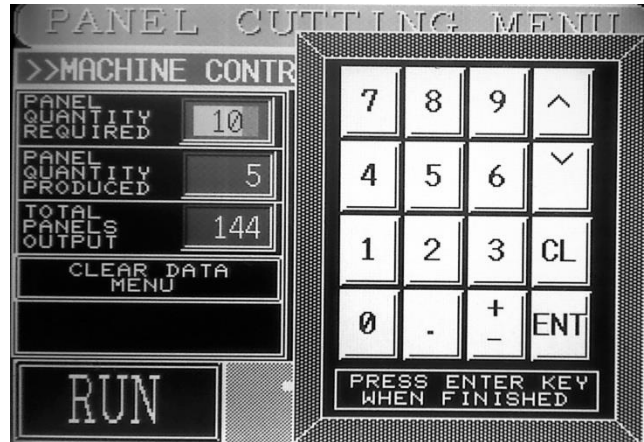




## 2.- PANEL QUANTITY PRODUCED

The number of panels ALREADY produced since that number was last cleared.

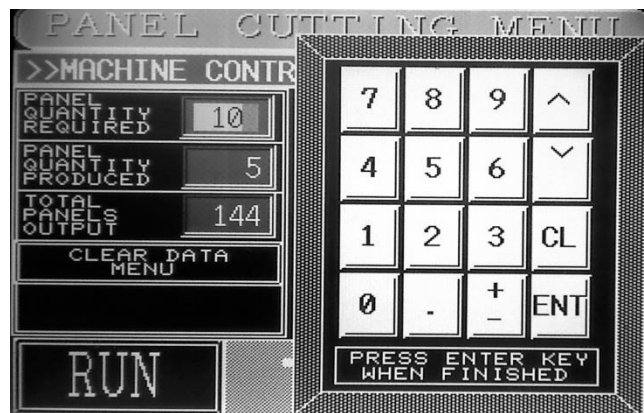
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



## 3. TOTAL PANELS OUTPUT

The number of panels produced since the total output number was last cleared.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



## 4. CLEAR DATA MENU

To erase the data on the 3 top screens.

You will get 3 options:

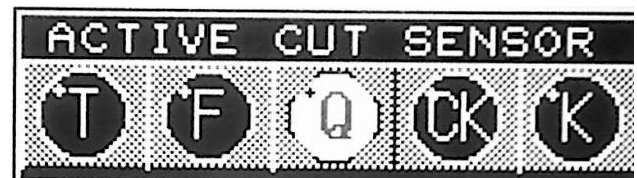
- CLEAR PANEL QTY PRODUCED
- CLEAR TOTAL PANEL OUTPUT
- PREV MENU



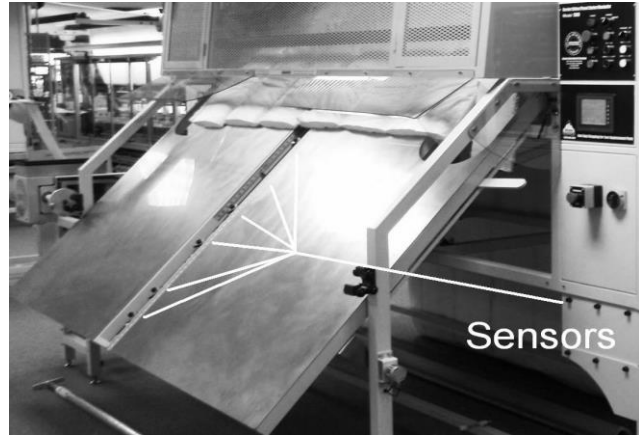
## 5. ACTIVE CUT SENSOR

Refers to the sensors located on the cutting table. The highlighted field is the active one.

[T]: Twin [F]: Full [Q]: Queen [CK]: California King [K] King



Location of the sensors on the panel table.



After pressing the blank space you will get the



### 6. PANEL CUT LENGTH screen

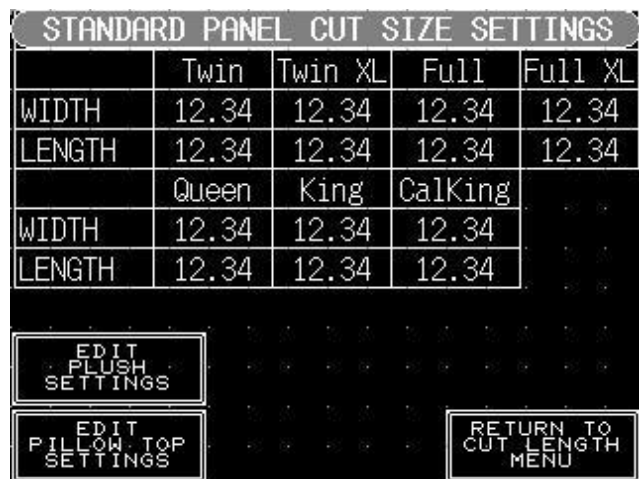
This screen is divided in 3 main columns.

- STANDARD for normal thickness.
- PLUSH for thick panels.
- PILLOW TOP for extra thick panels.

The highlighted fields are the ones active as this time.



**6.1 CHANGE CUT SIZE SETTINGS** after pressing this field the screen STANDARD PANEL CUT SIZES is shown. You will get all the actual dimensions of the panels' cut sizes.



6.1.1- To change dimensions, press on top of the number and modify the values



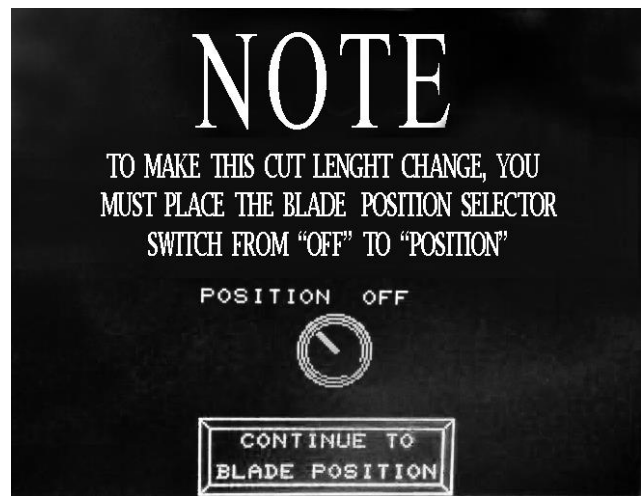
6.1.2- **EDIT PLUSH SETTINGS** to change the rest of the sizes.

6.1.3- **EDIT PILLOW TOP SETTINGS** to change the rest of the sizes.

6.1.4.- **RETURN TO CUT LENGTH MENU** to exit the screen

6.2 **CANCEL SIZE CHANGE** return to the original values.

6.3 **ACCEPT SIZE CHANGE** record any change made on dimensions



7.- **FINISH PANEL** allows operator to finish the panel that is presently in the machine.

8.- **JOG BLADE** allows the operator to jog both side trim blades equally in either direction to allow for shifting of the quilted material without changing the dimension.

9.- **MAIN MENU** Return to main menu





## b.- Border Cut Mode

b.- [BORDER CUT MODE]



1.- [BORDER YARDAGE REQUIRED] pressing the number field you will get a keyboard were you can change the numbers of piecas to be produce

2.- [CURRENT YARDAGE OUTPUT]

3.- [COMBINED YARDAGE OUTPUT]

4.- [CLEAR DATA MENU]

5.- [ENTER "0" TO DISABLE ENCODER]

6.- [BLADE ADJUST START]

7.- [BLADE ADJUST FINISH]

8.- [TABLE LIFT DOWN]

9.- [SLITTERS DISABLE]

10.- [WINDER DISABLE]

11.- [TRIM BLADES HOME]

12- [MAIN MENU] Return to Main Menu

13.- [RUN]

14.- [STOP]



Blink

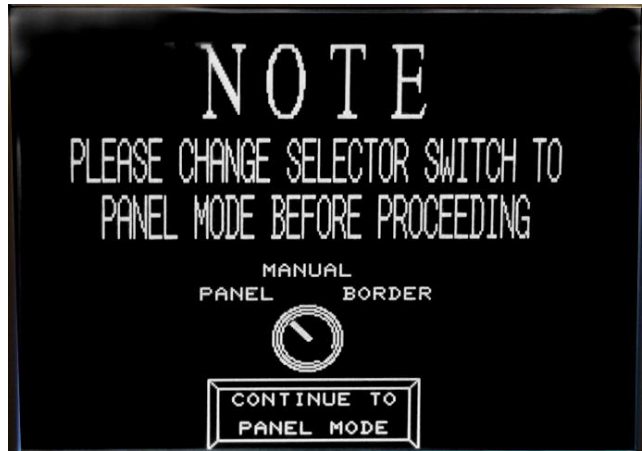
Blink

Blink

N/S

Starting at Main Menu

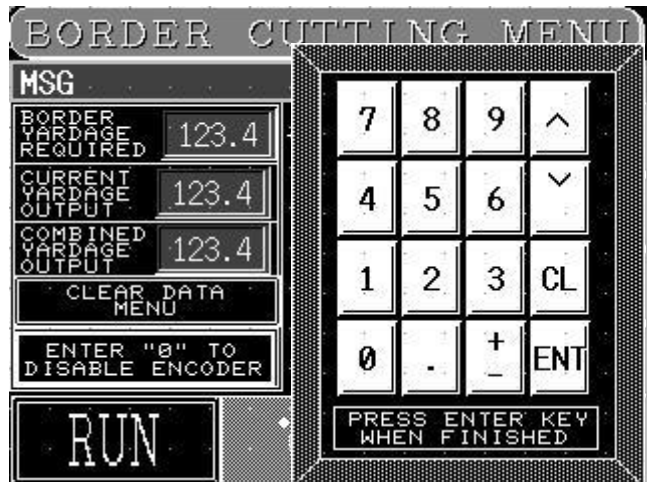
- Select **BORDER CUT MODE** from the Main Menu screen
- You will get a NOTE Screen
- Manually change the position of the Selector to BORDER
- Press **CONTINUE TO BORDER MODE**



After pressing **BORDER CUT MODE** from the MAIN MENU you will arrive to the **BORDER CUTTING MENU**



1. - **BORDER QUANTITY SET** pressing the number field you will get a keyboard were you can change the numbers of pieces to be produced. It is important to note that the machine will do a cross cut at the desired length of border. To deactivate the measuring function set the quantity to zero.



## 2.- BORDER QUANTITY PRODUCED

This is the number of preselected border lengths produced since this value was last cleared.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.

## 3- TOTAL BORDER OUTPUT

This is the total number of border lengths produced since this value was last cleared.

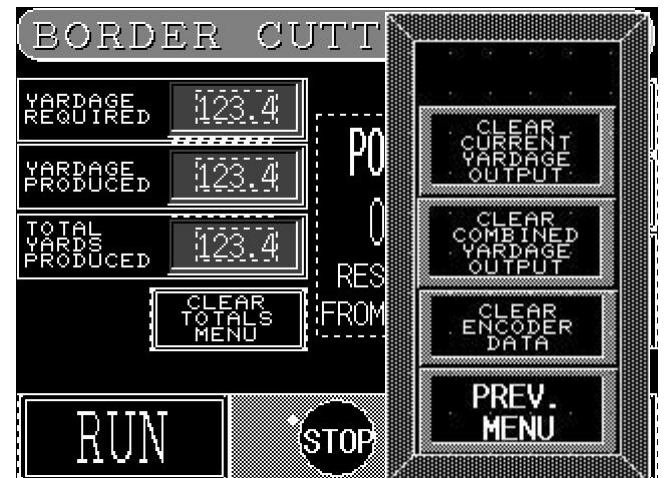
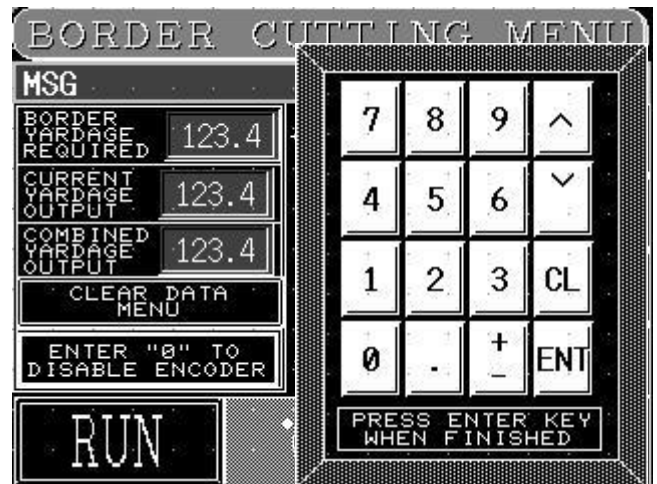
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.

## 4- CLEAR DATA MENU

To erase the data on the 3 top screens.

You will get 4 options:

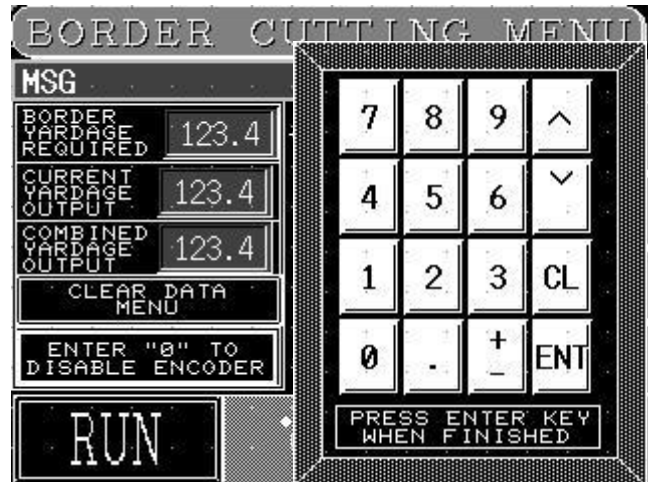
- CLEAR BORDER QTY PRODUCED.
- CLEAR TOTAL BORDER OUTPUT.
- CLEAR ENCODER.
- PREV. MENU.



### 5- BORDER CUT LENGTH

This is to set the length of border to be produced. When this length is reached the border will be cross cut. The units are in inches.

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



### 6- BLADE ADJUST START

When you press this button it will start blinking and the slitters will disable and the material will feed forward until the dancer bar reaches the upper sensor. At this position the operator will have access via the front access doors to reposition the slitter blades as desired. Note: When the access doors are opened the power will automatically shut off to the motors to prevent any possibility of the power being inadvertently turned on to the slitters while the operator is making adjustments.

### 7- BLADE ADJUST FINISH

When the operator is finished adjusting the blades he/she will have to reset the power on button in the Main Menu to re-energize the panel. Once the power is on, press Border Mode. In the Border Mode select Blade Adjust Finish and the material will reverse feed until the dancer bar returns to the middle position. Note: if it is necessary to feed more material through to get back to where the slitters were reset this will have to be done in the Manual mode.

### 8- SLITTERS DISABLE

When this button is pressed the IN-FEED guide roller will lift to prevent the border from coming in contact with the slitters. This is useful if rolling border to be slit at a later date.

### 9- WINDER DISABLE

When this button is pressed the winder will be disabled. This is useful if slitting border into a box rather than winding it on a roll.

### 10- BORDER LENGTH SINCE LAST CUT

The distance in inches since the cross cut was last activated.

### 11- MAIN MENU Return to Main Menu

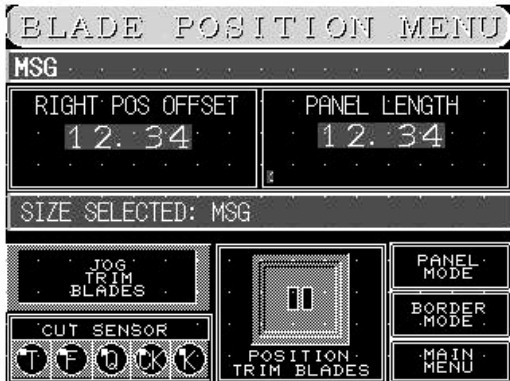
### 12- RUN Machine will start running on this mode

### 13- STOP Machine will Stop

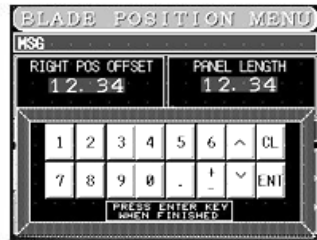


## c- Position Trim Blades

c.- [POSITION TRIM BLADES]



1.- RIGHT POS OFFSET



2.- PANEL LENGTH



3.- SIZE SELECT



4.- CUT WIDTH

N/S

5.- CUT SENSOR. Press Letter and size will be highlighted



6.- POSITION TRIM BLADES

7.- CONTROL POWER START

8.- MAIN MENU





Starting at Main Menu

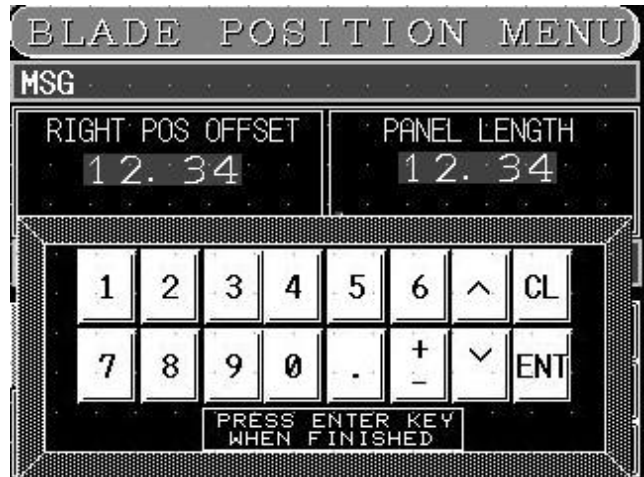
Press **POSITION TRIM BLADES** you will get the **BLADE POSITION MENU** screen.



**1.- RIGHT POSITION OFFSET**

This sets the distance from the right side (near the touch screen) that the trim knife will be set.

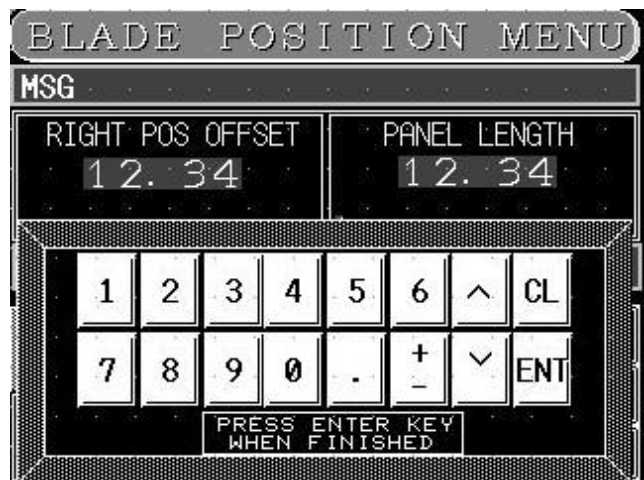
After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



**2.- PANEL LENGTH**

This sets the actual length of the panel to be cut (the distance between the two trim knives)

After selecting a number field a number pad will come up. Enter the desired number and select ENT to enter that number in the desired location.



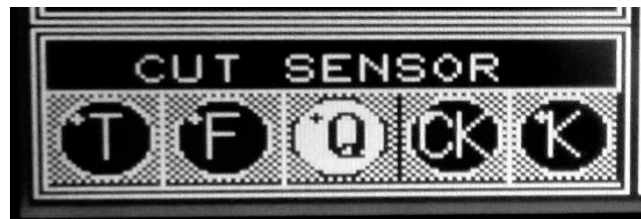
**3.- SIZE SELECT.**

This is useful to select a preset cut setting for a desired panel length.



**4.- CUT WIDTH** Show the value of the actual cut width according to the width sensor selected.

**5.- CUT SENSOR** Press Letter and size will be highlighted



**6.- POSITION TRIM BLADES**

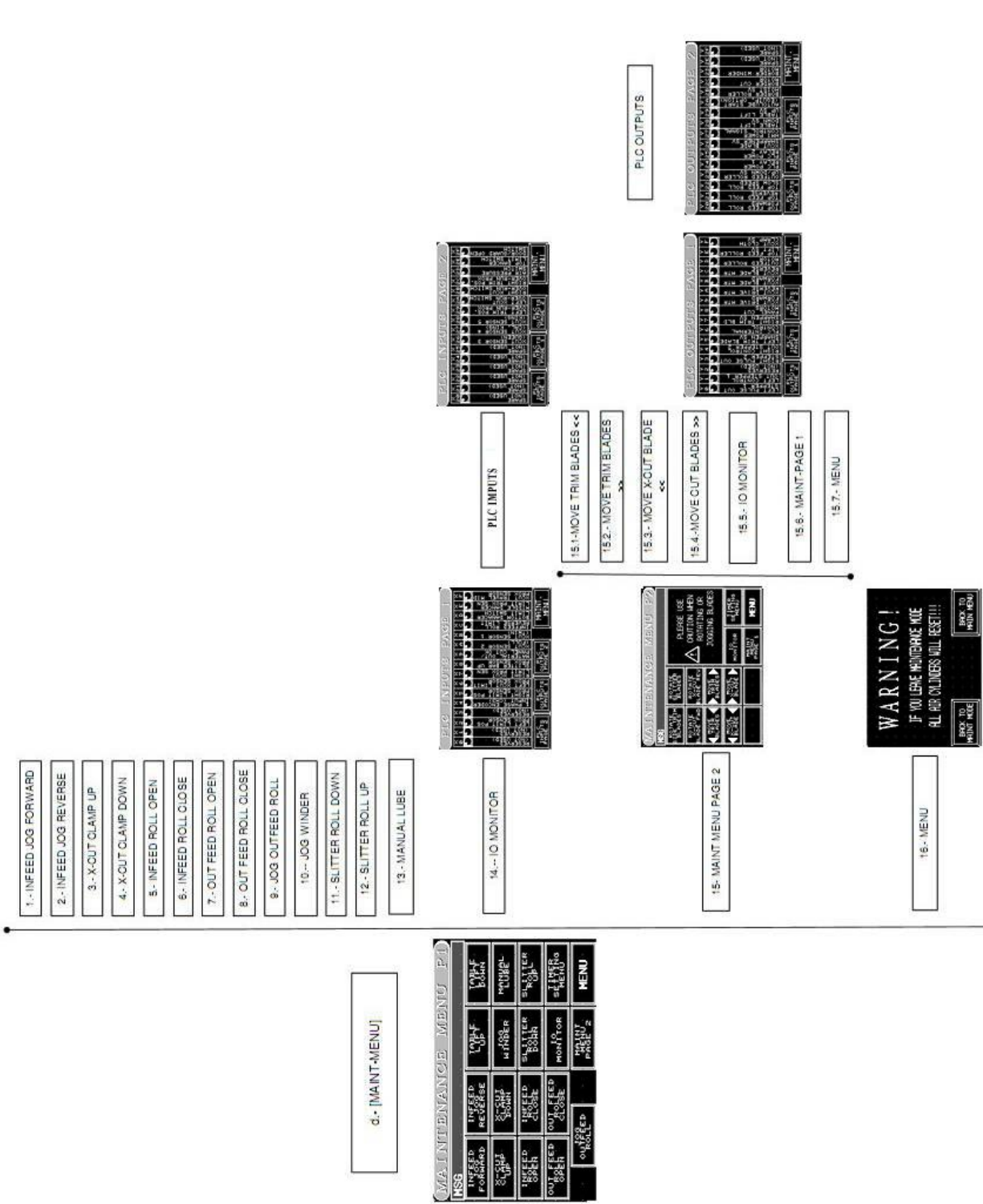
When the desired changes have been entered move the “Position/Off” selector on the panel to “Position” and push “Position Trim Blades”. The blades will now readjust to the new setting.

**7.- CONTROL POWER START**

If the power was shut off for whatever reasons this will need to be pressed to restore control panel power.

**8.- MAIN MENU** Return to main Menu.

# d- Maintenance Menu



Starting at Main Menu

Press **MAINT. MENU**  
you will get the MAINTENANCE MENU P1 screen.



**1.- IN-FEED JOG FORWARD** The main rollers will turn in the direction to advance material.

**2.- IN-FEED JOG REVERSE** The main rollers will turn in the direction to reverse the material

**3.- X-CUT CLAMP UP** The crosscut clamp bar will rise.

**4.- X-CUT CLAMP DOWN** The crosscut clamp bar will lower.

**5.- IN-FEED ROLL OPEN** The main IN-FEED pressure rollers will open.

**6.-IN-FEED ROLL CLOSE** The main IN-FEED pressure rollers will close

**7.- OUT FEED ROLL OPEN** The pressure roller at the back of the machine will rise.

**8.- OUT FEED ROLL CLOSE** The pressure roller at the back of machine will drop.

**9.- JOG OUT FEED ROLL** The lower OUT FEED roller will turn in the normal direction of movement.

**10.- JOG WINDER** The windup roller motor will activate.

**11.- SLITTER ROLL DOWN** The slitter bypass roller will lower.

**12.- SLITTER ROLL UP** The slitter bypass roller will lift.

**13.- MANUAL LUBE** The automatic lubrication cycle will activate momentarily.

**14.- IO MONITOR** Has two pages, INPUTS and OUTPUTS from the PLC.



14.1 - PLC INPUTS

PLC INPUTS PAGE 1			
RESERVED (NOT USED)	0X		
RESERVED (NOT USED)	1X		
RESERVED (NOT USED)	2X		
LEFT LIMIT POS	3X		
PROX SENSOR	4X		
RESERVED (NOT USED)	5X		
1 PHASE ENCODER INPUT (CH3)	6X		
RIGHT LIMIT POS	7X		
PROX SENSOR	8X		
LEFT XCUT LIMIT	9X		
PROX SENSOR	0X		
RIGHT XCUT LIMIT	1X		
PROX SEN	2X		
SPLITTER BAR UP	3X		
PROX SENSOR	4X		
MATERIAL OUT	5X		
PANEL CUT	6X		
XCUT SENSOR 2	7X		
XCUT SENSOR 1	8X		
(TRAIN)	9X		
INFEED ROLL REVERSE LIMIT	0X		
BOTTOM DANCER LIMIT SWITCH	1X		
MIDDLE DANCER LIMIT PROX SEN	2X		
XCUT TRAVEL MID PROX SENSOR	3X		

PLC INPUTS PAGE 2			
SPARE (NOT USED)	4X		
SPARE (NOT USED)	5X		
SPARE (NOT USED)	6X		
SPARE (NOT USED)	7X		
SPARE (NOT USED)	8X		
SPARE (NOT USED)	9X		
SPARE (NOT USED)	0X		
XCUT SENSOR 3	1X		
XCUT SENSOR 4	2X		
XCUT SENSOR 5	3X		
XCUT SENSOR 6	4X		
LEFT TRIM POS. (KING)	5X		
LEFT XCUT OVER-RUN PROX	6X		
LEFT XCUT OVER-RUN SWITCH	7X		
RIGHT XCUT OVER-RUN SWITCH	8X		
RIGHT TRIM POS. OVER-RUN PROX	9X		
AIR PRESSURE SWITCH	0X		
TOP DANCER LIMIT SWITCH	1X		
DOOR/GUARD OPEN SWITCH	2X		

14.2 - PLC OUPUTS

PLC OUTPUTS PAGE 1			
LEFT PULSE OUT STEPPER 1	0<		
LEFT CONTROL OUT STEPPER 1	1<		
RESERVED (NOT USED)	2<		
RIGHT PULSE OUT STEPPER 2	3<		
RIGHT CONTROL OUT STEPPER 2	4<		
LEFT TRIM BLADE SHARPEN SV	5<		
PLC INTERNAL CONTROL	6<		
RIGHT TRIM BLD SHARPEN SV	7<		
PANEL CUT MOTORS	8<		
XCUT DRIVE MTR FORWARD	9<		
XCUT DRIVE MTR REVERSE	0<		
XCUT BLADE MTR FORWARD	1<		
XCUT BLADE MTR REVERSE	2<		
OUTFEED ROLLER MOTOR	3<		
TOP FEED ROLLER LEFT SV	4<		
XCUT CLOTH CLAMP SV	5<		

PLC OUTPUTS PAGE 2			
TOP FEED ROLL FORWARD	6<		
TOP FEED ROLL REVERSE	7<		
TOP FEED ROLL SLOW SPEED	8<		
OUTFEED ROLLER UP/DOWN SV	9<		
PLC POWER RELAY 1	0<		
PLC POWER RELAY 2	1<		
XCUT BLADE SHARPENER SV	2<		
HMI POWER CONTROL SIGNAL	3<		
TABLE LIFT UP SV	4<		
TABLE LIFT DOWN SV	5<		
AUTOLUBE START (REGULP. OPTIONS)	6<		
BORDER ROLLER HOIST SV	7<		
BORDER CUT MOTOR	8<		
BORDER WINDER MOTOR	9<		
SPARE (NOT USED)	0<		
SPARE (NOT USED)	1<		



**15- MAINT MENU PAGE 2**

**15.1-ROTATE SIDE TRIM BLADES**

**15.2-ROTATE SLITTER BLADES**

**15.3-ROTATE X-CUT BLADES FORWARD**

**15.4-ROTATE X-CUT BLADES REVERSE**

**15.5-MOVE TRIM BLADES LEFT**

**15.6-MOVE TRIM BLADES RIGHT**

**15.7-MOVE X-CUT BLADE LEFT**

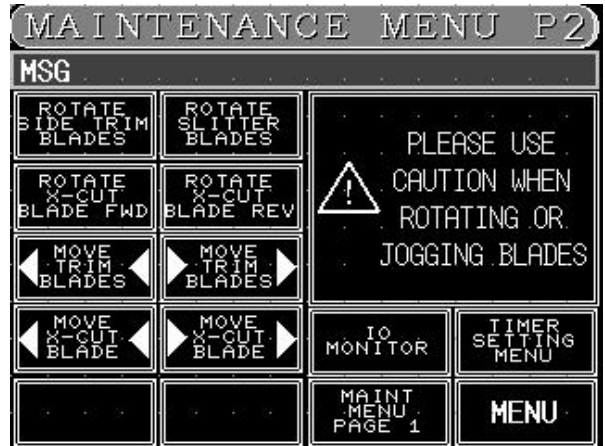
**15.8-MOVE X-CUT BLADE RIGHT**

**15.9-IO MONITOR**

**16.0-TIMER SETTING MENU**

**16.1-MAINT. MENU PAGE 1**

**16.2-MENU (Return to the Main Menu)**



## e- Panel Cut Batch



### 1- NUMBER FIELDS



### 2- BATCH DATA MENU



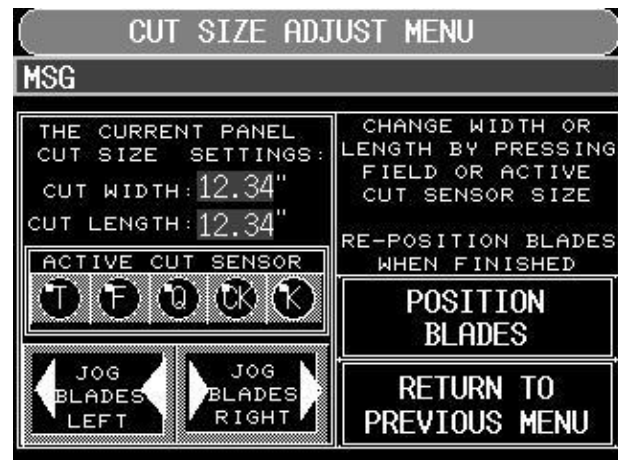
## 2.1 VIEW DATA MENU

	MANAGE BATCH DATA	BATCH STACK DATA MONITOR					SAVE DATA	PREV PAGE
Style Name	T	TXL	F	FXL	Q	K	OK	C
1 ABCDEFGHIJ	123	123	123	123	123	123	123	123
2 ABCDEFGHIJ	123	123	123	123	123	123	123	123
3 ABCDEFGHIJ	123	123	123	123	123	123	123	123
4 ABCDEFGHIJ	123	123	123	123	123	123	123	123
5 ABCDEFGHIJ	123	123	123	123	123	123	123	123
6 ABCDEFGHIJ	123	123	123	123	123	123	123	123
7 ABCDEFGHIJ	123	123	123	123	123	123	123	123
8 ABCDEFGHIJ	123	123	123	123	123	123	123	123
9 ABCDEFGHIJ	123	123	123	123	123	123	123	123
0 ABCDEFGHIJ	123	123	123	123	123	123	123	123

## 3.- CROP-OUT CUT MENU



## 4.- CUT SIZE ADJUST MENU



## 5.- MAIN MENU

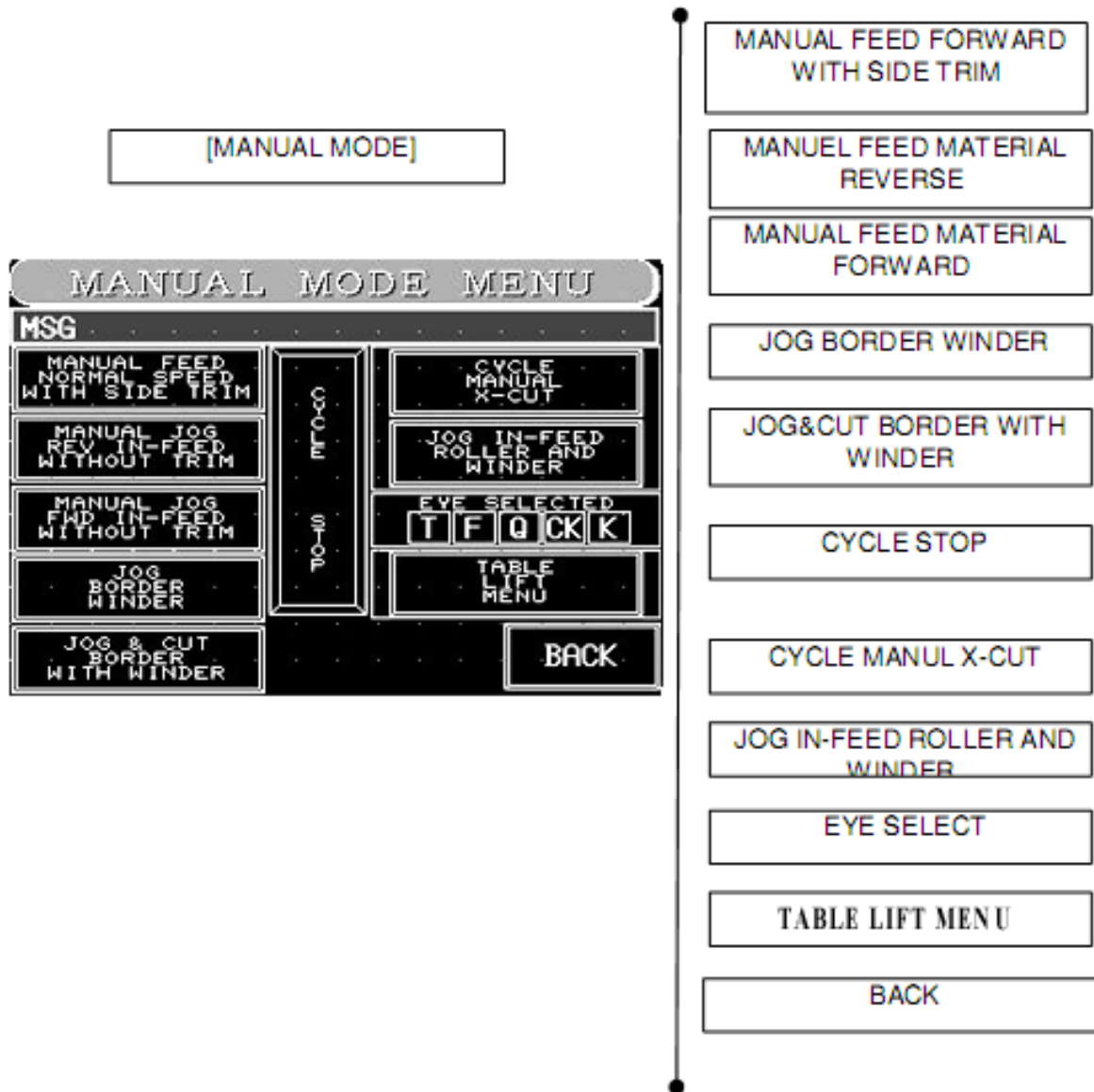
## 6.- RUN

## 7.- WITH : LENGTH : PRODUCE

## 8.- STOP



f.- Manual Mode



**1.- MANUAL FEED FORWARD WITH SIDE TRIM** Will advance material while side trimming.

**2.- MANUAL FEED MATERIAL REVERSE** Will reverse material with side trim knives not running.

**3.- MANUAL FEED MATERIAL FORWARD** Will advance material without side trimming.

**4.- JOG BORDER WINDER** The border winder motor will turn.

**5.- JOG & CUT BORDER WITH WINDER** The material will feed and side trim with winder motor turning.

**6.- CYCLE STOP** Interrupt selected cycle.

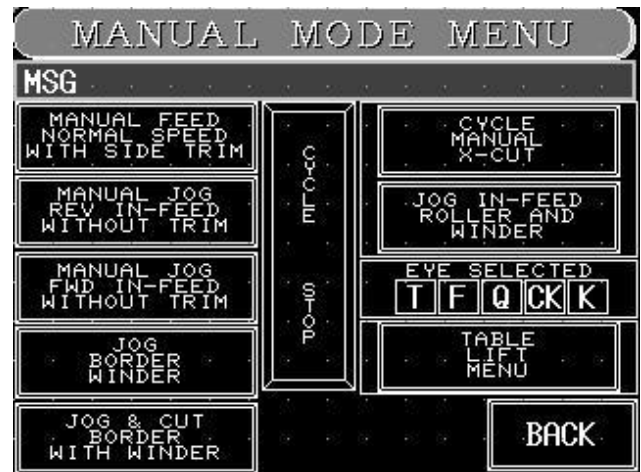
**7.- CYCLE MANUAL X-CUT** Performs one cross cut cycle.

**8.- JOG IN-FEED ROLLER AND WINDER** Will advance material without trimming while the windup motor turns.

**9.- EYE SELECTED** Shows which cut sensor is active.

**10.- CUT SENSOR DISABLE** Disables cut sensor.

**11.- BACK** Return to previous screen

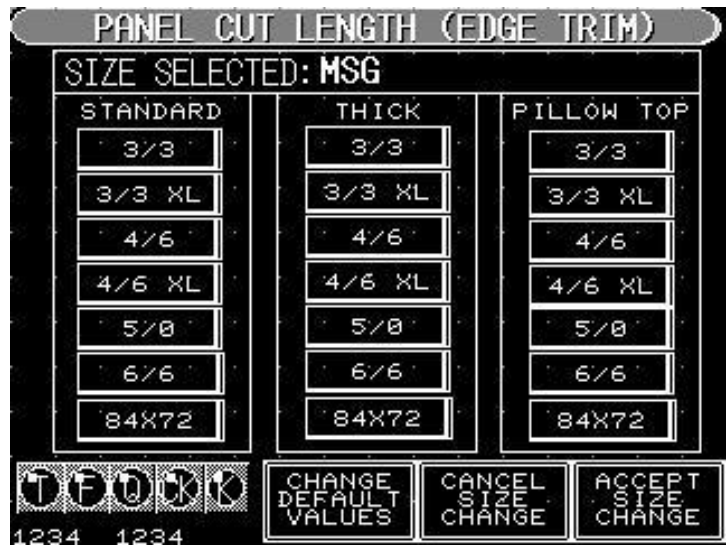


## g.- Select Cut length

This screen is divided in 3 main columns.

- STANDARD for normal thickness
- PLUSH for thick panels
- PILLOW TOP for extra thick

The highlighted fields are the ones active as this time



**1.- CHANGE CUT SIZE SETTINGS** after pressing this field the screen STANDARD PANEL CUT SIZES is shown. You will get all the actual dimensions the panels' sizes

STANDARD PANEL CUT SIZE SETTINGS				
	Twin	Twin XL	Full	Full XL
WIDTH	12.34	12.34	12.34	12.34
LENGTH	12.34	12.34	12.34	12.34
	Queen	King	CalKing	
WIDTH	12.34	12.34	12.34	
LENGTH	12.34	12.34	12.34	

At the bottom of the screen, there are buttons for 'EDIT PLUSH SETTINGS', 'EDIT PILLOW TOP SETTINGS', and 'RETURN TO CUT LENGTH MENU'.

To change dimensions, press on top of the number and modify the values.

**1.1.- EDIT PLUSH SETTINGS** To change the rest of the sizes

**1.2.- EDIT PILLOW TOP SETTINGS** to change the rest of the sizes.

**1.3.- RETURN TO CUT LENGTH MENU** to exit the screen

**2.- CANCEL SIZE CHANGE** . Return to the original values without accepting the changes.

**3.- ACCEPT SIZE CHANGE** record any change made in dimensions



## h.- Sharpen Blades

1.- **SHARPEN LEFT BLADE** – This will turn on the left trim knife motor and activate the sharpener for the predetermined time.

2.- **SHARPEN RIGHT BLADE** – This will turn on the right trim knife motor and activate the sharpener for the predetermined time.

3.- **SHARPEN X-CUT BLADE**

4.- **SHARPEN SLITTER BLADE**

5.- **SHARPEN TIME**

6.- **SHARPEN CYCLE STOP**

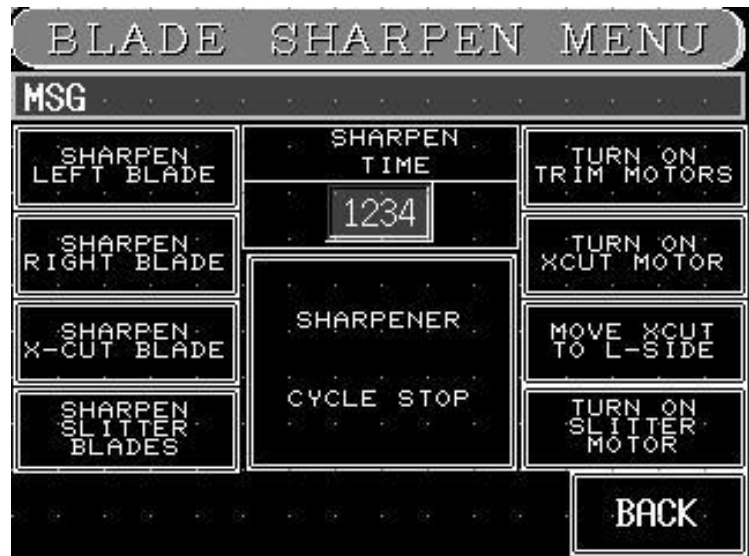
7.- **TURN ON TRIM MOTORS**

8.- **TURN ON XCUT MOTOR**

9.- **MOVE XCUT TO L-SIDE**

10.- **TURN ON SLITTER MOTOR**

11.- **BACK**



### i.- Timer settings menu

**1.- LUBE INTERVAL** Control the activation trimming of the automatic grease system. (OPTIONAL EQUIP.)



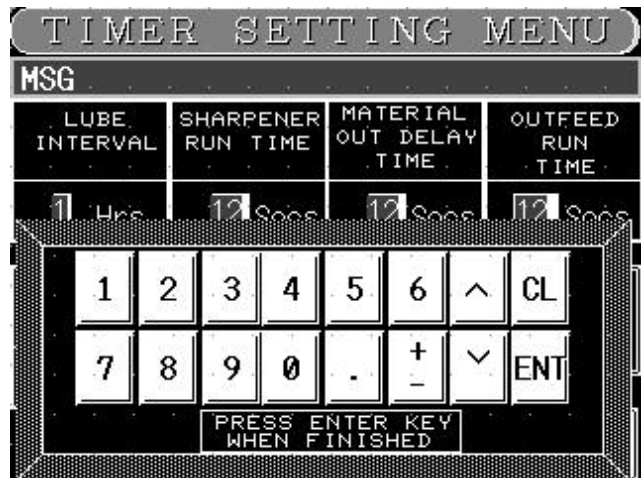
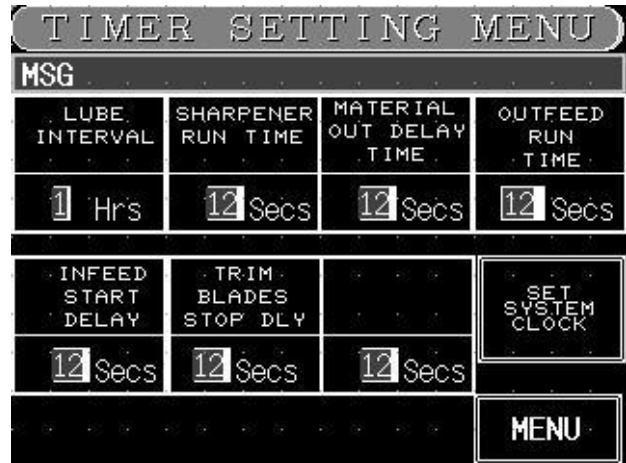
**2.- SHARPENER RUN TIME**

**3.- OUT FEED RUN TIME**

**4.- SET SYSTEM CLOCK**

Press any of the field and change values on the Keypad. Press enter Key when finish

**5.- MENU** Return to Main Menu





## j.- Control Power Start

Press this button to energize the control power to the machine

## k.- POWER OFF / POWER ON

This is an indicator to show when the control power is energized (Not a Button)

## l.- Control power off



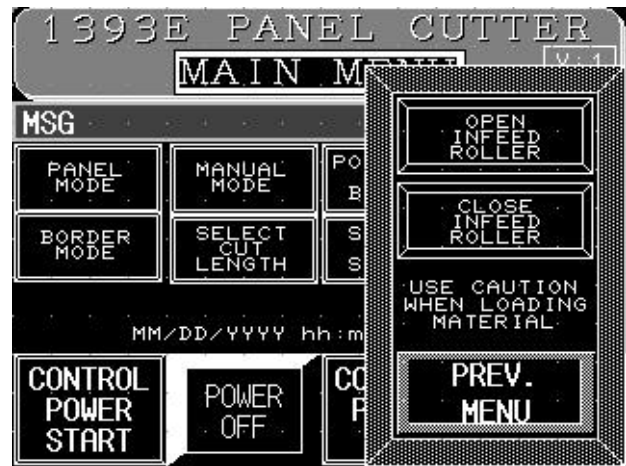
Press this button to de-energize all the control power to the machine.

**(PLEASE NOTE: THIS IS NOT THE SAME AS THE MAIN POWER)**

## m.- Load Material in feed roller

Press **LOAD MATERIAL IN FEED** on the Main Menu roller and you will get 3 options

- OPEN IN FEED ROLLER
- CLOSE IN FEED ROLLER
- PREV MENU Return to the Main menu



## 2.3.- Operating



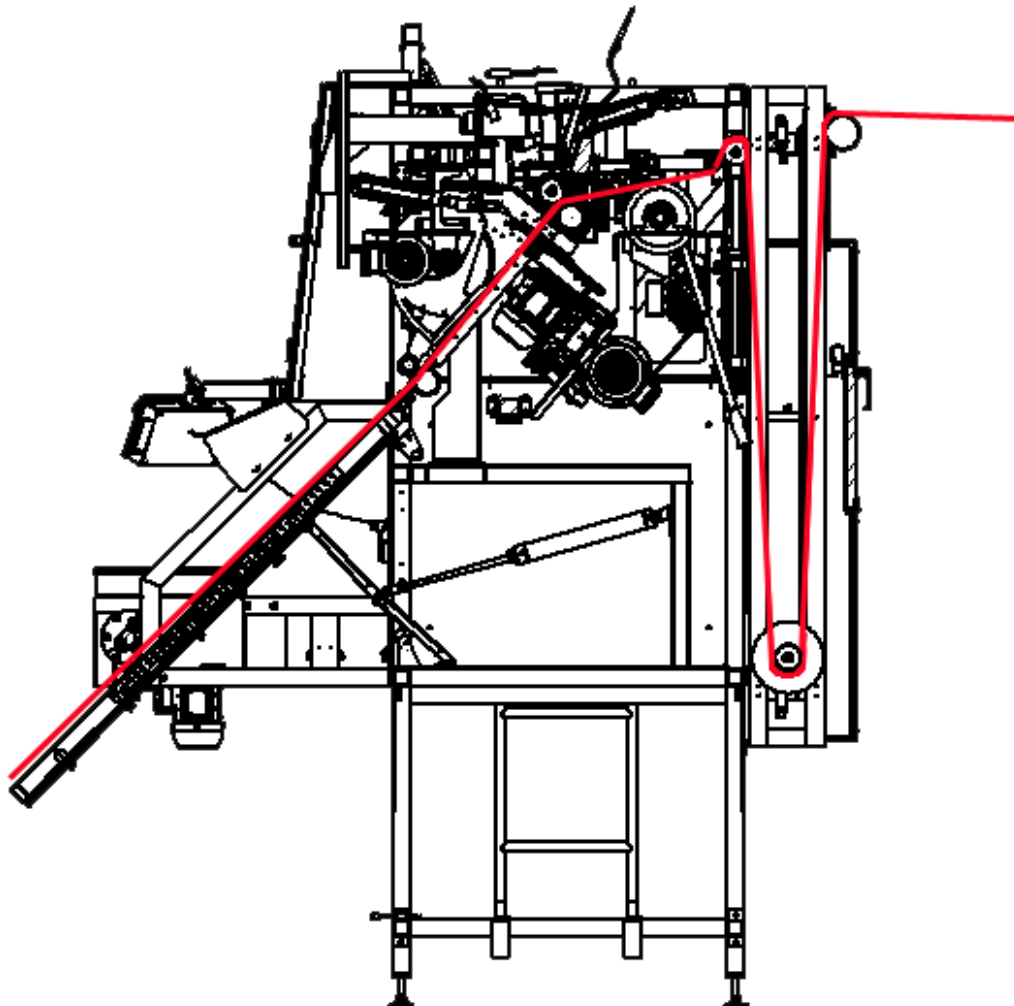
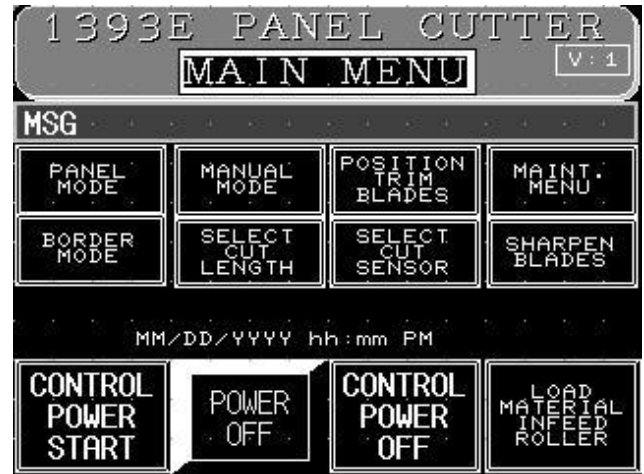
It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating

### A.- Turning ON

- a.- Make Sure that the Main Power switch is on the "ON" position
- b.- Press the "ON" button on the Control Panel  
Machine will show Atlanta Attachment logo and will power ON

### B.- Load the material

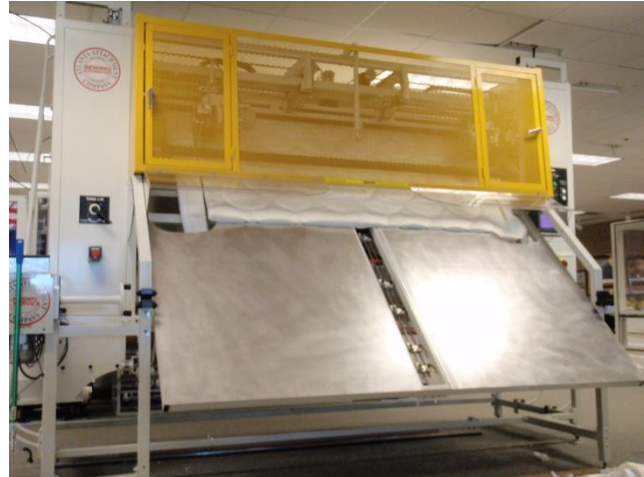
- a.- With the machine ON, Press **LOAD MATERIAL IN FEED** on the Main Menu
- b.- Press **OPEN INFEED ROLLER**,
- c.- Open the safety doors You will be able to load material through the machine. Follow the picture for a correct loading of the material.



- d.- close the safety doors and press **CLOSE IN FEED ROLLER** from the loading menu.
- e.- Press **PREV MENU** to Return to the Main menu

### c.- Panel Cutting

- a.- Set the table Lift switch to “Up” and remove the re-winder shaft
- b.- Make sure machine is loaded with material and all doors are close
- c.- Press **CONTROL POWER START** from the Main Menu Screen
- d.- Press **PANEL MODE** on the same screen.
- e.- Load the production required (Panel quantity, dimensions, etc.)
- f.- Press **RUN**.



**“ATTENTION “Never leaves the machine unattended”**

### d.- Border Cutting



- a.- Carefully adjust manually the cutting blades to the right border width.
- b.- Set the table Lift switch to “down” and install the re-winder shaft
- b.- Make sure machine is loaded with material and all doors are close
- c.- Press **CONTROL POWER START** from the Main Menu Screen
- d.- Press **BORDER MODE** on the same screen.
- e.- Load the production required (Border quantity, length, etc.)
- f.- Press **RUN**.
- g.- Readjust the re-winder air pressure if required.

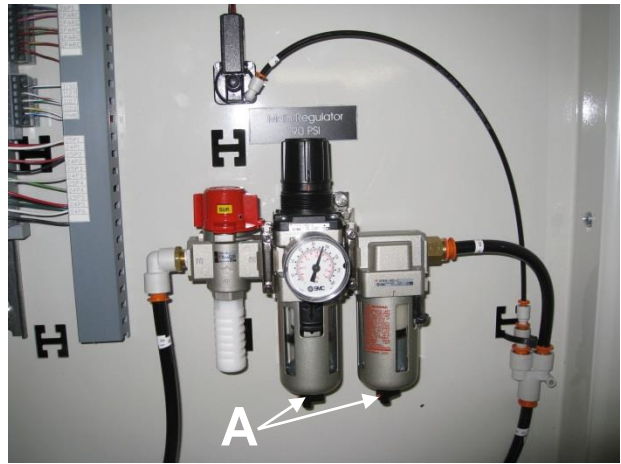


**“ATTENTION “Never leaves the machine unattended”**

## 2.4.- Maintenance

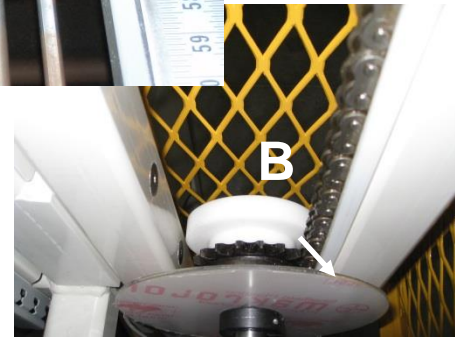
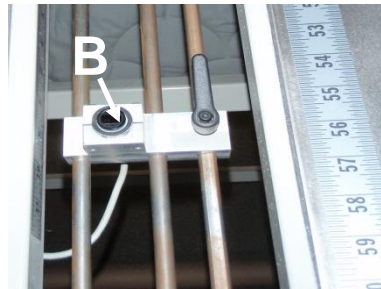
### a.- Daily

- 1.- Drain water from water trap in air pressure regulator.
- 2.- Clean any lint or debris from around bearings, blades and motors.
- 3.- Clean work area and check for any signs of abnormality or wear.



### b.- Weekly

- 1.- Clean dancer bar guide chains and sprocket.
- 2.- Clean lint and debris from inside machine around X-Cut linear rail bearings and belt.
- 3.- Clean lint and debris from Right & Left Trim blade bearing rails and belts.
- 4.- Clean panel width sensors.
- 5.- Check for any areas of wear or potential problems.



### c.- Monthly

- 1.- Thoroughly clean machine inside and out.
- 2.- Check condition of all drive belts.
- 3.- Check security of all blades.
- 4.- Check setting of blade sharpening stones.
- 5.- Clean threads from around all shafts and rollers.
- 6.- Clean cabinet cooling fan and filter.
- 7.- Check condition of dancer bar guide chain and sprocket alignment on both sides..
- 8.- Check and grease pillow block bearings as needed. (Look for rust or fine metal particles)





### 3.- SERVICE MANUAL



It is important that the machine operator read this manual and is familiar with all the functions and safety concerns of the unit before operating.

#### 1.- Pneumatic

a.- Re-winder pressure.

Control the pressure of the clutch Determine how tight the roll will be winder.

(Factory adjustment: 30 psi)

b.- Main air regulator

Determine the pressure for the whole machine.

(Factory adjustment 90 psi)

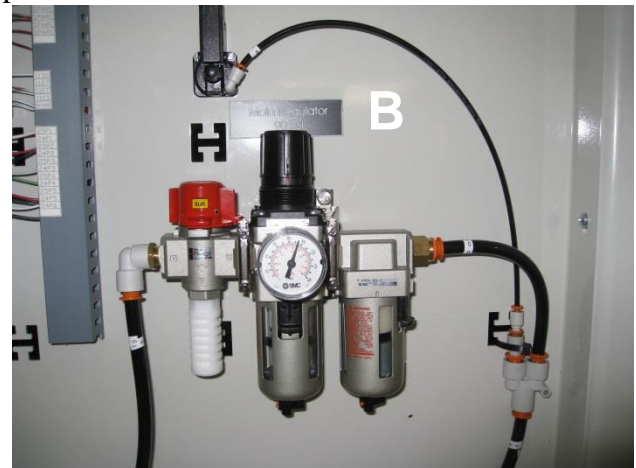
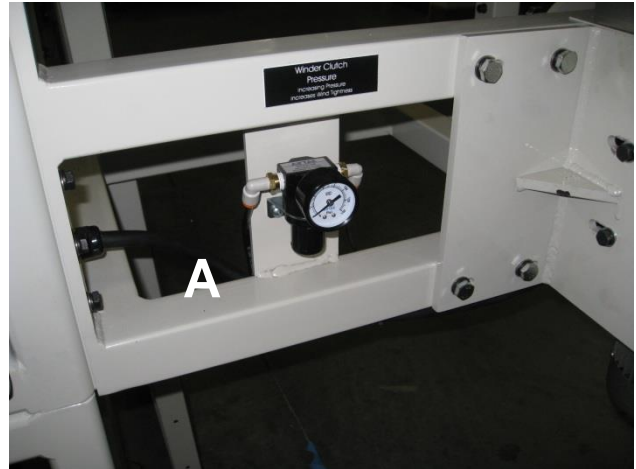
c.- Blade Sharpeners.

Control the reassure of the blade sharpeners.

(Factory adjustment 30 psi)

d.- Infeed Roll regulator. Control de pressure of the top in feed roll.

(Factory adjustment 20 to 40 psi)





# 1393E Panel Cutter Spare Parts Kit

NO.	QTY	PART #	DESCRIPTION
1	2	1393003	SHARPENER STONE MNT
2	1	AAE4V21008	VALVE,1/4" PORTED,24VDC
3	2	BBGER205-25	BEARING,BALL,25MM B,CLAMP
4	2	CJ2090200	BLADE, TRIM & XCUT,280MM OD
5	2	CJ21100900	BLADE, SLITTER, 205MM OD
6	1	EEMC12B11	CONTACTOR,IEC,230VAC
7	1	EEMC32A22	CONTACTOR,IEC,230VAC
8	1	EENI5Q18AN6X	LIMIT SW SENSOR
9	1	EERM699V3011	RELAY,REPLACEMENT

## Programming ACTech SCL/SCM Drive (1393E Only)

The drive is already pre-programmed\*\* with settings specifically for the 1393E Unit by Atlanta Attachment Co. These settings are listed in the chart on the following page. Password protection is currently disabled so that control of the parameters is immediately available to the user. After the controller settings have been "fine-tuned", you can use parameter 44 to set a password value between 1-999 to "lock" the control setting for the motors.

The buttons and display on the front of the motor controller can be used to change any specific parameter. Pressing the mode button will take you to the last parameter viewed. Parameters are designated with a "P" as the first character on the display. The arrow up and arrow down buttons will scroll through to the desired parameter. Pressing "Mode" displays the current parameter setting (point "above" decimal point blinks). This setting can be changed by using the arrow up and arrow down buttons. When the desired setting is found press the mode button to store the new value. This will store the new value and exit the program mode. To change another parameter value, press the mode key again and repeat the procedure.

\*\*In the event the controller has not been pre-programmed by AAC, the default password from the factory is 225.

Every SCL/SCM Series drive has an Electronic Programming Module (EPM) installed on the main control board. The EPM stores the user's parameter settings and special OEM default settings (if programmed). The EPM is removable, allowing it to be installed in another drive for quick set-up. For example, if a drive is being replaced with a new one, the EPM can be taken out of the first drive and installed in the new drive. Downtime is minimized because the new drive does not require programming - it is ready to run when the EPM is installed.

**NOTE:** The drive will not operate without the EPM installed. The drive will display "F1" if the EPM is missing or damaged.

### **WARNING!**

**Do not remove the EPM while power is applied to the drive. Damage to the EPM and/or drive may result.**

See tables on following pages...

## XCut Drive Motor Parameters Menu (INV1)

AAC custom setting shown in last column.

NO.	PARAMETER NAME	RANGE OF ADJUSTMENT	FACTORY DEFAULT	AAC SETTING
01	LINE VOLTAGE	High (01), LOW (02)	HIGH (01)	02
02	CARRIER FREQUENCY	4kHz (01), 6kHz (02), 8 kHz (03), 10 kHz (04)	6 KHZ (02)	04
03	START METHOD	NORMAL (01), START ON POWER UP (02), START WITH DC BRAKE (03), AUTO RESTART WITH DC BRAKE (04), FLYING RESTART 1 (05), FLYING RESTART 2 (06), FLYING RESTART 3 (07)	NORMAL (01)	---
04	STOP METHOD	COAST (01), COAST W/ DC BRAKE (02), RAMP (03), RAMP W/ DC BRAKE (04)	COAST (01)	04
05	STANDARD SPEED SOURCE	KEYPAD (01), PRESET #1 (02), 0-10VDC (03), 4-20mA (04)	KEYPAD (01)	02
06	RELAY OUTPUT	NONE (01), RUN (02), FAULT (03), INVERSE FAULT (04), FAULT LOCKOUT (05), AT SET SPEED (06), ABOVE PRESET #3 (07), CURRENT LIMIT (08), AUTO SPEED (09), REVERSE (10)	NONE (01)	06
10	TB-13A FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #1 (04), START FORWARD (05), RUN REVERSE (06), START REVERSE (07), EXTERNAL FAULT (08), INVERSE EXT FAULT (09), AUXILARY STOP (10), ACCEL/DECEL #2 (11)	NONE (01)	06
11	TB-13B FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #2 (04), DECREASE FREQ (05), START FORWARD (06), JOG FORWARD (07), JOG REVERSE (08), EXTERNAL FAULT (09), INVERSE EXT FAULT (10), AUXILARY STOP (11), ACCEL/DECEL #2 (12), REMOTE KEYPAD (13)	NONE (01)	04
12	TB-13E INPUT FUNCTIONS  TB-13 OUTPUT FUNCTIONS  OTHER FUNCTIONS	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #3 (04), INCREASE FREQ (05), START FORWARD (06), EXTERNAL FAULT (07), INVERSE EXT FAULT (08), AUX STOP (09), ACCEL/DECEL #2 (10),  RUN (11), FAULT (12), INVERSE FAULT (13), FAULT LOCKOUT (14), AT SET SPEED (15), ABOVE PRESET #3 (16), CURRENT LIMIT (17), AUTO SPEED (18), REVERSE (19), DYNAMIC BRAKING (20),  REMOTE KEYPAD (21)	NONE (01)	---

14	CONTROL	TERMINAL STRIP ONLY (01) REMOTE KEYPAD ONLY (02)	TERMINAL STRIP ONLY (01)	---
16	UNITS EDITING	TENTHS OF UNITS (01), WHOLE UNITS (02)	WHOLE UNITS (02)	---
17	ROTATION	FORWARD ONLY (01), FORWARD AND REVERSE (02)	FORWARD ONLY (01)	02
19	ACCELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	1.0
20	DECELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	0.2
21	DC BRAKE TIME	0.0 - 3600.0 SEC	0.0 SEC	0.3
22	DC BRAKE VOLTAGE	0.0 - 30.0%	0.0 %	1.5
23	MINIMUM FREQUENCY	0.0 - MAXIMUM FREQUENCY	0.0 Hz	---
24	MAXIMUM FREQUENCY	MINIMUM FREQUENCY - 240 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	80
25	CURRENT LIMIT	30 - 180 %	180 %	150
26	MOTOR OVERLOAD	30 - 100 %	100 %	---
27	BASE FREQUENCY	25.0 - 500 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	60
28	FIXED BOOST	0.0 - 30.0 %	1.0 %	20
29	ACCEL BOOST	0.0 - 20.0 %	0.0 %	---
30	SLIP COMPENSATION	0.0 - 5.0 %	0.00%	---
31	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	70
32	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	35
33-37			0.0	0.0
38	SKIP BANDWIDTH	0.0 - 10 Hz	0.0 Hz	---
39	SPEED SCALING	0.0 - 6500.0	0.0	---
42	ACCEL/DECEL #2	0.1 - 3600.0 SEC	20.0 SEC	---
44	PASSWORD	000 - 999	225	*000
45	SPD AT MIN SIGNAL	MINIMUM FREQUENCY - 999 Hz	0.0 Hz	---
46	SPD AT MAX SIGNAL	MINIMUM FREQUENCY - 999 Hz	SCL = 50.0Hz SCM = 60.0Hz	---
47	CLEAR HISTORY	MAINTAIN (01), CLEAR (02)	MAINTAIN (01)	---

**Technical Manual & Parts Lists**

48	PROGRAM SELECTION	USER SETTINGS (01), OEM SETTINGS (02), RESET OEM (03), RESET 60 (04), RESET 50 (05), TRANSLATE (06)	SCL = RESET 50 (05) SCM = RESET 60 (04)	---
50	FAULT HISTORY	(VIEW ONLY)	(N/A)	---
51	SOFTWARE CODE	(VIEW ONLY)	(N/A)	---
52	DC BUS VOLTAGE	(VIEW ONLY)	(N/A)	---
53	MOTOR VOLTAGE	(VIEW ONLY)	(N/A)	---
54	LOAD VOLTAGE	(VIEW ONLY)	(N/A)	---
55	0-10 VDC INPUT	(VIEW ONLY)	(N/A)	---
56	4-20mA INPUT	(VIEW ONLY)	(N/A)	---
57	TB STRIP STATUS	(VIEW ONLY)	(N/A)	---
58	KEYPAD STATUS	(VIEW ONLY)	(N/A)	---
* PASSWORD IS SET TO "000" WHICH DISABLES THE PASSWORD FUNCTION				



## Infeed Drive Motor Parameters Menu (INV2)

AAC custom setting shown in last column.

NO.	PARAMETER NAME	RANGE OF ADJUSTMENT	FACTORY DEFAULT	AAC SETTING
01	LINE VOLTAGE	High (01), LOW (02)	HIGH (01)	02
02	CARRIER FREQUENCY	4kHz (01), 6kHz (02), 8 kHz (03), 10 kHz (04)	6 KHZ (02)	04
03	START METHOD	NORMAL (01), START ON POWER UP (02), START WITH DC BRAKE (03), AUTO RESTART WITH DC BRAKE (04), FLYING RESTART 1 (05), FLYING RESTART 2 (06), FLYING RESTART 3 (07)	NORMAL (01)	---
04	STOP METHOD	COAST (01), COAST W/ DC BRAKE (02), RAMP (03), RAMP W/ DC BRAKE (04)	COAST (01)	04
05	STANDARD SPEED SOURCE	KEYPAD (01), PRESET #1 (02), 0-10VDC (03), 4-20mA (04)	KEYPAD (01)	02
06	RELAY OUTPUT	NONE (01), RUN (02), FAULT (03), INVERSE FAULT (04), FAULT LOCKOUT (05), AT SET SPEED (06), ABOVE PRESET #3 (07), CURRENT LIMIT (08), AUTO SPEED (09), REVERSE (10)	NONE (01)	06
10	TB-13A FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #1 (04), START FORWARD (05), RUN REVERSE (06), START REVERSE (07), EXTERNAL FAULT (08), INVERSE EXT FAULT (09), AUXILARY STOP (10), ACCEL/DECEL #2 (11)	NONE (01)	06
11	TB-13B FUNCTION SELECT	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #2 (04), DECREASE FREQ (05), START FORWARD (06), JOG FORWARD (07), JOG REVERSE (08), EXTERNAL FAULT (09), INVERSE EXT FAULT (10), AUXILARY STOP (11), ACCEL/DECEL #2 (12), REMOTE KEYPAD (13)	NONE (01)	04
12	TB-13E INPUT FUNCTIONS  TB-13 OUTPUT FUNCTIONS  OTHER FUNCTIONS	NONE (01), 0-10 VDC (02), 4-20 mA (03), PRESET SPEED #3 (04), INCREASE FREQ (05), START FORWARD (06), EXTERNAL FAULT (07), INVERSE EXT FAULT (08), AUX STOP (09), ACCEL/DECEL #2 (10),  RUN (11), FAULT (12), INVERSE FAULT (13), FAULT LOCKOUT (14), AT SET SPEED (15), ABOVE PRESET #3 (16), CURRENT LIMIT (17), AUTO SPEED (18), REVERSE (19), DYNAMIC BRAKING (20),  REMOTE KEYPAD (21)	NONE (01)	---

Technical Manual & Parts Lists

14	CONTROL	TERMINAL STRIP ONLY (01) REMOTE KEYPAD ONLY (02)	TERMINAL STRIP ONLY (01)	---
16	UNITS EDITING	TENTHS OF UNITS (01), WHOLE UNITS (02)	WHOLE UNITS (02)	---
17	ROTATION	FORWARD ONLY (01), FORWARD AND REVERSE (02)	FORWARD ONLY (01)	02
19	ACCELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	1.0
20	DECELERATION TIME	0.1 - 3600.0 SEC	20.0 SEC	0.3
21	DC BRAKE TIME	0.0 - 3600.0 SEC	0.0 SEC	0.5
22	DC BRAKE VOLTAGE	0.0 - 30.0%	0.0 %	1.0
23	MINIMUM FREQUENCY	0.0 - MAXIMUM FREQUENCY	0.0 Hz	---
24	MAXIMUM FREQUENCY	MINIMUM FREQUENCY - 240 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	80
25	CURRENT LIMIT	30 - 180 %	180 %	150
26	MOTOR OVERLOAD	30 - 100 %	100 %	---
27	BASE FREQUENCY	25.0 - 500 Hz	SCL = 50.0 Hz SCM = 60.0 Hz	60
28	FIXED BOOST	0.0 - 30.0 %	1.0 %	20
29	ACCEL BOOST	0.0 - 20.0 %	0.0 %	---
30	SLIP COMPENSATION	0.0 - 5.0 %	0.00%	---
31	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	60
32	PRESET SPEED	0.0 - MAXIMUM FREQUENCY	0.0 Hz	35
33-37			0.0	0.0
38	SKIP BANDWIDTH	0.0 - 10 Hz	0.0 Hz	---
39	SPEED SCALING	0.0 - 6500.0	0.0	---
42	ACCEL/DECEL #2	0.1 - 3600.0 SEC	20.0 SEC	---
44	PASSWORD	000 - 999	225	*000
45	SPD AT MIN SIGNAL	MINIMUM FREQUENCY - 999 Hz	0.0 Hz	---
46	SPD AT MAX SIGNAL	MINIMUM FREQUENCY - 999 Hz	SCL = 50.0Hz SCM = 60.0Hz	---
47	CLEAR HISTORY	MAINTAIN (01), CLEAR (02)	MAINTAIN (01)	---

48	PROGRAM SELECTION	USER SETTINGS (01), OEM SETTINGS (02), RESET OEM (03), RESET 60 (04), RESET 50 (05), TRANSLATE (06)	SCL = RESET 50 (05) SCM = RESET 60 (04)	---
50	FAULT HISTORY	(VIEW ONLY)	(N/A)	---
51	SOFTWARE CODE	(VIEW ONLY)	(N/A)	---
52	DC BUS VOLTAGE	(VIEW ONLY)	(N/A)	---
53	MOTOR VOLTAGE	(VIEW ONLY)	(N/A)	---
54	LOAD VOLTAGE	(VIEW ONLY)	(N/A)	---
55	0-10 VDC INPUT	(VIEW ONLY)	(N/A)	---
56	4-20mA INPUT	(VIEW ONLY)	(N/A)	---
57	TB STRIP STATUS	(VIEW ONLY)	(N/A)	---
58	KEYPAD STATUS	(VIEW ONLY)	(N/A)	---
* PASSWORD IS SET TO "000" WHICH DISABLES THE PASSWORD FUNCTION				



## Assembly Drawings & Parts Lists

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