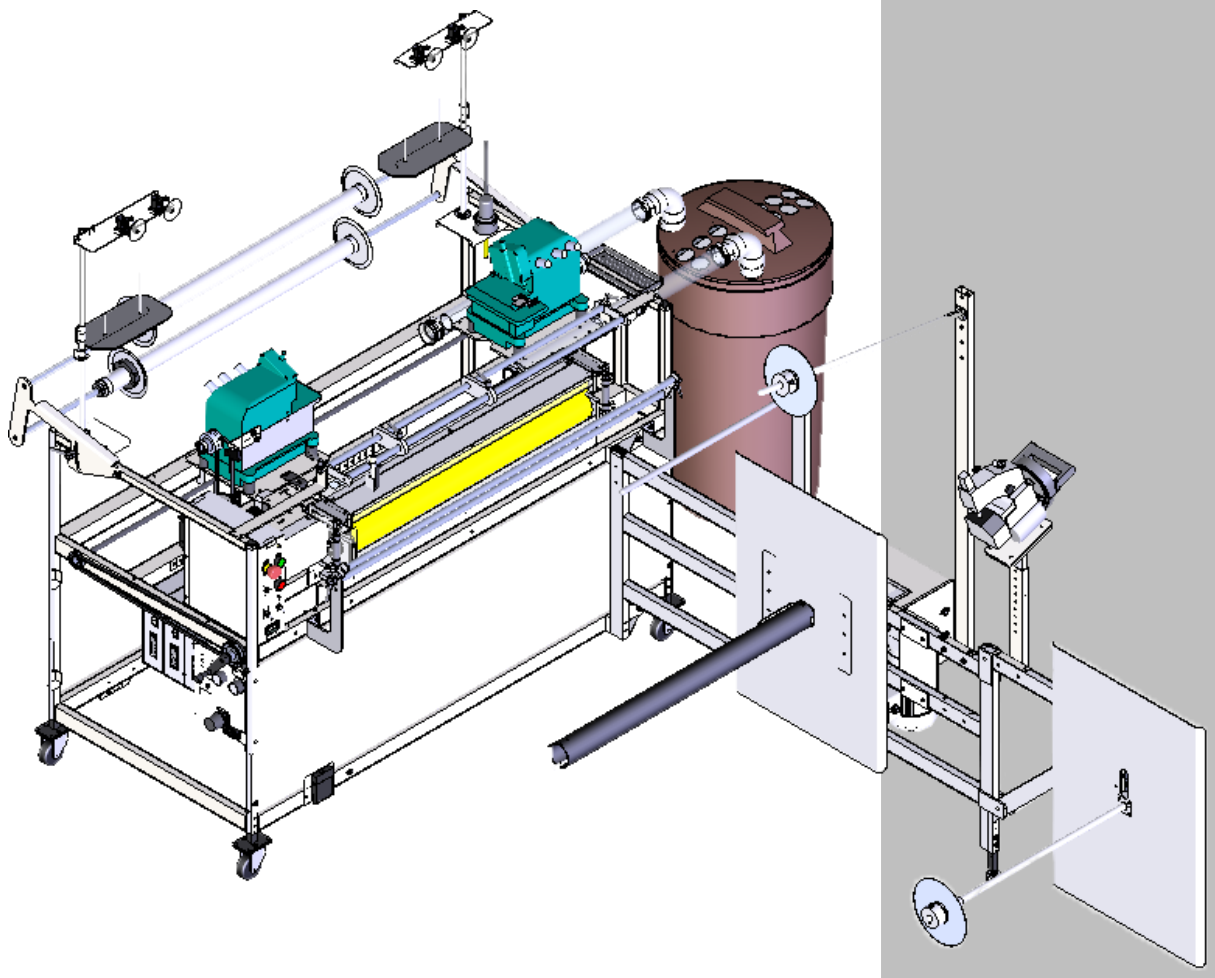
Model **1962**

Revision 3.1 Updated Sept 18, 2012

# Technical Manual & Parts Lists





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Foreign Patents: 9-520,472 ● 0,537,323 ● 92,905,522.6 ● 96,936,922.2 ● 2,076,379 ● 2,084,055
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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

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 1962 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.

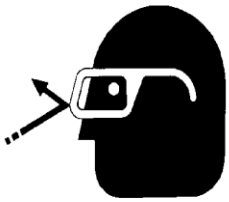
## Faults or Errors

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.

| | |
|---|---|
|  | General Information (Read) |
|  | Hazard warning sign: Electrical hazard, electrical hazard |
|  | Hazard warning sign: Beware of damage to hands. |
|  | Hazard warning sign: General Hazard |
|  | General Information Symbol |

The 1961 unit is an automatic workstation for serging both sides of a band of rolled or festooned material. This unit incorporates a variable torque winder on the rear of the machine to roll the material after surging.

## Features

- Automatically surges both edges of a band of material and winds onto a roll
- 125 feet of material sewn per minute
- Electrical lock out / tag out capability
- Variable speed puller with urethane rollers
- Electronic thread break detection
- Clutch motor driven left and right sergers.
- Turn off left head for single edge serging
- Foot pedal operation for manual sewing
- Variable torque winding
- Stops automatically when material runs out
- Adjustable tensioning of material as it is fed into the system
- Material capacity from 5" to 15" in width.

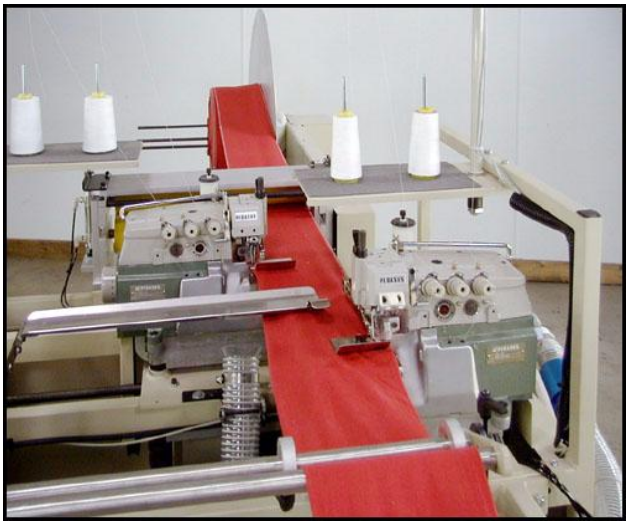
## General Machine Data

| | |
|---|---|
| Electrical: | 220 VAC, 10A, 50/60 Hz Single Phase |
| Pneumatic: | 70-80 PSI, 14 SCFM avg. |
| Sew Head (RH): | Pegasus EX5203-M0C3-333-W5 |
| Sew Head (LH): | Pegasus E52L-130/503-353W5 |
| Needle: | SNB27140 |
| Stitch Density: | 4 SPI |
| Speed: | 6000 RPM |
| Weight: | Approx. 1500 lbs. |
| Dimensions: | 4’ x 11’ |

## Operating Procedure

- Load roll of fabric onto roll rod in front of machine.
- Using the Left Head Adjustment Crank, set the Left head to the desired finished width.
- Feed fabric through guide assembly: over first bar, under second.
- Turn on Machine power. Turn off the left sewing head.
- Place the leading edge of the fabric under the foot of the right sewing head. Turn the head over by hand and check for interference problems and make sure machine is forming a stitch.
- Using the foot pedal, run the right head and gently pull the fabric until the leading edge of the fabric is at the foot of the left head.
- Place the leading edge of the fabric under the foot of the left sewing head. Turn the head over by hand and check for interference problems and make sure machine is forming a stitch.
- Turn on the left head. Power should now be on to both heads.
- Using the feed roller switch, lift the feed roller.
- Using the foot pedal, run both heads and gently pull the fabric until the leading edge of the fabric is between the feed rollers.
- Lower the feed roller.
- Using the foot pedal run about five to six feet of fabric through the machine.
- Place the fabric through the rods that form the winding mandrel.

- Press the Start button until the Sensor LED goes dark. The machine is now sewing in automatic mode.
- When all the fabric has been sewn the fabric sensor will stop the machine.
- Load a new roll of fabric onto the roll rod.
- Using the stapler provided in the spare parts kit, staple the leading edge of the new roll to the trailing edge of the previous roll.
- Using the foot pedal run the new fabric through the machine and around the winder. (If necessary, adjust the position of the left head)



**(Note: Better size transitions between rolls will be achieved if the left sew head is run with the foot pedal while being moved in/out with the adjustment crank.)**

- Cut the two rolls apart, remove the previous roll, and load the leading edge of the new roll through the rods that form the winding mandrel.
- (Repeat)

## Adjustments / Controls

- **Control Box (front)-** The front of the control box allows the operator to start and stop the automatic function of the machine, shut off power to the machine in the event of an emergency, view the hours of run time on the sewing heads, turn off power to the left sewing head, and to raise and lower the upper puller roller.

- **Control Box (rear)-** The rear of the control box allows the operator to turn the power on and off.

- **Left Head Adjustment Crank-** The left head adjustment crank is located on the left side of the machine. It allows the operator to move the Left head to sew various widths of fabric ranging from 0 to 18 inches wide.

- **Feed Speed Adjustment Thumbwheels-** The feed roller speed adjustment thumbwheels are located on the front of the step motor control box located behind the left door of the machine. It allows the operator to vary the speed of the feed roller. Increasing the speed of the feed roller causes fewer stitches per inch of sewing; likewise decreasing the speed of the feed roller causes more stitches per inch of sewing.

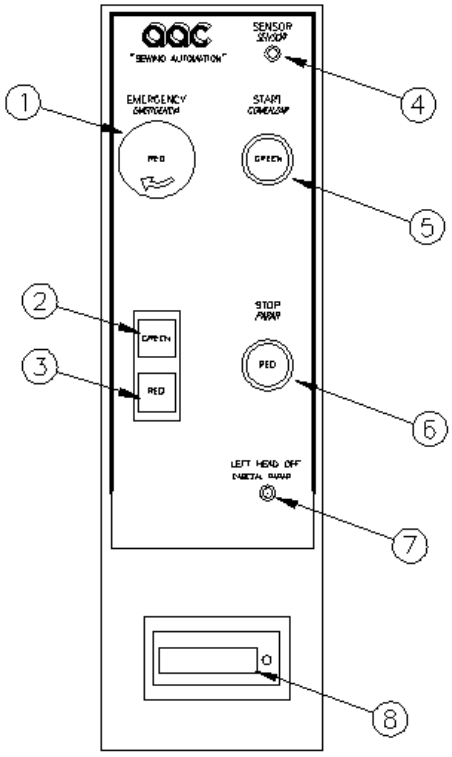
- **Winder Clutch Regulator-** The winder clutch regulator is located on the left side of the machine, behind the door. There are two regulators behind the door; the winder clutch regulator is the one on the top. The winder clutch regulator controls the amount of winding tension used to wind the fabric after being sewn. Increasing the air pressure supplied by the winder clutch regulator results in a more tightly wound roll of fabric.

# Control Box Functions

## Front of Control Box

(See Figure 1)

Figure 1




**1. Emergency Stop Button-** Pressing this button will turn off power to the machine. This button will lock when pressed. Twisting the button will cause it to unlock and return to its normal position. WARNING!! Unlocking the button with the Power On (Button 2, Figure 1) engaged will turn on power to the machine.

**2. Power On Button-** This button turns on power to the machine but the contactor is not engaged. This allows the operator to use the needle light without fear of the sewing heads running.

**3. Power Off Button-** This button turns off power to the machine and causes all functioning of the machine to stop.

**4. Sensor LED-** This LED is on when the contactor is engaged and the machine is ready for automatic operation.

**5. Start Button-** This button, pressed once, causes the contactor to engage the Sensor LED (4) to light. When this button is pressed again and held until the LED goes off, the automatic cycle is started.

**6. Stop Button-** This button causes the automatic cycle to stop.

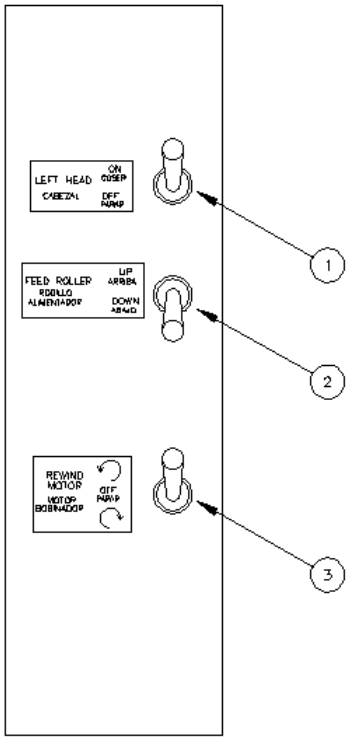
**7. Left Head Off LED-** This LED is on only when the left head is off.

**8. Head Timer-** This timer shows how much actual run time (hours) there is on the heads (this timer only runs when the heads are sewing).

## Rear of Control Box

(See Figure 2)

Figure 2

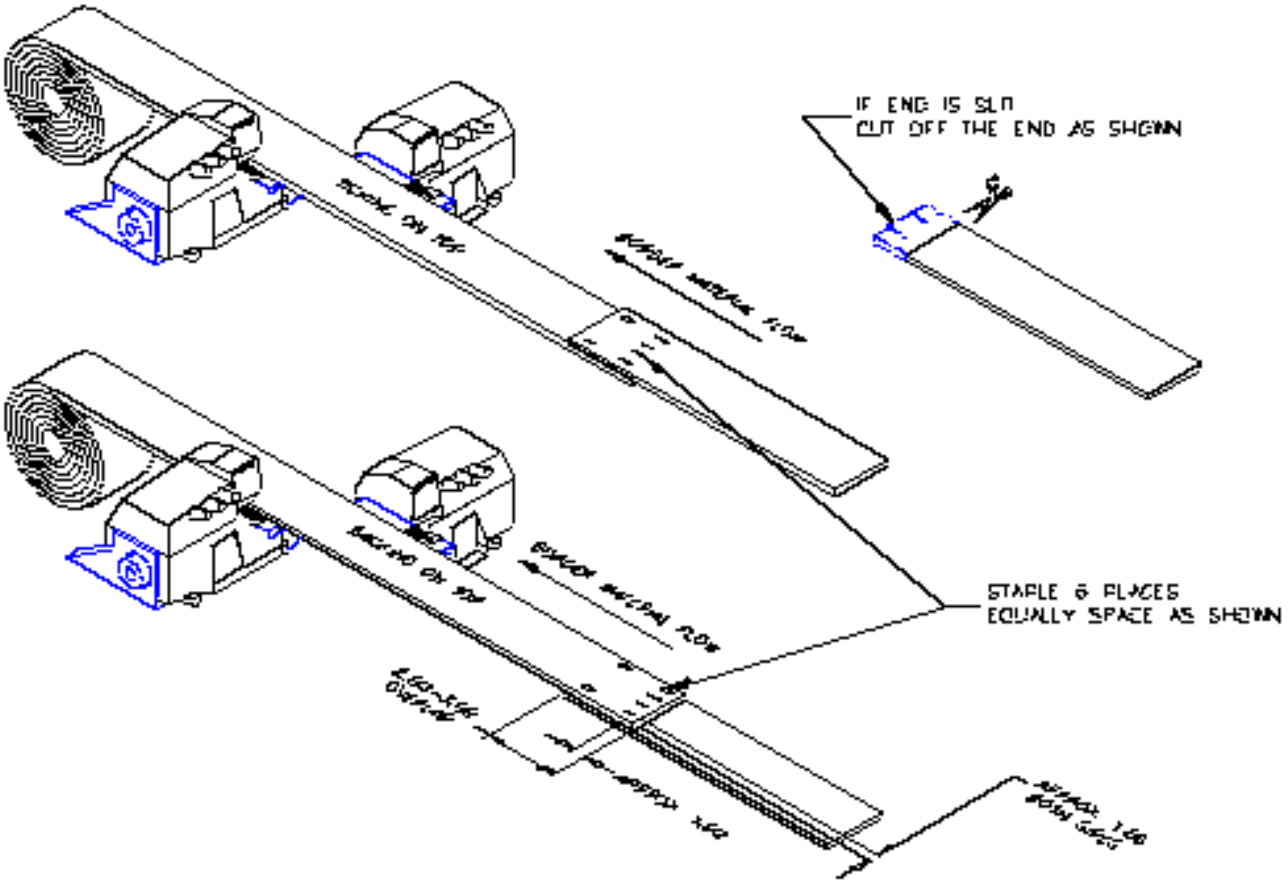



**1. Left Head Switch-** Turns the power on/off to the left head.

**2. Feed Roller Switch-** Positions the Feed Roller up/down. Feed Rollers must be down during operation.

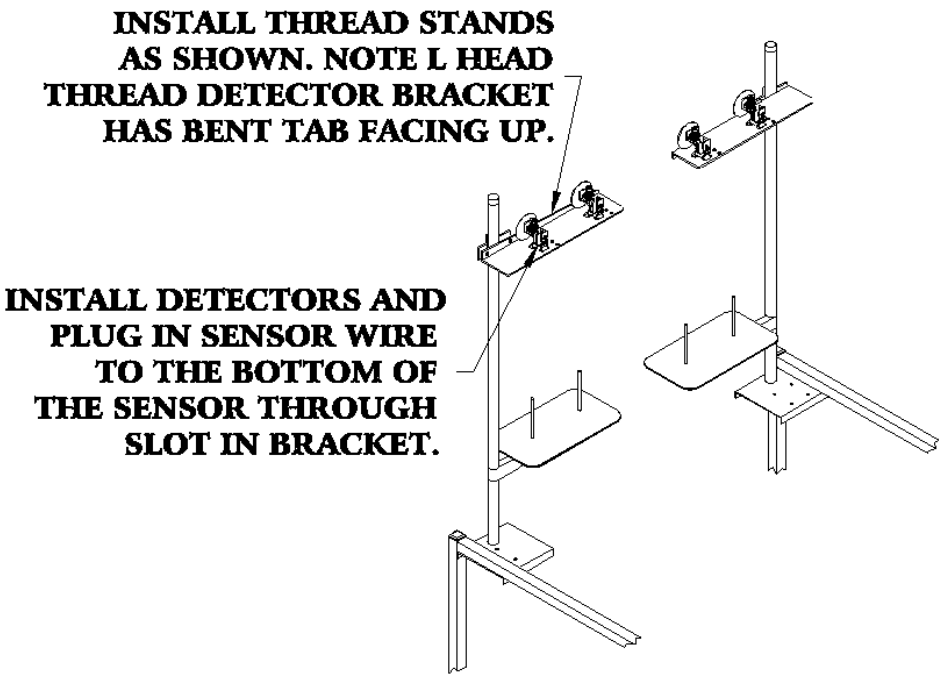
**3. (Optional) Rewind** Motor Switch- Reverses the direction of the rewind motor.

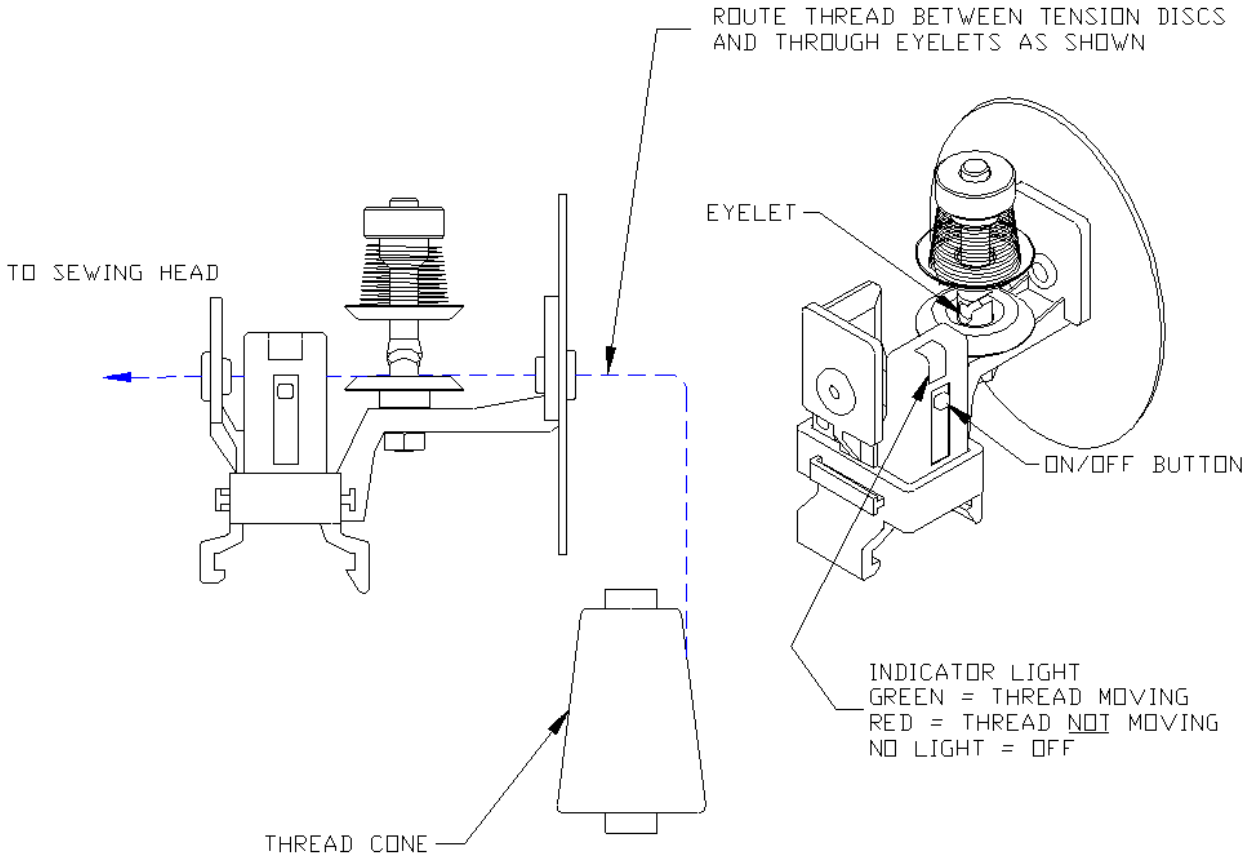
# Border Splicing Methods




**Note: The above illustration shows the two acceptable methods of border splicing for proper operation.**

# Thread Sensor Instructions



# Clutch-Brake Installation & Maintenance

## Installation

**Sheave and Pilot Mounting (See Figure 1)**

1) Insert the Key (Item 21) into the keyway of the mounting shaft.
2) Slide the BW Clutch onto the mounting shaft until the Key (Item 21) is seated in the BW Clutch.
3) Insert and tighten the two set screws (Item 20).

**Coupling Mounting (See Figure 2)**

1) Insert the Key (Item 21) into the keyway of the mounting shaft.
2) Slide the Pilot Mount BW Clutch onto the mounting shaft until the Key (Item 21) is seated in the Pilot Mount BW Clutch.
3) Insert and tighten the two set screws (Item 20).
4) Insert the customer supplied key into the coupling shaft.
5) Slide the Coupling Adapter onto the coupling shaft.
6) Using the cap screws provided with the Coupling Adapter, secure the Coupling Adapter to the Pilot Mount BW Clutch.
7) Insert and tighten the set screws provided with the Coupling Adapter.

**Brake Mounting (See Figure 3)**

1) Using the cap screws provided with the Brake Adapter, secure the Brake Adapter to the Pilot Mount BW Clutch.
2) Insert the Key (Item 21) into the keyway of the mounting shaft.
3) Slide the Pilot Mount BW Clutch with the Brake Adapter onto the mounting shaft and key.
4) Align the notch in the Brake Adapter with a torque pin or stop on the machine.
5) Insert and tighten the two set screws (Item 20).

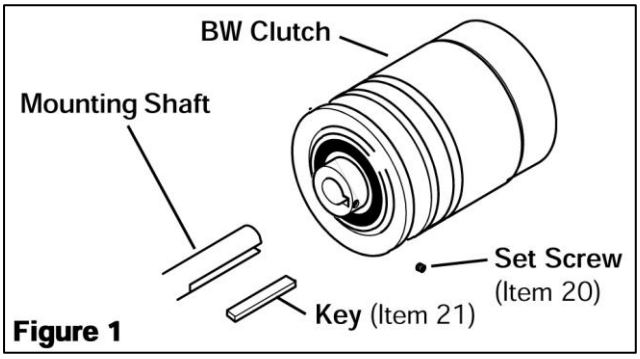


Figure 1

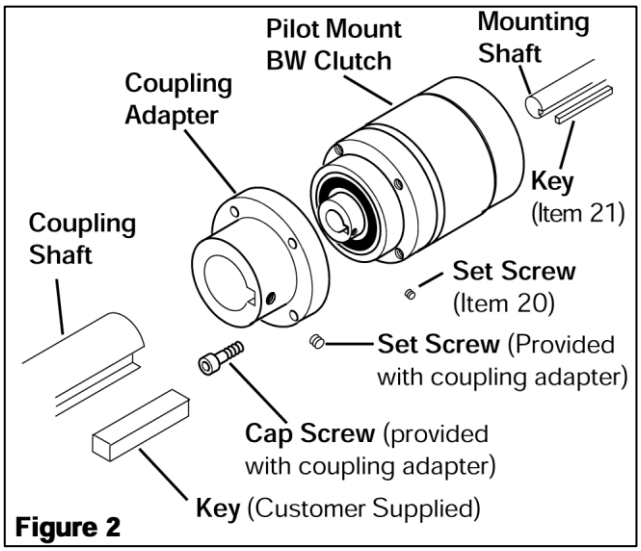


Figure 2

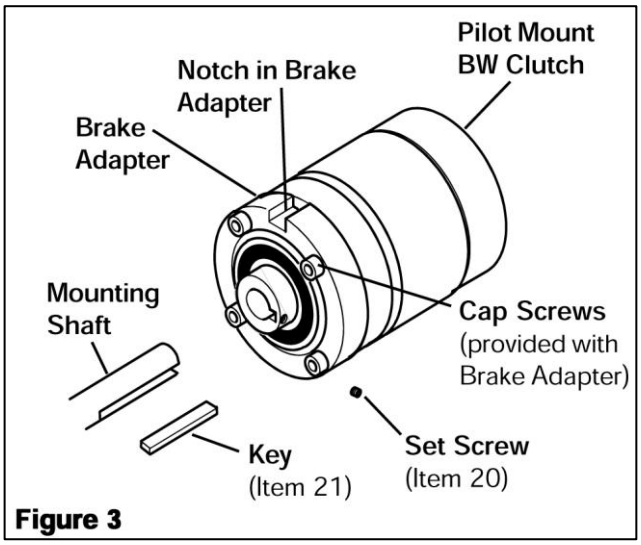


Figure 3

## Airline Connections

**See Figure 4 on page 19 for all references on this page**

A 1/8 NPT female air inlet fitting is provided in the piston (Item 13) for the airline connection. The Air Hose Assembly (Item 19) must be used so that no side forces are introduced to the air chamber-piston assembly.
Bearing drag on the hose during operation may be relieved by securing the hose to a support.

**Caution: The use of rigid pipe or tubing when connected directly to the BW Clutch will prevent proper actuation of the BW Clutch.**

## Lubrication

Nexen BW Clutches are factory lubricated and ready to install. The thrust bearings (Item 8) are packed with a lubricant specially selected for the BW Clutch. If it becomes necessary to lubricate the thrust bearings, use Nexen H-130 (Product No. 853900). Frequency of lubrication of the thrust bearings will depend on the speed of operation, temperature, and severity of application. The radial bearing (Item 3) is pre-lubricated, sealed, and requires no further lubrication. To disassemble the BW Clutch for lubrication, refer to Parts Replacement on page 19.

**Note: Pneumatically actuated devices require clean, pressure regulated, and lubricated air for maximum performance and long life. The most effective and economical way to lubricate Nexen Clutches is with and airline lubricator, which injects oil into the pressurized air, forcing an oil mist into the air chamber.**

Locate the lubricator above and within ten feet of the Clutch, and use a low viscosity oil such as SAE-10.

Synthetic lubricants are not recommended.

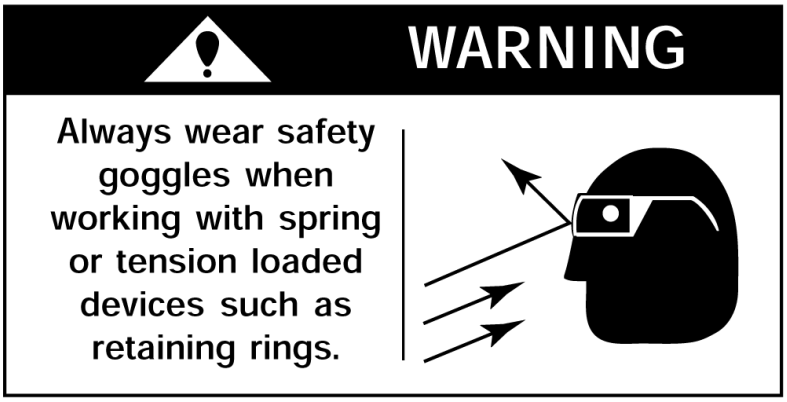
Lubricator Drip Rate Settings

**Note: These settings are for Nexen supplied lubricators. If you are not using a Nexen lubricator, calibration must replicate the following procedure.**

1) Close and disconnect the air line from the unit.
2) Turn the Lubricator Adjustment Knob clockwise three complete turns.
3) Open the airline.
4) Close the airline to the unit when a drop of oil forms in the Lubricator Sight Gage.
5) Connect the airline to the unit.
6) Turn the Lubricator Adjustment Knob counterclockwise until closed.
7) Turn the Lubricator Adjustment Knob clockwise 1/3 turn.
8) Open the airline to the unit.

# Parts Replacement

**See Figure 4 on page 19 for all references on this page**




1) Remove the Retaining Ring (Item 2)
2) Depending on which version of the BW Clutch is being used, remove the Pilot Mount Disc (Item 15) or the Sheave (Item 4).
3) Press the old Bearing (Item 3) out of the Sheave or Pilot Mount Disc.
4) Clean the bearing bore of the Sheave (Item 4) or Pilot Mount Disc (Item 15) with fresh solvent making sure all old Loctite® residue is removed.
5) Apply and adequate amount of Loctite® RC609 to evenly coat the outer race of the new Bearing (Item 3).
6) Carefully align the outer race of the new Bearing (Item 3) with the bore of the Sheave or Pilot Mount Disc and press the new Bearing (Item 3) into place.
7) Remove the first old Spring Retaining Washer (Item 23), old Return Spring (Item 5), and the second old Spring Retaining Washer (Item 23) from the Hub (Item 1).
8) Slide the old Friction Disc Assembly (Item 7) off of the Hub (Item 1).
9) Remove the old Disc Key (Item 6).
10) Slide the Hub (Item 1) out of the Air Chamber (Item 9) and Piston (Item 13).
11) Separate the Piston (Item 13) from the Air Chamber (Item 9).
12) Remove the old O-ring Seal (Item 11) form the Air Chamber (Item 9).
13) Press the old Thrust Bearing (Item 8) out of the Air Chamber (Item 9).
14) Carefully align the outer race of the new Thrust Bearing (Item 8) with the bore of the Air Chamber (Item 9) and press the new Thrust Bearing (Item 8) into place.
15) Remove the old O-ring Seal (Item 10) form the Piston (Item 13).
16) Press the old Thrust Bearing (Item 8) out of the Piston (Item 13).
17) Carefully align the outer race of the new Thrust Bearing (Item 8) with the bore of the Piston (Item 13) and press the new Thrust Bearing (Item 8) into place.
18) Clean the O-ring contact surfaces of the Air Chamber and Piston with fresh safety solvent.
19) Coat the O-ring contact surfaces of the Air Chamber and Piston with fresh O-ring lubricant and wipe off any excess lubricant.
20) Coat the new O-ring Seals (Items 10 and 11) with fresh O-ring Lubricant.
21) Install the new O-ring Seals (Items 10 and 11).
22) Slide the Piston (Item 13) into the Air Chamber (Item 9).
23) Slide the Air Chamber and Piston onto the Hub (Item 1).
24) Install the new Disc Key (Item 6) into the Hub.
25) Slide the new Friction Disc Assembly (Item 7 onto the Hub (Item 1) and Disc Key (Item 6).

**Note: The closed end of the Return Spring (Item 5) must face toward the Retaining Ring (Item 2).**

26) Install the new Return Spring (Item 5) and Spring Retaining Washers (Item 23).
27) Press the Pilot Mount Disc (Item 15) and Bearing (Item 3) or the Sheave (Item 4) and Bearing (Item 3) onto the Hub (Item 1).
28) Reinstall the Retaining Ring (Item 2).

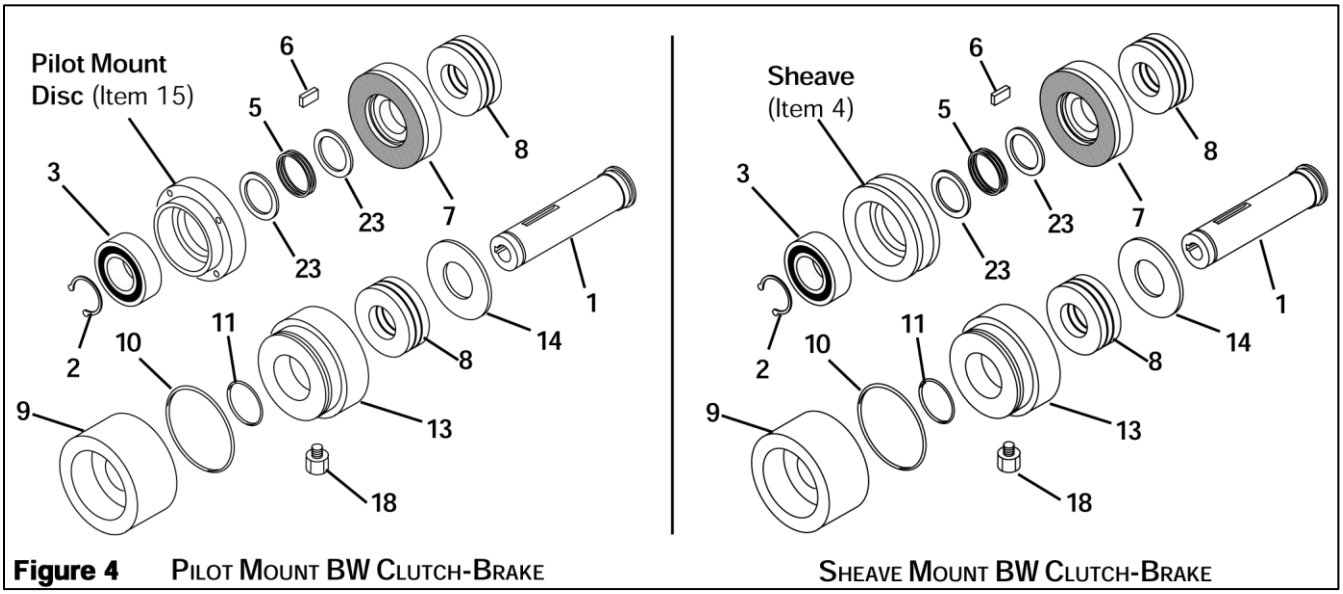



**Figure 4** PILOT MOUNT BW CLUTCH-BRAKE SHEAVE MOUNT BW CLUTCH-BRAKE

[1]

| ITEM | DESCRIPTION | QTY |
|---|---|---|
| 1 | Hub | 1 |
| 2 | Retaining Ring (Ext.) | 1 |
| 3 | Bearing | 1 |
| 4 | Sheave | 1 |
| 5[1] | Return Spring | 1 |
| 6[1] | Disc Key | 1 |
| 7[1] | Friction Disc Assembly | 1 |
| 8[1] | Thrust Bearing | 2 |
| 9 | Air Chamber | 1 |
| 10[1] | O-Ring Seal (Large) | 1 |
| 11[1] | O-Ring Seal (Small) | 1 |
| 13 | Piston | 1 |
| 14 | Washer | 1 |
| 15 | Pilot Disc Mount | 1 |
| 18 | Air Inlet Fitting | 1 |
| 19 | Air Hose Assembly (Not Shown) | 1 |
| 20 | Set Screw (Not Shown) | 2 |
| 21 | Key (Not Shown) | 1 |
| 23[1] | Spring Retaining Washer | 2 |

[1] Denotes Repair Kit Item (Repair Kit No. 846800)

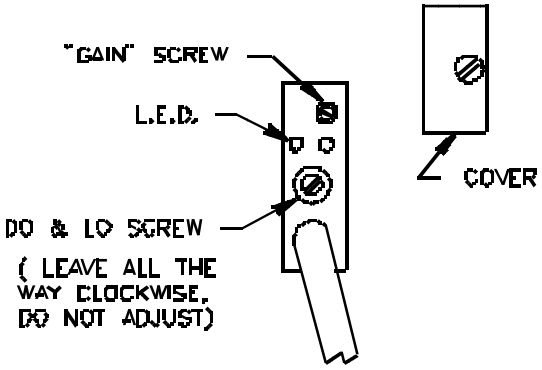
# Troubleshooting

| | |
|---|---|
| **Machine doesn't continue to run after the start button is pressed for the second time (after the power on LED is lit).** | |
| | 1. The thread break detectors are threaded wrong or damaged. (See thread sensor instructions on page 15).<br>2. The fabric sensor is not properly aligned (not looking through the slot) or damaged.<br>3. Left hand head is turned off, but the left hand head thread break sensors are turned on. |
| **Machine will not stop after fabric runs out** | |
| | 1. The fabric sensor is not properly aligned (not looking through the slot) or damaged.<br>2. Reflective tape on handwheel is worn or is not at least 1 inch long.<br>3. Motor speed has been decreased and is running slower than 5000 rpm. If this has occurred, call Atlanta Attachment Company for necessary adjustments to correct this problem. |
| **Sewing heads will not turn on** | |
| | 1. Check Left head on/off switch on rear of control box.<br>2. Check that all plugs on motor are plugged in securely. |
| **Heads sewing, but feed rollers not turning** | |
| | 1. Step motor control box should be turned on (see power light on front of step motor control box).<br>2. Check fuse in stepper motor control box.<br>3. Check belt going from step motor to feed roller.<br>4. Check pulleys on step motor and feed roller (set screws should be tight).<br>5. Thumbwheels on front of step motor control box should have a number value from 150-220. |
| **Heads sewing, feed rollers turning, but cloth not being pulled through** | |
| | 1. Check air pressure, should be 30-40 psi. Higher pressures may cause feed rollers to stall.<br>2. Check that feed roller switch is set for feed roller down.<br>3. Check that threads on edge of cloth are not wrapped around roll rod.<br>4. Thumbwheels on front of step motor control box should have a number value from 150-220. |
| **Cloth runs out from under foot.** | |
| | 1. Check that foot pressure on both heads is minimal - just enough to keep foot from vibrating. (Note: feed dogs are not used to feed the cloth on the 1961, the feed roller feeds the cloth and both feet just "float" on top of the cloth).<br>2. Check fabric threading through guide assembly: over first bar, under second. |

# Electric Eye Sensor Adjustment

To adjust the sensor, first remove the clear plastic cover from the end of the sensor. There are two adjusting screws under the cover. One is labeled “GAIN” and is used to set the sensitivity of the sensor. The other screw is labeled “DO & LO” and should always be fully clockwise.

With the end of the sensor pointing at the center of the reflective tape, turn the “GAIN” screw counter-clockwise until the red LED indicator is off. Then turn the “GAIN” screw clockwise until the LED indicator comes on. Then turn the “GAIN” screw one full turn clockwise. The LED indicator should be blinking slowly. Cover the eye so that the sensor cannot see the reflective tape and the LED should go off.




# Reflective Tape Maintenance

Use a soft cloth for cleaning.
Do not use chemicals or abrasives to clean it.
Avoid any contact with oils and liquids.
Do not touch the tape with bare fingers.
If tape is dirty or opaque, the eye may not function correctly.

# General Machine Maintenance

- Maintenance should only be performed by trained, qualified personnel. Before performing any maintenance or repair work, switch off the electrical, pneumatic, etc. power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.
- Always wear proper safety equipment when operating or performing maintenance on any equipment.
- All recommended maintenance is for a single shift schedule, adjust as necessary for a multi-shift operation.
- Equipment should not be used for purposes other than designed or specified.

## Daily (8 -10 hrs. of operation)

- Follow manufacturer’s recommendations and guidelines for operation, maintenance, and lubrication of the sewing head.
- Check for proper oil level and/or flow in the sewing head and other oil filled or lubed equipment, fill as needed. Oil all points as indicated.
- Clean the machine at the end of every shift or as excess materials accumulate.
- Clean lint, waste, etc. from the sewing, looper(s) and needle(s), area as it accumulates, remove or open covers as necessary for access.
- Remove any threads or other material(s) wrapped around or between any moving parts.
- Wipe all photocell lenses with a clean non-abrasive dry cloth.
- Open or remove doors and/or covers and inspect belt(s) for debris or wear and clean or replace as necessary.
- Monitor the air pressure filter/regulator and empty as necessary.
- Investigate and report any unusual noises to the proper personnel.

## Weekly (40 hrs. of operation)

- Sharp Cloth/Edge trimming knives are essential and should be sharpened as often as needed, check sharpness once a week and sharpen as necessary.
- Check the sewing head drive belt for proper tightness and wear. Adjust and replace as necessary.
- Inspect photocell reflective tape, i.e. (machine handwheel, etc.) and replace if dirty or worn.
- Inspect pillow blocks and other bearings (conveyors and rotating shafts) and remove thread and debris.
- Inspect all moving parts to ensure smooth operation, lube or clean as necessary.

## Monthly (160 hrs. of operation)

- Inspect pillow blocks and other non-sealed bearings (conveyors and rotating shafts) and apply one shot of recommended grease to each bearing/fitting.
- Refer to the manufacturer's guidelines for oil and oil filter changes and other maintenance pertaining to the sewing head and other OEM equipment.
- Monitor the air pressure filter/regulator and replace the filter as necessary.

# Recommended Spare Parts List

Contact AAC's sales department to order replacement parts.

Phone: 770-963-7369
Fax: 770-963-7641
Email: sales@atlatt.com
Website: www.atlatt.com

## AAC Part # SP1962EG24 Spare Parts Kit (Standard Cutter)

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 1 | 000593-91 | Timing Gauge | 9 | 100 | SNB27140 | Needle |
| 2 | 6 | 277000 | Upper Cutter | 10 | 1 | UM-68D | Stone |
| 3 | 6 | 277009 | Lower Cutter | 11 | 1 | UM-68KH10M | Lower Cutter Jig |
| 4 | 2 | 277014A | Spreader | 12 | 1 | UM-SKS10 | Portable Sharpener |
| 5 | 2 | 277034 | Lower Looper | 13 | 3 | ZZZSR-202 | Staples |
| 6 | 1 | 277511S70M | Throat Plate | 14 | 1 | ZZZSR-20W | Scizzors |
| 7 | 1 | FFT18FF100Q | Electric Eye | 15 | 1 | ZZZSR-220 | Plier |
| 8 | 1 | MM742-27BN | Bulb, 12V | | | | |

## AAC Part # SP1962EG24HD1 Spare Parts Kit (Wide 10mm Cutter)

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 1 | 000593-91 | Timing Gauge | 12 | 1 | 277511S70M | Throat Plate |
| 2 | 1 | 201230CM | Shoe, RH, Mod | 13 | 1 | FFT18FF100Q | Electric Eye |
| 3 | 4 | 210371 | Finger | 14 | 1 | MM742-27BN | Bulb, 12V |
| 4 | 6 | 277000 | Upper Cutter | 15 | 200 | SNB27140 | Needle |
| 5 | 4 | 277004 | Needle Guard | 16 | 1 | UM-68D10 | Stone |
| 6 | 4 | 277005 | Front Needle Guard | 17 | 1 | UM-68KH10M | Lower Cutter Jig |
| 7 | 6 | 277009 | Lower Cutter | 18 | 1 | UM-SKS10 | Portable Sharpener |
| 8 | 4 | 277014A | Spreader | 19 | 3 | ZZZSR-202 | Staples |
| 9 | 4 | 277034 | Lower Looper | 20 | 1 | ZZZSR-20W | Scizzors |
| 10 | 1 | 277378A25 | Feed Dog, Diff. | 21 | 1 | ZZZSR-220 | Plier |
| 11 | 1 | 27738025 | Feed Dog, Main | | | | |

# 1962-LPAR4 Parameter Settings

**Before Programming, Perform a Master Reset of Parameters (See Below)**

| PARAMETER | RANGE | VALUE | DESCRIPTION |
|---|---|---|---|
| 290 | | 0 | Mode of operation. MUST SET THIS PARAMETER FIRST! |
| 026 | 0-5 | 0 | F-026=0 to disable the EB401 selection after power on. |
| 111 | 400-9900 rpm | 5000/6000 | Maximum speed when "129" is 0, 1, or 2. |
| 119 | 1-3 | 1 | Linear acceleration |
| 161 | 0-1 | 1=CCW | Motor rotation |
| 240 | 0-31 | 6 | Machine run blockage with open contact |
| 270 | 0-5 | 1 | External handwheel sensor configuration. |
| 272 | 015-9999 | 1000 | Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111. (For Yamato and Pegasus, setting should be 1000; for Rimoldi, setting should be 1240) |
| 436 | | 0 | Use code "5913". This disables an input that was causing box to reset itself. |
| 401 | 0 | 1 | Change 401 from 0 to 1 to save all parameters |

Front panel LED's:

LED 1: Off
LED 2: Off
LED 3: Off
LED 4: Off
LED 5: Off
LED 6: Off
LED 7: Off, Stop at needle down.
LED 8: On, Stop at needle up.

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "3112"
3. Press "E" once and "2.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E"
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
8. Run sewing head to save parameters before powering down

**To Perform Master Reset of Parameters:**

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "5913"
3. Press "E" twice and "093" is displayed.
4. Press "+" once, "094" is displayed.
5. Press "P" to exit programming mode with all default values.

**NOTE: Set sewing speed at 5000 and puller speed to 800 for first 90 days of operation and then increase to 6000 and 1000 if desired.**

# 1962-PPAR4 Parameter Settings

**Before Programming, Perform a Master Reset of Parameters (See Below)**

1961 PARAMETER SETTINGS FOR PULLER MOTOR

| PARAMETER | RANGE | VALUE | DESCRIPTION |
|---|---|---|---|
| 290 | | 0 | Mode of operation. MUST SET THIS PARAMETER FIRST! |
| 026 | 0-5 | 0 | F-026=0 to disable the EB401 selection after power on. |
| 111 | 400-9900 | 800/1000* | Maximum speed when "129" is 0, 1, or 2. ** |
| 119 | 1-3 | 1 | Linear acceleration |
| 153 | 0-50 | 35 | Braking power at standstill |
| 161 | 0-1 | 1-CCW | Motor rotation |
| 161 | 0-1 | 0-CW | Motor rotation for worm drive pullers |
| 220 | 1-55 | 5 | Acceleration |
| 270 | 0-5 | 5 | No handwheel sensor |
| 272 | 015-9999 | 240 | Drive ratio for worm drive pullers. (current model)<br>(Older belt drive pullers should be set on 1000)<br>The smaller the number the higher the speed |
| 436 | | 0 | Use code "5913". This disables an input that was causing box to reset itself. |
| 401 | 0 | 1 | Change 401 from 0 to 1 to save all parameters |

Front panel LED's:

LED 1: Off
LED 2: Off
LED 3: Off
LED 4: Off
LED 5: Off
LED 6: Off
LED 7: Off, Stop at needle down.
LED 8: Off

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "3112"
3. Press "E" once and "2.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E"
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
8. Run sewing head to save parameters before powering down

**To Perform Master Reset of Parameters:**

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "5913"
3. Press "E" twice and "093" is displayed.
4. Press "+" once, "094" is displayed.
5. Press "P" to exit programming mode with all default values.

***Set sewing speed at 5000 and puller speed to 800 for first 90 days of operation and then increase to 6000 and 1000 if desired.**

# 1962-RPAR4 Parameter Settings

**Before Programming, Perform a Master Reset of Parameters (See Below)**

| PARAMETER | RANGE | VALUE | DESCRIPTION |
|---|---|---|---|
| 290 | | 0 | Mode of operation. MUST SET THIS PARAMETER FIRST! |
| 026 | 0-5 | 0 | F-026=0 to disable the EB401 selection after power on. |
| 111 | 200-9900 rpm | 5000/6000 | Maximum speed when "129" is 0, 1, or 2. |
| 119 | 1-3 | 1 | Linear acceleration |
| 161 | 0-1 | 0=CW | Motor rotation |
| 270 | 0-5 | 1 | External handwheel sensor configuration. |
| 272 | 015-9999 | 1000 | Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111. (For Yamato and Pegasus, setting should be 1000; for Rimoldi, setting should be 1240) |
| 436 | | 0 | Use code "5913". This disables an input that was causing box to reset itself. |
| 401 | 0 | 1 | Change 401 from 0 to 1 to save all parameters |

Front panel LED's:

LED 1: Off
LED 2: Off
LED 3: Off
LED 4: Off
LED 5: Off, Stop at needle down.
LED 6: On, Stop at needle up.
LED 7: Off
LED 8: Off

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "3121"
3. Press "E" once and "4.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E"
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
8. Run sewing head to save parameters before powering down

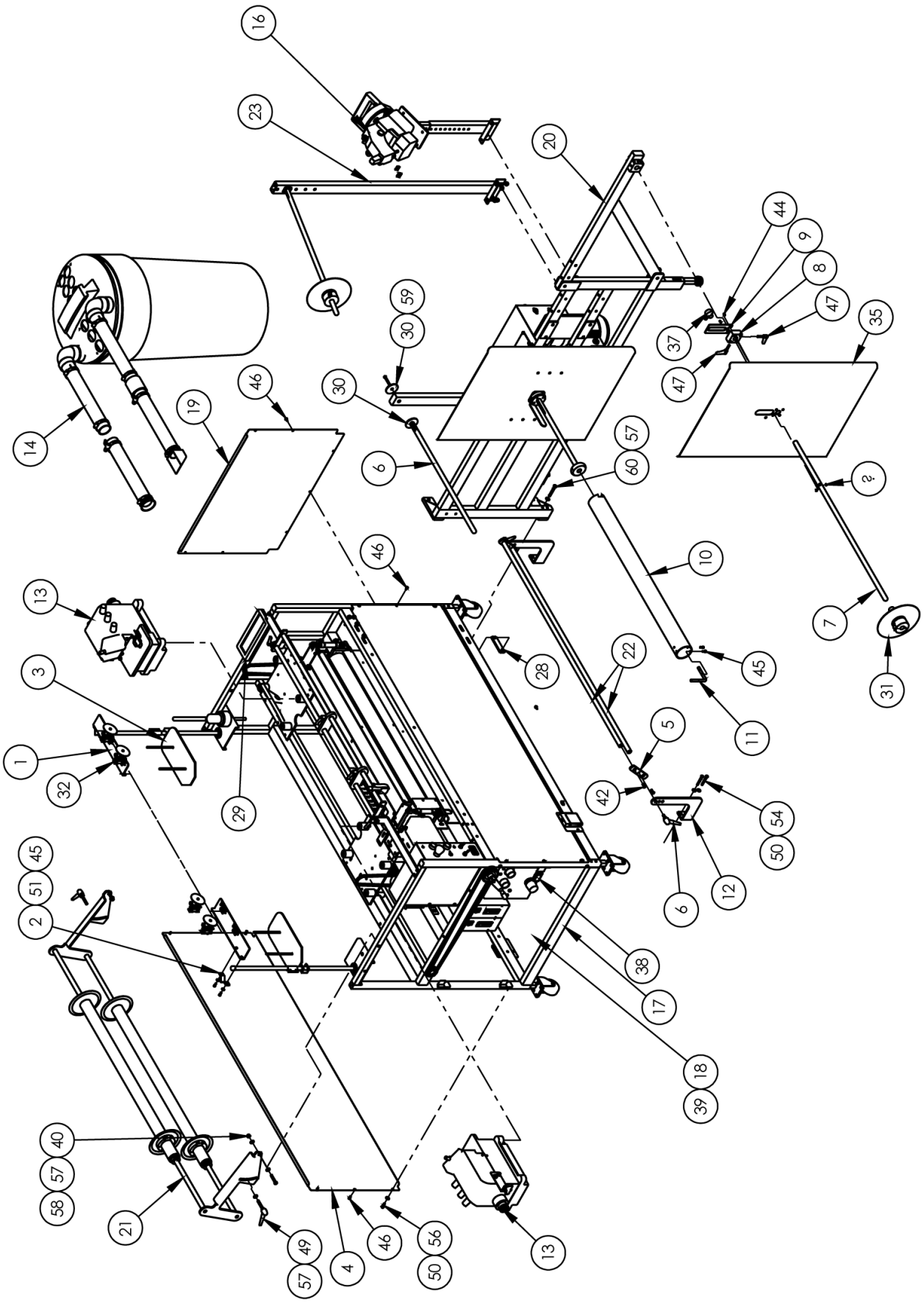
**To Perform Master Reset of Parameters:**

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "5913"
3. Press "E" twice and "093" is displayed.
4. Press "+" once, "094" is displayed.
5. Press "P" to exit programming mode with all default values.

**NOTE: Set sewing speed at 5000 and puller speed to 800 for first 90 days of operation and then increase to 6000 and 1000 if desired.**

# Assembly Drawings & Parts Lists

The materials contained herein are confidential and proprietary information of Atlanta Attachment Company. In addition to any confidentiality and non-disclosure obligations that currently exist between you and Atlanta Attachment Company, your use of these materials serves as an acknowledgment of the confidential and proprietary nature of these materials and your duty not to make any unauthorized use or disclosure of these materials.



# 11962EG24EH Auto Border Sew, O&U Head

AAC Drawing Number 9002052 Rev 12

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 2 | 0411-069B | BRKT, THREAD BREAK DETECT | 31 | 1 | 33008708 | BALL BEARING DISC ASSY |
| 2 | 2 | 0411-070 | CLAMP, SENSOR BRACKET | 32 | 4 | 4003-IS3WT2 | SENSOR,THREAD BREAK |
| 3 | 2 | 1959-112 | 2 POS THREAD PLATE ASSY | 33 | 2 | 4059-EXT1 | CABLE,18", 6 COND |
| 4 | 2 | 1961-152G | COVER,REAR, 0-36" | 34 | 2 | 4059-EXT2 | CABLE,18", 4 COND |
| 5 | 2 | 1961-207A | PLATE, END | 35 | 1 | 784B-2432 | PLATE, ALU |
| 6 | 1 | 1961-252D | ROD, ROLL, 27" L | 36 | 2 | 97-2250A | SPACER, THREAD STAND |
| 7 | 1 | 1961-252E | ROD,ROLL,38.0L | 37 | 1 | FFT18FF100Q | EYE,FIXED FIELD, 4IN |
| 8 | 1 | 1961-253A | HUB, UNWIND STAND | 38 | 1 | MM40450010 | FASTENER,SLIDE LOCK |
| 9 | 1 | 1961-255 | BRACKET, SENSOR MTG | 39 | 2 | MMSLD-ECH | 1/2" DIA RUBBER BUMPER |
| 10 | 1 | 1961-372E | SLEEVE, REWIND, 36" CAP | 40 | 2 | NNE5/16-18 | NUT,ELASTIC LOCK,5/16-18 |
| 11 | 1 | 1961-374A | HANDLE, SLEEVE | 41 | 10 | SNB27140 | NEEDLE, SIZE 140 |
| 12 | 2 | 1961-403D | SUPPORT, GUIDE | 42 | 4 | SSFC01048 | 1/4-20 X 3/4 FLAT CAP |
| 13 | 2 | 1961-500F | SEWING HEAD ASSEM. RH | 43 | 4 | SSFC80016 | SCR,FLAT HD,CAP,6-32 X 1/4 |
| 14 | 1 | 1961-800E | WASTE ASSEMBLY | 44 | 2 | SSSC80016 | 6-32 X 1/4 SOC CAP SC |
| 15 | AR | 1961-900WD3 | DIAGRAM, WIRING | 45 | 6 | SSSC98032 | 10-32X1/2, SOC CAP |
| 16 | 1 | 1961-KIT10 | BORDER SPLICING ASSY | 46 | 15 | SSZS93032 | SCREW, SHT.METAL 10 ZIP |
| 17 | 1 | 1962-001E | MAIN ASSY,O/U,36" CAP | 47 | 2 | TTH32416 | HANDLE,THRD,1/4-20X1-1/8 |
| 18 | 1 | 1962-151C | DOOR,1962,29.5X19.3 | 48 | 2 | TTH32425 | HANDLE,THRDED,5/16-18X3/4 |
| 19 | 1 | 1962-152 | COVER,SIDE,18,24 & 36" | 49 | 2 | TTH32429 | HANDLE,THRD,5/16-18X2.0 |
| 20 | 1 | 1962-320G | PREFEED & REWIND ASSY | 50 | 9 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 21 | 1 | 1962-350E | ROLLER ASSY,REAR,38" | 51 | 4 | WWFS10 | WASHER, FLAT, #10, SAE |
| 22 | 2 | 1962-353D | ROD, STRAIGHT. SP, 303 SS | 52 | 1 | WWL1/4 | WASHER,LOCK,1/4 |
| 23 | 1 | 1962-KIT6 | ROLLER ASSEMBLY | 53 | 4 | WWL10 | WASHER,LOCK,#10 |
| 24 | AR | 1962-LPAR | PARAMETER SETTINGS, LFT | 54 | 4 | SSHC01128 | 1/4-20 X 2 HEX CAP |
| 25 | AR | 1962-PPAR | PARAMETER SETTINGS P MTR | 55 | 4 | WWF5/8 | WASHER,FLAT,5/8 |
| 26 | AR | 1962-RPAR | PARAMETER SETTINGS, RT | 56 | 4 | SSHC01048 | 1/4-20 X 3/4 HEX CAP |
| 27 | 2 | 2 SPOOL TS | 2 SPOOL THREAD STAND | 57 | 10 | WWFS5/16 | WASHER,FLAT,SAE,5/16 |
| 28 | 2 | 211-038 | NUT PLATE, FOLDER MOUNT | 58 | 2 | SSHC10112 | SCREW,HEX,5/16-18X1-3/4 |
| 29 | 1 | 26151 | TOOL TRAY, 1X3.5X9 | 59 | 1 | SSHC01112 | HEX HEAD BOLT 1/4-20X1.75 |
| 30 | 2 | 33008226 | DISC,10GA,SS,2.25 x 10MM | 60 | 4 | SSHC10144 | SCREW,HEX,5/16-18X2-1/4 |

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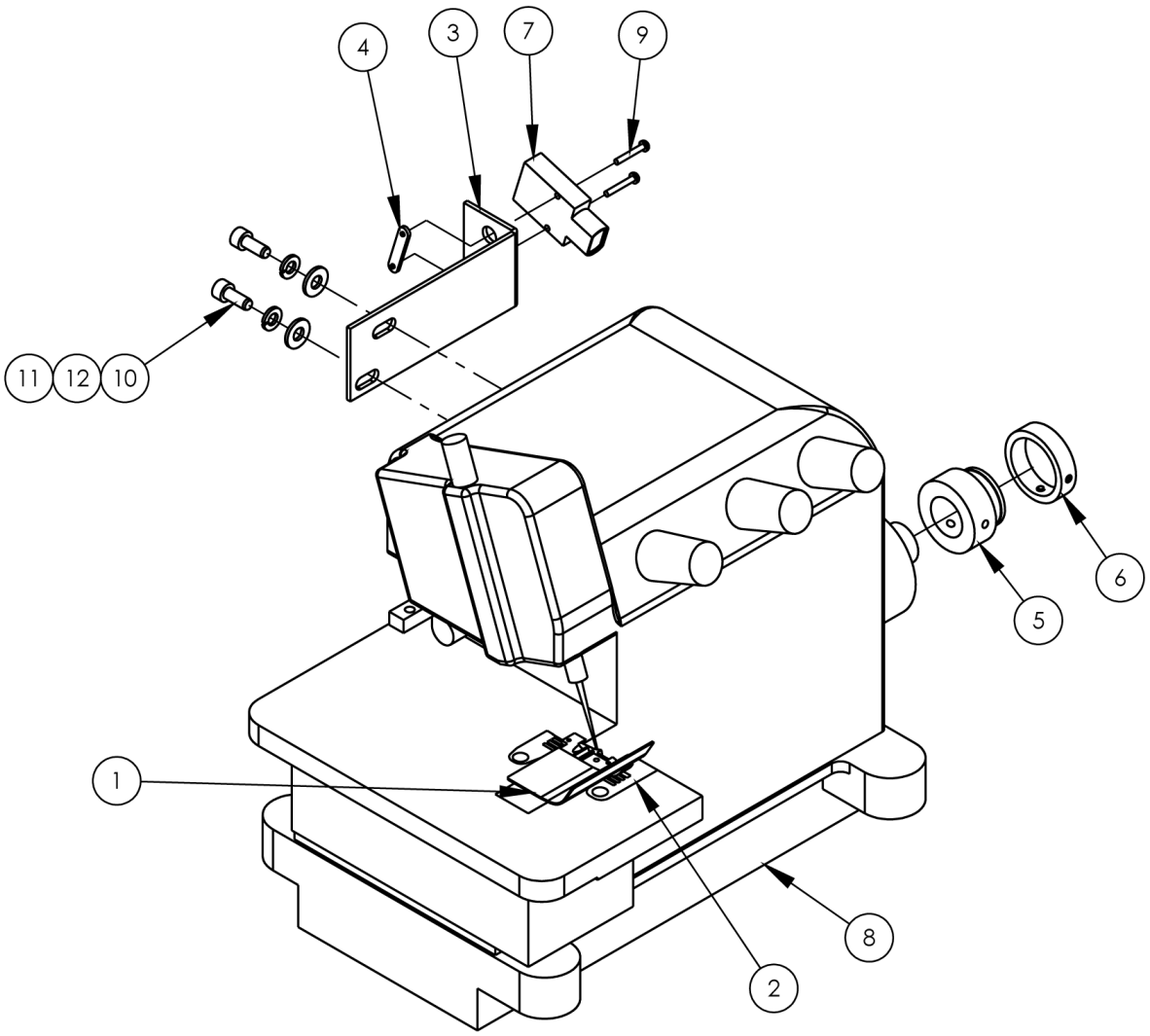
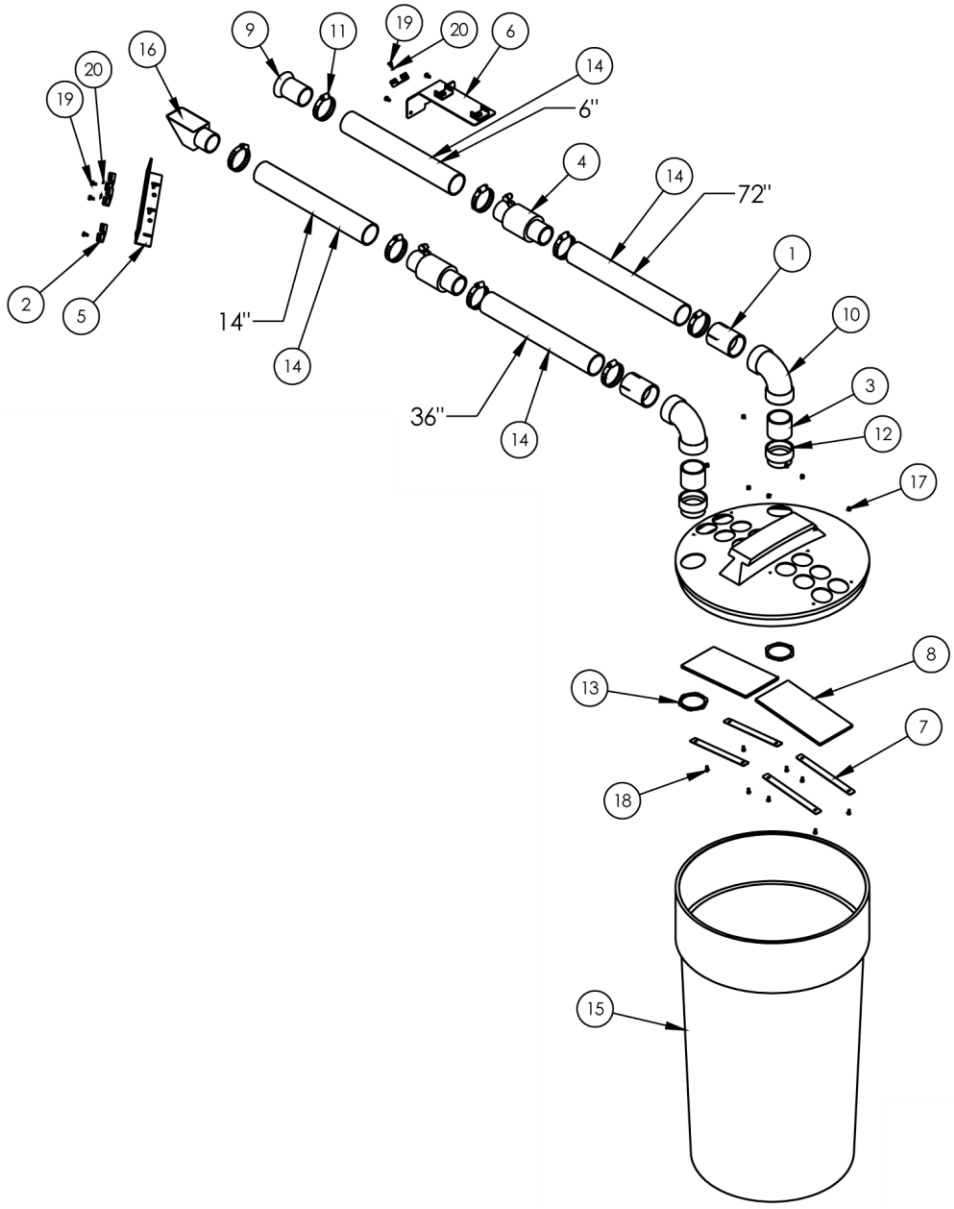



# 1961-500F Sewing Head Assembly

AAC Drawing Number 9001620 Rev 2

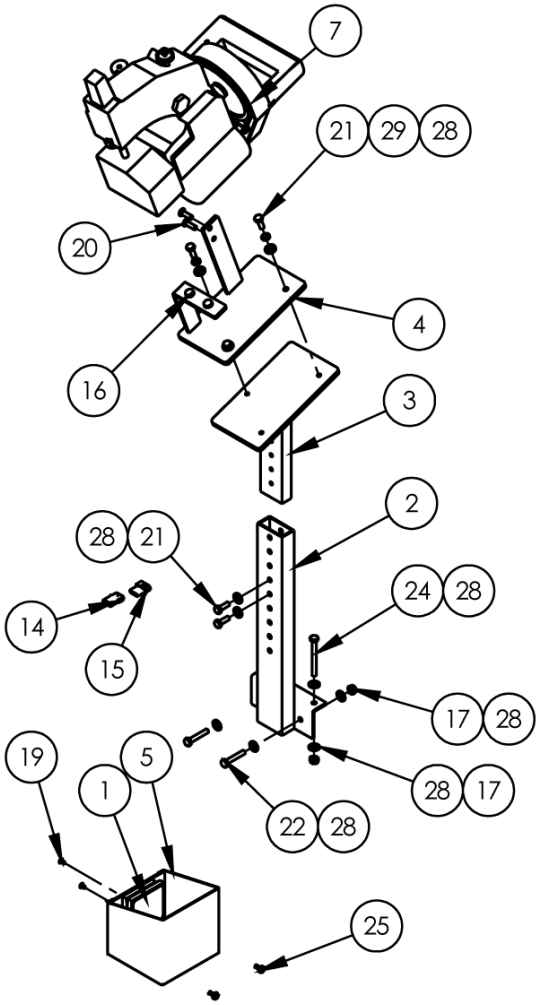
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | AR | 1961-411 | FOOT, R.H., MODIFIED |
| 2 | AR | 1961-419HD4 | PLATE, NEEDLE, MOD HD 4 R |
| 3 | 1 | 1962-424 | EYE MOUNT, POS. 1 SENSOR |
| 4 | 1 | 1975-412A | PLATE,NUT,4-40,.95CTC |
| 5 | 1 | 311-128 | HUB, HANDWHEEL, TAPE MOUN |
| 6 | 1 | 311-129 | SLEEVE TAPE MOUNT ADJUST |
| 7 | 1 | FFSM312LVQ | EYE,ELECTRIC,10-30VDC |
| 8 | 1 | spegex5203h | SEW HEAD,ST,NDL,DIFF,5MM |
| 9 | 2 | SSPS70048 | 4-40 X 3/4 PAN HD SLOTTED |
| 10 | 2 | SSSCM6X15 | M6X15 SOC CAP SCREW |
| 11 | 2 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 12 | 2 | WWL1/4 | WASHER,LOCK,1/4 |




# 1961-800E Waste Assembly

AAC Drawing Number 9002005 Rev 2

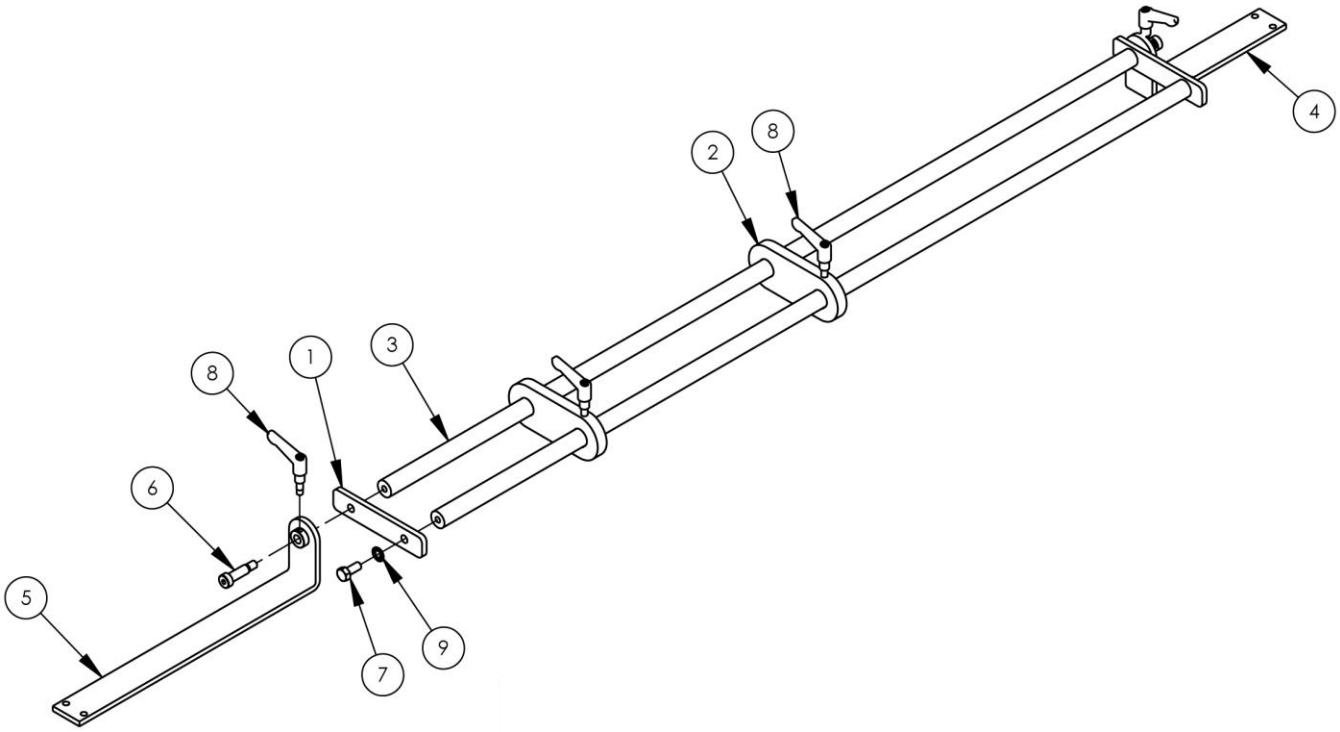
| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 2 | 1961-802 | ADAPTER, 2" PVC TO | 11 | 8 | MM5415K19 | CLAMP,HOSE,WORM TYPE 1-9/ |
| 2 | 6 | 1961-803 | CHANNEL, TUBE CLAMP | 12 | 2 | MM610364 | ADAPTOR, 2" PVC THR.M. |
| 3 | 2 | 1961-809 | PIPE SEGMENT, 2" ID | 13 | 2 | MM655462 | RING, 2" THREADED LOCK |
| 4 | 2 | 1961-817 | VENTURI ASSY,2" | 14 | *10.7' | MMFH200 | HOSE,FLEX 2" ID |
| 5 | 1 | 1961-818A | BRACKET, MOUNT, RIGHT | 15 | 1 | MMTC32GTAN | CONTAINER,WASTE |
| 6 | 1 | 1961-819 | BRACKET, MOUNT, LEFT | 16 | 1 | MMVLR-11T | FUNNEL, WASTE REMOVAL |
| 7 | 4 | 26282A | FILTER HOLDER | 17 | 8 | NNK8-32 | NUT,KEP,8-32 |
| 8 | 2 | 26285A | FILTER,WASTE SYSTEM | 18 | 8 | SSPS90024 | #8-32 X 3/8 LG PAN HD |
| 9 | 1 | MM00251 | FUNNEL,WASTE | 19 | 10 | SSPS98024 | 10-32X3/8 PAN HD SLOT |
| 10 | 2 | MM189472 | ELBOW, 2" SCH 40 PVC | 20 | 10 | WWL10 | WASHER,LOCK,#10 |




# 1961-KIT10 Border Splicing Assembly

AAC Drawing Number 9002027 Rev 7

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 1 | 1278-6161 | FOOT SWITCH MODIFICATION | 16 | 2 | MMSLD-ECH | 1/2" DIA RUBBER BUMPER |
| 2 | 1 | 1961-005 | BASE,MNT,BAG CLOSER | 17 | 4 | NNK1/4-20 | NUT,HEX,KEP,1/4-20,W/LOCK |
| 3 | 1 | 1961-008 | RISER,BAG CLOSER | 18 | 10 | SNDX1X25 | NEEDLE |
| 4 | 1 | 1961-014 | MTG BRKT,BAG CLOSER | 19 | 2 | SSFC80016 | SCR,FLAT HD,CAP,6-32 X 1/4 |
| 5 | 1 | 1961171 | PEDAL MOUNT PLATE,W/GUARD | 20 | 2 | SSFCM6X20 | M6 X 20 FLAT ALLEN |
| 6 | 6 | AAF3/16 | CLAMP, BLACK PLASTIC | 21 | 5 | SSHC01048 | 1/4-20 X 3/4 HEX CAP |
| 7 | 1 | BC-1 | BORDER CLOSER MACHINE | 22 | 2 | SSHC01096 | 1/4-20 X 1-1/2 HHCS |
| 8 | 1 | BC-1LAB | LABEL | 23 | 2 | SSHC01112 | HEX HEAD BOLT 1/4-20X1.75 |
| 9 | 6 | EE18-2 | BLACK TWO COND. CABLE | 24 | 2 | SSHC01160 | 1/4-20 X 2-1/2 HHCS |
| 10 | 12 | EE6X752 | TIE WRAP - Small. | 25 | 2 | SSZS93032 | SCREW, SHT.METAL 10 ZIP |
| 11 | 8 | FF19509 | CABLE,3 COND,18 AWG,SJTOW | 26 | 2 | TTAA5267 | TERMINAL, FE,INS,18-22 |
| 12 | 3 | FF31F1022 | PIN, MALE .093 | 27 | 1 | W1061-3 | NUT, WIRE |
| 13 | 3 | FF31F1023 | PIN, FEMALE .093 | 28 | 14 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 14 | 1 | FF59F1798 | CONNECTOR,FEMALE,3 PIN | 29 | 7 | WWL1/4 | WASHER,LOCK,1/4 |
| 15 | 1 | FF59F1803 | 3 PIN MALE CONN | | | | |

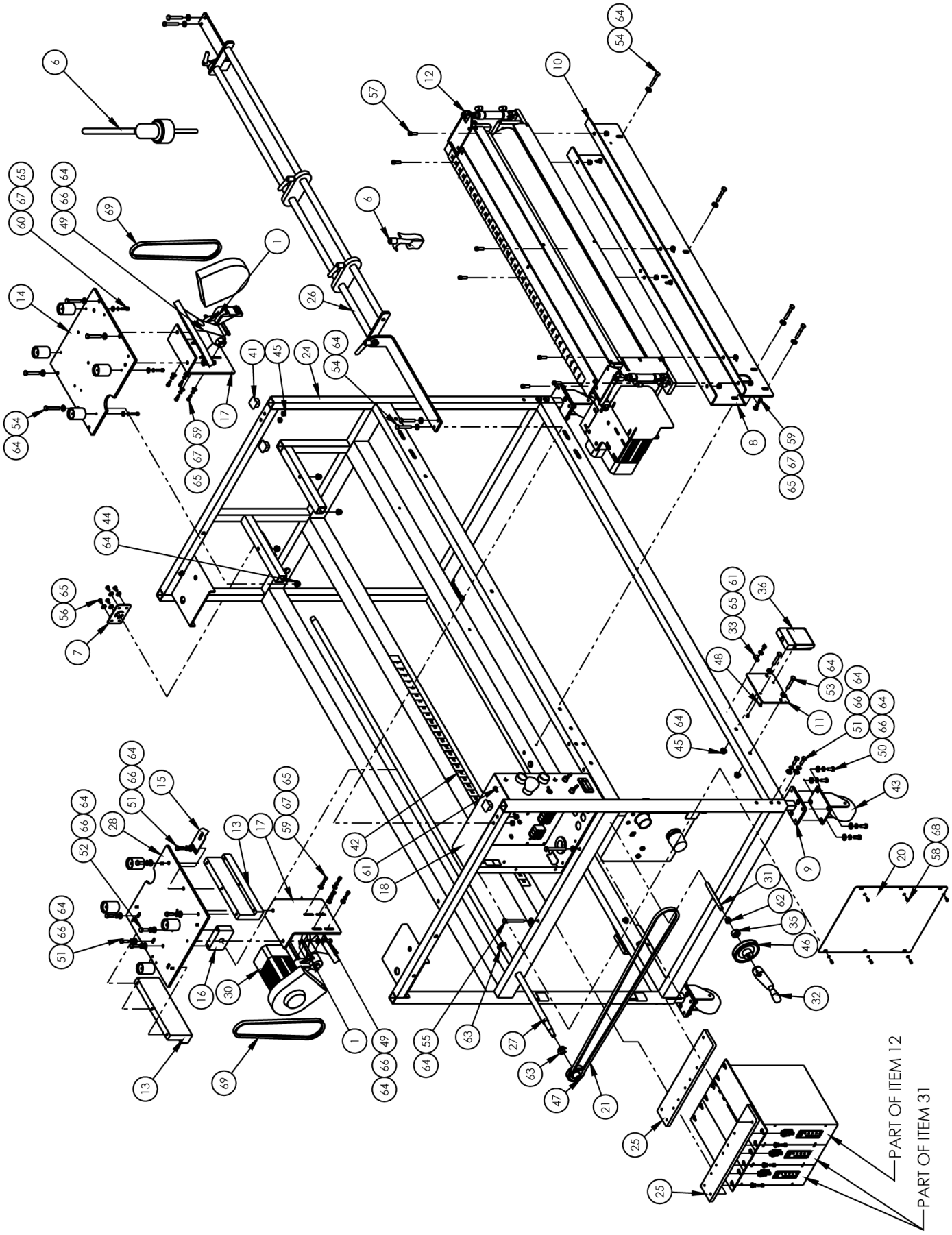





# 1962-210A Tension Rack Assembly, 36”

AAC Drawing Number 9002042 Rev 2

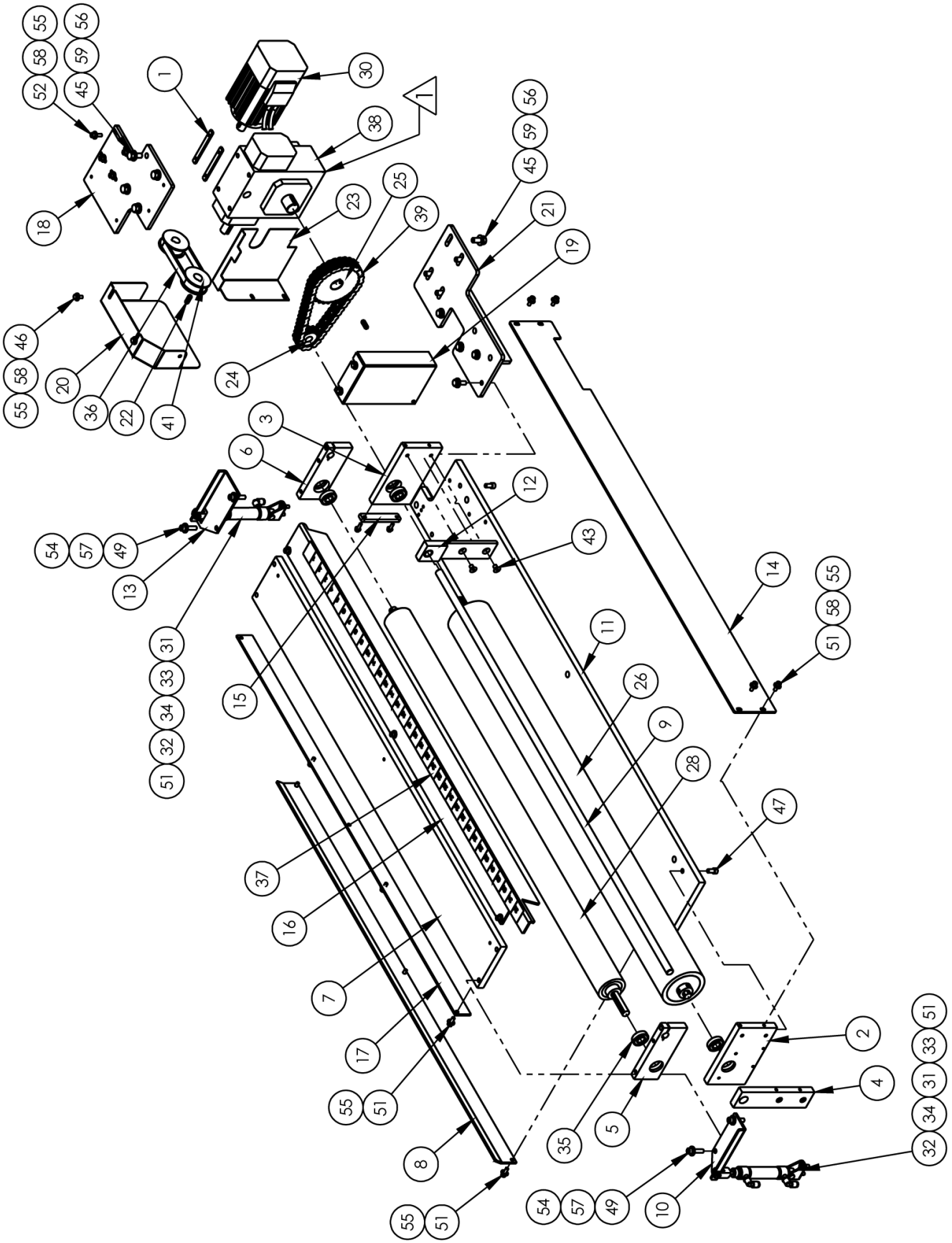
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 2 | 1961-207 | PLATE, END |
| 2 | 2 | 1961-211 | PLATE, EDGE GUIDE |
| 3 | 2 | 1962-206A | ROD, MATERIAL TENSION,42" |
| 4 | 1 | 1962-403 | SUPPORT, GUIDE |
| 5 | 1 | 1962-403B | SUPPORT, GUIDE, LONG |
| 6 | 2 | SSAS024064 | SHULDER BOLT 3/8 X .1.00L |
| 7 | 2 | SSHC10048 | 5/16-18 X 3/4 HHCS |
| 8 | 4 | TTH32415 | HANDLE,THREADED,1/4-20X7/ |
| 9 | 2 | WWSI5/16 | WASHER,INTERNAL TOOTH,5/16 |



# 1962-001E Main Assembly, O/U, 36” Cap

AAC Drawing Number 9002051 Rev 10

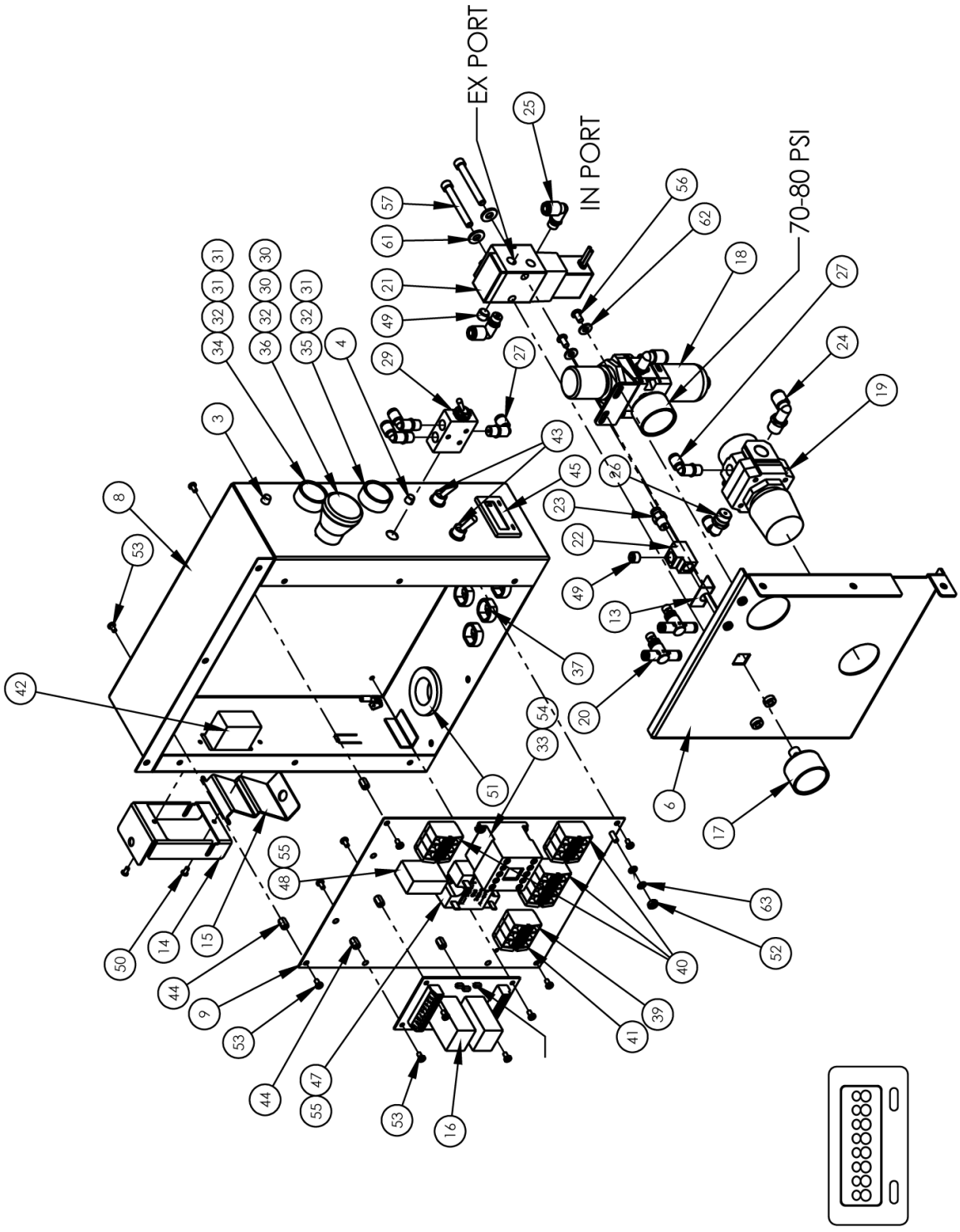
| | NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|---|
| | 1 | 4 | 0211-209 | PLATE,NUT,10-32@2.25 CTC | 36 | 2 | EE24F163 | FOOTSWITCH, TREADLITE |
| | 2 | 2 | 0211-702A | CABLE,POS. SENSOR,6' | 37 | 1 | EE37F3311 | CEE POWER CORD, 6' |
| | 3 | 1 | 0211-703A | CABLE,SYNC. ONLY | 38 | *3.5' | EEDC15X15 | DUCT,WIRE COVER,1.5 |
| | 4 | 1 | 0211-705H | CABLE,TREADLE,EXTENSION | 39 | *3.5' | EEDE15X15 | DUCT,WIRE,1.5X1.5 |
| | 5 | 8 | 1100321B | MOUNT,ISOLATOR | 40 | 1 | FFRK44T-4 | CABLE,EYE,12',NO END |
| | 6 | 1 | 1278-1095 | KIT,AAC,BLOW GUN & LIGHT | 41 | 3 | MM132-1202 | END CAP,SQUARE,BLACK |
| | 7 | 1 | 1961-101B | BRKT, HEAD ADJ SCREW | 42 | 1 | MM1910A23M | RULER,SILVER MYLAR 36" |
| | 8 | 1 | 1961-111E | SUPPORT,PULLER,HEAVY DUTY | 43 | 4 | MM427-3RB | CASTER,SWIVEL,3"RUBBER |
| | 9 | 4 | 1961-115 | LEG WELDMENT | 44 | 4 | NNH1/4-20 | NUT,HEX,1/4-20 |
| | 10 | 1 | 1961-121E | SUPPORT,PULLER | 45 | 19 | NNK1/4-20 | NUT,HEX,KEP,1/4-20,W/LOCK |
| | 11 | 2 | 1961-159 | PLATE, MOUNT, FOOT PEDAL | 46 | 1 | PPM6245K116 | PULLEY,V,3.0 OD, |
| Page 38 | 12 | 1 | 1961-300GB | PULLER ASSY,36"WORM GEAR | 47 | 1 | PPM6245K414 | PULLEY,V,2.0 OD, |
| | 13 | 2 | 1961-401 | RAIL,GUIDE | 48 | 4 | SSFC80016 | SCR,FLAT HD,CAP,6-32 X 1/4 |
| | 14 | 1 | 1961-409B | PLATE, MOUNT, RIGHT HEAD | 49 | 4 | SSHC01032 | 1/4-20 X 1/2 HHCS |
| | 15 | 1 | 1961-410B | POINTER,SERGE WIDTH | 50 | 16 | SSHC01040 | 1/4-20 X 5/8 HHCS |
| | 16 | 1 | 1961-412A | BLOCK,INDEX,LEFT HEAD | 51 | 14 | SSHC01048 | 1/4-20 X 3/4 HEX CAP |
| | 17 | 2 | 1961-421 | MT,MOTOR,EFKA | 52 | 2 | SSHC01056 | 1/4-20 X 7/8 HEX CAP |
| Page 40 | 18 | 1 | 1961-900D | CONTROL BOX | 53 | 4 | SSHC01096 | 1/4-20 X 1-1/2 HHCS |
| Page 48 | 19 | *AR | 1961-900WD3 | DIAGRAM, WIRING | 54 | 12 | SSHC01112 | HEX HEAD BOLT 1/4-20X1.75 |
| | 20 | 1 | 1961-903A | COVER, ELECTRICAL PANEL | 55 | 4 | SSHC01160 | 1/4-20 X 2-1/2 HHCS |
| | 21 | 4.5' | 1961-BELT | V-BELT,3/8 X 50.5" | 56 | 4 | SSPS98024 | 10-32X3/8 PAN HD SLOT |
| | 22 | *AR | 1961LAB3 | LABEL | 57 | 7 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| Page 47 | 23 | *AR | 1961PD1 | DIAGRAM, PNEUMATIC | 58 | 6 | SSSC80016 | 6-32 X 1/4 SOC CAP SC |
| | 24 | 1 | 1962-100E | FRAME,AUTO-BORDER, O/U,36 | 59 | 23 | SSSC98032 | 10-32X1/2, SOC CAP |
| | 25 | 2 | 1962-122A | MNT,MOTOR CONTROL, TRIPLE | 60 | 8 | SSSC98048 | 10-32 X 3/4 SOC CAP |
| Page 34 | 26 | 1 | 1962-210A | TENSION RACK ASSY, 36" | 61 | 8 | SSZS93032 | SCREW, SHT.METAL 10 ZIP |
| | 27 | 1 | 1962-406 | SCREW, HEAD LOCATION ADJ. | 62 | 2 | UUFF520-10 | BRG,BRONZE,.3765ID |
| | 28 | 1 | 1962-409 | PLATE, MT, LH, PEG EX5203 | 63 | 2 | UUFF723-05 | BEARING,BRONZE,.505ID |
| | 29 | 2 | 4003-MA3/FE | CABLE,8 FT,3 FEM | 64 | 68 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| | 30 | 2 | 4059-DC1500 | MOTOR,DC WITH CONTROLLER | 65 | 37 | WWFS10 | WASHER, FLAT, #10, SAE |
| | 31 | 1 | 4120-001 | ROD, STRAIGHT. SP, 1018 | 66 | 42 | WWL1/4 | WASHER,LOCK,1/4 |
| | 32 | 1 | 951A-0844 | CRANK HANDLE, MODIFIED | 67 | 31 | WWL10 | WASHER,LOCK,#10 |
| | 33 | 2 | AAF3/16 | CLAMP, BLACK PLASTIC | 68 | 6 | WWL6 | WASHER,LOCK,#6 |
| | 34 | 1 | AP-28-812 | CABLE,STEP MOTOR | 69 | 2 | ZX3827 | V-BELT,3/8 X 27" |
| | 35 | 2 | CCCL6F | CLAMP COLLAR- 3/8 | | | | |



# 1961-300GB Puller Assembly, 36” Worm Gear

AAC Drawing Number 9000849 Rev 2

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 2 | 0211-209 | PLATE,NUT,10-32@2.25 CTC | 31 | 2 | AAC7DP-1 | CYL.,AIR,DA 3/4 BORE,1STR |
| 2 | 1 | 1961-302 | PLATE,LEFT SIDE,PULLER | 32 | 2 | AAFBP-11C | BRKT,PIVOT,1/4 BORE |
| 3 | 1 | 1961-303 | PLATE,RIGHT SIDE,PULLER | 33 | 2 | AAFCT-7 | CLEVIS,AIR CYL, 1/4-28 |
| 4 | 1 | 1961-304 | HINGE PLATE,PULLER | 34 | 4 | AAQME-5-8 | QUICK MALE ELBOW |
| 5 | 1 | 1961-305 | TOP,LEFT SIDE,PULLER | 35 | 4 | BB1L005 | BEARING,BALL,.500D |
| 6 | 1 | 1961-306 | TOP,RIGHT SIDE,PULLER | 36 | 1 | GG124L050 | BELT, 3/8P,, 1/2W |
| 7 | 1 | 1961-307E | PLATE, TOP, PULLER | 37 | 1 | MM1910A23M | RULER,SILVER MYLAR 36" |
| 8 | 1 | 1961-309E | GUARD,ROLLER,36" CAPACITY | 38 | 1 | MM20U1-30M1 | WORM, REDUCE,30:1,RH |
| 9 | 1 | 1961-311E | ROD,STRIAGHT,CRS,1/2X | 39 | 1 | MMD35 (18.75" LG) | CHAIN,STEEL, DBL #35-2 X 32IN LG |
| 10 | 1 | 1961-312A | BRKT,LIFT,LEFT | 40 | 1 | MMD35CL | MASTER LINK,DBL,#35 CHAIN |
| 11 | 1 | 1961-313E | PLATE, BASE, PULLER | 41 | 1 | PP14LF050M1 | PULLEY, 3/8P, 14T, 5/8B |
| 12 | 1 | 1961-314 | HINGE PLATE, WORM PULLER | 42 | 1 | PP14LF050M2 | PULLEY, 3/8P, 14T, 14MM B |
| 13 | 1 | 1961-315A | BRKT,LIFT | 43 | 2 | SSFC01024 | 1/4-20 X 3/8 FLAT CAP |
| 14 | 1 | 1961-316E | BOTTOM,GUARD,36" CAPACITY | 44 | 4 | SSHC01048 | 1/4-20 X 3/4 HEX CAP |
| 15 | 1 | 1961-323 | SPACER, ALUM, 1/4 | 45 | 8 | SSHC10048 | 5/16-18 X 3/4 HHCS |
| 16 | 1 | 1961-363E | GUARD, TOP | 46 | 4 | SSHC98032 | 10-32X1/2 HEX HD |
| 17 | 1 | 1961-371E | GUARD,ROLLER,36" CAPACITY | 47 | 4 | SSSC01032 | 1/4-20X1/2 SOC CAP |
| 18 | 1 | 1961022 | MTG. PLT, EFKA MOTOR | 48 | 2 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 19 | 1 | 1961024 | GUARD, WORM DRIVE | 49 | 4 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 20 | 1 | 1961025 | GUARD, EFKA MOTOR | 50 | 2 | SSSC90032 | #8-32 X 1/2 SOC CAP SC |
| 21 | 1 | 1961027 | PLATE,MNT,WORM DRIVE | 51 | 17 | SSSC98032 | 10-32X1/2, SOC CAP |
| 22 | 2 | 1961028 | KEY, 3/16 SQ X 11/16 LG | 52 | 4 | SSSC98040 | 10-32 X 5/8 SOC CAP |
| 23 | 1 | 1961058 | COVER, ROLLER DRIVE BELT | 53 | 2 | WWF8 | WASHER, FLAT, #8 |
| 24 | 1 | 1961100 | SPROCKET, 12T, 35, DBL, M | 54 | 8 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 25 | 1 | 1961101 | SPROCKET, 30T, 35, DBL, | 55 | 21 | WWFS10 | WASHER, FLAT, #10, SAE |
| 26 | 1 | 33005603E | PULLER, ROLLER, 36" CAP. | 56 | 8 | WWFS5/16 | WASHER,FLAT,SAE,5/16 |
| 27 | 1 | 3.30E+09 | SHAFT, PREFEED DRIVE, 36" | 57 | 8 | WWL1/4 | WASHER,LOCK,1/4 |
| 28 | 1 | 33005652E | PULLER, ROLLER, 24" CAP | 58 | 21 | WWL10 | WASHER,LOCK,#10 |
| 29 | 1 | 3.30E+10 | SHAFT, PREFEED IDLER | 59 | 8 | WWL5/16 | WASHER, LOCK, 5/16 |
| 30 | 1 | 4059-DC1500 | MOTOR & CONTROLLER | | | | |




PROGRAMMING THE HOUR METER:
Enable the front keypad with the DIP switch #3. Press SEL.
The current range will be displayed. Press the RST button
until "88888888" is displayed. Press the SEL button.
Disable the front keypad with the DIP switch #3

# 1961-900D Control Box

AAC Drawing Number 9001726 Rev 2

| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 1 | 0211-703B | CABLE, LEFT CONTROL BOX | 33 | 1 | EECA491024 | CONTACTOR, MINI, 240V |
| 2 | 1 | 0211-705B | CABLE, TREADLE | 34 | 1 | EEPF3 | BUTTON, PUSH 22MM, GREEN MO |
| 3 | 1 | 0411-1950C | CABLE, LAMP AMBER 24 V | 35 | 1 | EEPF4 | BUTTON, PUSH 22MM, RED |
| 4 | 1 | 0411-1950D | CABLE, LAMP RED 24 V | 36 | 1 | EEPMTS44 | E-STOP BUTTON, TWIST REL. |
| 5 | AR | 1961-900WD3 | DIAGRAM, WIRING | 37 | 7 | FF1724 | STRAIN RELIEF |
| 6 | 1 | 1961-904B | MOUNT, REGULATORS | 38 | 1 | FF1N4007 | DIODE |
| 7 | 1 | 1961-909A | CABLE, FOOT PRDAL | 39 | 10 | FF264-341 | TERMBLK,WAGO,TOP,DUAL,GRY |
| 8 | 1 | 1961-912A | CONTROL PANEL | 40 | 3 | FF264-347 | TERMBLK,WAGO,TOP,DUAL,GRN |
| 9 | 1 | 1961-913A | SUB PANEL | 41 | 4 | FF264-371 | TERMBLK,WAGO,TOP,END |
| 10 | 1 | 1961-914A | CABLE, RELAY | 42 | 1 | FF3120L420A | CIRCUIT BREAKER, THERMAL |
| 11 | AR | 1961LAB3 | LABEL | 43 | 2 | FF34576Q | SW, TOGGLE DPDT 20A |
| 12 | AR | 1961PD1 | DIAGRAM, PNEUMATIC | 44 | 8 | FF67F4078 | SPACER,THREADED 3/8 L |
| 13 | 1 | 31103701 | BRKT,PRESSURE GAUGE | 45 | 1 | FF79998861 | HOUR METER, 8 DIGIT LCD |
| 14 | 1 | 40-322 | BOTTOM, AC POWER LOCKOUT | 46 | 1 | FF81F4591 | FASTON,PIGGY BACK,1/4" |
| 15 | 1 | 40-323 | TOP, AC POWER LOCKOUT | 47 | 1 | FFD2425F | RELAY,SSR,24VAC,25A |
| 16 | 1 | 4000D-02 | PC BOARD, RELAY | 48 | 1 | FFRAV781BW | MODULE, TVS, 240 VAC |
| 17 | 1 | AA198-503 | 0-30PSI AIR GAGE 1/8NPT | 49 | 2 | MM4554K11 | PLUG, 1/8" PIPE |
| 18 | 1 | AA198-5102 | REGULATOR W/GAUGE & NUT | 50 | 2 | MM4X641 | 1/8" RIVET ALUM |
| 19 | 1 | AA198-RP3 | REGULATOR,PRECISION AIR | 51 | 1 | MM9280K33 | GROMMET,FLANGE,1.03 ID |
| 20 | 2 | AA2001F-03 | FLOW CONTROL,INLINE,5/32 | 52 | 1 | NNH8-32 | HEX-NUT 8-32 REG. |
| 21 | 1 | AAE711C24D | AIR VALVE | 53 | 16 | SSPP80016 | #6-32X1/4 PAN PHILLIPS |
| 22 | 1 | AAF10289 | T-FITTING 1/4" NPT | 54 | 2 | SSPP80024 | #6-32X3/8 PAN PHILLIPS |
| 23 | 1 | AAQMC-5-8 | QU. MALE CONN 5/32X1/8 | 55 | 3 | SSPP90024 | 8-32X3/8 PAN PHLPS |
| 24 | 1 | AAQME-4-4 | ELBOW, MALE,1/4X1/4NPT | 56 | 2 | SSPP98024 | 10-32 X 3/8 PAN HD PHILIP |
| 25 | 2 | AAQME-4-8 | ELBOW,QUICK MALE,1/4X1/8 | 57 | 2 | SSSC01128 | 1/4-20 X 2 SOC CAP |
| 26 | 1 | AAQME-5-4 | ELBOW, MALE 5/32X1/4NPT | 58 | 7 | TT1825 | FEMALE, QUICK SLIDE |
| 27 | 4 | AAQME-5-8 | QUICK MALE ELBOW | 59 | 19 | TT1825-1 | FEMALE, QUICK SLIDE |
| 28 | 2 | AAQUT-5-5 | UNION TEE 5/32 | 60 | 1 | TT5811 | TERMINAL,RING,#10 STUD |
| 29 | 1 | AAV41V | VALVE,TOGGLE | 61 | 2 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 30 | 2 | EE3X01 | BLOCK,P.B. CONTACT, N.C. | 62 | 2 | WWFS10 | WASHER, FLAT, #10, SAE |
| 31 | 3 | EE3X10 | BLOCK,P.B. CONTACT, N.O. | 63 | 2 | WWSI8 | WASHER,INT. TOOTH,8 |
| 32 | 3 | EEA3L | LATCH,PUSH BUTTON | | | | |

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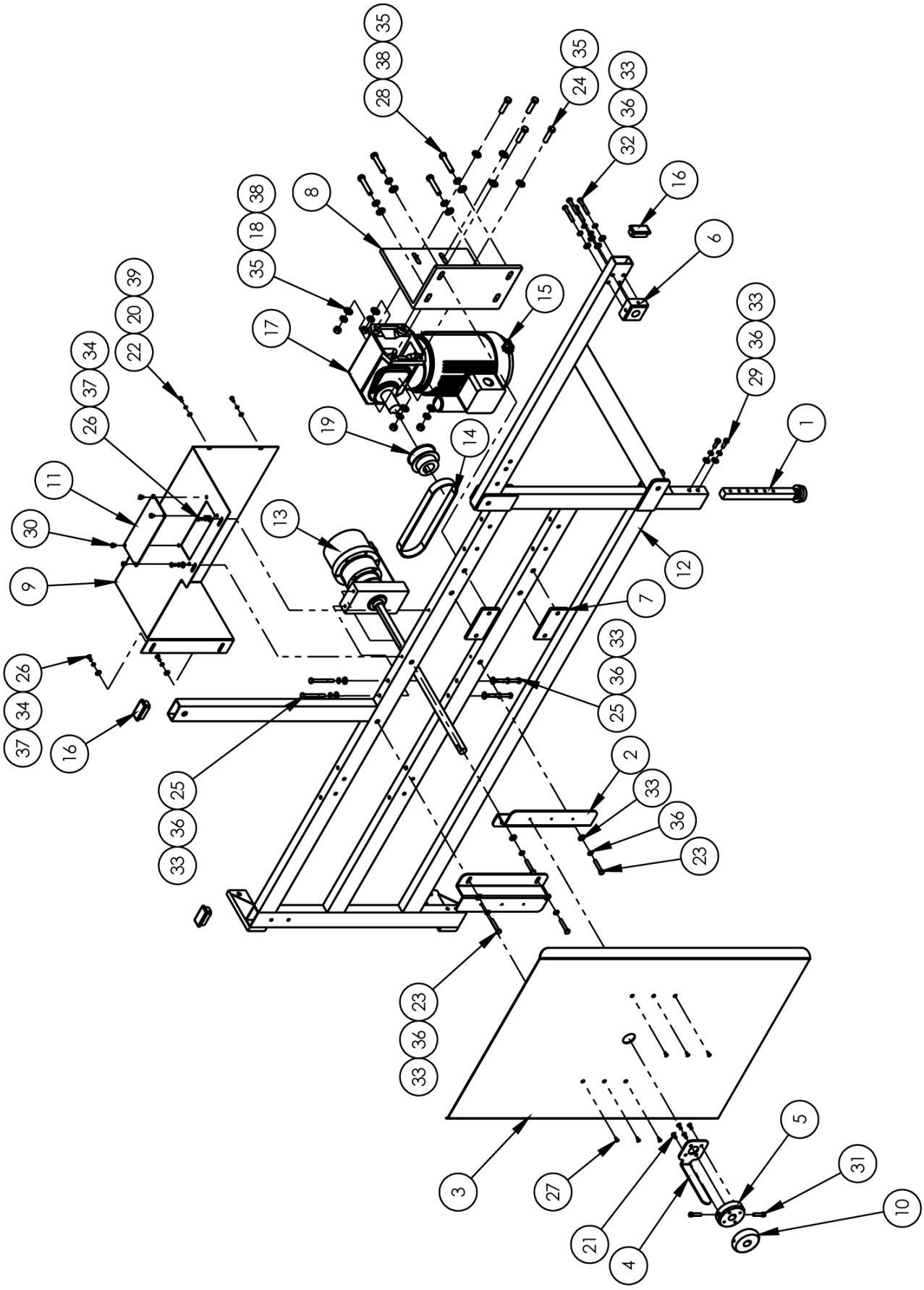
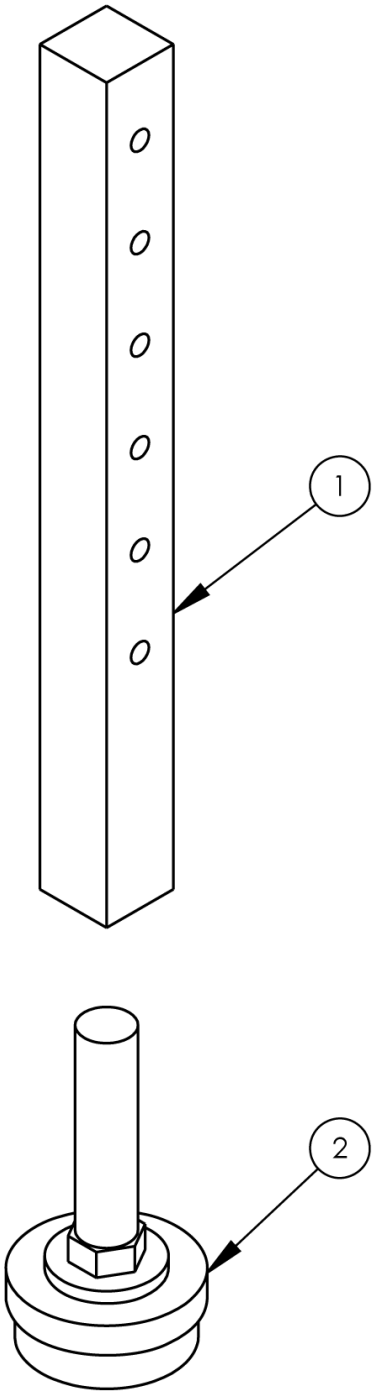


# 1962-320G Prefeed & Rewind Assembly

AAC Drawing Number 9001954 Rev 8

| NO. | QTY | PART # | DESCRIPTION | |
|---|---|---|---|---|
| 1 | 1 | 26238 | LEG SUB-ASSEMBLY | Page 43 |
| 2 | 2 | 1334326 | MOUNT, FLANGE | |
| 3 | 1 | 1334375 | DISC, REWIND, 24 X 32 | |
| 4 | 1 | 1334387 | CATCH, MATL. TAKEUP REEL | |
| 5 | 1 | 1334388 | HUB, TAKEUP SPINDLE | |
| 6 | 1 | 1961-251C | HUB UNWIND SHAFT | |
| 7 | 2 | 1961-319 | PLATE,NUT,3/8-16@3.00 CTC | |
| 8 | 1 | 1961-331 | MOUNT, MOTOR | |
| 9 | 1 | 1961-332 | COVER, MOTOR | |
| 10 | 1 | 1961-379 | SUPPORT,REWIND SLEEVE | |
| 11 | 1 | 1961104 | COVER, INSPECTION | |
| 12 | 1 | 1962-321A | FRAME, PREFEED & REWIND | |
| 13 | 1 | 1962-330G | CLUTCH ASSY,GENERIC | Page 44 |
| 14 | 1 | GG225L075 | BELT, 3/8P, 60T, 3/4W | |
| 15 | 1 | K-235A | CONNECTOR,ROMEX,3/4" | |
| 16 | 4 | MM132-1496 | PLUG 1 X 2 | |
| 17 | 1 | MMBH2LM22R | MOTOR,GEAR,R/A,220V | |
| 18 | 4 | NNH3/8-16 | NUT,HEX,3/8-16 | |
| 19 | 1 | PP22LB075-1-1/8 | PULLEY, GEAR, 3/8P, 22T | |
| 20 | 2 | WWF8 | WASHER, FLAT, #8 | |
| 21 | 4 | SSFC98032 | 10-32 X 1/2 FLAT ALLEN CAP | |
| 22 | 2 | SSPP90024 | 8-32X3/8 PAN PHLPS | |
| 23 | 4 | SSHC01096 | 1/4-20 X 1-1/2 HHCS | |
| 24 | 4 | SSHC25096 | 3/8-16 X 1 1/2 HEX HEAD | |
| 25 | 4 | SSHC01160 | 1/4-20 X 2-1/2 HHCS | |
| 26 | 4 | SSPP98032 | 10-32 X 1/2 PAN PHIL | |
| 27 | 6 | SSFC80024 | 6-32 X 3/8 FLAT CAP | |
| 28 | 4 | SSHC25128 | 3/8-16 X 2 HEX CAP | |
| 29 | 2 | SSHC01048 | 1/4-20 X 3/4 HEX CAP | |
| 30 | 4 | SSPS95024 | #10-24 X 1/4 PAN HD SLTD | |
| 31 | 2 | SSSC01064 | 1/4-20 X 1 SOC CAP | |
| 32 | 4 | SSHC01112 | HEX HEAD BOLT 1/4-20X1.75 | |
| 33 | 14 | WWFS1/4 | WASHER,FLAT,SAE,1/4 | |
| 34 | 4 | WWFS10 | WASHER, FLAT, #10, SAE | |
| 35 | 12 | WWFS3/8 | WASHER,FLAT,SAE,3/8 | |
| 36 | 14 | WWL1/4 | WASHER,LOCK,1/4 | |
| 37 | 4 | WWL10 | WASHER,LOCK,#10 | |
| 38 | 8 | WWL3/8 | WASHER, LOCK, 3/8 | |
| 39 | 2 | WWL8 | WASHER,LOCK,#8 | |

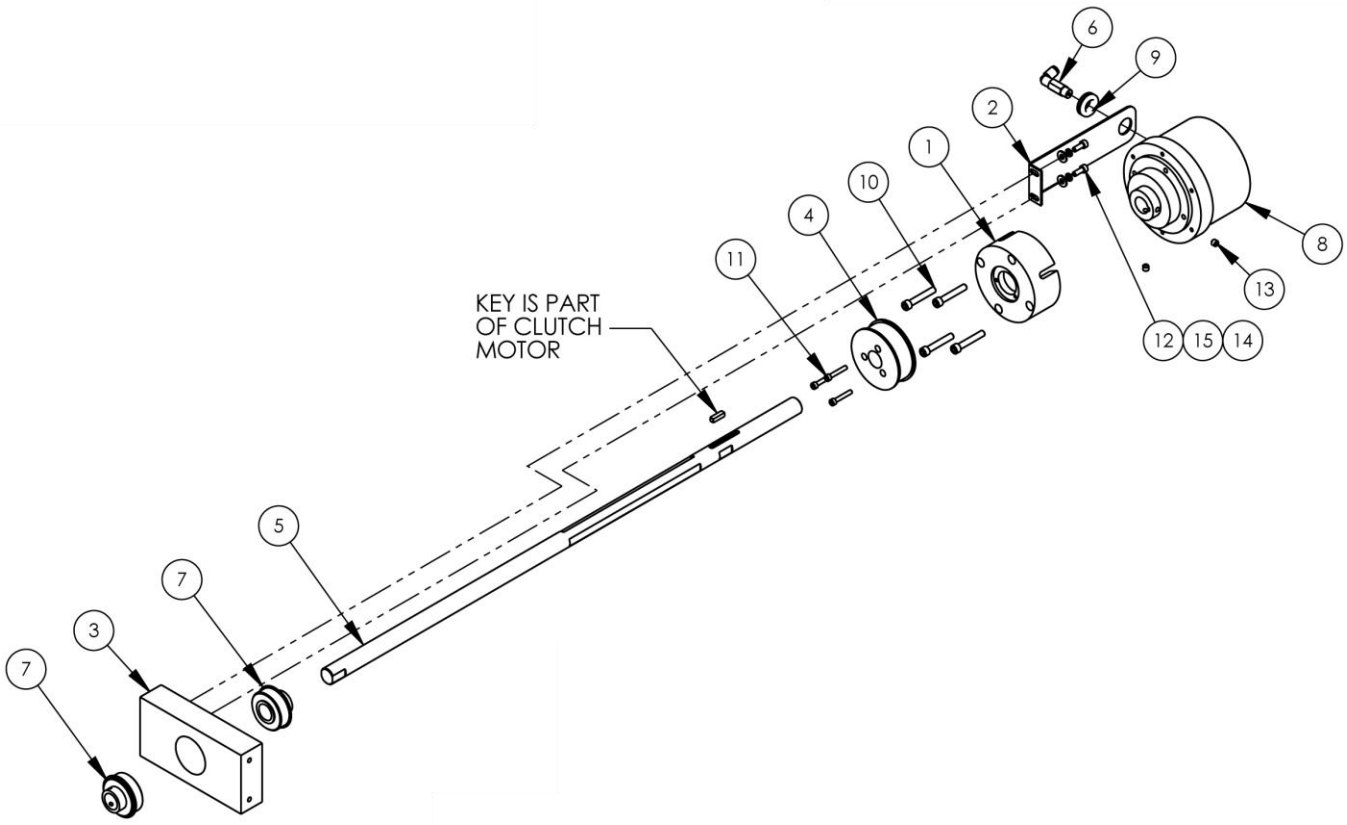





# 26238 Leg Sub-Assembly

AAC Drawing Number 9001599 Rev 1

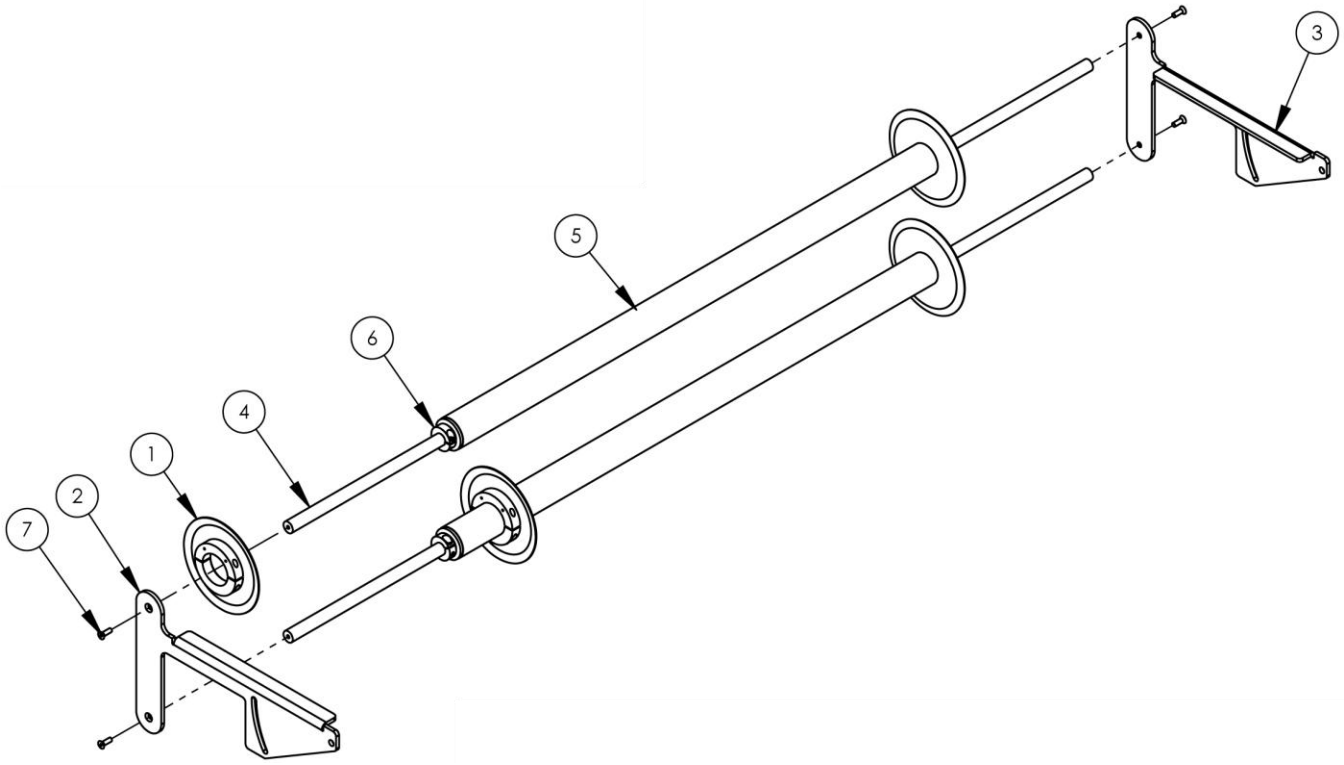
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 26127 | LEG FOR AP-26-02 |
| 2 | 1 | MMFB4444 | FOOT, RUBBER |




# 1962-330G Generic Clutch Assembly

AAC Drawing Number 9001953 Rev 2

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1961-321 | PLATE, ADAPTOR, AIR CLUTC |
| 2 | 1 | 1961-354B | SUPPORT, AIR CLUTCH |
| 3 | 1 | 1961-365B | BLOCK, BEARING MOUNT |
| 4 | 1 | 1961-366A | PULLEY,CLUTCH,22 TH,3/8 P |
| 5 | 1 | 1962-375 | SHAFT, AIR CLUTCH, MM8028 |
| 6 | 1 | AAQMEL-5-8 | QUICK MALE ELBOW,LONG |
| 7 | 2 | BBS8703-88 | BEARING,BALL,.75IDX1.75OD |
| 8 | 1 | MM802860 | CLUTCH,AIR,3/4 BORE,4.5"D |
| 9 | 1 | MM9600K21 | GROMMET,RUBBER,9/16 ID |
| 10 | 4 | SSSC01096 | 1/4-20 X 1-1/2 SOC CAP |
| 11 | 3 | SSSC90064 | #8-32 X 1 SOC CAP |
| 12 | 2 | SSSC98032 | #10-32 X 1/2 SOC CAP |
| 13 | 2 | SSSS01016 | 1/4-20 X 1/4 KNURL PT |
| 14 | 2 | WWFS10 | WASHER, FLAT #10 |
| 15 | 2 | WWL10 | #10 LW |

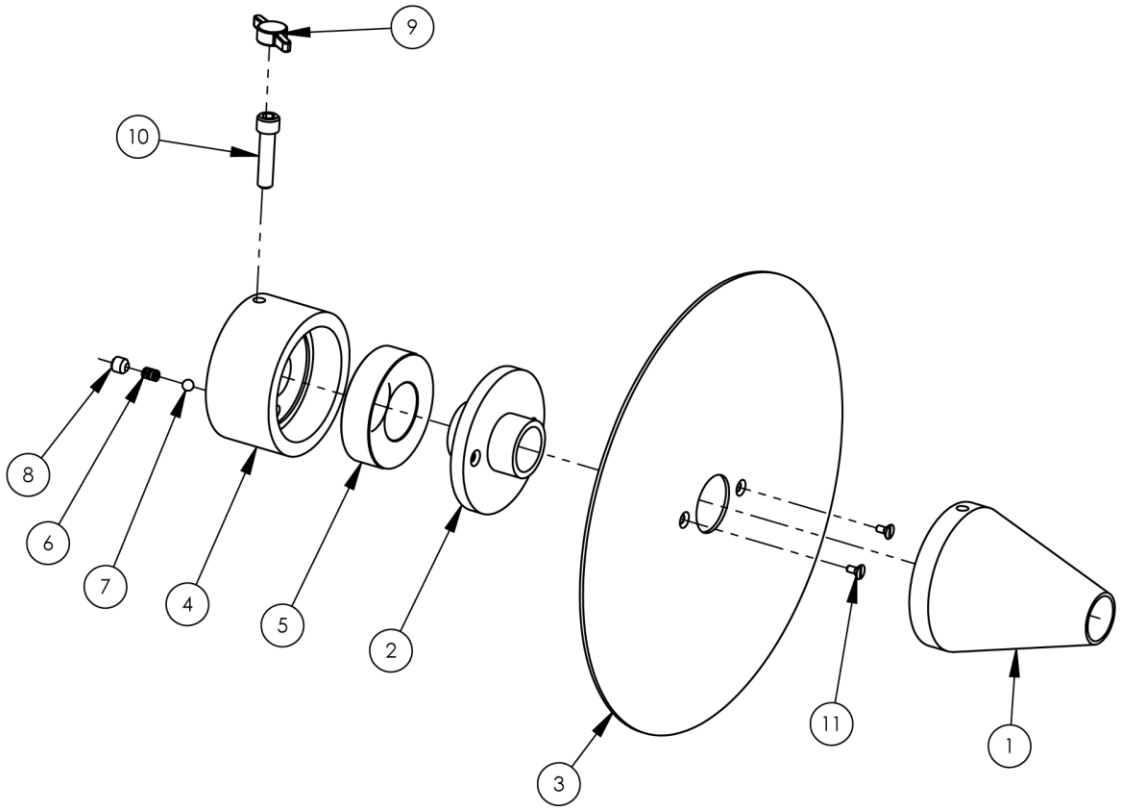





# 1962-350E Rear Roller Assembly, 38”

AAC Drawing Number 9002038 Rev 2

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 2 | 1335-813E | DISC,BEVEL EDGE,CLAMPING |
| 2 | 1 | 1962-351 | BRKT, LEFT, REAR ROLLER |
| 3 | 1 | 1962-352 | BRKT, RIGHT, REAR ROLLER |
| 4 | 2 | 1962-353E | ROD,STRA,SP,3/4 X 64.06L |
| 5 | 2 | 1962-354E | ROLLER, SINGLE FLANGE |
| 6 | 4 | CCCL12F | CLAMP COLLAR- 3/4 |
| 7 | 4 | SSFC01048 | 1/4-20 X 3/4 FLAT CAP |



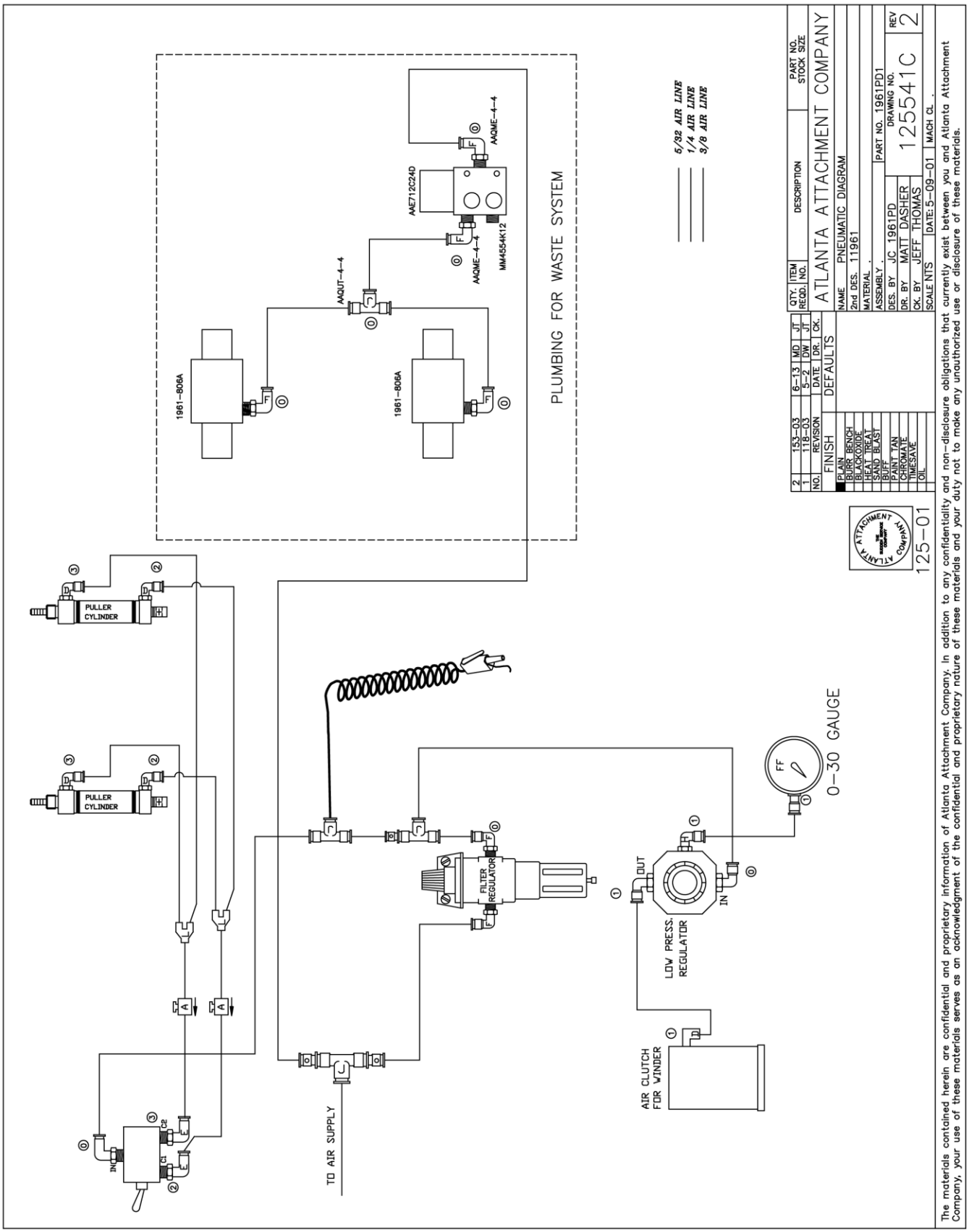

# 33008708 Ball Bearing Disc Assembly

AAC Drawing Number 9000904 Rev 4

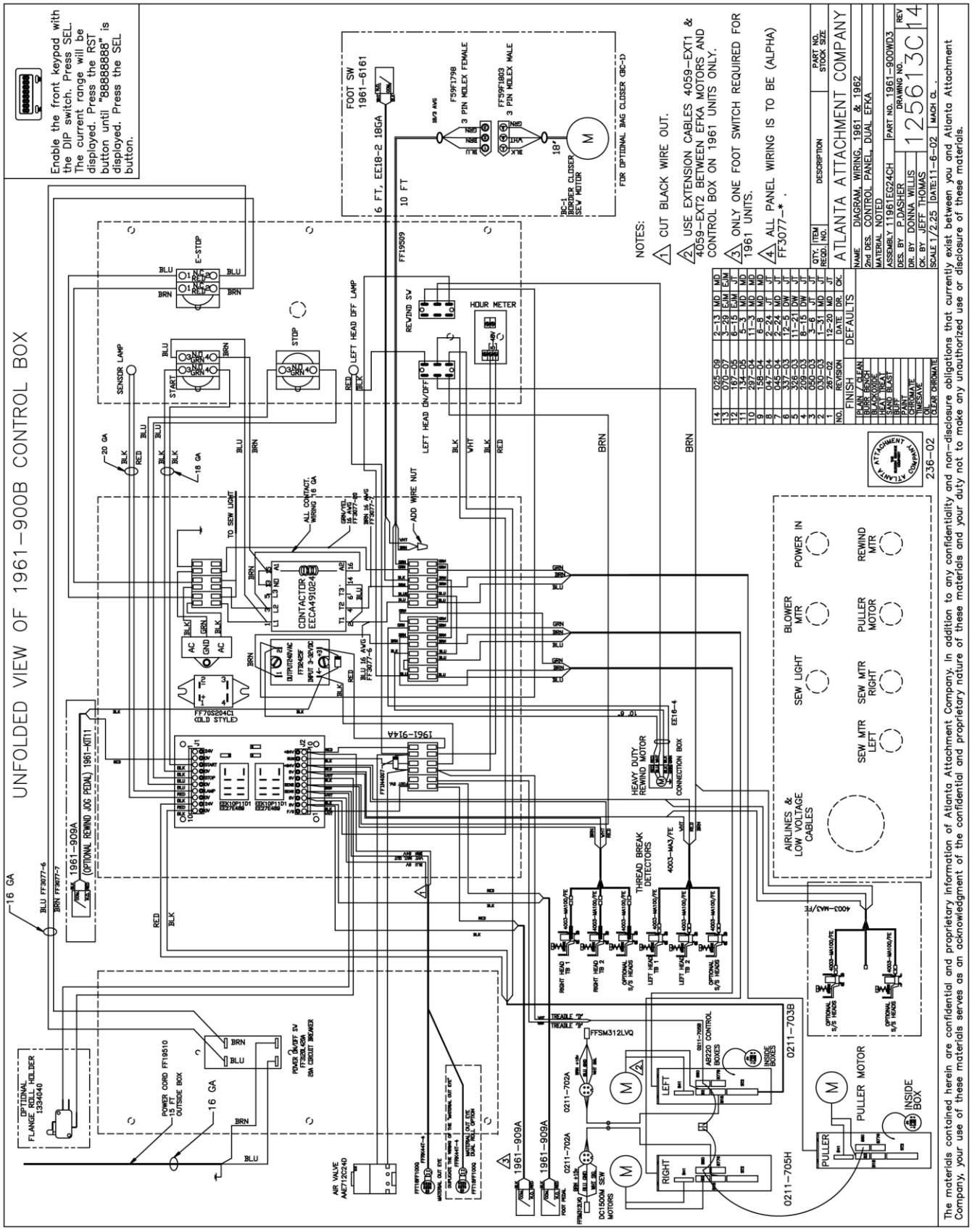
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 33008604 | CONE, SPOOL |
| 2 | 1 | 33008602 | HUB, FLANGE 3/4 BORE |
| 3 | 1 | SEE CHART | SEE CHART |
| 4 | 1 | 33008601 | HUB, CENTER, 3/4 SHAFT |
| 5 | 1 | BB23216-88 | BEARING,BALL,1.0B |
| 6 | 1 | RRLC026B1 | SPRING,COMP .026X.18X.25 |
| 7 | 1 | JJ012 | 3/16 DIA. BALL |
| 8 | 1 | SSSP01016 | 1/4-20 X 1/4 NYLOCK |
| 9 | 1 | SSW#1_4 | WING SCREW KNOB |
| 10 | 1 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 11 | 2 | SSFS80016 | 6-32 X 1/4, FLAT SLOT |

| | | | |
|---|---|---|---|
| - | BALL BEARING | DISC ASSEMBLY | 33008732 |
| 3 | 1 | 33008632 | DISC 32" DIA |
| - | BALL BEARING | DISC ASSEMBLY | 33008724 |
| 3 | 1 | 33008624 | DISC 24" DIA |
| - | BALL BEARING | DISC ASSEMBLY | 33008716 |
| 3 | 1 | 33008616 | DISC 16" DIA |
| - | BALL BEARING | DISC ASSEMBLY | 33008708 |

# 1961PD1 Pneumatic Diagram



# 1961-900WD3 Wiring Diagram



# 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 Garantia

## Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libres de defectos de mate-rial 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 prim-ero.
- 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 cual-quier 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 peri-odo de ochocientas (800) horas.
- Componentes mecánicos que fallen por defectos de materiales o de fabricación que han sido manu-facturados 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 neumáti-cas.
- 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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