Model **1306**

Revision 2.2 Updated Feb 5, 2013

Technical Manual & Parts Lists

Atlanta Attachment Company

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ATLANTA ATTACHMENT COMPANY, INC.

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IMPORTANT

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

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 1306 Roll Pack Workstation 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.

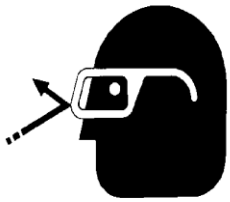
Faults or Errors

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.

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 Installing and operating.

1.1 - Parts and Components

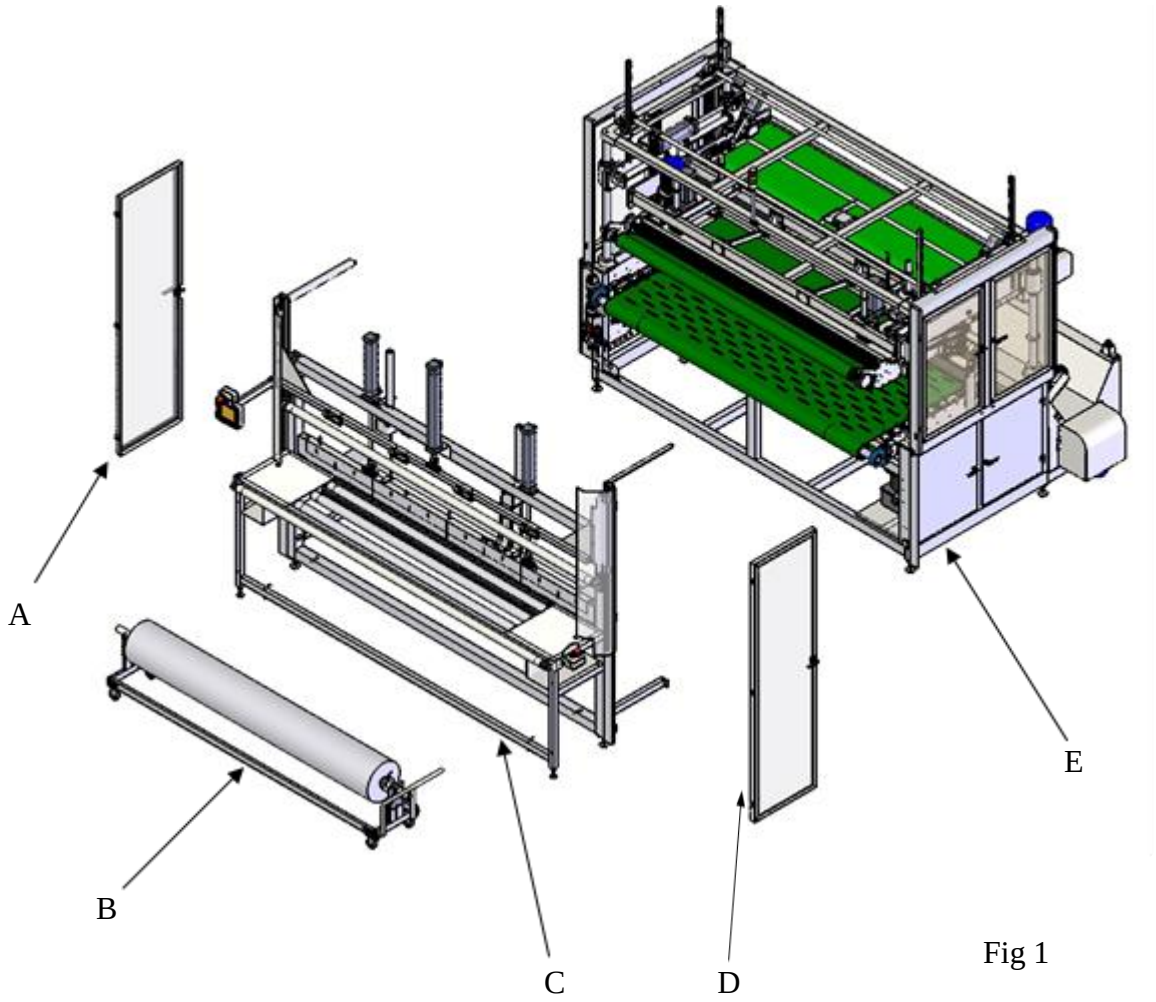


Fig 1

A. Left door
B. Roll Storage cart
C. Infeed unit
D. Right Door
E. Main Unit

In-feed (front)

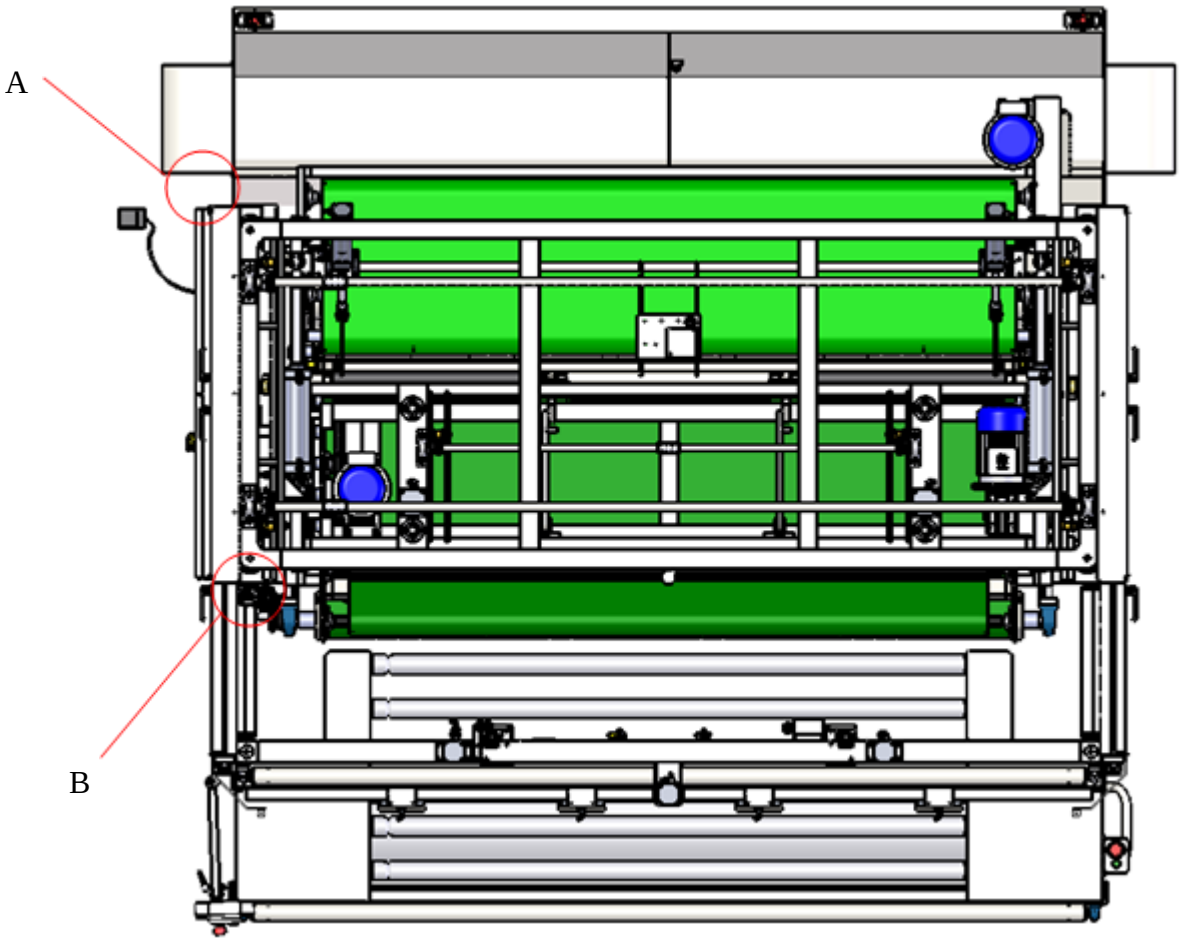


Fig. 2

Top View of 1306

A. Electrical drop = 208v-240v 50hz/60hz 50amp circuit
B. Air drop = 90 psi dried shop air. 3/8 inch line minimum.

1.2 - Technical Data

- Automatically compress & pack one unit per minute
- Accepts finished mattress and soft cushions made from foam (without border wire)
- Wrapper - PE, PVC & PU
- Compact design minimizes floor space
- Patented Serial Bus Control System
- Low and easy maintenance
- Easy to operate

SPECIFICATIONS / ESPECIFICACIONES		
Mattress width max (inch) / *Ancho máximo del colchón (pulgadas)*	86	
Mattress height max (inch) / *Altura máxima del colchón (pulgadas)*	15	
Voltage (v/ph/hz) / *Voltaje (v/ph/hz)*	220V 3PH 50/60HZ	
Current (amps) / *Amperaje (amperios)*	60	
Air pressure (psi) / *Presión de aire (psi)*	70-80	
	OPTIONAL TABLE	MAIN UNIT
Shipping weight (lbs) / *Peso de embarque (lbs)*	1,600	7,000
Shipping dimensions (w/l/h, inch) / *Dimensiones de embarque (w/l/h, pulgadas)*	78 x 133 x 98	96 x 147 x 96

PRODUCTION / PRODUCCIÓN	
Pieces per min. / *Piezas por minuto*	1-2

OPTIONS

- 1306141 - Plastic Roll Carriage

- LSC2005 - Conveyor System

- Extended Loading Table Use in case of no Conveyor System
- Pre-fold System Use in conjunction with Auto-Pac™ (1390B) with Compression Module

1.3- Installation & Set Up

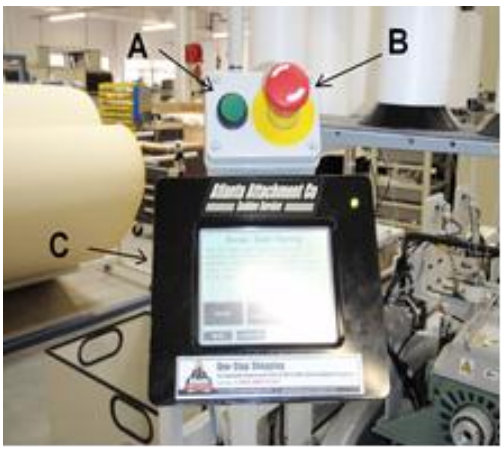
- Remove any shipping straps from machine.
- Inspect the machine for any damage that may have occurred during shipping. If damage is found, report this immediately to your supervisor. Document the damage and provide details and photographs.
- Position the main unit in a desired location on a sound and reasonably level floor. Make sure that there is sufficient lighting over the machine. Remove all packing material. Adjust the jack screws so the machine is level and approximately 3" high from the floor to the bottom of the jack screw mount plate.
- Move In-feed unit into position using the lower connector arm to properly space the bottom from the main unit. Install screws loosely.
- Adjust feet on In-feed to line up holes on upper connector bracket and screw into place. Fully tighten connector bolts on lower connector bracket.
- Attach heater wire to the cut bar relay inside the control box.
- Attach feed start emitter and feed start sensor to serial bus modules marked on sensor wires inside control box
- Connect (2) Main power/E-stop connectors from In-feed table to the back of the control box.
- Connect the touch screen connector to the touch screen serial bus wire hanging from the rear of the control box.

- Connect serial bus extension wire to the thermocouple module on in feed.
- Attach right and left doors to In-feed table.
- Provide a **220v AC, Three Phase, 50 Amps** at location specified in fig. 7.
- Provide **3/8" ID air supply line (90 PSI)** at location specified in Fig. 2.

- Turn the main air lock-out valve (Red Knob before the main pressure regulator) to the "ON" position.

- Twist the E-Stop "B" to return to its normal position.

Turn the machine "ON" by pressing the green button "A" on the box just above the touch screen. The machine will first display the language choices and after several seconds it will show the "Cut and Seal Bars Heating" screen. This screen is the one that the operator should always see upon power up if the serial bus is operating properly.



1.4 - Machine Layout

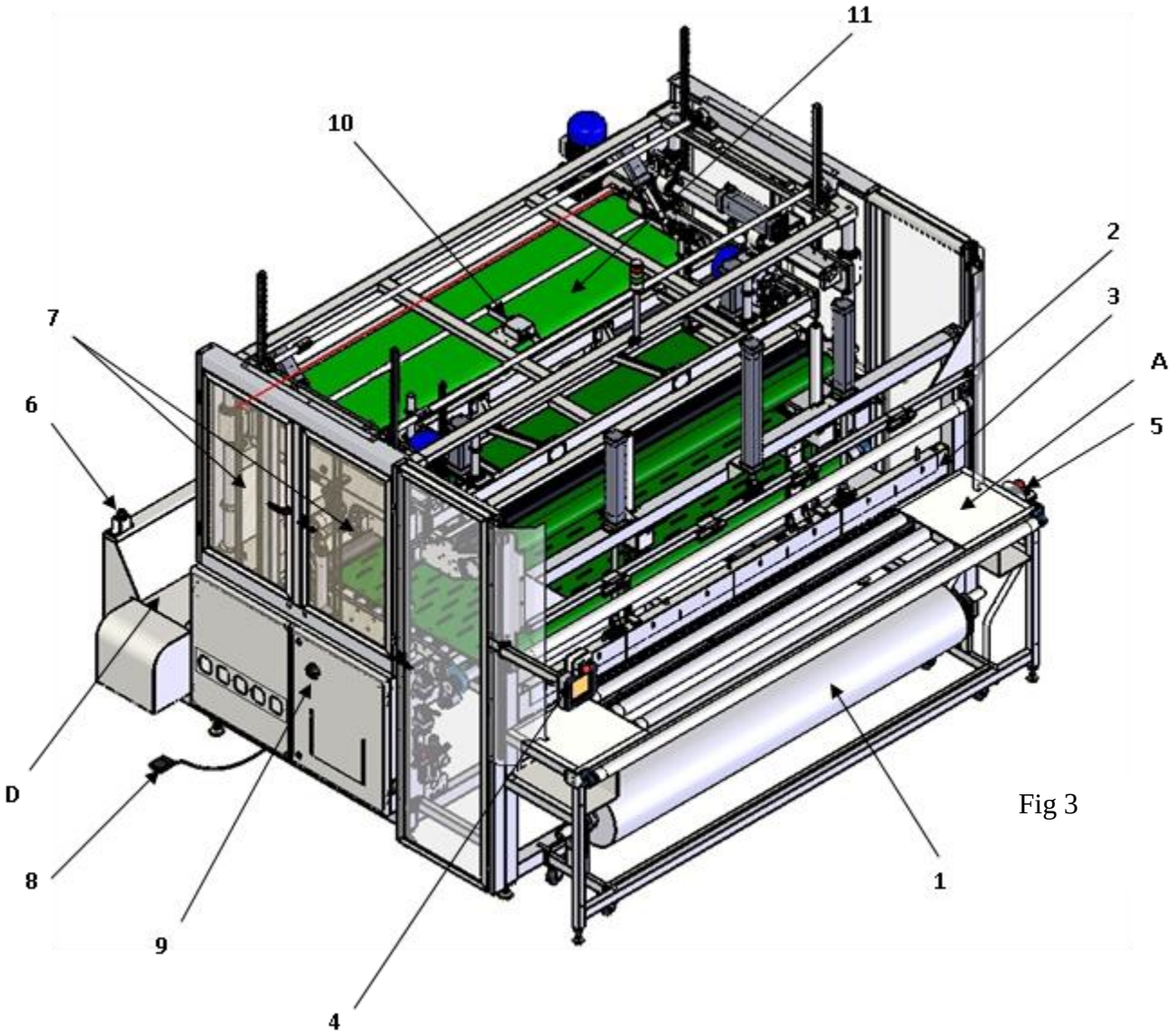


Fig 3

A. In-feed Unit

1. Roll Storage Cart.
2. Plastic Hold Down Bar.
3. Heated Cut Bar.

B. Machine Controls

4. Touch Screen with E-stop and Power Switch.
5. E-Stop and Power Switch.
6. Out-feed E-stop and Power switch.
7. Side Access Doors.
8. Out-feed Foot Switch.
9. Main Power Shut-Off

C. Main unit

10. Upper Pressing Platform
11. Rear Cross Seal

D. Output Carriage unit

1.5 - Machine Safety

The 1306 roll pack work station has many powerful drives and mechanisms.

ANYONE assigned to operate and/or maintain this machine must be properly trained by an Atlanta Attachment Technician, or a trained and qualified factory mechanic.

Operation and/or maintenance of this machine by untrained personnel may result in a serious injury or even death.

ANYONE assigned to operate and/or maintain this machine must read, understand, and follow the safety guidelines listed below and mentioned in the following pages. They must also be familiar with the locations of all operators' controls, with particular emphasis on the following :

- Main Electrical Power Shut Off
- Main Pneumatic Air Supply On/Off Valve
- Four Emergency-Stops, Located in the four corners of the machine.
- All Access doors being open will pause the machine in automatic mode. The doors Will **NOT** stop motion in Advanced manual mode.

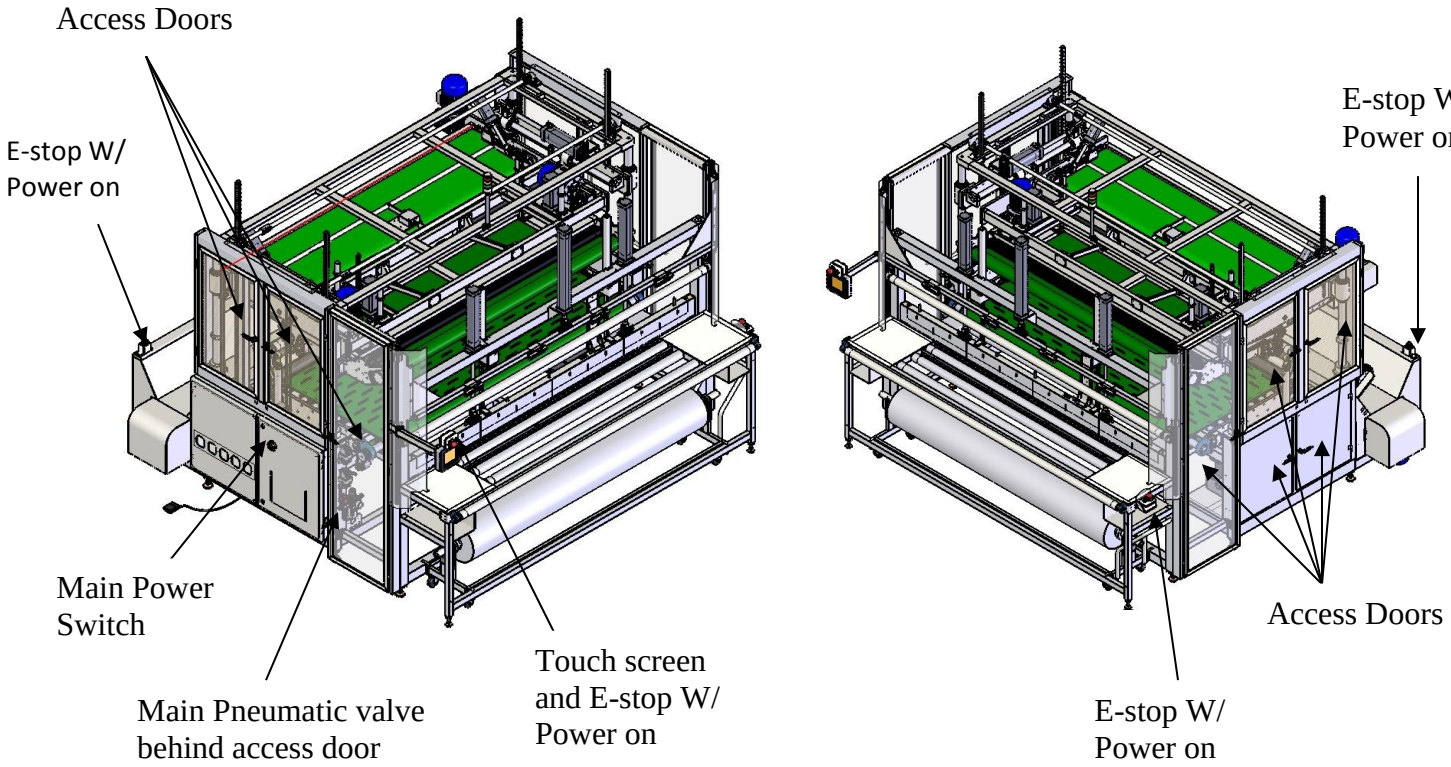


Fig 4

Warnings

In auto mode this machine can start automatically once the In-feed sensor is covered.
If the In-feed sensor should fail, in auto mode the machine could start moving without a bed being feed into the machine. For this reason, When the machine is in auto mode and the ready to load screen is active:

-NEVER ENTER INSIDE THE MACHINE.
-NEVER CRAWL UNDER THE MACHINE.
-NEVER CLIMB ON TOP OF THE MACHINE.
-NEVER REACH INSIDE THE MACHINE FOR ANY REASON.
-NEVER PLACE ANY PART OF YOUR BODY INSIDE THE MACHINE.

In advanced manual mode, this machine may be prompted to execute any of its functions. Therefore, to prevent injury or machine damage, only a properly trained operator or mechanic should use the machine in this mode of operation.

To perform any machine maintenance always follow the steps below:
1. FIRST, POWER DOWN THE MACHINE AND LOCK-OUT THE ELECTRICAL AND PNEUMATIC POWER SWITCHS.
2. WAIT UNTIL SEAL BARS COOL OFF SUFFICIENTLY (APPROX. 3 HOURS)BEFORE SERVICING THE SEAL BARS OR NEARBY AREAS OF THE MACHINE.

NOTE: If machine maintenance is absolutely necessary before seal bars have sufficiently cooled off, a service person must wear OSHA approved safety gear to protect himself/herself from a potential burn.

-NEVER ENTER OR ALLOW ANYONE ELSE TO ENTER INSIDE THE MACHINE DURING A POWER UP OR ENERGIZING WITH AIR PRESSURE!

The machine makes automatic movements at the beginning of power up that could pinch, crush, or kill a person inside the machine. Also never allow anyone in or on the machine when powering up.

1.6 - Lockout/Tagout Program

"Lockout/Tagout (LOTO)" refers to specific practices and procedures to safeguard employees from the unexpected energization or startup of machinery and equipment, or the release of hazardous energy during service or maintenance activities. This requires that a designated individual turns off and disconnects the machinery or equipment from its energy source(s) before performing service or maintenance and that the authorized employee(s) either lock or tag the energy-isolating device(s) to prevent the release of hazardous energy and take steps to verify that the energy has been isolated effectively. The following references provide information about the LOTO process.

Equipment Energy Control Procedure
Lockout/Tagout Program

Description:	Border Workstation	Model:	**1306**
Manufacturer:	Atlanta Attachment Co.	Location :	

Energy		Location	Magnitude	Control Method
Electrical:		Disconnect/Ctrl Box	220V	Lockout & Tag
Pneumatic:		Main Regulator	90 PSI	Lockout & Tag
Gravity:		Cut bar Assy, presser belt Assy, Seal Bar assembly, Plastic Holder Clamp		

Remember to Release All Stored Energy!

Shutdown Procedure:

1. Inform all affected personnel that the machine will be in Lockout status.
2. Turn the power and pneumatic disconnects to the OFF position.
3. Fill out the tag with necessary information of the Lockout.
4. Install the Lockout device.
5. Verify all stored electrical energy has been released by pressing the power on button

. Also, use meter to test circuits in the electrical panel to insure stored energy is released there as well.

Perform necessary maintenance, services and/or repairs.

Startup Procedure:

1. Inform all affected personnel that the Lockout of this machine is being removed.
2. Replace any guards or safety devices which may have been removed during maintenance.
3. Remove the Lockout device and tag.
4. Turn the power and pneumatic disconnects to the ON position.
5. Push the green button on the back of the control panel to turn the machine on.
6. Inform all affected personnel that the Lockout has been removed and that the machine is ready for normal production operation.

Approved By: _____ Date: _____

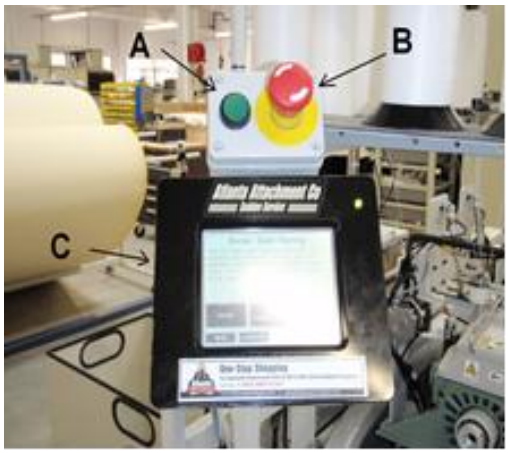
2 - OPERATING MANUAL

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

2.1.1 - Control Panel

The Control Panel 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.



A.- Emergency Stop (B)

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 engaged will turn on power to the machine.

B.- Power On (A)

Power the machine “ON”.

C.- Serial Bus control

Control all machine functions. See more details available on related chapters one this manual

2.1.2 - Light Tower 33001130

The purpose of the light tower is to indicate current status of the machine at some distance away from the machine. This makes it easy to see machine status at a glance. Definitions for the different light states currently available on the 4300 are included below.

Light Status	Definition
Green Steady:	Machine is operational and up to temperature.
Green Flashing:	Machine is in warm up sequence.
Yellow Steady:	Machine is in advanced manual mode.
Yellow Flashing:	Machine is currently in cycle.
Red Steady:	Safety Doors Open.
Red Flashing:	Heating element(s) have gone into over temp state.

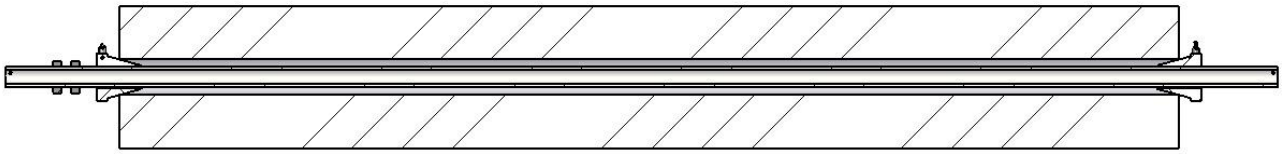
2.2 - Machine Set-up

2.2.1 - Film Loading.

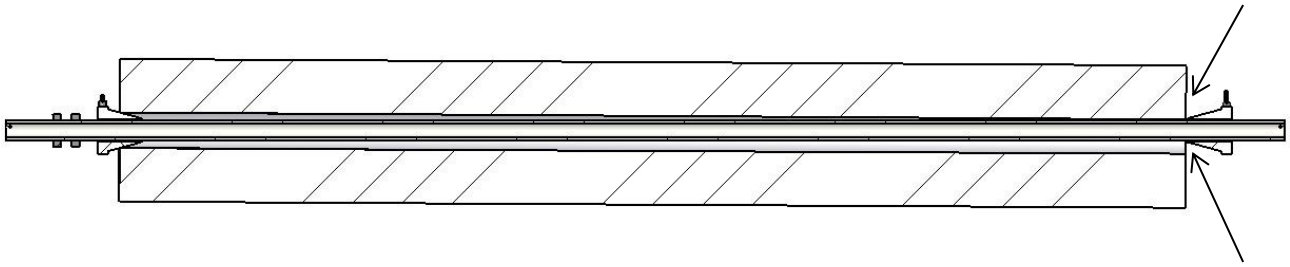
The Standard machine comes with a pull out film roll cart that can handle a 12” diameter x 92” long roll of plastic.

The film cart can be loaded two ways. It can be inserted from the left or the right of the machine for loading.

To load the rack
1. pull out the (2) locating/locking pins(one on each side of the machine) to unlock the cart from the machine.
2. Pull rack out from under the machine far enough to load the rolls of film.
3. Remove roll holder bar from cart.
4. Remove retaining collar on the opposite end of the bearing retainer collars.
5. Insert plastic retaining bar into core of plastic roll



Correct



Incorrect

Fig 5

6. Replace collar on roll holder bar to center roll holder inside roll core.
   NOTE: Make sure both collars are tight in the core to be sure roll will spin relatively freely on Film Holder.
7. Using a fork truck / 2 or more men, place plastic roller holder bar back on cart.
8. Insert cart under in feed table and replace pins.

2.2.1 - Film Loading Cont'd

9. Route plastic as shown in diagram.

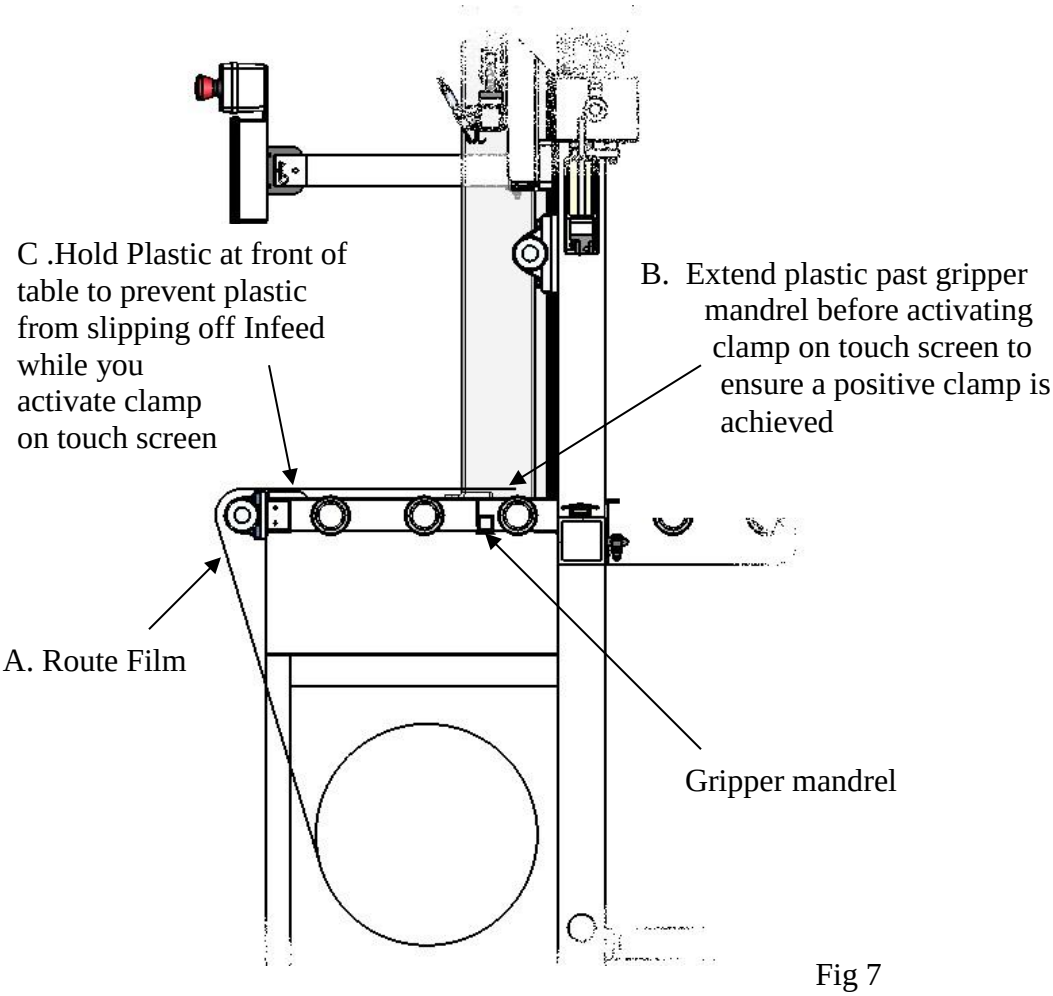
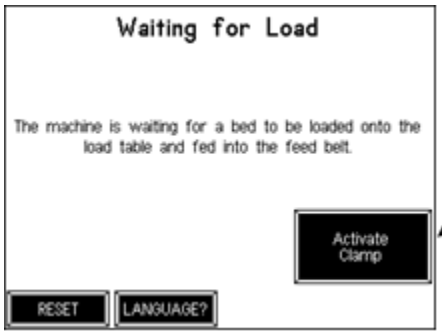


Fig 7

10. Refer to section 2.3.1 to get to automatic mode "waiting for load" screen



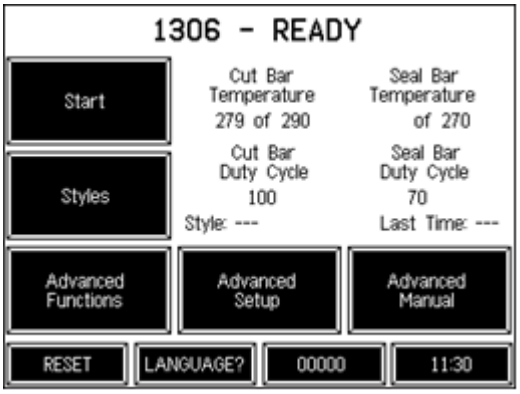
Press button on touch screen to activate clamp

NOTE: Be sure all pinch points are clear before clamping plastic!

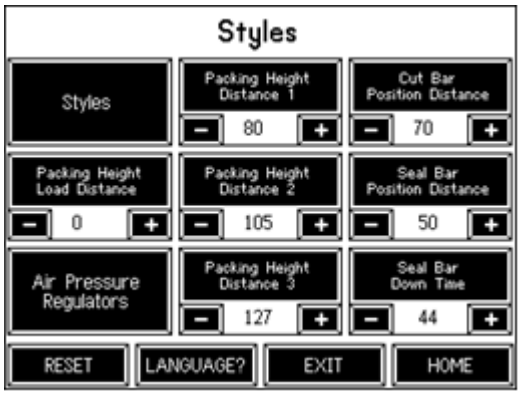
11. With hands and objects clear of the mandrel and plastic clamp pinch points, press the activate clamp button to lower plastic clamp and load plastic into gripper.

2.2.2 - Styles and Bed Roll Settings.

The Styles screen is accessed from the Styles button on the main machine screen.

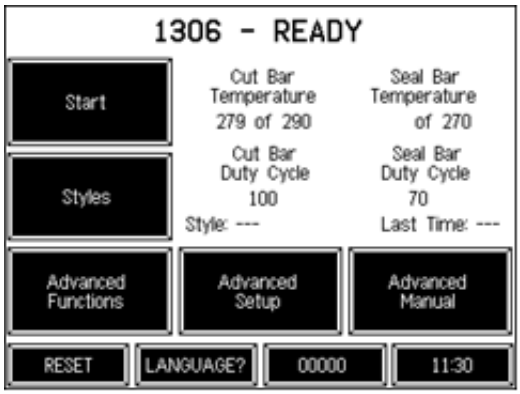


The styles screen allows settings for different bed thicknesses and types to be accessed, viewed and saved.

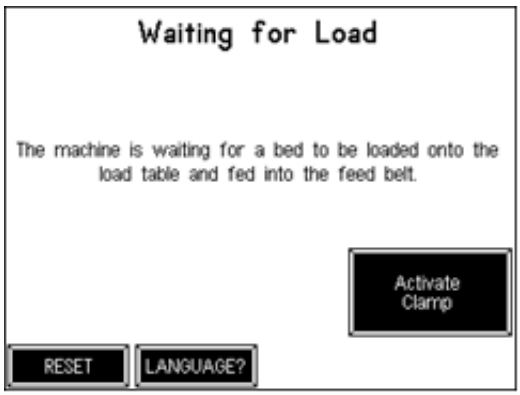


2.2.2.1 - Machine Sequence and Understanding the Effects of the Settings.

If the machine is up to temperature as indicated in the main screen, Pressing the start button will put the machine in automatic mode.

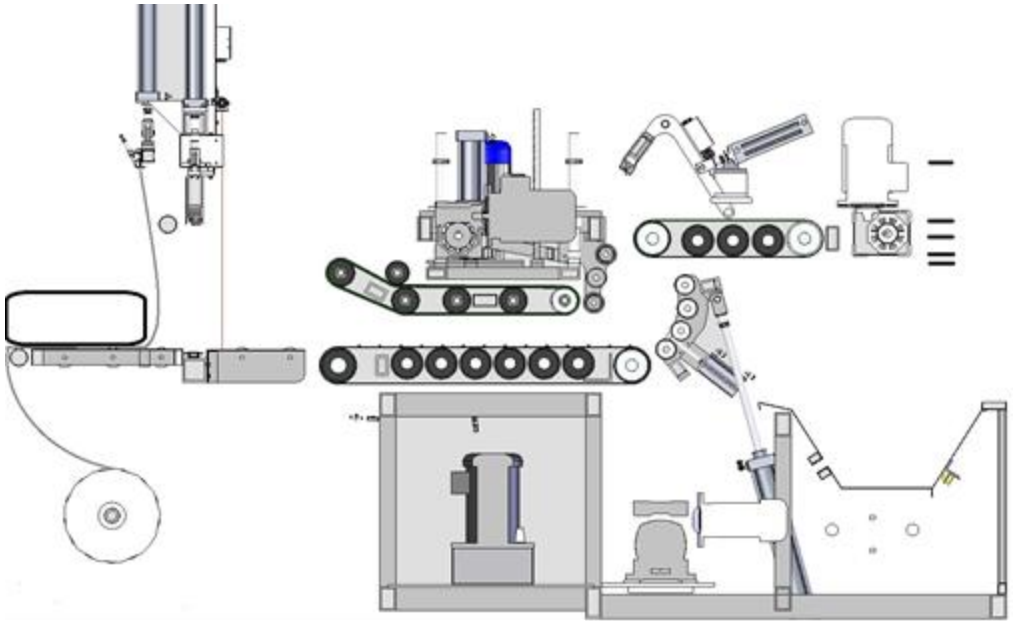


The waiting for load screen indicates the machine is ready to begin its automatic sequence.

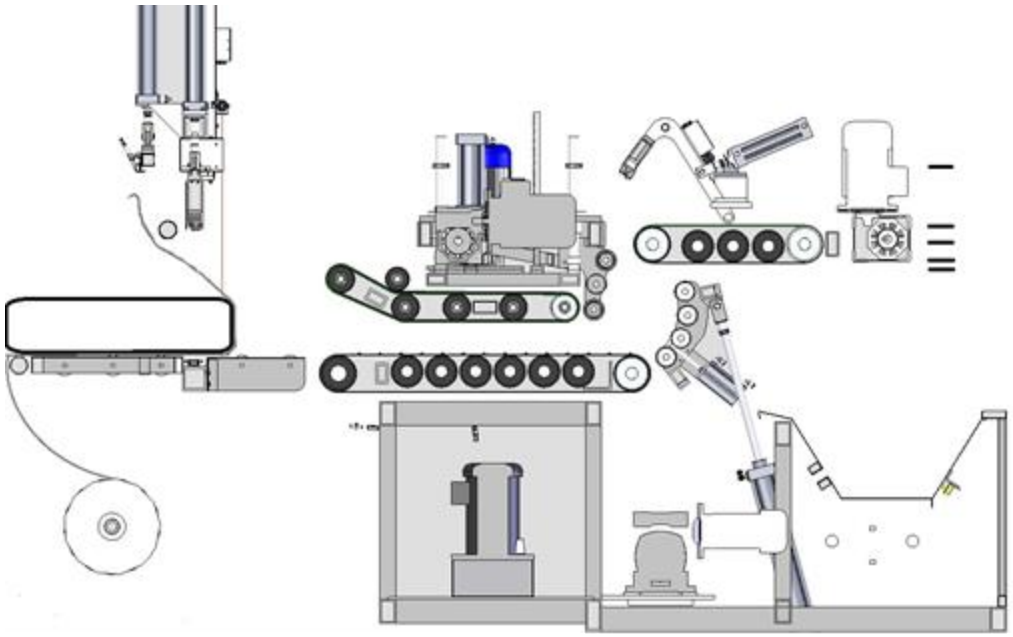


2.2.2.1- Machine Sequence and Understanding the effects of the settings. (Cont'd)

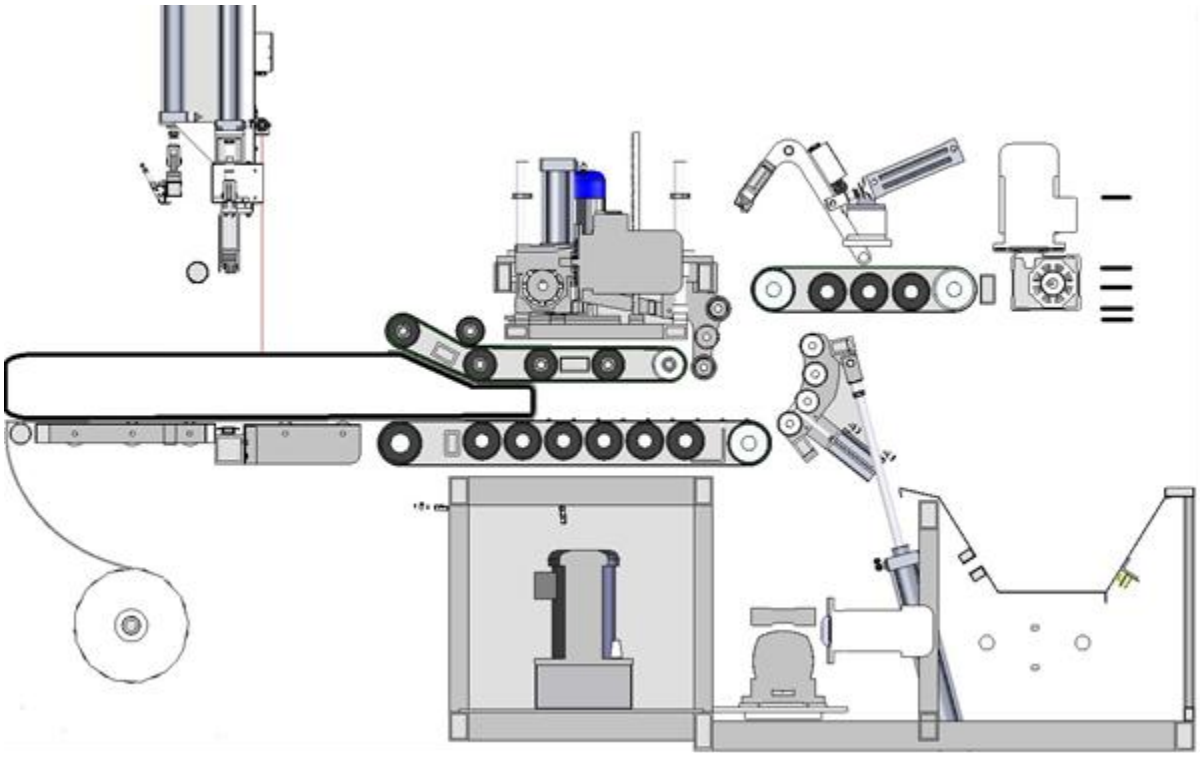
Step 1. The press platform lowers to the lower limit and resets the press position counter then rises to the **Packing Height Load Distance** setting. The machine is active and awaiting a mattress to begin a rolling cycle.



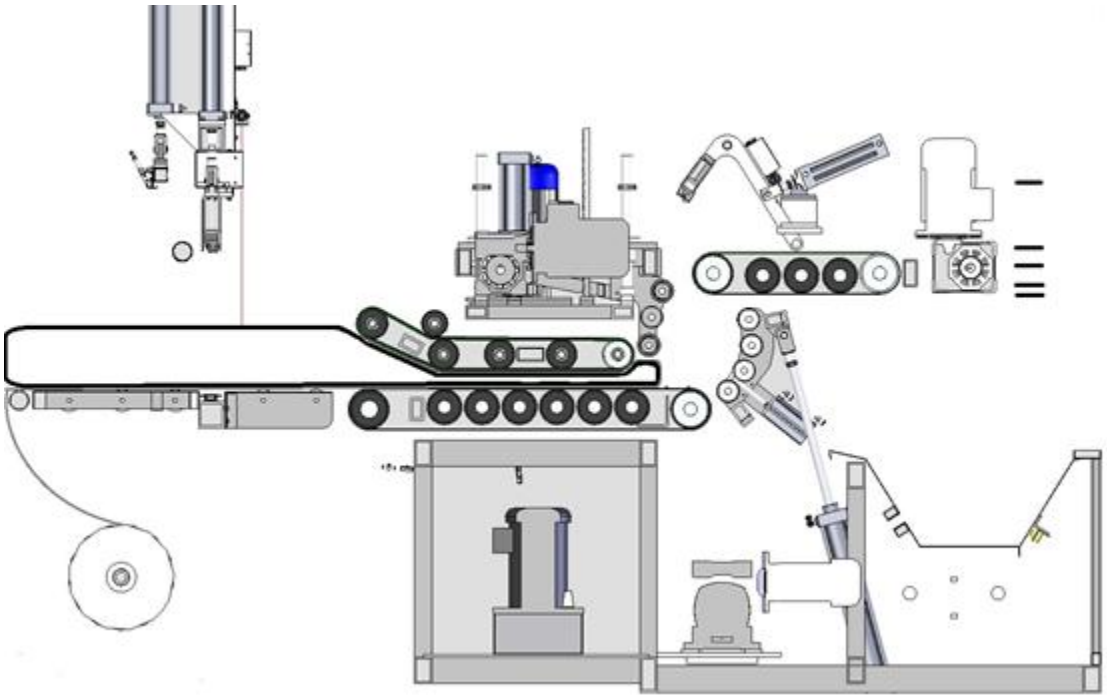
Step 2. The operator pushes the mattress into the loading table until the feed start sensor is blocked and the plastic is released. The conveyors begin to move in anticipation of the mattress to be rolled.



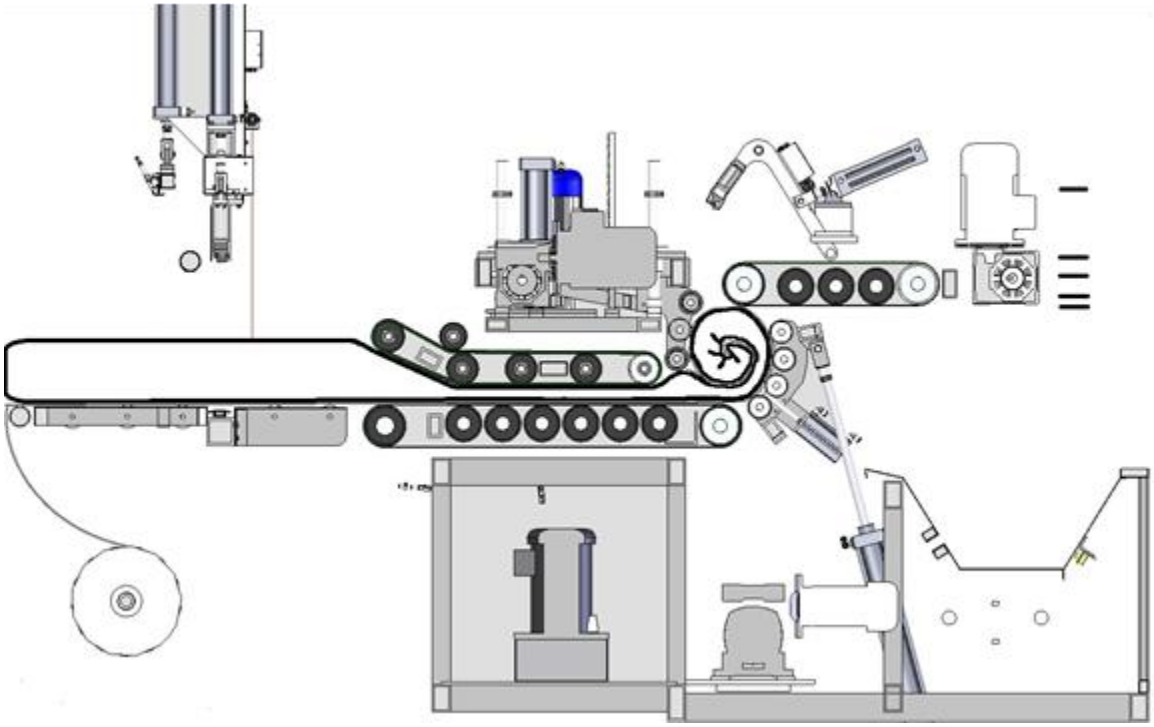
Step 3. The mattress is pushed into the conveyor belts and the conveyors draw the mattress towards the rolling chamber. The mattress is released by the operator at this time.



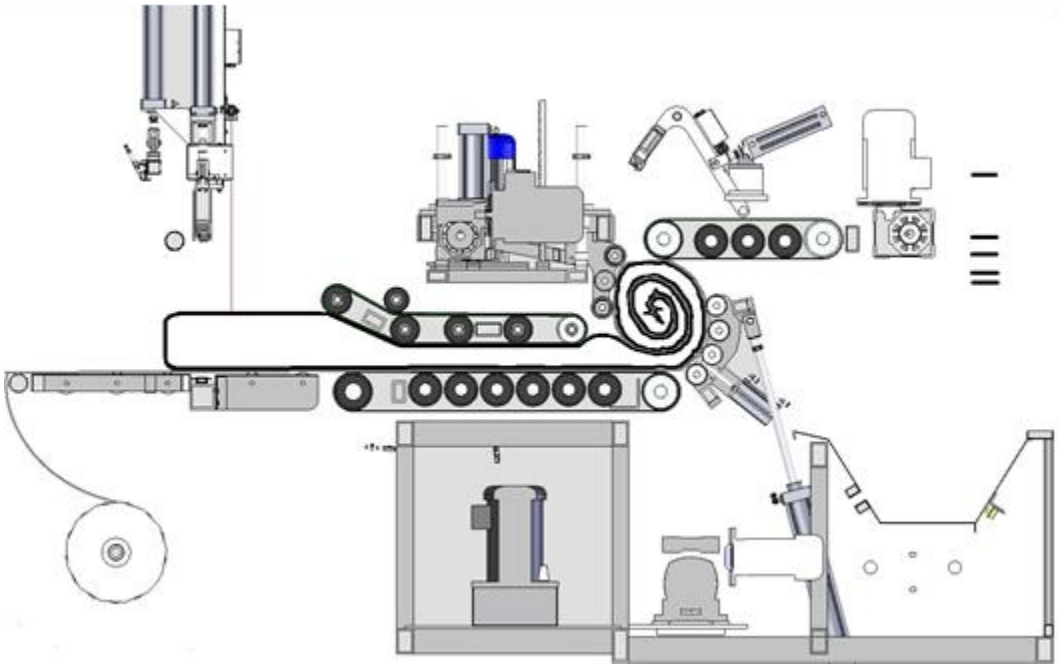
Step 4. The Pressing start sensor is blocked and pressing belt is lowered to the **Air Regulator Pressing Conveyor** setting. The Platform moves to the **Pressing Height Distance 1** setting. The Pack Position counter is reset to zero and the conveyor begins moving towards **Pack Position Distance 1**(Advanced Settings).



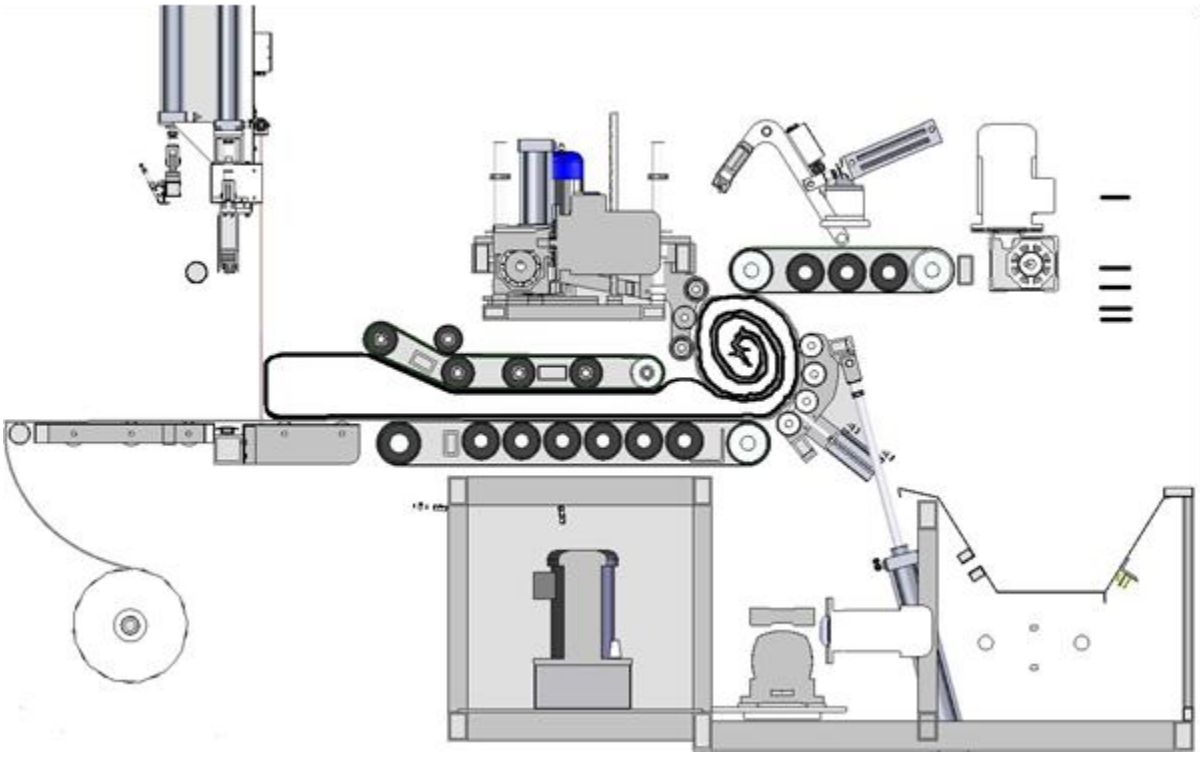
Step 5. The conveyor begins to feed the compressed mattress into the rolling chamber. As the roll becomes more compressed, the platform shifts to the left to maintain the **Air Regulator Compression** setting



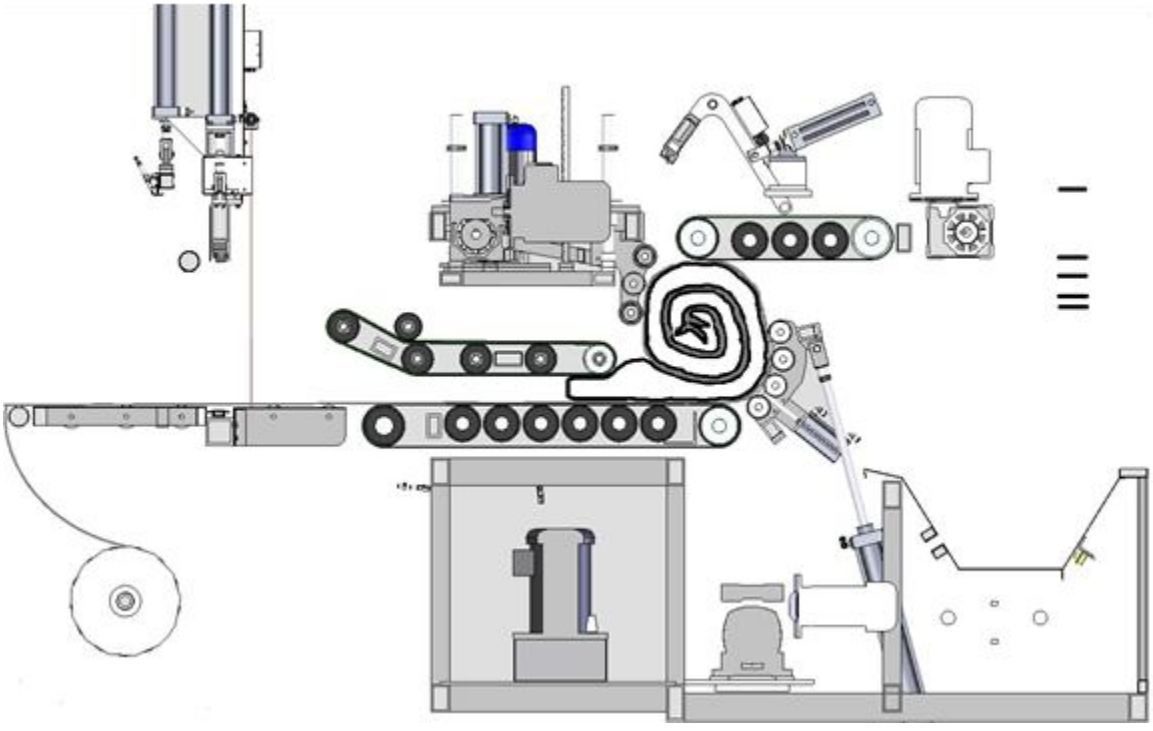
Step 6. The conveyor continues to feed the compressed mattress into the rolling chamber. **Pack Position Distance 1**(Advanced Settings) is met and the pressing platform indexes to the Packing Height Distance 2 position. The machine begins moving towards the **Pack Position Distance 2**(Advanced Settings) position.



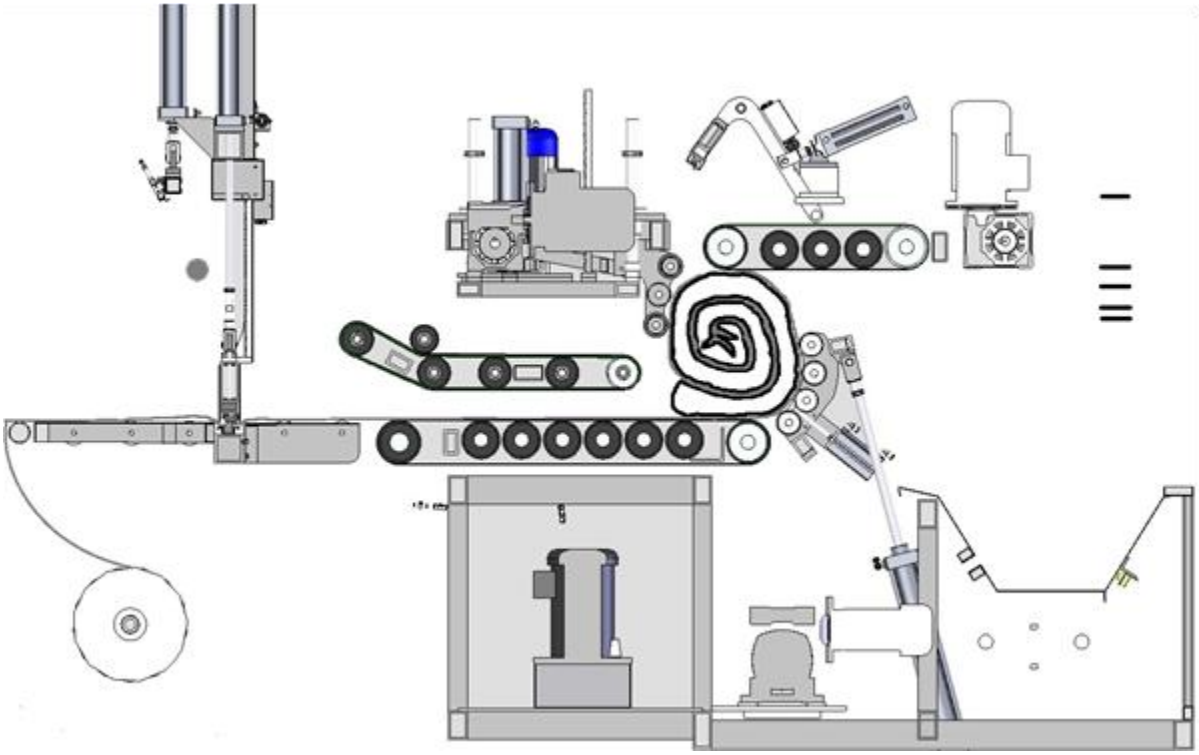
Step 7. The feed start sensor is unblocked and the machine resets the cut bar distance counter. The machine begins counting the **Cut Bar Distance** setting.



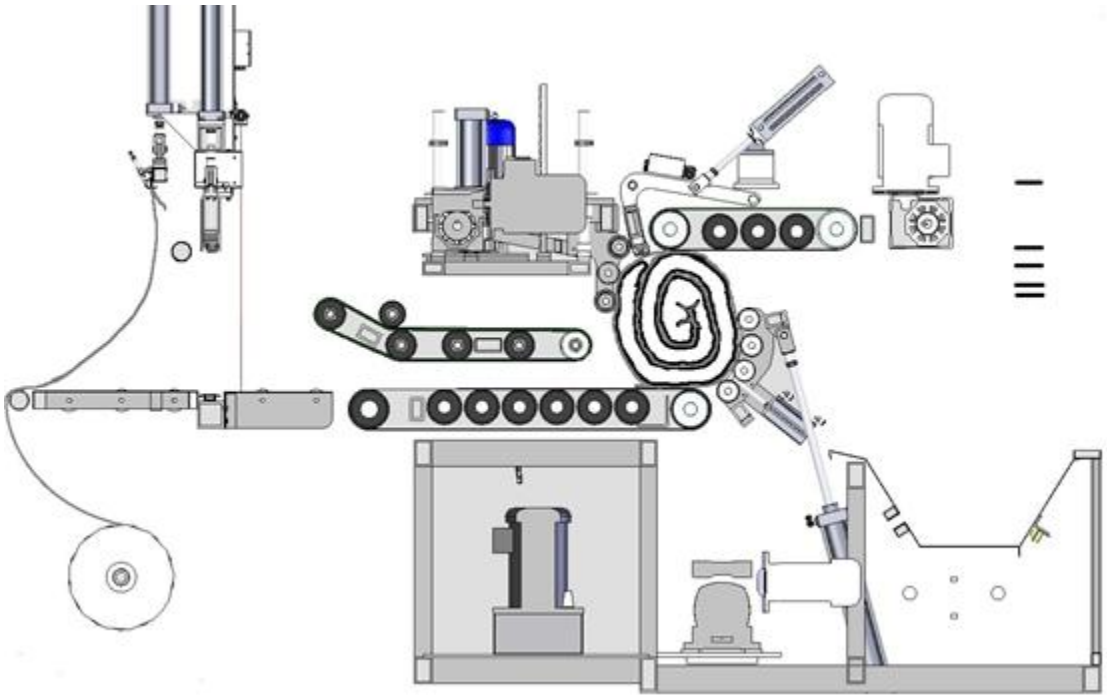
Step 8. the **Pack Position Distance 2**(Advanced Settings) position is met and the platform moves to the **Packing Height Distance 3** position.



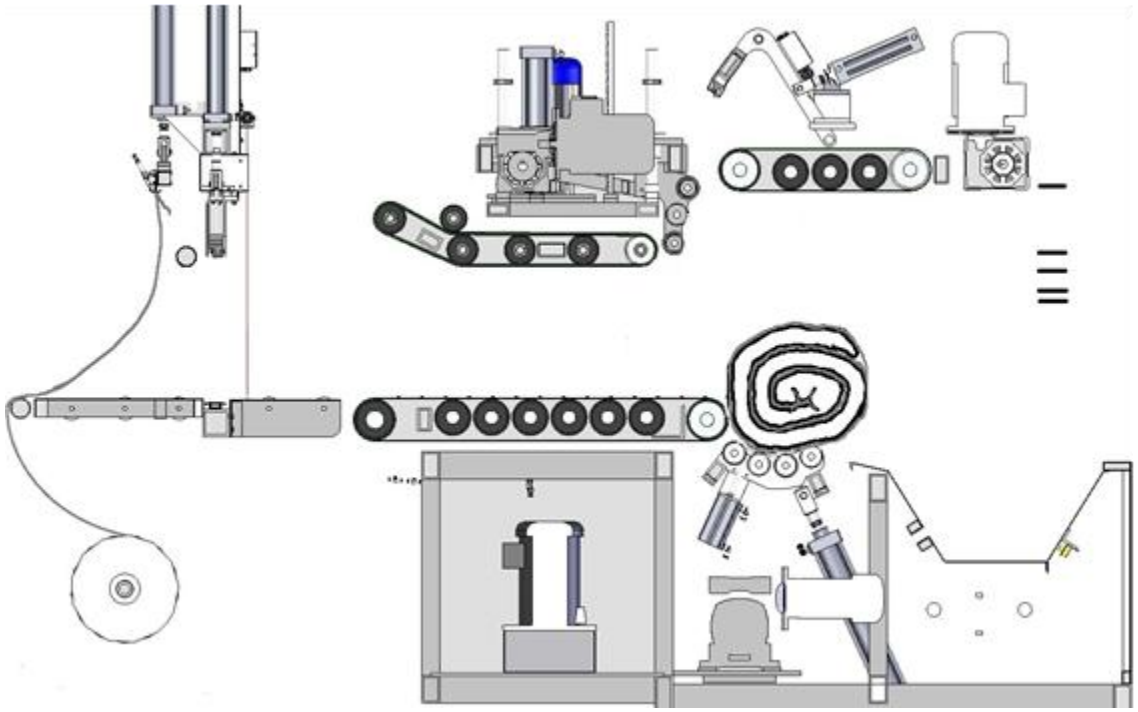
Step 9. The **Cut Bar Distance** setting is met and the cut bar and plastic gripper descend to cut the final wrap of plastic used to roll the mattress. The seal bar position counter is reset and the **Seal Bar Position Distance** setting begins to be counted.



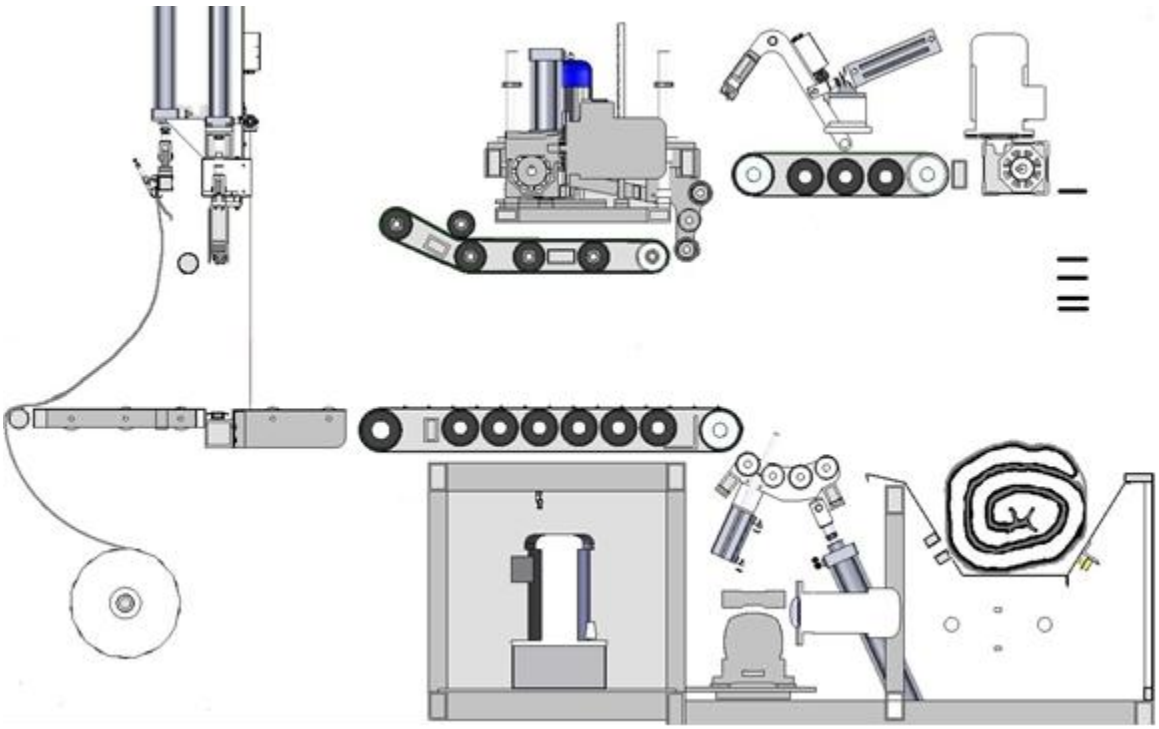
Step 10. The **Seal Bar Position Distance** setting is met and the seal bar descends to do the final seal of the mattress roll. The seal bar travels and dwells for the duration of the **Seal Bar Down Time** setting before retracting.



Step 11. The platform moves to the platform upper limit position and lowers the turn baffle to eject the mattress roll.

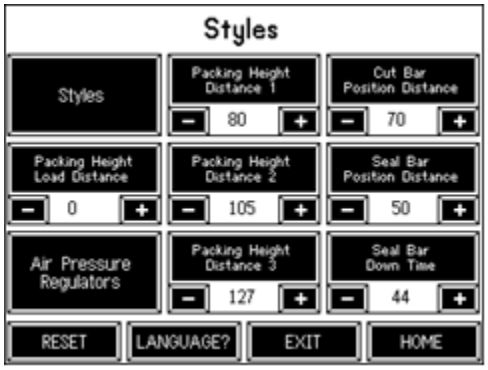


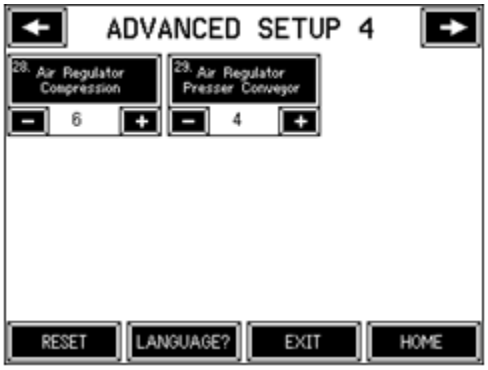
Step 12. If the unload sensor has not been met then the ejector finger fire to eject the roll from the turn baffle. The unload conveyor is cycled and the finished roll is ejected from the side of the machine. The cycle is complete and the machine returns to step 1.



2.2.2.2 - Managing the settings.

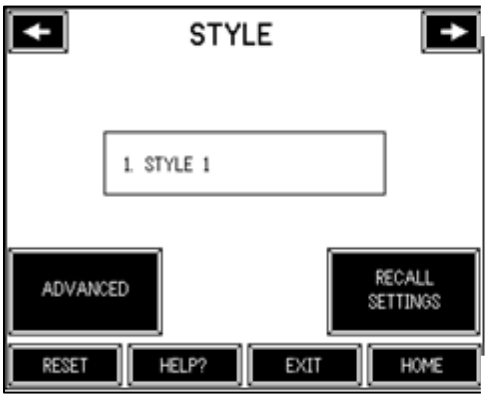
The settings can be adjusted by pressing the + and – symbols under the settings description. Pressing the actual name of the setting will bring you to the help screen that describes the settings function.





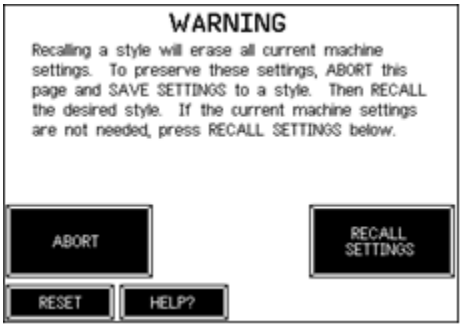
Pressing the styles button on the styles screen brings you to the select style menu. From this screen you can you can access 15 different settings configurations. These settings can be recalled making setting the machine for a different bed quick.

Pressing a specific style button will bring you to the style recall/edit screen. If the current security is lower than mechanic, you will only be able to recall settings. Pressing the Advanced button will allow the user to access the Advanced styles edit screen. This screen allows the user to save settings to style buttons and edit style names in addition to recalling style settings.



2.2.2.2 - Managing the settings. (cont'd)

Pressing the save settings button will record the current settings in the machine to the style being edited. **There is no warning so be careful hitting this button so you don't accidently corrupt your current setting!** Pressing the recall settings button will bring up the recall settings warning screen. Press the recall settings button to proceed or abort to exit without changing the settings. Pressing the edit name button will bring you to the style name edit screen. Exiting out of this screen saves the new name.



All settings should also be written down in case of a module failure or an update that would require the memory module to be defaulted. The styles settings are not backed up and all settings will be lost in the case of a memory module fault. These settings differ from manufacturer to manufacturer. Atlanta Attachment cannot be responsible for loss of settings due to updates. Below are starting points for settings. They are for reference only as every mattress rolls differently.

FINISHED ROLL DIAMETER	SENSOR 1	SENSOR 2	SENSOR 3	CUT BAR POSITION 1 WRAP	CUT BAR POSITION 2 WRAPS	SEAL POSITION
12	10	15	20	45	75	38
13	10	20	30	48	82	39
14	13	26	40	51	88	42
15	16	33	50	54	94	43
16	20	40	60	57	101	43
17	23	46	70	60	107	44
18	26	53	80	63	113	45
19	30	60	90	67	119	47
20	33	66	100	70	126	49
21	36	73	110	73	132	51
22	40	80	120	76	138	53
23	43	86	130	79	145	55
24	46	93	140	82	151	58

If two wraps of plastic are desired because of higher pressures encountered in spring mattress rolling or high compression foam bed rolling, the cut bar setting of **CUT BAR POSITION 2** wraps should be used. Otherwise use **CUT BAR POSITION 1** wrap for the cut bar position setting. The load position setting will depend on the thickness of mattress. It should be low enough to engage the mattress at the compression conveyors during in feed. The air regulator settings should be set so that you get equal compression in the pre-pressing that you are getting in the finished roll and equal pressure laterally in the rolling operation to that which is being given in the vertical axis by the pressing platform. These settings differ depending on mattress construction. A chart that compares mattress thickness to roll diameter to give compression % follows.

	COMPRESSION PERCENTAGE												
MATRESS THICKNESS OF 80" BED	30	35	40	45	50	55	60	65	70	75	80	85	90
3	14.6	14.1	13.5	13	12.4	11.7	11.1	10.3	9.57	8.74	7.82	6.77	5.53
4	16.9	16.3	15.6	15	14.3	13.5	12.8	11.9	11.1	10.1	9.03	7.82	6.38
5	18.9	18.2	17.5	16.7	16	15.1	14.3	13.4	12.4	11.3	10.1	8.74	7.14
6	20.7	19.9	19.1	18.3	17.5	16.6	15.6	14.6	13.5	12.4	11.1	9.57	7.82
7	22.3	21.5	20.7	19.8	18.9	17.9	16.9	15.8	14.6	13.4	11.9	10.3	8.44
8	23.9	23	22.1	21.2	20.2	19.1	18.1	16.9	15.6	14.3	12.8	11.1	9.03
9	25.3	24.4	23.5	22.5	21.4	20.3	19.1	17.9	16.6	15.1	13.5	11.7	9.57
10	26.7	25.7	24.7	23.7	22.6	21.4	20.2	18.9	17.5	16	14.3	12.4	10.1
11	28	27	25.9	24.8	23.7	22.5	21.2	19.8	18.3	16.7	15	13	10.6
12	29.3	28.2	27.1	25.9	24.7	23.5	22.1	20.7	19.1	17.5	15.6	13.5	11.1
13	30.4	29.3	28.2	27	25.7	24.4	23	21.5	19.9	18.2	16.3	14.1	11.5
14	31.6	30.4	29.3	28	26.7	25.3	23.9	22.3	20.7	18.9	16.9	14.6	11.9
15	32.7	31.5	30.3	29	27.6	26.2	24.7	23.1	21.4	19.5	17.5	15.1	12.4

Exceeding **85%** compression on any mattress is not recommended. **70%** compression showed the best results in recovery time and condition. Only the customer can dictate the line between quality and shipping cost cutting. Please test all new products by rolling at the desired settings and allowing for the maximum amount of shipping and storage time the mattress will be exposed to before running full production runs to prevent the loss of product and materials.

2.3 - Machine Operation

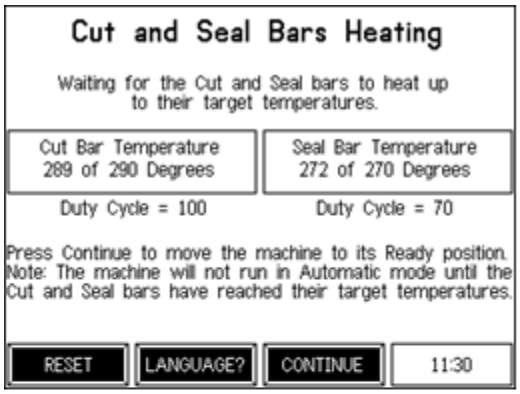
2.3.1 - Machine Start Up

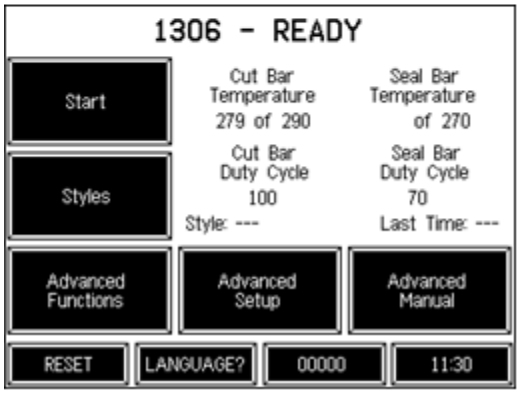
1. Turn main power disconnect switch to ON position.
2. Turn Main Air Valve to the ON position.
The pressure on the gauge should be set to 90 PSI.
3. Ensure all E-Stops are disengaged on all 4 corners of the machine.
4. Press the Green Power button Located on any of the four E-Stop Boxes.

NOTE: Machine will move during power up. It is the operator's responsibility to make sure the machine is clear before initiating power on.

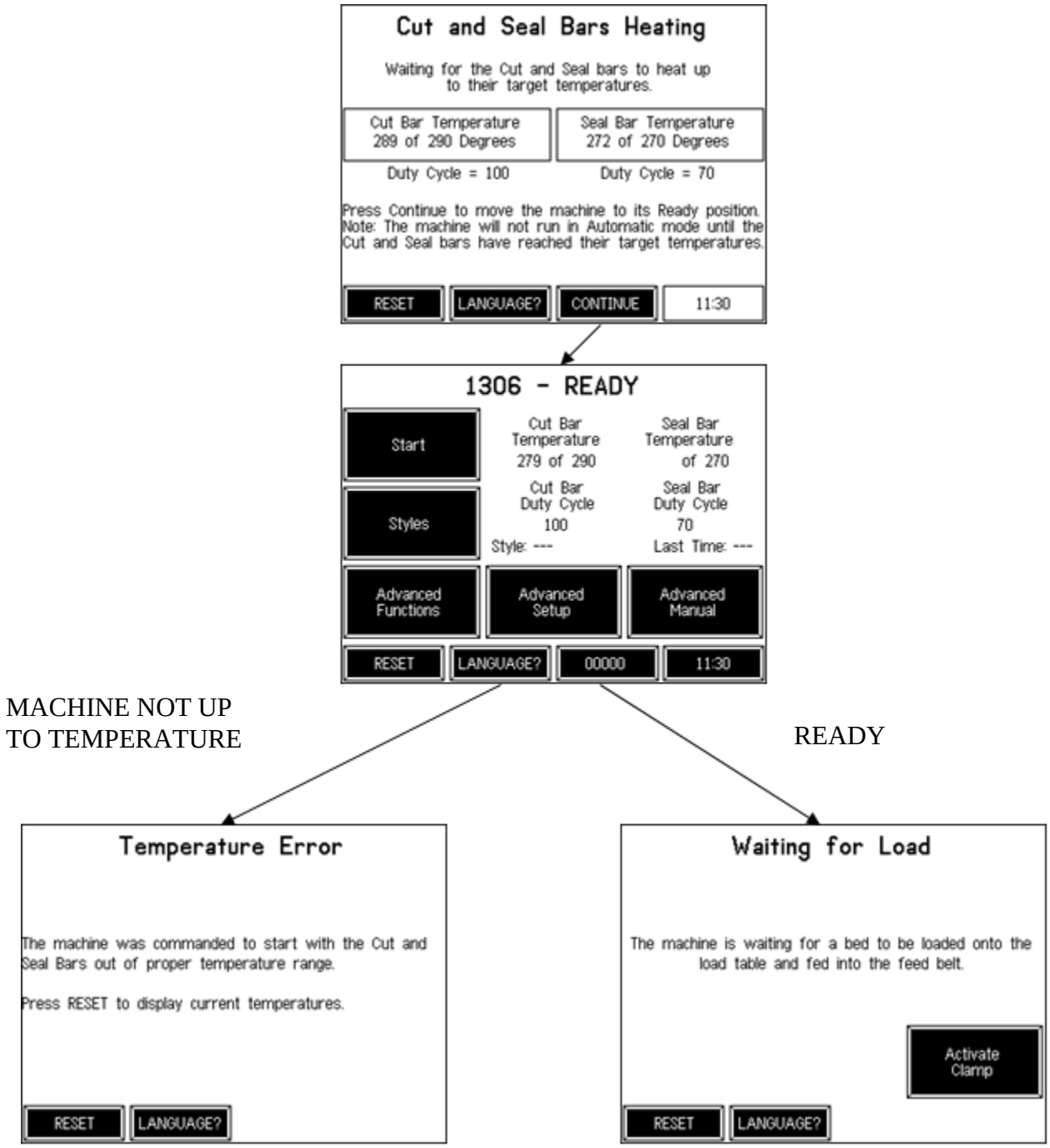
The seal bars will begin to heat up at this point. It takes approx. 30 minutes for the heated bars to come up to temperature and stabilize.

5. When the target temperatures have been reached on both bars and are staying within 5 degrees of the set point for 5 minutes, press continue on the heat up screen.





6. Press the Start button to enter automatic operation.
If the machine is not up to temperature, the temp error screen will be displayed and pressing the reset button will return you to the temperature monitor screen.
7. The ready to run screen will be displayed indicating the machine is ready to receive a mattress to roll.



8. Push mattress into plastic curtain in front of the loading table.
9. Machine will release plastic when the feed start sensor eye is block. Continue pushing Mattress till engaged in pressing conveyor.
10. Watch rolling sequence during first roll of new product to ensure the correct settings have been selected. Always be ready to hit the e-stop or pause the cycle to ensure product is not damaged during an improper feed and roll cycle.

2.4 - Touch-Screen

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.

2.4.1 - General Operation

ATTENTION: DO NOT USE ANY SHARP OBJECTS TO TOUCH THE SCREEN

The graphics images presented on the touch screen show "3-dimensional" buttons, which may be pressed to access other screens, change counters and timers, or actuate hardware. Areas lacking the "3- dimensional" border contain information only.

Counters are identified with the "+" and "-" buttons in the corners. These counters may be adjusted by touching the "+" and "-" boxes.

RESET: Clears all machine functions and returns to the main page.
time and date.
LANGUAGE: Return to the language screen. You can select multiple languages to use.
HOME: Return to the main screen.

ARROWS: Pressing the arrows right or left will take you to the next or previous pages.

NOTES: When a button has a white background the function is on or enabled. A dark background indicates off or disabled. Some buttons may toggle on or off, others must be held on.

Other screens display whenever there is a machine error or other condition that prohibits the operation of the machine. Simply follow the instruction on the screens to resolve the problem.
There are also “ADVANCED” settings and functions available. These functions are only accessible by a password, and include: timers that control machine hardware, input and output test screens, and machine statistics. To get to the advanced functions the appropriate password must be entered at the security screen. Security access is reset whenever the main power is turned off, or the RESET button on the main page is pressed. The factory default access code is "33333".

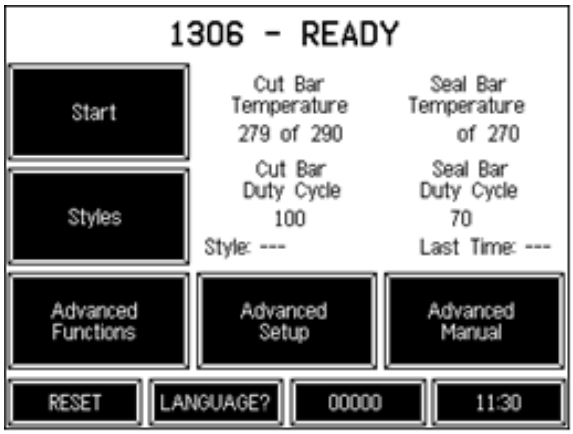
2.4.2 - Available Menus

The following is a summary of the different screens and their functions available for the Machine Operator.

2.4.2.1 - 1306 – Main Screen

The normal operation of the machine is controlled from the main 1306 – READY screen. From here you can start the automatic cycle and access all machine functions.

START: After touching this field the machine automatic function of the roll pack is activated. When this button is pressed the operator is brought to the "WAITING TO LOAD" screen.



LANGUAGE: This field is located in almost all the available screens. Select at any time to access other languages.

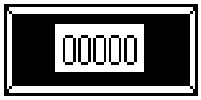
STYLES: main setting screen with set-up for rolling the current mattress. See section "" for more details about this screen.

EDIT NEW ORDER: See a section in this book with more details about this screen.

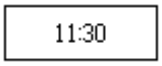
ADVANCE FUNCTIONS: Area reserved only for technicians

ADVANCE MANUAL: Area reserved only for mechanics and higher security. This contains means to move different parts of the machine for troubleshooting and maintenance purposes.

PIECE COUNT: The field on the left of the clock button is the piece counters that increment every time the border cycle is complete. Touching on this area will bring up a screen to reset this count. This counter can be used for a daily production monitor. On this screen is also located an efficiency monitor that displays the machine run time vs. the machine on time and displays it as a percentage.



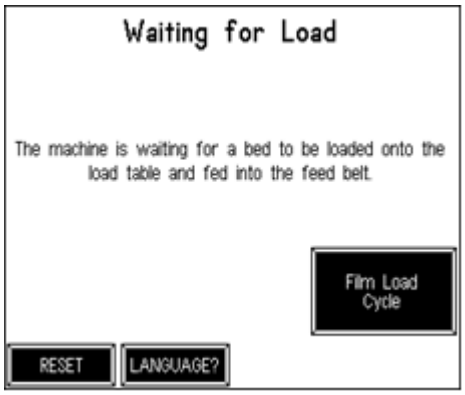
CLOCK: Lower right button allows access to a screen for setting the correct time.



2.4.2.2 - Waiting to Load Screen.

Operator is able to begin automatic rolling from this screen. Accessed by pressing start from the main screen while machine is up to temperature.

FILM LOAD CYCLE: This button actuates the plastic gripper bar to lower and grab the wrapping plastic.

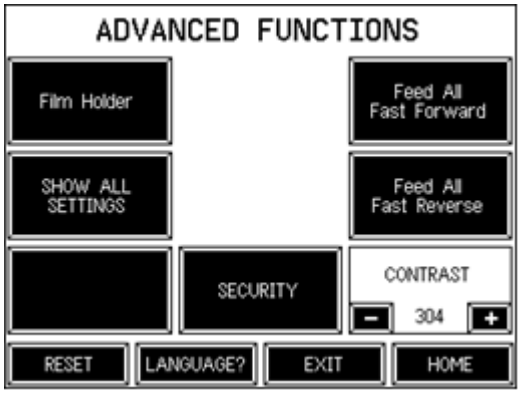


NOTE: Be sure hazard tapped area of in-feed table surface is clear of foreign objects and/or body parts before pressing this button.

2.4.2.3 - Advanced Functions

This screen allows access to SECURITY, SYSTEM INFORMATION, SHOW ALL SETTINGS, ADVANCED SETUP, MANUAL, and CONTRAST.

Film Holder: This button actuates the plastic gripper bar to lower and grab the wrapping plastic.



SHOW ALL SETTINGS page displays all machine settings as a matrix. Use this screen for recording all settings prior to a program update or for reference.

The **SECURITY** button accesses the security screen for changing the pass codes. Contact an Atlanta Attachment technician for instructions on changing the pass code.

The **CONTRAST** button changes the screen contrast using the "+" and "-" buttons. Press **EXIT** anytime to return to the previous or "**HOME**" to return to the **MAIN** screen.

ADVANCE SETTINGS and **ADVANCE MANUAL** are restricted areas for Technician; they can only by accessed by the use of a password.

2.5 - Maintenance

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.

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/tag out 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

2.5.1 - Daily

• Clean the seal and cut bars at least once a day, preferably at the beginning of shift before the machine has been turned on and the bars have heated up. To clean the bars, use a soft cloth and WD-40 as the solvent. Use extra care not to scratch the Teflon coating of the bars as this will cause the seal bars to stick to the plastic and render the bars ineffective at sealing/cutting.
• Check for proper oil level and leaks in hydraulic pump system. Pump uses Tellus® Oil 32 from Shell.
• Clean the machine and surrounding area, keeping debris from becoming a trip hazard. This should be done once a day. Plastic scraps could jam machine mechanisms.
• Wipe all photocell lenses with a clean non-abrasive dry cloth.
• Check condition of the Seal bar tape under the in feed cut bar. Replace if there is any noticeable tears or cuts in the tape.
• Open or remove doors and/or covers and inspect chains for debris or wear and clean or replace as necessary. WD-40 should be sprayed on all chains.
• Monitor the air pressure filter/regulator and empty as necessary.
• Investigate and report any unusual noises to the proper personnel.

2.5.2 - Weekly

• Oil bearing shafts for the main platform, pressing belt and unload unit. Oil all cylinder rods. Grease gear racks used on the cut bar assembly with Teflon based grease.
• remove oil filter bowl on the pneumatics and remove any accumulated debris.

2.5.3 - Quarterly

• Check all roller pillow bearings and grease use a Teflon base grease.
• Check condition of the Seal bar tape and the silicon rubber cushion bellow for damage.
Replace Tape as needed. Cushion May be flipped if one side is cut thru. If both sides are cut deeply replace cushion
• Clean the machine at the end of every shift or as excess materials accumulate.

2.4.3 Quarterly

• Wipe all photocell lenses with a clean non-abrasive dry cloth.
• Use a soft cloth for cleaning to clean all reflective tapes. 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.

3 - TECHNICAL MANUAL

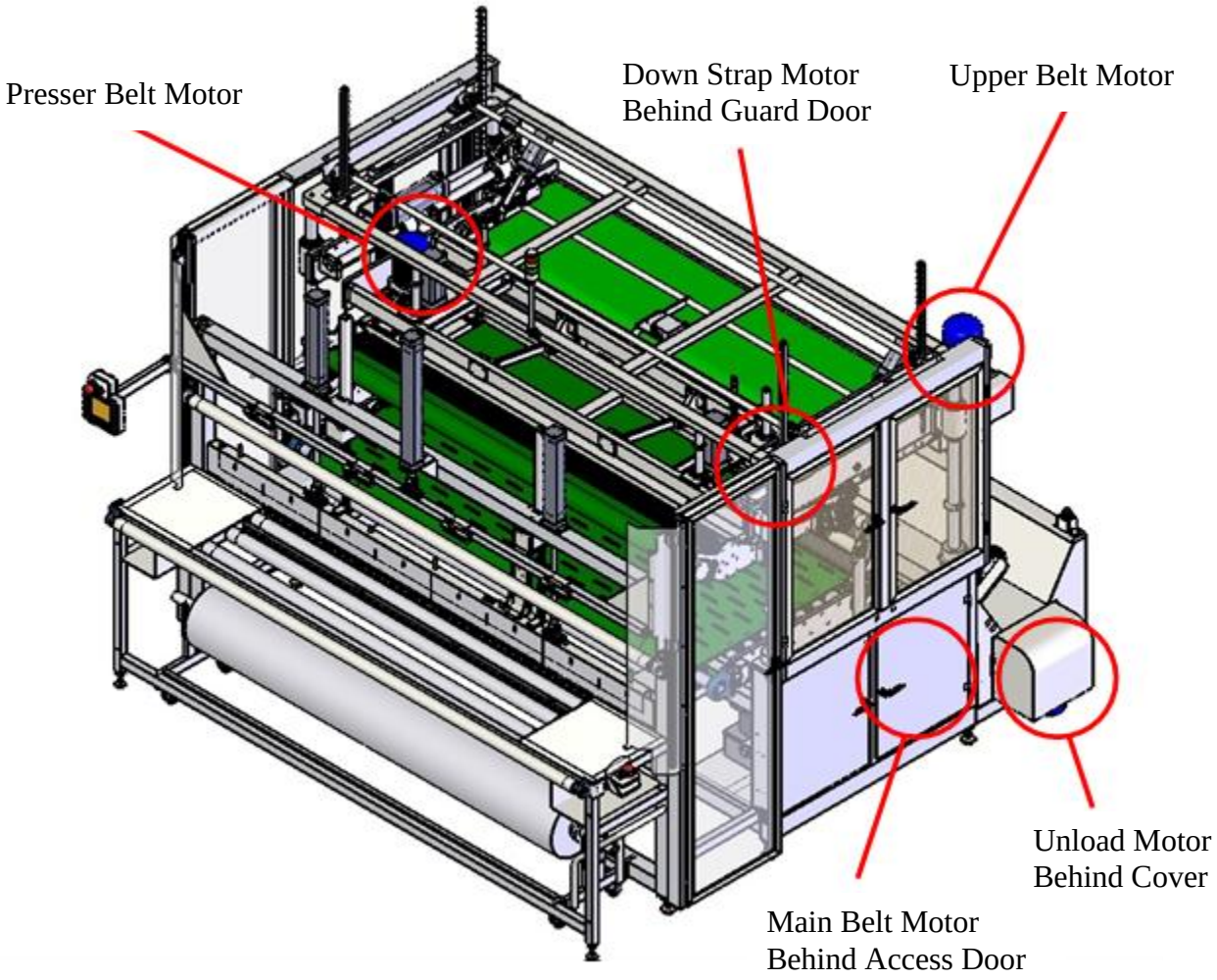
All maintenance should be performed by a qualified service technician.

3.1 - Mechanical

3.1.1 - Motor Drives and Settings

The drive motors for the 1306 are location in the lower left corner of the control box. The following table shows the drive machine parameters and their settings. These parameters may vary slightly based on the final installation requirements. To edit these settings, refer to the "Editing Motor Drive Parameters" on page XX. If the parameters have to be modified, record the new settings and keep them in this manual for future reference.

NOTE: DO NOT CHANGE ANY OF THE OTHER PARAMETERS. THESE SHOULD BE SET AT THEIR DEFAULT VALUES AND REQUIRE NO ADJUSTMENT.



3.1.2 - Editing Motor Drives Settings

In an effort to minimize the amount of information that the operator/mechanic has to look through, only the pages that pertain to programming and drive faults are shown here. For more information, please refer to the manufacturer's (AC Tech) manual included with the machine.

3.1.3 - Motor Drive Parameters

NOTE: A Complete motor drive User Manual is included in the machine documentation package.

1306 DRIVE PARAMETER LIST:						
PARAM.	DESCRIPTION	UNLOAD	PRESSER BELT	MAIN BELT	UPPER BELT	DOWN STRAP
1	208/230	02/01	02/01	02/01	02/01	02/01
2	DEFAULT	02	02	02	02	02
3	DEFAULT	01	01	01	01	01
4	RAMP DECEL	04	03	03	03	03
5	PRESET 1	02	02	02	02	02
6	RELAY = RUN	06	06	06	06	06
10	TB-13A = REVERSE	06	06	06	06	06
11	TB-13B = SPEED 2	04	04	04	04	04
12	TB-13C = SPEED 3	04	04	04	04	04
14	DEFAULT	01	01	01	01	01
16	DEFAULT	02	02	02	02	02
17	ROT. FWD AND REV	02	02	02	02	02
19	ACCEL	.8	0.3	0.3	.8	0.3
20	DECEL	.2	.4	.4	.2	.4
21	DEFAULT	10.0	0.0	0.0	0.0	0.0
22	DEFAULT	30.0	0.0	0.0	0.0	0.0
23	DEFAULT	0.0	0.0	0.0	0.0	0.0
24	MAX FEQUENCY	50.0	60.0	60.0	60.0	60.0
25	208/230	150/180	150/180	150/180	150/180	150/180
26	DEFAULT	100	100	100	100	100
27	BASE FREQUENCY	50.0	60.0	60.0	60.0	60.0
28	208/230	20/10	20/10	20/10	20/10	20/10
29	DEFAULT	0.0	0.0	0.0	0.0	0.0
30	DEFAULT	0.00	0.00	0.00	0.00	0.00
31	SPEED 1	50.0	59.0	60.0	60.0	60.0
32	SPEED 2	50.0	59.0	60.0	60.0	60.0
33	SPEED 3	30.0	30.0	30.0	30.0	30.0
34	DEFAULT	0.0	0.0	0.0	0.0	0.0
35	DEFAULT	0.0	0.0	0.0	0.0	0.0
36	DEFAULT	0.0	0.0	0.0	0.0	0.0
37	DEFAULT	0.0	0.0	0.0	0.0	0.0

3.2 - Pneumatic System

3.2.1 - Main Air pressure regulator AA198-5110

The regulator assembly is located behind the table. The regulator is for the main air pressure, this is normally set to 80 to 90 psi.

The purpose of the regulator is to keep the operating pressure of the system (secondary pressure) virtually constant regardless of fluctuations in the line pressure (primary pressure) and the air consumption.

Clean air in your compressed air system is essential for the safe and efficient operation of this reliable power source. Harmful contaminants like oil, dust, dirt, rust, and water-alone or in combination-can attack your system and clog sensitive pneumatic instruments. It can also reduce the efficiency of air-operated tools. Wear out seals and erode system components. Increase maintenance and repair costs. Contribute to product rejects, production downtime-even complete plant shutdown.

3.2.2 - Electronic Pressure Regulator AA198-3050A

The regulator assembly is located above main regulator. These regulators are used to control pressure exerted before and during the rolling process.

3.2.3 - Air pressure module. 4080-200

It is the Sensor responsible for the detection of the secondary air pressure, if it does not reach the pre-adjusted value.

For more details of connections see plumbing diagram part # 1306-PD located at the end of the manual.

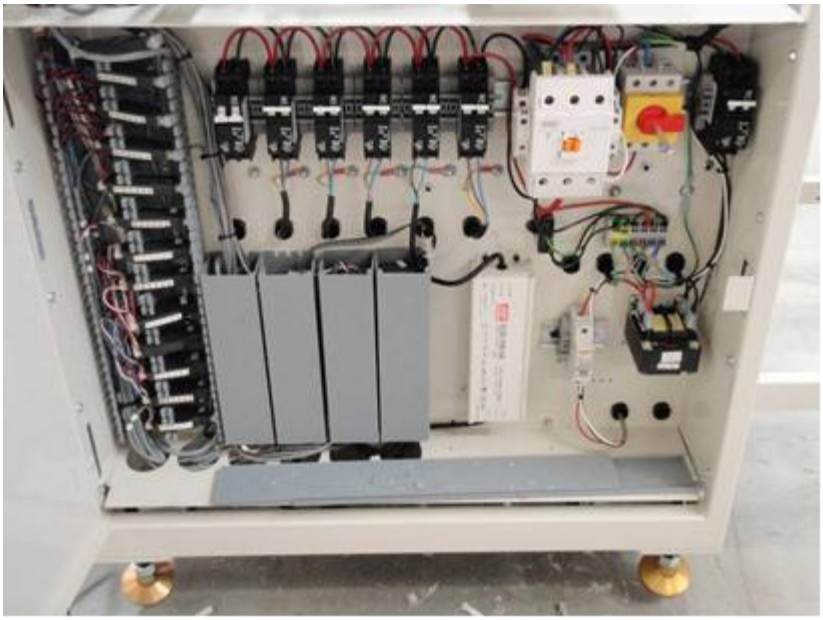
3.3 - Electrical

All maintenance should be performed by a qualified service technician.

3.3.1 - Main Power Switch

The main power On/Off switch is on the side of the machine. It is used to turn the power on to the whole machine. This machine requires 220V-240V Three Phase 50 Amps. If you have problems with the power not coming on when the On button is pressed you may check this switch by doing the following.

ATTENTION. Make sure that the machine is unplugged before proceeding and that all lock out/tag out procedures have been correctly followed (See to Lockout tag out procedure)



- Check the circuit breakers if any of the barkers had gotten overloaded at some point.
- Replace the cover, plug the machine in, and try turning the machine back on.
- If the contact still trips the overload, then there is a problem either with the wiring or the contactor.
- Use the wiring diagram for your machine in the parts manual to check the voltages.
- Try replacing the circuit breaker.

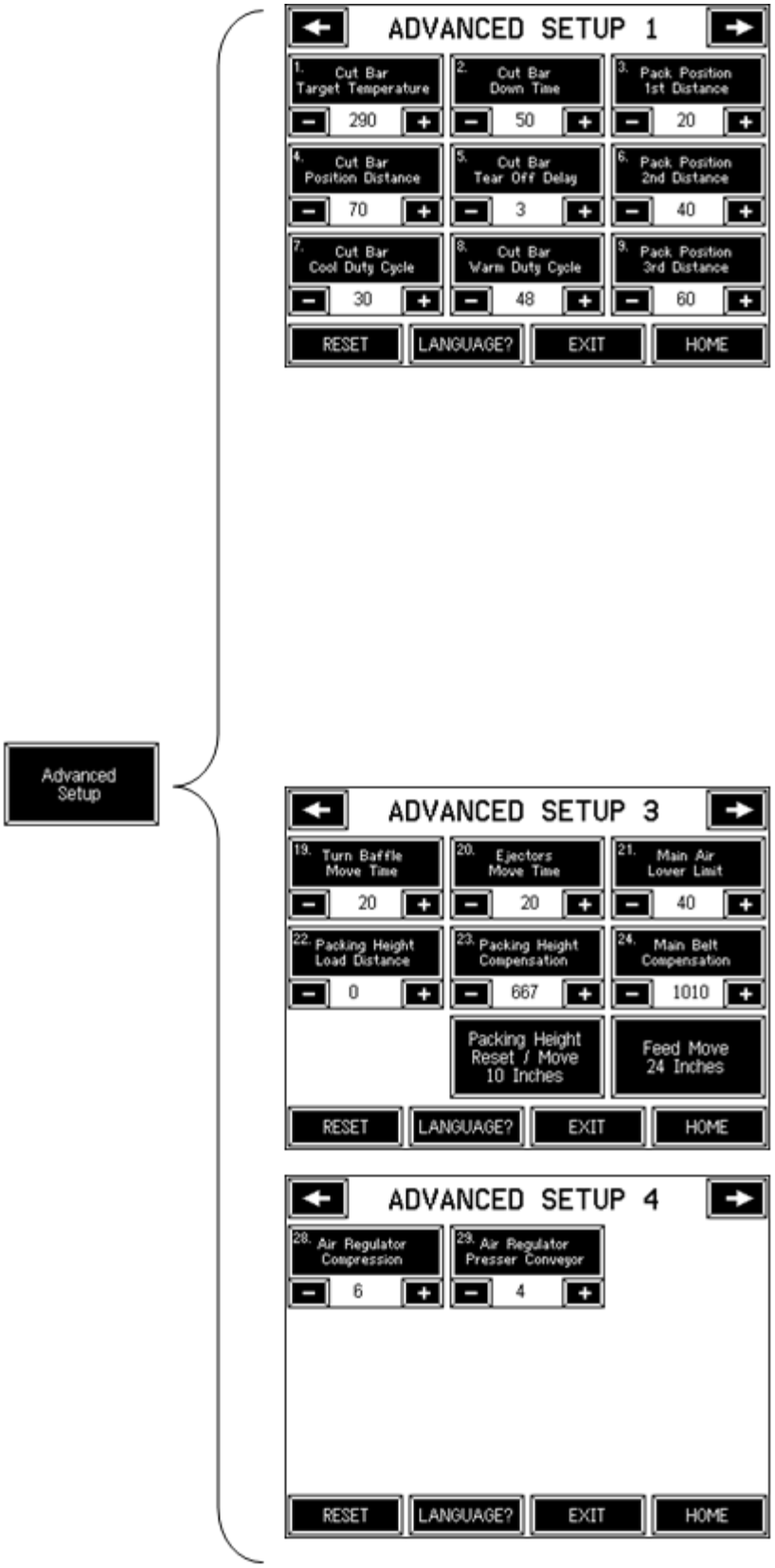
3.4 - Serial Bus

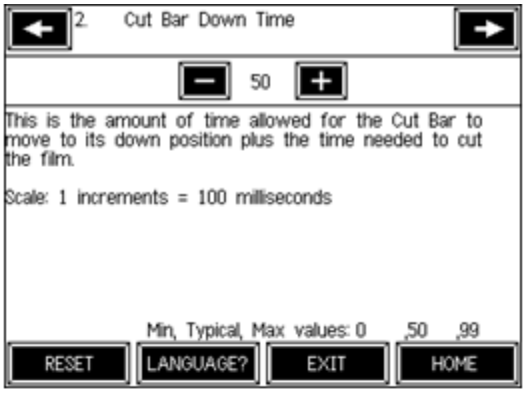
3.4.1 - Technical Menus

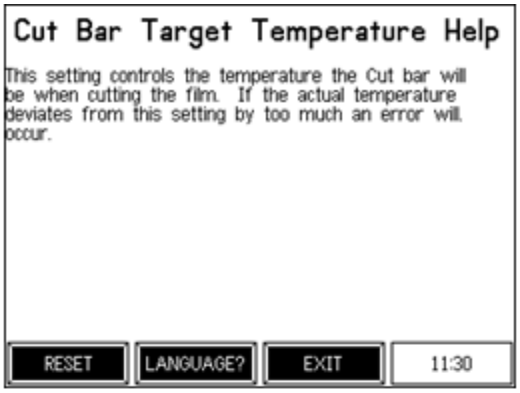
3.4.1.1 - Advance Settings

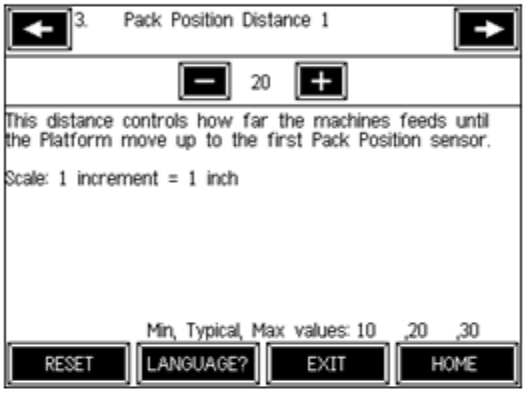
The ADVANCED SETTINGS from the ADVANCE FUNCTION menu accesses the advanced machine settings and functions not normally accessible by the operator. After power on or a reset, a pass code must be entered to access these screens.

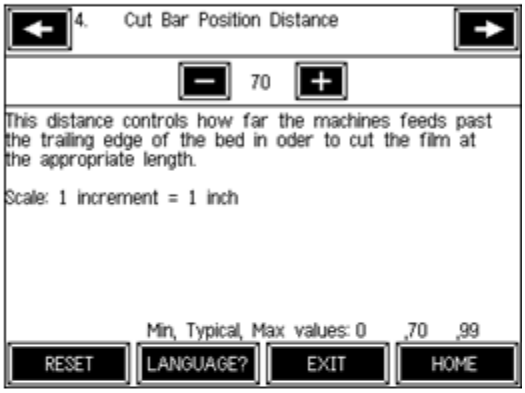
The two ADVANCED SETUP pages contain all the adjustable counters and timers that control the machine. The number in the upper left corner of each button represents the counter/timer number and is used on the SHOW ALL SETTINGS page matrix.

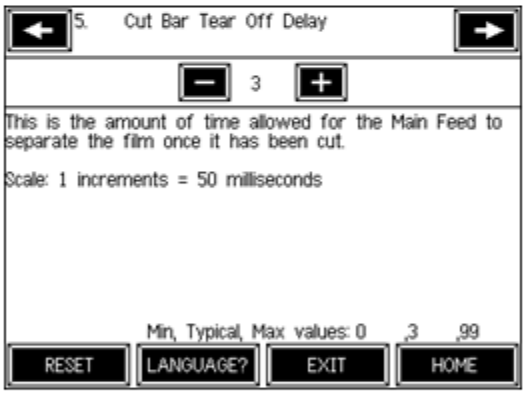


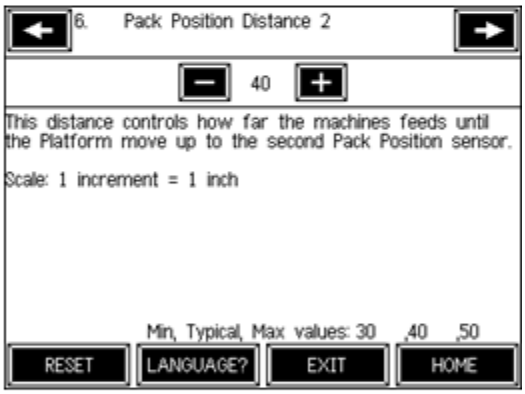


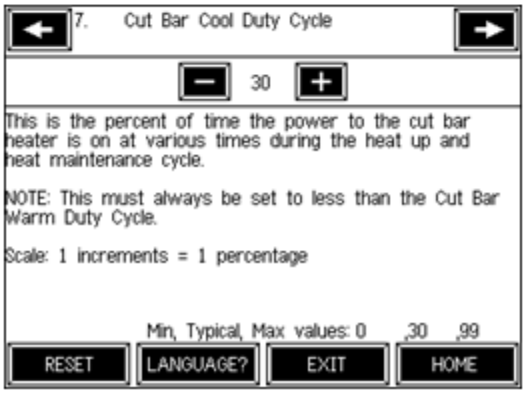


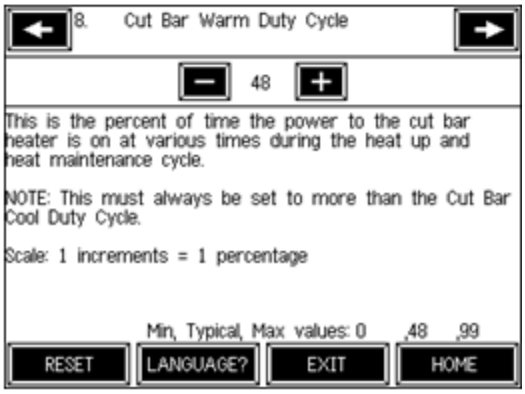


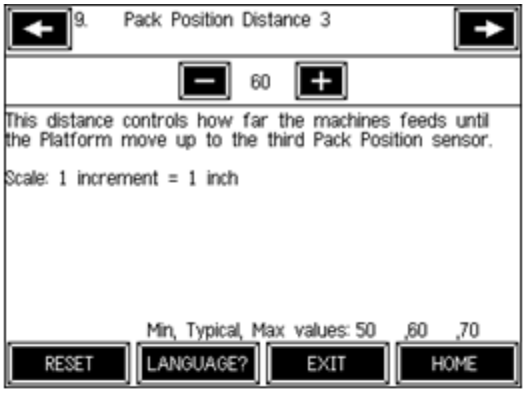


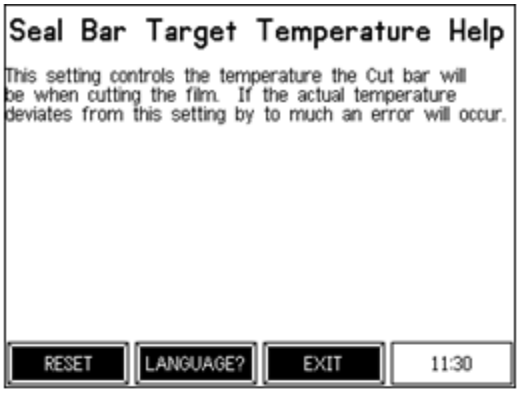


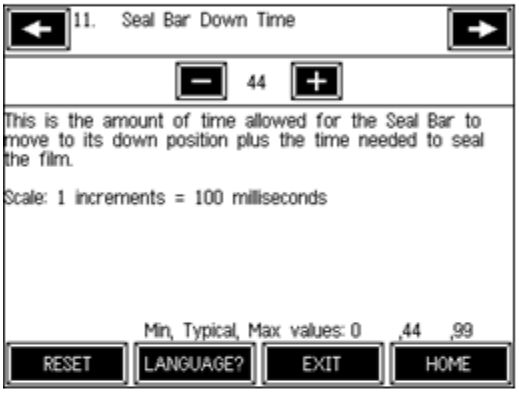


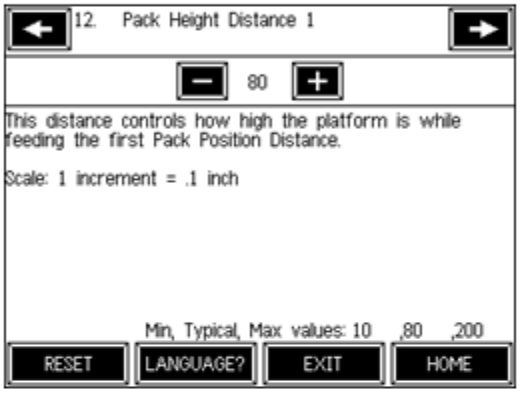


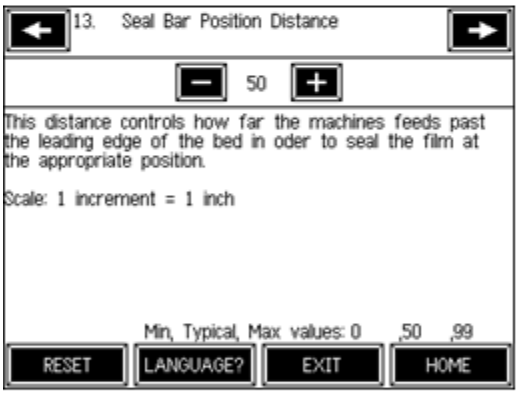


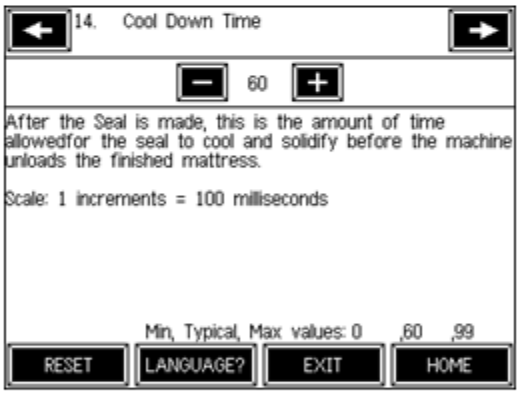


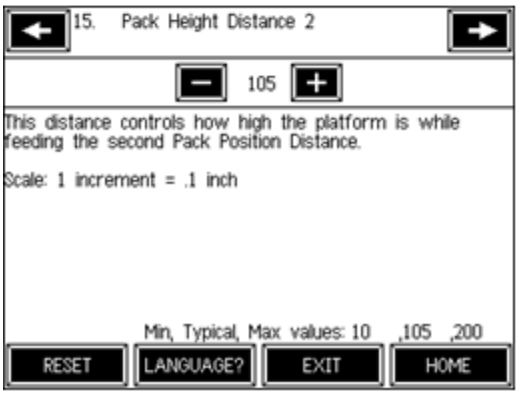


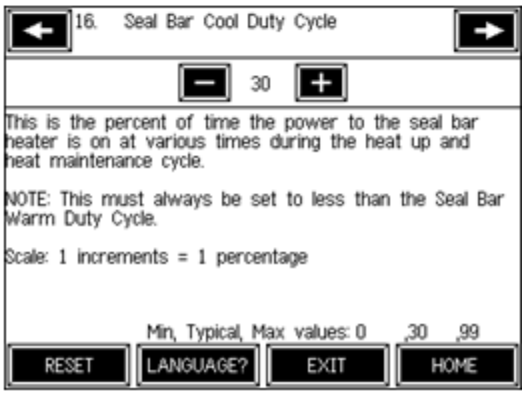


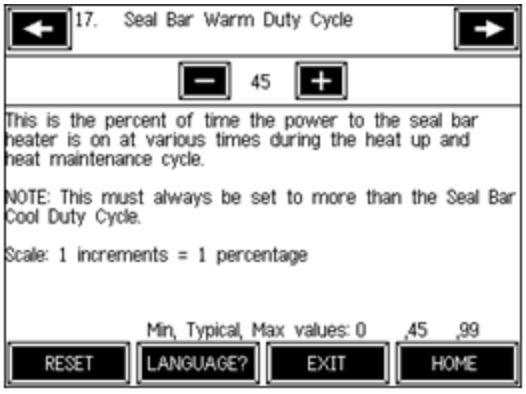


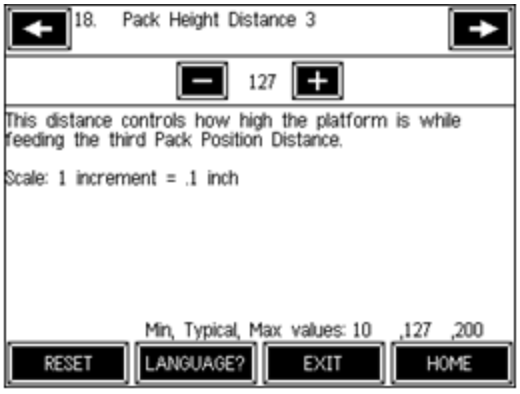


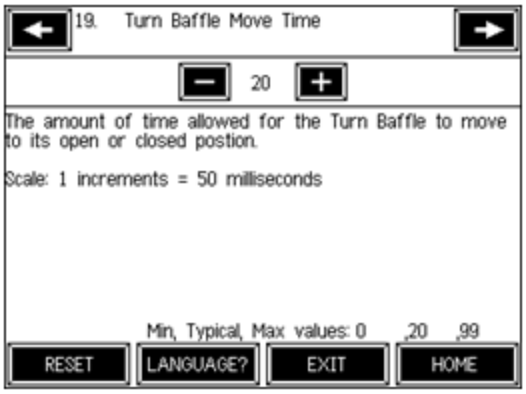


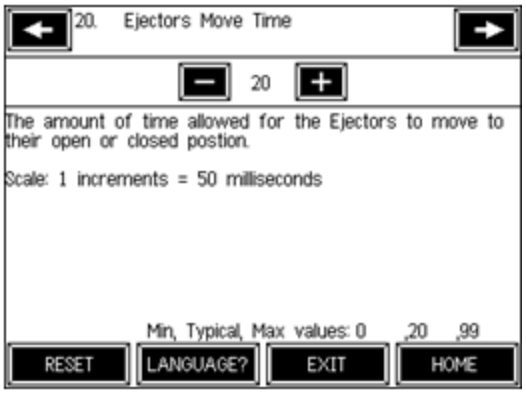


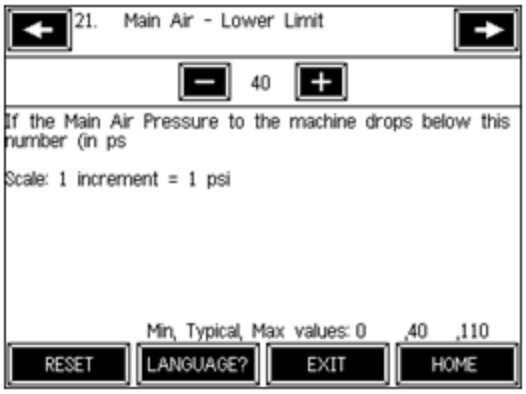


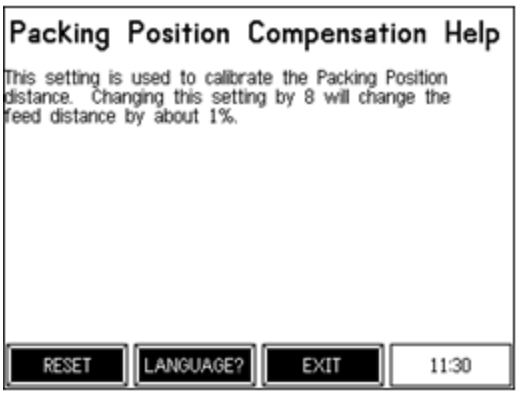


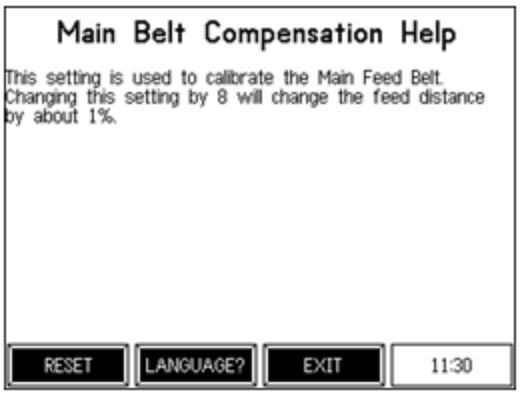






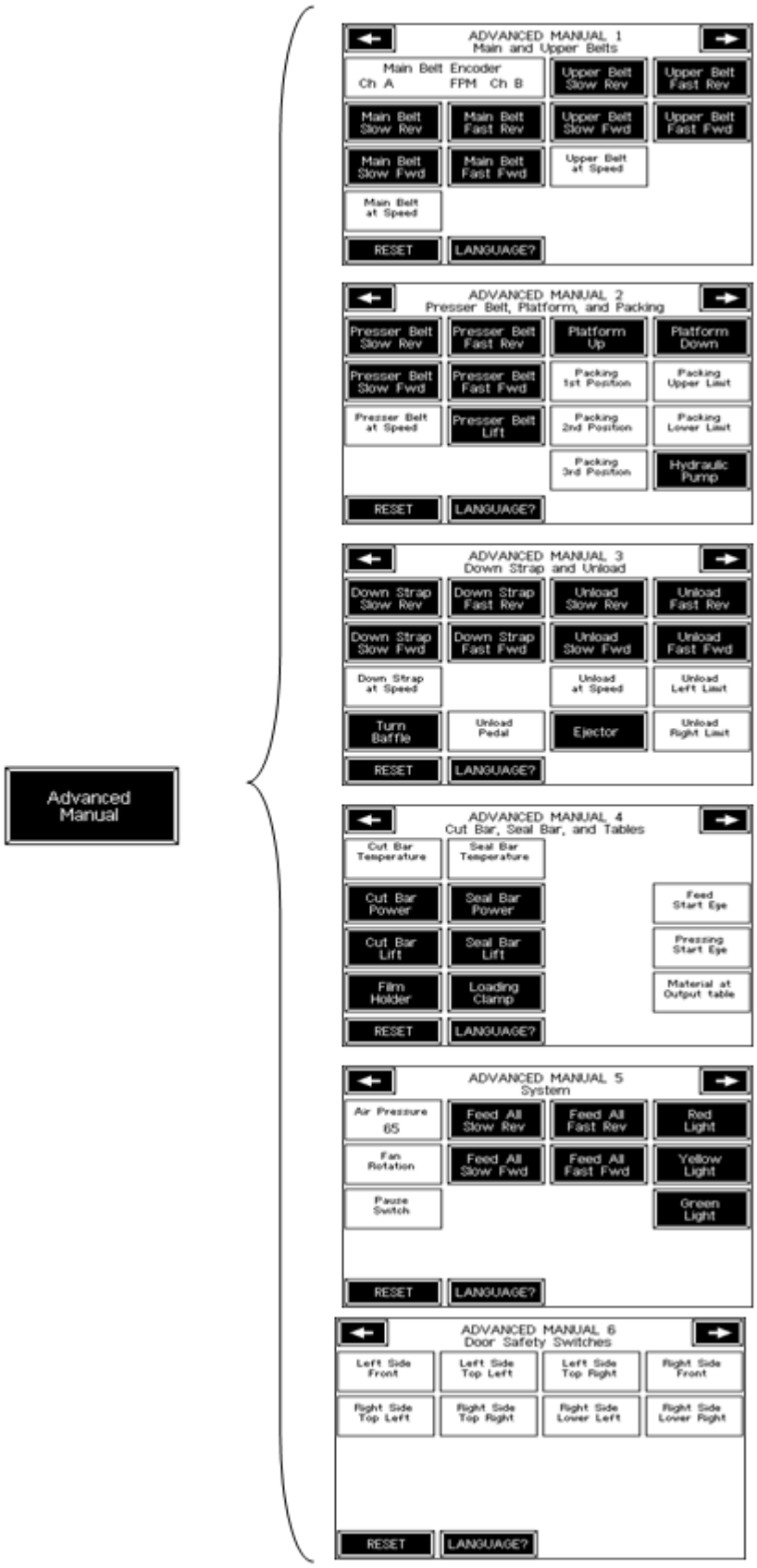






3.4.1.2 - Advance Manual.

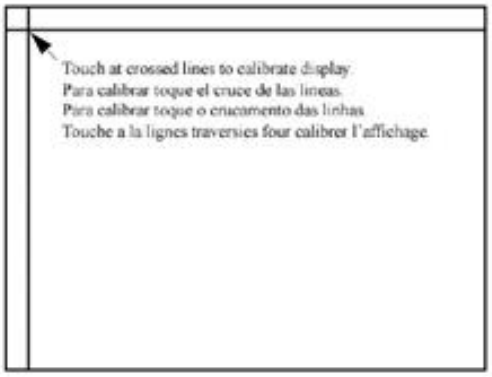
The four ADVANCED MANUAL pages contain buttons, shown as dark "3" dimensional rectangles, and input indicators, shown as light rectangles. The buttons are used to manually turn on or off individual output functions of the machine for testing and troubleshooting. The input indicators show if the computer can "see" the individual inputs for testing and troubleshooting.



3.4.2 - Calibrating the Touch Screen

If you are having troubles locating the right place to get access to the function by touching the screen a screen calibration may be required.
Proceed as following:

1. Place one finger on the screen “C: and hold it there while pushing the Green ON button.



2. When the screen turns light, remove your finger and the screen will display two lines, one vertical and one horizontal, intersecting at the top left corner. The text “Touch at the crossed lines to calibrate display.” should appear in various languages. In older machines, there will be no text.

3. Using a small pointing device that will not puncture or damage the screen (such as a pencil eraser), touch the screen where the two lines intersect. Do this with as much accuracy as possible.

4. When the screen is touched, the display will change to two lines intersecting at the lower right of the screen.

5. Repeat step 4 where these lines intersect.

NOTE: The implementation of step 3 and step 4 directly affects the validity of all the buttons in the entire program. It is very important to be accurate.

Press the language button of your choice.

Press the RESET button at the lower left corner of the screen. See figure 5.

3.4.3 - Installation of a new Touch Screen.

To program a new screen, they must follow these directions.

1. Install new screen and turn power on
2. When screen displays "Fatal Error Message" press continue
3. Enter Mechanic Security Code
4. After reading the "Warning Message" press continue again
5. Screen will begin to process the up-loading of existing program. This will take 60 - 90 seconds
6. After reading the "Last Warning Message" press continue again.
7. Screen will begin to process information again for 15 - 30 seconds
8. Reset routine will follow. Special note: Machine assemblies will reset or move to home positions
9. Screen will return to the Main Display and is ready to run.

3.4.4 - Standard Modules

1. - Program Module…4080-150

It stores the program information. It is also used to load program modifications or updates. For update procedures please refer to next chapter.

2. - Memory Module….4080-970

Stores the unique data required to operate this particular machine; such as serial number, original factory parameters, etc. This module should never be exchanged with another machine.

3. - Output Module…4080-140

They are responsible for transferring signals from the computer to the working elements such as valves, motors and relays, etc.

4. - Optical Output Module…4080-130

They are responsible for transferring signals from the computer to the electronic regulators to control air pressure.

5. - Input Module…4080-110

They are responsible for transferring signals from the machine to the computer such as switches, electric eyes, sensors, etc.

6. - Thermal Couple Module…4080-250

They are responsible for transferring heat measurements from the machine to the computer to control temperature on the cut and seal bars.

NOTE:

1. Even though all output and/or input modules within the machine are identical, they cannot be moved to replace another module same on the serial bus cable, as the computer automatically assigns a working address for each one.
2. If a replacement is necessary, always replace with a new or loaner module from another machine.
3. Electrical Power to the machine must be turned "OFF" during replacements.
4. Computer will show an error if one or more modules are missing.

Procedure: Remove the old module and connect the new one, after turning on the power, the computer will reassign the address to this new module.

7. - Update a Machine using a New Program Module

NOTE: Very Important
Before starting the procedure below, go to Advanced Settings and write down all the settings shown in these screens.

1. Turn off power to the machine.
2. Replace the existing Program Module with the Program Module that contains the updated program.
3. With your finger on the screen, turn power on to the machine. When the screen changes from dark to light, remove your finger from the screen.
4. Carefully calibrate the screen. See screen calibration.

ATTENTION: Do not turn off the machine during this process for any reason, as vital information will be corrupted and it will be necessary to the call manufacturer for assistance and/or return the touch screen and module for base programming.

5. Press the "Update Controller" button. Input mechanic security code (33333). This process takes up to 5 minutes and asks you to press the "Continue" button once during this time.
When complete the Controller will contain the updated program.

NOTE: Continue to item 6 only if you need to reprogram original module.

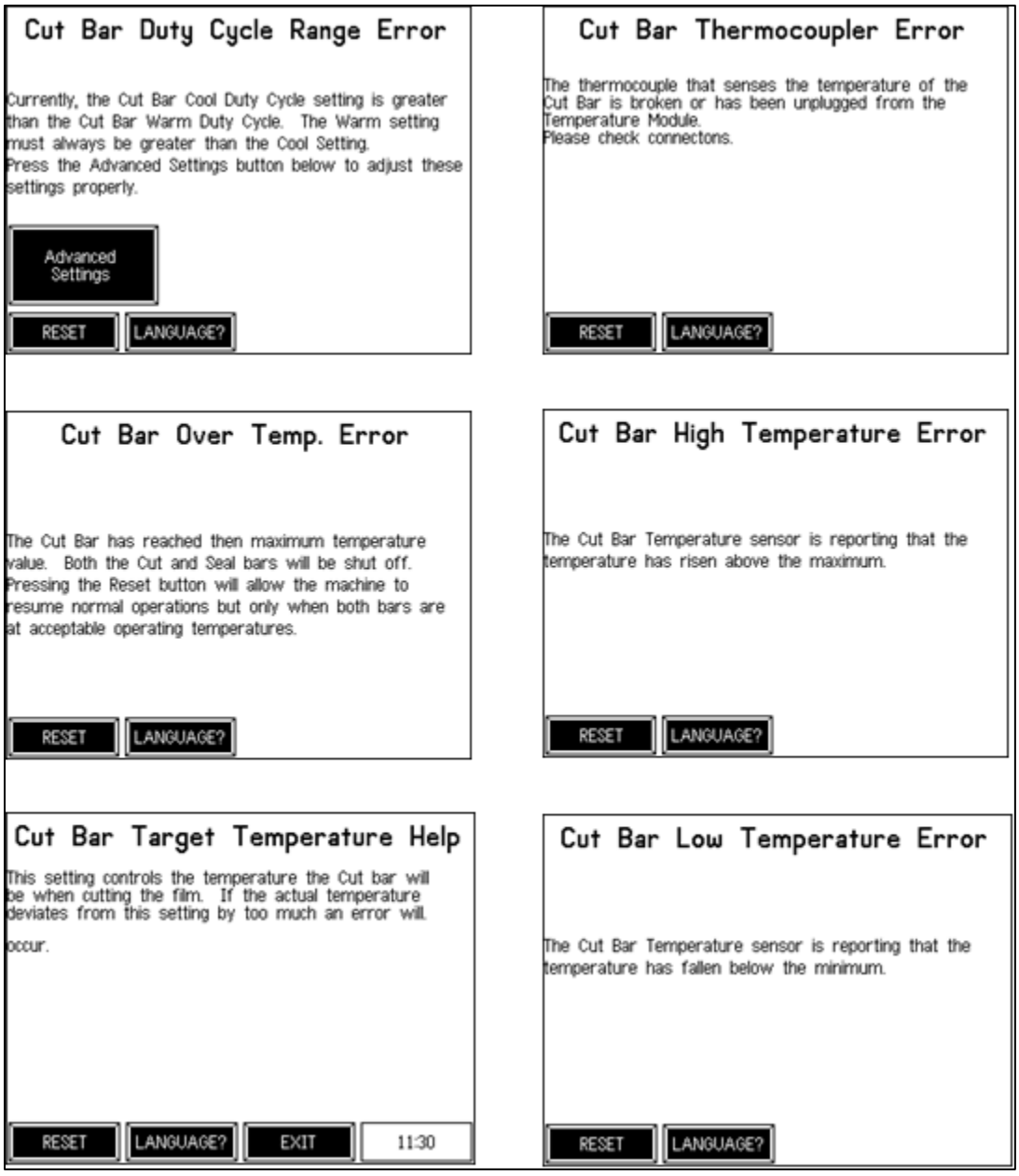
6. Turn off power to the machine.
7. Replace the Program Module that you installed in step #2 with the original Program Module that came with the machine.
8. With your finger on the screen, turn power on to the machine. When the screen changes from dark to light, remove your finger from the screen.
9. Carefully calibrate the screen.
10. Press the "Update Program Mod" button. Input technician security code (xxxxx). This process takes up to 5 minutes. When complete the original Program Module that came with the machine and the Controller will contain the updated program.

Now that the process is complete, go to Advanced Settings and verify them using the settings you wrote down at the beginning of the process. Make any necessary corrections.

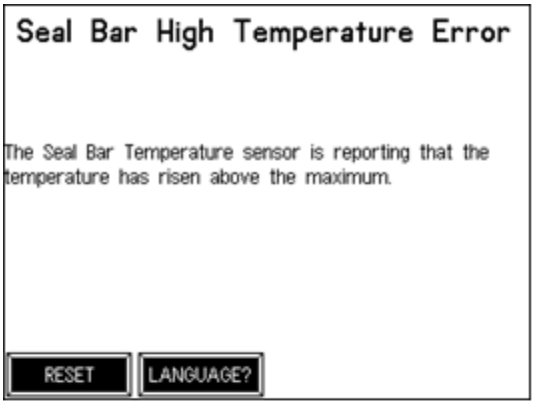
3.5. - Troubleshooting

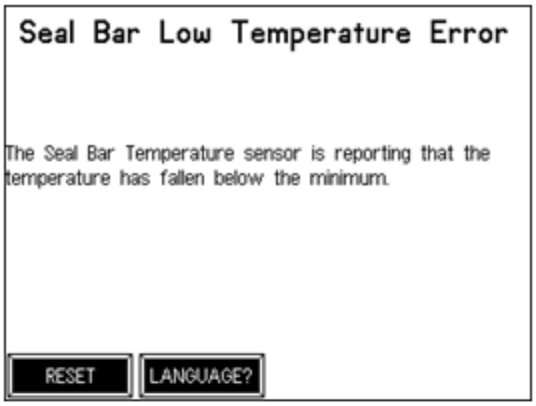
3.5.1. - Error Messages

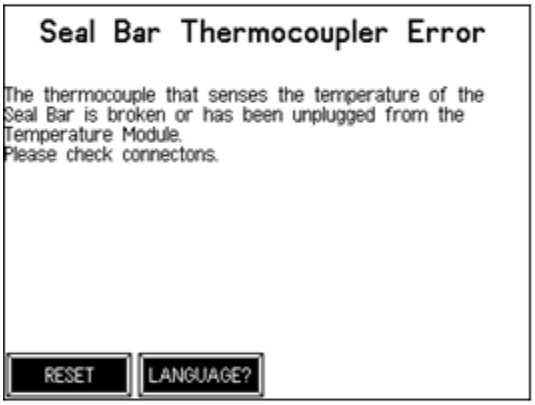
Cut Bar

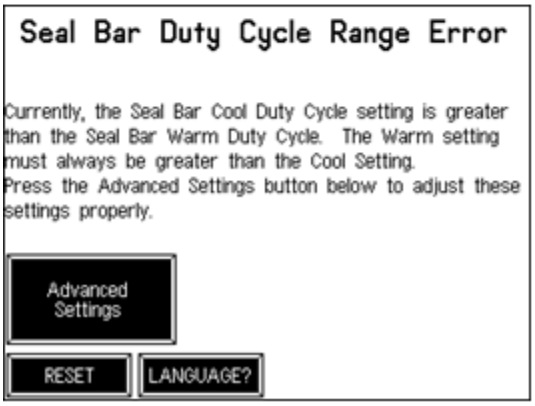


Seal Bar

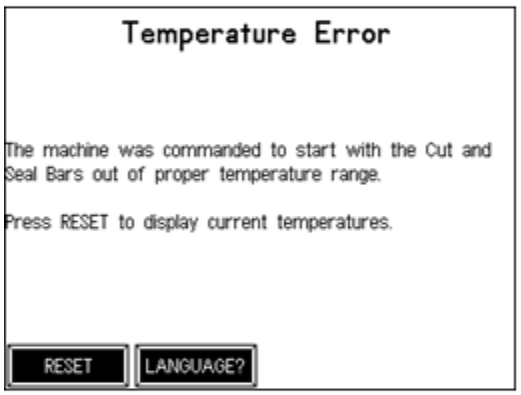


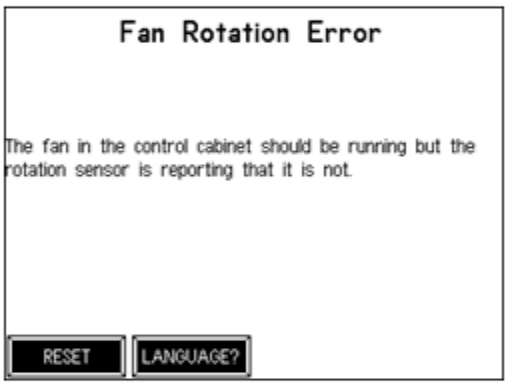






Others





Assembly Drawings & Parts Lists

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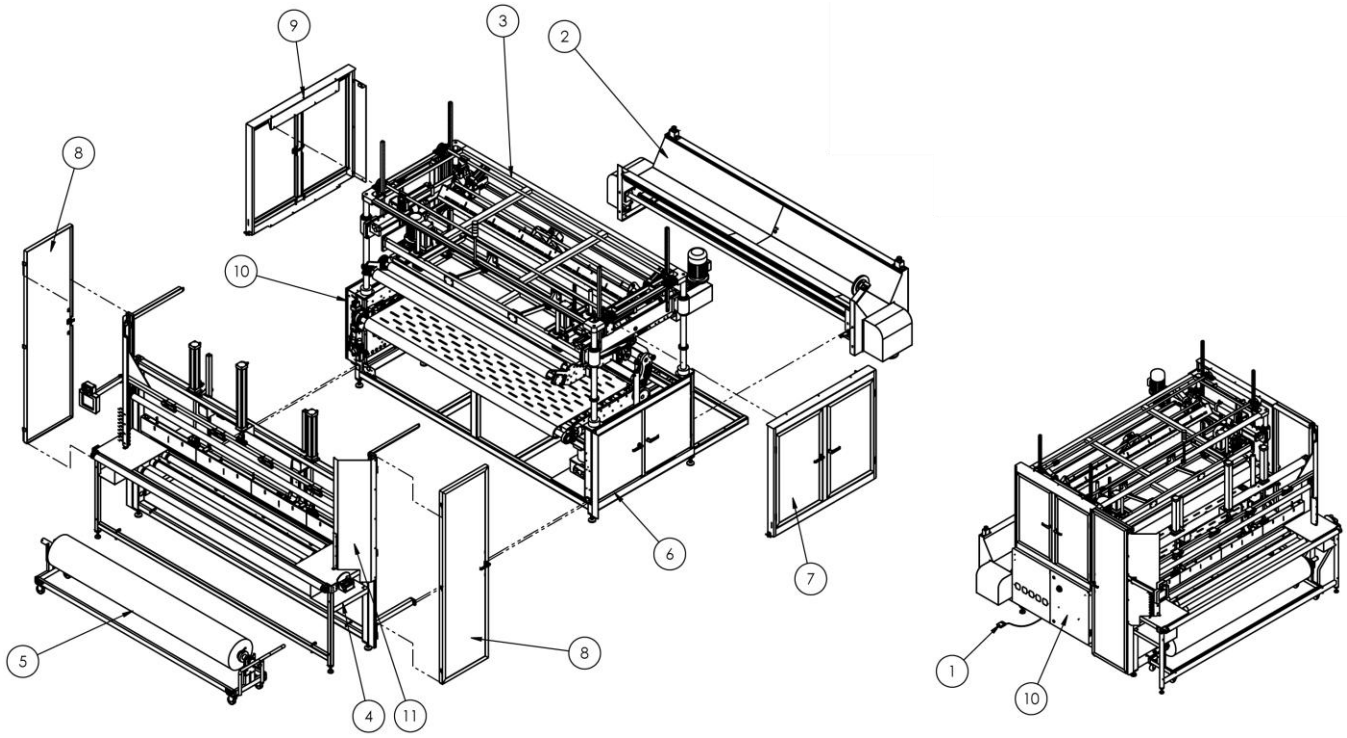
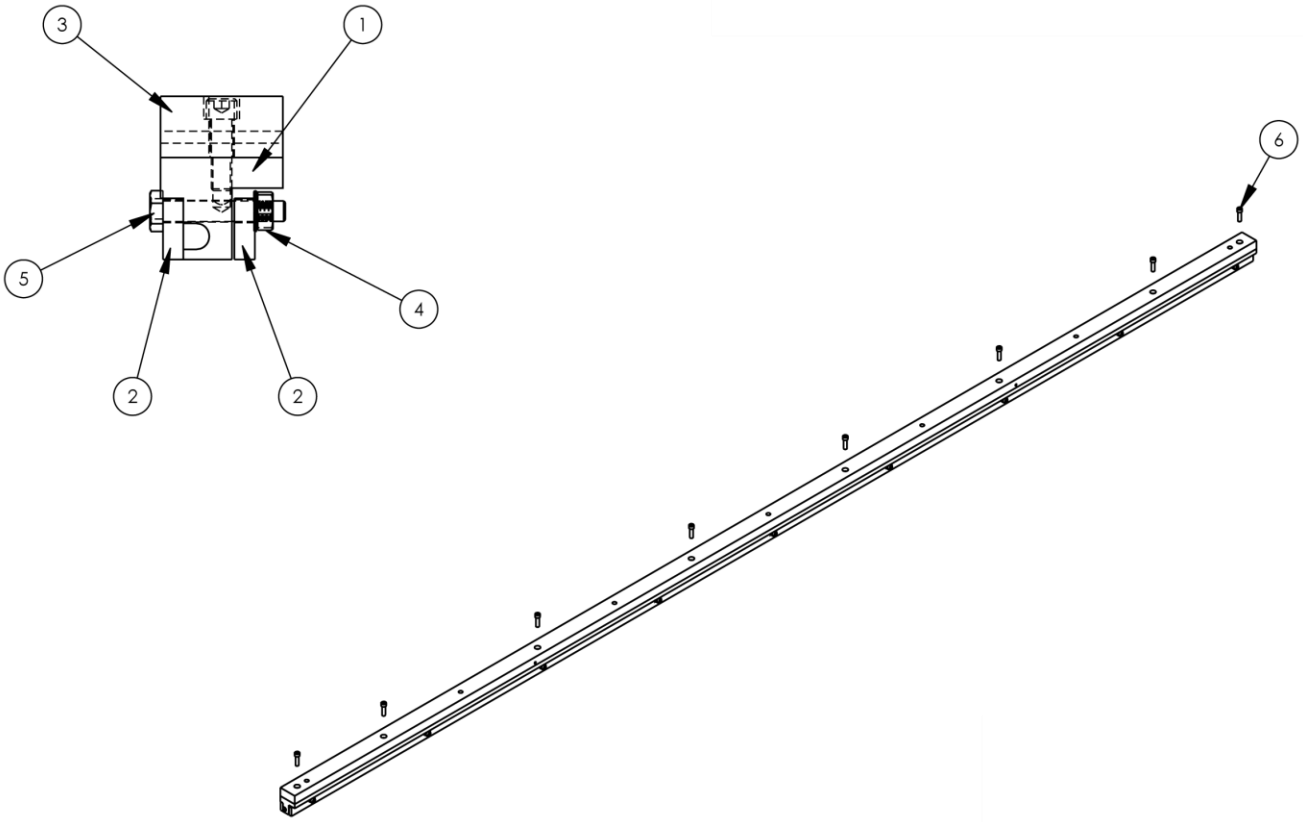


11306A Roll Pack, Height Sens

AAC Drawing Number 9004343 Rev0

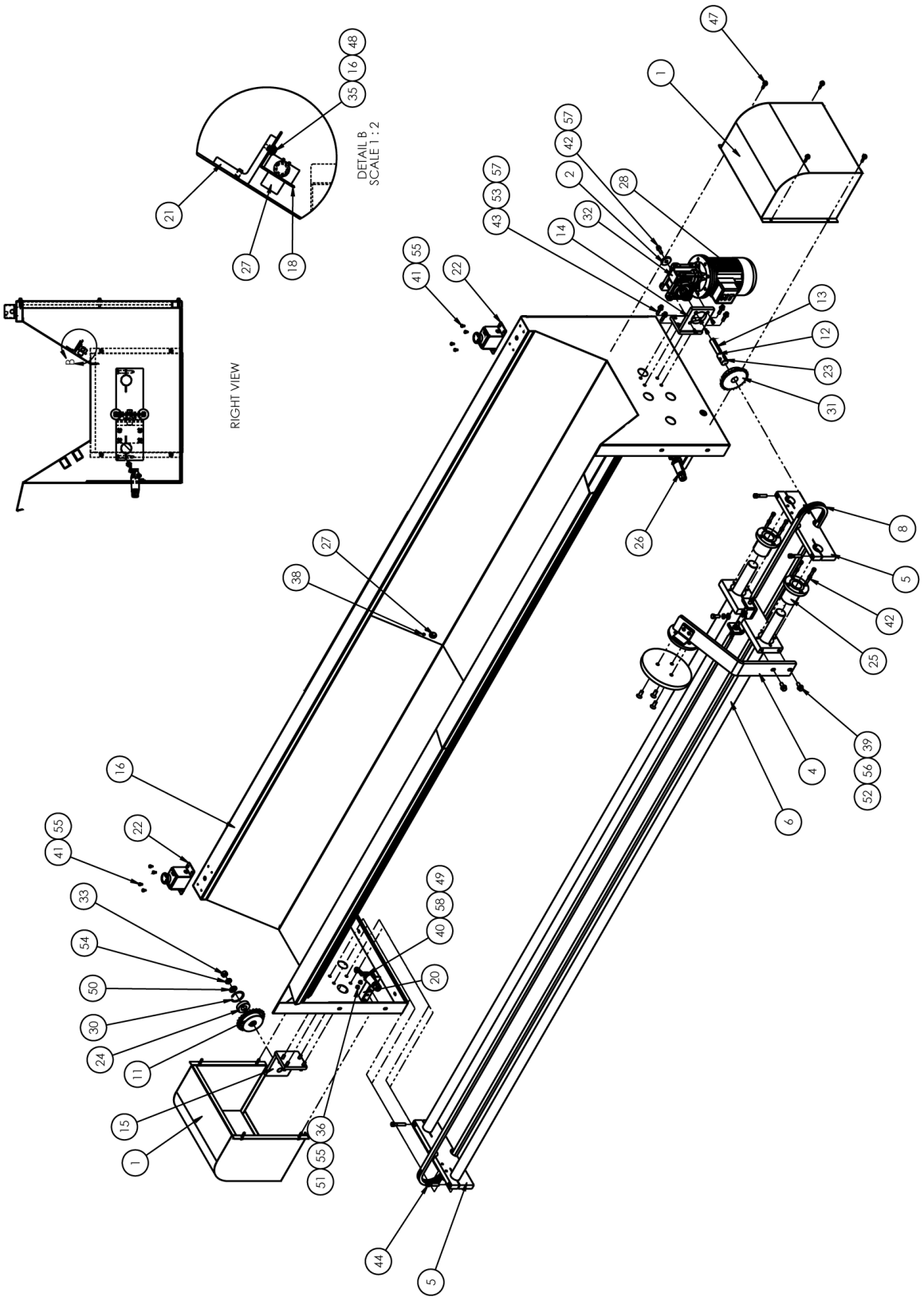
NO.	QTY	PART #	DESCRIPTION	
1	1	0411-1903	FOOT SWITCH CABLE ASSY	
2	1	1306016	OFFLOAD UNIT ASSY	Page 58
3	1	1306079	TOP COMPRESION ASSEMBLY	Page 62
4	1	1306096	LOAD TABLE ASSY	Page 64
5	1	1306141	CART,PLASTIC ROLLS	Page 69
6	1	1306377	LOWER COVEYOR ASSEMBLY	Page 86
7	1	1306437	GUARD,RIGHT,UPPER	Page 93
8	2	1306461	GUARD,DOOR,FRONT,LEFT	Page 94
9	1	1306462	GUARD, LEFT,UPPER	Page 95
10	1	1306500	CONTROL BOX ASSEMBLY	Page 98
11	1	1306638	KIT,HEIGHT SENSING	Page 80
12	*16'	AATPWL1	LOOM,WIRE,1"	
13	*32'	AATPWL5/8	LOOM,WIRE,1 5/8"	



1306007 Cutter Assembly, coated

AAC Drawing Number 1306007 Rev1

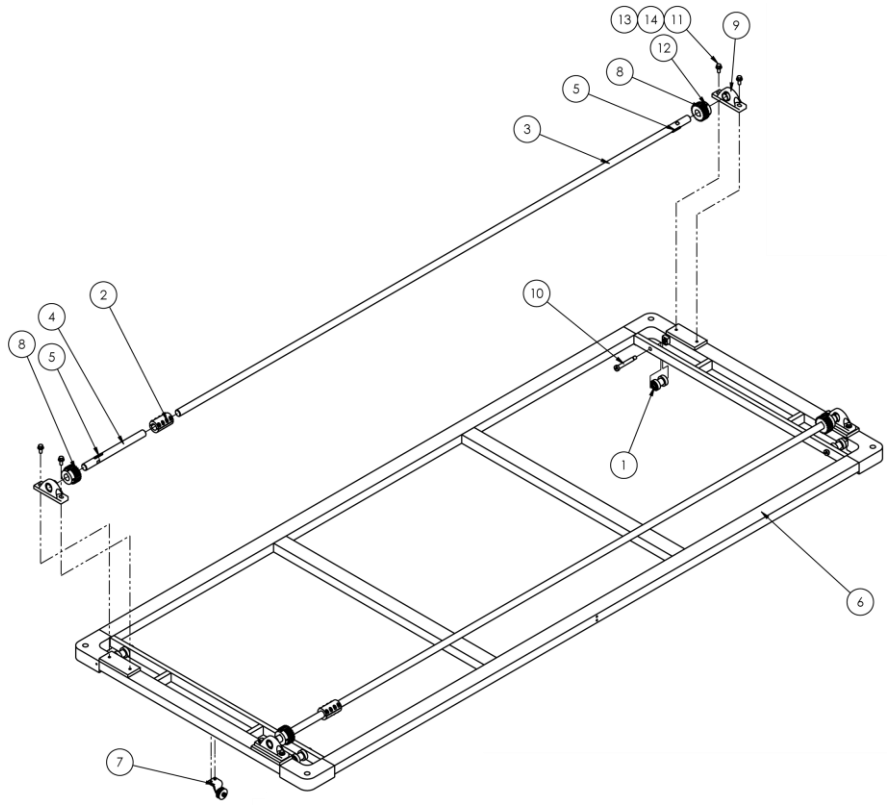
NO.	QTY	PART #	DESCRIPTION
1	1	1390190	BAR, SEAL, LOWER
2	2	1390436	SPACER, SEAL BAR 100"
3	1	1390977	BAR, SEAL, UPPER
4	9	NNK1/4-20	NUT,HEX,KEP,1/4-20,W/LOCK
5	9	SSHC01096	1/4-20 X 1-1/2 HHCS
6	8	SSSC05056SS	1/4-28 X 7/8



1306016 Offload Unit Assembly

AAC Drawing Number 1306016 Rev2

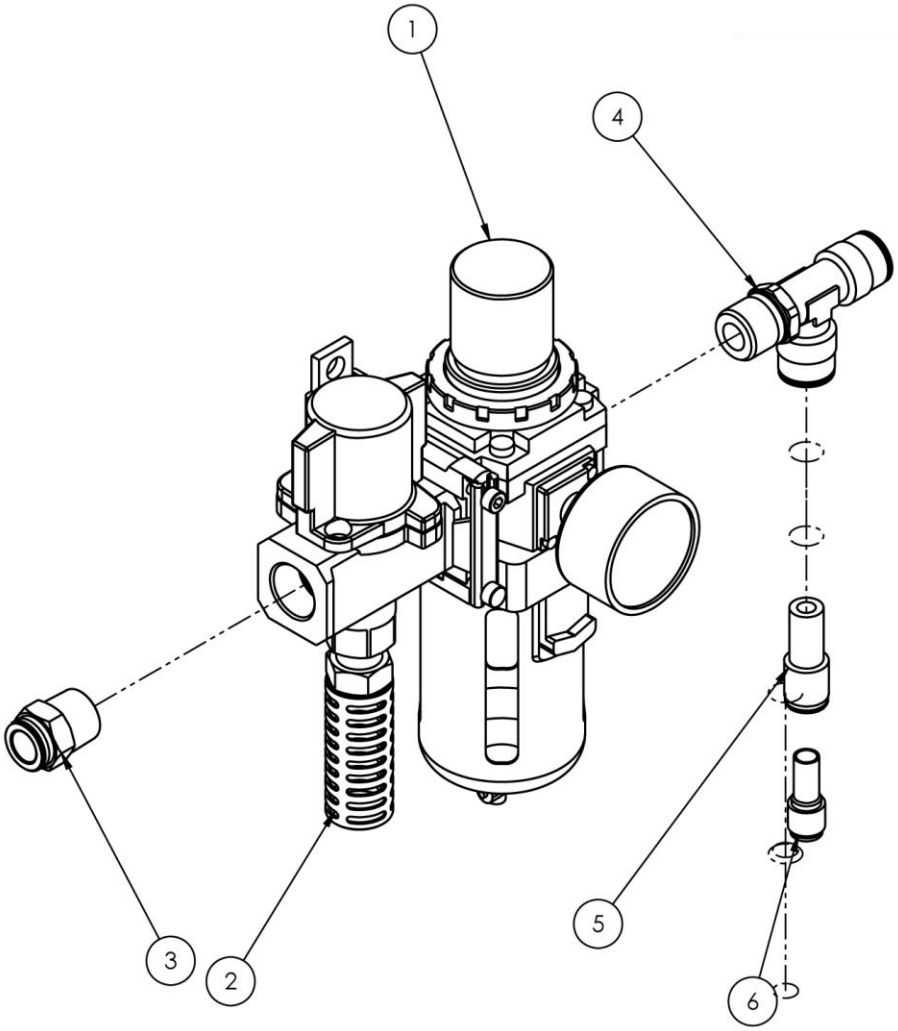
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	1306003	COVER,DRIVE SYSTEM	30	1	MM98409A244	E-RING, INT, 1-7/8 X .068
2	1	1306005	RETAINER,SHAFT,GEARBOX	31	1	MMH4026X1	SPROCKET,#40,26HT,1"B
3	1	1306012	PAD,EJECTOR	32	1	MMRV4025D71	GEARBOX,WORM,RV40,25:1
4	1	1306013	EJECTOR WELDMENT	33	1	NNH1/2-13	NUT,HEX,1/2-13
5	2	1306017	RETAINER,GUIDE BAR	34	4	NNH3/8-16	NUT,HEX,3/8-16
6	2	1306019	GUIDE,RAIL,OFFLOAD	35	2	SSBC90016	8-32 X 1/4 BUTTON CAP
7	1	1306020	MOUNT,EJECTOR ARM	36	4	SSBC98024	10-32 X 3/8 BUTTON CAP SC
8	1	1306024	DRIVE CHAIN, EJECTOR	37	3	SSFC25064	3/8-16 X 1 FLAT CAP
9	1	1306025	MOUNT,DRIVE CHAIN	38	2	SSFC90024	8-32 X 3/8 FL ALN CAP
10	2	1306026	THREADED,ROD,3/8-16X2.5	39	3	SSHC25064	3/8-16X1,HEX CAP
11	1	1306027	SPROCKET,#40,26HT,BEARING	40	4	SSPS90080	#8-32 X 1-1/4 PAN HD
12	1	1306028	SHAFT,EJECTOR,RV40GB	41	8	SSPS98024	10-32X3/8 PAN HD SLOT
13	1	1306029	KEY STOCK,6MMSQ,3IN	42	9	SSSC10064	5/16-18X1 SOCKET CAP
14	1	1306035	MOUNT, WELDMENT, RV40	43	8	SSSC10080	5/16-18 X 1-1/4 SOC CAP
15	1	1306036	MOUNT,DRIVE SYS	44	3	SSSC25112	3/8-16X1-3/4 SOC CAP
16	1	1306041	WELDMENT,OFFLOAD	45	1	SSSC25128	3/8-16X2" SOC CAP
17	2	1306048	PANEL,ACCESS,OFFLOAD	46	4	SSSCM6X12	M6X12 SOC CAP SCREW
18	1	1306183	BRKT, MTG, FFS18S/E	47	24	SSZS01080	SCREW,SHT MTL,W/WASHER
19	1	1306193	MOUNT,LIMIT,FFEVN200A,R	48	2	WWF8	WASHER, FLAT, #8
20	1	1306194	MOUNT,LIMIT,FFEVN200A,L	49	4	WWFM4.3	WASHER, FLAT, M4
21	1	1306196	MOUNT,SENSOR BRACKET	50	1	WWFS1/2	WASHER,FLAT,SAE,1/2
22	2	1393082	BOX, ESTOP	51	4	WWFS10	WASHER, FLAT, #10, SAE
23	1	13453507	KEY,1/4X1/4X7/8L, TOOL ST	52	5	WWFS3/8	WASHER,FLAT,SAE,3/8
24	1	BB1L017	BEARING,BALL,.787B	53	8	WWFS5/16	WASHER,FLAT,SAE,5/16
25	2	BBULHFR150	BEARING,LINEAR,1.5 B	54	1	WWL1/2	1/2 LOCK WASHER
26	2	FFEVN2000A	LIMIT SWITCH ASSEMBLY	55	12	WWL10	WASHER,LOCK,#10,S/S
27	1	FFT18FF100Q	EYE,FIXED FIELD, 4IN	56	3	WWL3/8	WASHER, LOCK, 3/8
28	1	MM71B4B5	MOTOR,.37KW,IEC,B5	57	9	WWL5/16	WASHER, LOCK, 5/16
29	1	MM9600K21	GROMMET,RUBBER,9/16 ID	58	6	WWL8	WASHER,LOCK,#8



1306077 Top Support Frame

AAC Drawing Number 1306077 Rev2

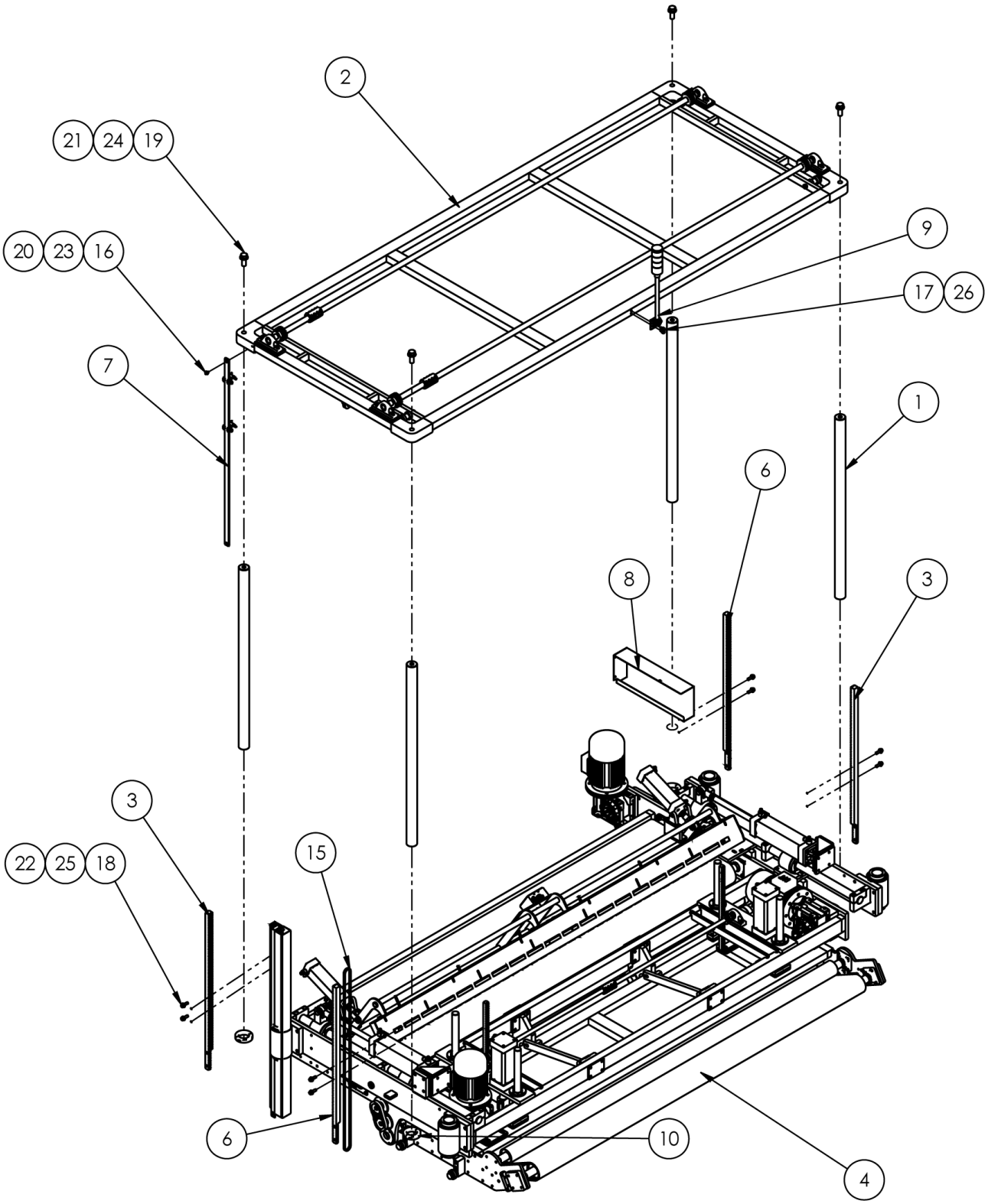
NO.	QTY	PART #	DESCRIPTION
1	4	1306081	ROLLER, GUIDE, RACK
2	2	1306082	COUPLING,2-PIECE,1" BORE
3	2	1306083	SHAFT, TRANSFER, LONG
4	2	1306084	SHAFT, TRANSFER, SHORT
5	4	1306086	KEY,1/4 X 1/4 X 1.61L
6	1	1306426	FRAME, SUPPORT, UPPER
7	1	1306600	PULLEY,IDLER,ASSEMBLY
8	4	MMNSS10F24-1M	GEAR,SPUR,10P,1 B W/KEY
9	4	MMVPLS-116	BEARING,PILLOW BLOCK 1.0B
10	4	SSAS032192	SHOULDER BOLT 1/2 X 3.0
11	8	SSHC25064	3/8-16X1,HEX CAP
12	4	SSSS01032	1/4-20 X 3/8 NYLON PT
13	8	WWFS3/8	WASHER,FLAT,SAE,3/8
14	8	WWL3/8	WASHER, LOCK, 3/8



1306327 Main Regulator Assembly

AAC Drawing Number 1306327 Rev0

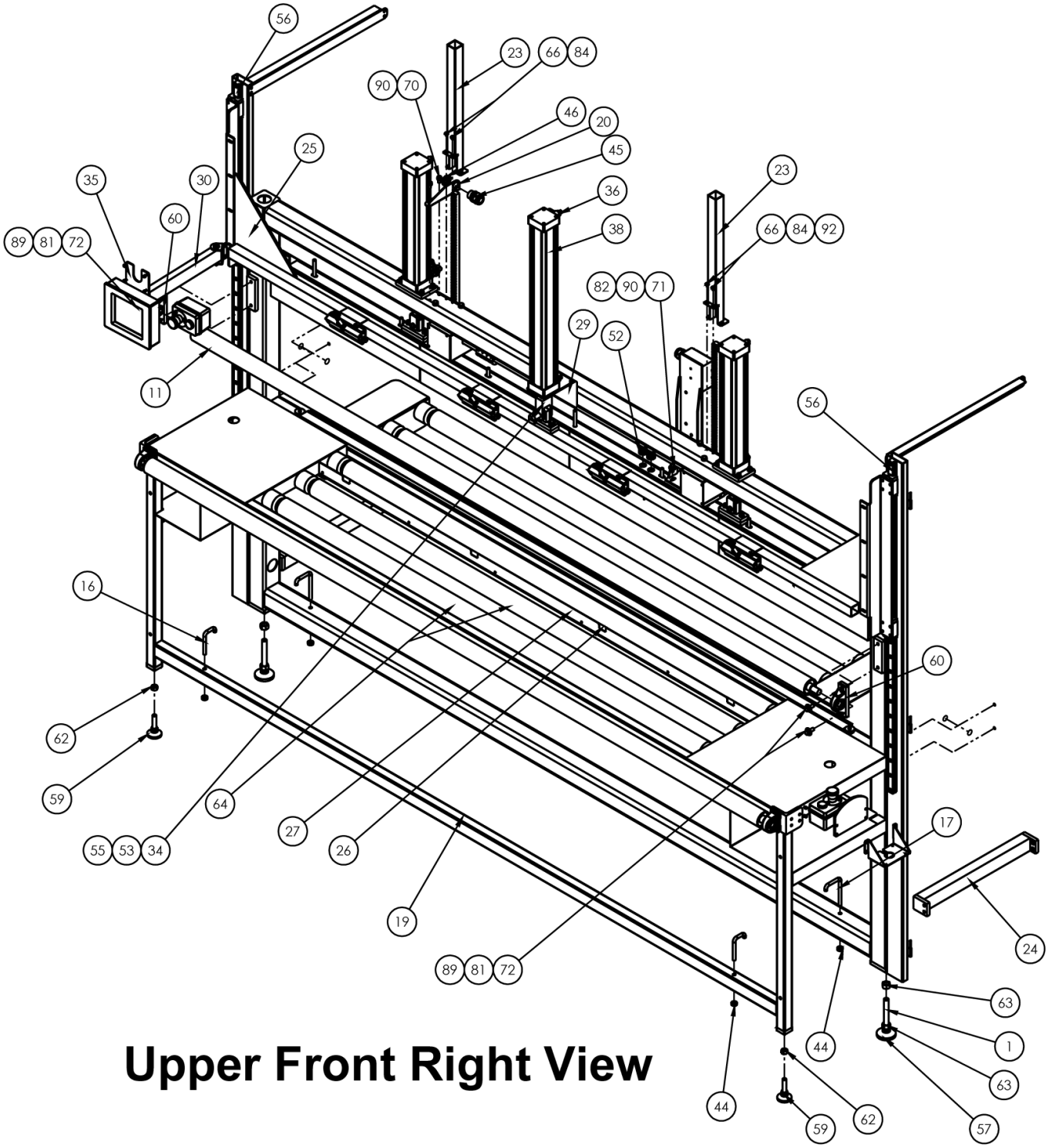
NO.	QTY	PART #	DESCRIPTION
1	1	AA198-AW40	REGULATOR ASSY,W/LOCKOUT
2	1	AAFAN300-N03	MUFFLER,3/8NPT,PLASTIC
3	1	AAQMC-2-2S	FITTING,STRT,1/2NPT,1/2
4	1	AAQMT-2-2S	TEE,1/2NPT-1/2 TUBE
5	1	AAQPR-2-3	QUICK PLUG REDUCER
6	1	AAQPR-3-4	QUICK REDUCER 3/8-1/4



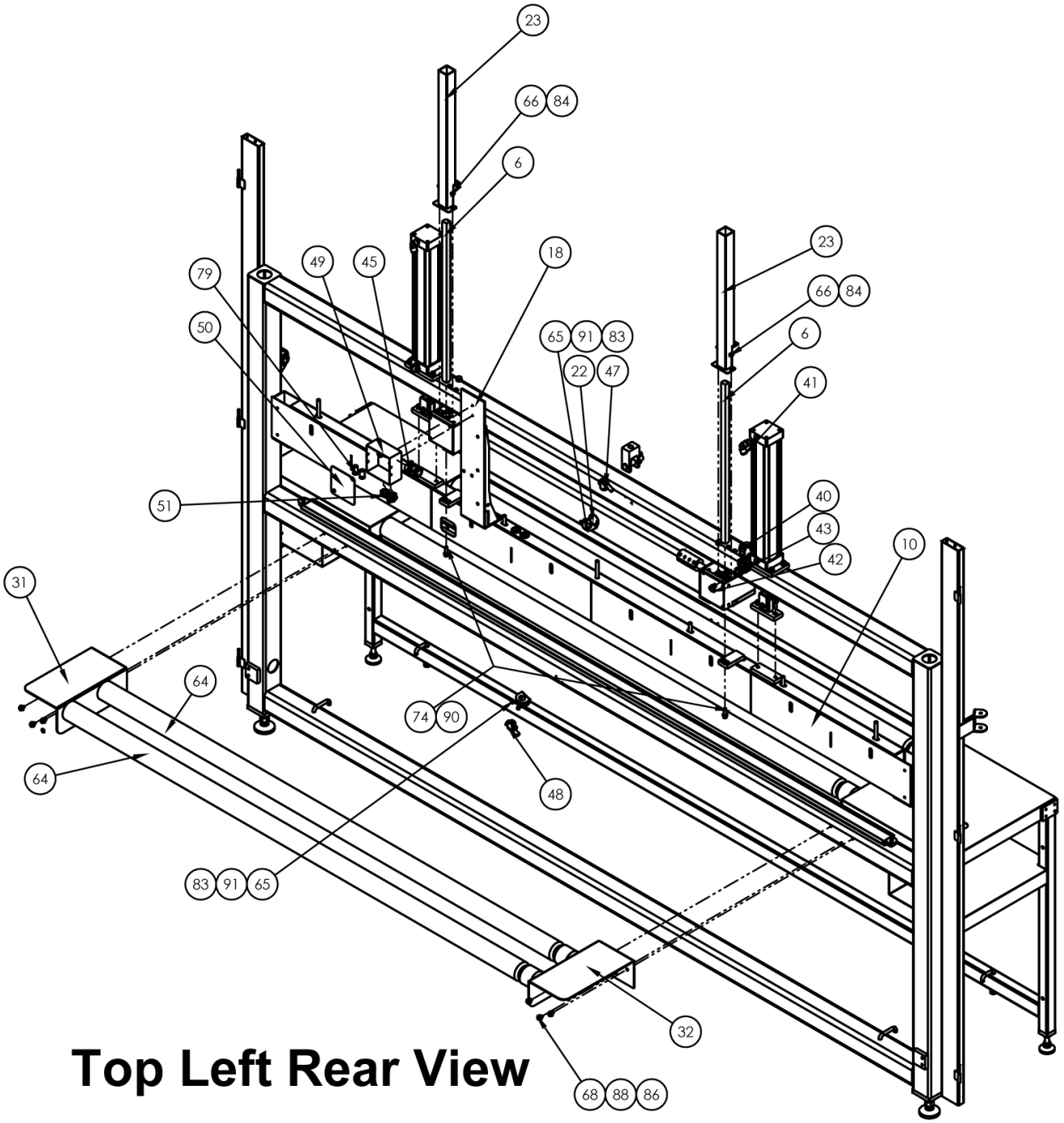
1306079 Top Compression Assembly

AAC Drawing Number 1306079 Rev2

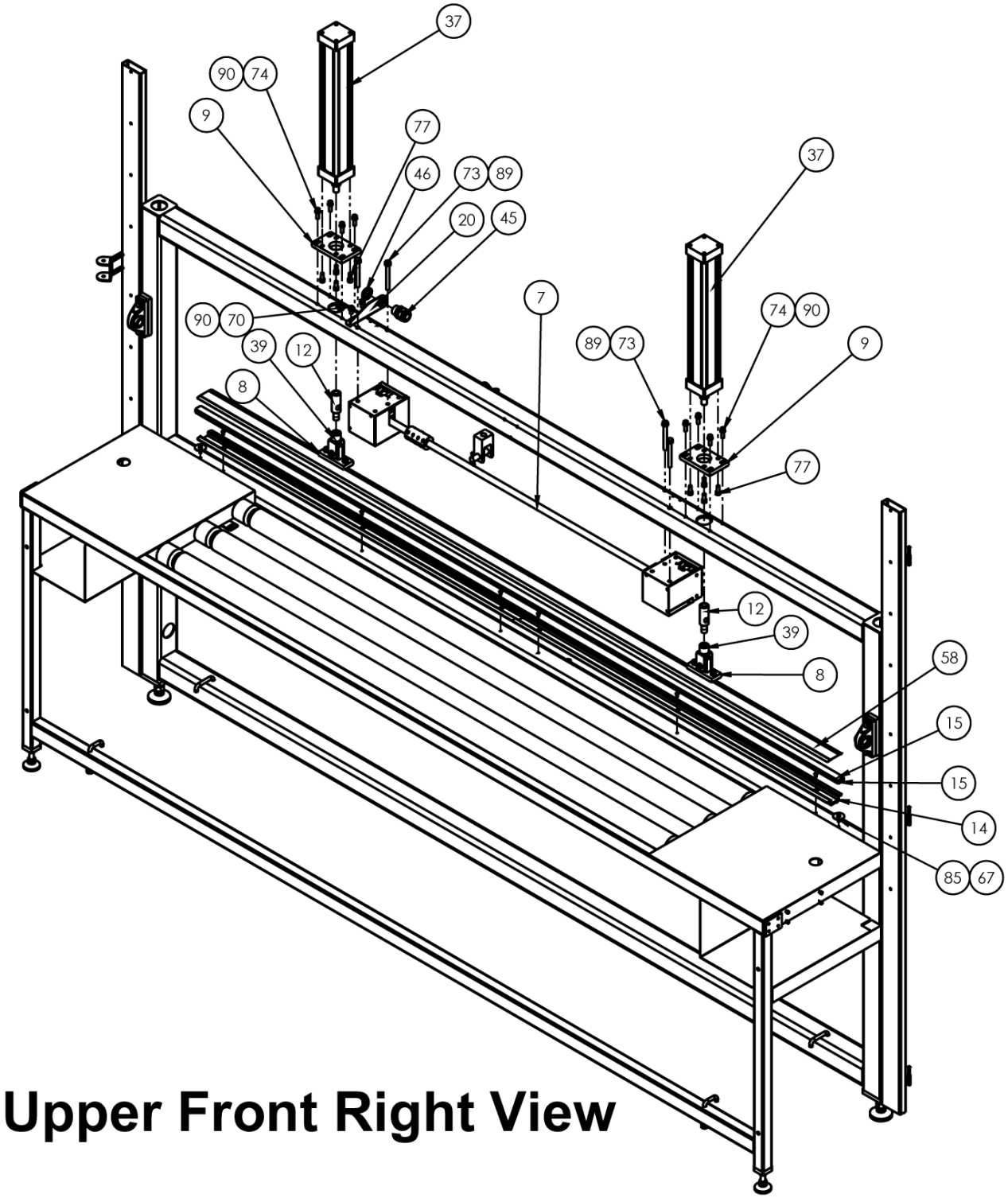
NO.	QTY	PART #	DESCRIPTION	
1	4	1306070	RAIL, LINEAR, ROUND,2"	
2	1	1306077	TOP SUPPORT FRAME	Page 59
3	2	1306080	GEAR RACK, 10DP, 1" FACE	
4	1	1306280	PRESSING CONVEYOR ASBLY	Page 76
5	1	1306290	MOUNT,WIRE HARNESS	
6	2	1306336	GEAR RACK,10DP,1" FACE	
7	1	1306430	BRACKET, SENSOR ASSM	Page 89
8	1	1306442	GUARD,DRIVE,REAR	
9	AR	1306615	LIGHT ASSEMBLY	
10	4	CCCL32	COLLAR, SPLIT.2" ID	
11	*42"	EEDC1LG	DUCT,WIRE COVER,1"	
12	*42"	EEDC2X2	COVER,WIRE DUCT	
13	*42"	EEDF1X1	DUCT,WIRE,1X1	
14	*42"	EEDF2X2	DUCT,WIRE,2X2, MOD	
15	1	GG850XL037	BELT,GEAR,1/5P,3/8W,425T	
16	1	SSHC01032	1/4-20 X 1/2 HHCS	
17	2	SSHC10032	5/16-18 X 1/2 HHCS	
18	8	SSHC25080	3/8-16 X 1-1/4 HEX CAP	
19	4	SSHC34128	3/4-10 X 2 HEX CAP	
20	1	WWFS1/4	WASHER,FLAT,SAE,1/4	
21	4	WWFS3/4	WASHER, .797ID X 1-1/2OD	
22	8	WWFS3/8	WASHER,FLAT,SAE,3/8	
23	1	WWL1/4	WASHER,LOCK,1/4	
24	4	WWL3/4	3/4 LOCK WASHER	
25	8	WWL3/8	WASHER, LOCK, 3/8	
26	2	WWL5/16	WASHER, LOCK, 5/16	



Upper Front Right View



Top Left Rear View



Upper Front Right View

1306096 Load Table Assembly

AAC Drawing Number 1306096 Rev 6

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	0411-1063	ROD, THREADED, 5/8-11 X 5	47	1	FFQS18VN6RQ8	SENSOR,LASER RECEIVER,NPN
2	1	0411-3708	NUT PLATE,BOX MOUNT	48	1	FFQS186LEQ8	SENSOR,LASER EMITTER
3	1	0411-3709	LOCK PIN	49	1	K-233	BOX,ELECTRICAL,SQUARE
4	2	1278-6010F	START/E-STOP ASSY, W/22' CABLE	50	1	K-234	COVER,4IN SQUARE
5	1	4080-003	CONTROLLER,SBUS,V3	51	2	K-235	CONNECTOR,ROMEX,1/2"
6	2	1306099	RACK GEAR 12P 14.5PA 24"L	52	2	MM9307K63	GROMMET,1/2ID,13/16 HOLE
7	1	1306102	3/4 BALANCING ASSY	53	1	MM97245A555C	CLEVIS PIN 2.75L, 2.5156 UL, .5 D
8	2	1306113	CROSS SEAL CYL. MNT	54	1	MM98335A04	SPRING CLIP, .06 WIRE
9	2	1306114	CYLINDER MOUNT PLATE	55	1	MM98338A225	COTTER PIN, 1/8 X 2 1/2
10	1	1306117	CUTTING BAR ASSEMBLY	56	2	MMAGR251340N	RAIL,LINEAR, AG 1340MM
11	1	1306134	ROLLER ASSY, LOADING TBL	57	2	MML-2	LEVELING PAD, 5/8-11
12	2	1306135	CYLINDER EXTENSION	58	1	MMSG1306	TAPE,TEFLON,3.4WX54FT
13	1	1306143	BRACKET, BUTTON BOX	59	2	MMTL-2	LEVELING PAD,1/2-13
14	2	1306153	CUT BAR SEAT	60	2	MMVPS-112	BEARING,PILLOW BLOCK 3/4B
15	2	1306154	FOAM ORANGE	61	1	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
16	2	1306160	CART RETAINER	62	2	NNH1/2-13	NUT,HEX,1/2-13
17	2	1306162	CART RETAINER, REAR	63	4	NNH5/8-11	NUT,HEX,5/8-11
18	1	1306166	BRACKET, J-BOX WELDMENT	64	5	RM44084SG	ROLLER,2.5"DIA,80.5 LEN
19	1	1306167	CUTBAR WELDMENT	65	4	SSBC90024	8-32X3/8 BUTTON CAP
20	1	1306168	BRACKET,HEATER WIRE	66	14	SSBC98024	10-32 X 3/8 BUTTON CAP SC
21	1	1306182	GUARD,PUSH BUTTON	67	2	SSBC98048	10-32 X 3/4 BUTTON CAP SC
22	2	1306183	BRKT, MTG, FFS18S/E	68	6	SSHC01032	1/4-20 X 1/2 HHCS
23	2	1306186	LOADING TABLE RACK GAURD	69	1	SSHC01192	HEX HEAD BOLTS, 1/4-20 X
24	2	1306190	TABLE CONNECTOR	70	2	SSHC10032	5/16-18 X 1/2 HHCS
25	1	1306583	CLAMP ASSEMBLY	71	2	SSHC20048	5/16-24 X 3/4 HEX CAP
26	1	1306587	CROSS BAR,FINGER MOUNT	72	4	SSHC25064	3/8-16X1,HEX CAP
27	1	1306589	PLATE,FINGER,CLAMP	73	4	SSHC25224	3/8-16 X 3.5 HEX CAP
28	1	1306590	ROLLER,TABLE,FRONT ASSY	74	14	SSSC10064	5/16-18X1 SOCKET CAP
29	1	1306592	MOUNT,CYLINDER,CLAMP	75	4	SSSC80024	6-32 X 3/8 SOC CAP SC
30	1	1306595	TUBE,16 L,PIVOT ARM	76	8	SSSC90040	8-32 X 5/8 SOC CAP SC
31	1	1306604	SUPPORT,TABLE,ROLLER MNT	77	8	SSSCM8X20	M8X20 SOC CAP
32	1	1306605	SUPPORT,TABLE,ROLLER MNT	78	1	TTH32429	HANDLE,THRD,5/16-18X2.0
33	2	1306606	SPACER,TABLE MOUNT	79	2	TTMB70476	CONNECTOR,WIRE,EX LARGE
34	1	1306640	CLEVIS, M16X1.5	80	3	WWF1/4	WASHER, FLAT, 1/4", COM
35	1	4300104	MOUNT, TOUCH SC AND SW	81	4	WWF3/8	WASHER,FLAT,3/8 OR 10MM
36	2	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8	82	2	WWF5/16	WASHER,FLAT,5/16
37	2	AACSU63X400	CYLINDER, 63MMBX400MM	83	4	WWF8	WASHER, FLAT, #8
38	1	AACSU63X600	CYLINDER, 63MMBX600MM	84	8	WWF10	WASHER, FLAT, #10, COM
39	2	AAFSGM16X1.5	CLEVIS ROD M16X1.5	85	2	WWFE012	WASHER,FENDER,3/16
40	1	AAQMC-3-3S	FITTING,STRT,3/8NPT,3/8	86	6	WWFS1/4	WASHER,FLAT,SAE,1/4
41	3	AAQME-3-3	MALE ELBOW 3/8OD X 3/8NPT	87	4	WWFS6	WASHER, FLAT, #6
42	1	AAQME-5-8U	QUICK MALE ELBOW- UNIFIT	88	6	WWL1/4	WASHER,LOCK,1/4
43	1	AAV78861717	VALVE, BLOCKING, R3/8	89	8	WWL3/8	WASHER, LOCK, 3/8
44	4	CCSC6F3_8	COLLAR,SET 3/8	90	18	WWL5/16	WASHER, LOCK, 5/16
45	2	FF3234	STRAIN RELIEF,3/4NPT	91	8	WWL8	WASHER,LOCK,#8
46	2	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK	92	8	WWL10	WASHER,LOCK,#10

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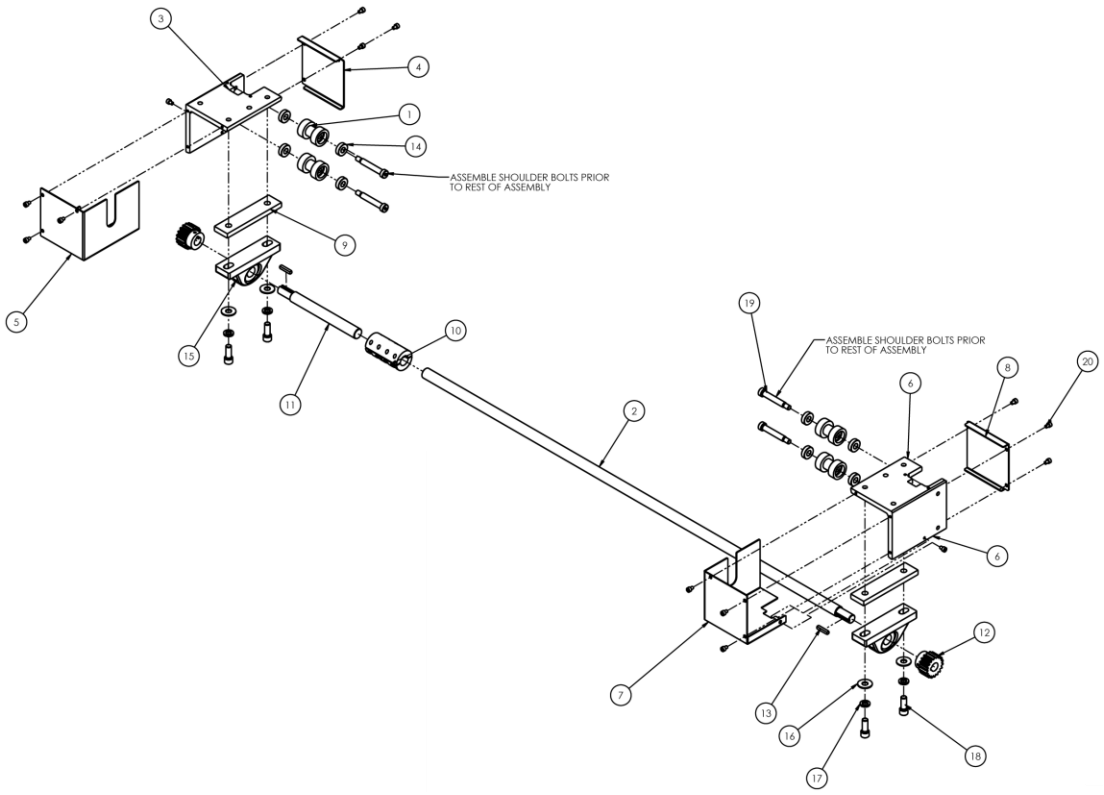
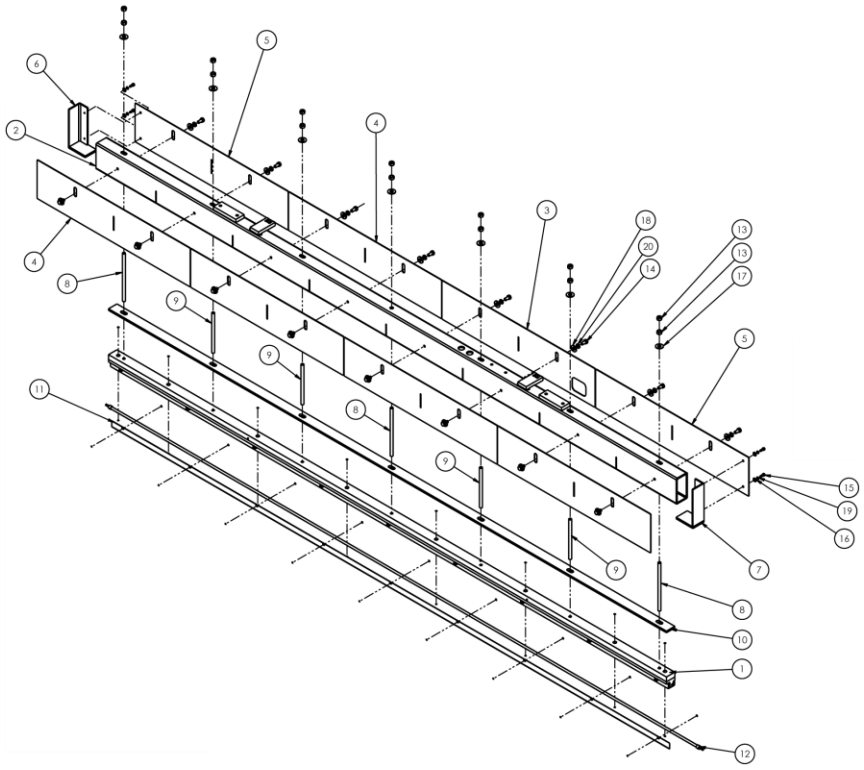


1306102 3/4 Balancing Assembly

AAC Drawing Number 1306102 Rev0

NO.	QTY	PART #	DESCRIPTION
1	4	1306098	HEATER RACK GUIDE
2	1	1306100	BALANCER CONNECTING ROD
3	1	1306103	FRONT BALANCER BRACKET
4	1	1306104	COVER PLATE GEAR BOX
5	1	1306105	GEAR BOX COVER
6	1	1306106	FRONT BALANCER BRACKET
7	1	1306107	GEAR BOX FRT COVER
8	1	1306108	GEAR BOX RR COVER
9	2	1306123	GEAR BOX SPACER
10	1	1306136	COUPLING, 2 PIECE, 3/4 IN
11	1	1306142	BALANCER CONNECTING ROD
12	2	1306302	SPUR GEAR 12P 18T 5/8B
13	2	1961-181	KEY, 3/16 X 1.00L
14	8	BB1L038	BEARING,BALL,.375B
15	2	MMVPS-112	BEARING,PILLOW BLOCK 3/4B
16	4	WWF3/8	WASHER,FLAT,3/8 OR 10MM
17	4	WWL3/8	WASHER, LOCK, 3/8
18	4	SSSC25088	3/8-16X1-3/8 SOC CAP
19	4	SSAS024128	SHULDER BOLT 3/8 X 2.0L
20	14	SSSC98016	10-32 X 1/4 SOC CAP



1306117 Cutting Bar Assembly

AAC Drawing Number 1306117 Rev1

NO.	QTY	PART #	DESCRIPTION
1	1	1306007	CUTTER ASSY,COATED
2	1	1306101	CUT BAR WELDMENT
3	1	1306120	SEAL CLAMP GUARD
4	5	1306121	GUARD, CUTTING BAR
5	2	1306122	GUARD, CUTTING BAR
6	1	1390130	END PLATE,RIGHT
7	1	1390131	END PLATE,LEFT
8	3	1390385	THREADED ROD, 7.5"
9	4	1390386	THREADED ROD, 6.25"
10	1	1390433	SPACER, PTFE
11	1	1391426	CUT BLADE 100", NO NOTCH
12	1	EERBN105A10A-2	HEAT ELEMENT,105L,.315D
13	14	NNH3/8-16	NUT,HEX,3/8-16
14	16	SSHC10040	5/16-18 X 5/8 HHCS
15	4	SSSC95032	10-24 X1/2, SOC CAP
16	4	WWF10	WASHER, FLAT, #10, COM
17	7	WWF3/8	WASHER,FLAT,3/8 OR 10MM
18	16	WWF5/16	WASHER,FLAT,5/16
19	4	WWL10	WASHER,LOCK,#10,S/S
20	16	WWL5/16	WASHER, LOCK, 5/16

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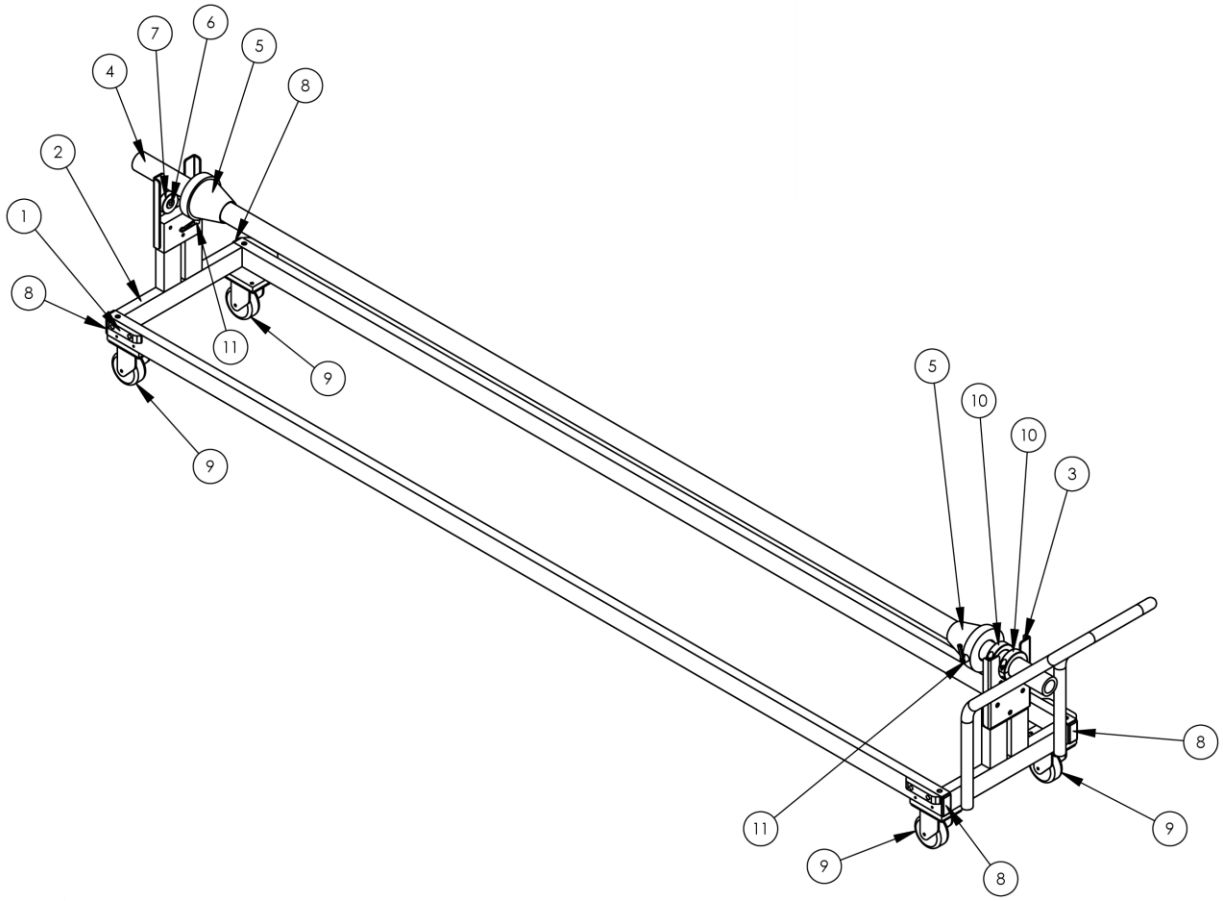
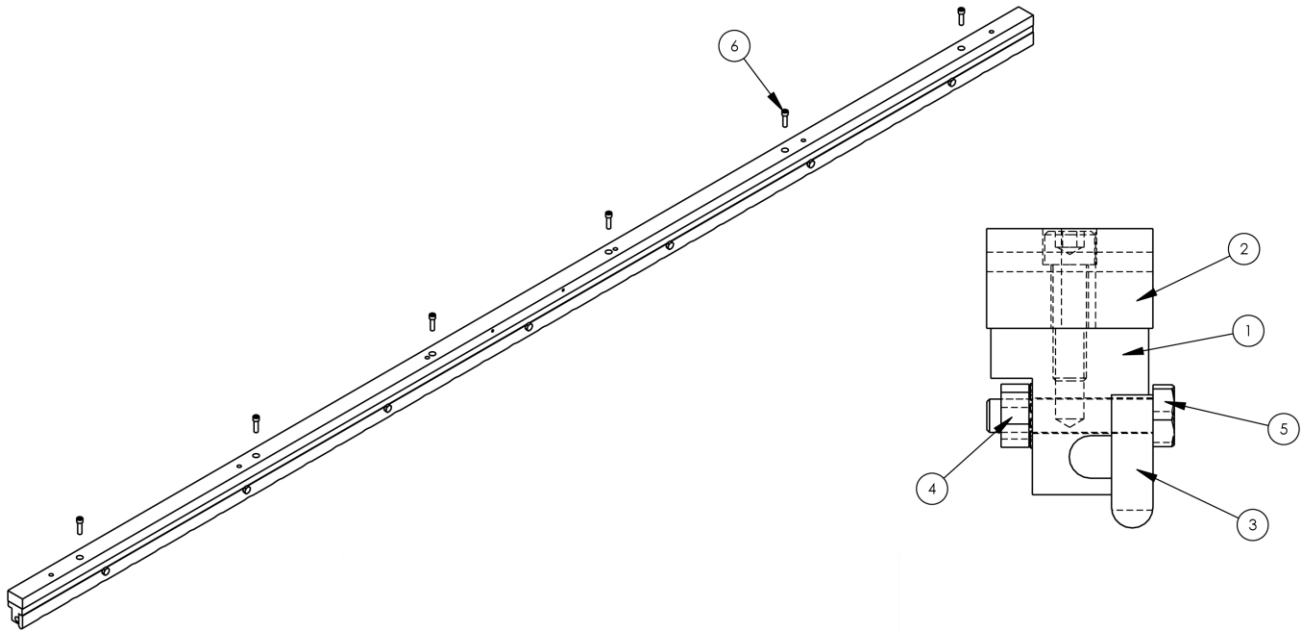


1306141 Plastic Rolls Cart

AAC Drawing Number 1306141 Rev0

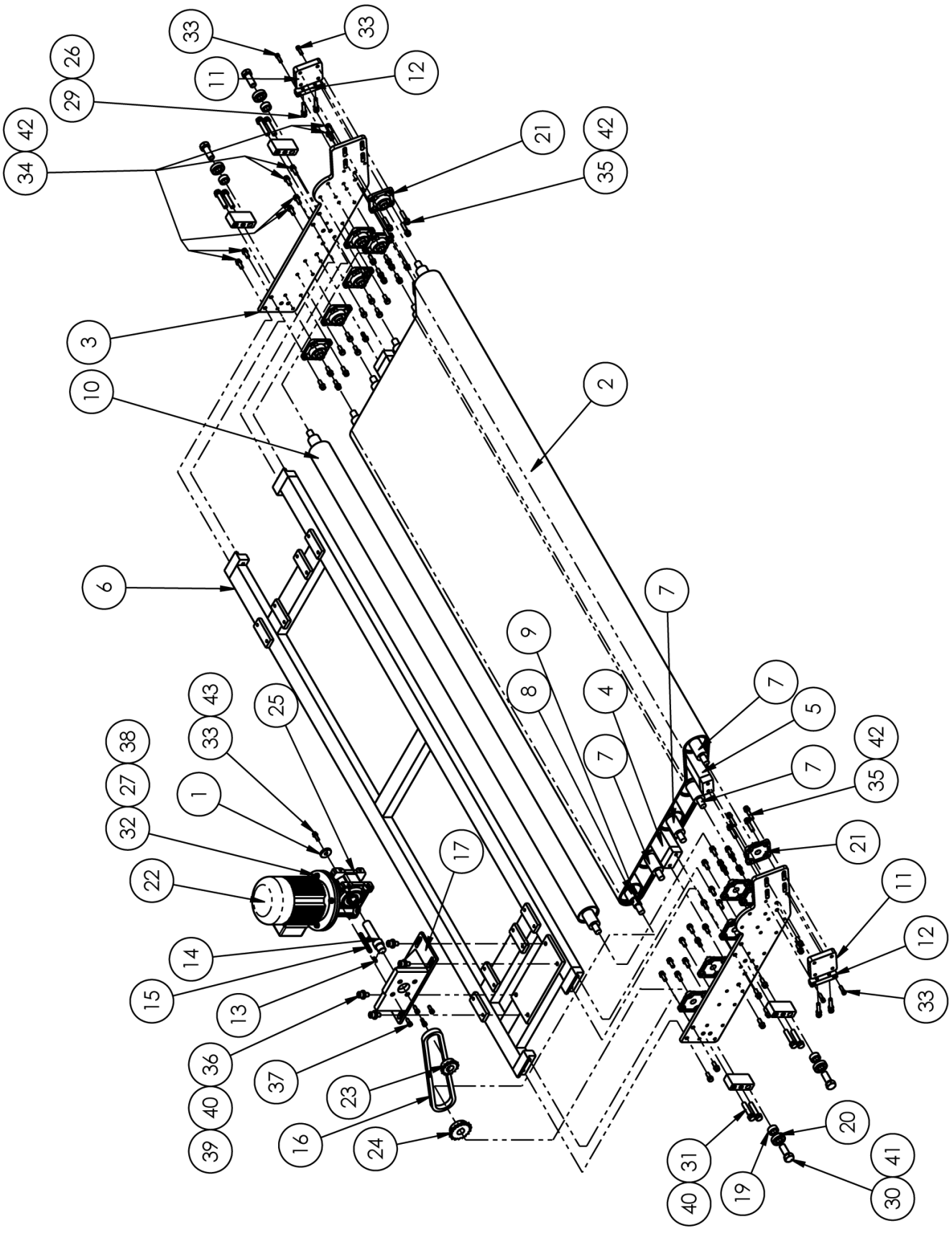
NO.	QTY	PART #	DESCRIPTION
1	4	1306129	BUMPER,CART
2	1	1306130	CART,FRAME,WELDMENT
3	2	1306137	BRACKET, ROLL HOLDER
4	1	1306140	BAR,ROLL HOLDER
5	2	1389928	CONE, 2 TO 3-1/4
6	4	1392476	BUSHING, BEARING MOUNT
7	4	BB1L017	BEARING,BALL,.787B
8	4	MM132-1496	PLUG 1 X 2
9	4	MM427-3RB	CASTER,SWIVEL,3"RUBBER
10	2	MM6436K25	COLLAR,SPLIT,1.75ID,2PC
11	2	TTH6324K63	HANDLE,THREADED,M8 X 20MM



1306203 Seal Bar Assembly 84in.

AAC Drawing Number 1306203 Rev1

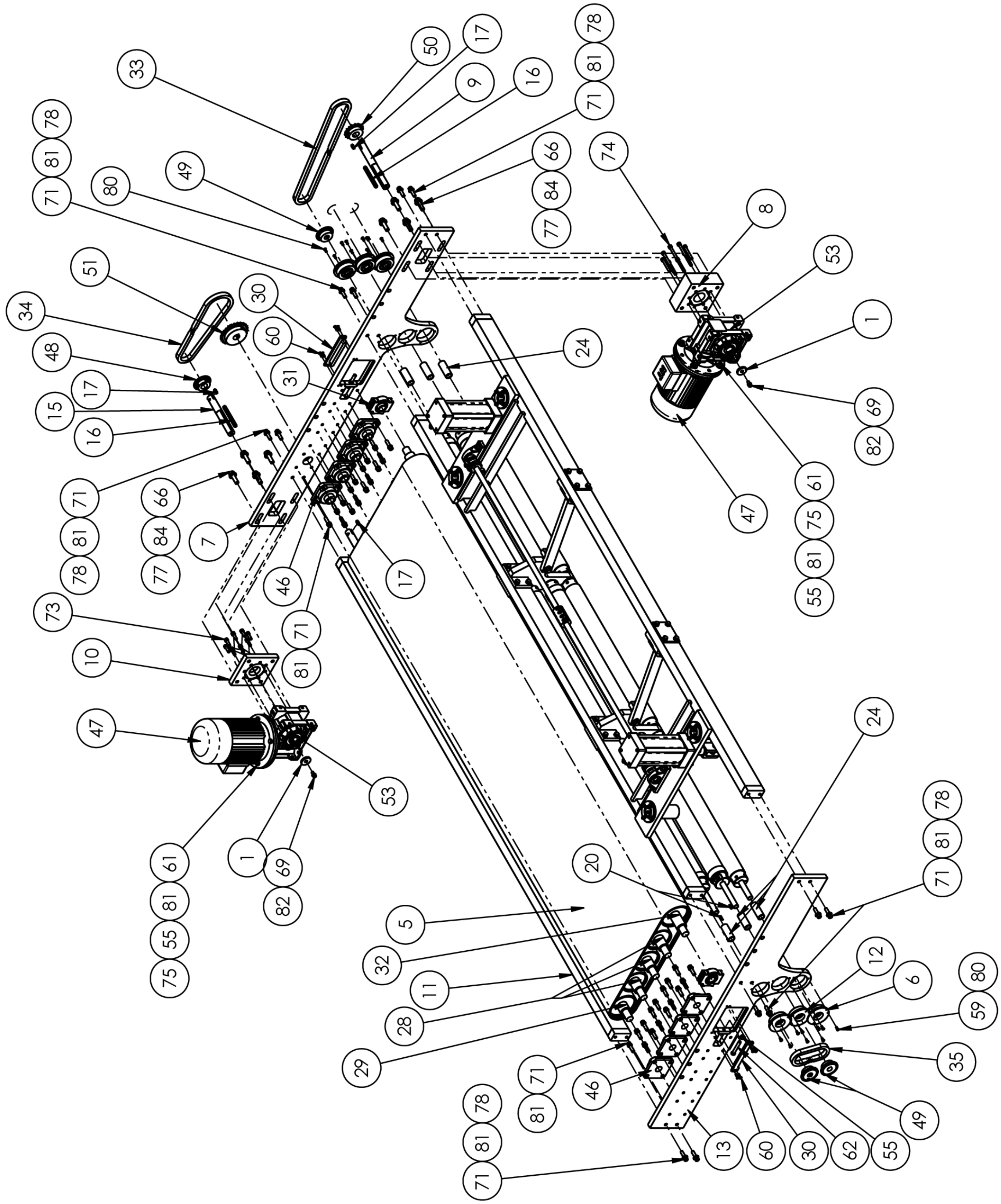
NO.	QTY	PART #	DESCRIPTION
1	1	1306388	BAR, SEAL, LOWER
2	1	1306389	BAR, SEAL, UPPER
3	1	1306390	SEAL, EDGE BAR- 84"L
4	7	NNK1/4-20	KEP NUT, 1/4-20
5	7	SSHC01080	1/4-20 X 1-1/4 HHCS
6	6	SSSC05056	1/4-28 X 7/8



1306211 Upper Conveyor

AAC Drawing Number 1306211 Rev3

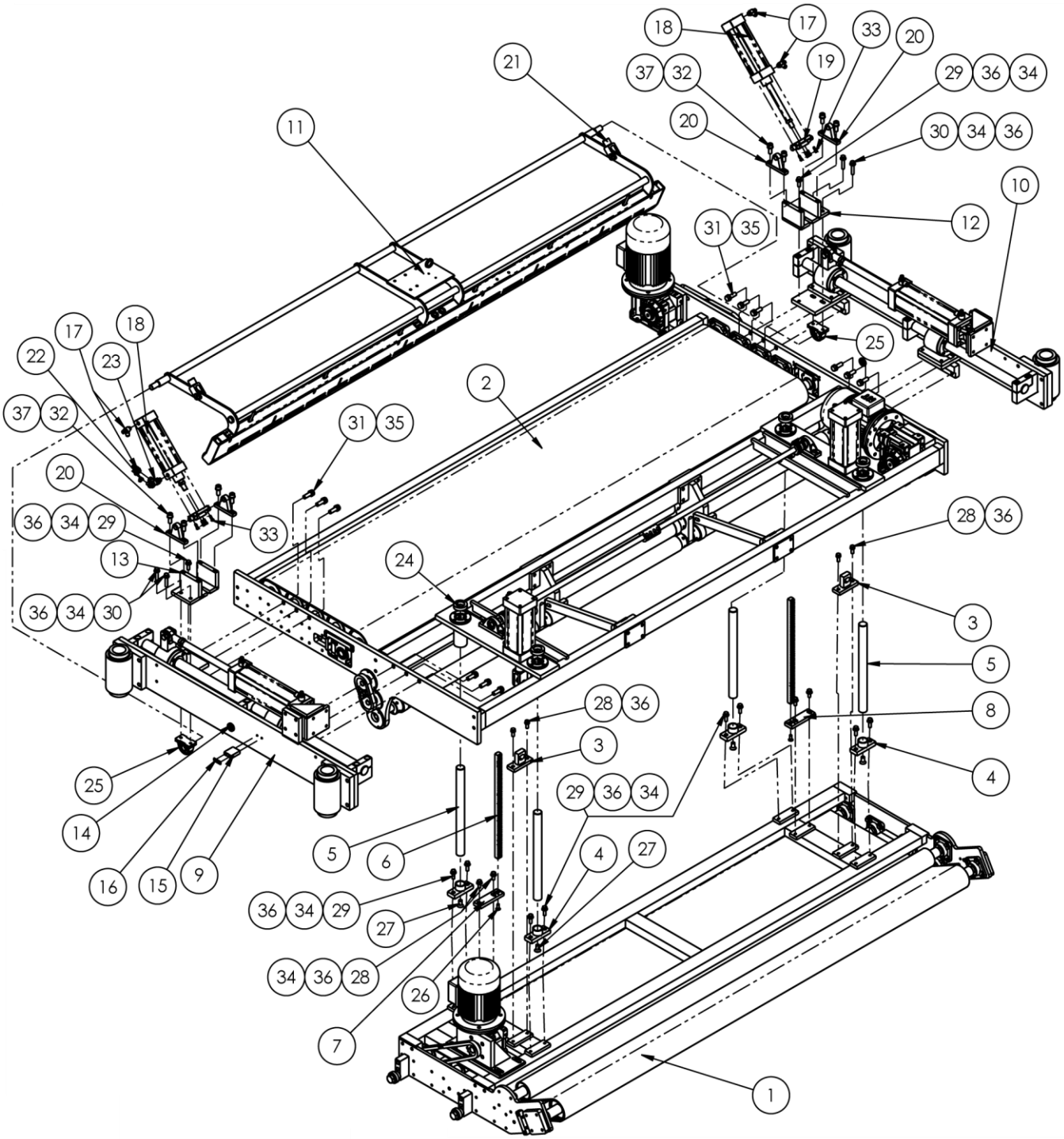
NO.	QTY	PART #	DESCRIPTION
1	1	1306005	RETAINER,SHAFT,GEARBOX
2	1	1306197	UPPER FRONT CONVEYOR BELT
3	2	1306207	PLATE, SIDE, UPPER CONV
4	1	1306208	TUBE, SUPPORT, CROSS
5	1	1306209	TUBE, SUPPORT, CROSS
6	1	1306210	FRAME,SUPPORT,UPPER CONV
7	4	1306215	ROLLER, IDLER, UPPER CONV
8	1	1306216	ROLLER, DRIVE, UPPER CONV
9	1	1306219	KEY,1/4X1/4X.95L
10	1	1306220	ROLLER, IDLER, UPPER CONV
11	2	1306221	PLATE, NUT, BELT TENSION
12	2	1306222	BAR, TENSION SCREW
13	1	1306241	KEY, 1/4 X 1/4 X .75
14	1	1306289	SHAFT, DRIVE, UPPER CONV
15	1	1306291	KEY,5/16X5/16X3.31L
16	1	1306292	DRIVE CHAIN, UPPER CONV
17	1	1306297	MOUNT, MOTOR, UPPER CONV
18	4	1306612	MOUNT,GUIDE,BEARING
19	4	1306613	SPACER, BEARING SUPPORT
20	4	BB2281288	BEARING,BALL,.75 ID
21	12	BBUCF204-12	BEARING,FLANGE,.75B
22	1	MM80B4B5	MOTOR,.75KW,IEC,B5,D80
23	1	MMH4014X1	SPROCKET,#40,14T,1"B
24	1	MMH4018X1	SPROCKET,#40,18T,1"B
25	1	MMRV5030D80	GEARBOX,WORM,RV50,30:1
26	4	NNH3/8-16	NUT,HEX,3/8-16
27	AR	NNHM8X1.25	M8 X 1.25 HEX NUT
28	17	SSHC25064	3/8-16X1,HEX CAP
29	4	SSHC25144F	3/8-16X2-1/4 HEX CAP SC
30	4	SSHC34128	3/4-10 X 2 HEX CAP
31	8	SSHC45160	1/2-13X2-1/2 HEX CAP
32	AR	SSHCM8X30	SCREW,HEX CAP M8X40
33	5	SSSC10064	5/16-18X1 SOCKET CAP
34	39	SSSC25064	3/8-16X1 SOC CAP
35	8	SSSC25112	3/8-16X1-3/4 SOC CAP
36	4	SSSC45064	SCREW,SOC CAP,1/2-13 X 1"
37	4	SSSCM8X20	M8X20 SOC CAP
38	AR	WWFM8	WASHER, FLAT, M8 I.D.
39	4	WWFS1/2	WASHER,FLAT,SAE,1/2
40	12	WWL1/2	1/2 LOCK WASHER
41	4	WWL3/4	3/4 LOCK WASHER
42	65	WWL3/8	WASHER, LOCK, 3/8
43	1	WWL5/16	WASHER, LOCK, 5/16



1306229 Main Pressing Assembly

AAC Drawing Number 1306229 Rev3

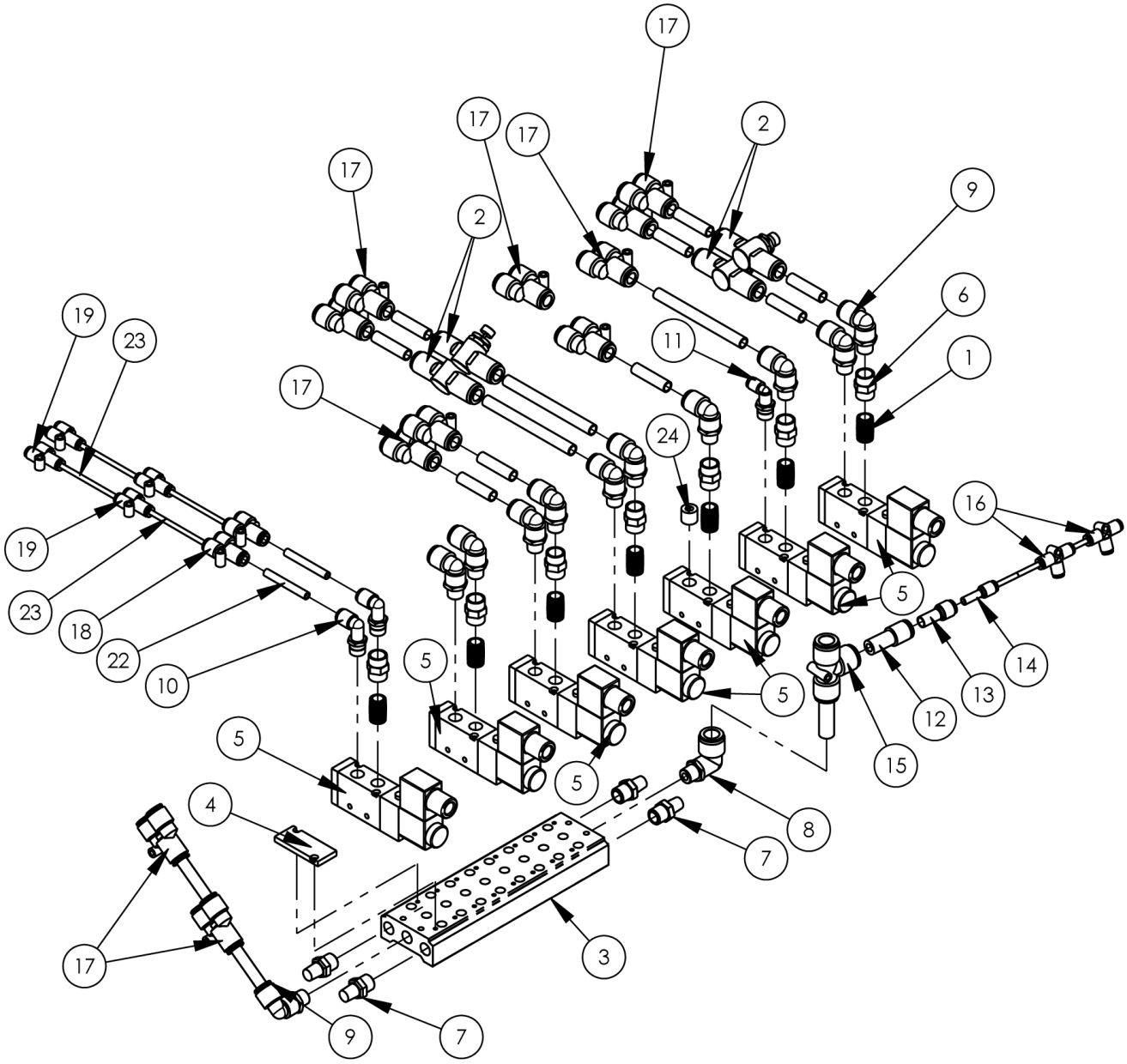
NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	1306005	RETAINER,SHAFT,GEARBOX	44	6	BB2281288	BEARING,BALL,.75 ID
2	2	1306098	HEATER RACK GUIDE	45	4	BB6483K77	BEARING,LINEAR,DBL,1.25B
3	1	1306136	COUPLING, 2 PIECE, 3/4 IN	46	8	BBFB250-1	BEARING,BALL,FLNG BLK,1"B
4	4	1306165	TURNING ROLLER, PLAIN	47	2	MM90L4B5	MOTOR,1.5KW,IEC,B5,2HP
5	1	1306198	UPPER REAR CONVEYOR BELT	48	1	MMH4015X1	SPROCKET, 1/2 P, 15T
6	4	1306224	BEARING HOUSING	49	3	MMH4015X3/4	SPROCKET, 1/2 P, 15T, 3/4 BORE
7	1	1306226	PLATE,SIDE,REAR CONV,RT	50	1	MMH4017X1	HT 17 ANSI 40 1" BORE
8	1	1306227	BLOCK, SPACER, MOTOR	51	1	MMH4026X1	SPROCKET,#40,26HT,1"B
9	1	1306228	SHAFT, DRIVE, REAR ROLLER	52	2	MMNSS12F20-075M	GEAR,SPUR,12P,3/4B W/KEY
10	1	1306230	BLOCK, SPACER, MOTOR	53	2	MMRV6330D90	GEARBOX,WORM,RV63,30:1
11	1	1306233	CROSS SUPPORT TUBE	54	2	MMVPS-112	BEARING,PILLOW BLOCK 3/4B
12	2	1306234	BEARING HOUSING, MIDDLE	55	12	NNH3/8-16	NUT,HEX,3/8-16
13	1	1306235	PLATE,SIDE,REAR CONV,LT	56	2	NNH5/8-11	NUT,HEX,5/8-11
14	1	1306236	FRAME, PRESSER SUPPORT	57	2	SSAS024160	SHOULDER BOLT 3/8 X 2.5L
15	1	1306239	SHAFT, DRIVE, REAR CONV	58	10	SSBC01024	1/4-20 X 3/8 BUT CAP SC
16	2	1306240	KEY,5/16X5/16X4.15L	59	18	SSBC98032	10-32 X 1/2 BUTTON CAP SC
17	3	1306241	KEY, 1/4 X 1/4 X .75	60	8	SSFC98048	#10-32 X .75 SHCSF
18	1	1306242	SHAFT, ROLLER, DRIVEN	61	8	SSHC25080	3/8-16 X 1-1/4 HEX CAP
19	1	1306243	SHAFT, ROLLER, DRIVEN	62	4	SSHC25144F	3/8-16X2-1/4 HEX CAP SC
20	3	1306244	KEY, 3/16 X.75 LG	63	16	SSHC25160	3/8-16X2-1/2 HEX CAP SC
21	2	1306247	PLATE, NUT,3/8-16X4	64	2	SSHC38128	7/16-14 X 2 HEX CAP
22	1	1306249	MOUNT,BEARING,CENTER,RT	65	2	SSHC41160	SCREW,HEX CAP
23	1	1306250	MOUNT,BEARING,CENTER,LT	66	8	SSHC45112	1/2-13X1-3/4 HEX CAP
24	6	1306254	SPACER, ROLLER	67	16	SSSC01064	1/4-20 X 1 SOC CAP
25	2	1306263	BRACE, FRONT TUBE	68	8	SSSC05040	1/4-28 X 5/8, SOC CAP
26	2	1306264	ARM ADJ. SUPPORT	69	2	SSSC10040	5/16-18X5/8 SOCKET CAP
27	2	1306265	PLATE, WASHER	70	AR	SSSC10064	5/16-18X1 SOCKET CAP
28	3	1306272	ROLLER,SUPPORT,REAR CONV	71	48	SSSC25088	3/8-16X1-3/8 SOC CAP
29	1	1306273	ROLLER,DRIVE,REAR CONV	72	8	SSSCM10X35	CAP SCREW 10MM X 35MM
30	2	1306276	RETAINER, BEARING	73	8	SSSCM8X25	SCREW,SOC CAP,M8X25
31	2	1306277	BEARING, TAKE-UP, 1", MOD	74	8	SSSCM8X60	M8X60 SOCKET CAP
32	1	1306278	ROLLER,DRIVEN,REAR CONV	75	8	WWF3/8	WASHER,FLAT,3/8 OR 10MM
33	1	1306298	DRIVE CHAIN, TURN ROLLER	76	2	WWF5/8	WASHER,FLAT,5/8
34	1	1306299	DRIVE CHAIN, REAR CONV	77	10	WWFS1/2	WASHER,FLAT,SAE,1/2
35	1	1306300	TRANS CHAIN, TURN ROLLER	78	16	WWFS3/8	WASHER,FLAT,SAE,3/8
36	2	1306303	SHAFT, TRANSFER	79	16	WWL1/4	WASHER,LOCK,1/4
37	5	1306392	TURNING ROLLER,COATED	80	18	WWL10	WASHER,LOCK,#10,S/S
38	1	1306632	SHAFT, ROLLER, IDLER	81	72	WWL3/8	WASHER, LOCK, 3/8
39	2	1961-181	KEY, 3/16 X 1.00L	82	2	WWL5/16	WASHER, LOCK, 5/16
40	2	AACSU80X150	CYLINDER,80MMB,150S	83	2	WWL5/8	3/8 LOCK WASHER
41	2	AAFSGM20X15	CLEVIS,ROD,M20 X 1.5	84	10	WWL7/16	WASHER,LOCK,7/16
42	4	AAQME-3-3	MALE ELBOW 3/8 OD TUBE	85	8	WWLM10	M10 LOCK WASHER
43	4	BB1L038	BEARING,BALL,.375B				



1306280 Pressing Conveyor Assembly

AAC Drawing Number 1306280 Rev1

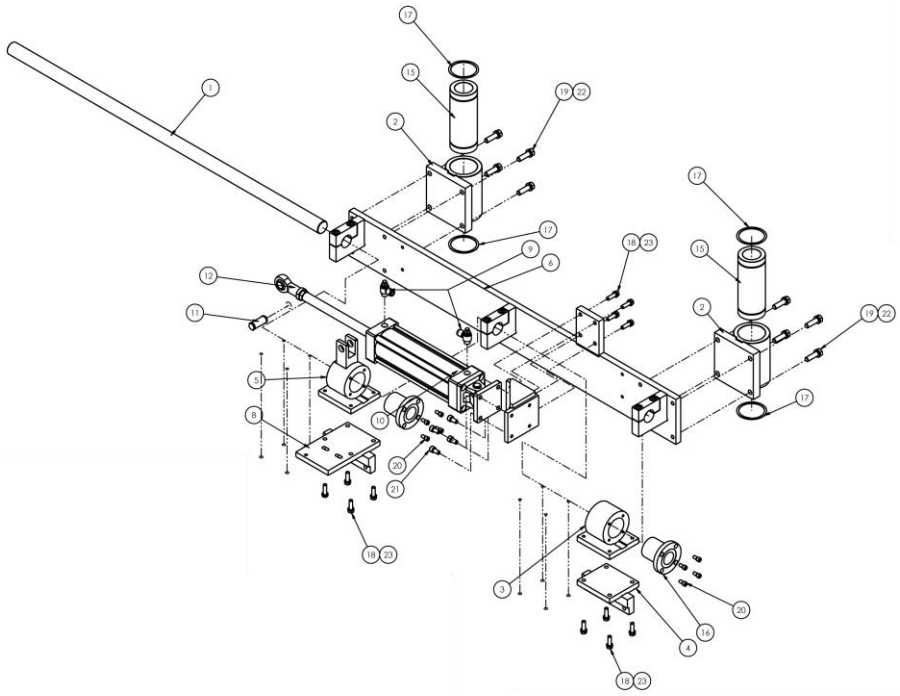
NO.	QTY	PART #	DESCRIPTION	
1	1	1306211	CONVEYOR, UPPER	Page 72
2	1	1306229	MAIN PRESSING ASBLY	Page 74
3	2	1306281	MOUNT, CLEVIS	
4	4	1306287	MOUNT, SHAFT	
5	4	1306288	SHAFT, GUIDE, UPPER CONV	
6	2	1306305	RACK, GUIDE, UPPER CONV	
7	1	1306306	MOUNT, GEAR RACK, LEFT	
8	1	1306307	MOUNT, GEAR RACK, RIGHT	
9	1	1306308	CARRIAGE,RIGHT,UPR CNVYR	Page 92
10	1	1306334	CARRIAGE,LEFT,UPR CNVYR	Page 79
11	1	1306393	SEAL BAR ASSEMBLY, 84"	Page 88
12	1	1306409	MOUNT,REAR HS CYLINDER,R	
13	1	1306411	MOUNT,REAR,HS CYLINDER,L	
14	2	1306427	SPACER,MOUNT,CYLINDER	
15	1	1306602	MOUNT,BELT,POSITIONING	
16	1	1306603	PLATE,BELT RETAINER	
17	4	AA198RA404U	FLOW CONTROL,1/4PTX1/4	
18	2	AACESI50X150	CYLINDER,AIR 50MM BORE	
19	2	AACSU50FTC	TRUNION MOUNT, 50MM BORE	
20	4	AACSU50TCM1	PIVOT MOUNT, 50MM BORE	
21	2	AAFSGM16X1.5	CLEVIS ROD M16X1.5	
22	1	AAQME-5-10	ELBOW, MALE,5/32X10-32	
23	1	AAV78861414	VALVE, BLOCKING, R1/4	
24	4	CCCL20F	COLLAR,1 1/4" CLAMP TYPE	
25	2	MMUCPA204-12	BEARING,PILLOW BLOCK,.75B	
26	2	SSFC10056	5/16-18X7/8 FLAT HD CAP	
27	4	SSFC45064	1/2-13 X 1 SOC FLAT CAP	
28	8	SSHC25064	3/8-16X1,HEX CAP	
29	10	SSHC25080	3/8-16 X 1-1/4 HEX CAP	
30	4	SSHC25128	3/8-16 X 2 HEX CAP	
31	12	SSHC45096	1/2-13X1-1/2 HEX CAP	
32	8	SSSCM12X30	SCREW, SOC CAP, M12 X 30	
33	8	SSSCM6X16	M6X16 SOC CAP SCREW	
34	18	WWFS3/8	WASHER,FLAT,SAE,3/8	
35	12	WWL1/2	1/2 LOCK WASHER	
36	22	WWL3/8	WASHER, LOCK, 3/8	
37	8	WWLM12	M12 LOCK WASHER	



1306304 Valve Stack Assembly/ 7

AAC Drawing Number 1306304 Rev1

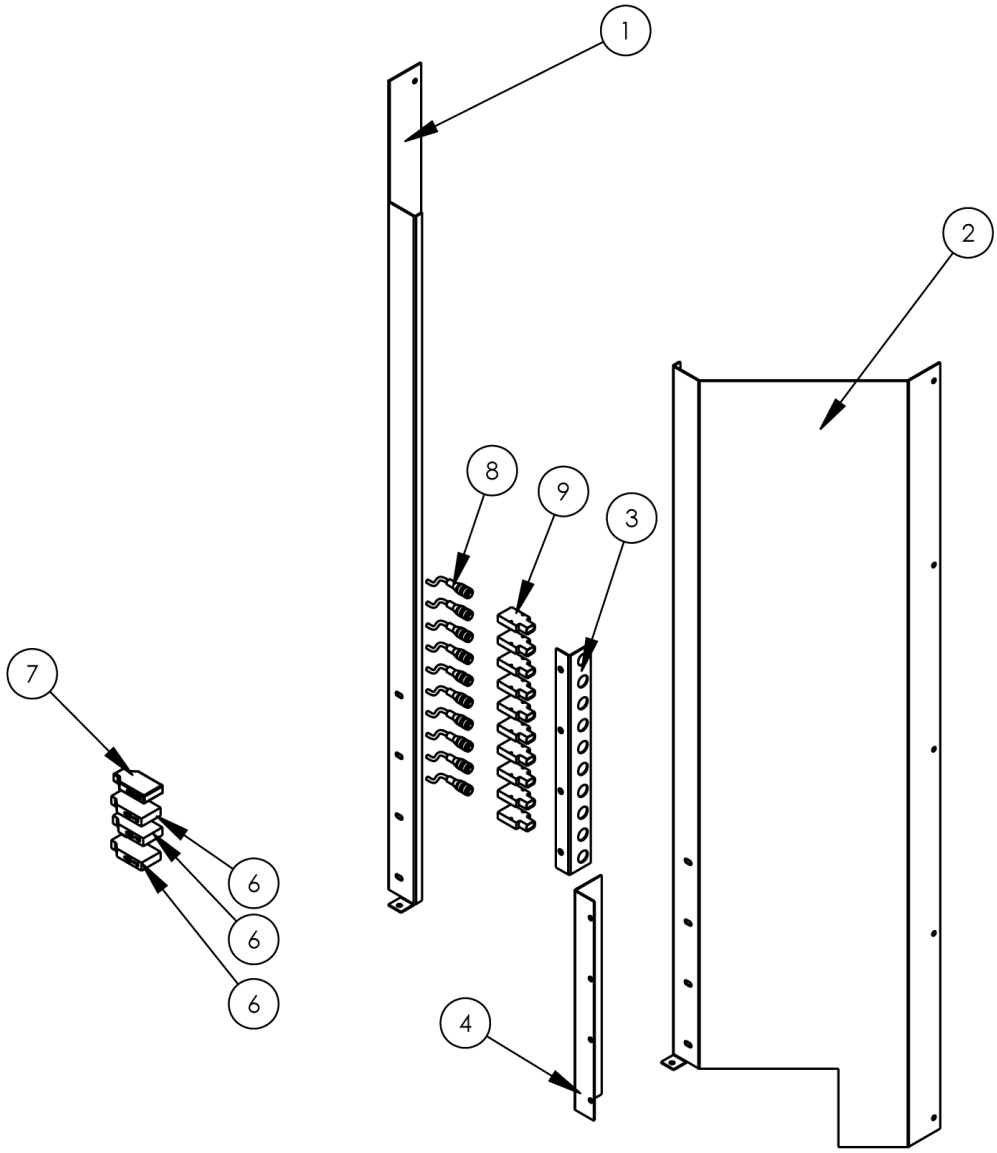
NO.	QTY	PART #	DESCRIPTION
1	7	2156	FTG,GALV,NPPL,CLOSE,1/4
2	4	AA3001F-11	FLOW CONT,INLINE,3/8 LINE
3	1	AAE4V200M8	MANIFOLD, 8 STATION
4	1	AAE4V200MB	MANIFOLD, BLANK PLATE
5	7	AAE4V21008	VALVE, 1/4" PORTED, 24VDC
6	7	AAF207P-4	COUPLING,1/4 NPT,FEMALE
7	4	AAFP28	MUFFLER,1/4 NPT
8	1	AAQME-4-2S	FITTING,ELBOW,1/4NPT,1/2
9	11	AAQME-4-3S	FITTING,ELBOW,1/4NPT,3/8
10	2	AAQME-4-4	QU. MALE EL 1/4X1/4NPT
11	1	AAQME-5-4	ELBOW, MALE 5/32X1/4NPT
12	1	AAQPR-2-3	QUICK PLUG REDUCER
13	1	AAQPR-3-4	QUICK REDUCER 3/8-1/4
14	1	AAQPR-5-4	QUICK PLUG-IN REDUCER
15	1	AAQUT-2-2	Male Branch Tee
16	2	AAQUT-5-5	QUICK UNION T,5/32X5/32
17	11	AAQUY-3-3	QUICK UNION Y 3/8 X 3/8
18	2	AAQUY-5-4	Y UNION, 5/32X1/4
19	4	AAQUY-5-5	QUICK UNION Y, 5/32
20	*4'	AATP1/2	1/2" OD POLYURETHANE
21	*150'	AATP3/8	3/8" OD POLYURETHANE
22	*24'	AATP4-1	1/4" OD POLYURETHANE
23	*20'	AATP5/32	TUBING, 5/32 OD
24	1	MM4554K12	PLUG, 1/4" PIPE



1306334 Left Carriage/ Upper Conveyor

AAC Drawing Number 1306334 Rev1

NO.	QTY	PART #	DESCRIPTION
1	1	1306313	RAIL,GUIDE,UPPER CONVEYOR
2	2	1306320	MOUNT, BEARING,WELDMENT
3	1	1306324	MOUNT,BRING,WELDMENT
4	1	1306328	MOUNT,CONVEYOR,WELDMENT
5	1	1306330	MOUNT,BRING/CYL,WLDMNT
6	1	1306332	MOUNT,UPPER MAIN,WLDMNT,R
7	1	1306335	MOUNT,CYL BRCKT,WLDMNT,L
8	1	1306395	MOUNT,CYL/CONVRY,WELDMENT
9	2	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8
10	1	AACSU80X250	CYLINDER,80MM,250S
11	1	AAFCCG2045	PIN,CLEVIS,20MM ODX53MM L
12	1	AAFSGSM20x15	ROD END, FEM-20MM X 1.5MM
13	1	AAFSU80CA	FLANGE,SWIVEL,80MM BORE,S
14	1	AAFSU80CB	FLANGE,SWIVEL,80MM BORE,D
15	2	BBIP32GW	2.0"ID, 3.0"OD, DW LINEAR BALL
16	2	BBULHFR150	BEARING,LINEAR,1.5 B
17	4	MM91665A630	SPRING,RETAINING,EXT,3"
18	12	SSHC25080	3/8-16 X 1-1/4 HEX CAP
19	8	SSHC45112	1/2-13X1-3/4 HEX CAP
20	8	SSSC10040	5/16-18X5/8 SOCKET CAP
21	4	SSSCM10X20	CAP SCREW 10MM X 20MM
22	8	WWL1/2	1/2 LOCK WASHER
23	12	WWL3/8	WASHER, LOCK, 3/8



1306638 Height Sensing Kit

AAC Drawing Number 1306638 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1306633	GUARD,TABLE,FRONT,LEFT
2	1	1306634	GUARD,TABLE,FRONT,RIGHT
3	1	1306635	BRACKET,SENSOR ARRAY,15"
4	1	1306636	BRACKET,SENSOR REFLECTOR
5	1	1306A-WD	DIAGRAM,WIRING,SBUS,1306
6	3	4080-110	MODULE,QUAD INPUT
7	AR*	4080-150	MODULE,PROGRAM
8	10	FFRK44T-4	CABLE,EYE,12',NO END
9	10	FFSM312LVQ	EYE,ELECTRIC,10-30VDC

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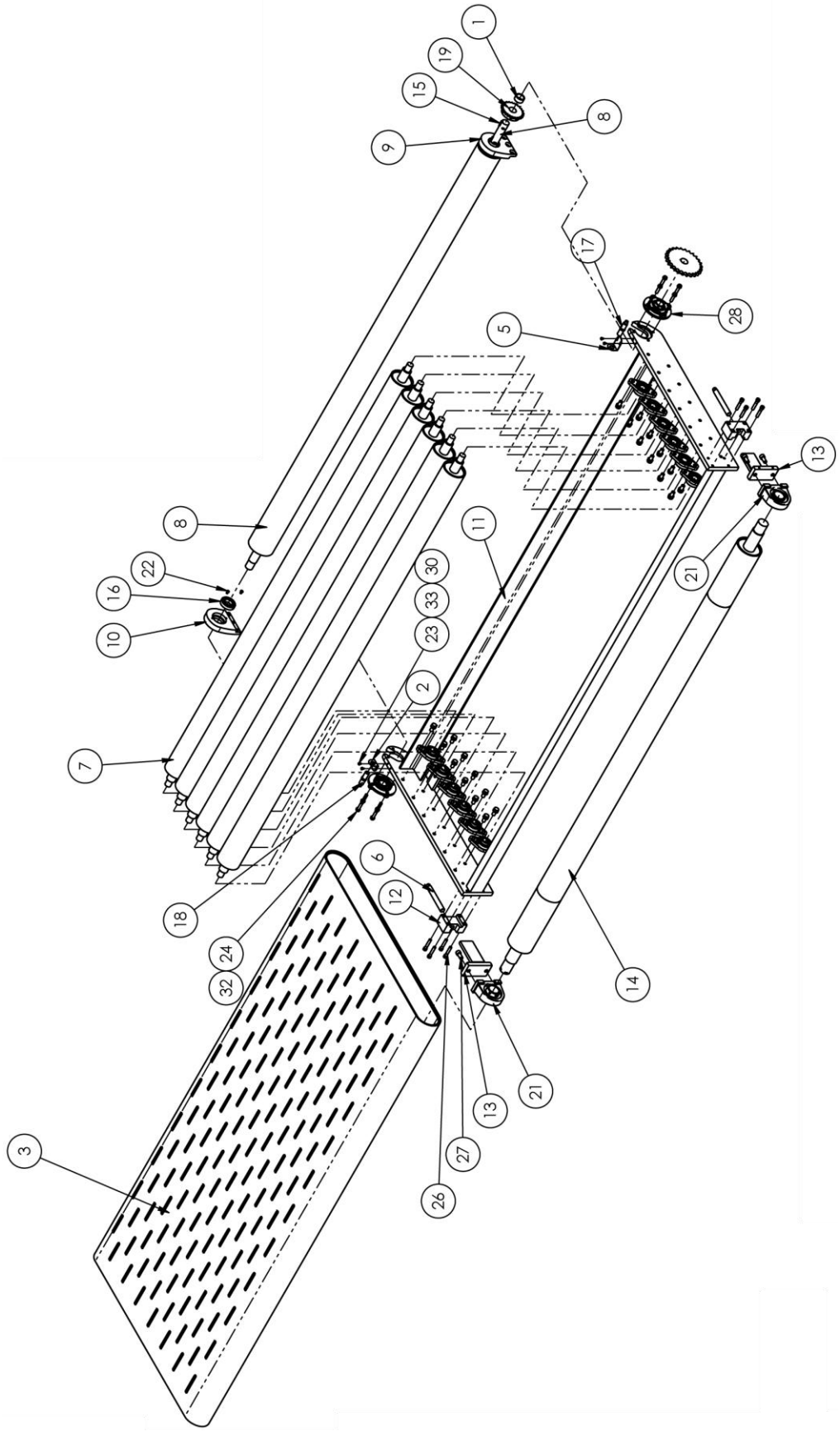
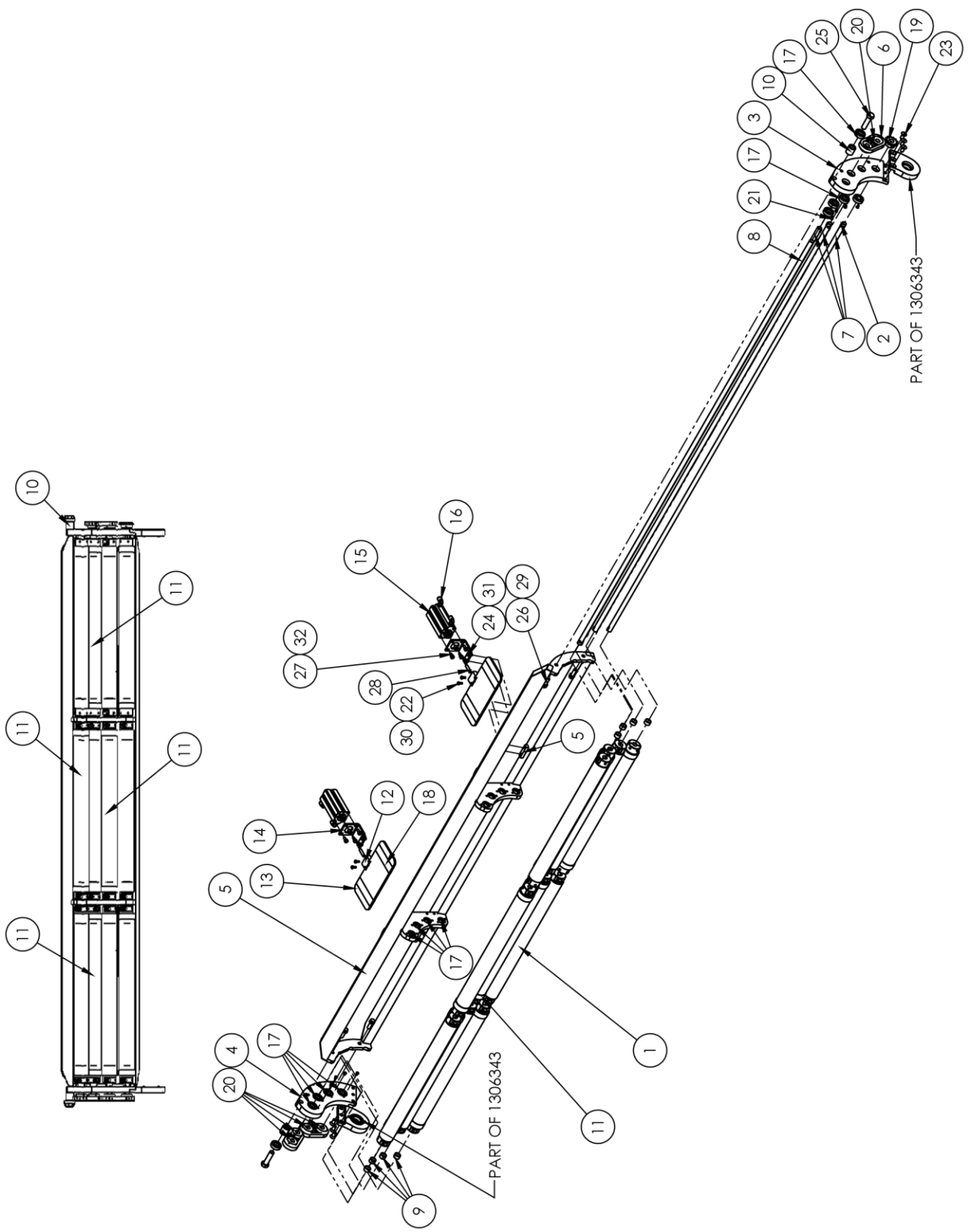


1306343 Lower Conveyor

AAC Drawing Number 1306343 Rev1

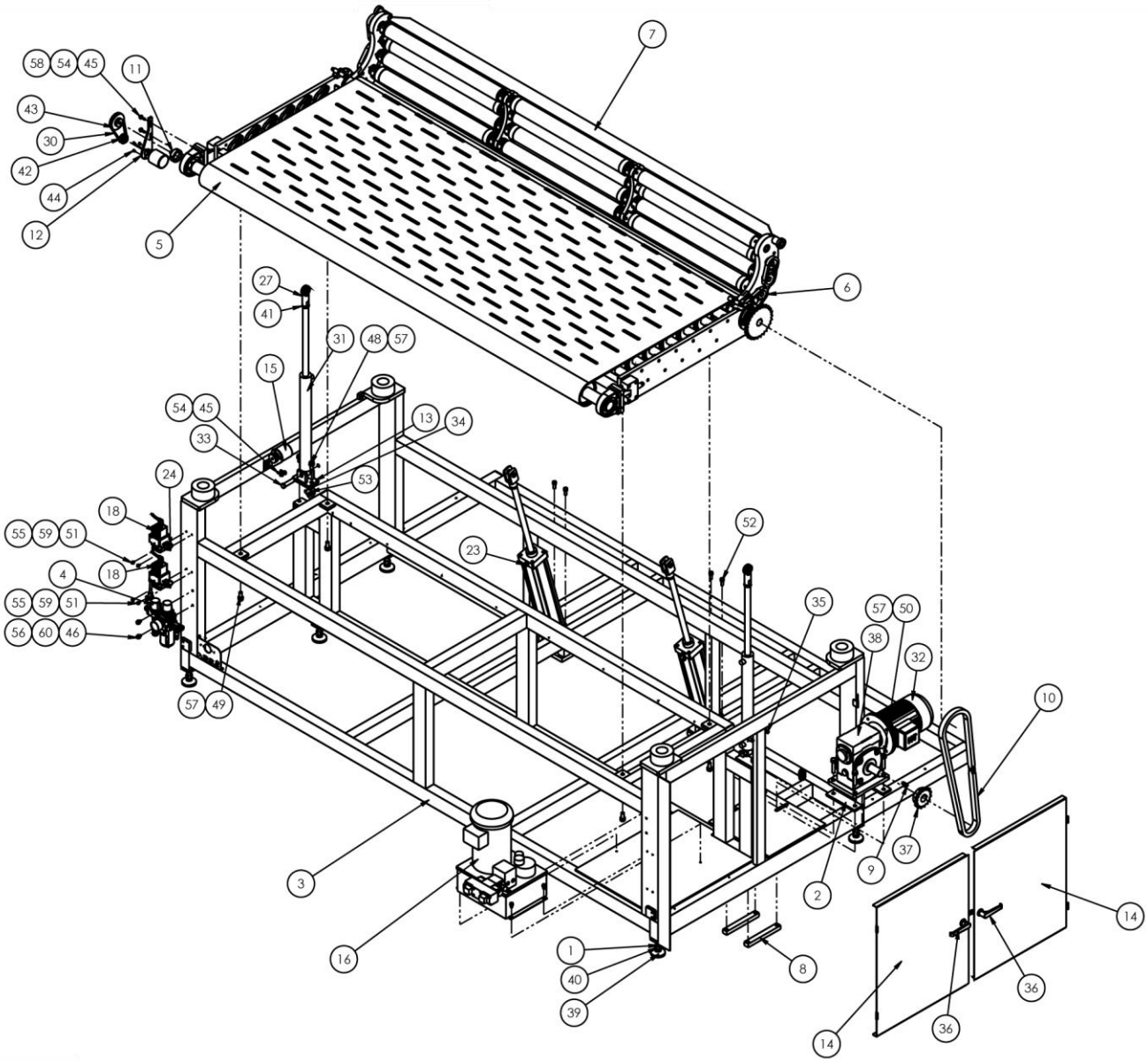
NO.	QTY	PART #	DESCRIPTION
1	1	1306159	SPACER, SPROCKET
2	1	1306183	BRKT, MTG, FFS18S/E
3	1	1306199	BELT, CONVEYOR, LOWER
4	1	1306241	KEY, 1/4 X 1/4 X .75
5	1	1306257	BRKT, MTG, FFS18S/E,EXT
6	2	1306317	SCREW, BELT TENSION
7	6	1306339	ROLLER, SUPPORT, BELT
8	1	1306345	ROLLER, DRIVE, LOWER
9	1	1306348	BEARING SUPPORT,RT FT
10	1	1306351	BEARING SUPPORT, LT FT
11	1	1306352	FRAME, CONVEYOR, LOWER
12	2	1306353	BLOCK, BELT TENSION
13	2	1306356	MOUNT, BEARING
14	1	1306357	ROLLER, DRIVEN, LOWER
15	1	1306380	KEY, 1/4 X 1/4 X 1.20
16	2	BBR22	BEARING,BALL,1.375B,2.5OD
17	1	FFS186EQ	EYE,OPPOSED,XMIT,IR LED,
18	1	FFS18SN6RQ	EYE,OPPOSED,RCVR,NPN,IR
19	1	MMH4024X1-1/4	SPROCKET,#40,24T,1.25B
20	1	MMH6026X1-1/4	SPROCKET,#60,26T,1.25B
21	2	MMUCPA209-28	BEARING,PILLOW BLOCK,1.25
22	4	SSBC01024	1/4-20 X 3/8 BUT CAP SC
23	4	SSBC90020	8-32X3/8 BUTTON CAP
24	8	SSHC25096	3/8-16 X 1 1/2 HEX HEAD
25	24	SSHC45064	1/2-13X1 HEX CAP
26	8	SSSC25128	3/8-16X2" SOC CAP
27	4	SSSC45064	SCREW,SOC CAP,1/2-13 X 1"
28	2	UUCFC206-20	BEARING,FLANGE,1.25B,4 BOLT
29	12	UUCFL205-16	BEARING,FLANGE,1",2 BOLT
30	4	WWF8	WASHER, FLAT, #8
31	24	WWL1/2	1/2 LOCK WASHER
32	9	WWL3/8	WASHER, LOCK, 3/8
33	4	WWL8	WASHER,LOCK,#8



1306369 Upturn Roller Assembly

AAC Drawing Number 1306369 Rev 3

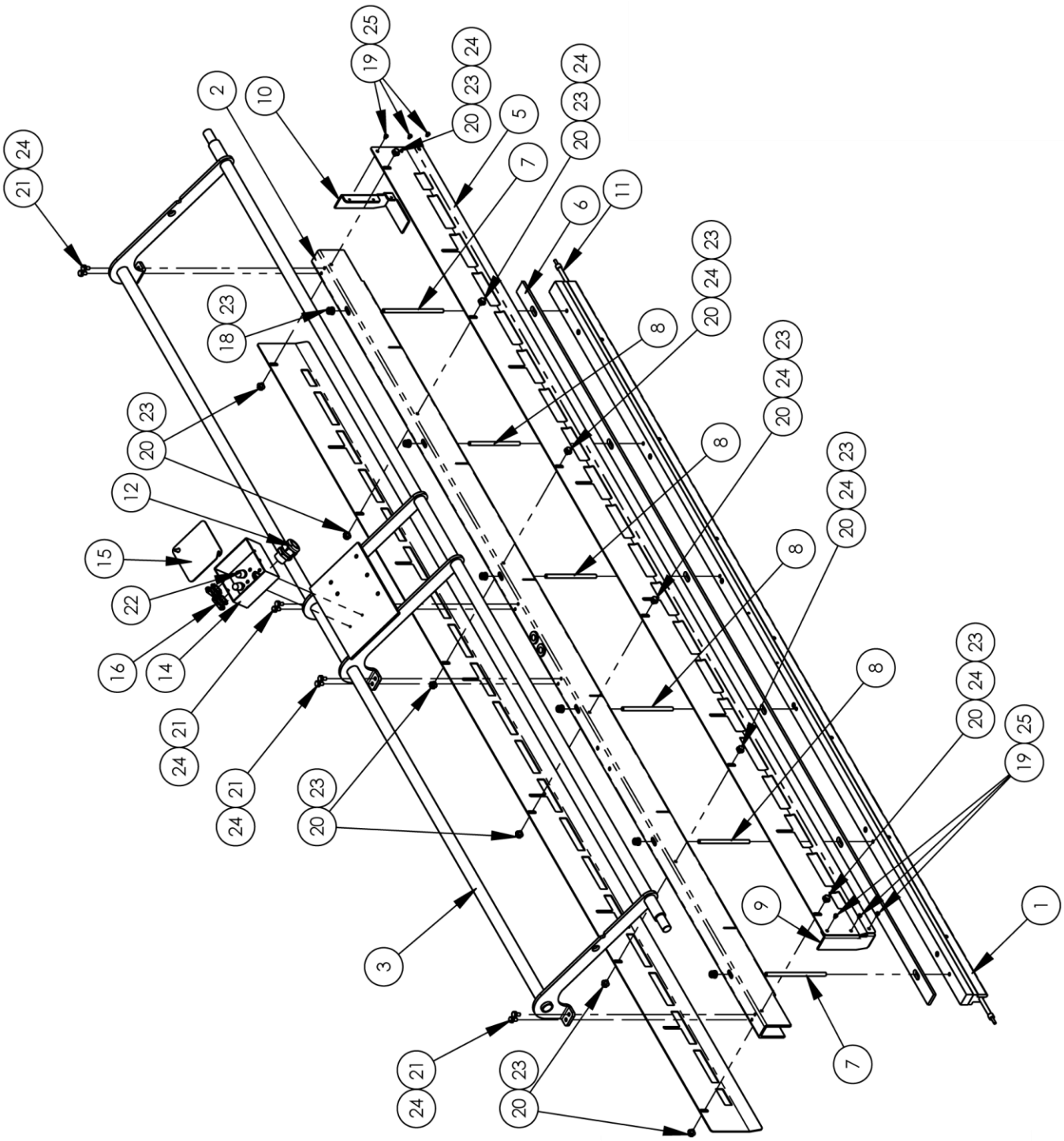
NO.	QTY	PART #	DESCRIPTION
1	6	1306165	TURNING ROLLER, PLAIN
2	7	1306244	KEY, 3/16 X.75 LG
3	1	1306349	BEARING SUPPORT, LT REAR
4	1	1306365	BEARING SUPPORT, RT REAR
5	1	1306366	CENTER SUPPORT FRAME
6	3	1306368	CHAIN, #40 X 26" LONG
7	3	1306370	SHAFT,UP ROLLER, DBL KEY
8	1	1306371	SHAFT,UP ROLLER,SGL KEY
9	8	1306372	SPACER,.75 IDX1.0X.625L
10	2	1306379	SPACER, BEARING SUPPORT
11	6	1306392	TURNING ROLLER,COATED
12	2	1306617	MOUNT,FINGER,EJECTOR
13	2	1306618	PLATE,PUSH FINGER
14	2	1306619	MOUNT,CYLINDER,UP ROLLERS
15	2	AACSDA50X100	COMPACT,CYLINDER,50MM B
16	4	AAQME-3-4U	MALE ELBOW,3/8OD TUBE 1/4
17	18	BB2281288	BEARING,BALL,.75 ID
18	48*	MM130-10A	TAPE,PTFE,1.5 WIDE
19	1	MMH4013X3/4	SPROCKET,#40,13T,3/4"B
20	6	MMH4014X3/4	SPROCKET,#40,14T,3/4"B
21	24	SSBC01024	1/4-20 X 3/8 BUT CAP SC
22	4	SSBC01048	SCREW,BUTTON CAP,1/4-20X3/4,SS
23	6	SSFC45064	1/2-13 X 1 SOC FLAT CAP
24	4	SSHC10040	5/16-18 X 5/8 HHCS
25	2	SSHC34176	3/4-10 X 2-3/4 HEX CAP
26	4	SSHC45096	1/2-13X1-1/2 HEX CAP
27	8	SSHCM8X20	SCREW,HEX CAP
28	2	SSSSM10X45	M10x1.5x45 THREADED STUD
29	4	WWL1/2	1/2 LOCK WASHER
30	4	WWL1/4	WASHER,LOCK,1/4
31	4	WWL5/16	WASHER, LOCK, 5/16
32	8	WWLM8	M8 LOCK WASHER



1306377 Lower Conveyor Assembly

AAC Drawing Number 1306377 Rev5

	NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
	1	6	0411-1063	ROD, THREADED, 5/8-11 X 5	31	*AR	HC251510PP14	CYL,HYD,1.5"B,1.0"R,14"S
	2	2	1306006	SPACER,GEARBOX,MAIN	32	1	MM90L4B5	MOTOR,1.5KW,IEC,B5,2HP
	3	1	1306049	FRAME,LOWER MAIN	33	2	MM97245A555C	CLEVIS PIN 1.11UL STL
Page 60	4	1	1306327	MAIN REGULATOR ASSEMBLY	34	2	MM98335A074	SPRING CLIP
Page 82	5	1	1306343	CONVEYOR, LOWER	35	*AR	MMAM1-AN-4A	PROX SWITCH,10-30VDC,12MM
	6	1	1306367	CHAIN,DRIVE,REAR ROLLER	36	2	MMELH149	LATCH HANDLE
Page 84	7	1	1306369	UPTURN ROLLER ASBLY	37	1	MMH6015X138	#60 GEAR 15HT 1.375ID BORE
	8	2	1306381	MOUNT,PLATE,MAIN DRIVE	38	1	MMIC8030D90	GEARBOX,WORM,RV80,30:1
	9	1	1306383	5/16 X 5/16 X 1.2 KEY	39	6	MML-2	LEVELING PAD, 5/8-11
	10	1	1306384	CHAIN,ROLLER,MAIN L DRIVE	40	12	NNH5/8-11	NUT,HEX,5/8-11
	11	1	1306385	MOUNT,GEAR,SHAFT END	41	2	NNJ3_4-16	3/4-10 JAM NUT
	12	1	1306387	BRACKET,MOUNT,ENCODER	42	1	PP24XLB37M1	PULLEY, GEAR,1/5 PITCH
	13	2	1306424	MOUNT,LOWER HYD CYL	43	1	PP48AXL037M2	PULLEY,GEAR,1/5P,48T 3/8B
	14	2	1306447	DOOR,FRAME, LOWER,R	44	3	SSFC98024	#10-32 X .375 FLAT CAP
Page 103	15	1	1306601	POSITIONING ENCODER ASSY	45	4	SSHC01064	1/4-20 X 1 HHCS
Page 105	16	1	1306614	HYD,POWER PACKAGE	46	2	SSHC10032	5/16-18 X 1/2 HHCS
	17	1	1953-405	ENCODER, W/PLUG	47	4	SSHC10040	5/16-18 X 5/8 HHCS
	18	2	AA198-3050A	REGULATOR,ELCTRO/PNEUM	48	4	SSHC45064	1/2-13X1 HEX CAP
	19	2	AACSU80X400	CYLINDER,80MMB,400S	49	4	SSHC45080	1/2-13X1-1/4 HEX CAP
	20	2	AAFSGM20X15	CLEVIS,ROD,M20 X 1.5	50	4	SSHC45160	1/2-13X2-1/2 HEX CAP
	21	2	AAFSU80CA	FLANGE,SWIVEL,80MM BORE,S	51	4	SSHC98032	10-32X1/2 HEX HD
	22	2	AAFSU80CB	FLANGE,SWIVEL,80MM BORE,D	52	4	SSSCM10X25	10M X 25MM, SOC CAP
	23	4	AAQME-3-3	MALE ELBOW 3/8 OD TUBE	53	2	WWF5/8	WASHER,FLAT,5/8
	24	4	AAQME-4-3S	FITTING,ELBOW,1/4NPT,3/8	54	4	WWFS1/4	WASHER,FLAT,SAE,1/4
	25	1	AAQUY-3-3	QUICK UNION Y 3/8 X 3/8	55	4	WWFS10	WASHER, FLAT, #10, SAE
	26	1	AATP3/8	3/8" OD POLYURETHANE	56	2	WWFS5/16	WASHER,FLAT,SAE,5/16
	27	2	BBAW-9	ROD END, 3/4-16, 3/4 B	57	12	WWL1/2	1/2 LOCK WASHER
	28	2	FF3200	STRAIN RELIEF, 1/2 NPT	58	4	WWL1/4	WASHER,LOCK,1/4
	29	2	FF8463	NUT,LOCK,1/2NPT,NYLON,BLK	59	4	WWL10	WASHER,LOCK,#10,S/S
	30	1	GG170XL037	BELT,GEAR,1/5P,3/8W,85T	60	6	WWL5/16	WASHER, LOCK, 5/16



1306393 Seal Bar Assembly, 84in.

AAC Drawing Number 1306393 Rev1

NO.	QTY	PART #	DESCRIPTION
1	1	1306203	SEAL BAR ASSEMBLY, 84"
2	1	1306394	TUBE, FRONT SEAL
3	1	1306401	SEAL BAR CARRIAGE
4	1	1306405	GUARD,REAR HEAT SEAL
5	1	1306408	GUARD,REAR HEAT SEAL,B
6	1	1306412	SPACER, PTFE
7	2	1306413	THREADED ROD, 6.25"
8	4	1306414	THREADED ROD, 5.25"
9	1	1306415	GUARD,REAR HEAT SEAL,R
10	1	1306416	GUARD,HEAT SEAL,END,L
11	1	EERBN9010S	HEAT ELEMENT,92"L,0.315D
12	1	FF3234	STRAIN RELIEF,LIQ TIGHT
13	1	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK
14	1	K-233	BOX,ELECTRICAL,SQUARE
15	1	K-234	COVER,4IN SQUARE
16	2	K-235	CONNECTOR,ROMEX,1/2"
17	2	MM9307K63	GROMMET,1/2ID,13/16 HOLE
18	12	NNH5/16-18	5/16-18 HEX NUT
19	6	SSBC90016	8-32 X 1/4 BUTTON CAP
20	12	SSHC01024	1/4-20 X 3/8 HHCS
21	8	SSHC01032	1/4-20 X 1/2 HHCS
22	2	TTMB70476	CONNECTOR,WIRE,EX LARGE
23	18	WWFS1/4	WASHER,FLAT,SAE,1/4
24	20	WWL1/4	WASHER,LOCK,1/4
25	6	WWL8	WASHER,LOCK,#8

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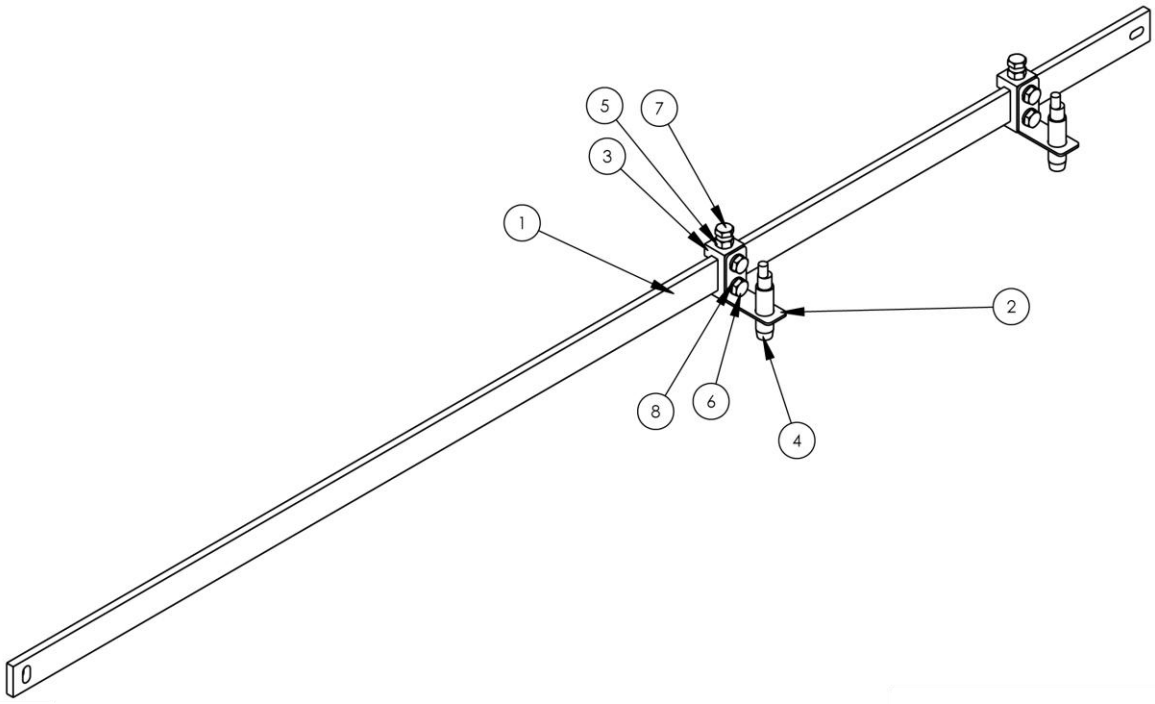
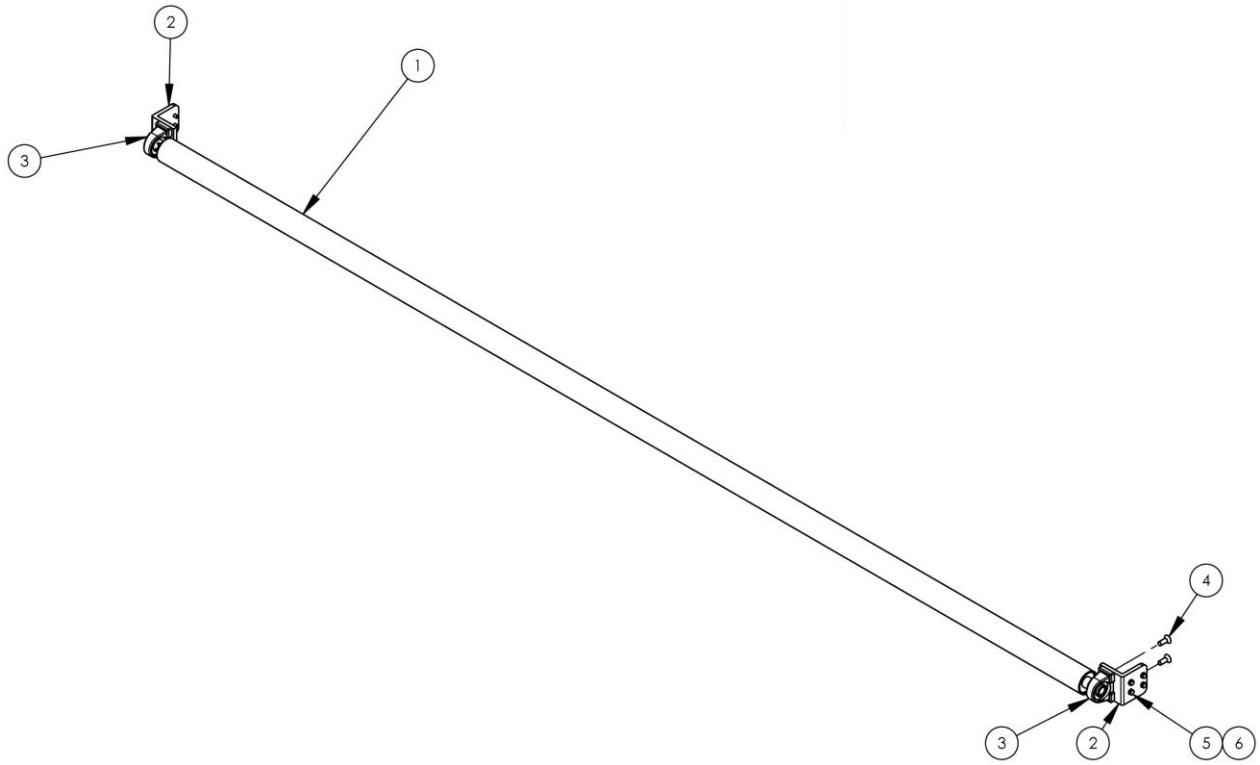


1306430 Bracket Sensor Assembly/Upper Conveyor Position

AAC Drawing Number 1306430 Rev1

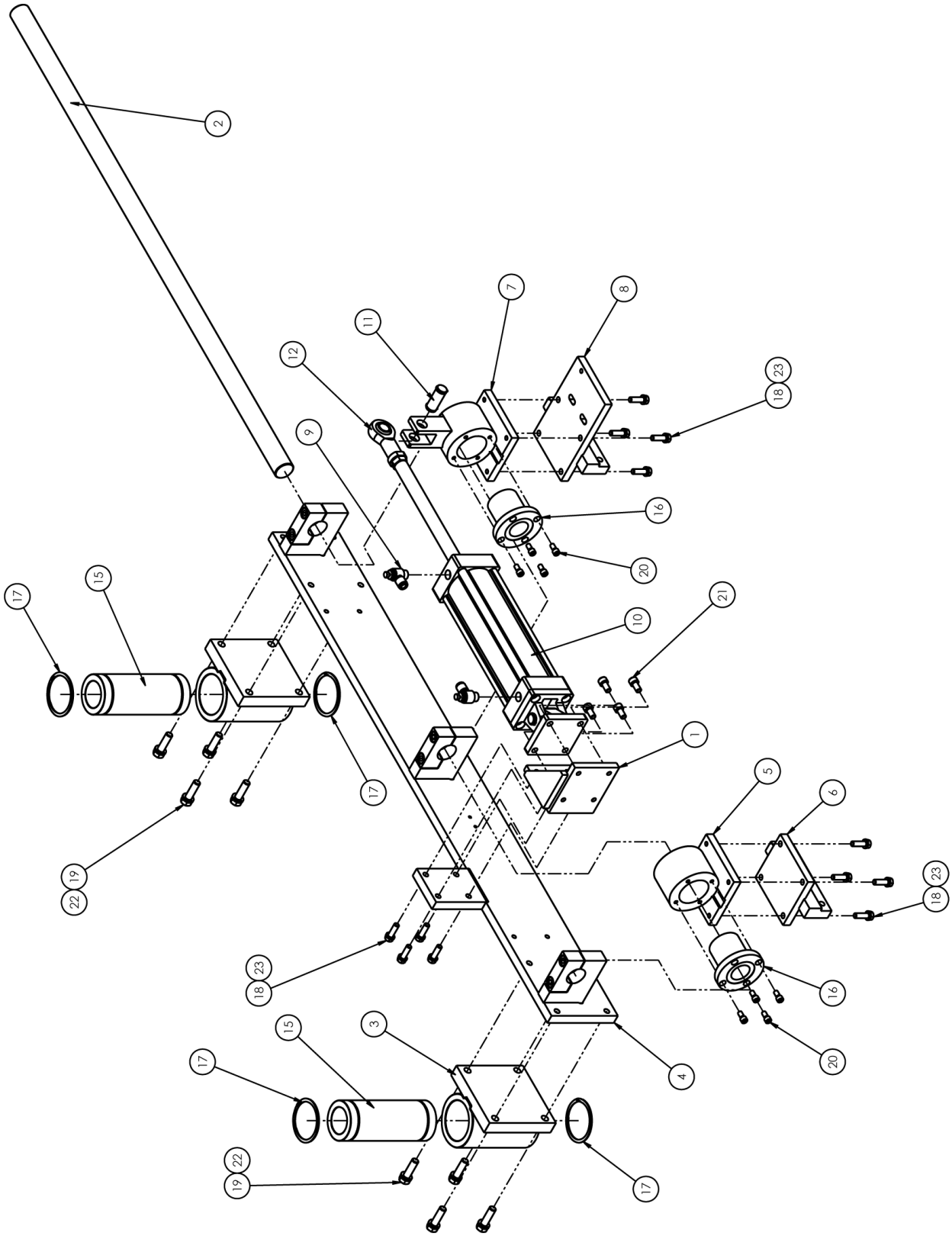
NO.	QTY	PART #	DESCRIPTION
1	1	1306431	BAR, SENSOR MOUNTING
2	2	1306433	BRACKET, SENSOR
3	2	1390410	BRACKET, SENSOR
4	*AR	MMAM1-AN-4A	PROX SWITCH,10-30VDC,12MM
5	2	NNH1/4-20	NUT,HEX,1/4-20
6	4	SSHC01024	1/4-20 X 3/8 HHCS
7	2	SSHC01040	1/4-20 X 5/8 HHCS
8	4	WWL1/4	WASHER,LOCK,1/4



1306590 Front Table Roller Assembly

AAC Drawing Number 1306590 Rev0

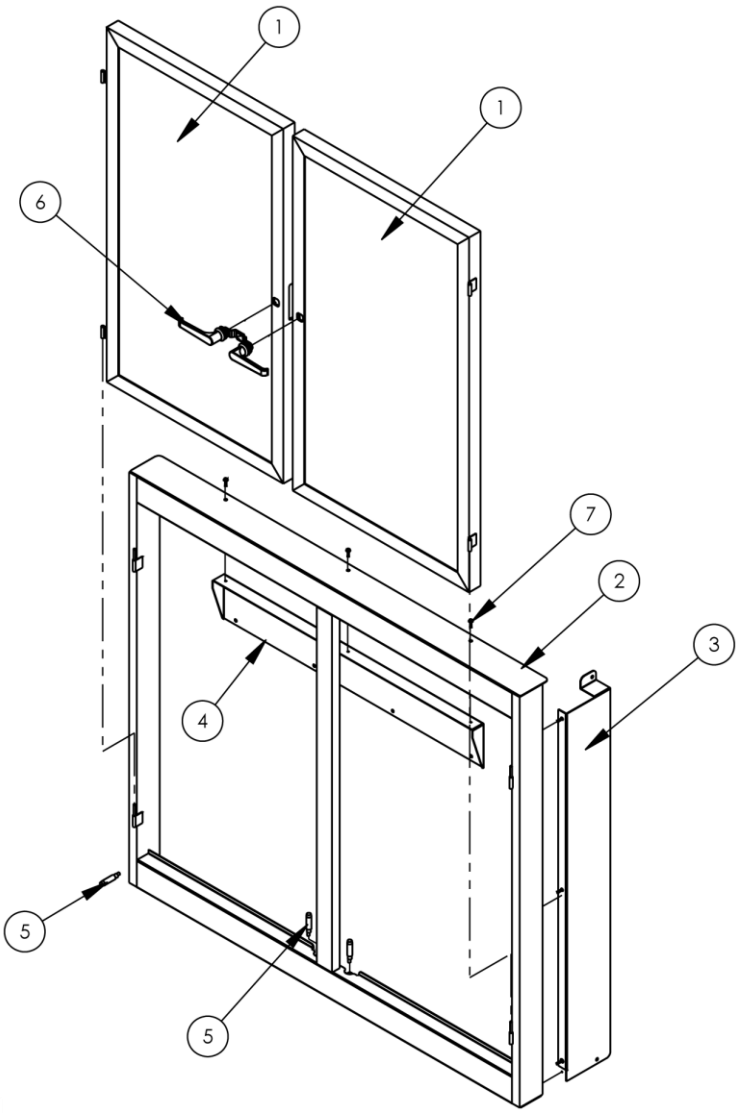
NO.	QTY	PART #	DESCRIPTION
1	1	1306134	ROLLER ASSY, LOADING TBL
2	2	1306591	MOUNT, BEARING,FRT ROLLER
3	2	MMUCPA204-12	BEARING,PILLOW BLOCK,.75B
4	4	SSFC25064	3/8-16 X 1 FLAT CAP
5	8	SSHC01048	1/4-20 X 3/4 HEX CAP
6	8	WWL1/4	WASHER,LOCK,1/4



1306308 Right Carriage/Upper Conveyor

AAC Drawing Number 1306308 Rev1

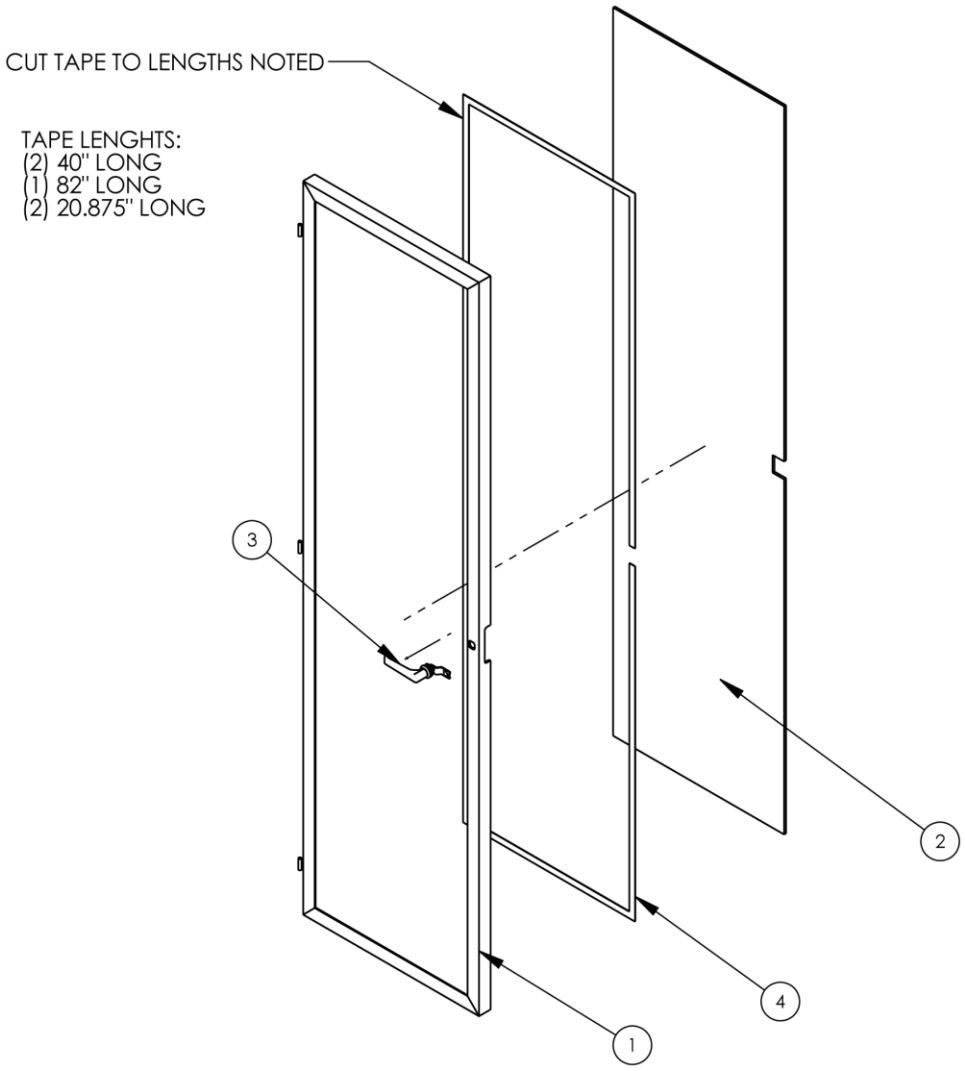
NO.	QTY	PART #	DESCRIPTION
1	1	1306312	MOUNT,CYL BRCKT,WLDMNT,R
2	1	1306313	RAIL,GUIDE,UPPER CONVEYOR
3	2	1306320	MOUNT, BEARING,WELDMENT
4	1	1306323	MOUNT,UPPER MAIN,WLDMNT,L
5	1	1306324	MOUNT,BRING,WELDMENT
6	1	1306328	MOUNT,CONVEYOR,WELDMENT
7	1	1306330	MOUNT,BRING/CYL,WLDMNT
8	1	1306396	MOUNT,CYL/CONVRY,WELDMENT
9	2	AA1983201FU0311	FLOW CONTL 3/8UNIFIT X3/8
10	1	AACSU80X250	CYLINDER,80MM,250S
11	1	AAFCCG2045	PIN,CLEVIS,20MM ODX53MM L
12	1	AAFSGSM20x15	ROD END, FEM-20MM X 1.5MM
13	1	AAFSU80CA	FLANGE,SWIVEL,80MM BORE,S
14	1	AAFSU80CB	FLANGE,SWIVEL,80MM BORE,D
15	2	BBIP32GW	2.0"ID, 3.0"OD, DW LINEAR BALL
16	2	BBULHFR150	BEARING,LINEAR,1.5 B
17	4	MM91665A630	SPRING,RETAINING,EXT,3"
18	12	SSHC25080	3/8-16 X 1-1/4 HEX CAP
19	8	SSHC45112	1/2-13X1-3/4 HEX CAP
20	8	SSSC10040	5/16-18X5/8 SOCKET CAP
21	4	SSSCM10X20	CAP SCREW 10MM X 20MM
22	8	WWL1/2	1/2 LOCK WASHER
23	12	WWL3/8	WASHER, LOCK, 3/8



1306437 Upper Right Guard

AAC Drawing Number 1306437 Rev0

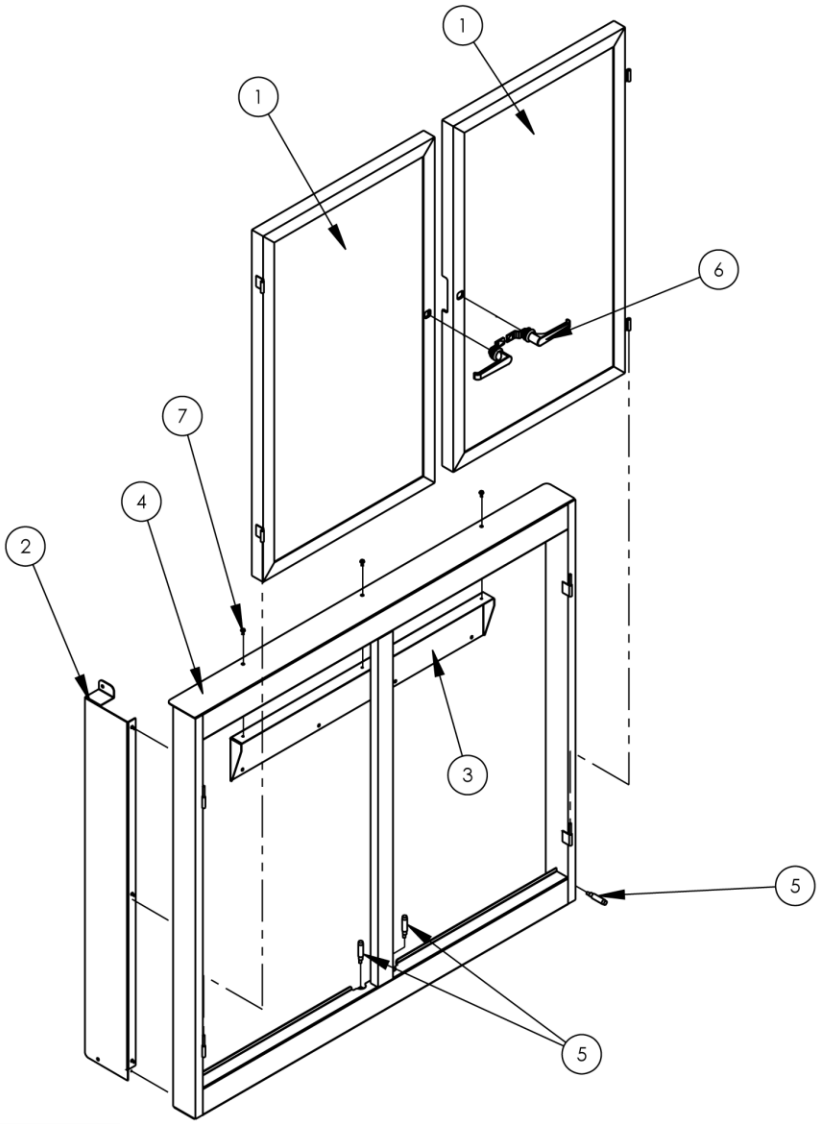
NO.	QTY	PART #	DESCRIPTION
1	2	1306355	DOOR,GUARD
2	1	1306438	FRAME,GUARD,WELDMENT,R
3	1	1306451	PANEL,GUARD,REAR,R
4	1	1306463	BRACKET,MOUNT,GUARD,UPPER
5	*AR	MMAM1-AN-4A	PROX SWITCH,10-30VDC,12MM
6	2	MMELH149	LATCH HANDLE
7	6	SSZS93048	SCREW, SHT.METAL 10 ZIP



1306461 Front Left Door Guard

AAC Drawing Number 1306461 Rev0

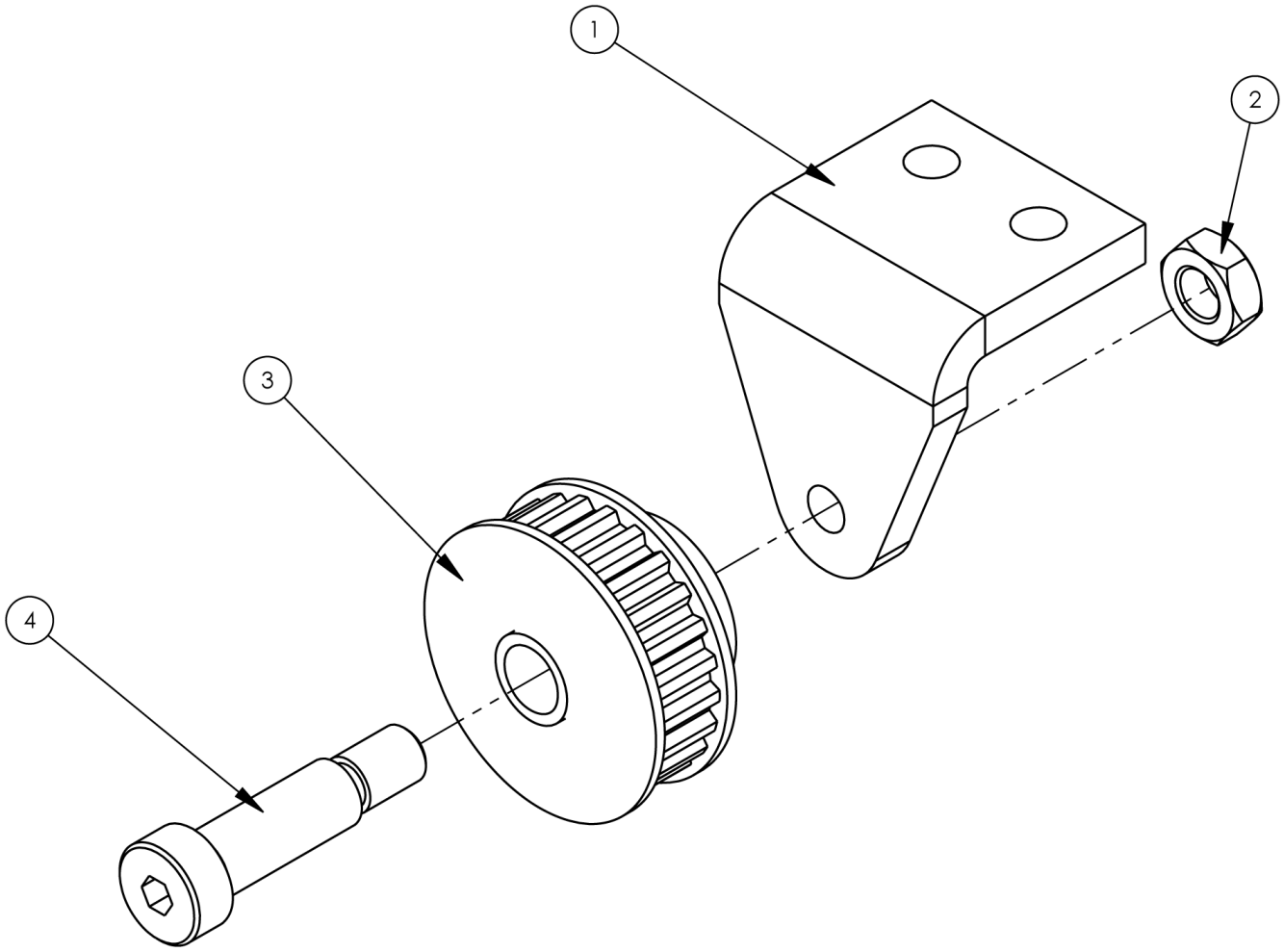
NO.	QTY	PART #	DESCRIPTION
1	1	1306458	DOOR,GUARD,FRONT,LH
2	1	1306460	GUARD,WINDOW
3	1	MMELH149	LATCH HANDLE
4	*17 FT	ZZZSH-310	TAPE, DOUBLE SIDED,3/4"W



1306462 Upper Left Guard

AAC Drawing Number 1306462 Rev0

NO.	QTY	PART #	DESCRIPTION
1	2	1306355	DOOR,GUARD
2	1	1306452	PLATE,GUARD,REAR,L
3	1	1306463	BRACKET,MOUNT,GUARD,UPPER
4	1	1306464	FRAME,GUARD,WELDMENT,L
5	*AR	MMAM1-AN-4A	PROX SWITCH,10-30VDC,12MM
6	2	MMELH149	LATCH HANDLE
7	6	SSZS93032	SCREW, SHT.METAL 10 ZIP



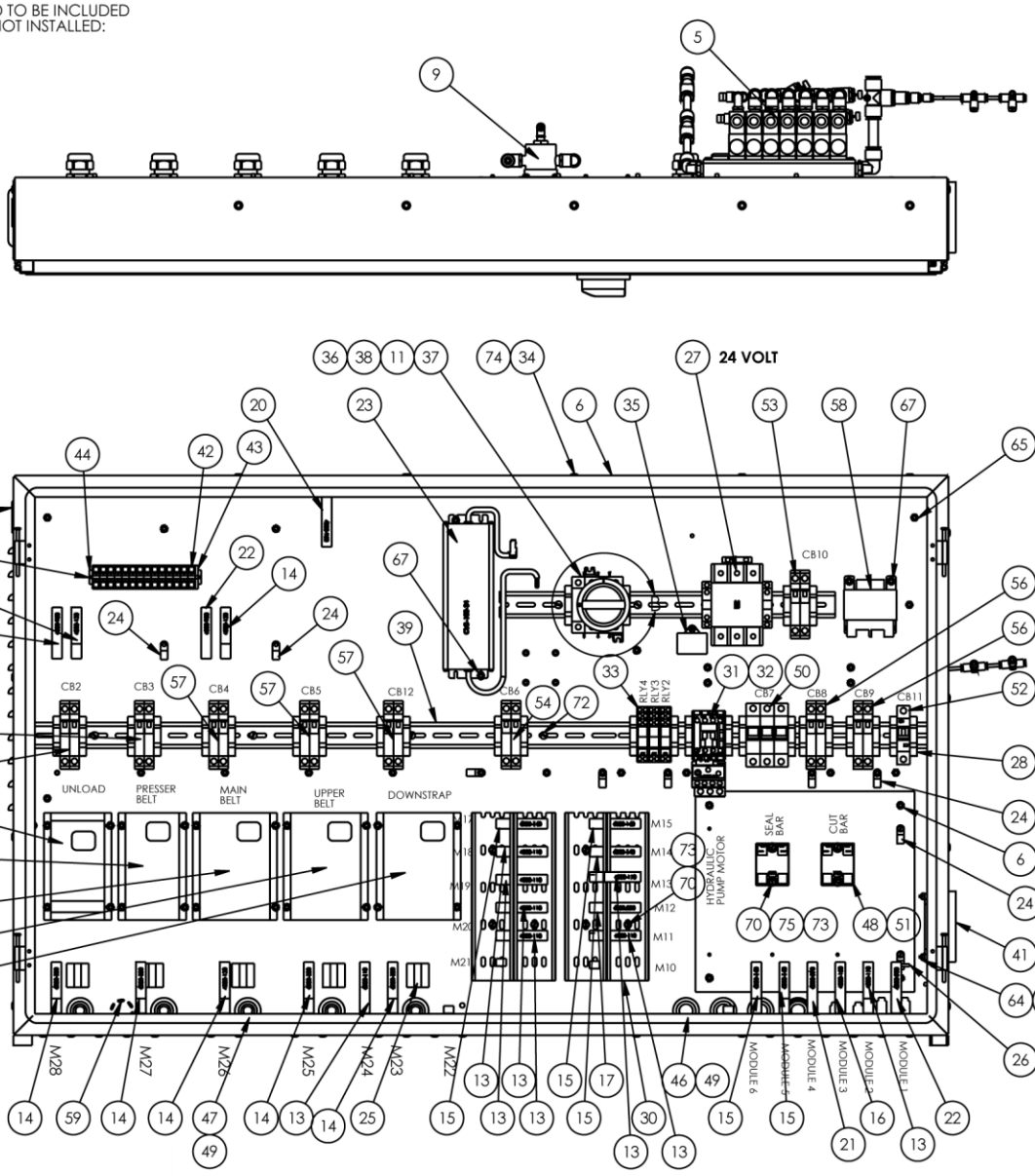
1306600 Idler Pulley Assembly

AAC Drawing Number 1306600 Rev0

NO.	QTY	PART #	DESCRIPTION
1	1	1306599	BRACKET,IDLER PULLEY
2	1	NNJ5/16-18	NUT,JAM,5/16-18
3	1	PP24XLB037M3	PULLEY,GEAR,1/5PITCH,IDLE
4	1	SSAS024064	SHULDER BOLT 3/8 X .1.00L

LABELS THAT NEED TO BE INCLUDED
WITH PANEL BUT NOT INSTALLED:

MODULE 7
MODULE 8
MODULE 9
MODULE 29
MODULE 30
MODULE 31
MODULE 32
MODULE 33



NOTE:

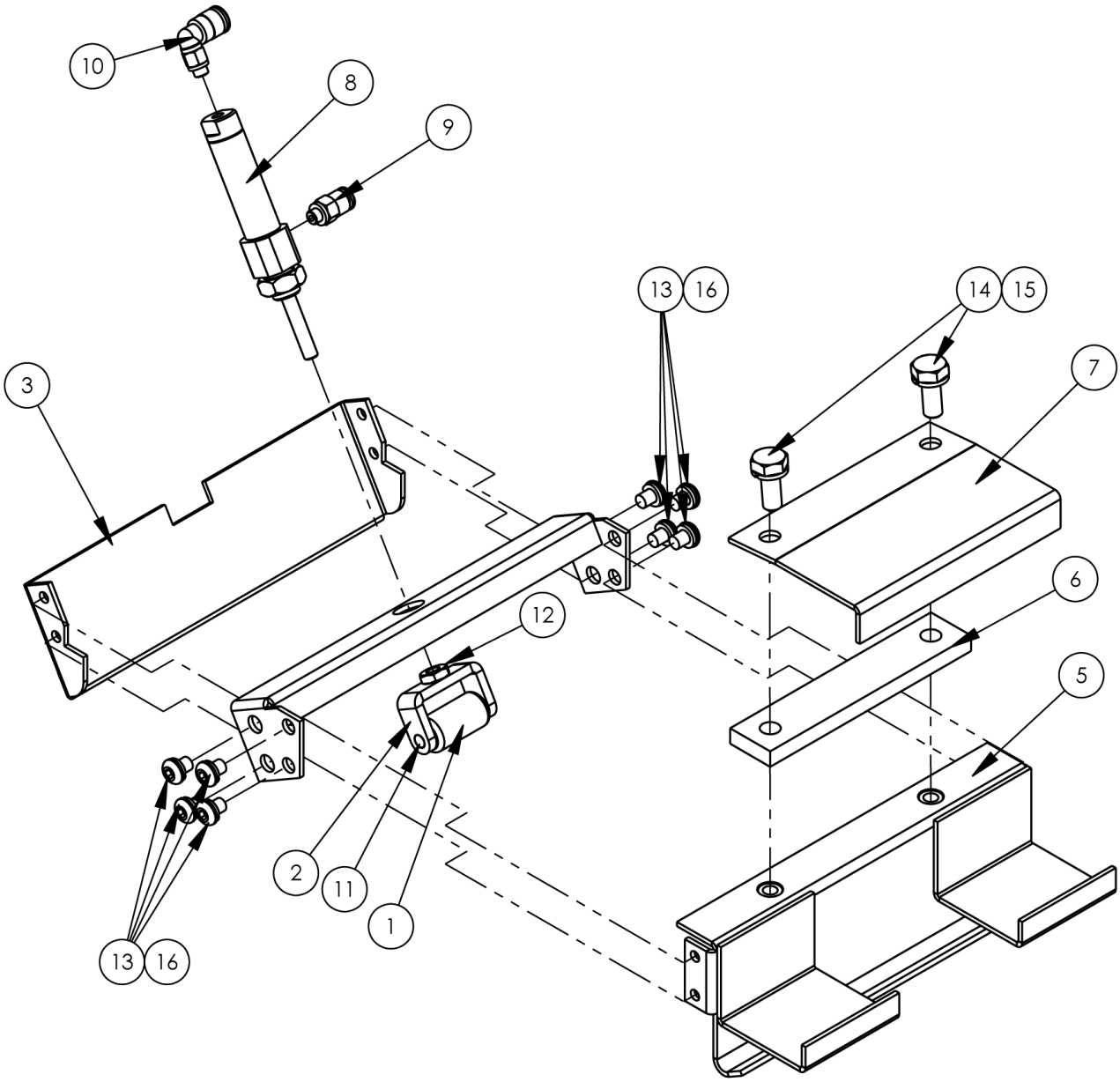
(31) EECN1116-NO HAS BEEN REPLACED WITH EEMC12B11

(32) EERHN1085A HAS BEEN REPLACED WITH EEMT32S8A

1306500 Control Box Assembly

AAC Drawing Number 1306500 Rev3

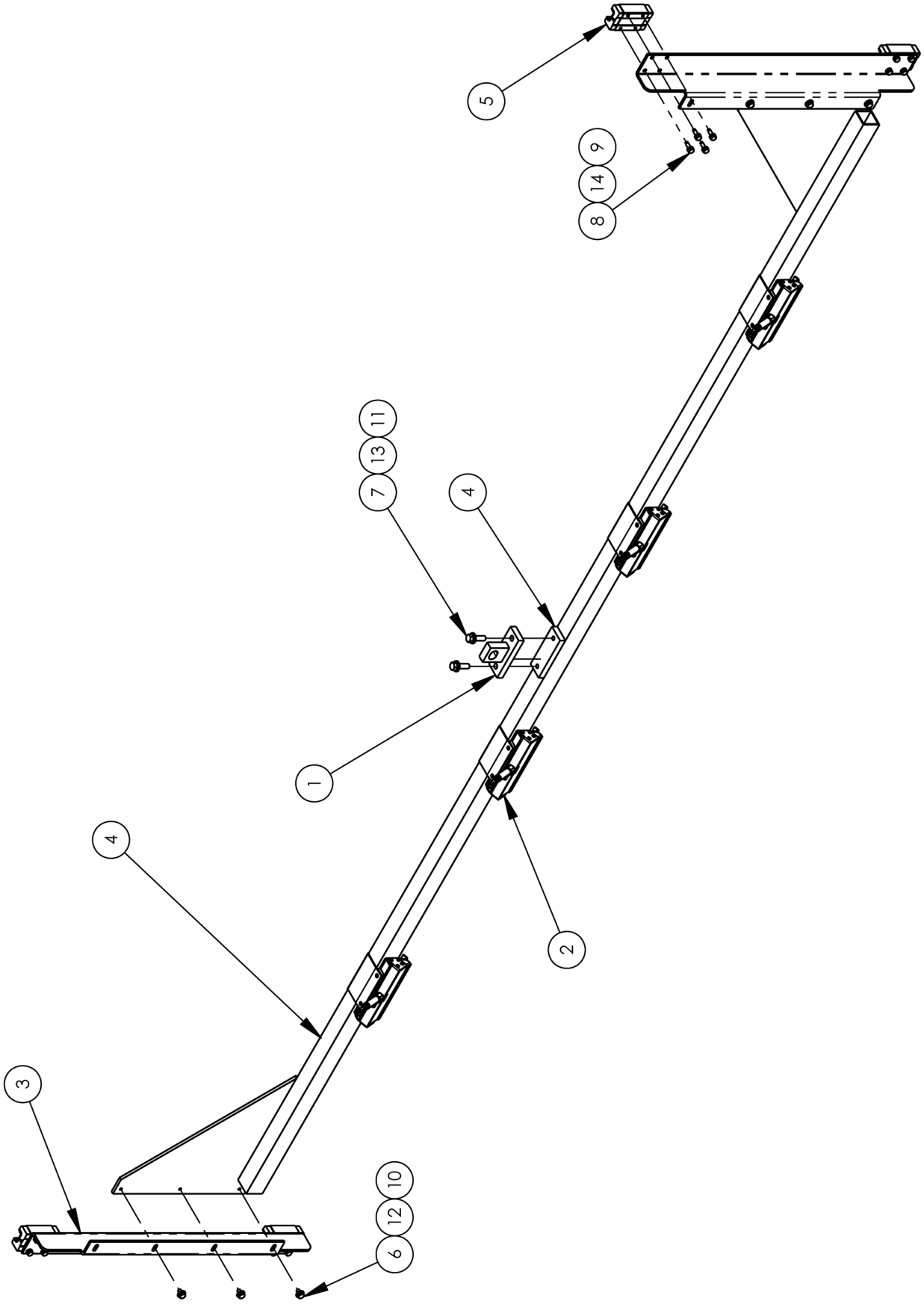
	NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
	1	3	12788-509A	JUMPER,OUTPUT,RESISTOR	39	1	EETS35X7.5A	DIN RAIL-EURO
Page 109	2	1	1306-PD	DIAGRAM,PNEUMATIC,1306	40	1	FF08174	FAN GUARD, 92MM, METAL
Page 106	3	1	1306-WD	DIAGRAM,WIRING,SBUS,1306	41	1	FF09362F30	FAN FILTER ASSY, 92MM
Page 108	4	1	1306-WD1	DIAGRAM,WIRING,CONT.BOX	42	14	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
Page 78	5	1	1306304	VALVE STACK ASSY, 7	43	1	FF264-371	TERMBLK,WAGO,TOP,END
	6	1	1306501	CONTROL BOX ASSM	44	1	FF264-3BKT6	MOUNT, WAGO TERMINAL
	7	1	1306513	CABLE KIT, 1306	45	2	FF264-3BKTS	STOP,MOUNT,WAGO TERMINAL
	8	1	1306514	ELECTRICAL KIT, 1306	46	4	FF3234	STRAIN RELIEF,LIQ TIGHT
Page 104	9	1	1306610	PILOT VALVE, ASSEMBLY	47	5	FF3460	STRAIN RELIEF,LIQ TIGHT
	10	2	1335-415	RESISTOR ARRAY	48	2	FF84140210M1	RELAY,SSR,24VAC,25A
	11	1	1391143	DISCONNECT SHAFT,MOD	49	9	FF8465	NUT,LOCK,3/4NPT,NYLON,BLK
	12	1	1391144	FAN - CONNECTOR ASSY	50	1	FFFAZD153NA	CIRCUIT BREAKER,UL489
	13	8	4080-110	MODULE,QUAD INPUT	51	2	FFHSP1	THERMAL PAD
	14	7	4080-130	MODULE,QUAD OPTO-ISO	52	1	FFL741C	CIRCUIT BREAKER,THERM-MAG
	15	5	4080-140	MODULE,QUAD OUTPUT	53	1	FFQL213DMKM02	CIRCUIT BREAKER,2A,2P
	16	1	4080-150	MODULE,PROGRAM	54	1	FFQL213DMKM05	CIRCUIT BREAKER,5A,2P
	17	1	4080-200	MODULE,AIR PRESSURE	55	1	FFQL213DMKM10	CIRCUIT BREAKER,10A,2P
	18	2	4080-250	MODULE,THERMOCOUPLE	56	3	FFQL213DMKM15	CIRCUIT BREAKER,15A,2P
	19	1	4080-4164	CABLE, BUS ASSY, 1306	57	3	FFQL213DMKM20	CIRCUIT BREAKER,THERM-MAG
	20	1	4080-950	MODULE,POWER	58	1	FFTX28/5A	TRANSFORMER,28V,4.6AMP
	21	1	4080-970	MODULE,MEMORY	59	1	MM8087K14	PLUG,KNOCK-OUT,3/4"
	22	3	4080-980	MODULE, ADAPTER	60	1	MM8087K16	PLUG,KNOCK-OUT,1"
	23	1	4080-990B	POWER SUPPLY, SBUS,	61	1	MMSL208S	DRIVE, VAR, FREQ. .75HP, 1PH
	24	9	AAF3/8	CLAMP, BLACK PLASTIC	62	1	MMSM210S	DRIVE,VARIABLE FREQUENCY
	25	5	EE64151B	FERRITE CORE,SPLIT,CABLE	63	3	MMSM220S	DRIVE, VARIABLE FREQ.
	26	20	EE6X752	TIE WRAP - Small.	64	5	NNE6-32	NUT,ELASTIC LOCK,6-32
	27	1	EECGC85A24	CONTACTOR,85A,24VAC	65	4	NNE8-32	NUT,ELASTIC LOCK, 8-32
	28	30	EECLIPFIX	ANCHOR,DIN RAIL	66	13	NNH8-32	HEX-NUT 8-32 REG.
	29	4	EEDC2X2	COVER,WIRE DUCT	67	38	NNK8-32	KEP NUT, 8-32
	30	4	EEDF2X2	DUCT,WIRE,2X2, MOD	68	4	SSFC80096	6-32 X 1-1/2 FT HD CAP
	31	1	EEMC12B11	CONTACTOR,IEC,230VAC	69	4	SSPP90020	SCREW,PHP #8-32X5/16
	32	1	EEMT32S8A	RELAY,OVERLOAD,5.0-8.0A	70	14	SSPS90024	#8-32 X 3/8 LG PAN HD
	33	3	EEP18524DC	RELAY, INTERFACE 24VDC, 1	71	4	SSPS90080	#8-32 X 1-1/4 PAN HD
	34	56	EEPBMSH25C	MOUNT,CABLE TIE,NYLON	72	10	SSPS98024	10-32X3/8 PAN HD SLOT
	35	1	EERCM601BUZ4	PROTECTOR, SURGE	73	16	WWF8	WASHER, FLAT, #8
	36	1	EESD2080RR	DISCONNECT, 3 POLE, 80A, IEC	74	40	WWFM6	WASHER, FLAT, M6, SAE
	37	1	EESD2GP	DISCONNECT PE,80A	75	4	WWSB8	WASHER,BELVEL,#8
	38	1	EESDHRY	DISCONNECT HANDLE, RED/YEL				



1306568 Gripper Clamp

AAC Drawing Number 1306568 Rev0

NO.	QTY	PART #	DESCRIPTION
1	1	1306569	ROLLER,CLAMP
2	1	1306571	CLEVIS,ROLLER,CLAMP
3	1	1306572	BRACKET,GUIDE,CLAMP
4	1	1306573	MOUNT,CYLINDER,BRACKET
5	1	1306578	WELDMENT,MOUNT,CLAMP
6	1	1306581	SPACER,MOUNT,CLAMP
7	1	1306582	PLATE,MOUNT,CLAMP
8	1	AAC8S-.5	CYLINDER,AIR,SA
9	1	AAQMC-5-10	QUICK MALE CONNECT
10	1	AAQME-5-10	ELBOW, MALE,5/32X10-32
11	1	IID012X080	DOWEL PIN,3/16 X 1 1/4
12	1	NNJ10-32	NUT,JAM,THIN #10-32
13	8	SSBC98016	10-32 X 1/4 BUTTON CAP SC
14	2	SSHC01040	1/4-20 X 5/8 HHCS
15	2	WWL1/4	WASHER,LOCK,1/4
16	8	WWL10	WASHER,LOCK,#10,S/S



1306583 Clamp Assembly

AAC Drawing Number 1306583 Rev1

NO.	QTY	PART #	DESCRIPTION
1	1	1306113	CROSS SEAL CYL. MNT
2	4	1306568	CLAMP,GRIPPER
3	2	1306577	MOUNT,BEARING,CLAMP BAR
4	1	1306580	CROSS BAR,MOUNT,CLAMP
5	4	MMAGH25CAN	LINEAR BEARING
6	6	SSHC01032	1/4-20 X 1/2 HHCS
7	2	SSHC25080	3/8-16 X 1-1/4 HEX CAP
8	16	SSHCM6X16	SCREW, HEX M6X16
9	16	WWFM6	WASHER, FLAT, M6, SAE
10	6	WWFS1/4	WASHER,FLAT,SAE,1/4
11	2	WWFS3/8	WASHER,FLAT,SAE,3/8
12	6	WWL1/4	WASHER,LOCK,1/4
13	2	WWL3/8	WASHER, LOCK, 3/8
14	16	WWLM6	M6 LOCK WASHER

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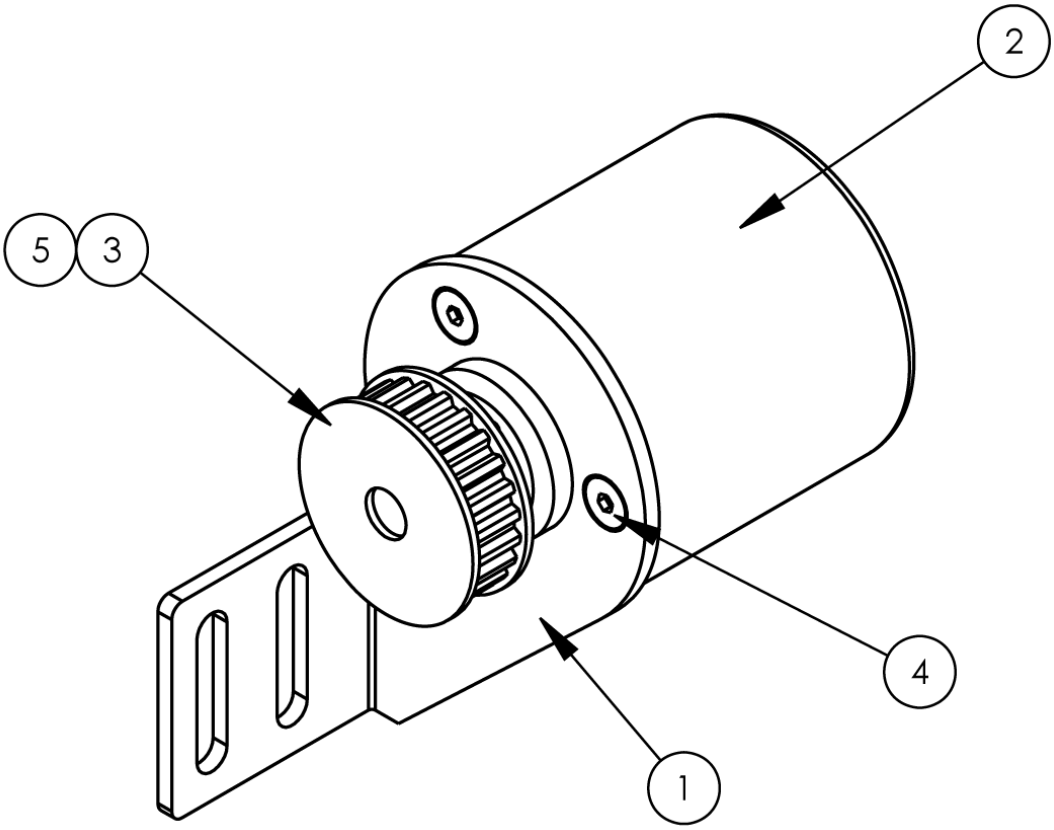
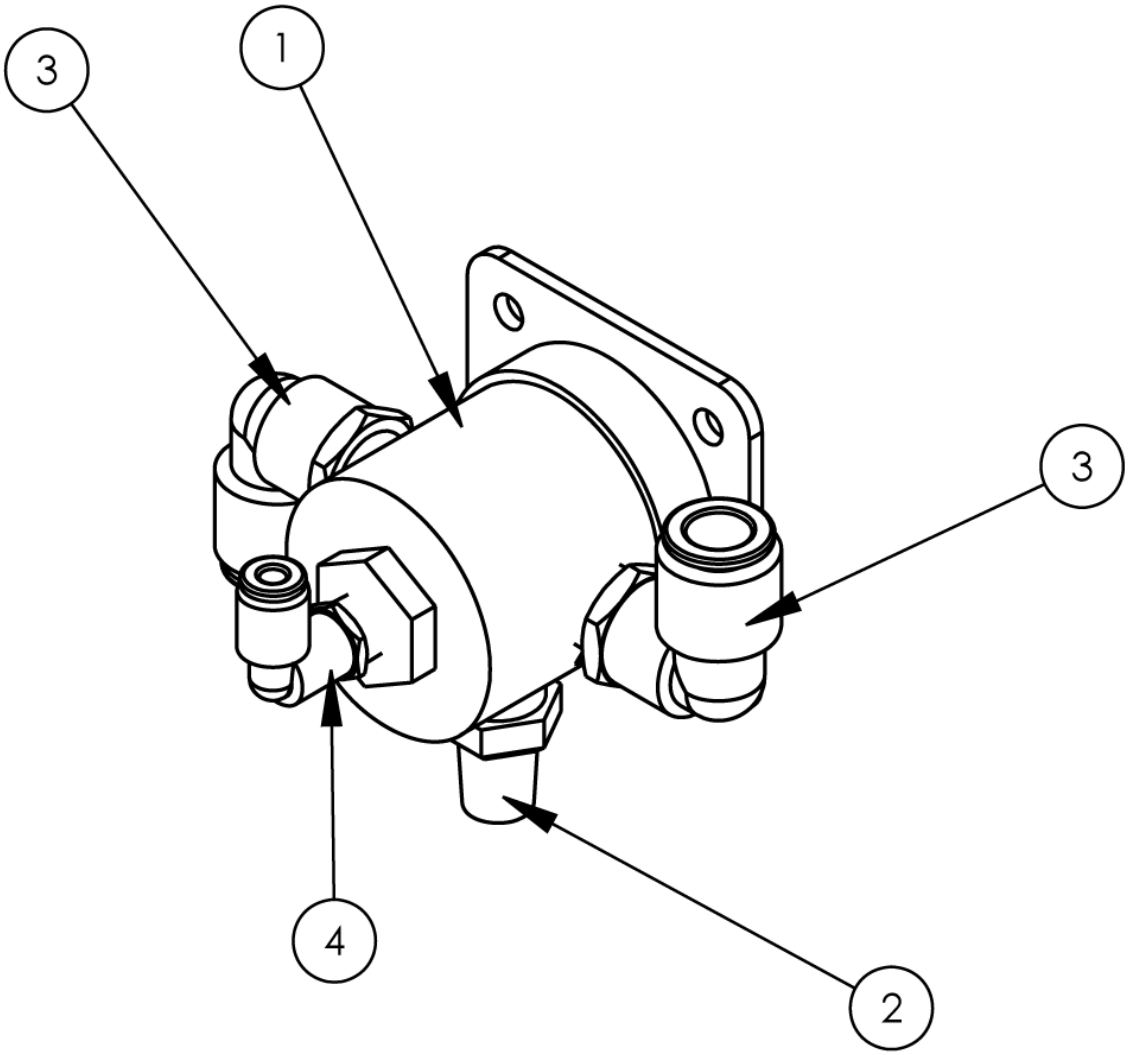


1306601 Position Encoder Assembly

AAC Drawing Number 1306601 Rev1

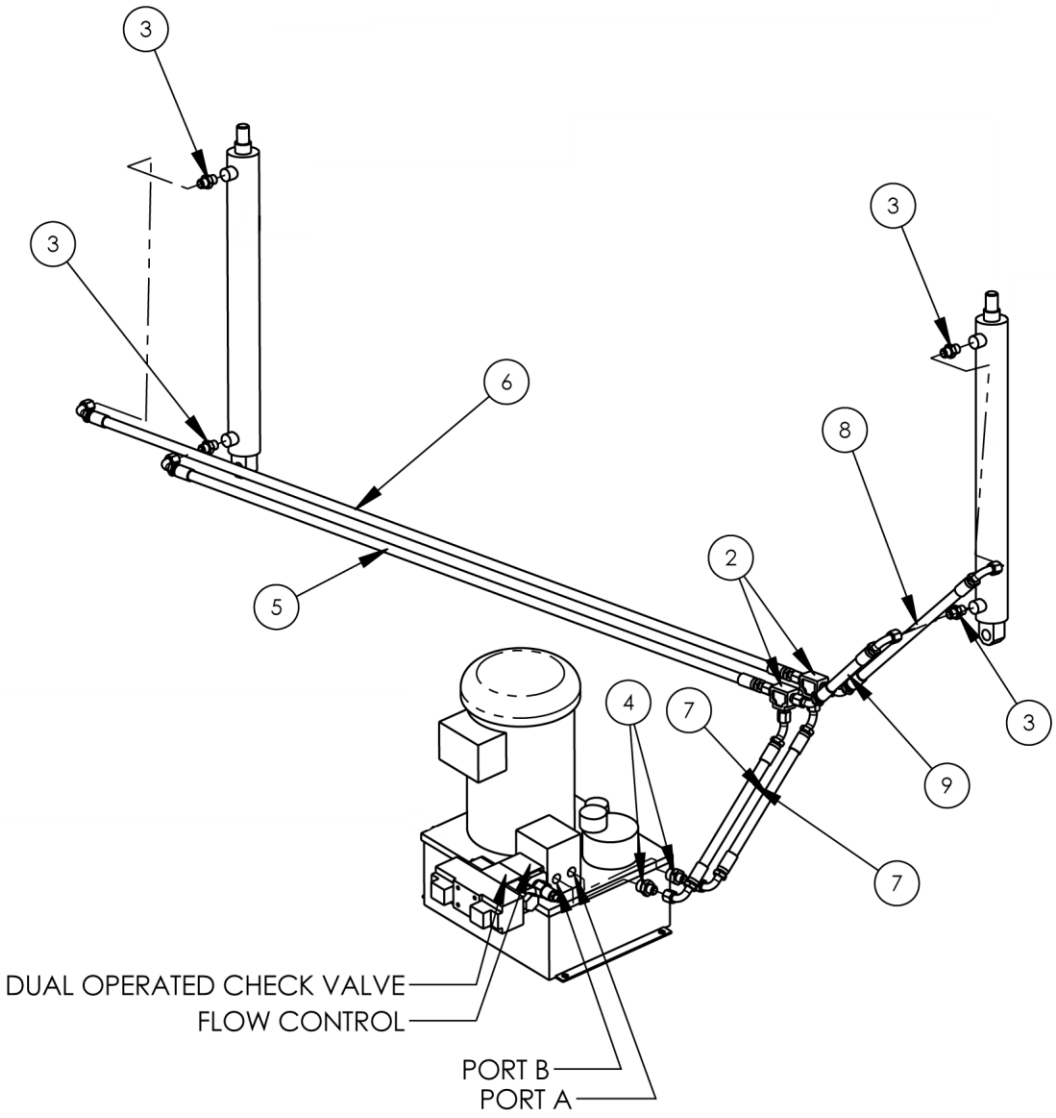
NO.	QTY	PART #	DESCRIPTION
1	1	1306598	BRACKET,ENCODER MOUNT
2	1	1953-405	ENCODER, W/PLUG
3	1	PP24XLB37M1	PULLEY, GEAR,1/5 PITCH
4	3	SSFC98024	#10-32 X .375 FLAT CAP
5	2	SSSS90016	#8-32 X 1/4 SET SCREW



1306610 Pilot Valve Assembly

AAC Drawing Number 1306610 Rev0

NO.	QTY	PART #	DESCRIPTION
1	1	AAV250A	PILOT VALVE
2	1	AAFP28	MUFFLER,1/4 NPT
3	2	AAQME-3-4	MALE ELBOW 3/8OD TUBE
4	1	AAQME-5-8	QUICK MALE ELBOW

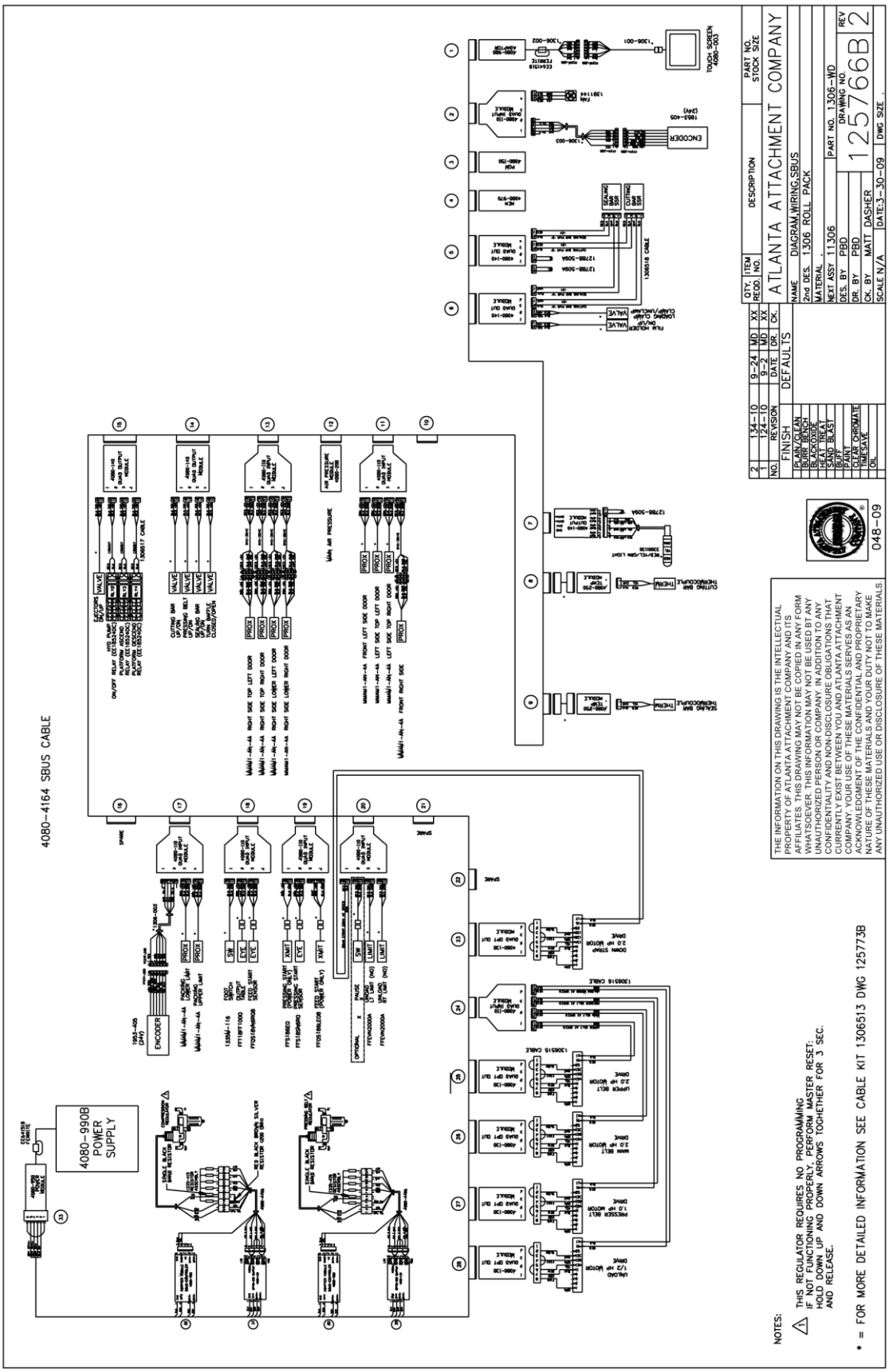


1306614 Hydraulic Power Package

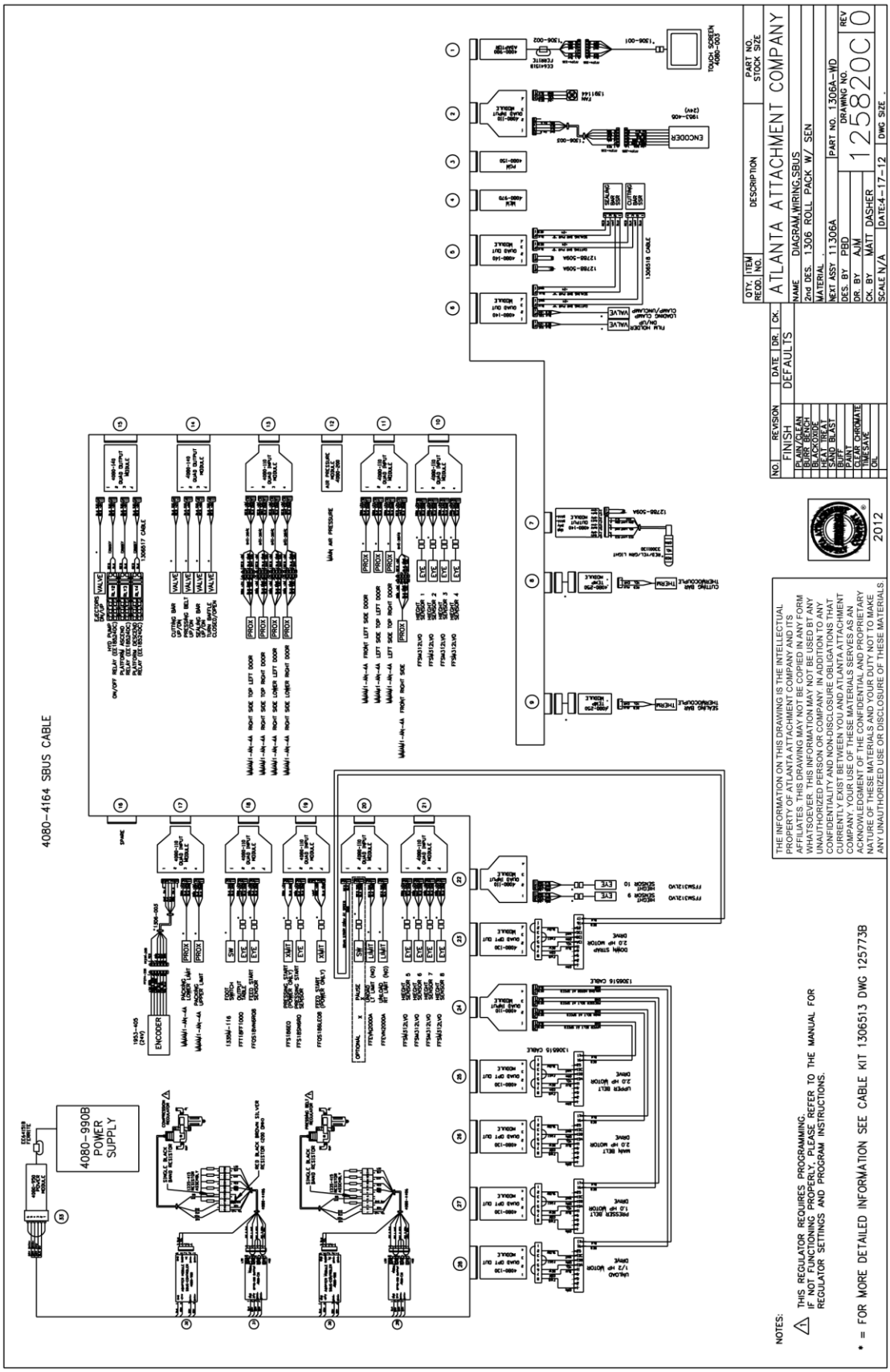
AAC Drawing Number 1306614 Rev1

NO.	QTY	PART #	DESCRIPTION
1	2	HC251510PP14	CYL,HYD,1.5"B,1.0"R,14"S
2	2	HF033T0606	TEE, 9/16-18 M-JIC, #6
3	4	HF20270266S	FITTING,HYD,STR,O-RING
4	2	HF64000608	FITTING,HYD,STR,O-RING
5	1	HH42246690105	HYD HOSE,105",6X6X90X1/4
6	1	HH42246690123	HYD HOSE,123",6X6X90X1/4
7	2	HH422466904519	HYD HOSE,19",45X90X1/4T
8	1	HH422466904526	HYD HOSE,26",45X90X1/4
9	1	HH42246690458	HYD HOSE,8",45X90X1/4
10	1	HYMG2A	HYD PUMP,2GAL/MIN,2HP,3PH

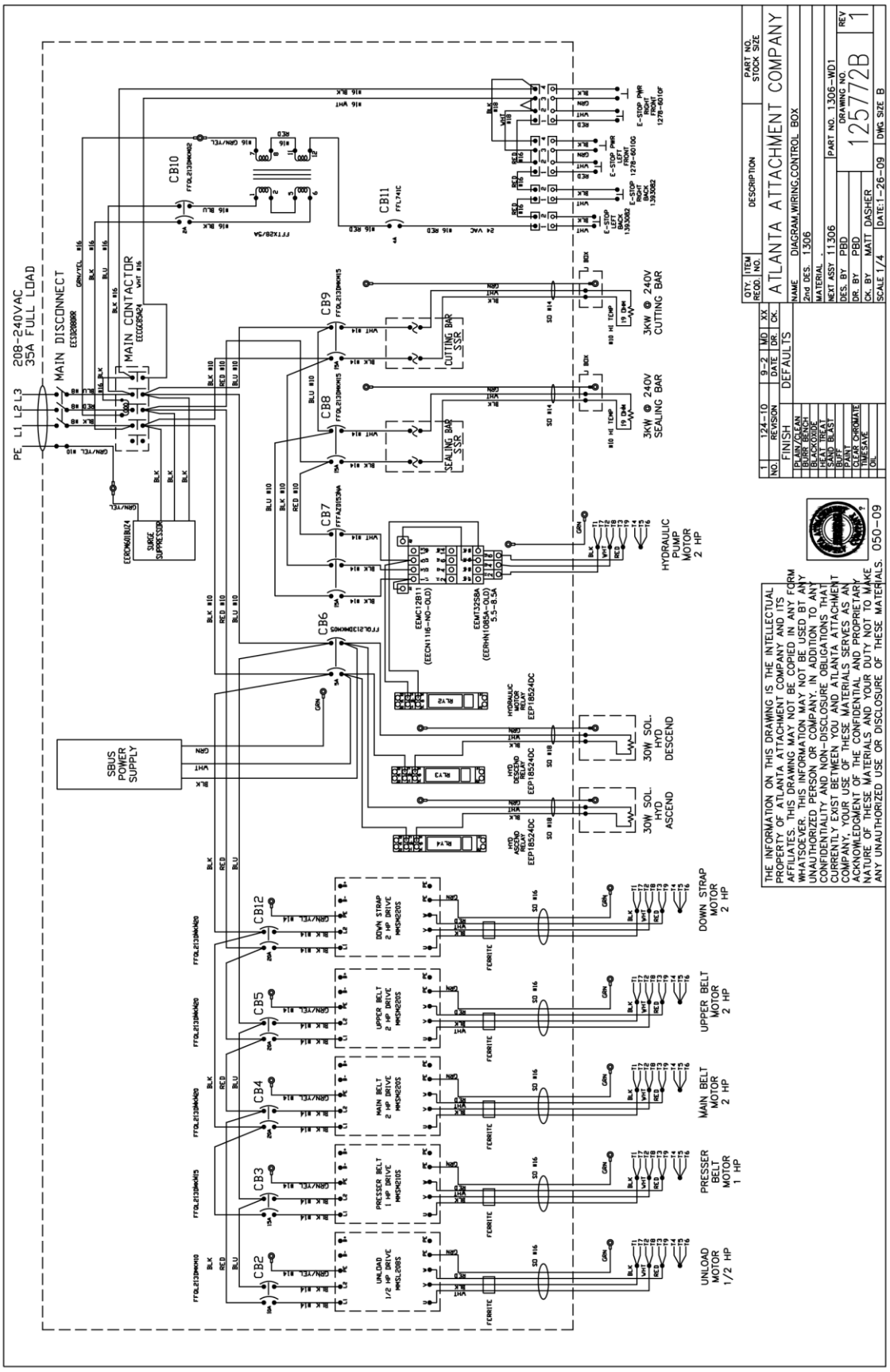
1306-WD Wiring Diagram/SBUS



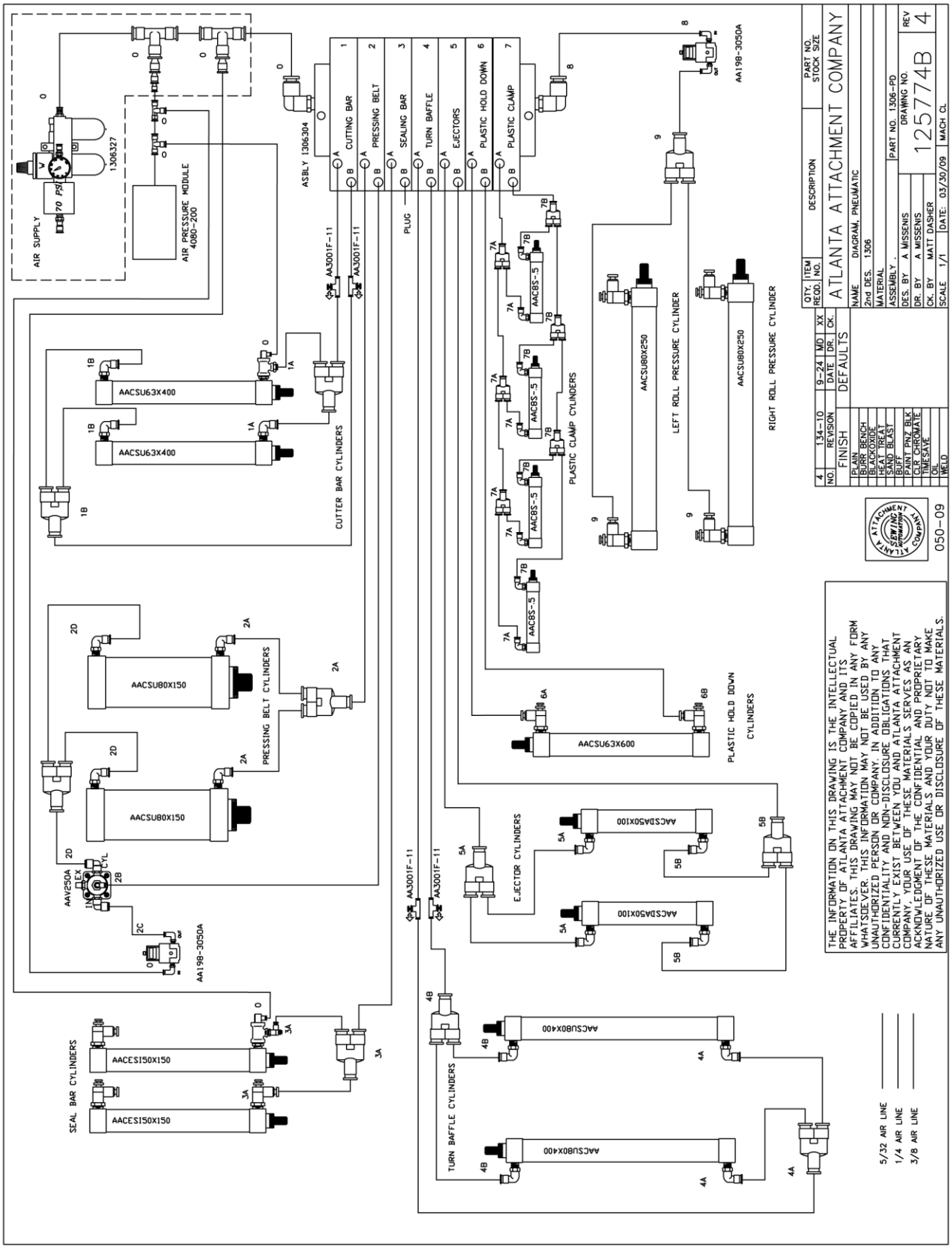
1306A-WD Wiring Diagram, SBUS



1306-WD1 Wiring Diagram/ CONTROL BOX



1306-PD Pneumatic 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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