Model **1315A**

Revision 3.1 Updated Aug 29, 2012

# Technical Manual & Parts Lists



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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 1959 Automatic Handle 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.

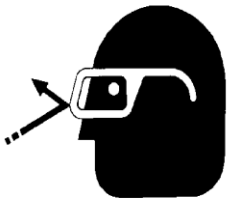
## Faults or Errors

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.

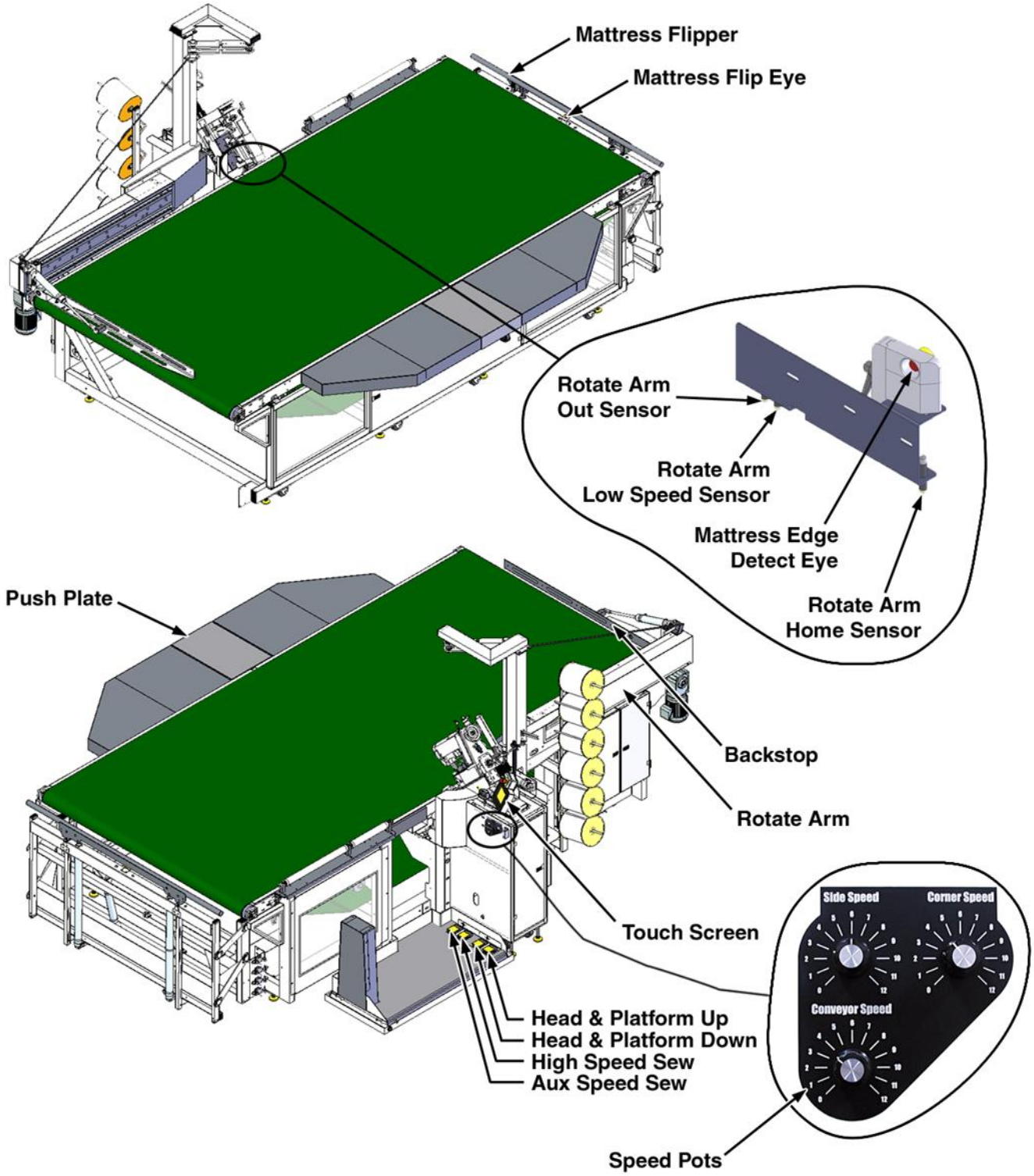
Operator's position must always be readily accessible. Escape routes must always be kept clear and safety areas should be identified.

# 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 maintain a safe distance from people when operating.
- 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.

# Component Identification



# General Machine Data

## Electrical & Pneumatic Specifications

| | |
|---|---|
| Electrical: | 220 VAC, 5amp, 50/60 Hz Single Phase |
| Pneumatic: | Main Air - 80 PSI, 5 SCFM avg. (3/8" supply line) |
| | Belt Tension - 40-50 PSI |
| Sewing Head: | Singer 300UX5 |
| Sewing Speed: | 3000 RPM |
| Needle (Standard): | SN62X8524 |
| Stitch Density: | 5-6 SPI |

## Basic Machine Operation

The operator loads a mattress and covers the Mattress Edge Detect Eye. The machine will not sew unless the eye is covered.
The Footlift Touch Switch is used to raise the foot for loading a mattress. The machine will not sew if the footlift output is on. If the sew pedals are pressed while the foot is up, the conveyor will run at forward Aux speed or forward High speed.
There are four pedals that can be used: Aux Speed Sew, High Speed Sew, Head & Platform Down and Head & Platform Up.

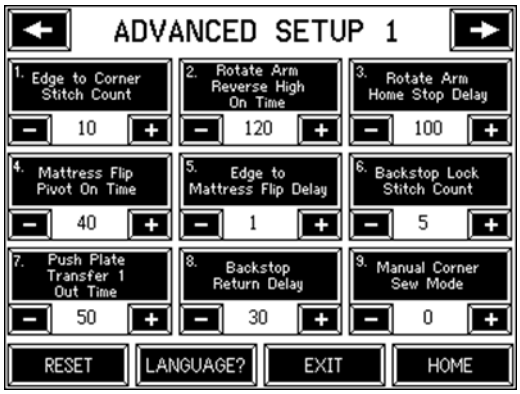
- The Aux Speed Sew pedal runs the sew head at a preset speed set in the Efka motor and the conveyor will run at a preset speed set in the conveyor inverter. This pedal can be used to finish sewing off a mattress when the binding is overlapped or for sewing difficult mattresses at a slower speed.
- The High Speed Sew pedal runs the sewing head at high speed and the conveyor moves forward at medium (sew) speed.
- The Head & Platform Up and Down pedals are used to adjust the height of the sewing head and operator to the thickness of mattress being sewn.

There are three speed pots located on the side of the sewing head console: Side Speed, Corner Speed and Conveyor Speed.

- The Side Speed pot is used to adjust only the speed of the sew head while sewing at high speed down the side of a mattress.
- The Corner Speed pot is used to adjust only the speed of the sewing head while sewing at low speed during the corner rotation.
- The Conveyor Speed pot is used to adjust only the speed of the conveyor while sewing down the side of a mattress.


The operator starts sewing in the middle of the foot end of the mattress. As the mattress approaches a corner, the Mattress Edge Detect Eye detects the edge of the mattress which starts the **Edge to Corner Stitch Count** setting. This setting decides how many stitches are sewn after the eye is uncovered before the mattress is rotated for corner sewing. The **Backstop Lock Stitch** Count setting is also used during this time to lock the Backstop in place a few stitches before the mattress is rotated for

corner sewing. This setting ensures that the mattress is tight against the Backstop before the mattress is rotated.




After the **Edge To Corner Stitch Count** is reached, the head switches to a corner sew speed (low), the conveyor moves forward at low speed and the Rotate arm turns on in a forward medium speed. Everything stops if the operator releases the sew pedal.

Once the Rotate Arm Low Speed Sensor is reached, the Rotate Arm switches into a forward low speed until the Rotate Arm Out Sensor is reached which automatically sends the Rotate Arm home.
The Rotate Arm then goes toward home in a reverse high speed for the length of the **Rotate Arm Reverse High On Time** setting. As the Rotate Arm starts home, the **Backstop Return Delay** is also turned on which delays the timing of when the Backstop transfer cylinder is sent home. This setting delays the Backstop from going home until it is clear of the mattress.

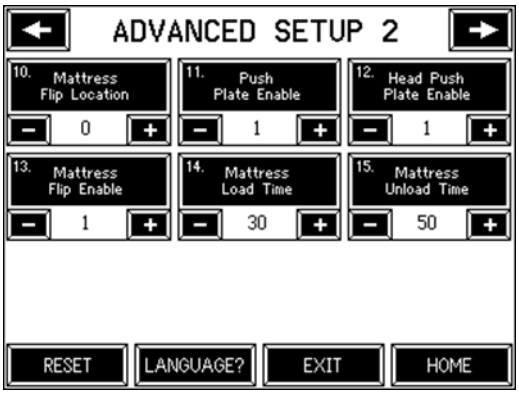
Once the **Rotate Arm Reverse High On Time** setting is reached. The arm is then switched into reverse low speed. The arm continues to move in reverse low speed until the Rotate Arm Home Sensor is reached. The **Rotate Arm Home Stop Delay** then starts which allows for adjusting the arm to stop parallel to the conveyor. Sewing resumes at high speed once the Rotate Arm Home Sensor is reached.

After all 4 corners are sewn and the binding is overlapped and finished off, the operator sews off the mattress and trims the thread with scissors.

The operator then pushes the Mattress Flip Cycle button to start the flipping cycle.
The first thing that happens during the flip cycle is the head push plate cylinder extends which pushes the mattress away from the head for flipping. Once the head push plate out sensor is reached, the conveyor turns on to move the mattress toward the mattress flipper.

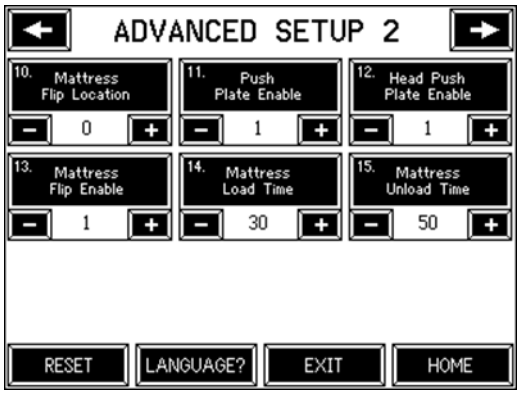
If the **Mattress Flip Location** setting is set to "0" (infeed) the conveyor moves the mattress in the reverse direction toward the Mattress Flipper. If the Setting is set to "1" (outfeed) the conveyor waits until the Backstop is raised and then the conveyor moves the mattress in the forward direction toward the Mattress Flipper.

The Mattress Flip Eye detects the end of the mattress and turns on the **Edge to Mattress Flip delay**. If the Flip Eye does not see the mattress within 5 seconds, the conveyor turns off.




After the **Edge to Mattress Flip Delay** is reached the Mattress Flip Lift solenoid turns on which extends the mattress flip lift cylinders. The Mattress Flip Lift sensor is then reached approx. half way up on the lift cylinders, which turns on the Mattress Flip Pivot solenoid and the **Mattress Flip Pivot On Time** setting. Once the **Mattress Flip Pivot On Time** setting times out, the Mattress flip pivot and lift cylinders retract and the conveyor turns off.

After the flip cycle has been completed the operator uses the High Speed Sew pedal to bring the mattress back to the middle of the conveyor. If the **Mattress Flip Location** setting is set to "0" the conveyor pedal will move the conveyor in the forward direction or if the setting is set to "1" the conveyor pedal will move the conveyor in the reverse direction. Once the operator releases the foot pedal, the push plate cycle is then initiated. During the flipping cycle, the Push Plate transfer 1 cylinder is extended. (if the **Push Plate Enable** setting is disabled, the transfer cylinder will not extend during the flipping cycle)




After the Push plate cycle is initiated, the Push plate lift cylinders extend until the lift sensor is true. Once the sensor is true, the Push plate transfer 1 cylinder retracts and the Push plate transfer 2 cylinder extends. The software now looks at the Mattress edge detect eye to see that the mattress has been pushed all the way back to the sewing head.

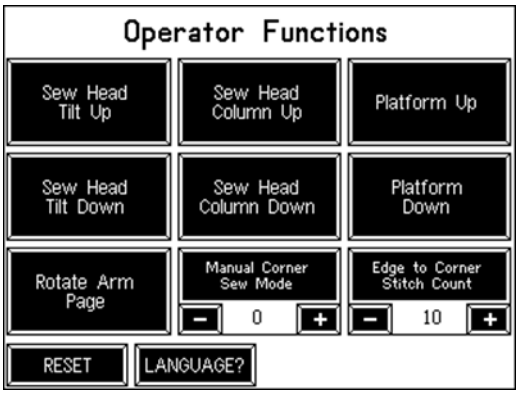
Once the Mattress edge detect eye is covered for a short time, the Push plate transfer 2 cylinder retracts until the Push plate transfer 2 retract sensor is true. The Push plate lift cylinders are now retracted to lower the Push plate tray.

The operator is now ready to sew the other side of the mattress.

## Notes:

1. There is also a **Manual Corner Sew Mode** setting that can be enabled. If this setting is enabled it allows the operator to choose when to rotate for corner sewing instead of using the mattress edge detect eye. Once the eye uncovers, the sewing head and

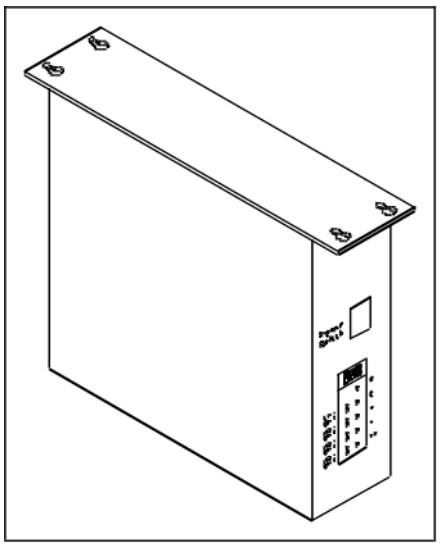
conveyor stop. The operator can now use the Head & Platform Down pedal to sew in low speed to allow the operator to accurately stop where they want to rotate. Once the operator reaches the point where they want to rotate they can now use the High Speed Sewing pedal to start the rotate for corner sewing.




2. The operator can use the buttons on the Operator Functions page to adjust the Sew Head Column, Sew Head Tilt and the Operator Platform individually for the correct ergonomic height relationship between the operator and the sewing head. After this is set, the operator can now use the Head & Platform Up and Down pedals to move the platform and the sew head up and down together for adjustment between different thickness mattresses.

# Efka Control Box

The sewing machine is powered by the Efka motor controller. It has its own on/off switch which should be left on at all times. It also has some small buttons and LED's on the front to indicate the enabled functions. The only LED that should be on is the second to last from the bottom which sets the control to stop the machine needle down at neutral treadle and needle up after full heal back. The functions can be changed upon power up or after a full heal back. The control box has been programmed to operate specifically with the 1315A unit. If the box is later replaced, the new box will need to be programmed according to the included parameter list in order to function properly. Notice that the sewing head does not stop at normal needle up (lockstitch heads) position after full heal back, but stops at needle top dead center to allow more room for loading thicker material



# General Machine Maintenance

## Daily

- Clean machine at the end of every shift.
- Clean lint etc. from the looper area on the sewing head.
- Remove any threads wrapped around moving parts.
- Wipe all photo eye lenses with a clean nonabrasive dry cloth.
- Use a blow-off hose to get rid of excess lint, thread and other clippings.
- Open conveyor door and inspect belt for debris and remove with broom or air hose.
- Follow manufactures recommendations and guidelines for daily maintenance and lubricating of sewing head.

## Weekly

- Check sewing head drive belt for tightness and condition.
- Inspect reflective tape on handwheel and replace if dirty or worn.
- Inspect conveyor bearings and remove thread and debris if needed.

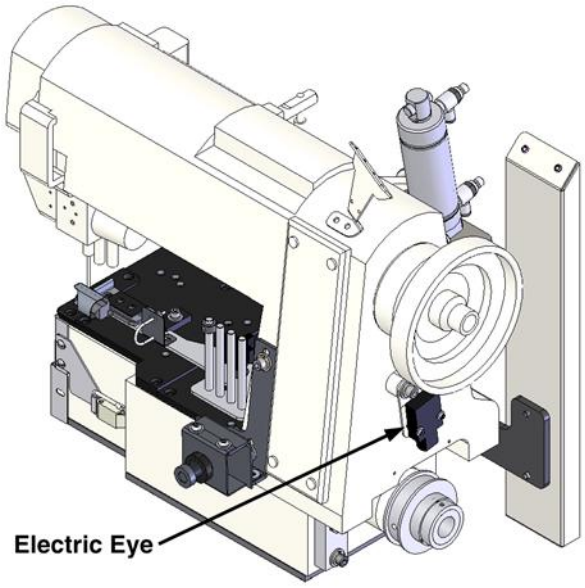
## Monthly

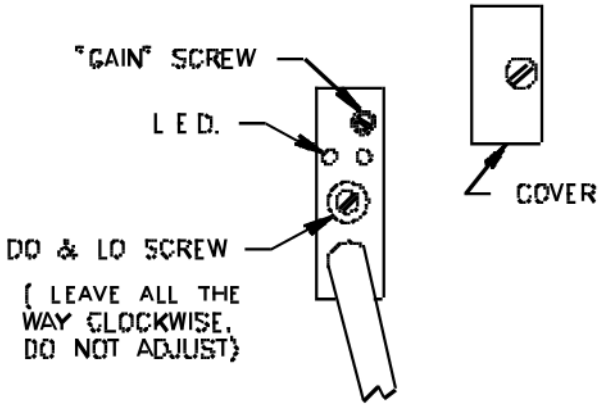
- Inspect conveyor bearings and apply one shot of bearing grease to each bearing as needed.

# Electric Eye Sensor Adjustment

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

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




# Reflective Tape Maintenance

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

# Efka Parameter Settings (Sewing Head Motor)

## Programming Instructions

Power on holding down the “P” button until “COD” is displayed.
Press “>>” once and enter the number “311”
Press “E” once and “2.0.0” is displayed. This is a parameter.
Proceed to the parameter to be changed and press “E”.
The value now shows in the screen. Adjust to desired value.
Press “E” to enter value and continue with parameter setting.
Repeat for other parameters. Press “P” one time when complete.
Run sewing head to save parameters before powering down.

## To Perform Master Reset of Parameters

Power on holding down the “P” button until “COD” is displayed.
Press “>>” one time and enter the number “591”
Press “E” twice and “093” is displayed.
Press “+” once, “094” is displayed.
Press “P” to exit programming mode with all default values.

| Parameter | Range | Value | Description |
|---|---|---|---|
| 290 | 0-26 | 5 | Mode of Operation. MUST BE SET FIRST! |
| 111 | 400-9900 rpm | 320 | Maximum side speed. |
| 112 | 200-9900 rpm | 20 | Minimum corner speed. |
| 113 | 200-9900 rpm | 100 | Maximum corner speed. |
| 114 | 400-9900 rpm | 150 | Auxiliary sewing speed. |
| 124 | 200-9900 rpm | 990 | Maximum possible for minimum side speed. |
| 125 | 200-9900 rpm | 200 | Minimum side speed. |
| 153 | 0-50 | 35 | Braking power at machine stand still. |
| 161 | 0-1 | 0=CW | Motor Rotation |
| 202 | 0-500 | 500 | Sew start delay after footlift off. |
| 204 | 1-100 | 100 | Holding power of footlift (disables footlift chopping). |
| 219 | 20090 | 35 | Braking power at stop of the drive. |
| 220 | 20090 | 5 | Sew start acceleration of the drive. |
| 224 | 0-1 | 0 | Speed gate 2 on/off |
| 270 | 0-5 | 1 | External handwheel sensor configuration. |
| 271 | 0-255 | 165 | Ref angle for Pos 1 (ndl down) from Pos 2 (ndl up tape) |
| 272 | 020-255 | 100 | Drive ratio between motor pulley and handwheel pulley. If handwheel pulley is smaller than motor pulley, increase this value to slow down sewing head until measured speed matches speed set with parameter 111. (For Yamato and Pegasus, setting should be 100; for Rimoldi, setting should be 124) |
| 436 | | 0 | Use code "5913". This disables an input that was causing box to reset itself. |

Front Panel LED’s:
LED 1-6: Off, LED 7: On, Stop at needle down, LED 8: Off

# Programming ACTech SCL/SCM Drive

The drive is already programmed** with settings specifically for the 1315A unit by Atlanta Attachment Co. These settings are listed in the chart on the following page. Password protection is currently disabled so that control of the parameters is immediately available to the user. After the controller settings have been "fine-tuned", you can use parameter 44 to set a password value between 1-999 to "lock" the control setting for the motors. (See page 23 of the ACTech manual).

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

**In the event the controller has not been programmed by AAC, the default password from the factory is 225. See page 23 of the ACTech manual and the tables on the following pages for detailed programming instructions.

# Conveyor Motor Parameter Menu

AAC custom setting shown in last column.

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

| NO. | PARAMETER NAME | RANGE OF ADJUSTMENT | FACTORY DEFAULT | AAC SETTINGS |
|---|---|---|---|---|
| 17 | ROTATION | FORWARD ONLY (01), FORWARD AND REVERSE (02) | FORWARD ONLY (01) | 02 |
| 19 | ACCELERATION TIME | 0.1 - 3600.0 SEC | 20.0 SEC | 1.0 |
| 20 | DECELERATION TIME | 0.1 - 3600.0 SEC | 20.0 SEC | 1.0 |
| 21 | DC BRAKE TIME | 0.0 - 3600.0 SEC | 0.0 SEC | 2.0 |
| 22 | DC BRAKE VOLTAGE | 0.0 - 30.0% | 0.0 % | 30.0 |
| 23 | MINIMUM FREQUENCY | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 24 | MAXIMUM FREQUENCY | MINIMUM FREQUENCY - 240 Hz | SCL = 50.0 Hz SCM = 60.0 Hz | --- |
| 25 | CURRENT LIMIT | 30 - 180 % | 180 % | --- |
| 26 | MOTOR OVERLOAD | 30 - 100 % | 100 % | --- |
| 27 | BASE FREQUENCY | 25.0 - 500 Hz | SCL = 50.0 Hz SCM = 60.0 Hz | --- |
| 28 | FIXED BOOST | 0.0 - 30.0 % | 1.0 % | 5.3 |
| 29 | ACCEL BOOST | 0.0 - 20.0 % | 0.0 % | --- |
| 30 | SLIP COMPENSATION | 0.0 - 5.0 % | 0.00 % | --- |
| 31 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 32 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | 5 |
| 33 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | 60 |
| 34 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 35 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 36 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | 12 |
| 37 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 38 | SKIP BANDWIDTH | 0.0 - 10 Hz | 0.0 Hz | --- |
| 39 | SPEED SCALING | 0.0 - 6500.0 | 0.0 | --- |
| 42 | ACCEL/DECEL #2 | 0.1 - 3600.0 SEC | 20.0 SEC | --- |
| 44 | PASSWORD | 000 - 999 | 225 | *000 |
| 45 | SPD AT MIN SIGNAL | MINIMUM FREQUENCY - 999 Hz | 0.0 Hz | --- |
| 46 | SPD AT MAX SIGNAL | MINIMUM FREQUENCY - 999 Hz | SCL = 50.0Hz SCM = 60.0Hz | --- |
| 47 | CLEAR HISTORY | MAINTAIN (01), CLEAR (02) | MAINTAIN (01) | --- |
| 48 | PROGRAM SELECTION | USER SETTINGS (01), OEM SETTINGS (02), RESET OEM (03), RESET 60 (04), RESET 50 (05), TRANSLATE (06) | SCL = RESET 50 (05) SCM = RESET 60 (04) | --- |
| 50 | FAULT HISTORY | (VIEW ONLY) | (N/A) | --- |
| 51 | SOFTWARE CODE | (VIEW ONLY) | (N/A) | --- |
| 52 | DC BUS VOLTAGE | (VIEW ONLY) | (N/A) | --- |
| 53 | MOTOR VOLTAGE | (VIEW ONLY) | (N/A) | --- |
| 54 | LOAD VOLTAGE | (VIEW ONLY) | (N/A) | --- |
| 55 | 0-10 VDC INPUT | (VIEW ONLY) | (N/A) | --- |
| 56 | 4-20mA INPUT | (VIEW ONLY) | (N/A) | --- |
| 57 | TB STRIP STATUS | (VIEW ONLY) | (N/A) | --- |
| 58 | KEYPAD STATUS | (VIEW ONLY) | (N/A) | |
| * PASSWORD IS SET TO “000” WHICH DISABLES THE PASSWORD FUNCTION | | | | |

# Rotate Arm Motor Parameter Menu

AAC custom setting shown in last column.

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

| NO. | PARAMETER NAME | RANGE OF ADJUSTMENT | FACTORY DEFAULT | AAC SETTINGS |
|---|---|---|---|---|
| 17 | ROTATION | FORWARD ONLY (01),FORWARD AND REVERSE (02) | FORWARD ONLY (01) | 02 |
| 19 | ACCELERATION TIME | 0.1 - 3600.0 SEC | 20.0 SEC | 1.2 |
| 20 | DECELERATION TIME | 0.1 - 3600.0 SEC | 20.0 SEC | 1.2 |
| 21 | DC BRAKE TIME | 0.0 - 3600.0 SEC | 0.0 SEC | 2.0 |
| 22 | DC BRAKE VOLTAGE | 0.0 - 30.0% | 0.0 % | 30.0 |
| 23 | MINIMUM FREQUENCY | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 24 | MAXIMUM FREQUENCY | MINIMUM FREQUENCY - 240 Hz | SCL = 50.0 Hz SCM = 60.0 Hz | --- |
| 25 | CURRENT LIMIT | 30 - 180 % | 180 % | --- |
| 26 | MOTOR OVERLOAD | 30 - 100 % | 100 % | --- |
| 27 | BASE FREQUENCY | 25.0 - 500 Hz | SCL = 50.0 Hz SCM = 60.0 Hz | --- |
| 28 | FIXED BOOST | 0.0 - 30.0 % | 1.0 % | 4.4 |
| 29 | ACCEL BOOST | 0.0 - 20.0 % | 0.0 % | --- |
| 30 | SLIP COMPENSATION | 0.0 - 5.0 % | 0.00 % | --- |
| 31 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | 15 |
| 32 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | 35 |
| 33 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | 60 |
| 34 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 35 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 36 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 37 | PRESET SPEEDS | 0.0 - MAXIMUM FREQUENCY | 0.0 Hz | --- |
| 38 | SKIP BANDWIDTH | 0.0 - 10 Hz | 0.0 Hz | --- |
| 39 | SPEED SCALING | 0.0 - 6500.0 | 0.0 | --- |
| 42 | ACCEL/DECEL #2 | 0.1 - 3600.0 SEC | 20.0 SEC | --- |
| 44 | PASSWORD | 000 - 999 | 225 | *000 |
| 45 | SPD AT MIN SIGNAL | MINIMUM FREQUENCY - 999 Hz | 0.0 Hz | --- |
| 46 | SPD AT MAX SIGNAL | MINIMUM FREQUENCY - 999 Hz | SCL = 50.0Hz SCM = 60.0Hz | --- |
| 47 | CLEAR HISTORY | MAINTAIN (01), CLEAR (02) | MAINTAIN (01) | --- |
| 48 | PROGRAM SELECTION | USER SETTINGS (01), OEM SETTINGS (02), RESET OEM (03), RESET 60 (04), RESET 50 (05), TRANSLATE (06) | SCL = RESET 50 (05) SCM = RESET 60 (04) | --- |
| 50 | FAULT HISTORY | (VIEW ONLY) | (N/A) | --- |
| 51 | SOFTWARE CODE | (VIEW ONLY) | (N/A) | --- |
| 52 | DC BUS VOLTAGE | (VIEW ONLY) | (N/A) | --- |
| 53 | MOTOR VOLTAGE | (VIEW ONLY) | (N/A) | --- |
| 54 | LOAD VOLTAGE | (VIEW ONLY) | (N/A) | --- |
| 55 | 0-10 VDC INPUT | (VIEW ONLY) | (N/A) | --- |
| 56 | 4-20mA INPUT | (VIEW ONLY) | (N/A) | --- |
| 57 | TB STRIP STATUS | (VIEW ONLY) | (N/A) | --- |
| 58 | KEYPAD STATUS | (VIEW ONLY) | (N/A) | |
| * PASSWORD IS SET TO “000” WHICH DISABLES THE PASSWORD FUNCTION | | | | |

# Speed Setting Controls

Use the information below to help select which electrical component to adjust in order to synchronize the following sewing speeds.

## Side Sewing Speed Controls

| | | |
|---|---|---|
| Sewing head | - | Side speed pot located on the sewing head console |
| Conveyor | - | Conveyor speed pot located on the sewing head console |

## Corner Sewing Speed Controls

| | | |
|---|---|---|
| Sewing head | - | Corner speed pot located on the sewing head console |
| Conveyor | - | Conveyor AC Tech drive - Parameter 32 (default = 5) |
| Rotate arm | - | Rotate Arm AC Tech drive - Parameter 32 (default = 35) |

## Auxiliary Sewing Speed Controls

| | | |
|---|---|---|
| Sewing head | - | Efka control box - Parameter 114 (default = 150) |
| Conveyor | - | Conveyor AC Tech drive - Parameter 36 (default = 12) |

The Auxiliary sewing speed can be adjusted and used for any additional speed the operator may require. It can be used for slow speed stitching to finish off a bed or it can be set as an additional sewing speed to be used to sew around difficult to sew beds.

# Conveyor Belt Tracking Instructions

1. Turn off the air pressure before making any adjustments.

2. The first step is to make sure the upper conveyor drive roller is perpendicular to the frame. The motor mounted end of the roller is fixed so this is your starting point. The other end of the roller should be adjusted in or out until it is in the same relationship to the frame as the motor mounted end.

3. The next step is to make sure the upper conveyor driven roller is parallel to the upper conveyor drive roller. This can be determined by measuring diagonally across the conveyor from opposite ends of each roller. Adjust the mounting brackets for each end of the driven roller until both diagonal measurements are the same.

4. Next, locate the lower idler roller assembly mount brackets that are attached to the upper frame. These mount brackets each have two adjustment screws that allow you to tilt the mount bracket forward or backward in relation to the conveyor belt travel. Start the adjustment process with all four mount brackets adjusted perpendicular to the conveyor frame.

5. If the belt is tracking toward the operator, adjust the driven roller mount brackets as follows: The mount bracket that is on the same side as the operator should be tilted to the right toward the drive roller end of the conveyor. The three mounting bolts for each bracket must be loosened before the bracket can be adjusted. Next, adjust the mount bracket on the opposite side of the same roller the same angle as the first bracket, but in the opposite direction (toward the driven roller). Both brackets need to be adjusted the same amount to ensure that the lower idler roller remains parallel to the upper conveyor surface.

6. If the belt is tracking away from the operator, adjust the driven roller mount brackets in the opposite direction as mentioned in step 5.

7. Make sure all adjustment screws are touching the lower surface of the frame member and that the bracket mounting bolts are tightened properly.

8. Turn on the air pressure and test the belt tracking with the manual conveyor buttons on the touch screen.

# Servicing the Sew Head

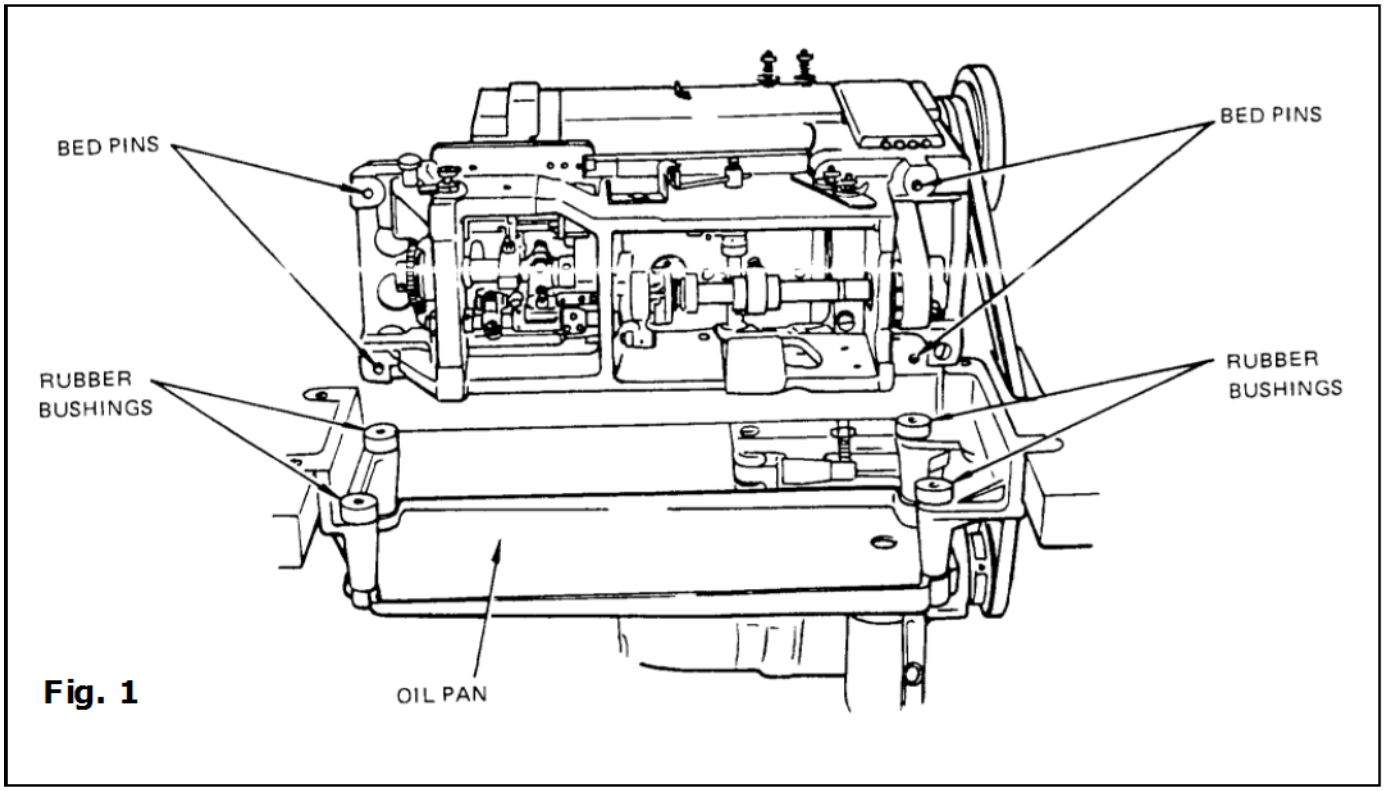



Fig. 1

## Installation

Assemble the oil pan to the hangers. Insert the assembled oil pan into the machine cut-out table placing four rubber bushings in the hanger holes as shown in Fig. 1. Attach the oil drain jar to the oil pan as shown in Fig. 2.

Place the machine on the oil pan assembly with the four bed pins passing through the four rubber bushings shown in Fig. 1.

Connect the foot lifter treadle to the foot lifter lever, Fig. 3, at the back of the machine by chain furnished for this purpose.

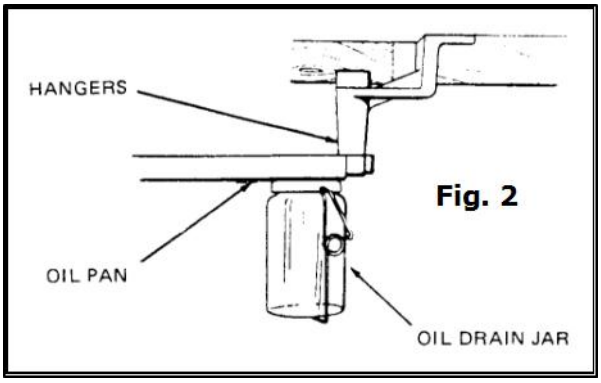



Fig. 2

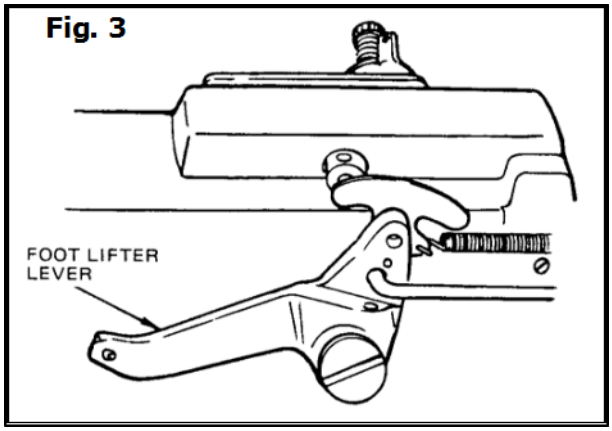



Fig. 3

# Lubrication

Machines of Class 300U have a semi-automatic lubricating system comprising of a hollow arm shaft and a hollow bed shaft which act as oil reservoirs. The oil is distributed to all of the principal bearings by centrifugal force through small jets in the shafts when the machine is in operation. Provision is also made for hand lubricating other movable parts which are not lubricated from the reservoirs.

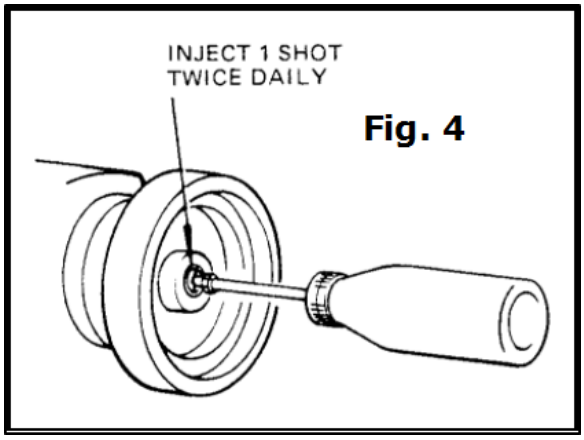


Fig. 4

## Caution:

User Singer Oil, “Type B” or “Type D”. Use “Type D” oil when an oil is desired which will produce minimum stain on fabrics even after long period of storage.

Do not use additives in sewing machine oil as they may cause a reduction in the normal flow of oil that can result in damage to the machine.

Before starting the machine, the machine must be oiled as instructed. Failure to do this will result in damage to the machine.

The Pressure Oil Can, furnished with the machine is to be used to oil all points requiring lubrication.

## To Oil the Arm Shaft

To fill the arm shaft reservoir, insert spout of the pressure oil can in hole, Fig. 4, and inject 1 shot of oil into shaft twice daily.

## To Oil the Bed Shaft

To fill the bed shaft reservoir, push the spring cover, Fig. 5, to the left and insert spout of pressure oil can into the hole and inject 1 shot of oil into shaft twice daily. Close oil hole spring cover.

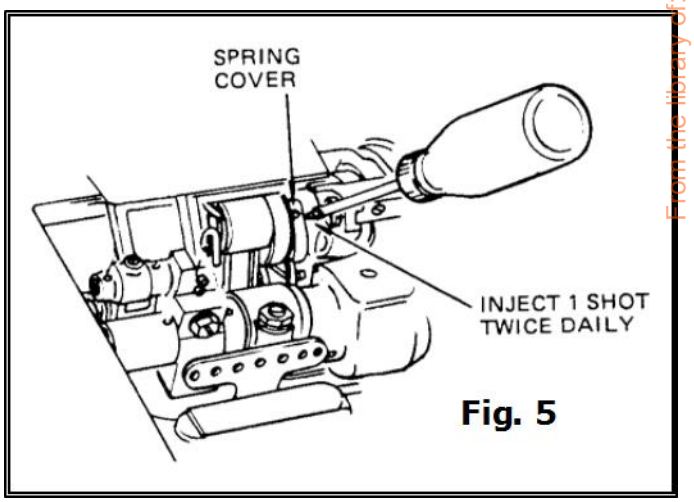


Fig. 5

## Other Oiling Points

Applying oil to all work plate and arm oil holes, needle bar bearings and connections, needle bar rock frame bearings, looper rocker sleeve and presser lifting mechanism.

## Caution:

For machines in continuous use, all oiling points must be oiled daily. Occasionally oil tension release mechanism and looper pull-out rack.

# Setting the Needle

Refer to Fig. 6.

Turn the machine pulley over toward the operator until the needle bar is at its highest point.

Loosen the needle set screw.

Insert the needle into the needle bar and clamp as far as it will go making certain that the scarf of the needle faces toward the left.

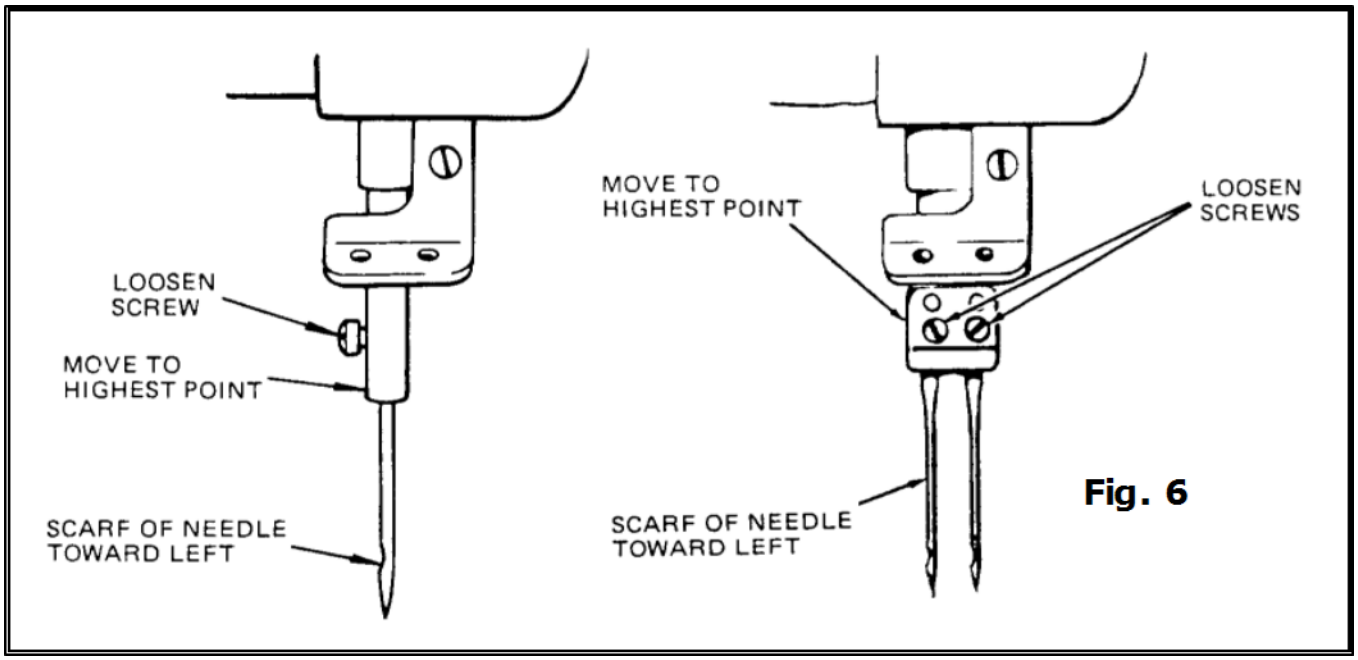



Fig. 6

# Threading the Machine

Either left twist or right twist thread may be used in the needles and loopers. Rough or uneven thread, or thread which passes through the needle eye with difficulty will interfere with successful operation of the machine.

Upper Threading

Turn the machine pulley over toward the operator until the needle bar is at its highest point. Pass the thread from the unwinder through the threading points indicated in Fig. 7. Draw approximately two inches of thread through the needle eye with which to start sewing. Make certain that each thread passes through the thread tension device

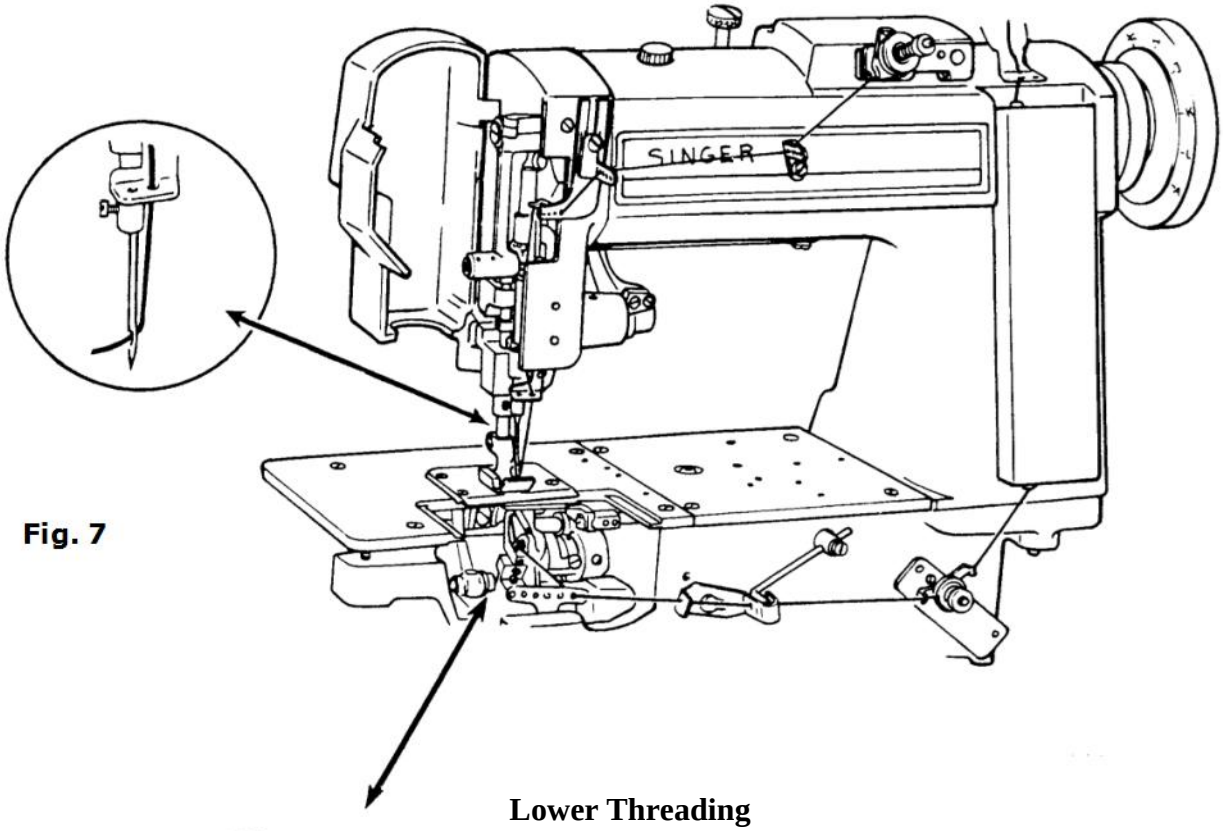
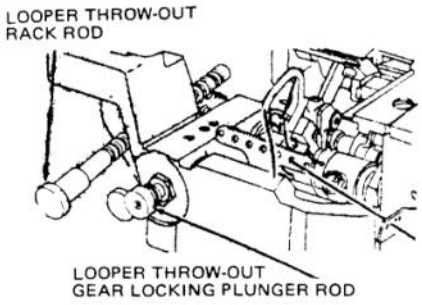



Fig. 7

**Lower Threading**




Open the front table section, remove the bed slide and turn the machine pulley over toward the operator until the needle bar is at its highest point. Move the looper throw-out gear locking plunger rod and looper throw-out rack rod, Fig. 7, out as far as possible. This will place loopers in position for easier threading and prevent accidental operation of machine until loopers are returned to sewing position.

**Threading The Loopers**

Pass the thread from the unwinder through the threading points as indicated. Draw approximately two inches of thread through the looper eye with which to start sewing.

# Tension

Tension on the thread should be as light as possible while still sufficient to set the stitch correctly in material.

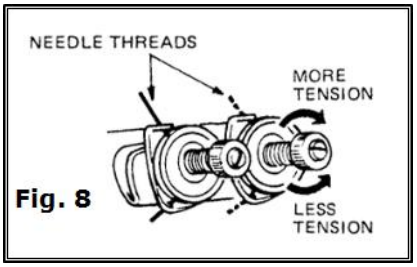


Fig. 8

## Needle Thread Tension

To regulate the needle thread tension, turn the thumb screw indicated in Fig. 8 as may be required.

Important: Regulate the needle thread tension only when the presser foot is down.

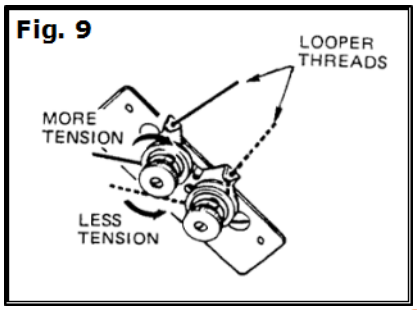


Fig. 9

## Looper Thread Tension

To regulate the looper thread tension, turn the thumb screws as indicated in Fig. 9 as may be required.

# Pressure

Pressure on material should be as light as possible while still sufficient to insure correct feeding.

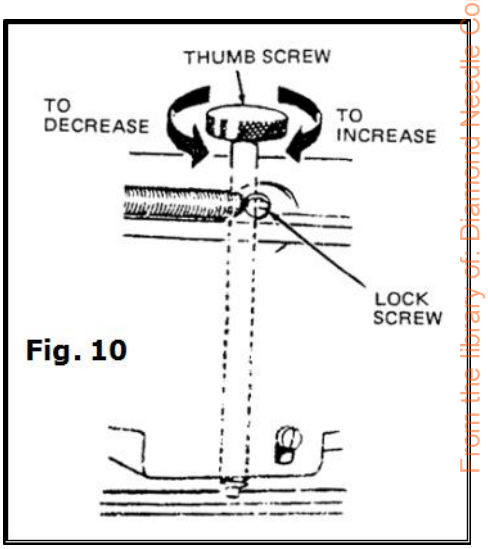


Fig. 10

## Presser Foot Pressure

To regulate the presser foot pressure, loosen the lock screw, Fig. 10, at the rear of the machine. tighten the thumb screw to increase pressure; loosen to decrease pressure. When the correct feeding pressure is attained, tighten the lock screw.

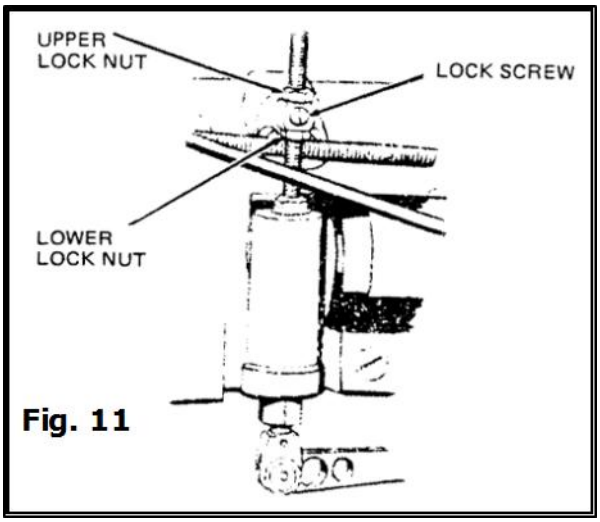


Fig. 11

## Alternating Pressers

To increase pressure, loosen the lower lock nut and loosen the lock screw, then tighten the upper lock nut, see Fig. 11. When the correct pressure is attained, tighten the lock screw. Then tighten the lower lock nut. To decrease pressure, loosen the upper lock nut and loosen the lock screw, then tighten the lower lock nut. When correct pressure is attained, tighten the lock screw. Then tighten the upper lock nut.

# Alternating Presser with Pneumatic Pressure Control

Adjust the height of the Pressure Cylinder with the presser feet resting on the throat plate. There should be a clearance of 1/4" between the Presser Bar Spring Fork and bottom of the cylinder. To raise the cylinder, loosen the lower lock nut and tighten upper lock nut, see Fig. 12. To lower the cylinder, loosen the upper lock nut and tighten the lower lock nut. When correct adjustment is attained, tighten both lock nuts.

Regulate air pressure: The correct air pressure is set for average feeding when the Presser Bar Spring Fork rises to approximately 1/16" from the bottom of the cylinder.

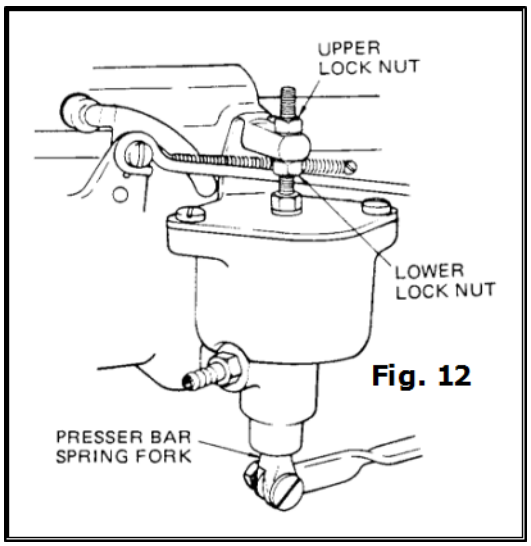


Fig. 12

## Upper Feed Roll Pressure

To regulate the pressure of the upper feed roll, turn the thumb screw as shown in Fig. 13.

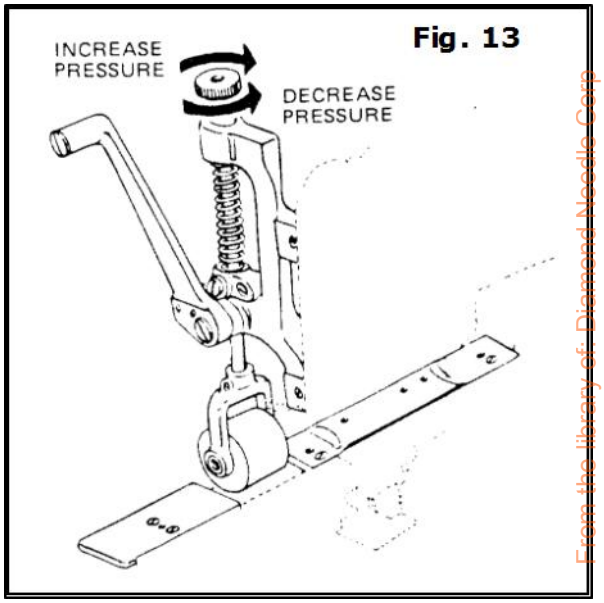


Fig. 13

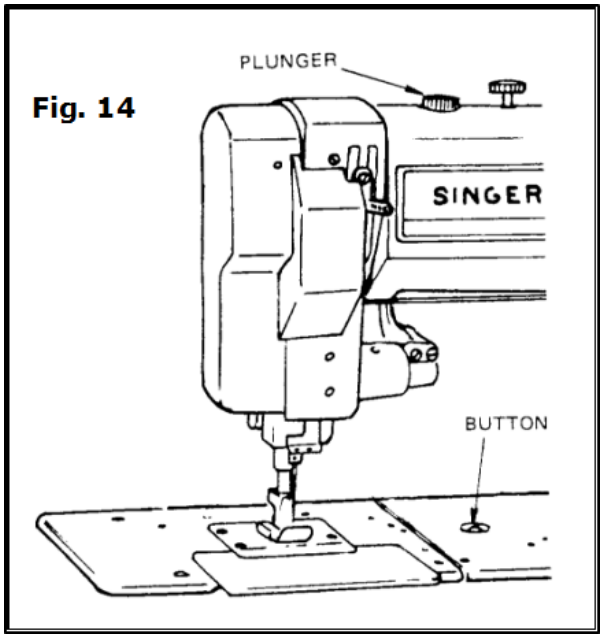


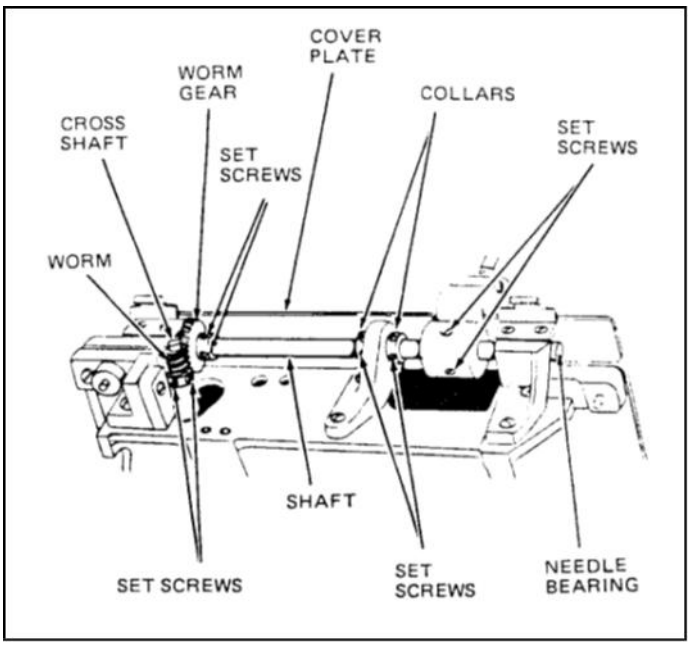
Fig. 14

## Stitch Length

To adjust the stitch length, depress the plunger, Fig. 15, located on top of the arm. Continue to hold the plunger down and turn the machine pulley toward the operator until the plunger enters the notch in the arm shaft eccentric. Then turn the plunger to lock in position. Depress the button located on the machine bed. Hold down and turn the machine pulley toward the operator to increase length of the stitch, or away from the operator to decrease the length of the stitch. Letter "A" on the machine pulley indicates the lowest stitch. When desired length is indicated by a letter and is opposite of the arrow on the front of the machine, release button and turn the plunger to the right or left until it springs outward.

**Caution: Never turn the machine pulley with the plunger in the locked position until the button on the machine bed is depressed.**

# Machine with Puller Feed




The length of the stitch is determined by the stitch gears in the puller feed mechanism. The compound feed stitch length should be set slightly shorter than the stitch length of the puller feed.

To change the Puller Feed gears for adjusting stitch length, remove the two cover plate screws and remove the cover plate, Fig. 15. Loosen the set screws. Slide the puller feed shaft to the right far enough to allow removal of the worm and worm gear. Place the new worm on the cross shaft. Turn the worm in the operating direction and tighten the first set screw into the flat of the shaft. Then securely tighten both set screws, checking for excessive end play. Engage the new worm gear with the worm and slide the puller feed shaft through the worm gear until the end of the shaft is flush with the needle bearing. Remove the end play in the shaft by setting the two collars against the bracket and tightening the four set screws. Align the lower feed roll with the upper feed roll and tighten the two set screws. Center the worm gear on the center of the worm. Tighten the two set screws with the first screw in the spline of the shaft. Replace the cover plate and adjust the compound feed.

## Presser Bar Lift

When the presser foot is raised by the presser bar lifter and the needle is at its highest position, the point of the needle should not protrude below the presser foot.

To adjust, turn the machine pulley over toward the operator until the needle is at its highest position. Loosen the set screw, Fig. 16. Raise the presser foot to the correct height, place the stop collar against the upper bracket, and tighten the set screw.

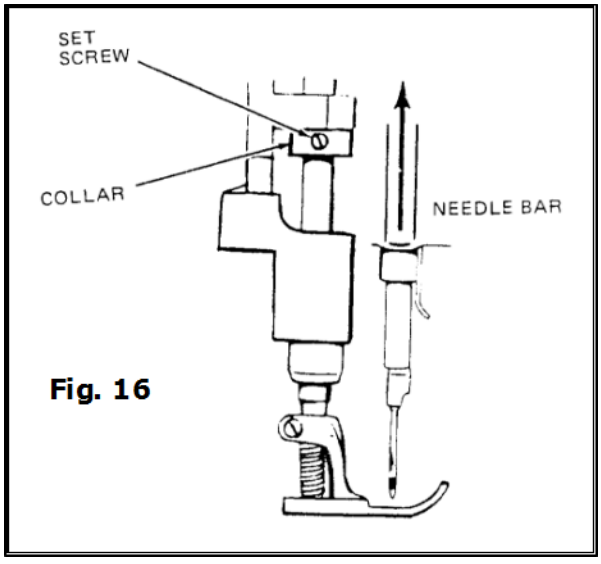



**Fig. 16**

# Machines with Alternating Pressers

The lift of the vibrating and lifting pressers is controlled by an adjustable eccentric. To adjust, remove the arm cover at the rear of the machine. Turn the machine pulley over toward the operator until the feeding presser is down. Loosen the two lock screw, Fig. 17, and the two clamp screws. Insert a screw driver into the notch of the adjusting disc, and turn the machine pulley as indicated in Fig. 17. Then tighten the two clamp screws and the two lock screws.

When it is desirable to have either one of the pressers lift higher than the other, turn the machine pulley over toward the operator until the lifting presser is at its highest position. Loosen the tow clamp screws, Fig. 18, and turn the lifting rock shaft crank up or down until the desired lift of each presser is attained. Then tighten the tow clamp screws.

**Caution: Limit lift of pressers to a minimum required for the work, as this permits higher speeds.**

The vibrating presser should be timed so that under normal sewing conditions, the presser foot will seat on the material at approximately the same time the needle enters the material. This timing can be advanced or retarded slightly depending on the type of operation being performed, such as sewing over seams. To adjust, loosen the tow holding screws, Fig. 18, not more than one half turn. Then turn the adjustable eccentric, Fig. 17, until the vibrating presser seats at the correct time. Securely tighten the tow holding screws after the adjustment is made.

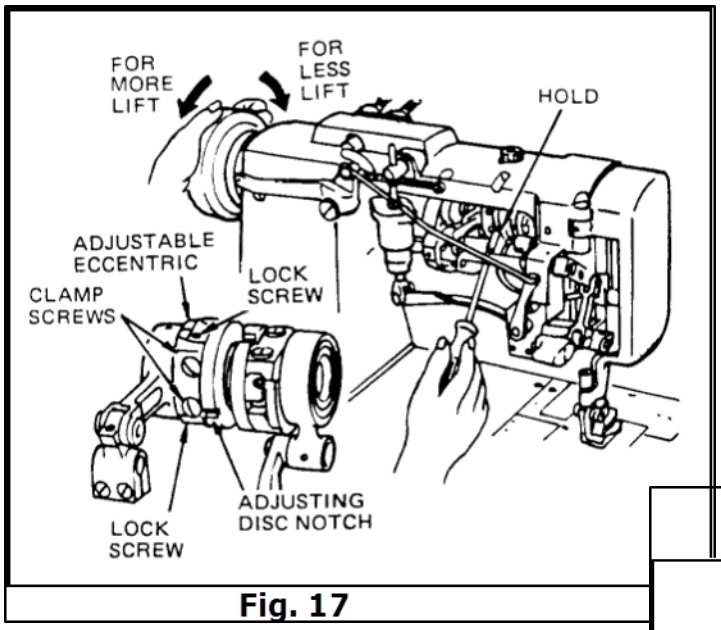



Fig. 17

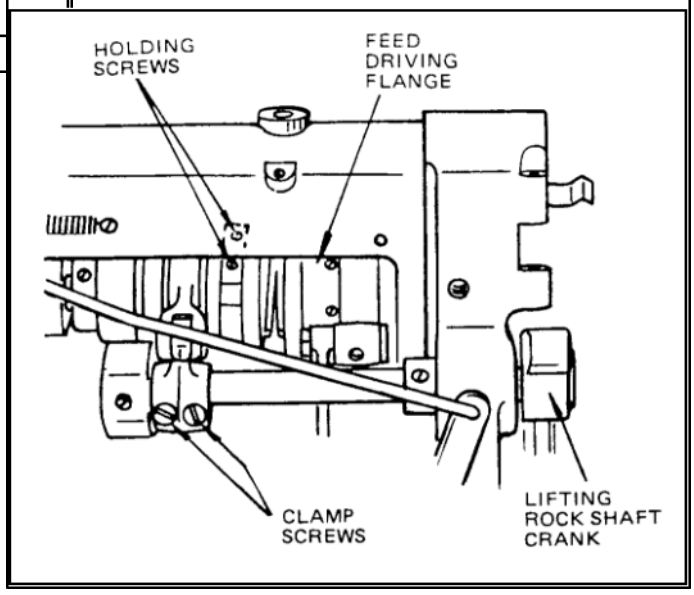
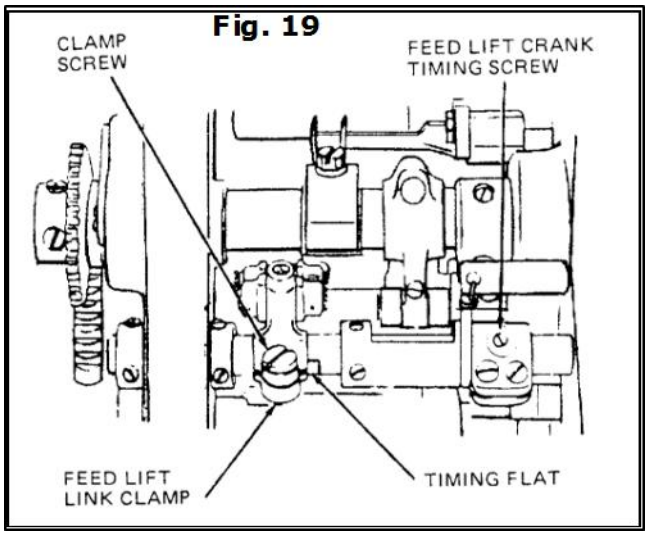



Fig. 18

# Setting the Height of Feed Bar

When the feed bar is set at the correct height, the feed lift link clamp will be aligned with the rock shaft timing flat. To adjust, make certain that the feed lifting crank timing screw, Fig. 19, engages the shaft spot correctly. Loosen the clamp screw and move the feed lift clamp link to the correct position. Then tighten the clamp screw.

Fig. 19



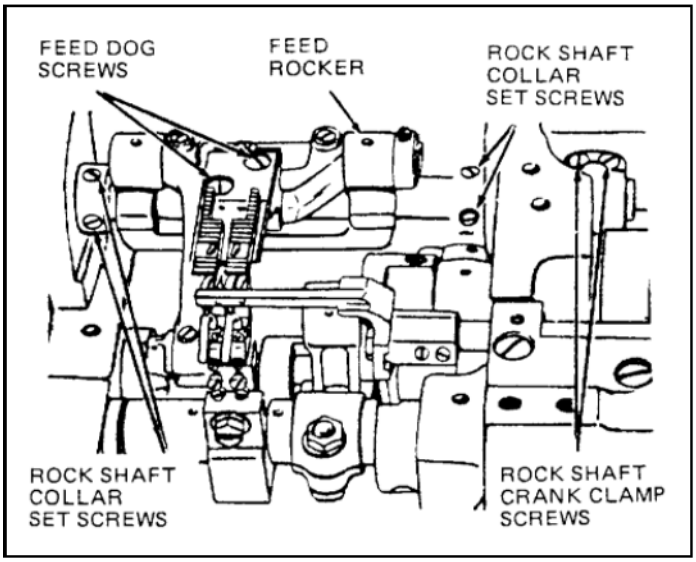

## Centralizing the Feed Dog

**Sidewise Setting**

The needle should enter the needle hole of the feed dog with the same clearance between the needle and the left or right side of the hole. To adjust, loosen the feed dog screws, Fig. 20. Move the feed dog until the correct clearance is attained. Hold in position, and tighten the feed dog screws.

Additional adjustment, if necessary, may be attained by loosening the four shaft collar set screws, the two rock shaft crank clamp screws, Fig. 20, and the feed lifting clamp screw, Fig. 19. Move the complete assembly to required position and tighten screws.

Fig. 20



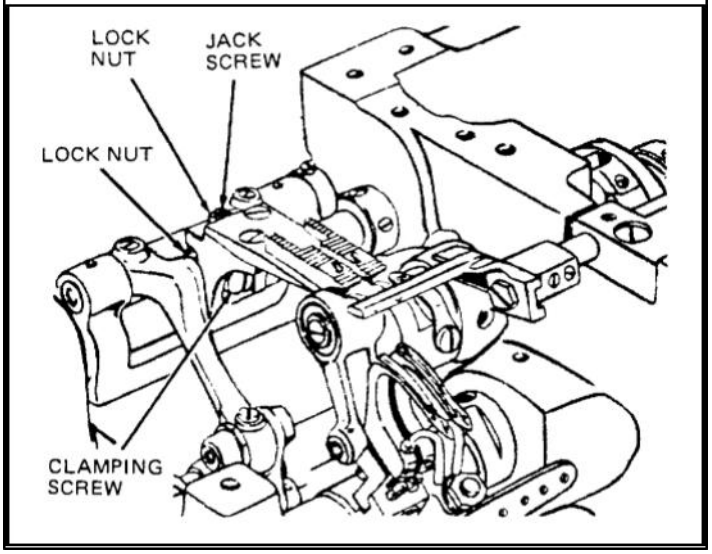

**Lengthwise Setting**

The feed dog should clear the ends of the feed slots in the throat plate equally at both ends of the feed travel. To adjust, set the feed for the desired stitch length. Loosen the two rock shaft crank clamp screws, Fig. 20. Move the feed rocker forward or backward until the correct positioning is attained. Then tighten the two clamp screws.

## Setting the Height of the Feed Dog

When the feed dog height is set correctly, approximately the full depth of the teeth will show above the throat plate. To adjust, loosen the lock nuts, Fig. 21, and slightly loosen the feed dog clamping screw. To raise the feed dog turn the jack screw clockwise; to lower, turn the jack screw counter-clockwise and tap the feed dog down. When the correct setting is attained, tighten the clamping screws and lock the nuts.

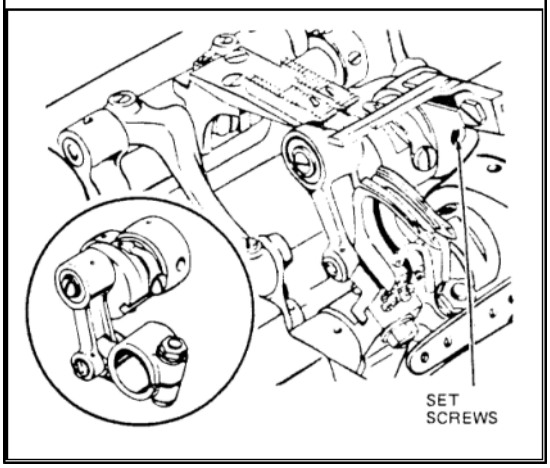
Fig. 21



# Timing the Feed Lift Eccentric

When the feed dog is at its highest position, the top of the teeth should be parallel with, and project full depth of the teeth above the upper surface of the throat plate. To adjust, insert screwdriver in the hole in the feed strap and loosen the two set screws, Fig. 22. Move the feed lift eccentric forward for earlier rise of the feed dog, or backwards for later rise. Then tighten the two set screws.

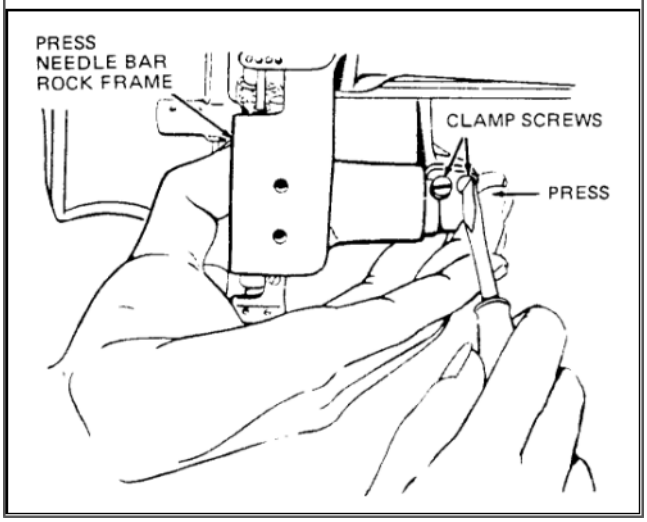
Fig. 22




## Needle Bar Positioning

The needles should enter the needle holes of the feed dog toward the front with approximately the same clearance between the front of the needles and the needle holes as at the side. To adjust, press the needle bar rock frame, Fig. 23, against the drive arm clamp screws. Continue holding the rock frame against the drive arm, move the needle bar to correct the position and tighten the two clamp screws.

Fig. 23




## Positioning the Loop Deflectors

When the loop deflector, located on the underside
of the feed dog, is positioned correctly, there should be a clearance of approximately
1/32” between the right side of the needle and loop deflector. To adjust, move the looper out of sewing position and tilt the machine back on its hinges. Loosen the loop deflector screws, Fig. 24. Move the deflectors toward the rear of the feed dog as far as the screw slots allow. Tighten slightly to allow for further adjustment. Return the looper to the sewing position and turn the machine pulley until the needle bar has descended to the bottom of the needle bar stroke. Tap the deflector to the left or right until the correct clearance is attained. Move the looper out of the sewing position and tighten the loop deflector screws.

Fig. 24

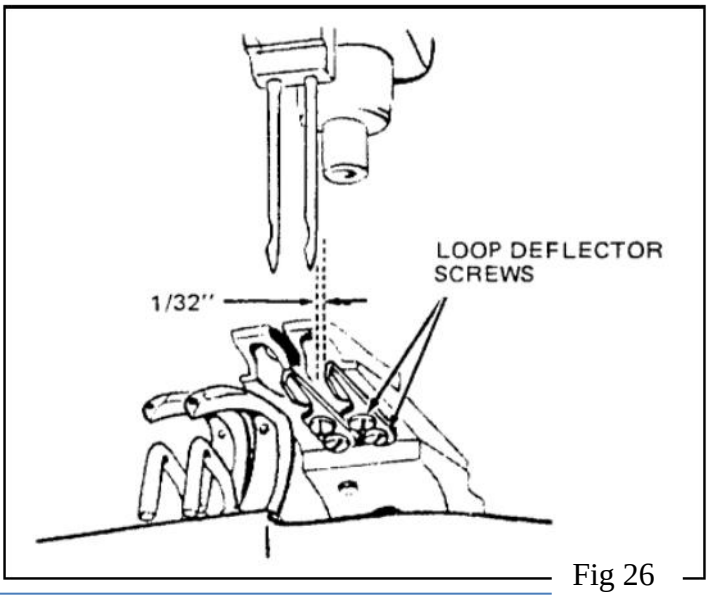
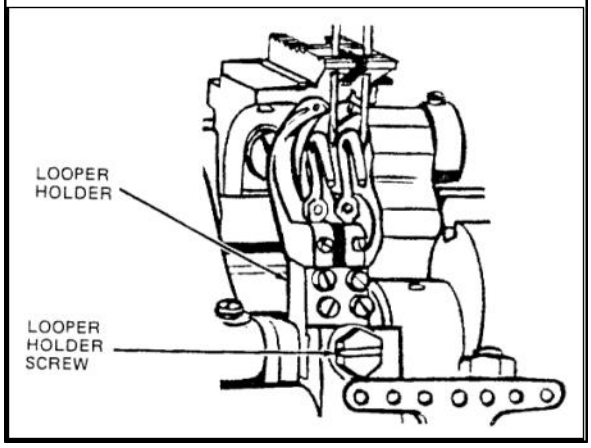
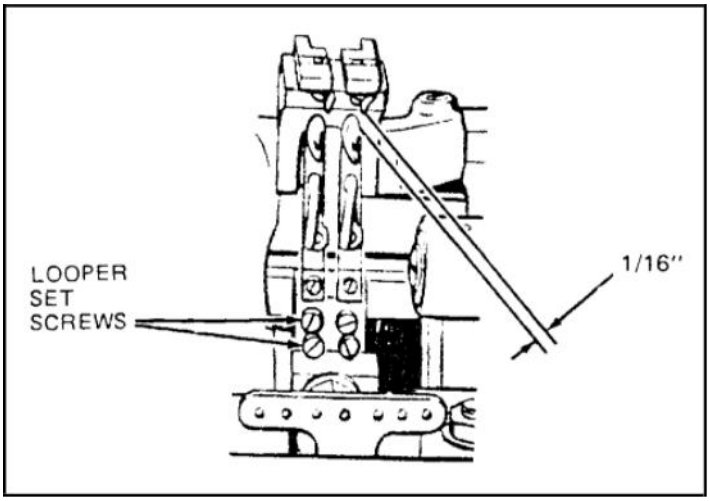



Fig 26

# Setting the Distance from the Looper to the Needle

Fig. 25




## Sidewise Setting

When the looper is correctly positioned, the point of the looper just clears the scarf of the needle on the forward stroke of the looper. To adjust, turn the machine pulley until the looper point is directly opposite of the center of the needle. Loosen the looper holder screw, Fig. 25, and tap the holder to the left or right until the correct clearance is attained. Then securely tighten the looper holder screw.

Move the looper to the extreme forward position. Check the clearance between the heel of the looper and the loop deflector, Fig. 26, which should be approximately 1/16”. To adjust, loosen the two looper set screws. Turn the looper to the left or right until the correct clearance is attained. Hold in position and securely tighten the two set screws.

**Caution:** On single and multi-needle machines, make certain that the point of each looper just clears the scarf of its respective needle. To adjust, with the looper point directly opposite the center of the needle, loosen the two set screw, Fig. 26, and turn the looper slightly to the left or right. Then tighten the set screws.

## Lengthwise Setting & Setting the Height of the Needle Bar

Fig. 27

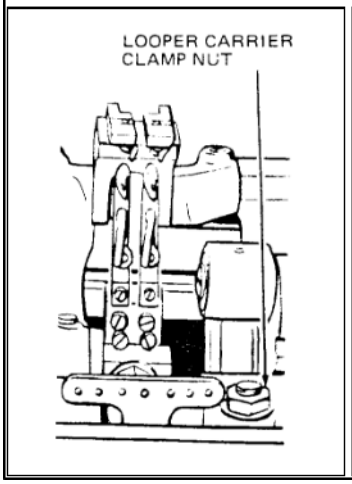
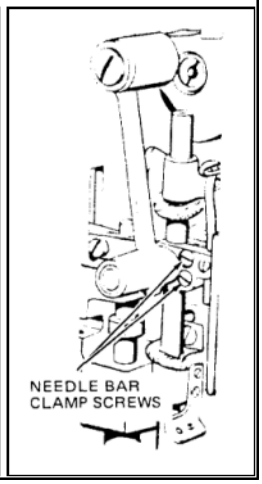



Fig. 28




When correctly set: the point of the looper should be directly opposite of the center of the needle, and at the center of the clearance above the eye of the needle when the looper timing mark LT on the machine pulley is opposite of the timing arrow on the arm..

To adjust the looper, loosen the looper carrier clamping nut, Fig. 27. Move the carrier forward or backward until the looper point is directly opposite of the center of the needle. Then tighten the clamping nut.

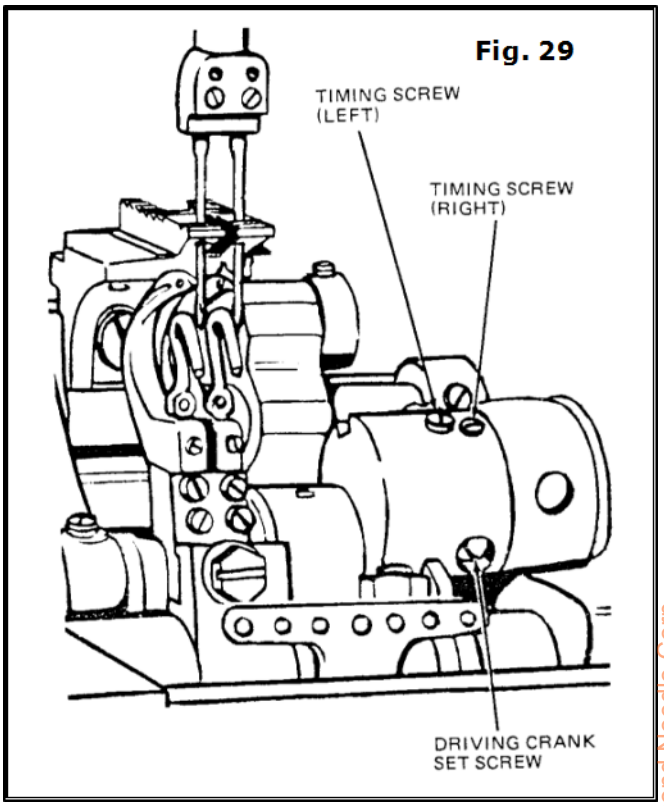
To adjust the needle bar, first make certain that the needle is inserted up into the needle bar or clamp as far as possible. Loosen the two needles bar clamping screws, Fig. 28, and raise or lower the needle bar to correct position. Then tighten the clamping screws

# Timing Looper Driving Crank

When the looper driving crank is properly timed, the point of the looper will pass above the eye of the needle at the same distance on both the forward and backward strokes of the looper.

To adjust when the point of the looper passes higher on the forward stroke, loosen the looper driving crank set screw, Fig. 29. Loosen the looper crank timing screw (left) approximately 1/8 turn, and tighten the looper crank timing screw (right). Continue to adjust until the correct adjustment is made. Then securely tighten the set screw.

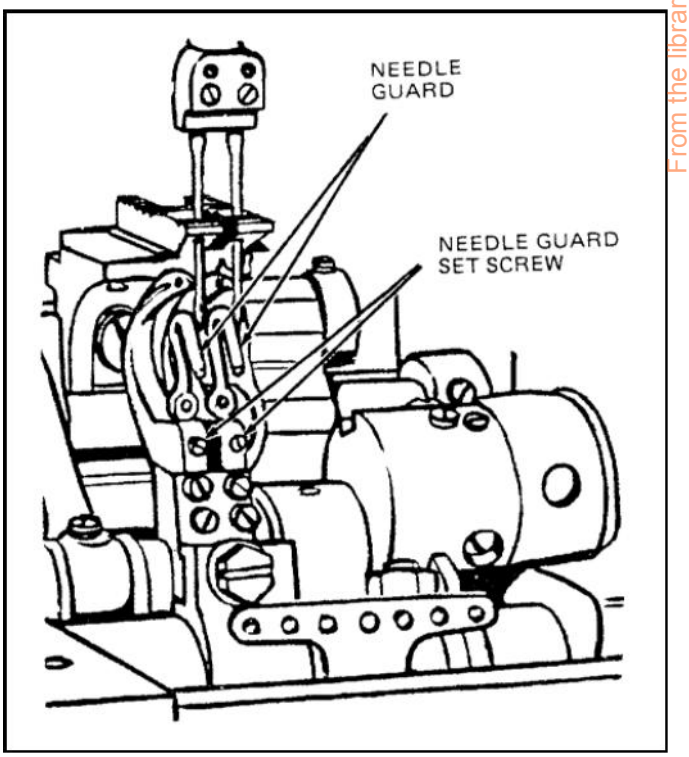
When the point of the looper passes higher on the backward stroke, reverse the adjustment by loosening the timing screw (right) and tightening the timing screw (left).




## Setting the Needle Guards

When the needle guards are properly set, they should pass as close as possible to the needles without touching. To adjust the guard turn the machine pulley over toward the operator until the points of the loopers are about to pass the needles on their forward strokes. At this point, the looper timing mark LT on the machine pulley should be approximately 1/8” above the arrow on the machine arm. Loosen the needle guard set screws, Fig. 30. Turn the needle guards as close to the needles as possible without touching. Tighten the set screws. Check by springing the needles to the left and turning the machine pulley to make certain that the looper points do not stroke the needles.

Fig. 30



# Positioning Spreader

Fig 31

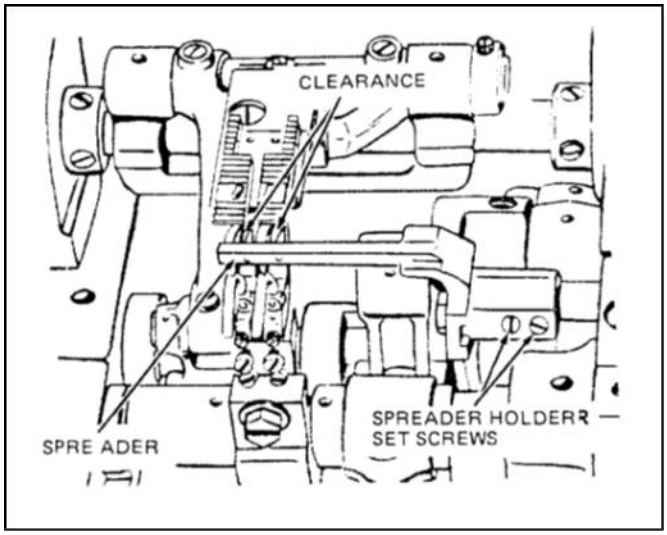
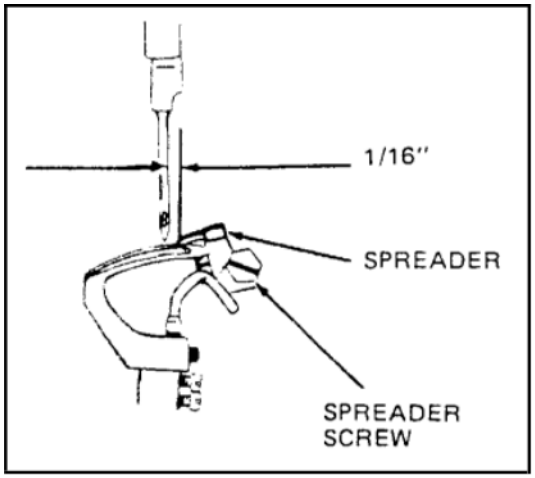



Fig 32




## Sidewise and Height Setting

When the looper on its forward stroke is passing the spreader

a) The point of the spreader should be exactly opposite the top of the thread groove at the left side of the looper.

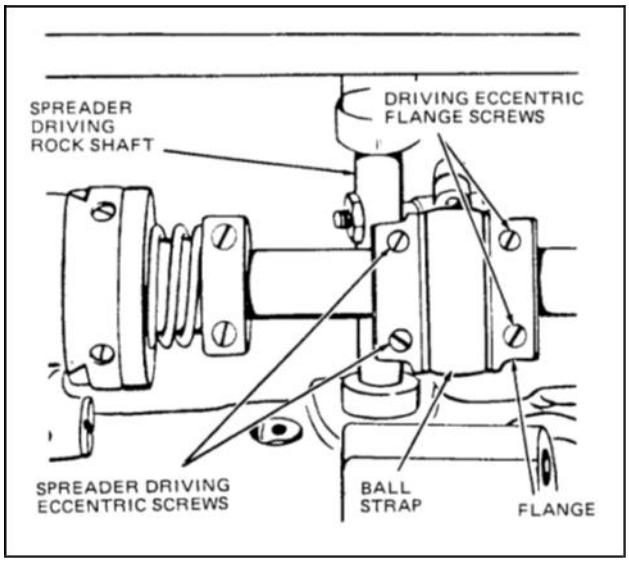
b) The clearance between the spreader point and the looper should be approximately the double thickness of ordinary paper.

To adjust, loosen the two spreader holder set screw, Fig. 31. Move the spreader and holder to the correct position. Hold in position and tighten the set screws.

Lengthwise Setting

When the point of the needle on its downward stroke is even with the point of the spreader, the clearance between the two points should be approximately 1/16". To adjust, loosen the spreader screw, Fig. 32, and move the spreader forward or backward to correct position. The tighten the spreader screw

Fig 33




## Changing Movement of Spreader

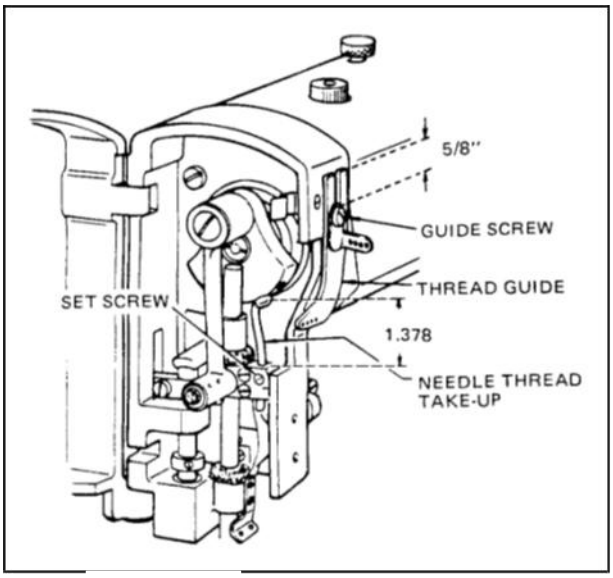
The sidewise movement of the spreader may be adjusted for sewing under abnormal conditions. Under normal conditions, maximum spreader movement is generally used. To adjust, tilt the machine back on its hinges, loosen the two spreader driving eccentric screws, Fig. 33, and the two spreader driving eccentric flange screws. Move eccentric to the left to increase movement, or to the right to decrease movement. When correctly positioned, tighten the two spreader driving eccentric screws first, hold flange against strap and tighten flange screws. Then refer to preceding information regarding positioning of spreader.

Adjusting Needle Thread Take-Up

The needle thread take-up and thread guide may be adjusted to increase or decrease the amount of thread drawn at the top of the needle bar stroke. To increase the amount, loosen the thread take-up screw, Fig. 34, and raise the take-up or loosen the guide screw and lower the guide. To decrease the amount, reverse the adjustment by lowering the take-up or raising the guide.

For average sewing conditions, the guide should be set with upper end 5/8" above the guide screw. The thread take-up should be set with the lower end 1.378" below the bottom of its holder.

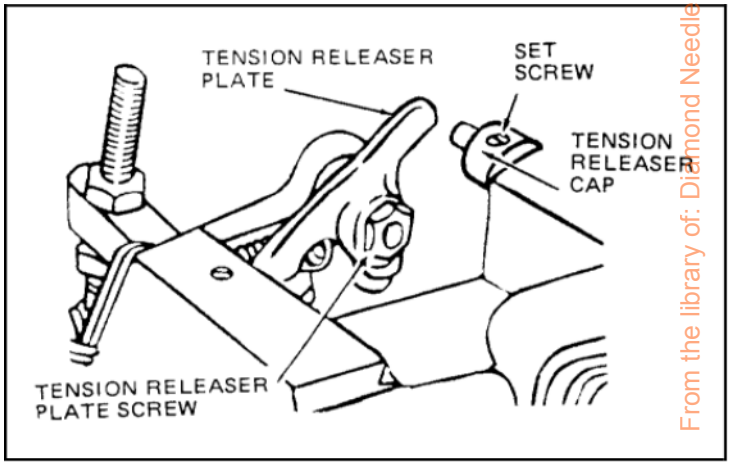
Fig 34




## Adjusting Needle Thread Tension Releaser

When correctly adjusted, the tension releaser should release tension on the needle thread when the presser foot is raised and allow full adjusted tension when presser foot is down. To adjust, loosen the set screw, Fig. 35, and move tension releaser cap out for earlier release of tension or in for later release. Hold in position and tighten the set screw. Should the tension releaser not release tension at the correct time after making the above adjustments, loosen the tension releaser plate screw and move plate sidewise to correct position. Then tighten the screw.

Fig 35





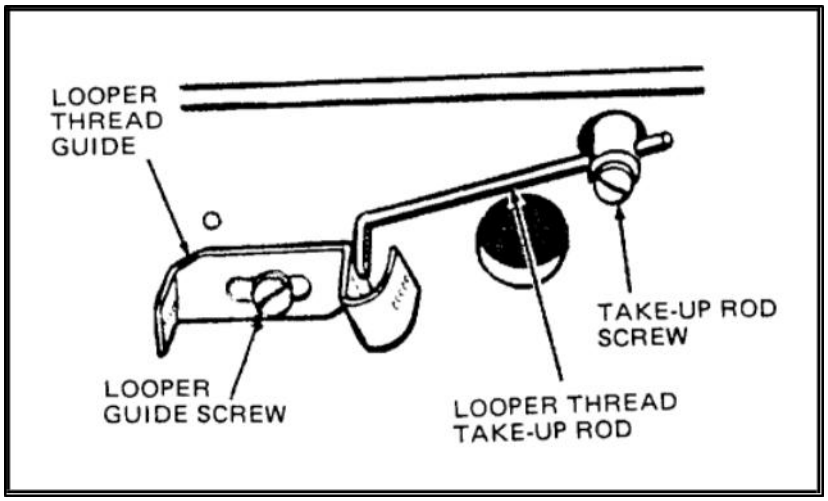

## Adjusting Looper Thread Take-Up

The looper thread take-up and guide may be adjusted for handling more or less thread, according to the thickness of material and length of . stitch, and to change the ratio of looper thread in the finished stitch.

To change the amount of thread handled, loosen the looper thread guide screw, Fig. 36, and looper thread take-up rod screw. Move the thread guide and take-up rod to the left for more thread or to the right for less thread. Tighten the two screws making certain that the take-up rod passes through the center of the guide yoke.

To change the ratio of looper thread in finished stitch, loosen the thread guide screw, Fig. 36, and lower the yoke or right end of the thread guide for more thread. For less thread, raise the end of the guide. Hold in position and tighten the guide screw.

Fig 36



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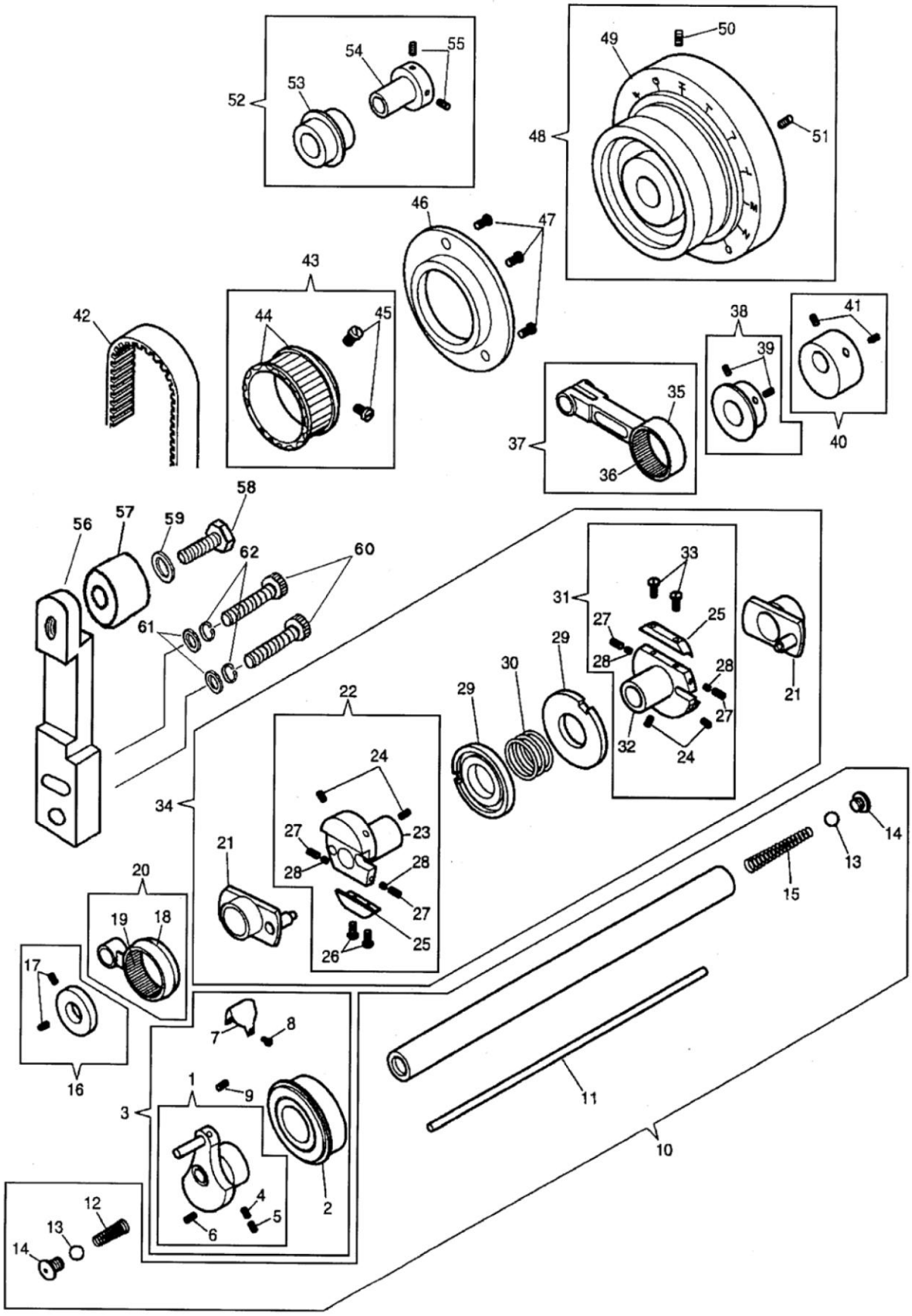
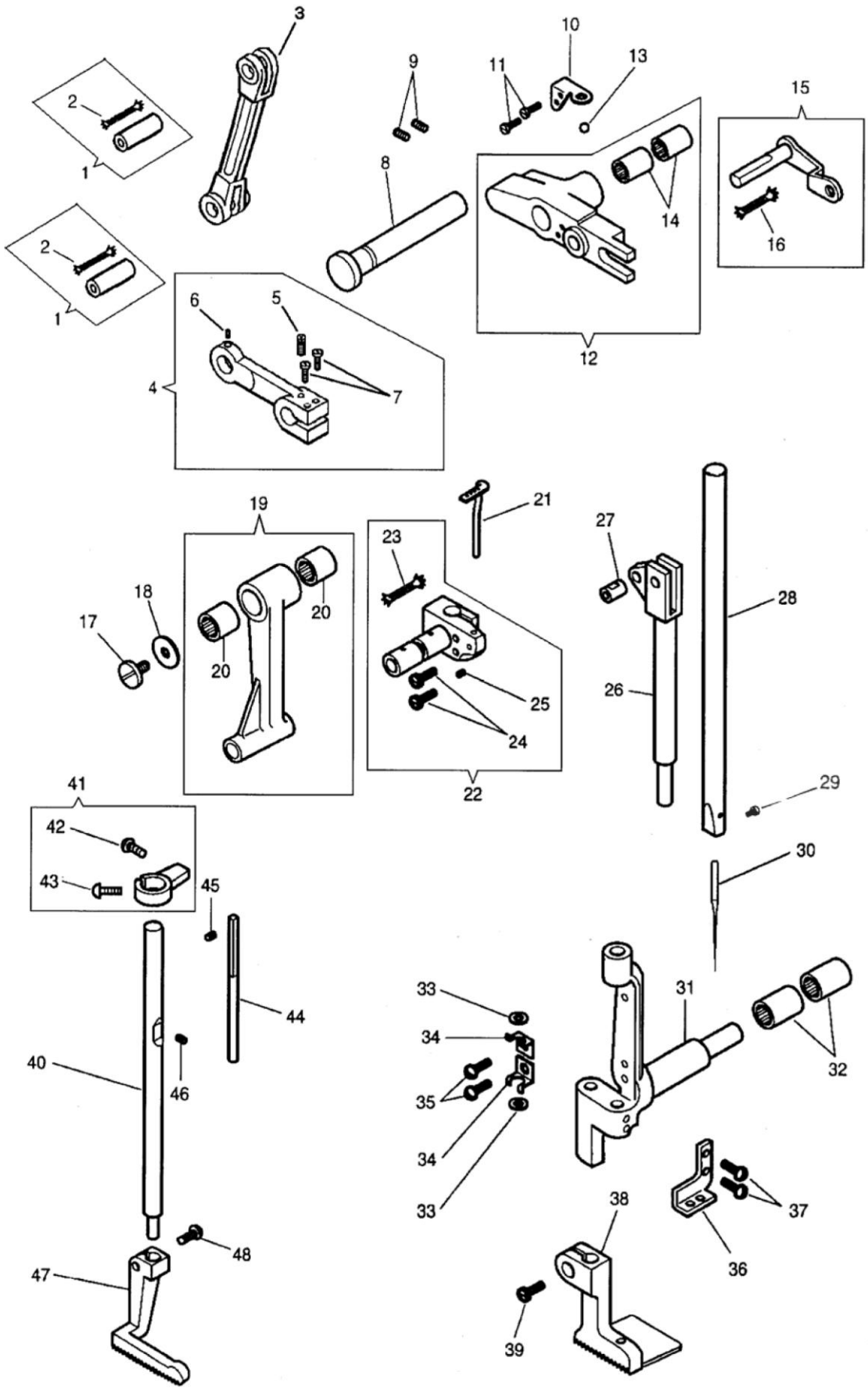


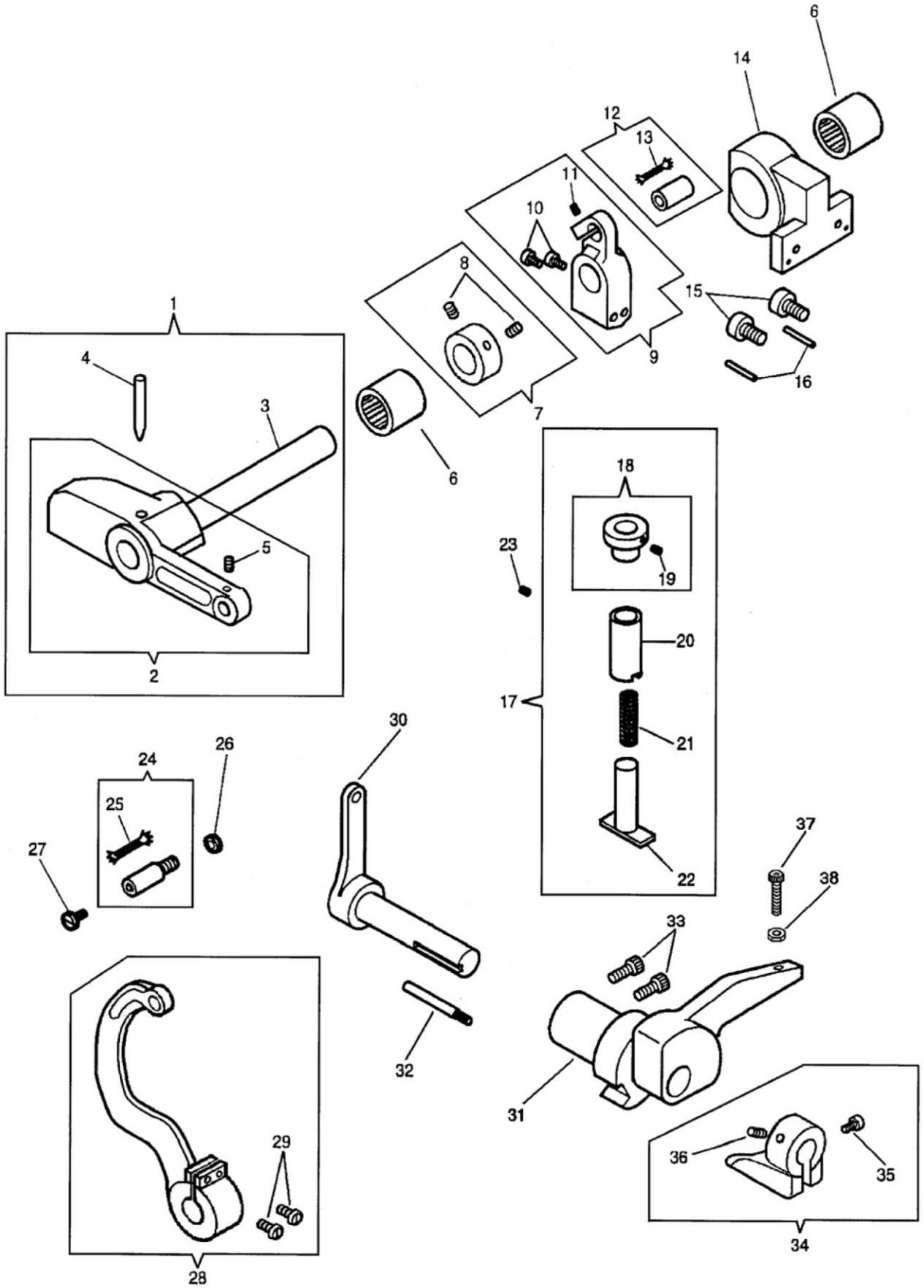
# Upper Shaft Assembly

| NO. | PART # | DESCRIPTION | NO. | PART # | DESCRIPTION |
|---|---|---|---|---|---|
| 1 | 415138 | CRANK, NEEDLE BAR | 32 | 415077 | LIFTING ECC FLANGE |
| 2 | 32848 | BEARING | 33 | 374098 | SCREW |
| 3 | 2812239 | NEEDLE BAR CRANK COMPLETE | 34 | 415081 | ECCENTRIC COMP |
| 4 | 549024 | SCREW | 35 | 268491 | LIFTING ECCENTRIC |
| 5 | 544358 | SET SCREW | 36 | 271055 | FEED DRIVING CONNECTION NEEDLE |
| 6 | 500272 | NEEDLE BAR CRANK SCREW | 37 | 268491 | LIFTING ECC CONN |
| 7 | 281206 | CRANK COVER | 38 | 415086 | SPACE COLLAR |
| 8 | 545205451 | SCREW, WHITE | 39 | 414529 | SCREW |
| 9 | 281258 | NEEDLE BAR CRANK OIL PACKING ( | 40 | 281256 | BALANCE WEIGHT CPL |
| 10 | 415128 | ARM SHAFT | 41 | 544208005 | SCREW |
| 11 | 268264 | ROD, OIL CONTROL | 42 | 268270 | CONNECTION BELT |
| 12 | 415200 | SPRING | 43 | 281290 | PULLEY |
| 13 | 268214 | BALL, OIL STOP | 44 | 202253 | SPRING FLANGE |
| 14 | 414578 | BALL SCREW | 45 | 414546 | SCREW |
| 15 | 268044 | SPRING, OIL STOP BALL | 46 | 268004451 | HOUSING |
| 16 | 415308 | SPACING COLLAR | 47 | 544336 | STUD SCREW |
| 17 | 414529 | SCREW | 48 | 281296467 | MACHINE PULLEY (W/414525 & 414 |
| 18 | 271055 | FD DRIVE CONN | 49 | 281297467 | MACHINE PULLEY |
| 19 | 271055 | FEED DRIVING CONNECTION NEEDLE | 50 | 414525 | SCREW |
| 20 | 267609 | FEED DRIVING CONN | 51 | 414526 | SCREW |
| 21 | 267610 | FEED DRIVE ECC | 52 | 281294 | ARM SHAFT THRUST COLLAR |
| 22 | 415078 | ECCEN FLANGE CPL | 53 | 272142 | BALL BEARING |
| 23 | 415078 | ECCENTRIC FRANGE | 54 | 281295001 | BED SHAFT THRUST COLLAR |
| 24 | 414555 | SCREW | 55 | 544209005 | SET SCREW |
| 25 | 267623 | FRICTION PLATE | 56 | KE0022 | BELT TENSION BRACKET |
| 26 | 374098 | SCREW | 57 | KE0023 | CAM FOLLOWER |
| 27 | 414557 | SCREW | 58 | KE0074 | CAM FOLLOWE SCREW |
| 28 | 241763 | PACKING FIBRE | 59 | KE0082 | CAM FOLLOWER SCREW WASHER |
| 29 | 268065 | ECC ADJUSTING DISC | 60 | 414753004 | BELT TENSION BRACKET SET SCREW |
| 30 | 267618 | ADJUSTING DISC SPR | 61 | 270 543803005 | WASHER |
| 31 | 415076 | LIFT ECC FLANGE CPL | 62 | 270 543805005 | WASHER |



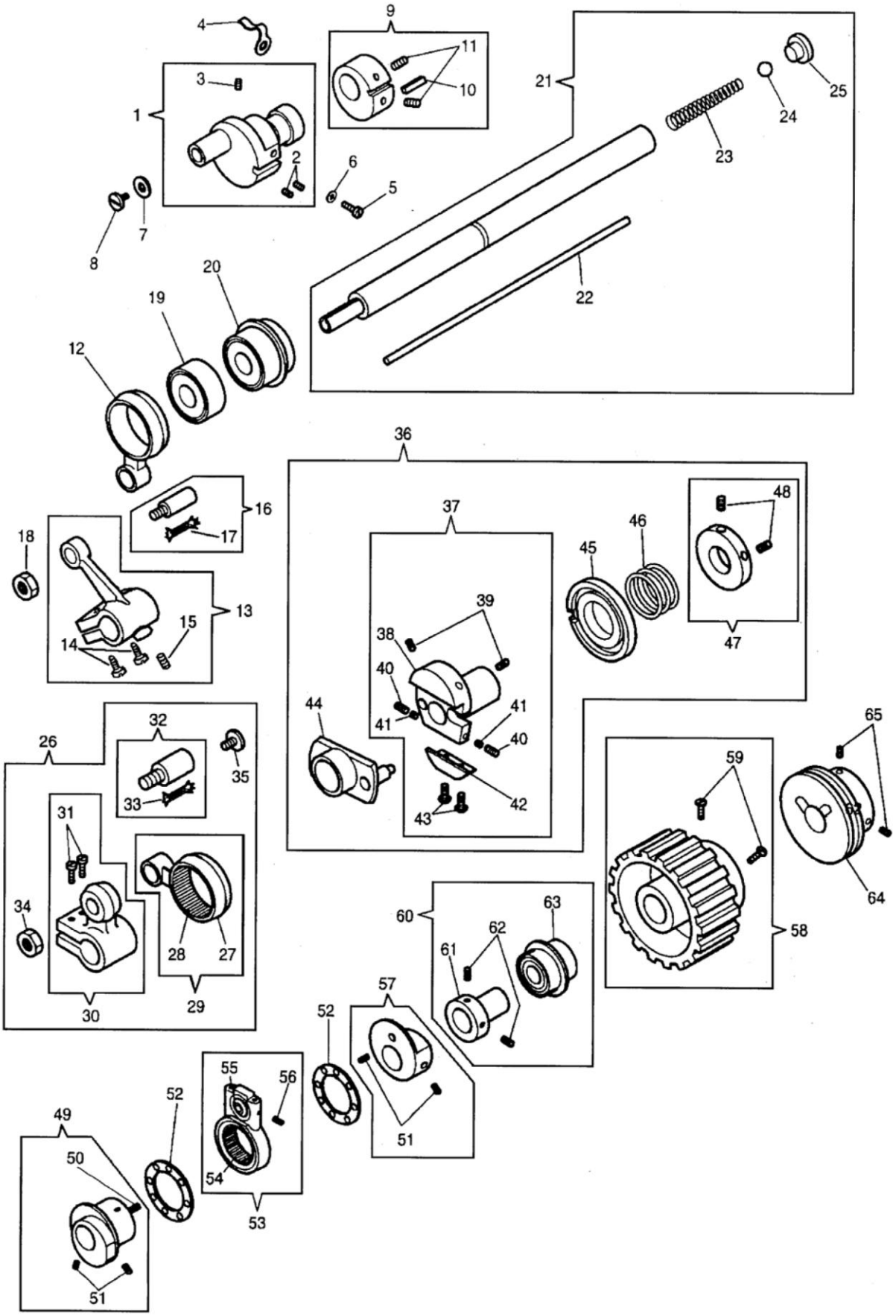
# Front Assembly Sewing Arm

| NO. | PART # | DESCRIPTION | NO. | PART # | DESCRIPTION |
|---|---|---|---|---|---|
| 1 | 267617 | LINK HINGE PIN | 25 | 414545 | SET SCREW |
| 2 | 268258 | PACKING WICK | 26 | 267657 | VIB PRESSER BAR |
| 3 | 267627 | LIFTING LINK | 27 | 267658 | VIBRATING PRESSER BAR HINGE ST |
| 4 | 415061 | LIFTING CRANK | 28 | 281912 | NEEDLE BAR |
| 5 | 141338 | SCREW | 29 | 414519 | SCREW |
| 6 | 141424 | SCREW | 30 | | SINGER NEEDLE 62x59 size 23 |
| 7 | 414511 | SCREW | 31 | 415045 | FRAME, NEEDLE BAR |
| 8 | 267626 | HINGE STUD | 32 | 268029 | NEEDLE BEARING |
| 9 | 544322 | SET SCREW | 33 | 268144 | N BAR OILING FELT |
| 10 | 267718 | PRESSER BAR SPRING ARM BALL RE | 34 | 268278 | OILING FELT HOLDER |
| 11 | 414548 | RETAINER SCREW | 35 | 414522 | SCREW |
| 12 | 415067 | Lifting lever | 36 | 268219 | THREAD GUIDE |
| 13 | 276025 | BALL, PRESSER BAR SPRING ARM | 37 | 414539 | SCREW |
| 14 | KE0008 | LIFTING LEVER BUSHING | 38 | KE0069 | VIBRATING PRESSER FOOT |
| 15 | 267631 | PR BAR LIFT CRANK | 39 | 414638 | SCREW |
| 16 | 268258 | PACKING WICK | 40 | 267628 | LIFTING PR BAR |
| 17 | 414517 | SCREW | 41 | 415059 | GUIDE BLOCK |
| 18 | 268139 | WASHER | 42 | 414516 | SCREW |
| 19 | 281916 | NEEDLE BAR CONNECTING LINK (30 | 43 | 414512 | SCREW |
| 20 | 270266 | NEEDLE BEARING (GBH68) | 44 | 267907 | GUIDE ROD |
| 21 | 268512 | THREAD GUIDE | 45 | 544301 | SCREW |
| 22 | 281914 | NEEDLE BAR CONNECTING STUD CPL | 46 | 414530 | SCREW |
| 23 | 202330 | OIL WICK | 47 | 559059 | LIFTING PRESSER FOOT |
| 24 | 414511 | SCREW | 48 | 414638 | SCREW |



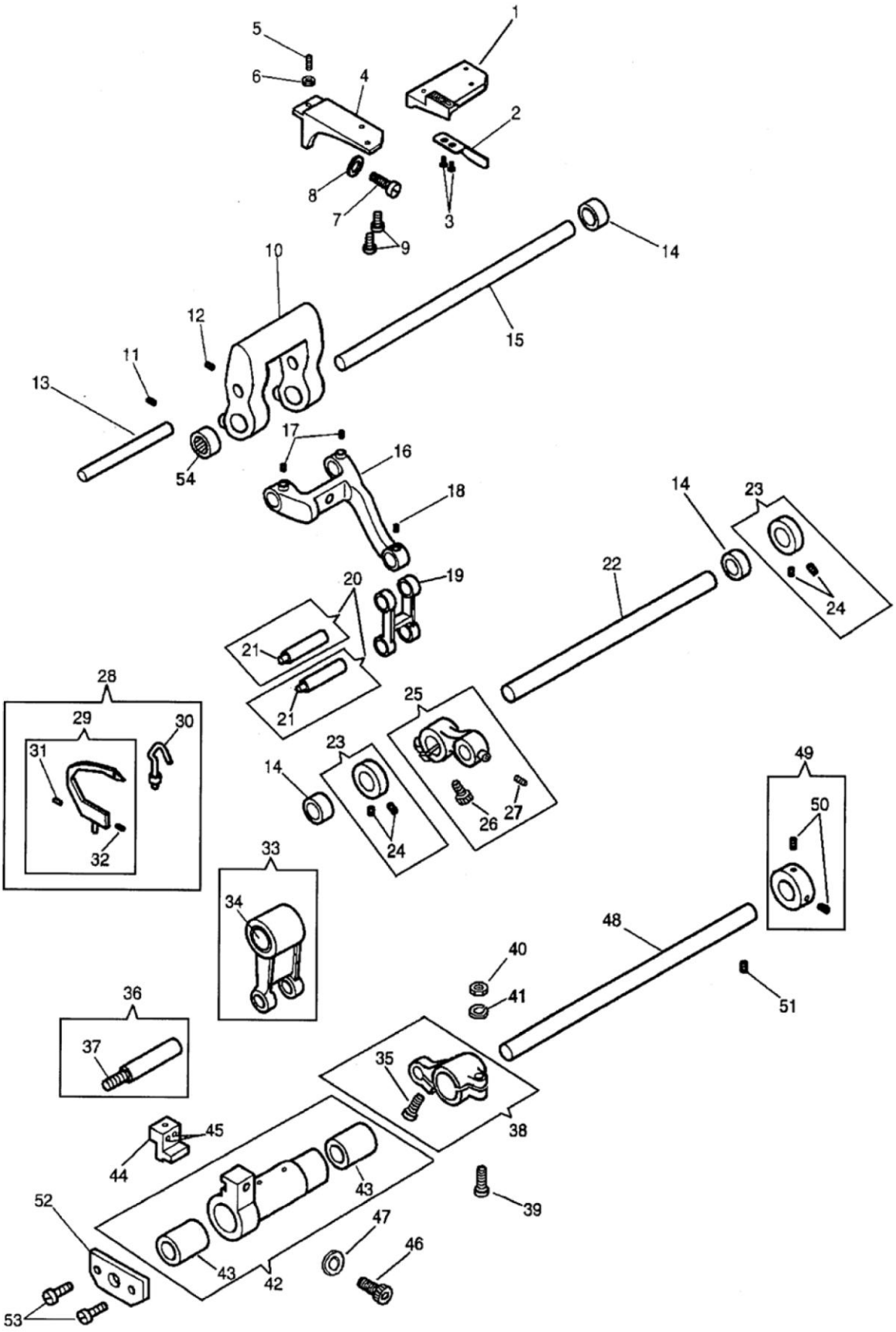
# External Parts Sewing Arm #1

| NO. | PART # | DESCRIPTION |
|---|---|---|
| 1 | 32788 | ROCK SHAFT |
| 2 | 32788 | ROCK SHAFT |
| 3 | 32789 | ROCK SHAFT |
| 4 | 548035 | PIN |
| 5 | 141424 | SCREW |
| 6 | 267110 | NEEDLE BEARING,GBH-78 |
| 7 | 415065 | COLLAR COMP |
| 8 | 504020 | SCREW (300UX5) |
| 9 | 415069 | CONN CRANK |
| 10 | 414509 | SCREW |
| 11 | 374362 | SUBSTITUTION REQUIRED |
| 12 | 267617 | LINK HINGE PIN |
| 13 | 268258 | PACKING WICK |
| 14 | 415071451 | LIFTING ROCK SHAFT BRACKET |
| 15 | 414504 | SCREW |
| 16 | 543841001 | PIN |
| 17 | 415098 | STUD COMP |
| 18 | 415099 | STUD CAP |
| 19 | 414528 | SCREW |
| 20 | 268149 | ROCK SHAFT SLEEVE (300UX5) |
| 21 | 214529 | SPRING |
| 22 | 268148 | STUD |
| 23 | 414527 | SCREW |
| 24 | 415091 | HINGE STUD |
| 25 | 268258 | PACKING WICK |
| 26 | 541197 | NUT |
| 27 | 545297 | SCREW |
| 28 | 415094451 | NEEDLE BAR ROCK FRAM DRIVING ARM |
| 29 | 414790 | SCREW |
| 30 | 267612 | CRANK, FOOT LIFT |
| 31 | 267719452 | ARM FULCRUM (WHITE)(HIGH LIFT) |
| 32 | 414566 | SCREW STUD |
| 33 | 350604 | SCREW |
| 34 | 415122 | FT L ARM COMP |
| 35 | 414509 | SCREW |
| 36 | 545213 | SET SCREW |
| 37 | 414750004 | PRESSER BAR SPRING ARM FULCRUM |
| 38 | 541166001 | NUT |



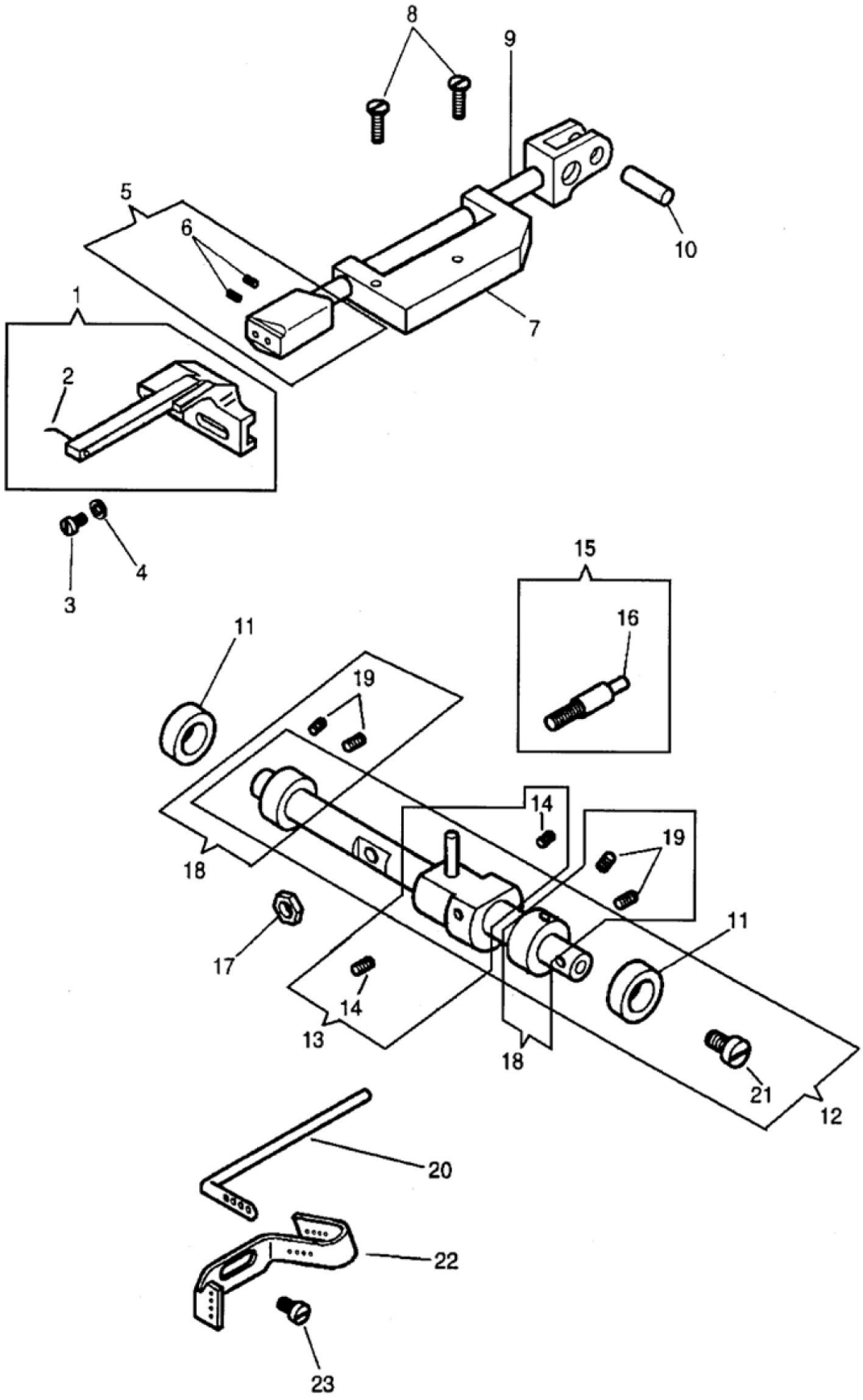
# Lower Shaft Assembly

| NO. | PART # | DESCRIPTION | NO. | PART # | DESCRIPTION |
|---|---|---|---|---|---|
| 1 | 415176 | DRIVE CRANK | 34 | 541197 | NUT |
| 2 | 374099 | SCREW | 35 | 545297 | SCREW |
| 3 | 500264833 | LOOPER DRIVING CRANK SET SCREW | 36 | 415082 | ECCENTRIC COMP |
| 4 | 268102 | COVER, OIL HOLE | 37 | 415073 | FEED DRIVING ECC FLANGE |
| 5 | 414563 | SCREW | 38 | 415073 | SUBSTITUTION REQUIRED |
| 6 | 204925 | SPRING STUD WASHER(5) | 39 | 414555 | SCREW |
| 7 | 268139 | WASHER | 40 | 414557 | SCREW |
| 8 | 200100 | SCREW | 41 | 241763 | PACKING FIBRE |
| 9 | 415210 | FEED LIFT ECCEN | 42 | 267623 | FRICTION PLATE |
| 10 | 268077 | LUBRICATING PAD | 43 | 374098 | SCREW |
| 11 | 544208005 | SCREW | 44 | 267610 | FEED DRIVE ECC |
| 12 | 268074 | FD LIFT CONNECTION | 45 | 268065 | ECC ADJUSTING DISC |
| 13 | 415206 | ROCK SHAFT CRANK | 46 | 268066 | ADJUSTING DISC SPR |
| 14 | 414511 | SCREW | 47 | 412011 | SPRING COLLAR |
| 15 | 414549 | SCREW | 48 | 544325 | SET SCREW |
| 16 | 415091 | HINGE STUD | 49 | 415187 | SPREADER DRIVING ECCENTRIC |
| 17 | 268258 | PACKING WICK | 50 | 543808002 | PIN |
| 18 | 541197 | NUT | 51 | 414528 | SCREW |
| 19 | 281216 | BED SHAFT BALL BEARING | 52 | 268220 | THRUST WASHER |
| 20 | 281224 | BED SHAFT BALL BEARING | 53 | 281246001 | SPREADER DRIVING ECC CPL |
| 21 | 559038 | BED SHAFT CPL | 54 | 415368 | NEEDLE BEARING (300UX5) |
| 22 | 268265 | CONTROL ROD | 55 | 281248 | SPRD DR RCK SHFT SCR STD BALL |
| 23 | 268044 | SPRING, OIL STOP BALL | 56 | 544203001 | SCREW |
| 24 | 268214 | BALL, OIL STOP | 57 | 415190 | COUNTER BALANCE (300UX5) |
| 25 | 414578 | BALL SCREW | 58 | 281292 | BED SHAFT CONNECTION BELT PULL |
| 26 | 415215 | DRIVE SHAFT COMP | 59 | 414546 | SCREW |
| 27 | 271055 | FD DRIVE CONN | 60 | 281294 | ARM SHAFT THRUST COLLAR |
| 28 | 271055 | FEED DRIVING CONNECTION NEEDLE | 61 | 281295001 | BED SHAFT THRUST COLLAR |
| 29 | 267609 | FEED DRIVING CONN | 62 | 544209005 | SET SCREW |
| 30 | 415213 | SHAFT CRANK | 63 | 272142 | BALL BEARING |
| 31 | 414511 | SCREW | 64 | KE0038 | BED SHAFT PULLEY |
| 32 | 415091 | HINGE STUD | 65 | 544209005 | SET SCREW |
| 33 | 268258 | PACKING WICK | | | |



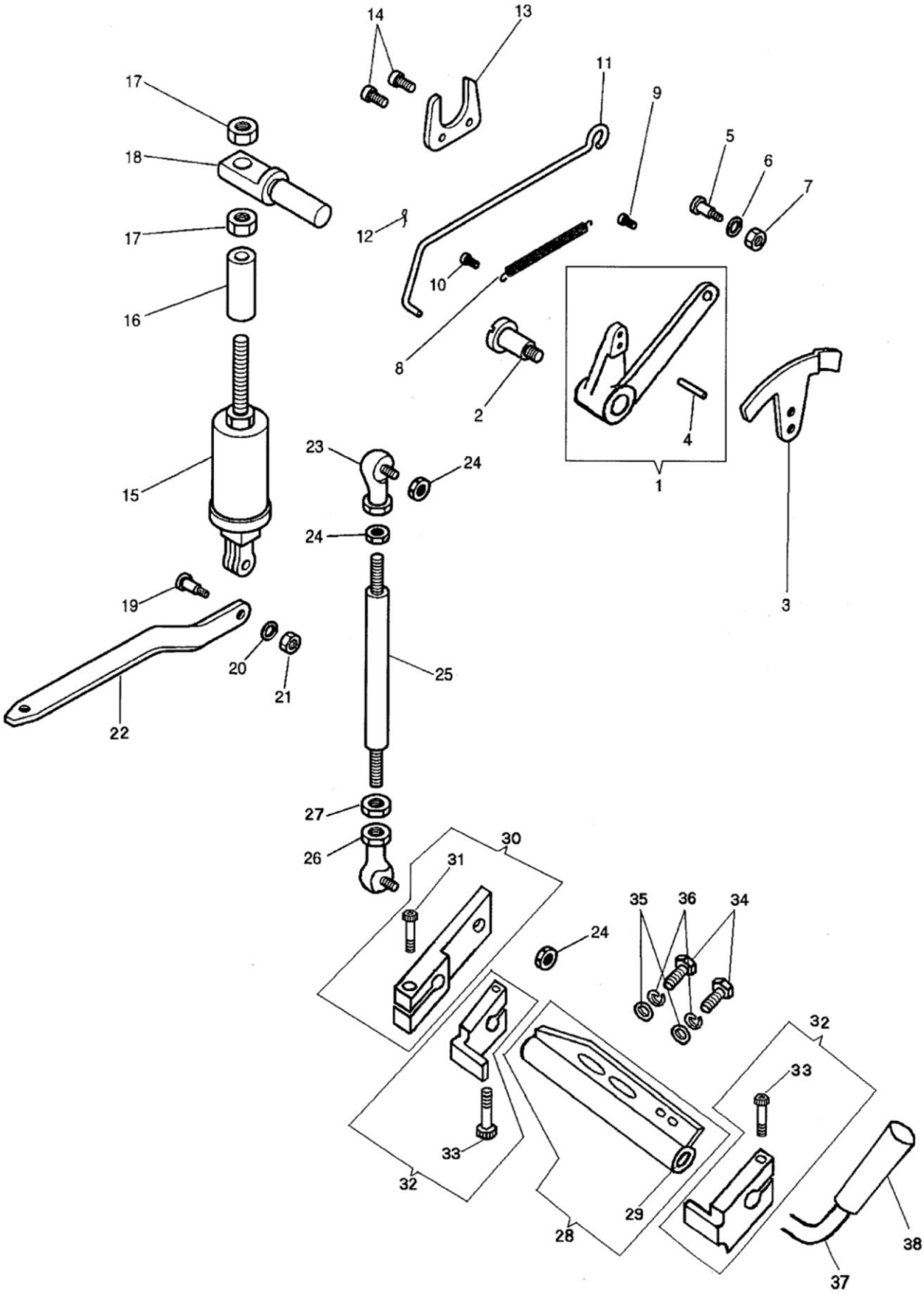
# Front Assembly Sewing Bed

| NO. | PART # | DESCRIPTION | NO. | PART # | DESCRIPTION |
|---|---|---|---|---|---|
| 1 | 559061 | FEED DOG | 28 | 281208 | LOOPER COMPLETE WITH GUARD |
| 2 | 267665 | LOOP DEFLECTOR | 29 | 268382 | LOOPER ONLY (ORDER 281207 FOR |
| 3 | 412176 | LINK, CONN CRANK | 30 | 281207 | NEEDLE GUARD |
| 4 | 559064 | FEED DOG SHANK | 31 | 141478 | SCREW |
| 5 | 414559 | SCREW | 32 | 141494 | SCREW |
| 6 | 541200 | LOCK NUT | 33 | 281223 | LOOPER DRIVING CONNECTION CPL |
| 7 | 414750002 | SCREW | 34 | 415500 | BUSHING |
| 8 | 543804004 | WASHER | 35 | 414516 | SCREW |
| 9 | 374107003 | SCREW | 36 | 268208 | CRANK HINGE PIN |
| 10 | 559049 | FEED DRIVE ROCK FRAME | 37 | 268258 | PACKING WICK |
| 11 | 549024 | SCREW | 38 | 415174 | LOOPER CARR CR CPL |
| 12 | 500264833 | FEED DRIVING ROCK FRAME SET SCREW | 39 | 415292 | CLAMPING STUD |
| 13 | 559051 | FEED BAR HINGE PIN | 40 | 541198 | NUT |
| 14 | 415297 | BUSHING | 41 | 548459 | WASHER |
| 15 | 268070 | SHAFT, DRIVE ROCK | 42 | 559041 | LOOPER CARRIER |
| 16 | 559045 | FEED BAR | 43 | 415500 | BUSHING |
| 17 | 270 544204001 | SCREW | 44 | 559055 | LOOPER HOLDER CPL |
| 18 | 545213 | SET SCREW | 45 | 414558 | SCREW |
| 19 | 268078 | FEED LIFTING LINK | 46 | 414750002 | SCREW |
| 20 | 268079 | LINK HINGE PIN | 47 | 543804004 | WASHER |
| 21 | 268258 | PACKING WICK | 48 | 269617 | CARRIER SHAFT |
| 22 | 559052 | FEED LIFTING ROCK SHAFT | 49 | 415172 | SHAFT COLLAR |
| 23 | 415065 | COLLAR COMP | 50 | 270 544204001 | SCREW |
| 24 | 504020 | SCREW (300UX5) | 51 | 544209003 | SCREW |
| 25 | 415204 | CRANK | 52 | 559044 | LOOPER CARRIER SHAFT SUPPORTIN |
| 26 | 414501 | SCREW | 53 | 200100 | SCREW |
| 27 | 545213 | SET SCREW | 54 | 415297 | NEEDLE BEARING |



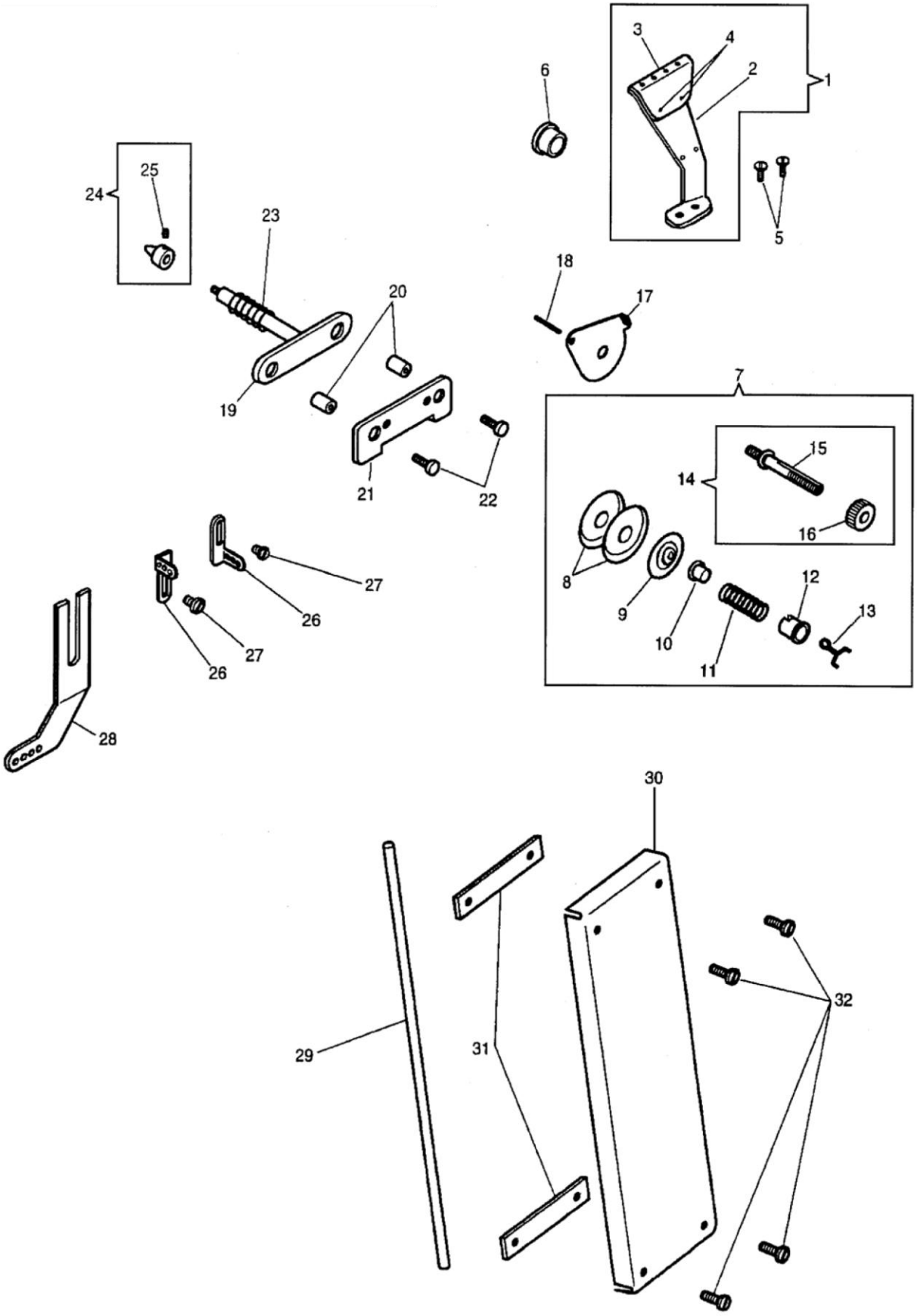
# Cross Shaft in Sewing Bed

| NO. | PART # | DESCRIPTION |
|---|---|---|
| 1 | 281975 | SPREADER |
| 2 | 268162 | SPREADER POINT |
| 3 | 414552 | SCREW |
| 4 | 547670 | WASHER |
| 5 | 415196 | SPREADER HOLDER |
| 6 | 414529 | SCREW |
| 7 | 268184 | SPREADER BAR BRACKET |
| 8 | 414524 | SCREW |
| 9 | 559065 | SPREADER BAR |
| 10 | 268190 | SPREADER DRIVE PIN |
| 11 | 415297 | BUSHING |
| 12 | 415389 | ROCK SHAFT |
| 13 | 415194 | CRANK COMP |
| 14 | 270 544204001 | SCREW |
| 15 | 281249 | SPREADER DRIVING ROCK SHAFT SC |
| 16 | 32825 | OIL WICK |
| 17 | 545424 | NUT |
| 18 | 415065 | COLLAR COMP |
| 19 | 504020 | SCREW (300UX5) |
| 20 | 268052 | LOOPER TAKE UP ROD |
| 21 | 545385 | SCREW |
| 22 | 269619 | THREAD GUIDE |
| 23 | 414510 | SCREW |



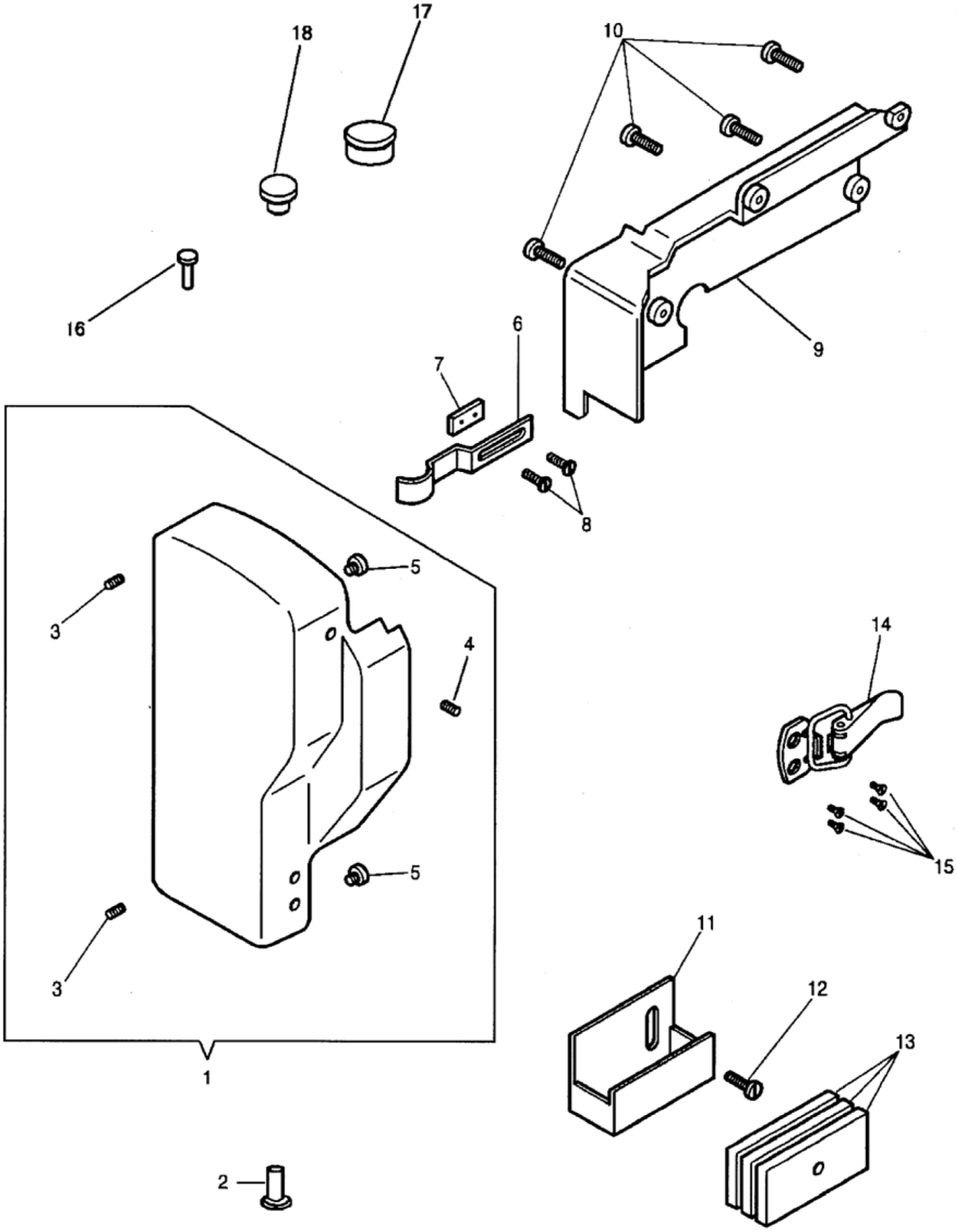
# External Parts Sewing Arm #2

| NO. | PART # | DESCRIPTION |
|---|---|---|
| 1 | KE0085 | FOOT LIFTER LEVER |
| 2 | 201363 | SCREW 300W |
| 3 | 267707 | RELEASING PLATE |
| 4 | 543850001 | PLATE PIN |
| 5 | 414577 | HINGE SCREW |
| 6 | 543804004 | WASHER |
| 7 | 541166003 | NUT |
| 8 | 204348 | SWITCH SPRING |
| 9 | 414570 | SCREW |
| 10 | 544336 | STUD SCREW |
| 11 | 267704 | LIFTER LEVER ROD |
| 12 | 248423 | COTTER PIN |
| 13 | 267650 | RETAINER |
| 14 | 545205451 | SCREW, WHITE |
| 15 | 415106 | PRESSER BAR SPRING HOUSING ASS |
| 16 | 559077 | PRESSER BAR SPRING HOUSING COL |
| 17 | 541198 | NUT |
| 18 | 267714 | HOUSING SUPPORT |
| 19 | 414567 | HINGE SCREW |
| 20 | 548154 | SCREW WASHER |
| 21 | 545405 | NUT |
| 22 | 267738 | PR BAR SPR ARM |
| 23 | 412373 | CONNECTION (UPPER) |
| 24 | 541166001 | NUT |
| 25 | 559068 | LIFTING ROD |
| 26 | 559067 | LIFTING ROD CONNECTION (LOWER) |
| 27 | 414774 | NUT |
| 28 | KE0026 | FOOT LIFT PIVOT COMPLETE |
| 29 | KE0030 | BUSHING |
| 30 | KE0083 | FOOT LIFT LEVER COMPLETE |
| 31 | 414753004 | BELT TENSION BRACKET SET SCREW |
| 32 | KE0084 | STOP COLLAR COMPLETE |
| 33 | 414750004 | PRESSER BAR SPRING ARM FULCRUM |
| 34 | 544499072 | SCREW |
| 35 | 270 543803005 | WASHER |
| 36 | 270 543805005 | WASHER |
| 37 | KE0034 | PIVOT ARM |
| 38 | KE0035 | HANDLE |



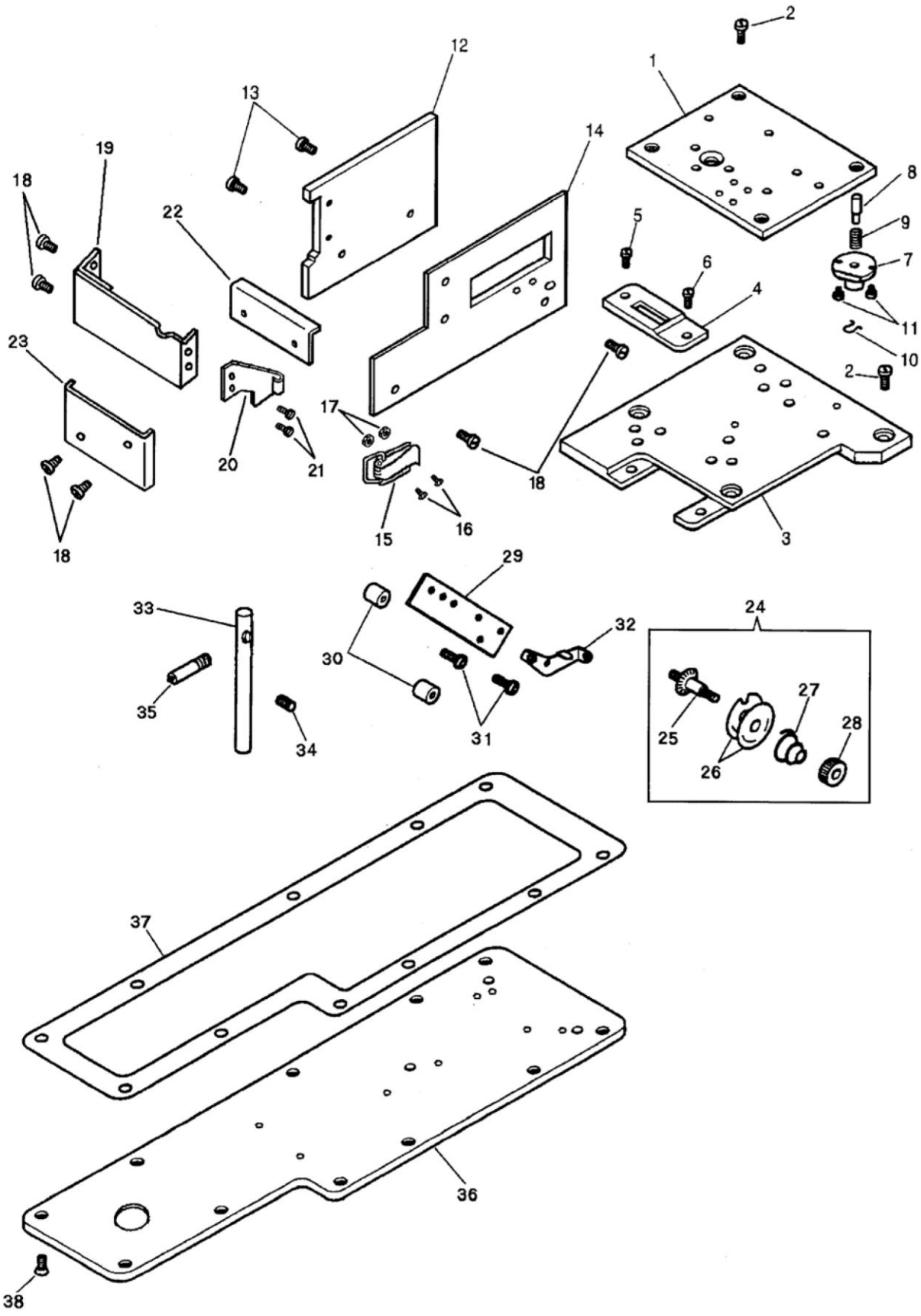
# External Parts Sewing Arm #3

| NO. | PART # | DESCRIPTION |
|---|---|---|
| 1 | 268506 | TH GUIDE BRACKET |
| 2 | 268111 | LOOPER BRACKET |
| 3 | 268505 | LOOPER TH GUIDE |
| 4 | 50169 | SCREW (5) |
| 5 | 414537 | SCREW |
| 6 | 544875 | PLUG |
| 7 | 267971 | THREAD TENSION |
| 8 | HA046072 | TENSION DICS |
| 9 | 32572 | TENSION DISC (5) |
| 10 | 59538 | SPRING BUSHING |
| 11 | 131741 | TENSION SPRING |
| 12 | 143657 | BUSHING |
| 13 | 143658 | LOCKING SPRING |
| 14 | 59539 | TENSION SCREW STUD |
| 15 | 59539 | TENSION SCREW STUD |
| 16 | 51570 | NUT |
| 17 | 54279 | THREAD GUIDE |
| 18 | 226206 | LATCH SPRING PIN |
| 19 | 415357 | TENSION RELEASER |
| 20 | 543853003 | NEEDLE THREAD TENSION BRACKET |
| 21 | 268167 | TENSION BRACKET |
| 22 | 544336 | STUD SCREW |
| 23 | 204365 | SPRING |
| 24 | 415252 | RELEASER CAP |
| 25 | 504048 | SCREW |
| 26 | 268513 | N THREAD GUIDE |
| 27 | 414514 | SCREW |
| 28 | 268312 | THREAD GUIDE |
| 29 | 268123 | THREAD TUBE |
| 30 | 415342451 | LOOPER THREAD TUBE COVER |
| 31 | 268500 | GASKET |
| 32 | 414639 | GUIDE SCREW |



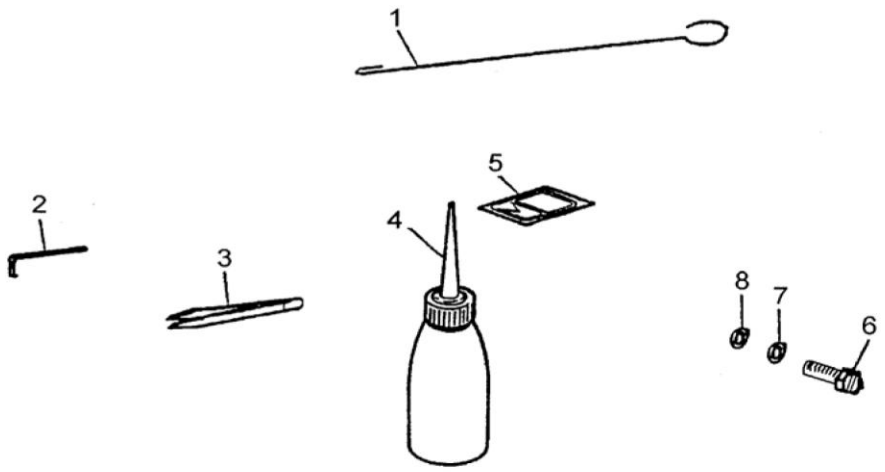
# External Parts Sewing Arm #4

| NO. | PART # | DESCRIPTION |
|---|---|---|
| 1 | KE0021 | FACE PLATE (WITH 268033) |
| 2 | 268330 | FACE PLATE HINGE STUD |
| 3 | 544053 | SET SCREW |
| 4 | 268033 | LOCK STUD |
| 5 | 228661 | COVER CUSHION |
| 6 | 268032 | LOCK SPRING |
| 7 | 415016 | SPRING PLATE |
| 8 | 414534 | SCREW |
| 9 | KE0072 | ARM SIDE COVER |
| 10 | 545295 | SCREW |
| 11 | 267656452 | THREAD LUBRICATOR |
| 12 | 545385 | SCREW |
| 13 | 236957 | OIL PAD,THREAD LUBRICATOR (FEL |
| 14 | 559032 | FACE PLATE LOCKER |
| 15 | 374397002 | FACE PLATE LOCKER SCREW |
| 16 | KE0007 | FACE PLATE HINGE STUD |
| 17 | 544875 | PLUG |
| 18 | 502986 | PLUG |



# External Parts Sewing Arm #5

| NO. | PART # | DESCRIPTION |
|---|---|---|
| 1 | KE0073 | BED PLATE (RIGHT) |
| 2 | 414508 | SCREW |
| 3 | KE0037 | BED PLATE (LEFT) |
| 4 | 559060 | THROAT PLATE |
| 5 | 374107001 | THROAT PLATE SCREW (BACK) |
| 6 | 200100 | SCREW |
| 7 | KE0075 | FEED REGULATING STUD SOCKET |
| 8 | 268081 | STUD, FEED REG |
| 9 | 270026 | FEED REG STUD SPR |
| 10 | 240245 | RETAINING SPRING, (5PK) |
| 11 | 545249452 | FEED REGULATING STUD SOCKET SC |
| 12 | 559075 | BED COVER (BACK) |
| 13 | 414520 | SCREW |
| 14 | KE0068 | BED COVER (FRONT) |
| 15 | KE0044 | BED COVER (FRONT) LOCKER |
| 16 | 270 544211051 | STRIKER SCREW |
| 17 | 541164001 | NUT |
| 18 | 544252 | SET SCREW (300UX5) |
| 19 | KE0039 | LOOPER COVER |
| 20 | KE0042 | SNAP HOOK LATCH |
| 21 | 544252 | SET SCREW (300UX5) |
| 22 | 559074 | BED COVER (LEFT) |
| 23 | KE0043 | END COVER |
| 24 | 415294 | TENSION COMP |
| 25 | 415291 | TENSION STUD |
| 26 | 412203 | TENSION DISC |
| 27 | 10148 | SPRING |
| 28 | 541452 | NUT |
| 29 | 415255 | TENSION BRACKET |
| 30 | 543853003 | NEEDLE THREAD TENSION BRACKET |
| 31 | 414532 | SCREW |
| 32 | 268333 | THREAD GUIDE |
| 33 | 52239 | LOOPER THREAD GUIDE |
| 34 | 270 544211052 | SCREW |
| 35 | 559078 | LOOPER THREAD GUIDE (PIPE) |
| 36 | KE0005 | BOTTM PLATE |
| 37 | 559034 | BOTTOM PLATE GASKET |
| 38 | 414533 | SCREW |




# Accessories

| NO. | PART NO. | DESCRIPTION |
|---|---|---|
| 1 | 170 415377 | THREADER WIRE |
| 2 | 170 021887 | WRENCH |
| 3 | 270 BENTTWEEZER | BENT TWEEZERS, METAL |
| 4 | 170 413448001 | OILER |
| 5 | 160 411201120 | NEEDLE, 62X59 |
| 6 | 170 KE0015 | BOLT |
| 7 | 170 KE0016 | WASHER |
| 8 | 170 KE0017 | SPRING WASHER |

# Assembly Drawings & Parts Lists

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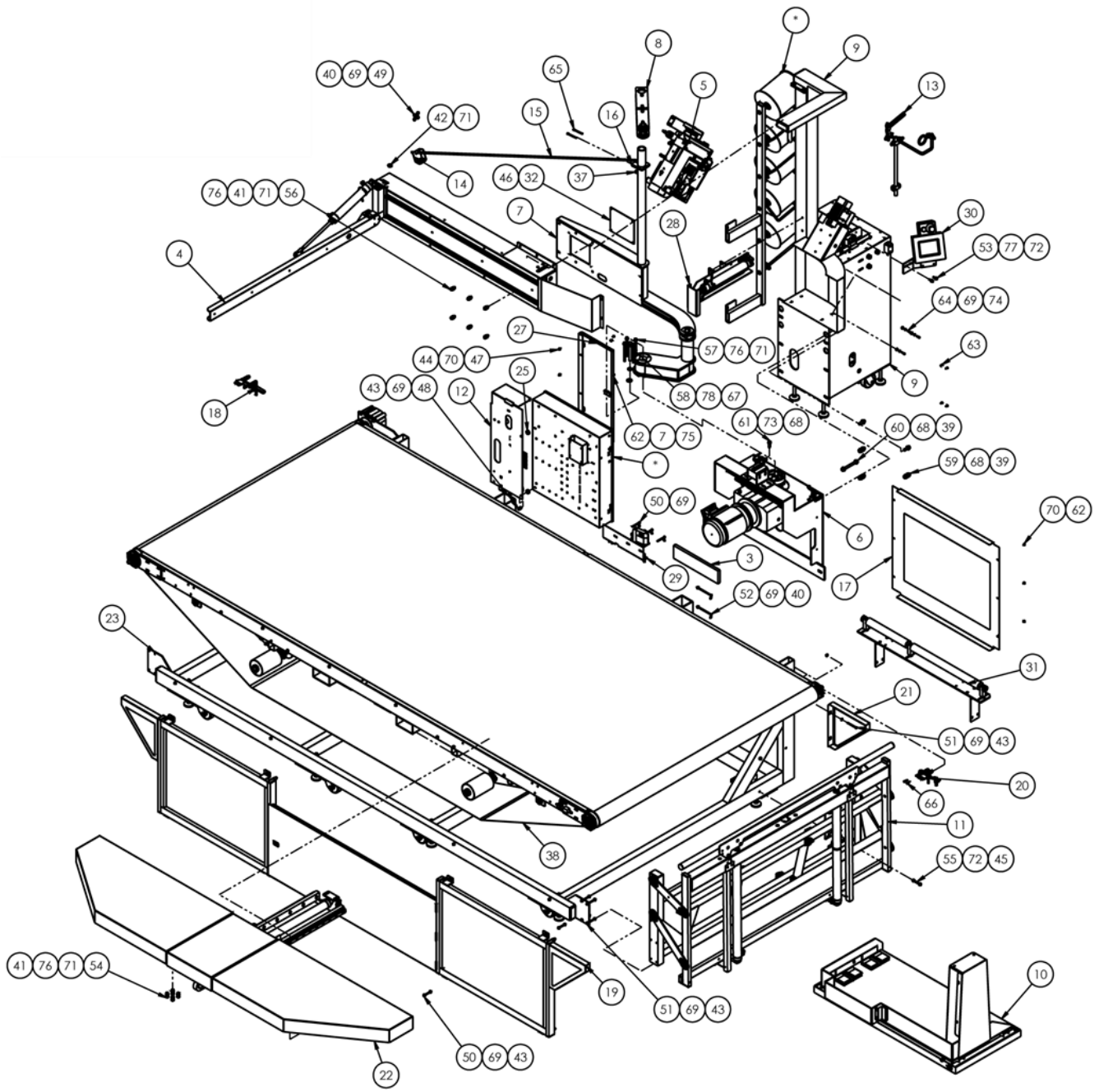
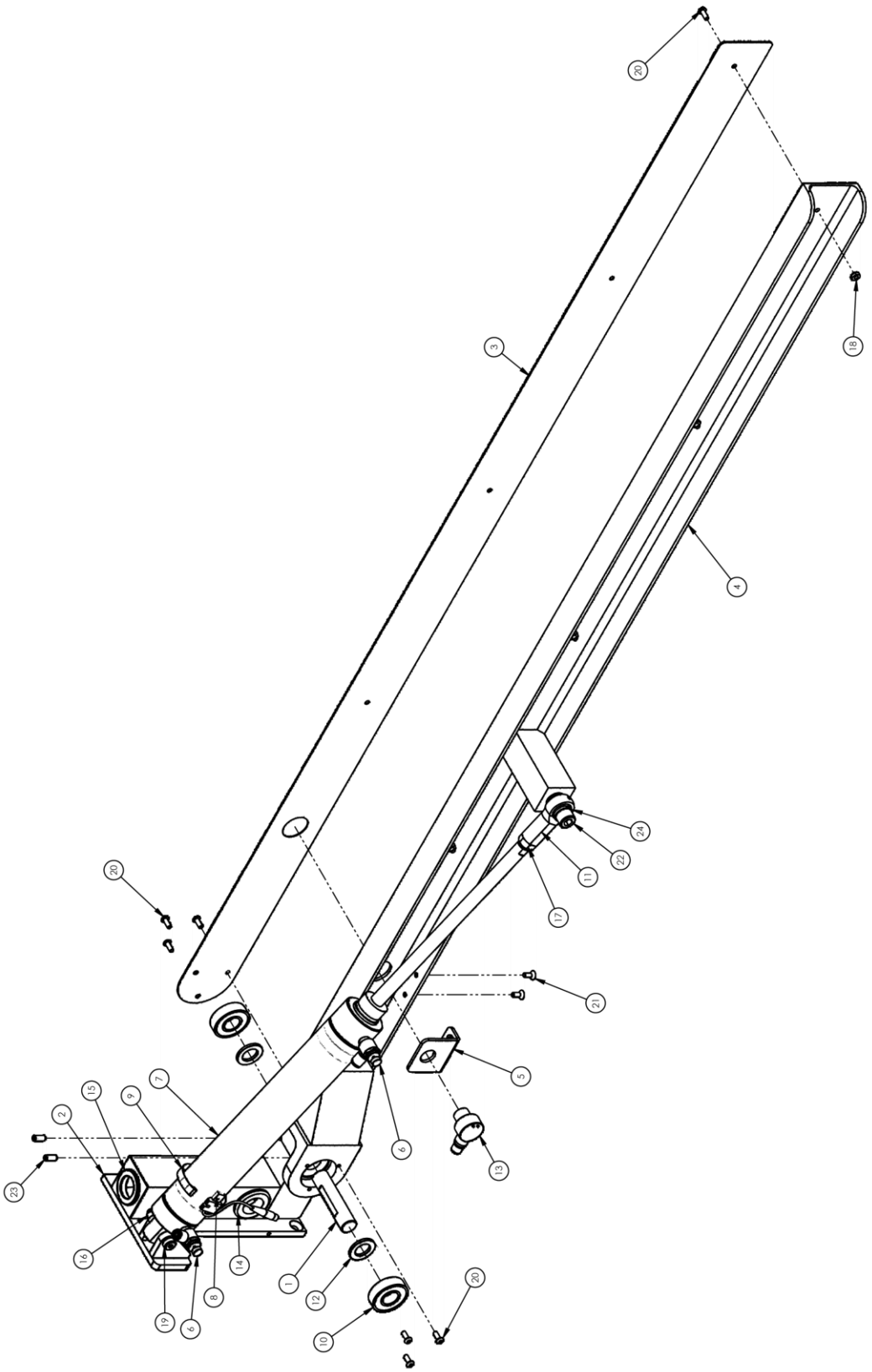


# 11315A Auto Tape Edge Machine

AAC Drawing Number 9000740 Rev0

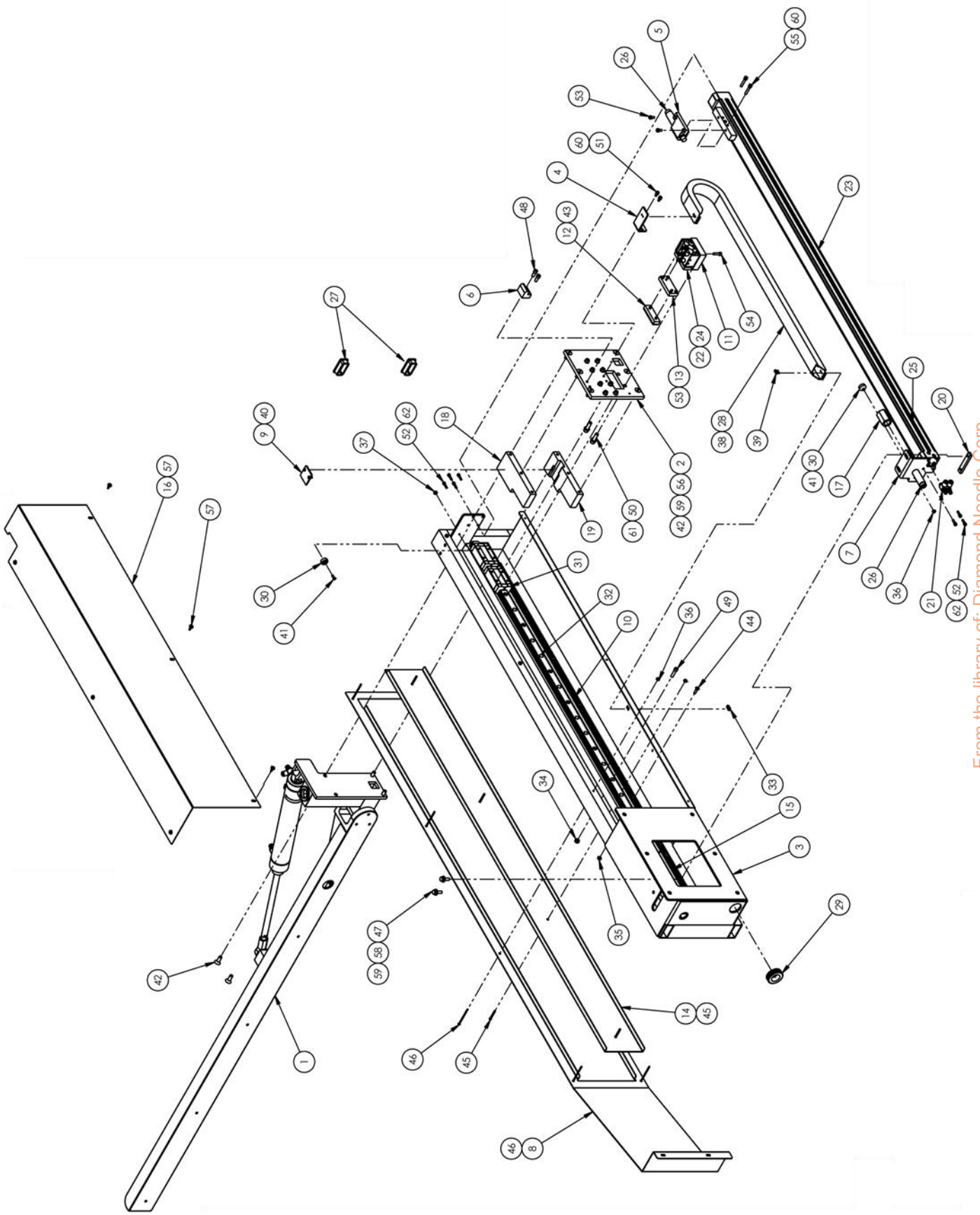
| | NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|---|
| | 1 | *1 | 1315-LAB1 | LABELS,MAIN | 40 | 8 | NNH1/4-20 | 1/4-20 HEX NUT |
| | 2 | *1 | 1315-LAB2 | LABELS,CAUTION | 41 | 16 | NNH3/8-16 | 3/8-16 HEX NUT |
| | 3 | 1 | 1315049 | PAD, HIP | 42 | 2 | NNH3/8-24 | 3/8-24 HEX NUT |
| Page 67 | 4 | 1 | 1315050 | ROTATE ARM ASSEMBLY | 43 | 26 | NNK1/4-20 | KEP NUT, 1/4-20 |
| Page 71 | 5 | 1 | 1315100 | SEW HEAD ASSEMBLY | 44 | 2 | NNK10-32 | KEP NUT, 10-32 |
| Page 73 | 6 | 1 | 1315115 | ARM GEARBOX ASSEMBLY | 45 | 2 | NNK5/16-18 | KEP NUT, 5/16-18 |
| | 7 | 1 | 1315160 | WELDMENT, ROTATE ARM | 46 | 4 | SSBC90024 | #8-32 X 3/8 BUT HEAD |
| | 8 | 1 | 1315195 | ARM, SUPPORT, UPPER | 47 | 2 | SSBC98040 | #10-32 X 5/8 BUT HEAD |
| Page 77 | 9 | 1 | 1315300 | CONSOLE ASSEMBLY | 48 | 2 | SSHC01064 | 1/4-20 X 1 HEX HEAD |
| Page 79 | 10 | 1 | 1315327 | LIFT PLATFORM ASSEMBLY | 49 | 2 | SSHC01112 | 1/4-20 X 1-3/4 HEX HEAD |
| Page 81 | 11 | 1 | 1315400 | ASSY, FLIPPER | 50 | 15 | SSHC01160 | 1/4-20 X 2-1/2 HEX HEAD |
| Page 82 | 12 | 1 | 1315430 | PANEL, PNEUMATIC | 51 | 11 | SSHC01192 | 1/4-20 X 3 HEX HEAD |
| Page 85 | 13 | 1 | 1315450 | TAPE GUIDE ASSEMBLY | 52 | 4 | SSHC01320 | 1/4-20 X 5 HEX HEAD |
| | 14 | 1 | 1315460 | BRACKET, ARM SUPPORT | 53 | 4 | SSHC10064 | 5/16-18 X 1" HEX HEAD |
| | 15 | 1 | 1315462 | ROD, SUPPORT | 54 | 8 | SSHC10080 | 5/16-18 X 1-1/4 HEX HEAD |
| | 16 | 1 | 1315463 | CLAMP, SUPPORT ROD | 55 | 2 | SSHC10176 | 5/16-18 X 2-3/4 HEX HEAD |
| | 17 | 1 | 1315472 | ASSY, COVER REAR | 56 | 8 | SSHC25064 | 3/8-16 X 1 HEX HEAD |
| Page 86 | 18 | 1 | 1315479 | AIR JET ASSEMBLY; RIGHT | 57 | 4 | SSHC35352 | 3/8-24 X 5.50L HEX HEAD |
| | 19 | 1 | 1315480 | SUPPORT FRAME & DOOR ASSY | 58 | 1 | SSHC41320 | 5/8-11 X 5.0L HEX HEAD |
| Page 87 | 20 | 1 | 1315483 | AIR JET ASSEMBLY; LEFT | 59 | 6 | SSHC45096 | 1/2-13 X 1-1/2 HEX HEAD |
| | 21 | 1 | 1315485 | ASSY, GUARD TRI LEFT | 60 | 2 | SSHC45288 | 1/2-13 X 4-1/2 HEX HEAD |
| Page 89 | 22 | 1 | 1315498 | PUSH PLATE ASSEMBLY | 61 | 2 | SSHC46080F | 1/2-20 X 1-1/4 HEX HEAD FULL THD |
| Page 91 | 23 | 1 | 1315502 | TABLE ASSEMBLY | 62 | 8 | SSPP98024 | #10-32 X 3/8 PAN HD PHIL |
| Page 93 | 24 | 1 | 1315560 | CONTROL BOX ASSEMBLY | 63 | 4 | SSPP98032 | #10-32 X 1/2 PAN HD PHIL |
| | 25 | 4 | 1315564 | SPACER, CONTROL BOX | 64 | 3 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| Page 84 | 26 | 1 | 1315575 | HOLDER, TAPE ROLL | 65 | 2 | SSSC01176 | 1/4-20 X 2-3/4 SOC CAP |
| | 27 | 1 | 1315590 | DOOR, PNEU. PANEL | 66 | 4 | SSSC98064 | #10-32 X 1 SOC CAP |
| Page 83 | 28 | 1 | 1315595 | HEAD PUSHER ASSEMBLY | 67 | 1 | WWF5/8 | WASHER, FLAT, 5/8 |
| Page 94 | 29 | 1 | 1315603 | SENSOR BRKT. ASSEMBLY | 68 | 16 | WWFS1/2 | WASHER, FLAT, 1/2 |
| Page 95 | 30 | 1 | 1315610 | TOUCH SCREEN ASSEMBLY | 69 | 71 | WWFS1/4 | WASHER FLAT, 1/4 |
| Page 69 | 31 | 1 | 1315620 | GUIDE ROLLER ASSEMBLY | 70 | 10 | WWFS10 | WASHER, FLAT #10 |
| | 32 | 1 | 1315642 | COVER, ACCESS HOLE | 71 | 38 | WWFS3/8 | WASHER, FLAT, 3/8 |
| | 33 | *1 | 1315A-CAB | CABLE PACKAGE | 72 | 8 | WWFS5/16 | WASHER, FLAT, 5/16 |
| | 34 | *1 | 1315A-LAB | LABEL PACKAGE | 73 | 8 | WWL1/2 | 1/2 LW |
| Page 96 | 35 | *1 | 1315A-PD | DIAGRAM,PNEUMATIC | 74 | 11 | WWL1/4 | 1/4 LW |
| Page 97 | 36 | *1 | 1315A-WD | DIAGRAM,WIRING | 75 | 2 | WWL10 | #10 LW |
| | 37 | 1 | CCCL6F | CLAMP COLLAR- 3/8 | 76 | 20 | WWL3/8 | 3/8 LW |
| | 38 | 1 | MMNCA2206 | BELT, URETHANE,350" LONG | 77 | 4 | WWL5/16 | 5/16 LW |
| | 39 | 6 | NNH1/2-13 | 1/2-13 HEX NUT | 78 | 1 | WWL5/8 | 5/8 LW |



# 1315030 Backstop Assembly

AAC Drawing Number 1315030 Rev1

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315023 | SHAFT, BACK STOP PIVOT |
| 2 | 1 | 1315024 | WELDMENT, PIVOT BLOCK |
| 3 | 1 | 1315029 | PLATE, ARM COVER |
| 4 | 1 | 1315059 | WELDMENT, BACKSTOP |
| 5 | 1 | 1315062 | BRACKET, BACKSTOP SENSOR |
| 6 | 2 | AA2201-07 | FLOW CONTROL,1/4TX1/4NPT |
| 7 | 1 | AACCM3110DXP | CYLINDER,AIR,DA,W/MAGNET |
| 8 | 1 | AAEHSKQ | SWITCH,HALL EFFECT BIMBA |
| 9 | 1 | AAFD35875-14 | BAND, CYLINDER,HSKQ HAL |
| 10 | 2 | BB2281288 | BEARING,BALL,.75 ID |
| 11 | 1 | BBAW-8Z | BEARING,ROD END,FEMALE |
| 12 | 2 | BBTT5906K518 | BEARING,THRUST .75IDX1.25 |
| 13 | 1 | FFT18FF100Q | EYE,FIXED FIELD, 4IN |
| 14 | 1 | MM9307K74 | GROMMET,3/4ID,1.38OD,.13GV |
| 15 | 1 | MM9602K14 | GROMMET,RUBBER,1" ID |
| 16 | 1 | NNE5/16-18 | NUT,ELASTIC LOCK,5/16-18 |
| 17 | 1 | NNJ1/2-20 | 1/2-20 HEX JAM NUT |
| 18 | 4 | NNK10-32 | KEP NUT, 10-32 |
| 19 | 1 | SSAS024096 | 3/8 X 1-1/2 X 5/16-18 SHLD, BOLT |
| 20 | 10 | SSBC98032 | #10-32 X 1/2 BUT HEAD |
| 21 | 2 | SSFC98032 | #10-32 X 1/2 FLAT ALLEN |
| 22 | 1 | SSSC46096 | 1/2-20 X 1-1/2 SOC CAP |
| 23 | 2 | SSSS01040 | 1/4-20 X 5/8 KNURL PT |
| 24 | 1 | WWL1/2 | 1/2 LW |

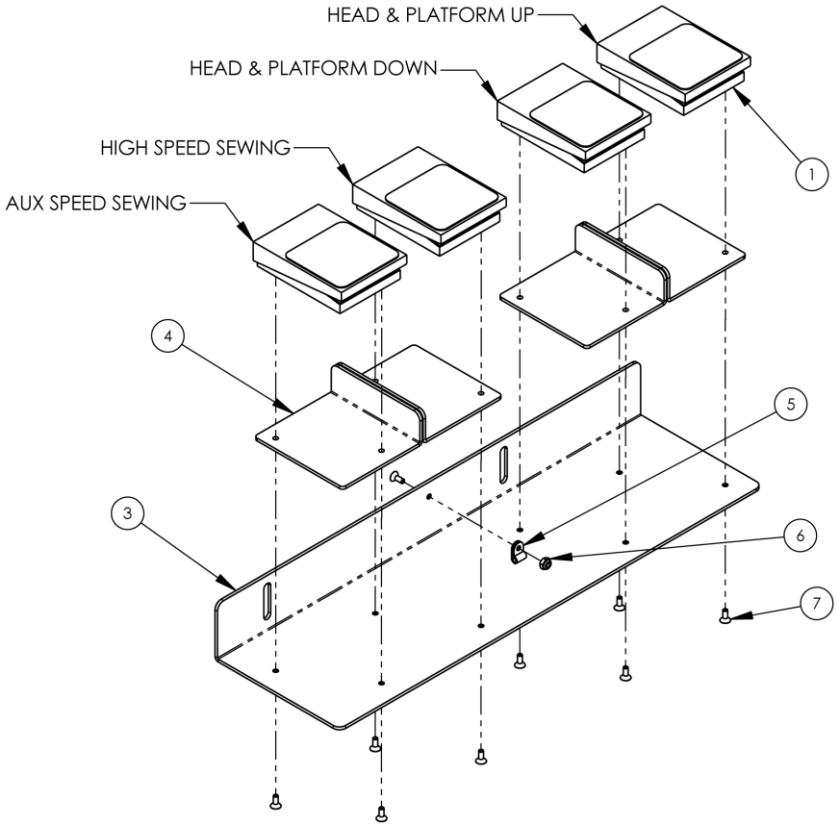


# 1315050 Rotate Arm Assembly

AAC Drawing Number 1315050 Rev3

Page 65

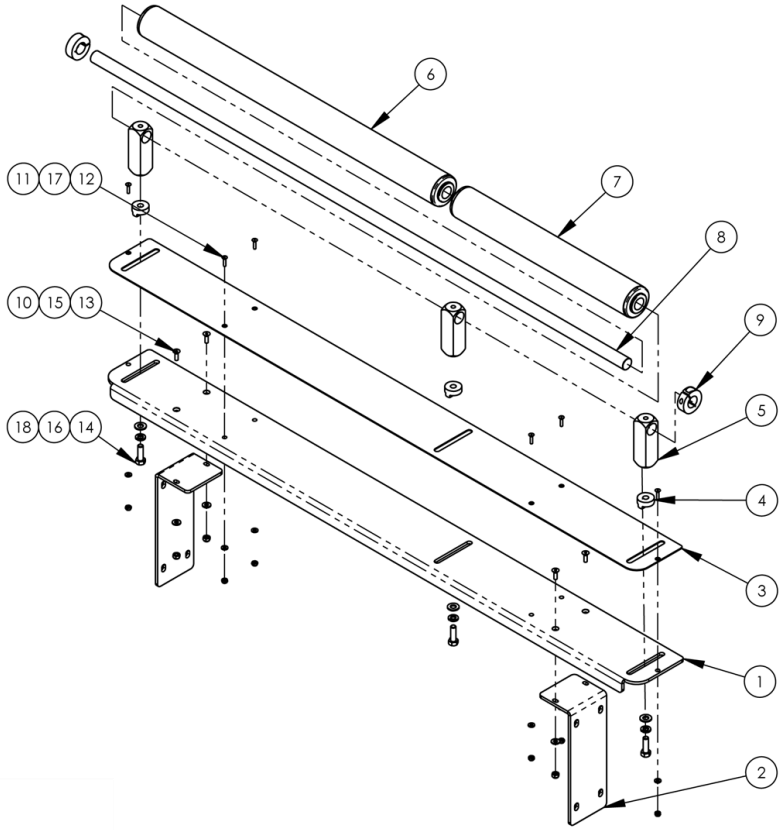
| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 1 | 1315030 | BACKSTOP ASSEMBLY | 32 | 1 | MMAGR251430N | RAIL,LINEAR, AG SERIES |
| 2 | 1 | 1315033 | CARRIER, BACK STOP | 33 | 2 | NNE6-32 | NUT,ELASTIC LOCK,6-32 |
| 3 | 1 | 1315035 | ARM, WELDMENT | 34 | 10 | NNK1/4-20 | KEP NUT, 1/4-20 |
| 4 | 1 | 1315036 | MOUNT, CABLETRAK | 35 | 9 | NNK10-32 | KEP NUT, 10-32 |
| 5 | 1 | 1315038 | MOUNT, SHOCK | 36 | 13 | NNK6-32 | KEP NUT, 6-32 |
| 6 | 1 | 1315039 | BLOCK, STOP | 37 | 1 | NNK8-32 | KEP NUT, 8-32 |
| 7 | 1 | 1315040 | MOUNT, CYLINDER | 38 | 2 | SSBC80016 | #6-32 X 1/4 BUT HEAD |
| 8 | 1 | 1315041 | COVER, ARM LONG | 39 | 2 | SSBC80024 | #6-32 X 3/8 BUT HEAD |
| 9 | 1 | 1315042 | COVER, CABLE | 40 | 2 | SSBC90024 | #8-32 X 3/8 BUT HEAD |
| 10 | 1 | 1315184 | RACK, LONG GEAR | 41 | 2 | SSBC90032 | #8-32 X 1/2 BUT HEAD |
| 11 | 1 | 1315186 | BLOCK, MOUNT CYL | 42 | 10 | SSFC10056 | 5/16-18 X 7/8 FLAT ALLEN |
| 12 | 1 | 1315187 | RACK, LOCKING GEAR | 43 | 2 | SSFC98032 | #10-32 X 1/2 FLAT ALLEN |
| 13 | 1 | 1315188 | MOUNT, GEAR RACK SMALL | 44 | 9 | SSFC98048 | #10-32 X 3/4 FLAT ALLEN |
| 14 | 1 | 1315197 | COVER, ARM CENTER | 45 | 4 | SSFS80080 | #6-32 X 1-1/4 FLAT SLOT |
| 15 | 1 | 1315199 | RACK, SHORT GEAR | 46 | 8 | SSFS80144 | #6-32 X 2-1/4, FLAT SLOT |
| 16 | 1 | 1315432 | COVER, ARM, FRONT | 47 | 2 | SSHC01056 | 1/4-20 X 7/8 HEX HEAD |
| 17 | 1 | 1315445 | COLLAR, STOP | 48 | 2 | SSSC01040 | 1/4-20 X 5/8 SOC CAP |
| 18 | 1 | 1315516 | SPACER, PIVOT PLATE | 49 | 10 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 19 | 1 | 1315520 | SPACER, PIVOT PLATE | 50 | 2 | SSSC10064 | 5/16-18 X 1 SOC CAP |
| 20 | 1 | 96-5606 | PLATE, NUT 2.0 CTC 1/4 | 51 | 2 | SSSC98024 | #10-32 X 3/8 SOC CAP |
| 21 | 2 | AA198RA408U | FLOW CONTROL,RC 1/8X1/4 | 52 | 7 | SSSCM4X16 | M4-0.7 X 16 SOC CAP |
| 22 | 2 | AA198RA510 | FLOW CONTROL,5/32X10-32 | 53 | 6 | SSSCM5X10 | M5-0.8 X 10 SOC CAP |
| 23 | 1 | AACDGP251220 | CYLINDER,AIR,RODLESS | 54 | 4 | SSSCM5X20 | M5-0.8 X 20 SOC CAP |
| 24 | 1 | AACMGPM1610 | CYLINDER, AIR,DUAL ROD | 55 | 2 | SSSCM5X30 | M5-0.8 X 30 SOC CAP |
| 25 | 1 | AAESME8KLED24M | SENSOR FOR FESTO DNCB CYL | 56 | 8 | SSSCM6X20 | M6-1.0 X 20 SOC CAP |
| 26 | 2 | AAOEM.5BSA | SHOCK, 3/4-18 X 3.5 | 57 | 6 | SSZS93032 | SCREW, SHT.METAL 10 ZIP |
| 27 | 2 | MM132-1496 | PLUG 1 X 2 | 58 | 2 | WWFS1/4 | WASHER FLAT, 1/4 |
| 28 | 1 | MM180302848 | DUCT,WIRE MICROTRAK | 59 | 10 | WWL1/4 | 1/4 LW |
| 29 | 1 | MM2772 | GROMMET,1 ID X 3/16 GR | 60 | 4 | WWL10 | #10 LW |
| 30 | 2 | MM9405K14 | BUMPER,RECESSED,ELASTOMER | 61 | 2 | WWL5/16 | 5/16 LW |
| 31 | 2 | MMAGH25CAN | LINEAR BEARING | 62 | 7 | WWL8 | #8 LW |




# 1315060 Foot Pedal Assembly

AAC Drawing Number 1315060 Rev0

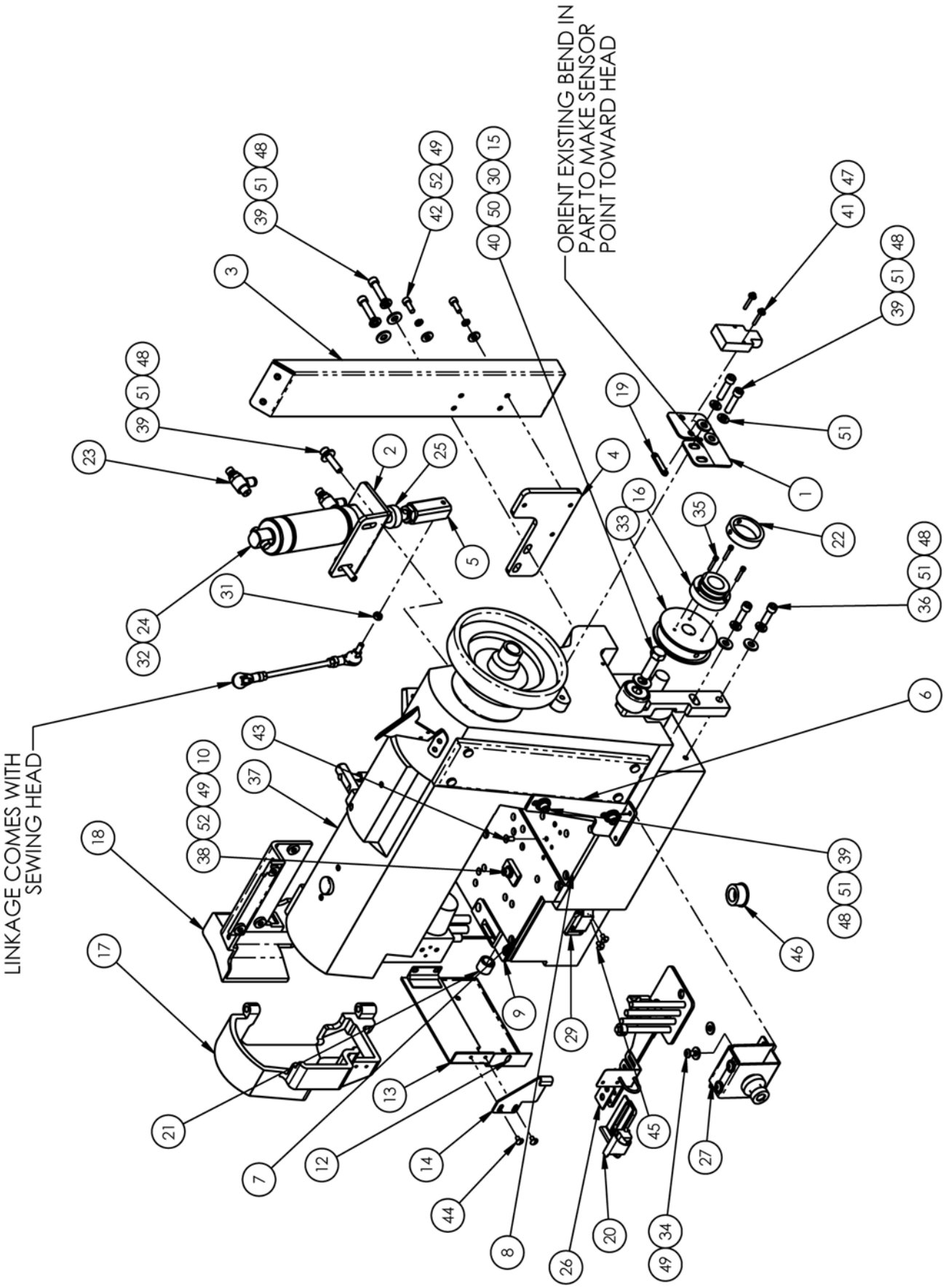
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 4 | 1278-6161 | FOOT SWITCH MODIFICATION |
| 2 | 1 | 1315-010 | CABLE, FOOT PEDAL |
| 3 | 1 | 1315047 | PLATE, PEDAL MOUNT |
| 4 | 4 | 1315048 | GUARD, PEDAL |
| 5 | 1 | AAF1/8 | 1/8" PLASTIC CLAMP |
| 6 | 1 | NNE6-32 | NUT,ELASTIC LOCK,6-32 |
| 7 | 9 | SSFC80024 | #6-32 X 3/8 FLAT ALLEN |




# 1315620 Guide Roller Assembly

AAC Drawing Number 1315620 Rev2

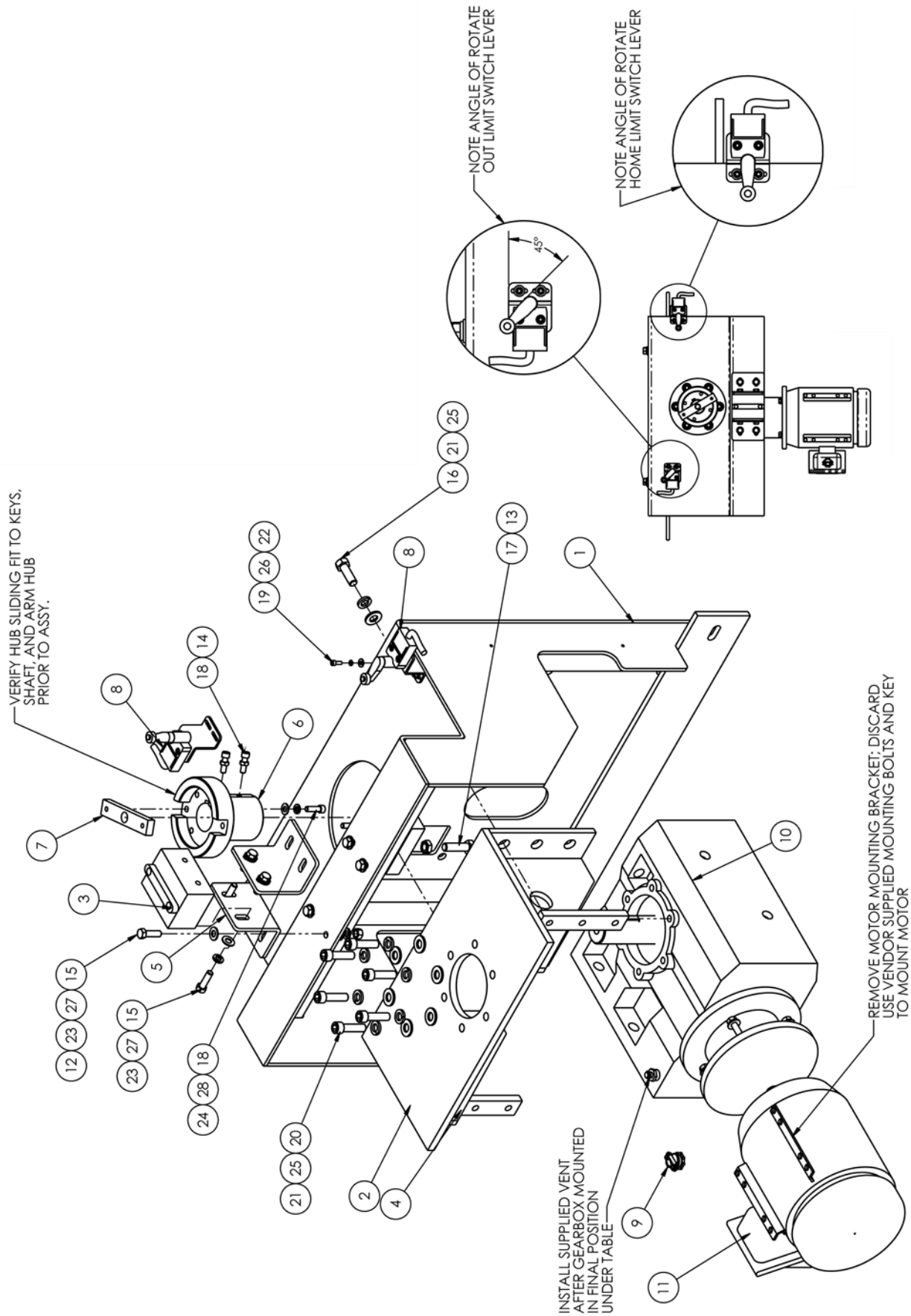
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315418 | PLATE, EDGE GUIDE |
| 2 | 2 | 1315422 | MOUNT, EDGE PLATE |
| 3 | 1 | 1315423 | TOP, EDGE GUIDE SS |
| 4 | 3 | 1315438 | MOUNT, AXLE EDGE GUIDE |
| 5 | 3 | 1315619 | POST, ROLLER GUIDE |
| 6 | 1 | 1315621 | ROLL, ASSY 2"OD 24.25" LG |
| 7 | 1 | 1315623 | ROLL, ASSY 2"OD 14.25"LG |
| 8 | 1 | 1315625 | AXLE, GUIDE ROLLERS |
| 9 | 2 | CCCL12SS | CLAMP COLLAR- 3/4 |
| 10 | 4 | NNE10-32 | NUT,ELASTIC LOCK |
| 11 | 6 | NNE6-32 | NUT,ELASTIC LOCK,6-32 |
| 12 | 6 | SSFC80040 | #6-32 X 5/8 FLAT ALLEN |
| 13 | 4 | SSFC98040S | #10-32 X 5/8 S/S FLAT ALLEN |
| 14 | 3 | SSHC10064 | 5/16-18 X 1" HEX HEAD |
| 15 | 4 | WWFS10 | WASHER, FLAT #10 |
| 16 | 3 | WWFS5/16 | WASHER, FLAT, 5/16 |
| 17 | 6 | WWFS6 | WASHER, FLAT, #6 |
| 18 | 3 | WWL5/16 | 5/16 LW |



# 1315100 Sew Head Assembly

AAC Drawing Number 1315100 Rev6

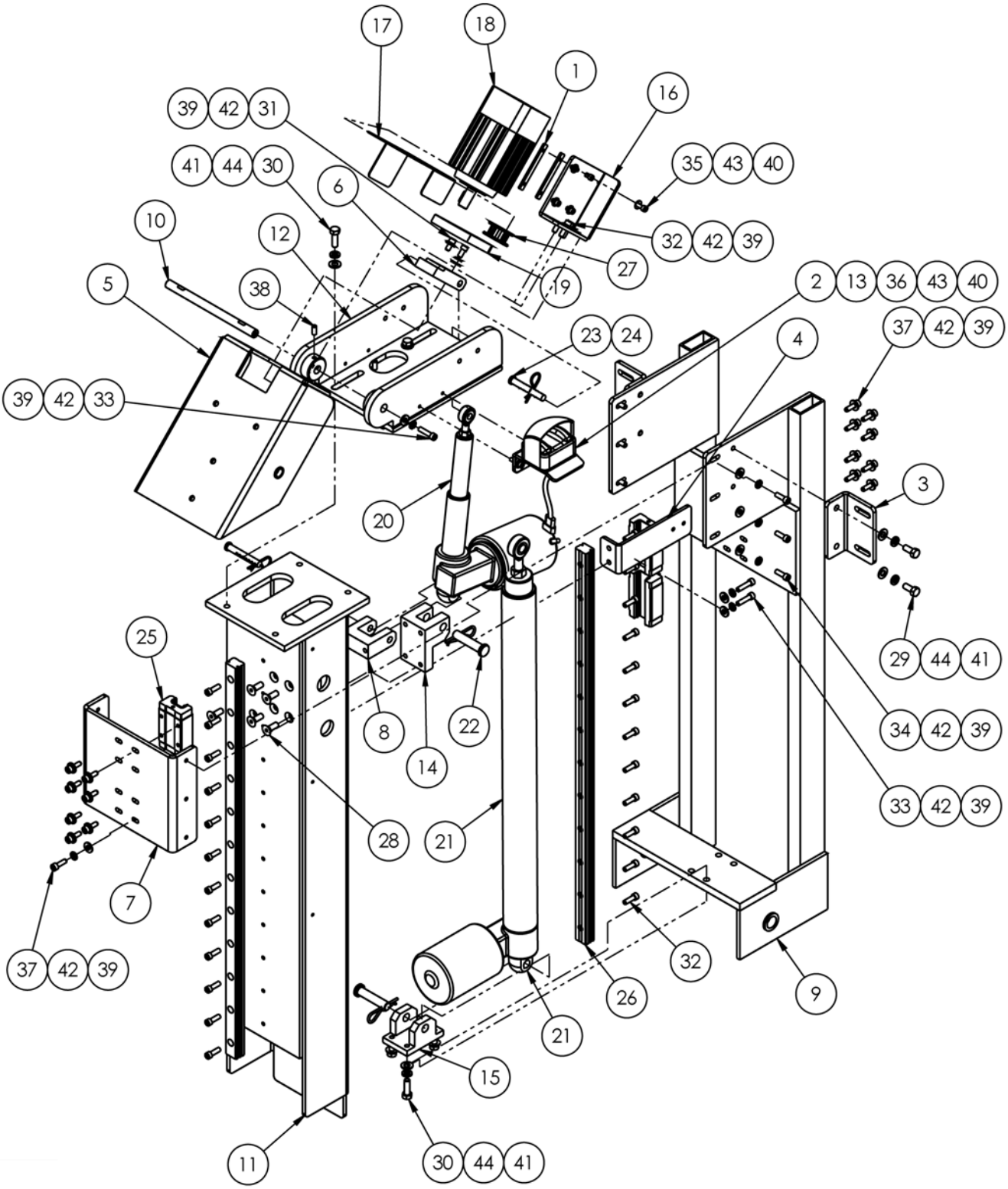
| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 1 | 1315246 | BRKT, EYE | 27 | 1 | FFSM312LVQ | EYE,ELECTRIC,10-30VDC |
| 2 | 1 | 1315507 | BRACKET, CYLINDER | 28 | 1 | MM1590A13 | LATCH, DRAW PULL |
| 3 | 1 | 1315574 | GUIDE, THREAD | 29 | 1 | MMCYR114S | FOLLOWER, CAM |
| 4 | 1 | 1315585 | BRKT, MOUNT, THREAD GUIDE | 30 | 1 | NNHM5X0.8 | NUT,HEX,M5-0.8 |
| 5 | 1 | 1317307 | CYLINDER END, FOOT LIFT | 31 | 1 | NNJ7/16-20 | NUT,JAM,7/16-20 |
| 6 | 1 | 1338115 | BRKT, TENSION FOLDER | 32 | 1 | PP20LB050M2 | PULLEY,GEAR,3/8P,.63B,20T |
| 7 | 1 | 1345-002 | PLATE. BED, LEFT MOD | 33 | 1 | SSBC98016 | 10-32 X 1/4 BUTTON CAP SC |
| 8 | 1 | 1345-002A | PLATE, BED, RIGHT,MOD | 34 | 3 | SSSC70040 | 4-40 X 5/8, SCREW,SOCKET CAP |
| 9 | 1 | 1345-003 | MOD. THROAT PLATE STD. | 35 | 2 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 10 | 1 | 1345-004 | BLOCK, STOP FOR BINDER | 36 | 1 | SSIN-300UX6 | SEWING HEAD, 300UX6 |
| 11 | 1 | 1345-005 | SEWING HEAD,MOD | 37 | 1 | SSSC98040 | 10-32 X 5/8 SOC CAP |
| 12 | 1 | 1345-011 | PLATE, END COVER | 38 | 8 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 13 | 1 | 1345-012 | THREAD ACCESS DOOR ASSY | 39 | 1 | SSHC25080 | 3/8-16 X 1-1/4 HEX CAP |
| 14 | 1 | 1345-014 | LATCH, SNAP HOOK | 40 | 2 | SSSC98032 | 10-32X1/2, SOC CAP |
| 15 | 1 | 13453066 | MOUNT,BELT TENSION | 41 | 1 | SSFC90024 | 8-32 X 3/8 FL ALN CAP |
| 16 | 1 | 13453646 | TAPE MOUNT, PULLEY | 42 | 2 | SSTS80016 | #6-32 X 1/4 TRUSS HD |
| 17 | 1 | 160505B | COVER,END, MOD. | 43 | 2 | SSTS85016 | #6-40 X 1/4 TRUSS HEAD |
| 18 | 1 | 160506B | BACK COVER, UX5 MOD. | 44 | 1 | TA2351004-R0 | RUBBER PLUG |
| 19 | 1 | 1975-412A | PLATE,NUT,4-40,.95CTC | 45 | 2 | WWF4 | WASHER, FLAT, #4 |
| 20 | 1 | 221-TCBINDER | BINDER BLOCK, SPEC. BY CUST. | 46 | 12 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 21 | 1 | 268071 | BEARING,NEEDLE LFT RCK SHIFT 300U | 47 | 5 | WWFS10 | WASHER, FLAT, #10, SAE |
| 22 | 1 | 311-129 | SLEEVE, TAPE MOUNT ADJUST | 48 | 1 | WWFS3/8 | WASHER,FLAT,SAE,3/8 |
| 23 | 2 | AA198RA508 | FLOW CONTROL,5/32 X 1/8" | 49 | 12 | WWL1/4 | WASHER,LOCK,1/4 |
| 24 | 1 | AAC5DP-2 | AIR CYLINDER, SMC | 50 | 3 | WWL10 | WASHER,LOCK,#10,S/S |
| 25 | 1 | CCSCL7F | CLAMP COLLAR- 7/16 | 51 | 2 | SSSC70048 | 4-40 X 3/4 SOCKET CAP |
| 26 | 1 | F221-T008 | TENSIONER BOX ASSY,2" MAX | | | | |



# 1315115 Arm Gearbox Assembly

AAC Drawing Number 1315115 Rev4

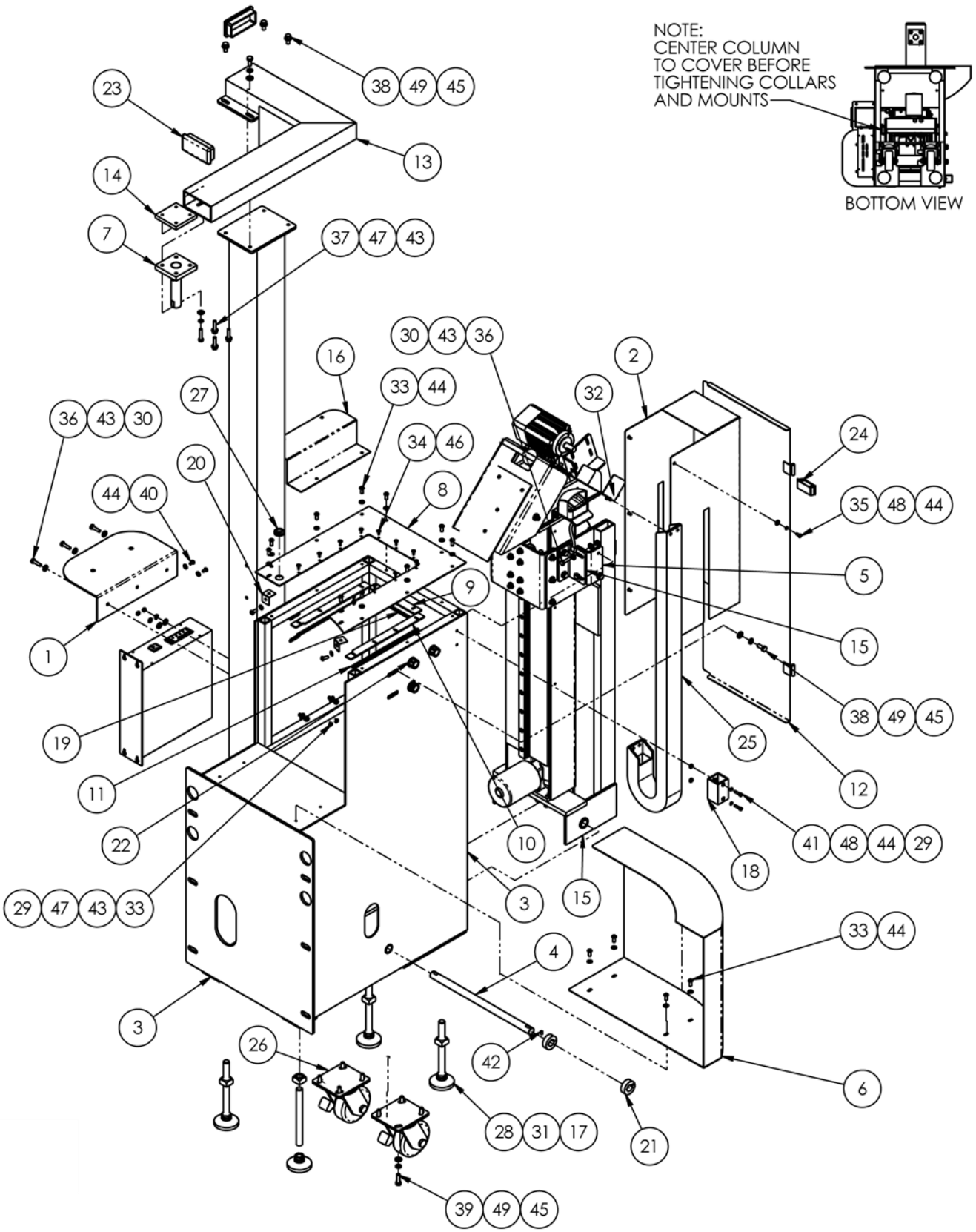
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315105 | MOUNT, ARM MOTOR WELD |
| 2 | 1 | 1315110 | MOUNT, ARM MOTOR |
| 3 | 1 | 1315111 | MOUNT, SLIDE MOTOR |
| 4 | 2 | 1315112 | PLATE, NUT 1/2-13 2.5 CTC |
| 5 | 2 | 1315113 | BRACKET, MOTOR MOUNT |
| 6 | 1 | 1315283 | HUB, ARM MOTOR |
| 7 | 1 | 1315372 | KEY, ROTATE ARM |
| 8 | 2 | 1315435 | LIMIT SWITCH ASSEMBLY |
| 9 | 1 | K-235A | CONNECTOR,ROMEX,3/4" |
| 10 | 1 | MMWMR4072 | REDUCER,GEAR,192:1,LH |
| 11 | 1 | MMY368 | MOTOR, INVERT DUTY 2 HP |
| 12 | 4 | NNH3/8-16 | NUT,HEX,3/8-16 |
| 13 | 2 | NNJ1/2-20 | 1/2-20 JAM NUT |
| 14 | 2 | NNJ5/16-24 | NUT,JAM,5/16-24 |
| 15 | 12 | SSHC25080 | 3/8-16 X 1-1/4 HEX CAP |
| 16 | 4 | SSHC45096 | 1/2-13X1-1/2 HEX CAP |
| 17 | 2 | SSHC46112F | 1/2-20X1-3/4 FULL THD HC |
| 18 | 4 | SSSC20064 | 5/16-24X1, SOC SAP |
| 19 | 4 | SSSC98032 | 10-32X1/2, SOC CAP |
| 20 | 6 | SSSCM12X45 | SCREW, SOCKET CAP |
| 21 | 10 | WWFS1/2 | WASHER,FLAT,SAE,1/2 |
| 22 | 4 | WWFS10 | WASHER, FLAT, #10, SAE |
| 23 | 16 | WWFS3/8 | WASHER,FLAT,SAE,3/8 |
| 24 | 2 | WWFS5/16 | WASHER,FLAT,SAE,5/16 |
| 25 | 10 | WWL1/2 | 1/2 LOCK WASHER |
| 26 | 4 | WWL10 | WASHER,LOCK,#10,S/S |
| 27 | 12 | WWL3/8 | WASHER, LOCK, 3/8 |
| 28 | 2 | WWL5/16 | WASHER, LOCK, 5/16 |



# 1315200 Column Assembly

AAC Drawing Number 1315200 Rev6

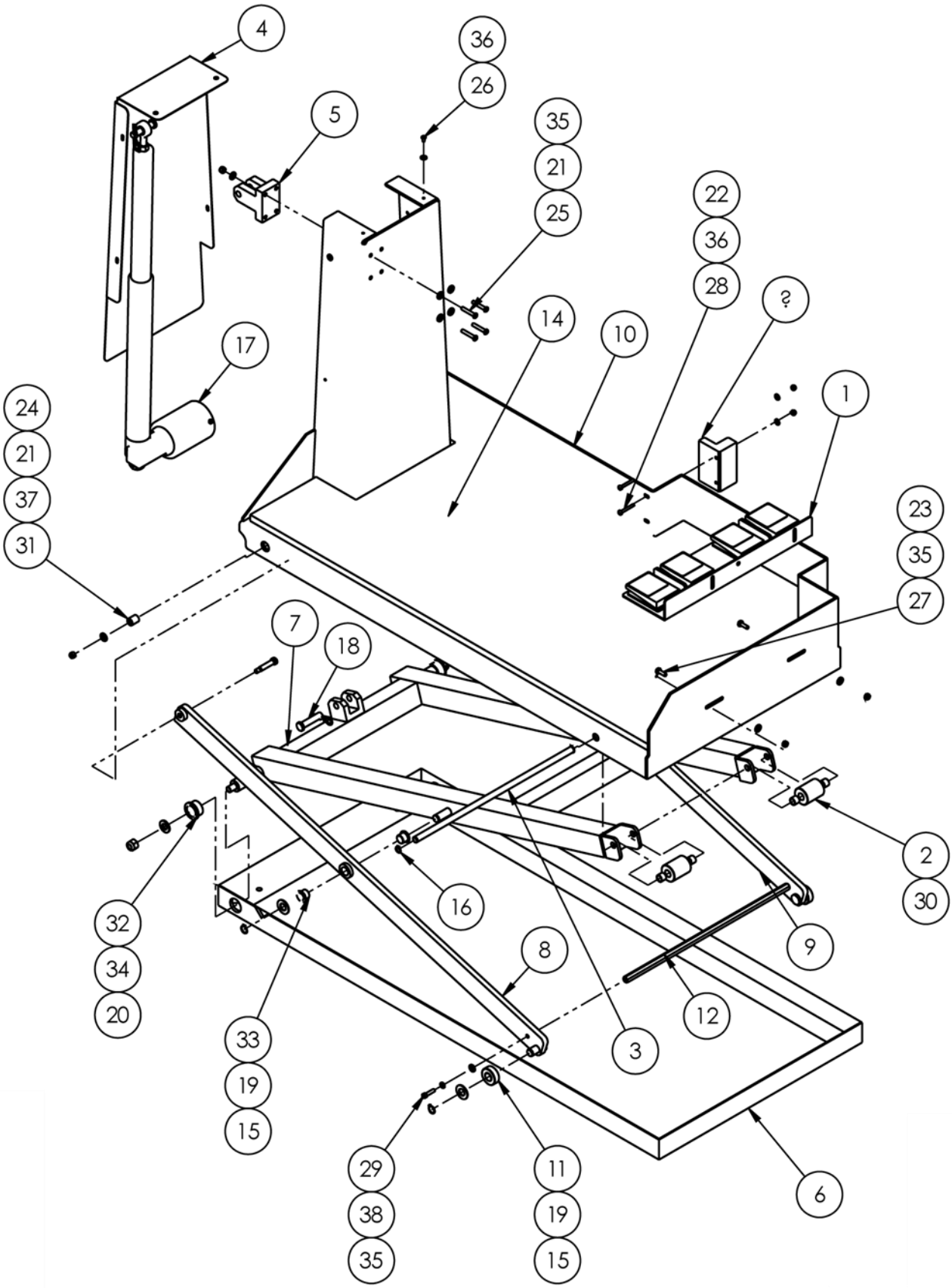
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 2 | 0211-209 | PLATE,NUT,10-32@2.25 CTC |
| 2 | 1 | 1278-6602A | TOUCH SWITCH ASSY W/3 PIN |
| 3 | 2 | 1315129 | MOUNT, COLUMN |
| 4 | 1 | 1315132 | MOUNT, CABLETRAK COLUMN |
| 5 | 1 | 1315276 | PLATE, SEWING HEAD MOUNT |
| 6 | 1 | 1315277 | MOUNT, ROD END |
| 7 | 1 | 1315279 | MOUNT, COLUMN FRONT |
| 8 | 1 | 1315282 | PIVOT, SUPPORT, ACTUATOR |
| 9 | 1 | 1315297 | ASSY, COLUMN BASE |
| 10 | 1 | 1315313 | SHAFT, SEW PIVOT |
| 11 | 1 | 1315530 | COLUMN, SEWING HEAD |
| 12 | 1 | 1315536 | WELDMENT, SEW HEAD PIVOT |
| 13 | 1 | 1315652 | BRACKET, TOUCH SWITCH |
| 14 | 1 | 1349012 | BLOCK, PIVOT UPPER |
| 15 | 1 | 1349013 | MOUNT, LIFT LOWER |
| 16 | 1 | 13453608 | BRKT, MOTOR MOUNT |
| 17 | 1 | 13453612 | BELT, GUARD |
| 18 | 1 | 4059-DC1500ABA2 | MOTOR & CONTROLLER |
| 19 | 1 | GG124L050 | BELT, 3/8P,, 1/2W |
| 20 | 1 | MM85151-2M2 | ACTUATOR, MOD |
| 21 | 1 | MM85199-20M1 | ACTUATOR, ELEC. LINEAR |
| 22 | 2 | MM97245A718 | CLEVIS PIN WITH SPG PIN |
| 23 | 2 | MM98330A245 | CLEVIS PIN 2.25LG STL |
| 24 | 2 | MM98335A064 | SPRING CLIP |
| 25 | 4 | MMAGH25CAN | LINEAR BEARING |
| 26 | 2 | MMAGR25710N | RAIL, LINEAR, AG SERIES |
| 27 | 1 | PP10LF050M3 | PULLEY,GEAR,3/8P,10T,14MM |
| 28 | 6 | SSFC10056 | 5/16-18X7/8 FLAT HD CAP |
| 29 | 4 | SSHC10048 | 5/16-18 X 3/4 HHCS |
| 30 | 8 | SSHC10064 | 5/16-18 X 1 HHCS |
| 31 | 2 | SSSC01032 | 1/4-20X1/2 SOC CAP |
| 32 | 27 | SSSC01048 | 1/4-20 X 3/4" SOC CAP SC |
| 33 | 4 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 34 | 6 | SSSC05048 | 1/4-28 X 3/4, SOC CAP |
| 35 | 4 | SSSC98032 | 10-32X1/2, SOC CAP |
| 36 | 2 | SSSC98048 | 10-32 X 3/4 SOC CAP |
| 37 | 16 | SSSCM6X20 | SCREW, SOCKET CAP |
| 38 | 4 | SSSS01040 | SCREW, SET, 1/4-20 X 5/8 |
| 39 | 31 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 40 | 6 | WWFS10 | WASHER, FLAT, #10, SAE |
| 41 | 12 | WWFS5/16 | WASHER,FLAT,SAE,5/16 |
| 42 | 31 | WWL1/4 | WASHER,LOCK,1/4 |
| 43 | 6 | WWL10 | WASHER,LOCK,#10,S/S |
| 44 | 12 | WWL5/16 | WASHER, LOCK, 5/16 |



# 1315300 Console Assembly

AAC Drawing Number 1315300 Rev3

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315123 | MOUNT, EFKA |
| 2 | 1 | 1315124 | COVER, COLUMN |
| 3 | 1 | 1315125 | CONSOLE BASE, WELDMENT |
| 4 | 1 | 1315128 | AXLE, COLUMN |
| 5 | 2 | 1315130 | MOUNT, CONSOLE |
| 6 | 1 | 1315138 | COVER, WELDMENT |
| 7 | 1 | 1315144 | AXEL, PIVOT |
| 8 | 1 | 1315146 | COVER, CONSOLE |
| 9 | 1 | 1315148 | WIPER, COLUMN SHORT |
| 10 | 2 | 1315149 | WIPER, COLUMN LONG |
| 11 | 2 | 1315150 | PLATE, NUT 6-32 |
| 12 | 1 | 1315151 | DOOR, BACK |
| 13 | 1 | 1315161 | PIVOT WELDMENT, TOP |
| 14 | 1 | 1315162 | PLATE, NUT TOP PIVOT |
| 15 | 1 | 1315200 | ASSY, COLUMN |
| 16 | 1 | 1315340 | BRKT, THREAD GUIDE |
| 17 | 4 | 1315661 | ROD, THREADED, 5/8-11X7LG |
| 18 | 1 | 13453385 | HOLDER, SCISSOR |
| 19 | 1 | 13453652 | PLATE,NUT,6-32,3PL@2.5 OC |
| 20 | 2 | 98-6819A | CORNER BKT |
| 21 | 2 | CCCL12F | CLAMP COLLAR- 3/4 |
| 22 | 3 | FF274-416 | KNOB,SPEED CONTROL |
| 23 | 2 | MM132-2X4 | END CAP,RECT,BLACK |
| 24 | 1 | MM40450010 | FASTENER,SLIDE LOCK |
| 25 | 1 | MM45021-26 | DUCT,WIRE PLASTITRAK |
| 26 | 2 | MM644001PHNTLB | CASTER, 4" SWIVEL W/BRAKE |
| 27 | 1 | MM9600K21 | GROMMET,RUBBER,9/16 ID |
| 28 | 4 | MML-2 | LEVELING PAD, 5/8-11 |
| 29 | 4 | NNH10-32 | #10-32 HEX NUT |
| 30 | 10 | NNK1/4-20 | KEP NUT, 1/4-20 |
| 31 | 4 | NNSH5/8-11 | NUT, SQUARE, 5/8-11 |
| 32 | 2 | SSBC01032 | 1/4-20 X 1/2 BUT HEAD |
| 33 | 18 | SSBC01040 | 1/4-20 X 5/8 BUT HEAD |
| 34 | 11 | SSBC80032 | #6-32 X 1/2 BUT HEAD |
| 35 | 6 | SSBC98032 | #10-32 X 1/2 BUT HEAD |
| 36 | 7 | SSHC01064 | 1/4-20 X 1 HEX HEAD |
| 37 | 4 | SSHC01080 | 1/4-20 X 1-1/4 HEX HEAD |
| 38 | 8 | SSHC10048 | 5/16-18 X 3/4 HEX HEAD |
| 39 | 8 | SSHC10064 | 5/16-18 X 1" HEX HEAD |
| 40 | 4 | SSPP98024 | #10-32 X 3/8 PAN HD PHIL |
| 41 | 2 | SSSC98048 | #10-32 X 3/4 SOC CAP |
| 42 | 4 | SSSS01024 | 1/4-20 X 3/8 KNURL PT |
| 43 | 23 | WWFS1/4 | WASHER FLAT, 1/4 |
| 44 | 28 | WWFS10 | WASHER, FLAT #10 |
| 45 | 16 | WWFS5/16 | WASHER, FLAT, 5/16 |
| 46 | 11 | WWFS6 | WASHER, FLAT, #6 |
| 47 | 6 | WWL1/4 | 1/4 LW |
| 48 | 8 | WWL10 | #10 LW |
| 49 | 16 | WWL5/16 | 5/16 LW |



# 1315327 Lift Platform Assembly

AAC Drawing Number 1315327 Rev2

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315060 | ASSY,FOOTPEDAL |
| 2 | 2 | 1315339 | ROLLER, TOP |
| 3 | 1 | 1315341 | AXLE, TOP ROLLERS |
| 4 | 1 | 1315354 | COVER, TOWER |
| 5 | 1 | 1315355 | BLOCK, PIVOT TOWER |
| 6 | 1 | 1315380 | ASSY, BASE PLATFORM |
| 7 | 1 | 1315385 | RISER, WELDMENT |
| 8 | 1 | 1315386 | ASSY, RISER, .5 FRONT |
| 9 | 1 | 1315387 | RISER, .5 REAR WELDMENT |
| 10 | 1 | 1315388 | PLATFORM WELDMENT |
| 11 | 2 | 1315389 | ASSY, ROLLER SMALL |
| 12 | 1 | 1315391 | SPACER, ROLLER |
| 13 | 1 | 1315593 | BLOCK, POSITIONING LIFT |
| 14 | 1 | 1315617 | MAT, PLATFORM, CUT |
| 15 | 4 | 1315631 | SPACER, PLATFORM LIFT |
| 16 | 2 | MM8410A122 | RING,RETAINING,EXT,1/2" |
| 17 | 1 | MM85199-12 | ACTUATOR, ELEC. LINEAR 12 |
| 18 | 2 | MM97245A718 | CLEVIS PIN WITH SPG PIN |
| 19 | 4 | MMSH62STPA | RING,SNAP,EXTERNAL |
| 20 | 2 | NNE1/2-13 | NUT, ELASTIC 1/2-13 |
| 21 | 6 | NNE1/4-20 | NUT,ELASTIC LOCK,1/4-20 |
| 22 | 2 | NNE10-32 | NUT,ELASTIC LOCK |
| 23 | 2 | NNK1/4-20 | KEP NUT, 1/4-20 |
| 24 | 2 | SSAS024096 | 3/8 X 1-1/2 X 5/16-18 SHLD, BOLT |
| 25 | 4 | SSBC01096 | 1/4-20 X 1-1/2 BUT HEAD |
| 26 | 6 | SSBC98024 | #10-32 X 3/8 BUT HEAD |
| 27 | 2 | SSHC01048 | 1/4-20 X 3/4 HEX HEAD |
| 28 | 2 | SSPS98096 | #10-32 x 1-1/2 LG PHS |
| 29 | 2 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 30 | 4 | UUAA628-10 | BEARING,BRONZE,.5015ID |
| 31 | 2 | UUAA630-12 | BEARING,BRONZE,.5015ID |
| 32 | 2 | UUFF102-6 | BEARING,FLG,1.003X1.254 |
| 33 | 4 | UUFF703-03 | BEARING,BRONZE,.6265 ID |
| 34 | 2 | WWFS1/2 | 1/2 FLAT WASHER |
| 35 | 14 | WWFS1/4 | WASHER FLAT, 1/4 |
| 36 | 8 | WWFS10 | WASHER, FLAT #10 |
| 37 | 2 | WWFS5/16 | WASHER, FLAT, 5/16 |
| 38 | 2 | WWL1/4 | 1/4 LW |

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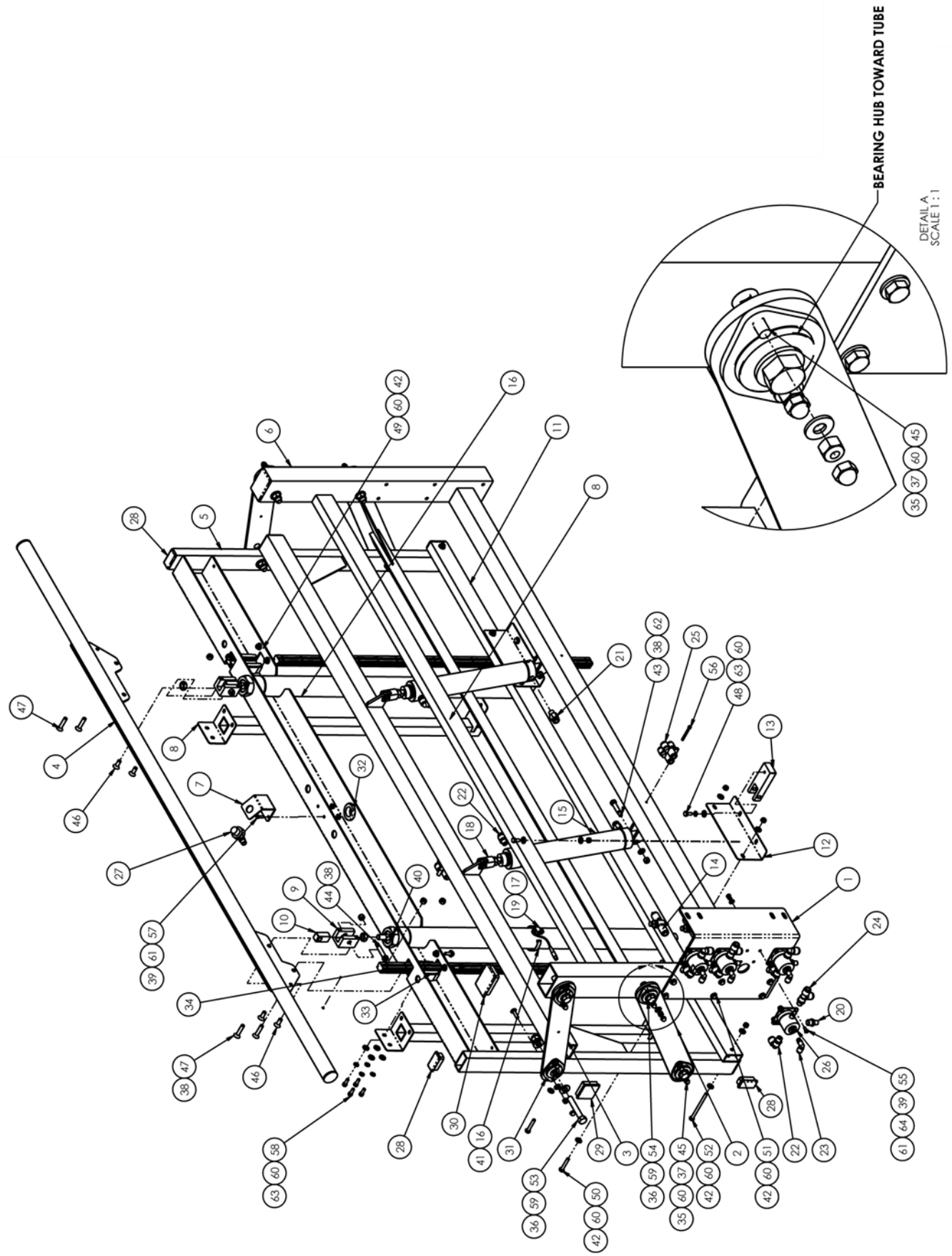
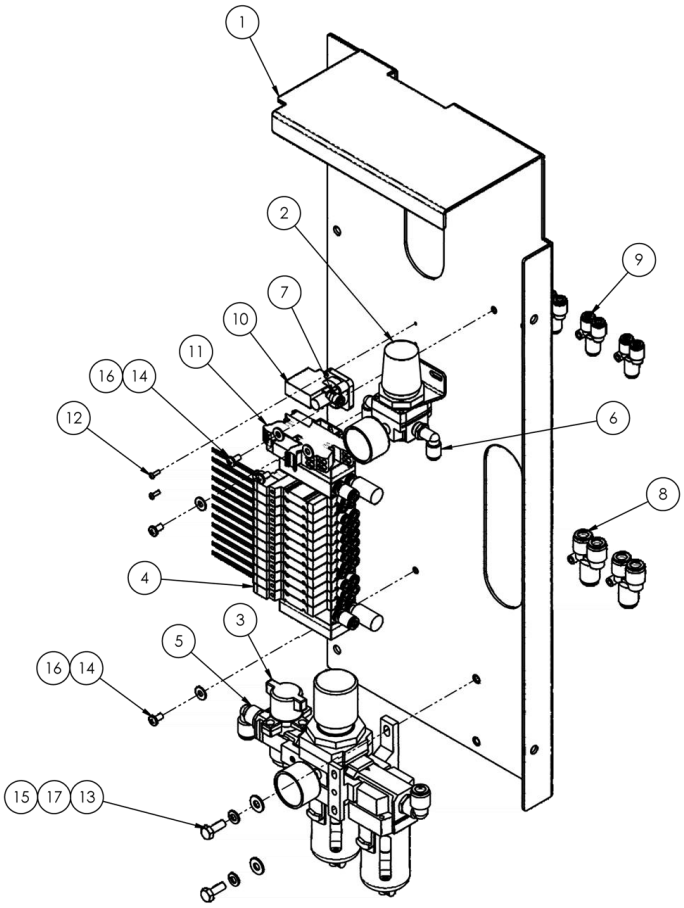


# 1315400 Flipper Assembly

AAC Drawing Number 1315400 Rev6

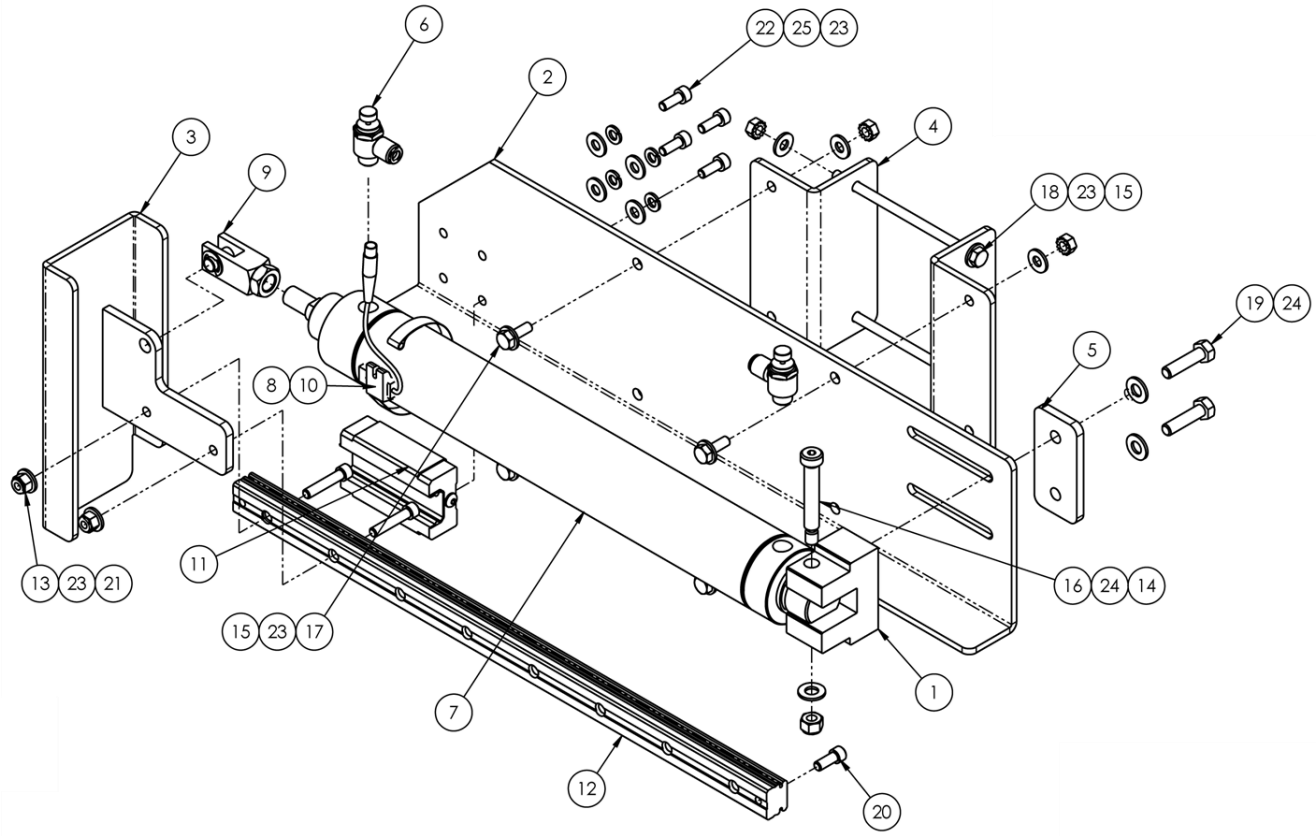
| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 1 | 1315318 | MOUNT, FLIP | 33 | 2 | MMAGH25CAN | LINEAR BEARING |
| 2 | 1 | 1315397 | LINK, FLIP LOWER | 34 | 2 | MMAGR25992M | RAIL,LINEAR AG SERIES |
| 3 | 2 | 1315401 | LINK, FLIP UPPER | 35 | 16 | NNC1_4-20 | NUT, CAP, 1/4-20 |
| 4 | 1 | 1315408 | ASSY, TUBE FLIP | 36 | 8 | NNE1/2-13 | NUT, ELASTIC 1/2-13 |
| 5 | 1 | 1315409 | ASSY, FLIP | 37 | 16 | NNE1/4-20 | NUT,ELASTIC LOCK,1/4-20 |
| 6 | 1 | 1315410 | MOUNT, FLIP TO TABLE | 38 | 10 | NNE5/16-18 | NUT,ELASTIC LOCK,5/16-18 |
| 7 | 1 | 1315434 | BRACKET, SENSOR FLIP EDGE | 39 | 18 | NNH10-32 | #10-32 HEX NUT |
| 8 | 2 | 1315452 | ASSY, RAIL COVER | 40 | 2 | NNJ1-1/4-12 | 1-1/4-12 HEX JAM NUT |
| 9 | 2 | 1315633 | BLOCK, FOR CYL | 41 | 2 | NNJ1/2-20 | 1/2-20 HEX JAM NUT |
| 10 | 2 | 1315634 | COUPLING, CYL FLIPPER | 42 | 18 | NNK1/4-20 | KEP NUT, 1/4-20 |
| 11 | 1 | 1315653 | TUBE, CYL SUPPORT | 43 | 2 | SSAS024080 | 3/8X1-1/4,5/16-18SHLDBOLT |
| 12 | 2 | 1315654 | SUPPORT, RAIL AND CYL | 44 | 4 | SSAS024096 | 3/8 X 1-1/2 X 5/16-18 SHLD, BOLT |
| 13 | 2 | 1315655 | SUPPORT, CYL | 45 | 16 | SSBK01064 | 1/4-20 X 1 BOLT, CARG |
| 14 | 4 | AA3001F-11 | FLOW CONT,INLINE,3/8 LINE | 46 | 4 | SSFC10056 | 5/16-18 X 7/8 FLAT ALLEN |
| 15 | 2 | AACCM3110DXP | CYLINDER,AIR,DA,W/MAGNET | 47 | 4 | SSFC10096 | 5/16-18 X 1-1/2 FLAT ALLEN |
| 16 | 2 | AACCM3130DXP | CYLINDER,AIR,DA W/MAGNET | 48 | 4 | SSHC01040 | 1/4-20 X 5/8 HEX HEAD |
| 17 | 1 | AAEHSKQ | SWITCH,HALL EFFECT BIMBA | 49 | 4 | SSHC01048 | 1/4-20 X 3/4 HEX HEAD |
| 18 | 2 | AAFD2313 | CLEVIS, AIR CYLINDER | 50 | 4 | SSHC01096 | 1/4-20 X 1-1/2 HEX HEAD |
| 19 | 1 | AAFD35875-14 | BAND, CYLINDER,HSKQ HAL | 51 | 6 | SSHC01192 | 1/4-20 X 3 HEX HEAD |
| 20 | 4 | AAFP28 | MUFFLER,1/4 NPT | 52 | 2 | SSHC01224 | 1/4-20 X 3-1/2 HEX HEAD |
| 21 | 4 | AAQMC-3-4 | QUICK MALE CONNECTOR | 53 | 4 | SSHC45192 | 1/2-13 X 3 HEX HEAD |
| 22 | 10 | AAQME-3-4 | MALE ELBOW 3/8OD TUBE | 54 | 4 | SSHC45256 | 1/2-13 X 4 HEX HEAD |
| 23 | 4 | AAQME-4-8 | ELBOW,QUICK MALE,1/4X1/8 | 55 | 16 | SSPP98032 | #10-32 X 1/2 PAN HD PHIL |
| 24 | 2 | AAQMT-3-4 | MALE RUN TEE | 56 | 1 | SSSC90112 | #8-32 X 1-3/4 SOC CAP |
| 25 | 4 | AAQUY-3-3 | QUICK UNION Y 3/8 X 3/8 | 57 | 2 | SSSC98040 | #10-32 X 5/8 SOC CAP |
| 26 | 4 | AAV250A | PILOT VALVE | 58 | 8 | SSSCM6X16 | M6-1.0 X 16 SOC CAP |
| 27 | 1 | FFT18FF100Q | EYE,FIXED FIELD, 4IN | 59 | 16 | WWFS1/2 | WASHER, FLAT, 1/2 |
| 28 | 6 | MM132-1496 | PLUG 1 X 2 | 60 | 62 | WWFS1/4 | WASHER FLAT, 1/4 |
| 29 | 2 | MM132-2X2A | END CAP, SQUARE, BLACK | 61 | 18 | WWFS10 | WASHER, FLAT #10 |
| 30 | 2 | MM132-2X3 | END CAP, RECT,BLACK,2X3 | 62 | 2 | WWFS5/16 | WASHER, FLAT, 5/16 |
| 31 | 8 | MM5913K51 | BEARING, FLANGE, 1/2 BORE | 63 | 10 | WWL1/4 | 1/4 LW |
| 32 | 1 | MM9307K74 | GROMMET,3/4ID,1.38OD,.13GV | 64 | 18 | WWL10 | #10 LW |




# 1315430 Pneumatic Panel

AAC Drawing Number 1315430 Rev2

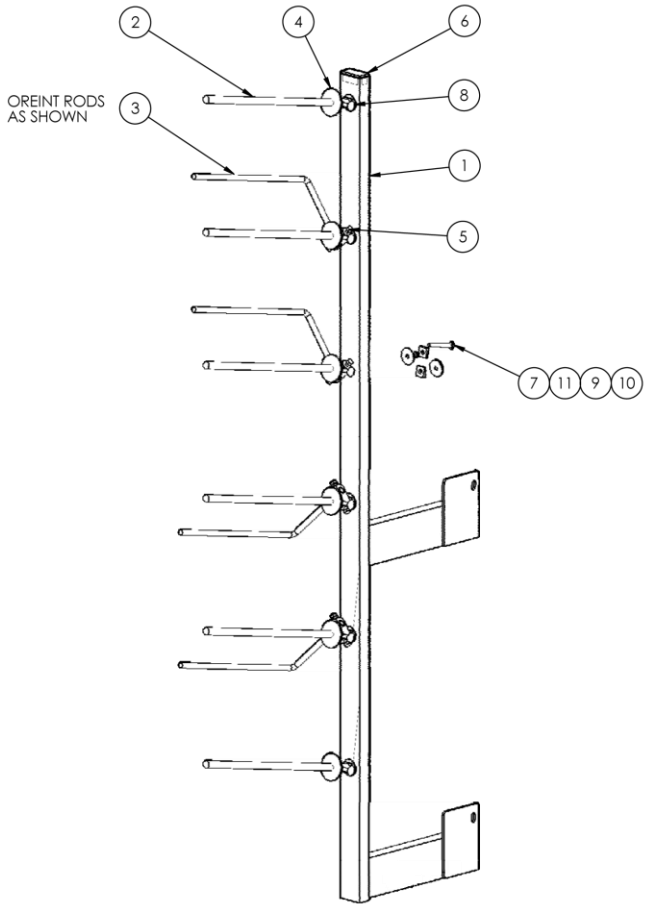
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315566 | PANEL, PNEUMATIC |
| 2 | 1 | AA198-508 | REGULATOR,0-160 W/GAUGE |
| 3 | 1 | AA198-5110 | FILTER/REGULATOR/LOCKOUT |
| 4 | 1 | AAE1315-12 | SOLENOID ASSY,12 STATION |
| 5 | 2 | AAQME-3-4 | MALE ELBOW 3/8OD TUBE |
| 6 | 2 | AAQME-4-4 | ELBOW, MALE,1/4X1/4NPT |
| 7 | 1 | AAQME-5-10 | ELBOW, MALE,5/32X10-32 |
| 8 | 2 | AAQUY-3-3 | QUICK UNION Y 3/8 X 3/8 |
| 9 | 5 | AAQUY-4-4 | Y UNION, 1/4X1/4 |
| 10 | 1 | AAVF51FM1B | AIR/ELEC PRESSURE SW |
| 11 | 1 | EE788304 | RELAY,24V,SPDT,WAGO |
| 12 | 2 | SSBC70024 | #4-40 X 3/8 BUT HEAD |
| 13 | 2 | SSHC01048 | 1/4-20 X 3/4 HEX HEAD |
| 14 | 4 | SSPP98024 | #10-32 X 3/8 PAN HD PHIL |
| 15 | 2 | WWFS1/4 | WASHER FLAT, 1/4 |
| 16 | 4 | WWFS10 | WASHER, FLAT #10 |
| 17 | 2 | WWL1/4 | 1/4 LW |




# 1315595 Head Pusher Assembly

AAC Drawing Number 1315595 Rev1

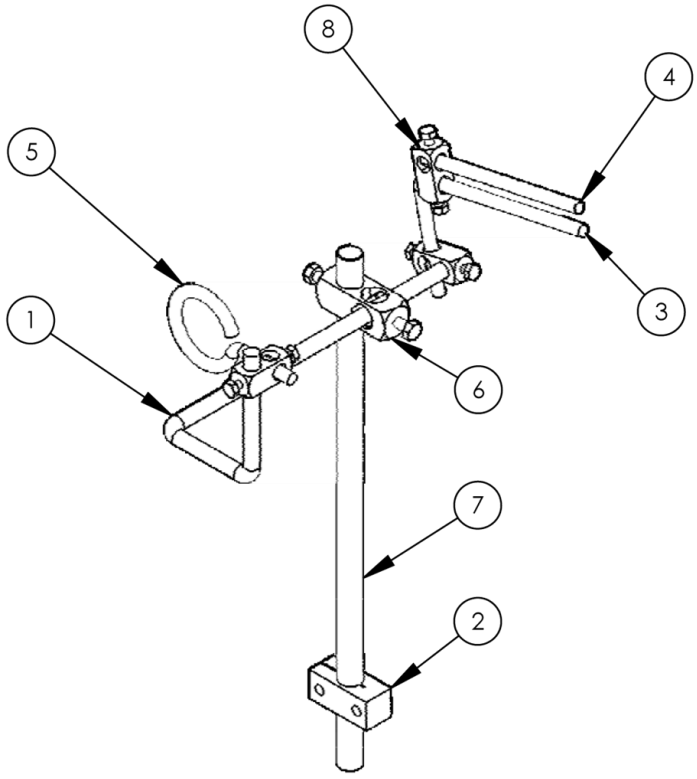
| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 1 | 1315597 | MOUNT, CYLINDER BASE | 14 | 1 | NNE5/16-18 | NUT,ELASTIC LOCK,5/16-18 |
| 2 | 1 | 1315598 | BASE, HEAD PUSHER | 15 | 6 | NNK1/4-20 | KEP NUT, 1/4-20 |
| 3 | 1 | 1315600 | WELDMENT, HEAD PUSHER RAM | 16 | 1 | SSAS024128 | 3/8 X 2 X 5/16-18 SHLD, BOLT |
| 4 | 2 | 1315601 | MOUNT, HEAD PUSHER BASE | 17 | 4 | SSHC01048 | 1/4-20 X 3/4 HEX HEAD |
| 5 | 1 | 1315604 | WASHER PLATE | 18 | 2 | SSHC01320 | 1/4-20 X 5 HEX HEAD |
| 6 | 2 | AA2201-07 | FLOW CONTROL,1/4TX1/4NPT | 19 | 2 | SSHC10080 | 5/16-18 X 1-1/4 HEX HEAD |
| 7 | 1 | AACM3112DXP | CYLINDER,AIR,2" BORE | 20 | 1 | SSSC01040 | 1/4-20 X 5/8 SOC CAP |
| 8 | 1 | AAEHSKQ | SWITCH,HALL EFFECT BIMBA | 21 | 2 | SSSC01080 | 1/4-20 X 1-1/4 SOC CAP |
| 9 | 1 | AAFD2313 | CLEVIS, AIR CYLINDER | 22 | 4 | SSSCM6X16 | M6-1.0 X 16 SOC CAP |
| 10 | 1 | AAFD35875-14 | BAND, CYLINDER,HSKQ HAL | 23 | 18 | WWFS1/4 | WASHER FLAT, 1/4 |
| 11 | 1 | MMAGH25CAN | LINEAR BEARING | 24 | 3 | WWFS5/16 | WASHER, FLAT, 5/16 |
| 12 | 1 | MMAGR25480M1 | RAIL, MOD 480MM | 25 | 4 | WWL1/4 | 1/4 LW |
| 13 | 2 | NNE1/4-20 | NUT,ELASTIC LOCK,1/4-20 | | | | |




# 1315575 Tape Roll Holder

AAC Drawing Number 1315575 Rev0

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315570 | WELDMENT, ROLL HOLDER |
| 2 | 6 | 1335-816 | ROD,SS, 1/2 X 15.0 L |
| 3 | 4 | 1349127 | ROD, SS, "L", 3/8, 6 X 12 |
| 4 | 6 | A-4-032 | HUB,1/2" ID ALUMINUM |
| 5 | 4 | A-U | ROD CROSS BLOCK |
| 6 | 1 | MM132-1496 | PLUG 1 X 2 |
| 7 | 6 | SSHC01144 | 1/4-20 X 2-1/4 HEX HEAD |
| 8 | 6 | SST001048 | SCREW,THUMB,1/4-20X3/4 |
| 9 | 12 | WWFE016 | WASHER,FENDER,LARGE,1/4 |
| 10 | 6 | WWL1/4 | 1/4 LW |
| 11 | 12 | WWSQ044 | WASHER,SQUARE STRUCTURAL |

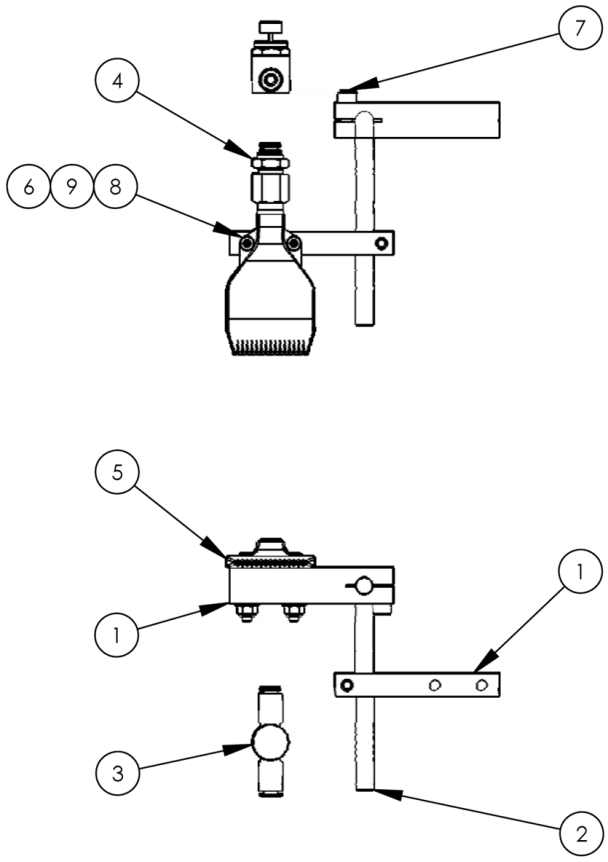





# 1315450 Tape Guide Assembly

AAC Drawing Number 1315450 Rev2

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315174 | ROD, BENT, 1/2 CRS |
| 2 | 1 | 1315475 | CLAMP, 3/4 ROD |
| 3 | 1 | 1335-316 | ROD, SS, "L", 3/8, 4.0 X |
| 4 | 1 | 1335-320 | ROD,S/S,3/8,6.5L |
| 5 | 1 | 1338-028 | RING,TAPE GUIDE |
| 6 | 1 | 28201 | BLOCK,CROSS,(LARGE) |
| 7 | 1 | 28202 | ROD,STRAIGHT,1018 |
| 8 | 3 | A-U | ROD CROSS BLOCK |



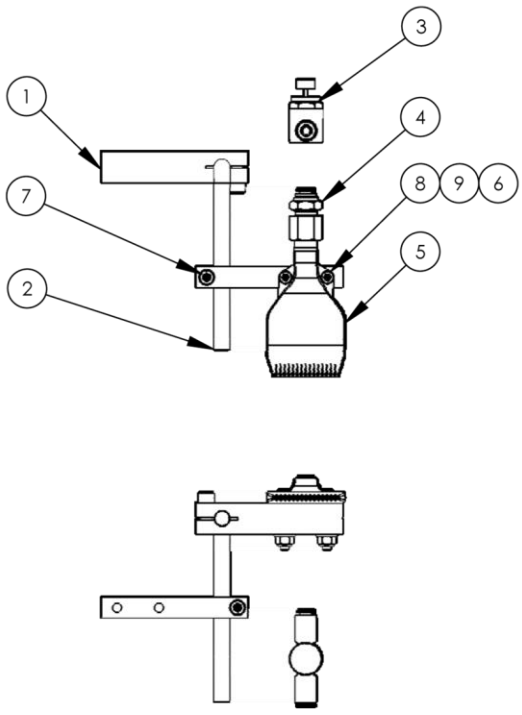

**RIGHT SIDE ASSEMBLY**



# 1315479 Air Jet Assembly; (Right Side)

AAC Drawing Number 1315479 Rev1

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 2 | 1315477 | BLOCK, CLAMP 3/8 ROD |
| 2 | 1 | 1315478 | ROD, 3/8" AIR JET MOUNT |
| 3 | 1 | AA3001F-03 | FLOW CONT,INLINE,1/4 LINE |
| 4 | 1 | AAQBC-4-4 | BULKHEAD CONN,1/4QUIC |
| 5 | 1 | MM5329K21 | AIR NOZZLE |
| 6 | 2 | NNE10-32 | NUT,ELASTIC LOCK |
| 7 | 2 | SSSC01048 | 1/4-20 X 3/4 SOC CAP |
| 8 | 2 | SSSC98080 | #10-32 X 1-1/4 SOC CAP |
| 9 | 2 | WWFS10 | WASHER, FLAT #10 |



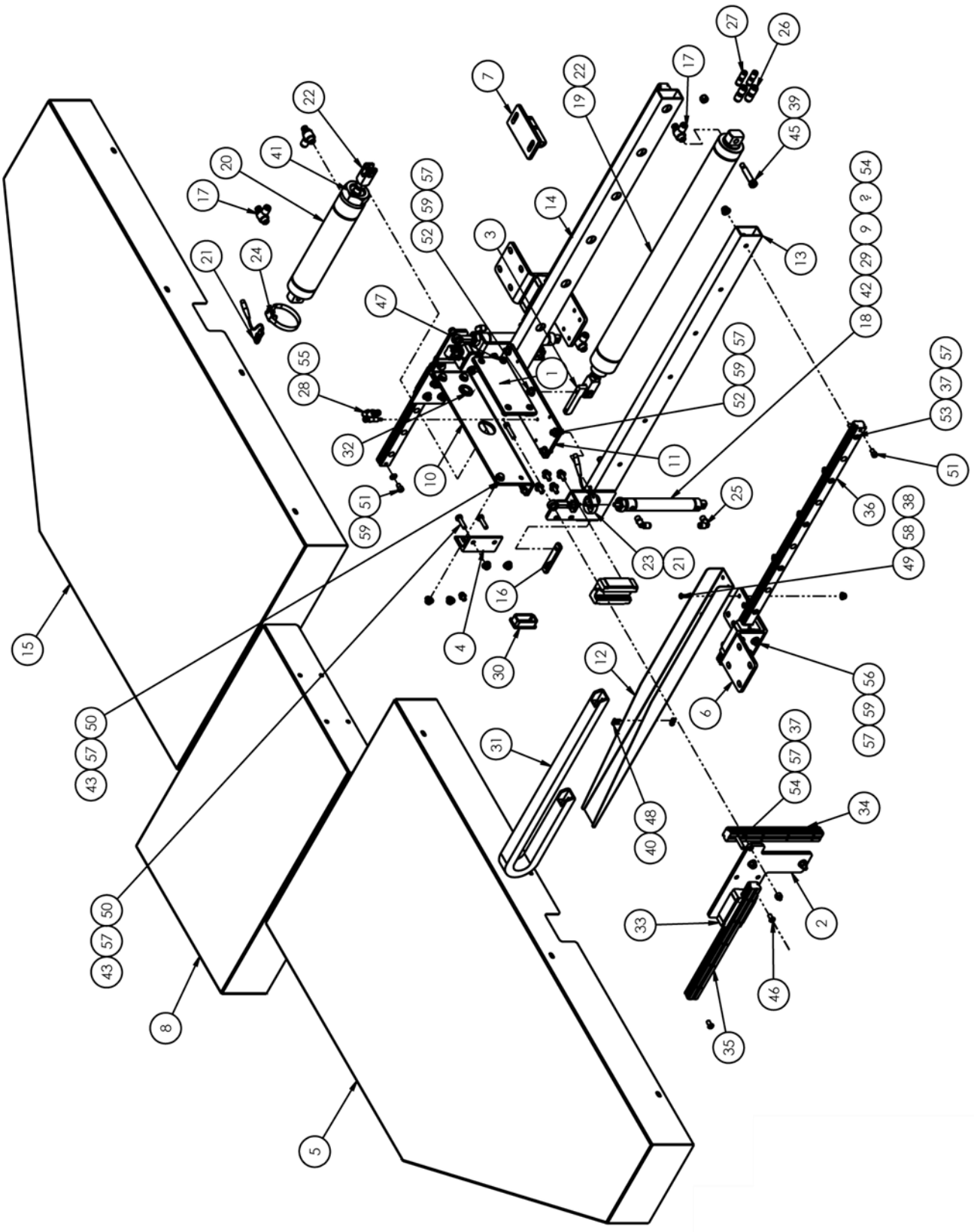

LEFT SIDE ASSEMBLY



# 1315483 Air Jet Assembly; (Left Side)

AAC Drawing Number 1315483 Rev0

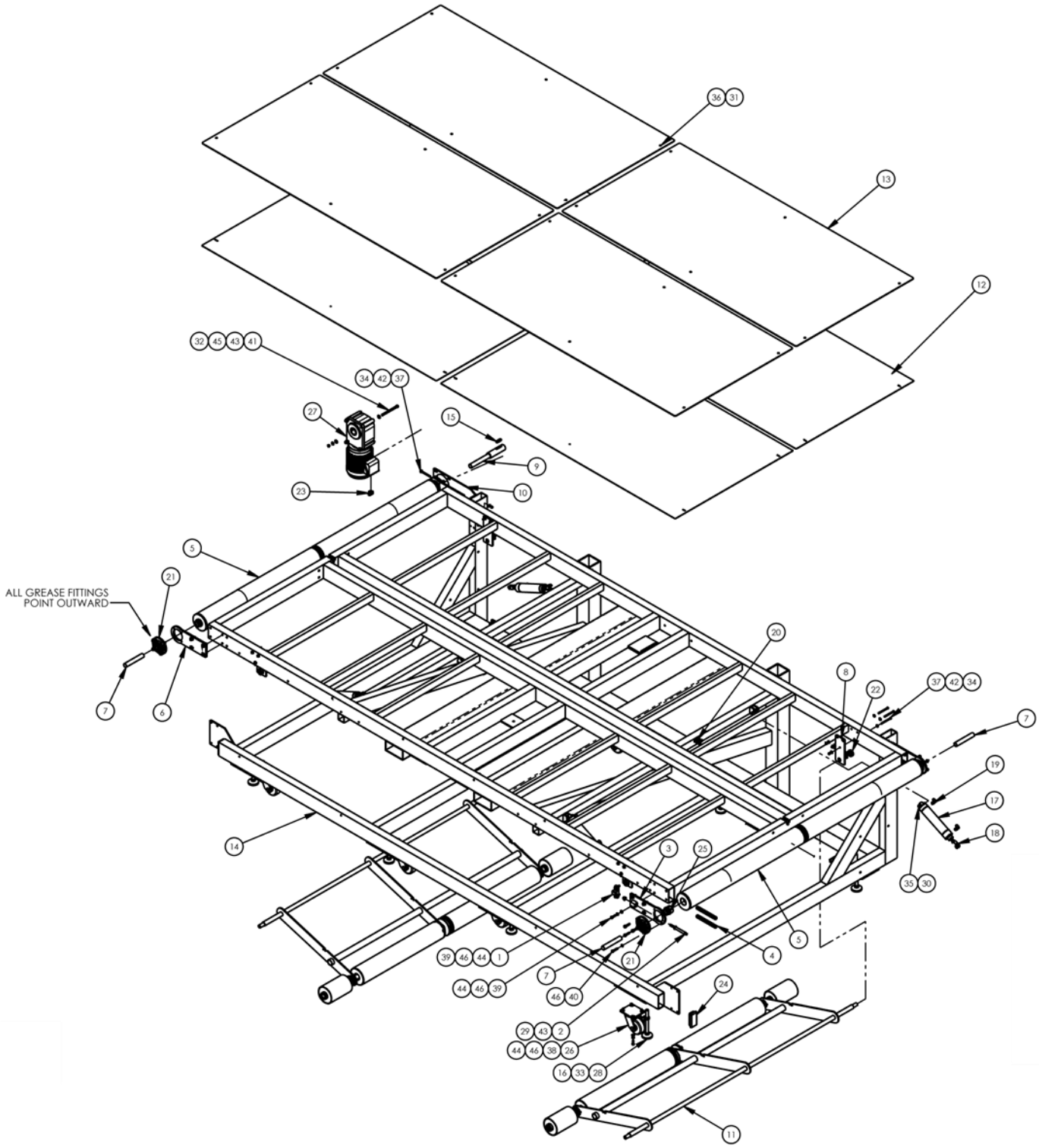
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 2 | 1315477 | BLOCK, CLAMP 3/8 ROD |
| 2 | 1 | 1315478 | ROD, 3/8" AIR JET MOUNT |
| 3 | 1 | AA3001F-03 | FLOW CONT,INLINE,1/4 LINE |
| 4 | 1 | AAQBC-4-4 | BULKHEAD CONN,1/4QUIC |
| 5 | 1 | MM5329K21 | AIR NOZZLE |
| 6 | 2 | NNE10-32 | NUT,ELASTIC LOCK |
| 7 | 2 | SSSC01048 | 1/4-20 X 3/4 SOC CAP |
| 8 | 2 | SSSC98080 | #10-32 X 1-1/4 SOC CAP |
| 9 | 2 | WWFS10 | WASHER, FLAT #10 |



# 1315498 Push Plate Assembly

AAC Drawing Number 1315498 Rev2

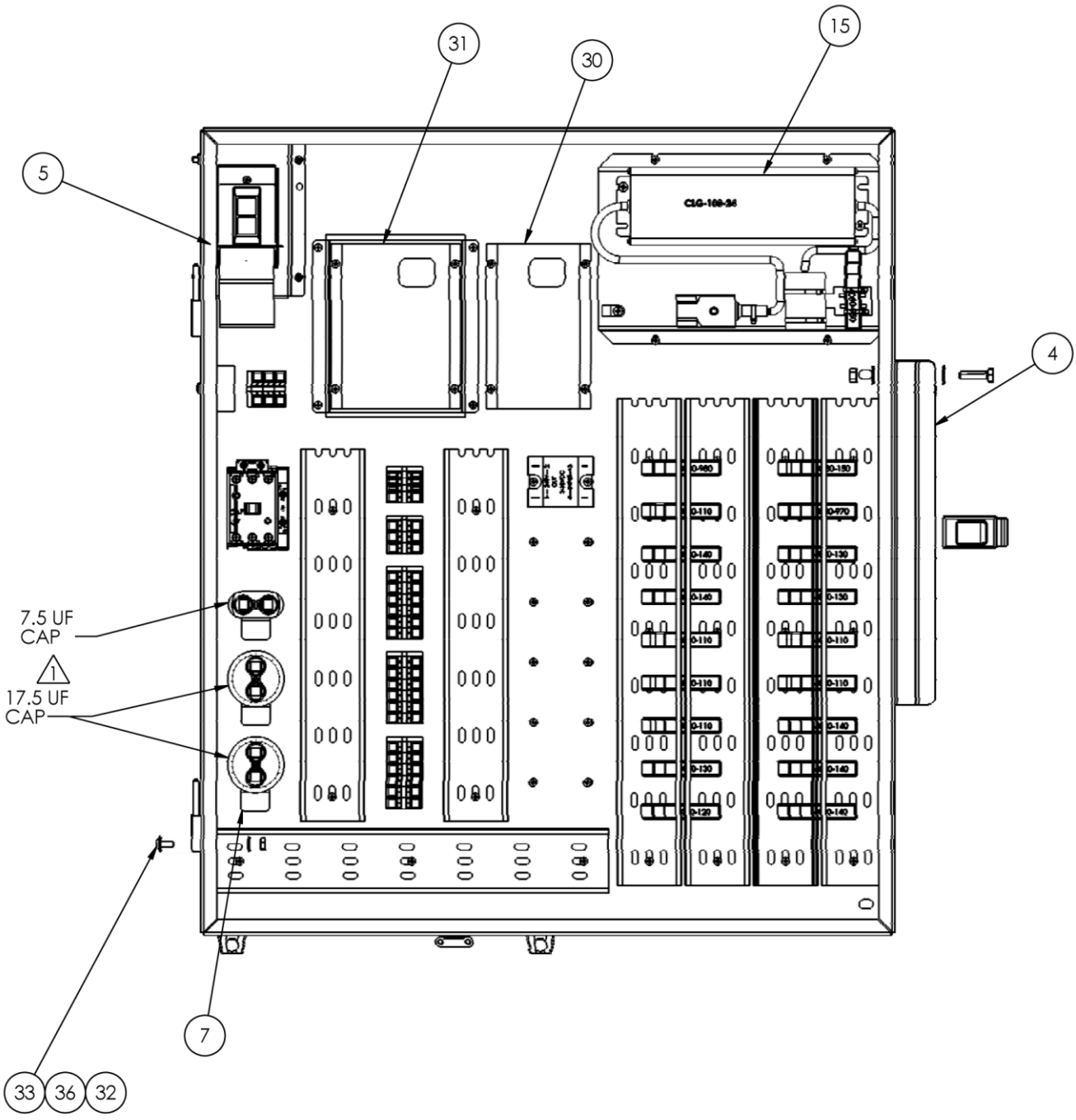
| NO. | QTY | PART # | DESCRIPTION | NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|---|---|---|---|
| 1 | 1 | 1315465 | ASSY, CYL. MOUNT PUSHER | 31 | 1 | MM18222837 | DUCT,WIRE MICROTRAK |
| 2 | 2 | 1315537 | MOUNT, BEARING AND RAIL | 32 | 1 | MM2761 | GROMMET,.50 ID X 3/16 GR |
| 3 | 1 | 1315543 | MOUNT,CYLINDER HORZ | 33 | 6 | MMAGH25CAN | LINEAR BEARING |
| 4 | 2 | 1315549 | BRACKET, L | 34 | 2 | MMAGR25220M | MOD,RAIL 220MM |
| 5 | 1 | 1315550 | TRAY WELDMENT,RIGHT | 35 | 2 | MMAGR25303M | MOD, RAIL BRG 303MM |
| 6 | 2 | 1315553 | MOUNT, PUSHER TO FRAME | 36 | 2 | MMAGR25650M | MOD, RAIL 650MM |
| 7 | 1 | 1315554 | MOUNT, CYL TO FRAME | 37 | 22 | NNE1/4-20 | NUT,ELASTIC LOCK,1/4-20 |
| 8 | 1 | 1315555 | PUSHER TRAY | 38 | 4 | NNE10-32 | NUT,ELASTIC LOCK |
| 9 | 2 | 1315557 | SPACER, ROD END | 39 | 1 | NNE5/16-18 | NUT,ELASTIC LOCK,5/16-18 |
| 10 | 1 | 1315565 | MOUNT, HORZ. CYL | 40 | 2 | NNE6-32 | NUT,ELASTIC LOCK,6-32 |
| 11 | 1 | 1315567 | PLATE, CYL MOUNT | 41 | 1 | NNJ1-1/4-12 | 1-1/4-12 HEX JAM NUT |
| 12 | 1 | 1315576 | TRAY, SUPPORT WIRE DUCT | 42 | 2 | NNJ1/4-28 | 1/4-28 HEX JAM NUT |
| 13 | 1 | 1315578 | ASSY, CYL. MOUNT RIGHT | 43 | 7 | NNK1/4-20 | KEP NUT, 1/4-20 |
| 14 | 1 | 1315580 | ASSY, RAIL MOUNT LEFT | 44 | 1 | NNK8-32 | KEP NUT, 8-32 |
| 15 | 1 | 1315582 | TRAY WELDMENT,LEFT | 45 | 1 | SSAS024096 | 3/8 X 1-1/2 X 5/16-18 SHLD, BOLT |
| 16 | 2 | 96-5606 | PLATE, NUT 2.0 CTC 1/4 | 46 | 4 | SSBC01032 | 1/4-20 X 1/2 BUT HEAD |
| 17 | 4 | AA2201-07 | FLOW CONTROL,1/4TX1/4NPT | 47 | 4 | SSBC01048 | 1/4-20 X 3/4 BUT HEAD |
| 18 | 2 | AACM064DXP | CYLINDER,AIR,DA W/MAGNET | 48 | 4 | SSBC80032 | #6-32 X 1/2 BUT HEAD |
| 19 | 1 | AACM3120DXP | CYLINDER,AIR,DA W/MAGNET | 49 | 4 | SSBC98040 | #10-32 X 5/8 BUT HEAD |
| 20 | 1 | AACM316DXP | CYLINDER,AIR,2" BORE | 50 | 8 | SSHC01064 | 1/4-20 X 1 HEX HEAD |
| 21 | 2 | AAEHSKQ | SWITCH,HALL EFFECT BIMBA | 51 | 12 | SSSC01024 | 1/4-20 X 3/8 SOC CAP |
| 22 | 2 | AAFD2313 | CLEVIS, AIR CYLINDER | 52 | 6 | SSSC01048 | 1/4-20 X 3/4 SOC CAP |
| 23 | 1 | AAFD35456-8 | BAND,09 CYLINDER,HSKQ | 53 | 12 | SSSC01064 | 1/4-20 X 1 SOC CAP |
| 24 | 1 | AAFD35875-14 | BAND, CYLINDER,HSKQ HAL | 54 | 6 | SSSC01080 | 1/4-20 X 1-1/4 SOC CAP |
| 25 | 4 | AAQME-5-8 | QUICK MALE ELBOW | 55 | 1 | SSSC90080 | #8-32 X 1-1/4 SOC CAP |
| 26 | 2 | AAQSU-4-4 | UNION,QUICK STATION,1/4X | 56 | 24 | SSSCM6X16 | M6-1.0 X 16 SOC CAP |
| 27 | 2 | AAQSU-5-5 | UNION,QUICK STATION,5/32 | 57 | 66 | WWFS1/4 | WASHER FLAT, 1/4 |
| 28 | 2 | AAQUY-5-5 | QUICK UNION Y, 5/32 | 58 | 4 | WWFS10 | WASHER, FLAT #10 |
| 29 | 2 | BBAW-4 | BEARING,ROD END,FEMALE | 59 | 34 | WWL1/4 | 1/4 LW |
| 30 | 2 | MM132-1496 | PLUG 1 X 2 | | | | |



# 1315502 Table Assembly

AAC Drawing Number 1315502 Rev4

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 2 | 1315003 | BLOCK, ROLLER TAKE-UP |
| 2 | 2 | 1315004 | BOLT, BELT ADJUSTER |
| 3 | 2 | 1315007 | PLATE, ADJUSTABLE BEARING |
| 4 | 8 | 1315008 | BAR, NUT |
| 5 | 2 | 1315010 | ROLLER, CONVEYOR |
| 6 | 2 | 1315013 | PLATE, BEARING MOUNT |
| 7 | 3 | 1315052 | SHAFT,IDLE ROLL |
| 8 | 4 | 1315054 | MOUNT, TENSION ROLL |
| 9 | 1 | 1315056 | SHAFT, DRIVE WELDMENT |
| 10 | 1 | 1315198 | MOUNT, CONV. MOTOR |
| 11 | 2 | 1315240 | ASSY, TENSIONER ROLL |
| 12 | 4 | 1315263 | PANEL, TOP |
| 13 | 4 | 1315369 | PANEL, TOP UHMW |
| 14 | 1 | 1315501 | ASSY, FRAME |
| 15 | 1 | 1315632 | KEY, CONV. MOTOR |
| 16 | 8 | 1315661 | ROD, THREADED, 5/8-11X7LG |
| 17 | 4 | AAC316DXP | CYLINDER,AIR,2" BORE |
| 18 | 4 | AAFD2313 | CLEVIS, AIR CYLINDER |
| 19 | 8 | AAQME-4-4 | ELBOW, MALE,1/4X1/4NPT |
| 20 | 4 | AAQUT-4-4 | QUICK UNION T 1/4X1/4 |
| 21 | 4 | BBMFC-16T | BEARING,4B PILOTED FLANGE |
| 22 | 4 | CCCL12F | CLAMP COLLAR- 3/4 |
| 23 | 1 | K-235A | CONNECTOR,ROMEX,3/4" |
| 24 | 2 | MM132-2X4 | END CAP,RECT,BLACK |
| 25 | 4 | MM6202240 | TRANTORQUE,1" BORE |
| 26 | 8 | MM644001PHNTLB | CASTER, 4" SWIVEL W/BRAKE |
| 27 | 1 | MMBF2SM35-015 | GEARMOTOR, HOLLOW BORE |
| 28 | 8 | MML-2 | LEVELING PAD, 5/8-11 |
| 29 | 2 | NNE3/8-16 | NUT, ELASTIC 3/8-16 |
| 30 | 3 | NNE5/16-18 | NUT,ELASTIC LOCK,5/16-18 |
| 31 | 24 | NNE8-32 | NUT,ELASTIC LOCK, 8-32 |
| 32 | 4 | NNH5/16-18 | 5/16-18 HEX NUT |
| 33 | 8 | NNH5/8-11 | 5/8-11 HEX NUT |
| 34 | 14 | NNK1/4-20 | KEP NUT, 1/4-20 |
| 35 | 3 | SSAS024080 | 3/8X1-1/4,5/16-18SHLDBOLT |
| 36 | 24 | SSFC90032 | #8-32 X 1/2 FLAT ALLEN |
| 37 | 19 | SSHC01192 | 1/4-20 X 3 HEX HEAD |
| 38 | 32 | SSHC10064 | 5/16-18 X 1" HEX HEAD |
| 39 | 20 | SSHC10080 | 5/16-18 X 1-1/4 HEX HEAD |
| 40 | 16 | SSHC10096 | 5/16-18 X 1-1/2 HEX HEAD |
| 41 | 4 | SSHC25320 | 3/8-16 X 5 HEX HEAD |
| 42 | 33 | WWFS1/4 | WASHER FLAT, 1/4 |
| 43 | 12 | WWFS3/8 | WASHER, FLAT, 3/8 |
| 44 | 52 | WWFS5/16 | WASHER, FLAT, 5/16 |
| 45 | 4 | WWL3/8 | 3/8 LW |
| 46 | 68 | WWL5/16 | 5/16 LW |
| 47 | 1400 IN | ZZZSH-310 | TAPE,DOUBLE SIDED,3/4" |

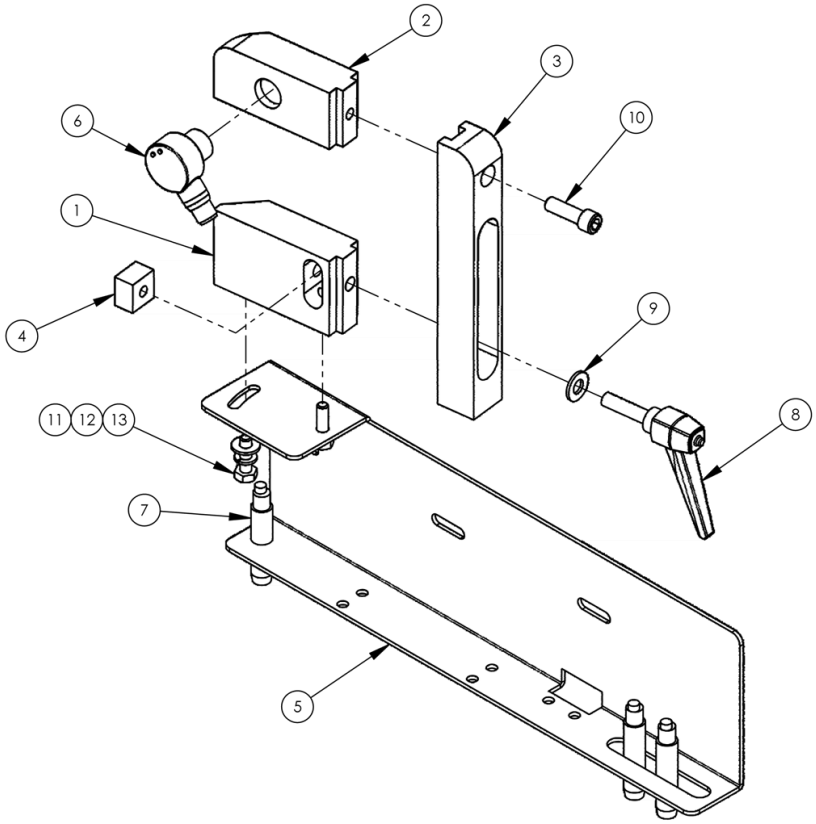



1 CAPACITORS INCLUDED WITH ACTUATORS

# 1315560 Control Box Assembly

AAC Drawing Number 1315560 Rev3

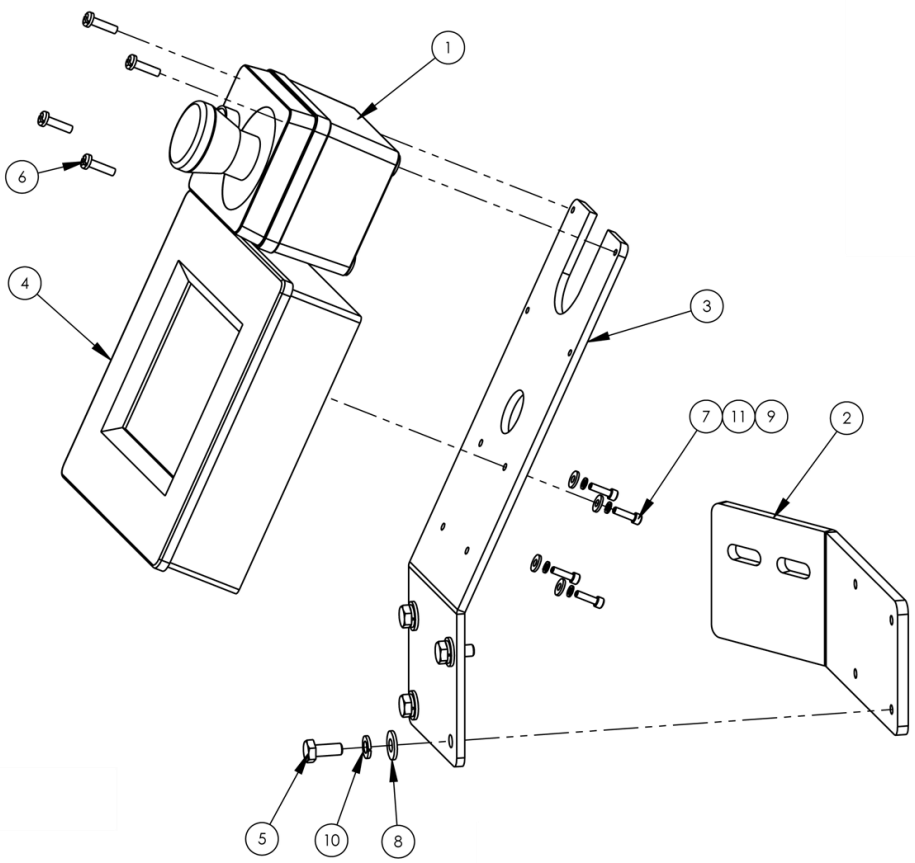
| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315415 | BRKT, AC TECH |
| 2 | 1 | 1315561 | BOX, CONTROL |
| 3 | 1 | 1315562 | DOOR, CONTROL BOX |
| 4 | 1 | 1315588 | CATCH, PNEU. PANEL |
| 5 | 1 | 1315650 | AC POWER DISCONNECT ASSY |
| 6 | AR | 1315A-WD | WIRING DIAGRAM |
| 7 | 3 | 13459004 | MOUNTING BRACKET, CAPACIT |
| 8 | 6 | 4080-110 | MODULE,QUAD INPUT |
| 9 | 1 | 4080-120 | MODULE,DUAL OPTO-ISO |
| 10 | 3 | 4080-130 | MODULE,QUAD OPTO-ISO |
| 11 | 5 | 4080-140 | MODULE,QUAD OUTPUT |
| 12 | 1 | 4080-150 | MODULE,PROGRAM |
| 13 | 1 | 4080-970 | MODULE,MEMORY |
| 14 | 1 | 4080-980 | MODULE, ADAPTER |
| 15 | 1 | 4080-990R | POWER SUPPLY,SBUS,CLASS 2 |
| 16 | 1 | EECA73710 | CONTACTOR,IEC,4P,37A,220V |
| 17 | 4 | EEDC2X2 | COVER,WIRE DUCT |
| 18 | 7 | EEDF2X2 | DUCT,WIRE,2X2, MOD |
| 19 | 2 | FF1724 | STRAIN RELIEF |
| 20 | 20' | FF19511 | CABLE, 3 COND, 14GA |
| 21 | 3 | FF264-311 | TERMBLK,WAGO,TOP,SINGLE,GRY |
| 22 | 19 | FF264-341 | TERMBLK,WAGO,TOP,DUAL,GRY |
| 23 | 6 | FF264-347 | TERMBLK,WAGO,TOP,DUAL,GRN |
| 24 | 6 | FF264-371 | TERMBLK,WAGO,TOP,END |
| 25 | 1 | FFD2425F | RELAY,SSR,24VAC,25A |
| 26 | 1 | FFRAV781BW | MODULE, TVS, 240 VAC |
| 27 | 1 | K-235 | CONNECTOR,ROMEX,1/2" |
| 28 | 2 | MM1155LA | HINGE, MALE, LEFT |
| 29 | 1 | MM40450010 | FASTENER,SLIDE LOCK |
| 30 | 1 | MMSM210S | DRIVE,VARIABLE FREQUENCY |
| 31 | 1 | MMSM220S | DRIVE, VARIABLE FREQ. |
| 32 | 3 | NNK10-32 | KEP NUT, 10-32 |
| 33 | 2 | SSBC98032 | #10-32 X 1/2 BUT HEAD |
| 34 | 1 | SSHC01064 | 1/4-20 X 1 HEX HEAD |
| 35 | 64 | SSPP90024 | #8-32 X 3/8 PAN HD PHIL |
| 36 | 10 | WWFS10 | WASHER, FLAT #10 |




# 1315603 Sensor Bracket Assembly

AAC Drawing Number 1315603 Rev1

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1315015 | BLOCK, EYE MOUNT |
| 2 | 1 | 1315016 | BLOCK, SENSOR |
| 3 | 1 | 1315017 | BRACKET, SENSOR MOUNT |
| 4 | 1 | 1315020 | BLOCK, NUT |
| 5 | 1 | 1315605 | BRACKET, SENSOR MTG |
| 6 | 1 | FFT18FF100Q | EYE,FIXED FIELD, 4IN |
| 7 | 3 | MMAM1-A0-4AM | PROX SWITCH,10-30VDC,12MM |
| 8 | 1 | TTH32426 | HANDLE,THRD,5/16-18X1-1/4 |
| 9 | 1 | WWFS5/16 | WASHER, FLAT, 5/16 |
| 10 | 1 | SSSC10064 | 5/16-18 X 1 SOC CAP |
| 11 | 2 | WWFS1/4 | WASHER FLAT, 1/4 |
| 12 | 2 | WWL1/4 | 1/4 LW |
| 13 | 2 | SSHC01056 | 1/4-20 X 7/8 HEX HEAD |

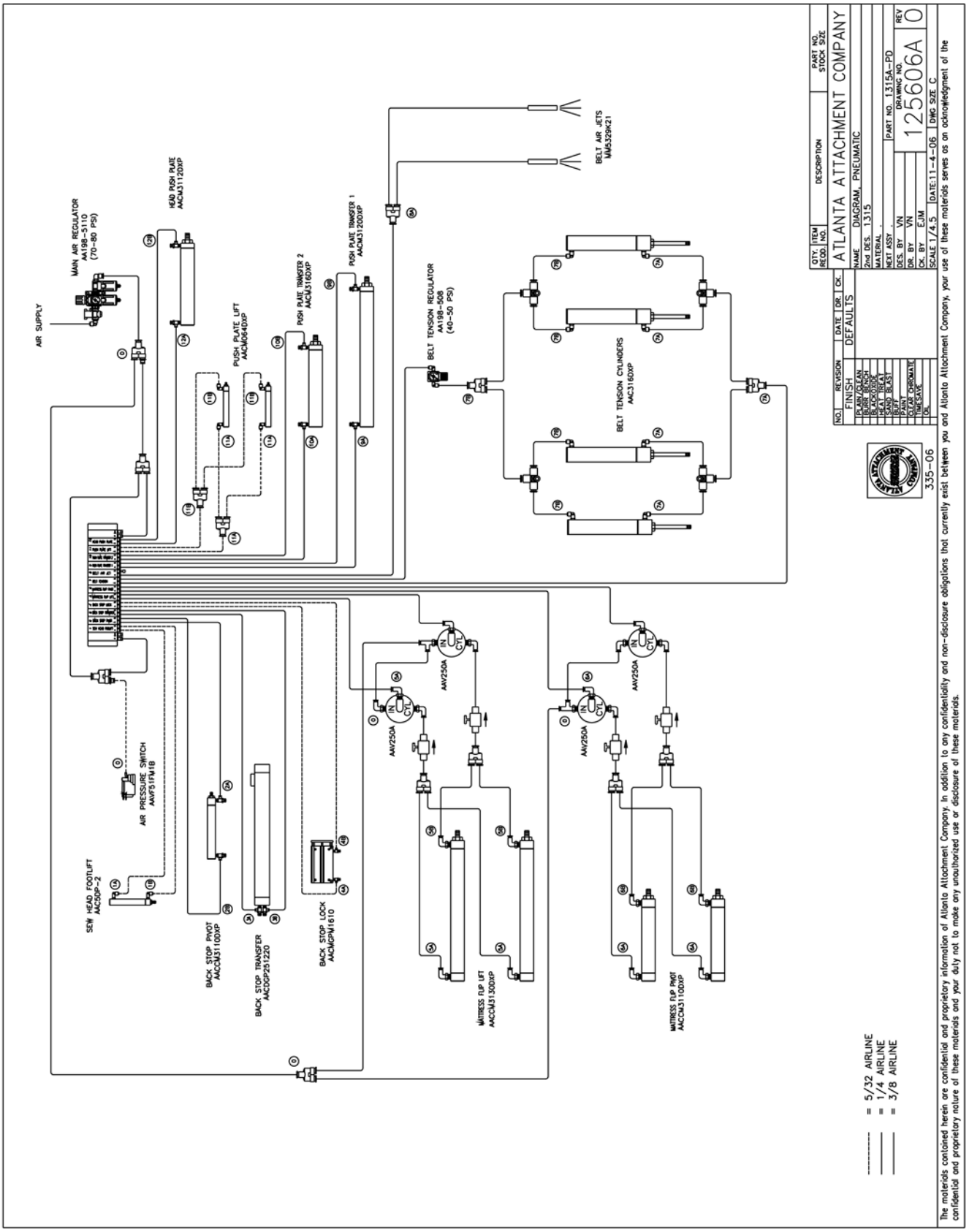



# 1315610 Touch Screen Assembly

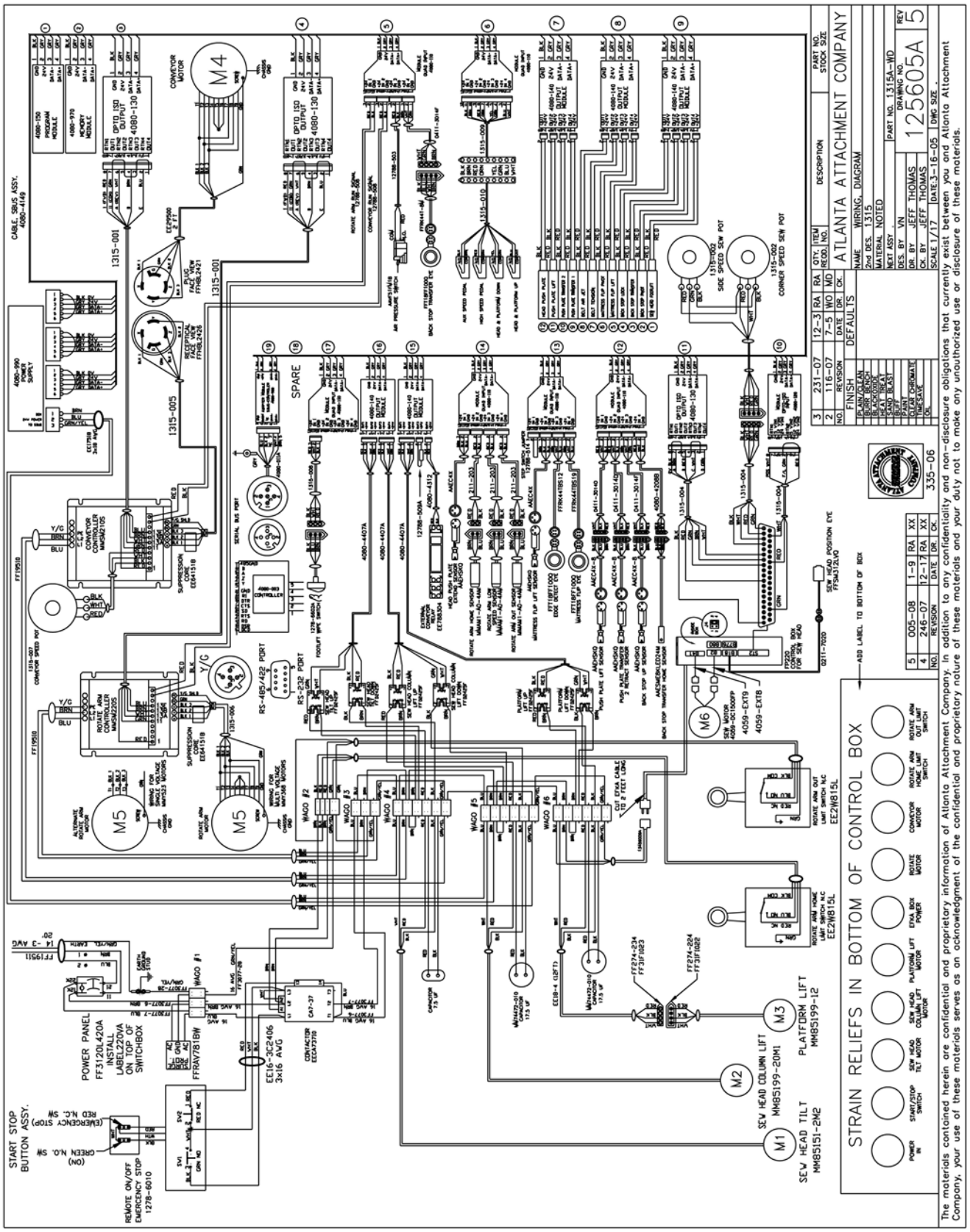
AAC Drawing Number 1315610 Rev1

| NO. | QTY | PART # | DESCRIPTION |
|---|---|---|---|
| 1 | 1 | 1278-6010 | START/STOP BUTTON ASSY |
| 2 | 1 | 1315607 | MOUNT, TOUCH SCREEN |
| 3 | 1 | 1315608 | BRACKET, TOUCH SCREEN |
| 4 | 1 | 4080-003 | CONTROLLER,SBUS,V3 |
| 5 | 4 | SSHC01040 | 1/4-20 X 5/8 HHCS |
| 6 | 4 | SSPS90040 | #8-32 X 5/8 LG. PAN HD SLOT |
| 7 | 4 | SSSC80032 | #6-32 X 1/2 SOC CAP |
| 8 | 4 | WWFS1/4 | WASHER,FLAT,SAE,1/4 |
| 9 | 4 | WWFS6 | WASHER, FLAT, #6 |
| 10 | 4 | WWL1/4 | WASHER,LOCK,1/4 |
| 11 | 4 | WWL6 | WASHER,LOCK,6 |

# 1315A-PD Pneumatic Diagram



# 1315A-WD Wiring Diagram



# Atlanta Attachment Company (AAC) Statement of Warranty

## Manufactured Products

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

## Terms and Conditions:

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

## What Is Covered

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

## What Is Not Covered

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

# Declaración de Garantia

## Productos Manufacturados

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

## Términos y Condiciones:

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

## Lo Que Está Garantizado

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

## Lo Que No Está Garantizado

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

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