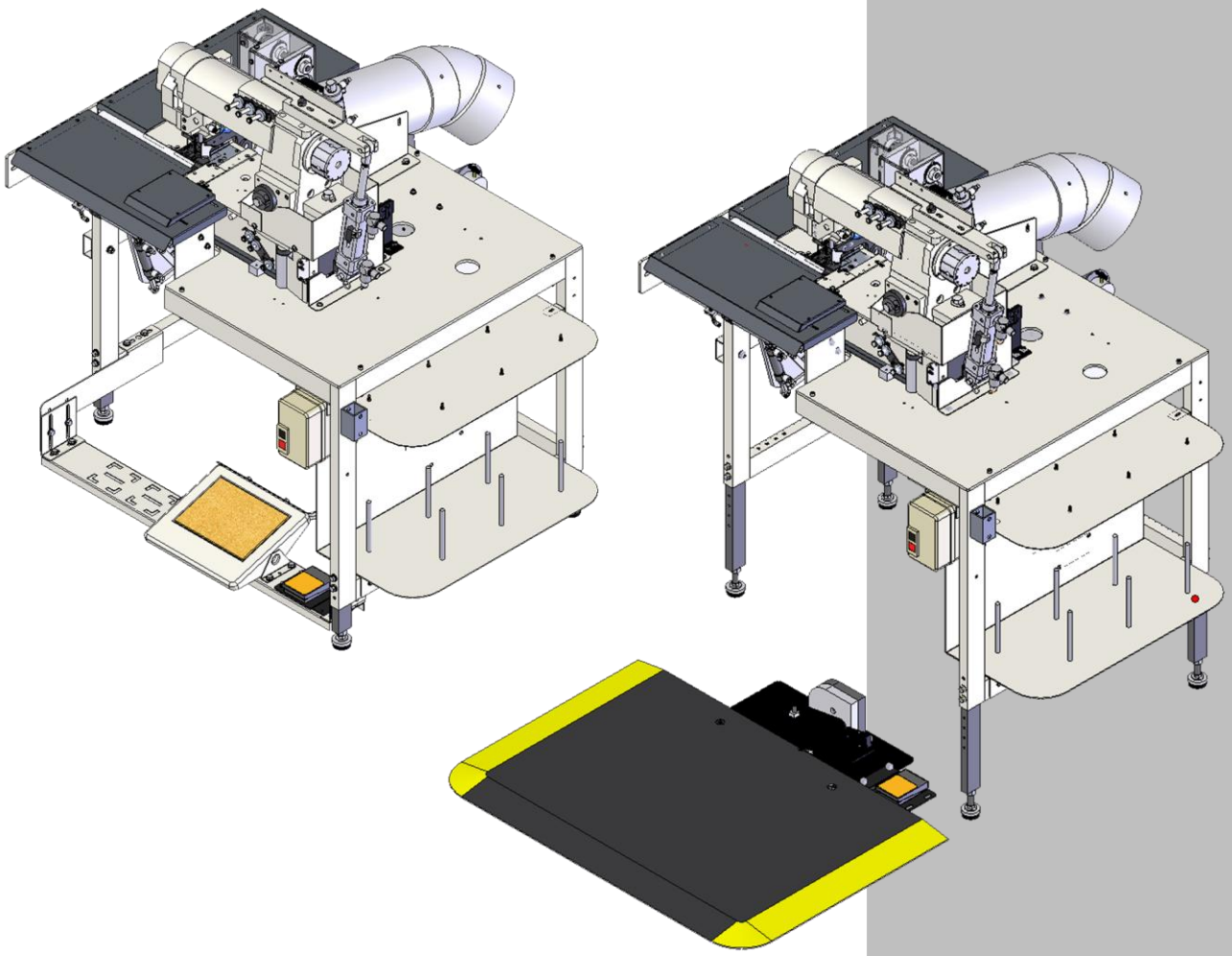
Model **1317**

Revision 2.1 Updated Aug 29, 2012

Technical Manual & Parts Lists



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IMPORTANT

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

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Important Safety Instruction

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

Mandatory Information

All persons operating and/or working on the 1317 Semi-Automatic Panel Flanger should read and understand all parts of the Safety Instructions. This applies, in particular, for persons who only operate and/or work on the unit occasionally (e.g. for maintenance and repair). Persons who have difficulty reading must receive particularly thorough instruction.

Scope of the Instruction Material

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

And may also include;

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

Intended Use

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

Exclusion of Misuse

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

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

Liability

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

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

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

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

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

Choice and Qualification of Personnel

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

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

Training

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

Responsibilities

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

A Word to the Operator

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

ALWAYS BE CONSCIOUS OF THESE DANGERS!

Safety Equipment on the Machines

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

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

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

Damage

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

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

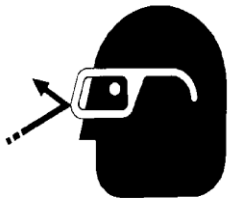
Faults or Errors

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

Signs on the Machine

Safety and danger signs on the machine should be observed and checked at regular intervals to ensure that they are complete and undamaged. They should be clearly visible and legible at all times.
Clothing, Jewelry, Protective Equipment
Long loose hair, loose-fitting clothes, gloves and jewelry, including rings, should be avoided in order to avoid injuries due to being caught, drawn in and wound up inside the machine.

Protective Eyewear



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

Tools

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

Oils, Lubricants, Chemicals

Note the applicable safety regulations for the product used.

No Smoking, Fire, Explosion Hazard

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

Workplace

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

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

Emergency STOP

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

First Aid

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

Important Notices

Reporting and Fighting Fires

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

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

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

Electrical Power Supply

Before undertaking any maintenance or repair work on the machine, switch off the electrical power to the machine at the main source and secure it with a padlock so that it cannot be switched on again without authorization.
In practice, this may mean that the technician, electrician and operator all attach their own padlock to the master switch simultaneously so that they can carry out their work safely. Locking extension plates should be available for multiple locks if required. The primary purpose for a lockout/tagout procedure is to protect workers from injury caused by unexpected energizing or start-up of equipment.

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

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

- Electricity - The machine is always isolated from the electrical power supply whenever the master switch has been switched off. However, this does not apply for the power supply in the control cabinet, nor for equipment that does not draw its power via the master switch.

- Pneumatic / hydraulic energy - Almost all our machines carry compressed air. In addition to switching off the master switch, the air supply must also be disconnected and the machine checked to ensure it is depressurized before starting any work on the machine; otherwise the machine may execute uncontrolled movements.

- Kinetic energy - Note that some motors or spindles, for example, may continue to run or coast run on after being switched off.

- Potential energy - Individual assemblies may need to be secured if necessary for repair work.

Delivery of the Machine/Packaging

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

Transport Damage

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

Interim Storage

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

Transporting the Machine

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

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

Never allow the straps to rest against the machine enclosure and never push or pull sensitive parts of the machine. Ensure that the load is always properly secured. Before or immediately after loading the machine, secure it properly and affix corresponding warnings.
All transport guards and lifting devices must be removed before the machine is started up again. Any parts that are to be removed for transport must be carefully refitted and secured before the machine is started up again.

Workplace Environment

Our machines are designed for use in enclosed rooms: Permissible ambient temperature approx. 5 - 40 °C (40 - 104 °F). Malfunctions of the control systems and uncontrolled machine movements may occur at temperatures outside this range.
Protect against climatic influences, such as electrostatic charges, lightning strikes, hail, storm damage, high humidity, salinity of the air in coastal regions.

Protect against influences from the surroundings: no structure-borne vibrations, no grinding dust, or chemical vapors.
Protect against unauthorized access.
Ensure that the machine and accessories are set up in a stable position.
Ensure easy access for operation and maintenance (Instruction Manual and layout diagram); also verify that the floor is strong enough to carry the weight of the machine.

Local Regulations

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

Maintenance

General Safety Instructions

The machine shall be switched off, come to a standstill and be secured so that it cannot be switched on again inadvertently before starting any maintenance work whatsoever. Use proper lockout/tagout procedures to secure the machine against inadvertent startup.
Remove any oil, grease, dirt and waste from the machine, particularly from the connections and screws, when starting the maintenance and/or repair work. Do not use any corrosive-cleaning agents. Use lint-free rags.
Retighten all screw connections that have to be loosened for the maintenance and repair work. Any safety mechanisms that have to be dismantled for setting-up, maintenance or repair purposes must be refitted and checked immediately after completing the work.

Maintenance, Care, Adjustment

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

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

Waste, Disassembly, Disposal

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

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

Repair

Replacement Parts

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

Repair, Electrical

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

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

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

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

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

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

Ventilation/Hazardous Gases

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

Hydraulic and Pneumatic Systems

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

General Liability

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

Starting Machine Movements

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

A Word to the End User

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

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

Safety Precautions

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

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

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

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

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

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

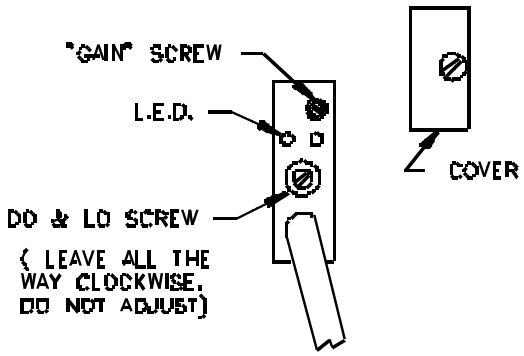
General Machine Data

Electrical Requirements: 220vAC, 5 Amp, 50/60 Hz Single Phase
Pneumatic Requirements: 80 PSI, 20 SCFM avg. 3/8" Air Supply

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.

Parameter Settings for Efka Controller

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

290	0-26	5	Mode of operation. MUST SET THIS PARAMETER FIRST!
111	400-9900	250	Maximum speed
153	0-50	35	Braking power at machine stand still
161	0-1	1 = CCW	Motor rotation
202	0-500	500	Sew start delay after footlift off
219	20090	35	Braking power at stop
270	0-5	1	External handwheel sensor configuration
271	0-255	210	Ref angle for Pos 1 (needle down) from Pos 2 (needle up tape)
272	020-255	100	Drive ration 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.
0	0-9	5	Insert signal on time (1=1/10 sec)
1	0-9	2	Cut signal on time (1=1/10 sec)

Front panel LED's:

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

Programming Instructions:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "311"
3. Press "E" once and "2.0.0." is displayed this is a parameter
4. Proceed to the parameter to be changed and press "E"
5. The value now shows in the screen, adjust to desired value.
6. Press "E" to enter value and continue with parameter setting.
7. Repeat for other parameters, press "P" once when complete.
8. Run sewing head to save parameters before powering down

To Perform Master Reset of Parameters:

1. Power on holding down the "P" button till "COD" is displayed.
2. Press ">>" once and enter the number "591"
3. Press "E" twice and "093" is displayed.
4. Press "+" once, "094" is displayed.
5. Press "P" to exit programming mode with all default values.

Efka Error Codes

E1	Needle position eye blocked or defective
E2	Incoming power voltage too low
E3	Motor overloaded or machine locked up
E4	Safety ground is not connected
E9	Internal Efka error or defective eprom
U1	Low air pressure upon power up
U2	Head not down upon power up
U3	Cut & Insert pedal down upon power up
U4	Low air pressure at Cut & Insert
U5	Low air pressure upon sewing
U6	Head not down upon sewing
U7	Head down timeout (4 sec)

Servicing the Sew Head

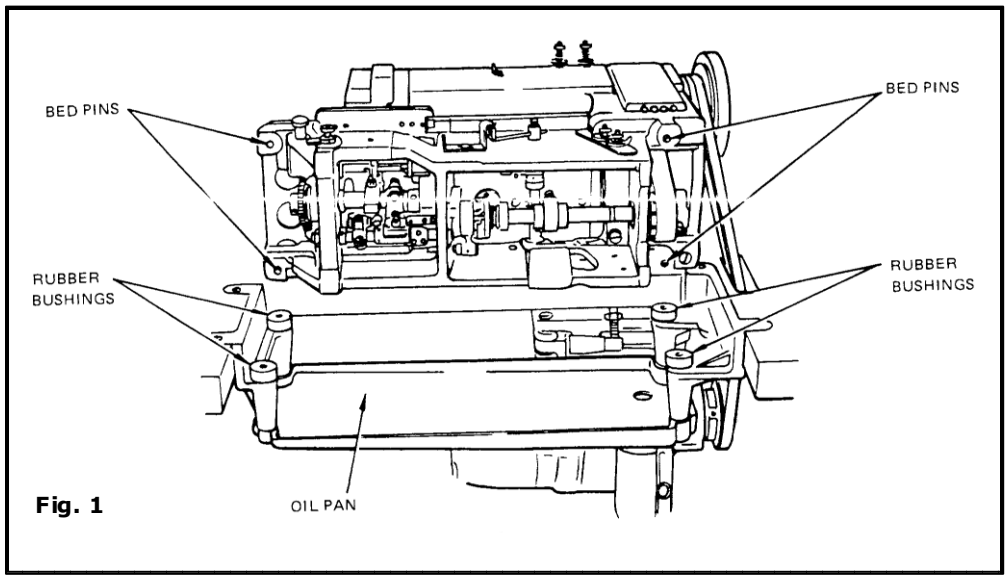


Fig. 1

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.

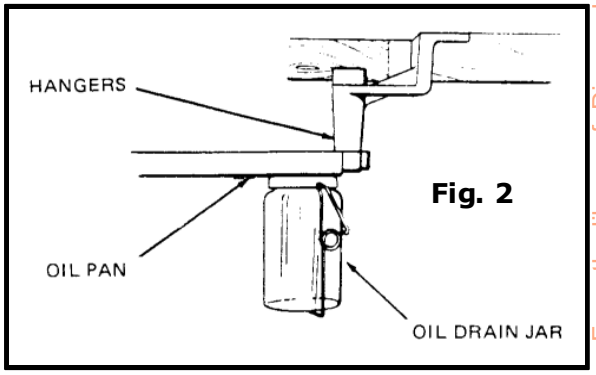


Fig. 2

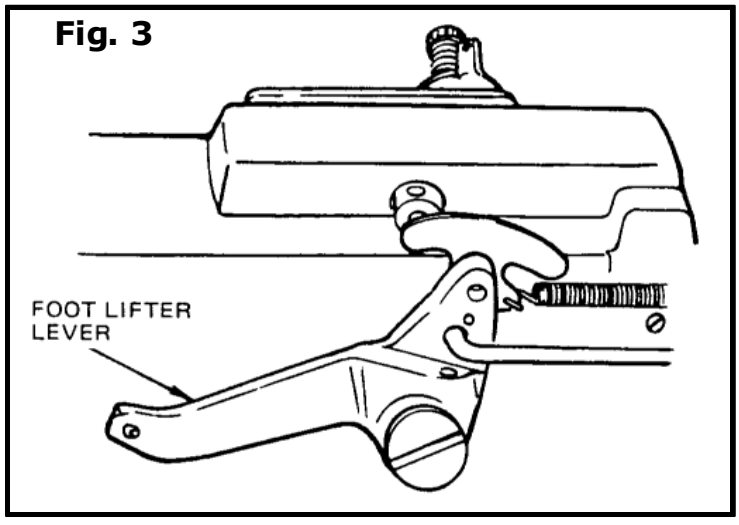


Fig. 3

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.

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.

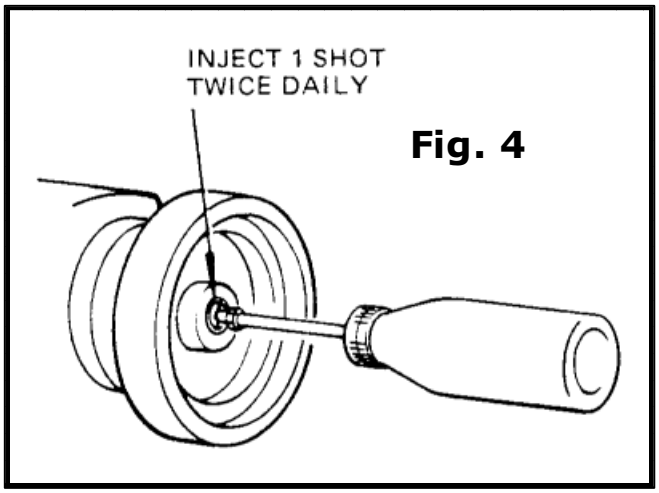


Fig. 4

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.

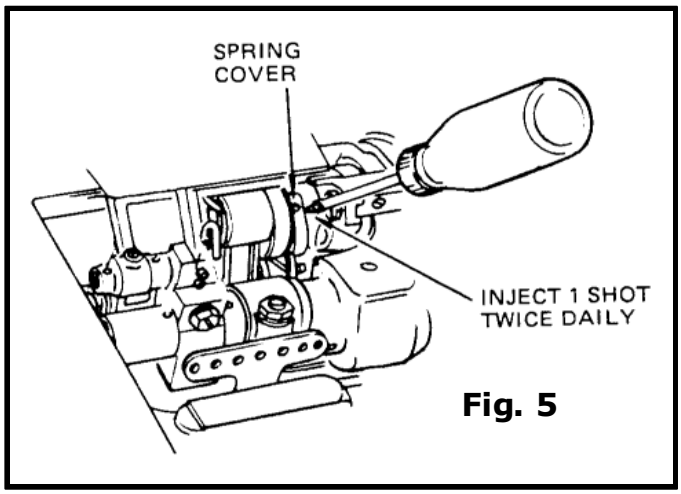


Fig. 5

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.

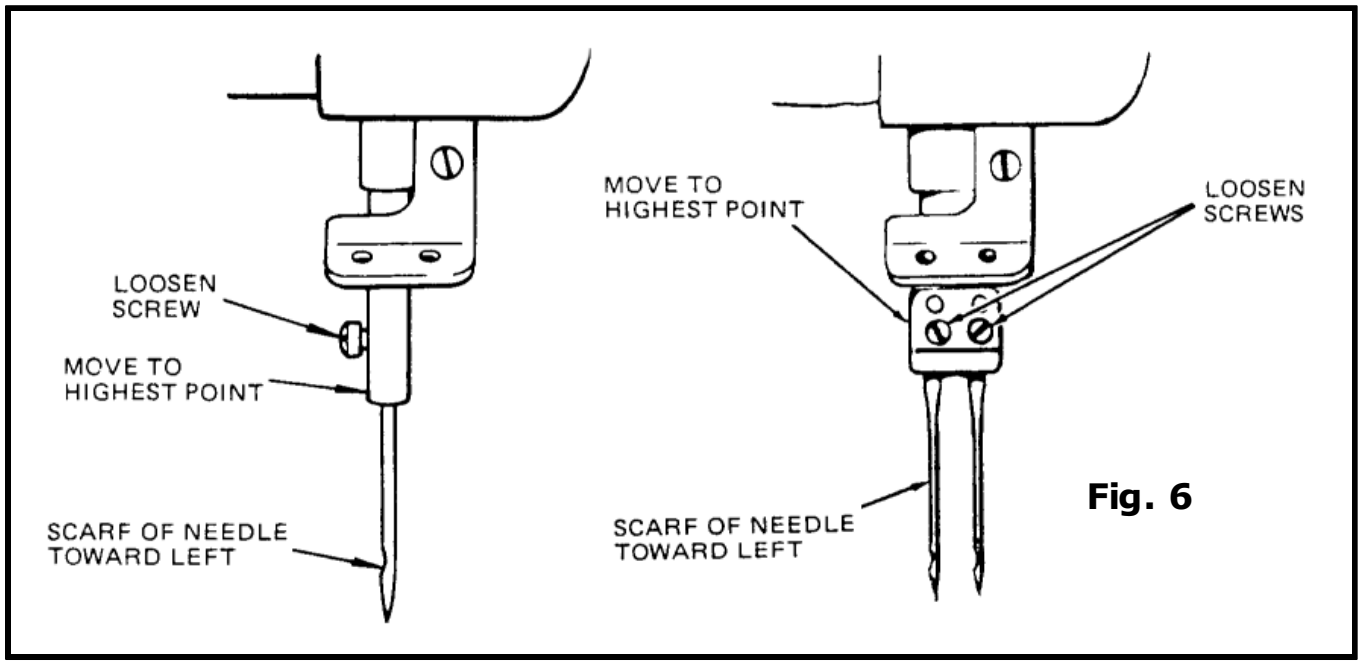


Fig. 6

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.

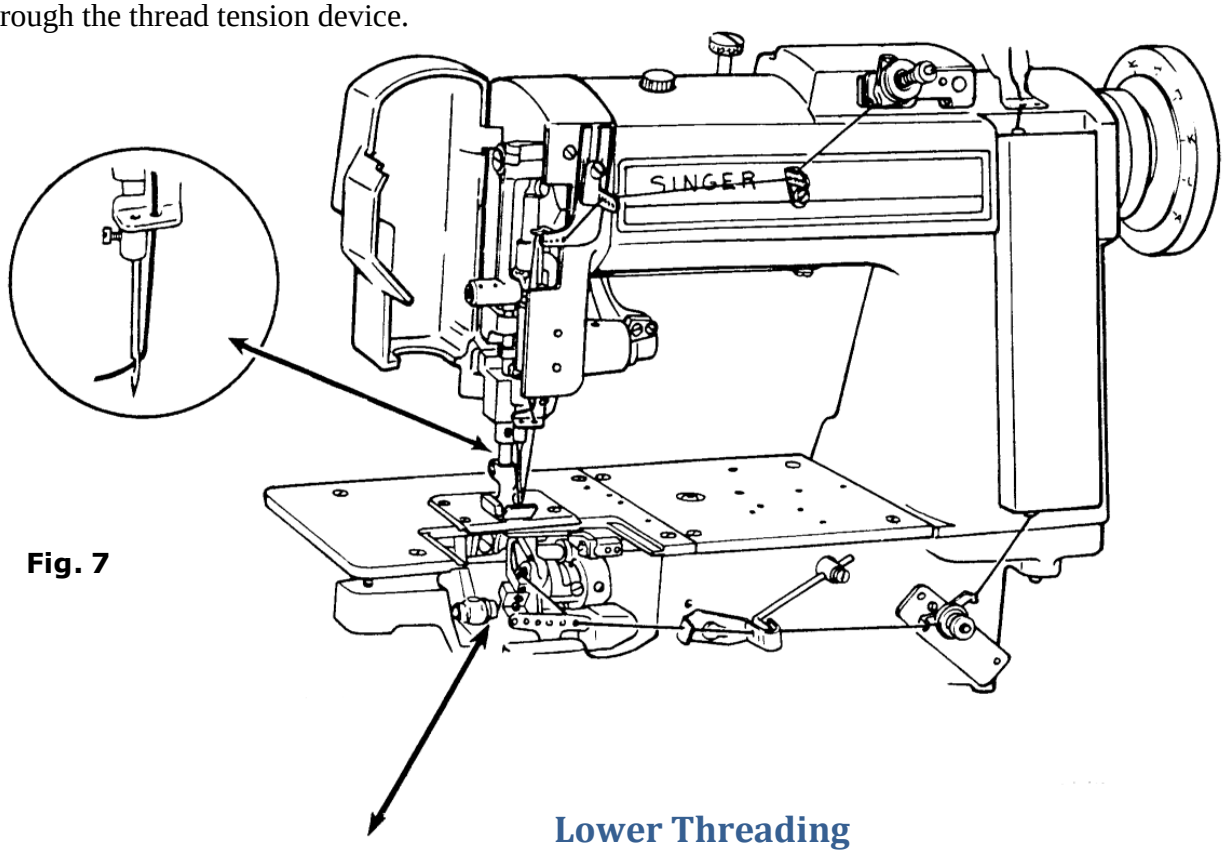
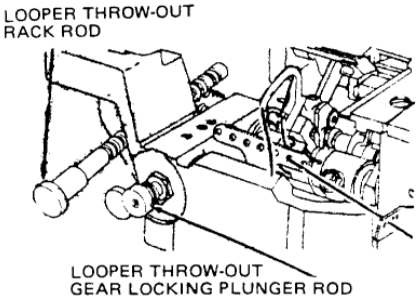


Fig. 7

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.

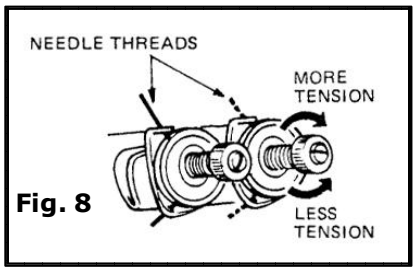


Fig. 8

Tension

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

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.

Looper Thread Tension

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

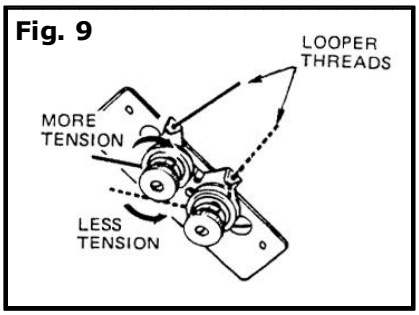


Fig. 9

Pressure

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

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.

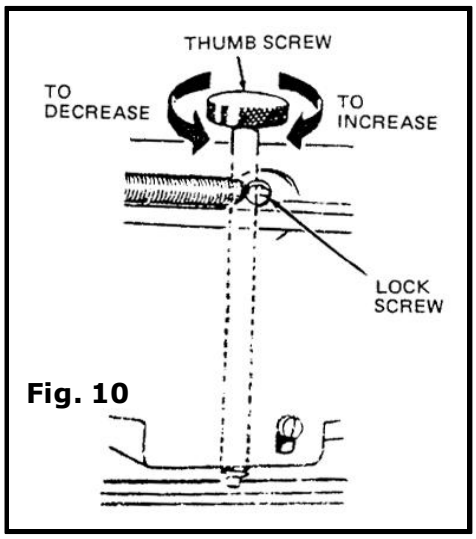


Fig. 10

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.

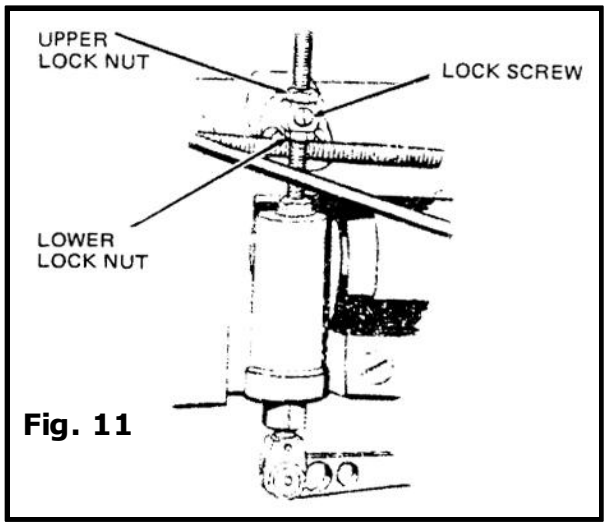


Fig. 11

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.

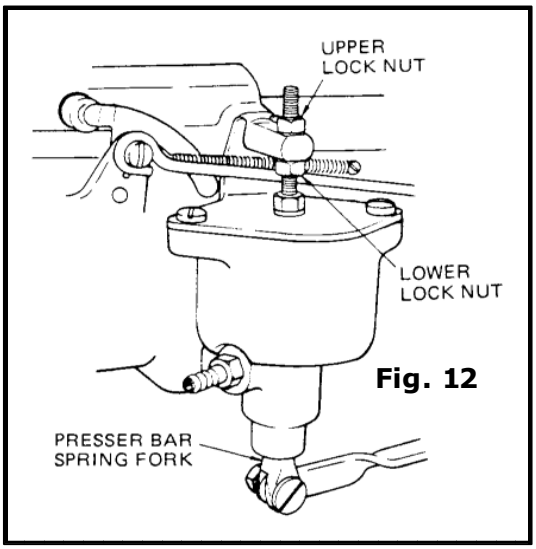


Fig. 12

Upper Feed Roll Pressure

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

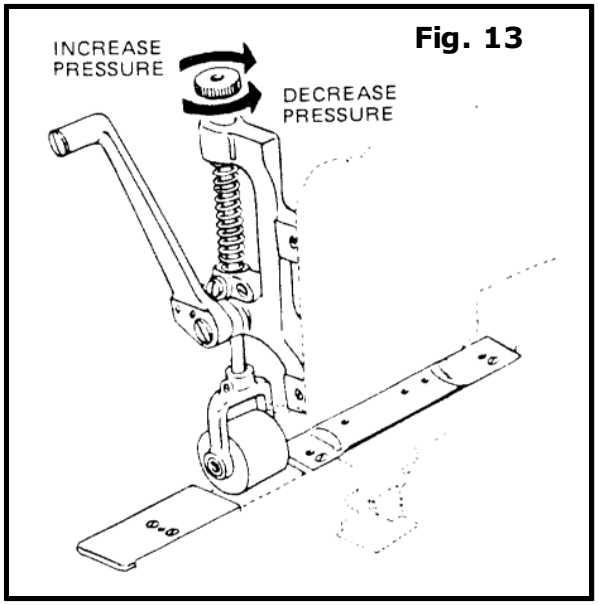


Fig. 13

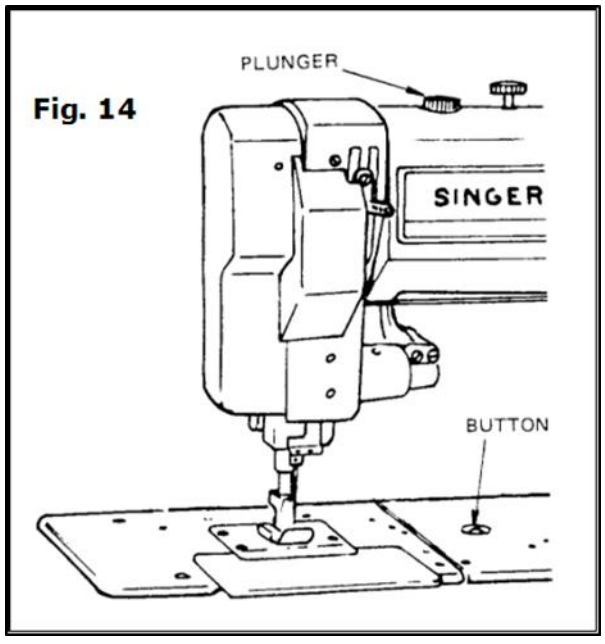


Fig. 14

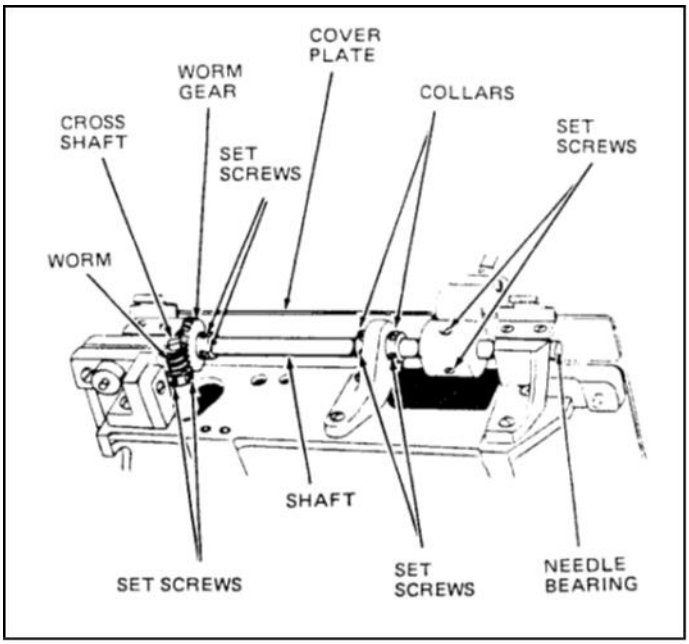
Stitch Length

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, indicated by letter, is opposite 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.

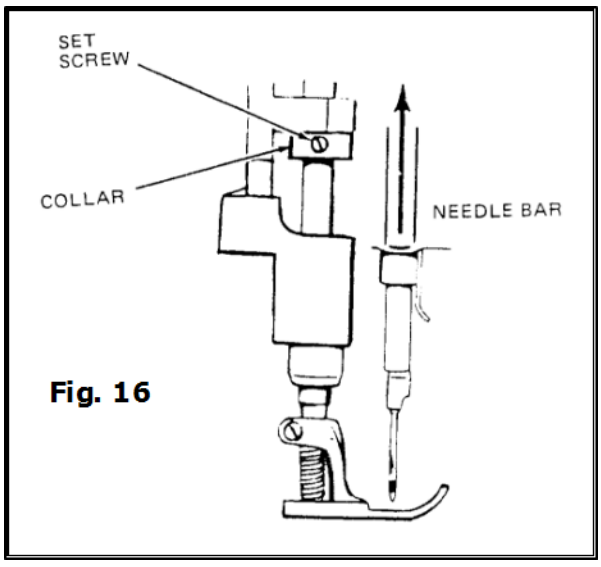


Fig. 16

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.

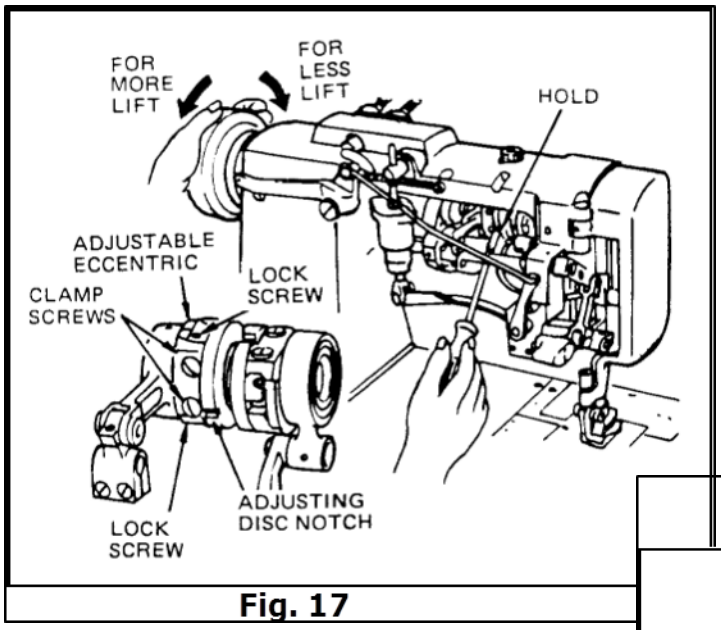


Fig. 17

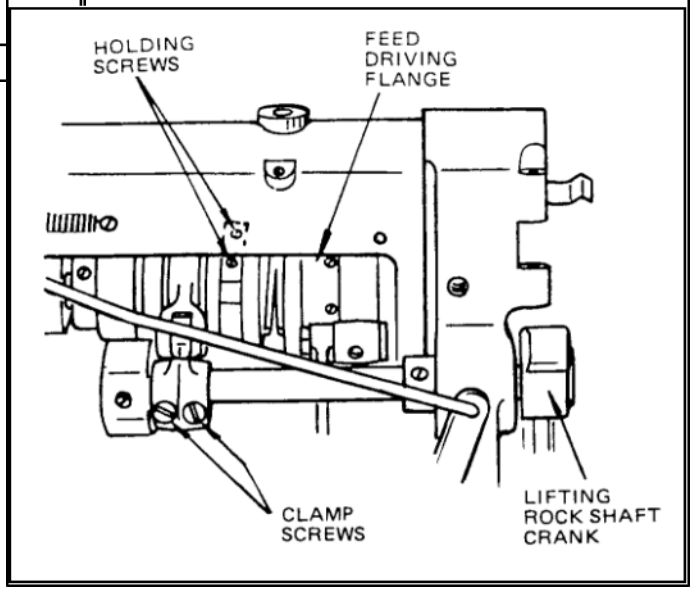
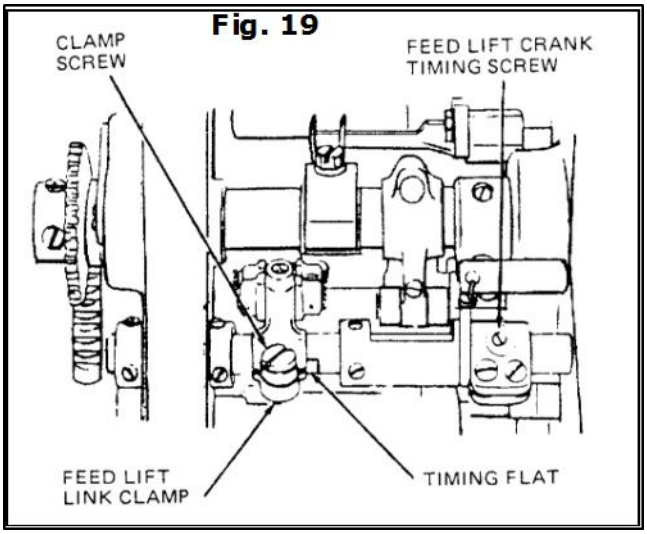


Fig. 18

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

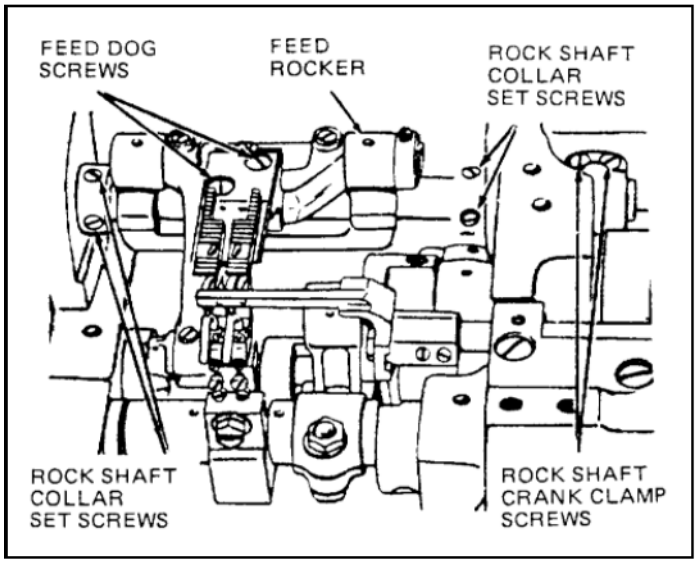
The needle should enter the needle hole of the feed dog with the same clearance between the needle and the left or right side of the hole. To adjust, loosen the feed dog screws, Fig. 20. Move the feed dog until the correct clearance is attained. Hold in position, and tighten the feed dog screws.

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.

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.

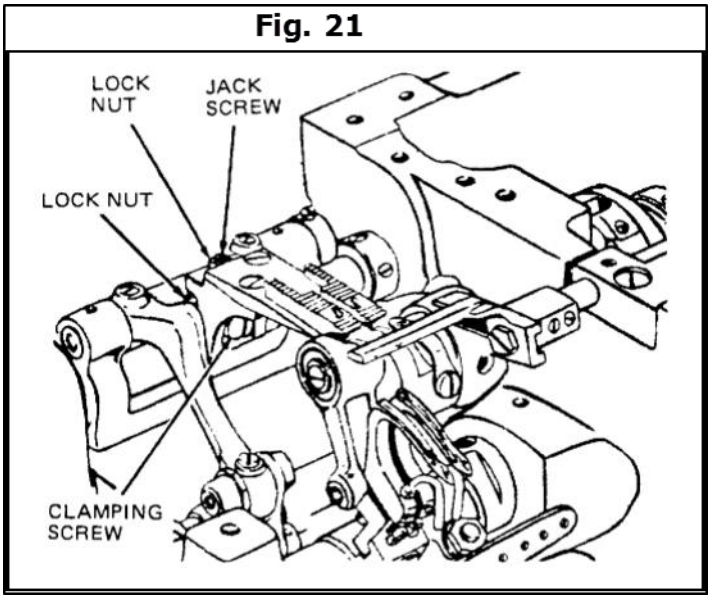
Fig. 20



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.

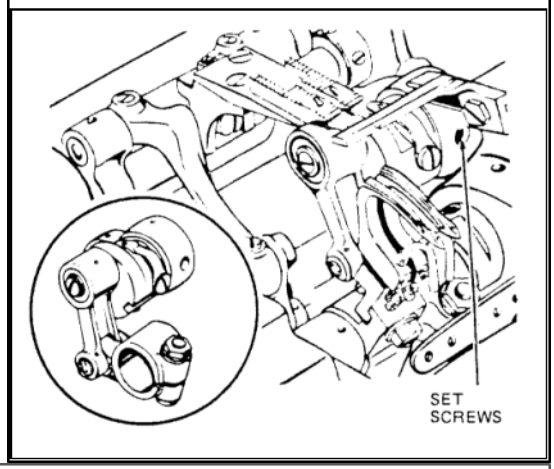
Fig. 21



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.

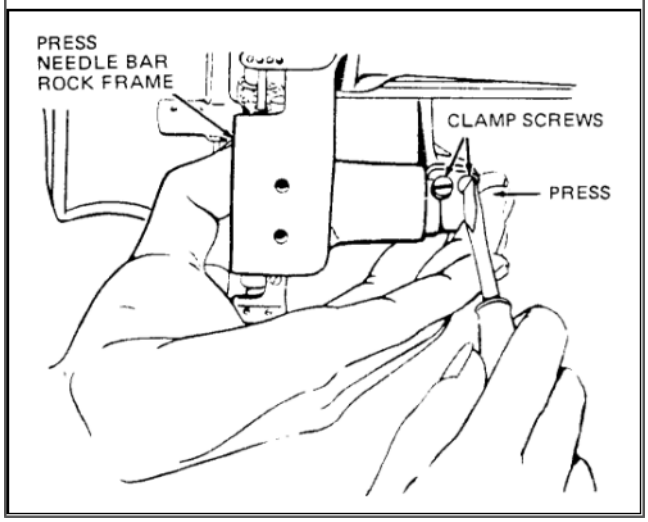
Fig. 22



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.

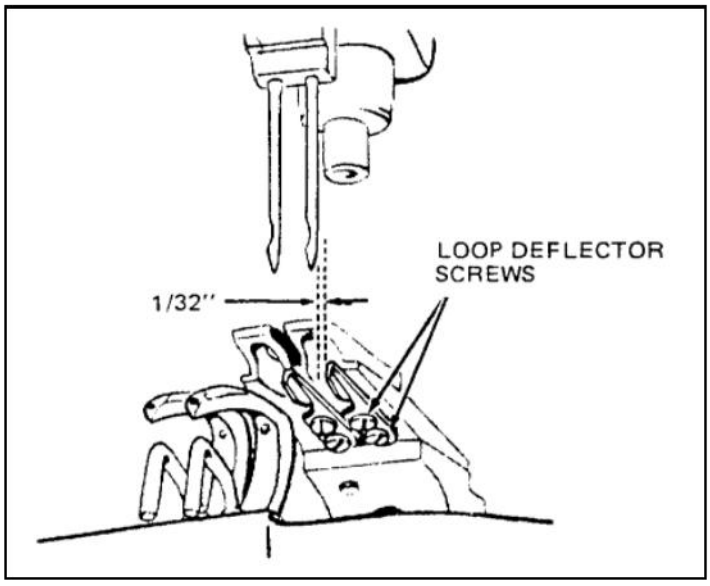
Fig. 23



Positioning the Loop Deflectors

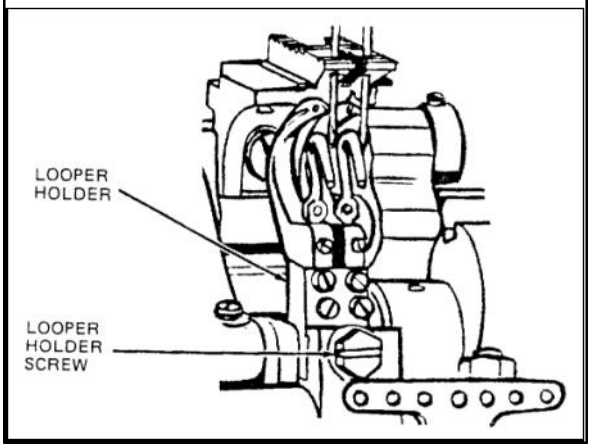
When the loop deflector, located on the underside of the feed dog, is positioned correctly, there should be a clearance of approximately 1/32" between the right side of the needle and loop deflector. To adjust, move the looper out of sewing position and tilt the machine back on its hinges. Loosen the 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.

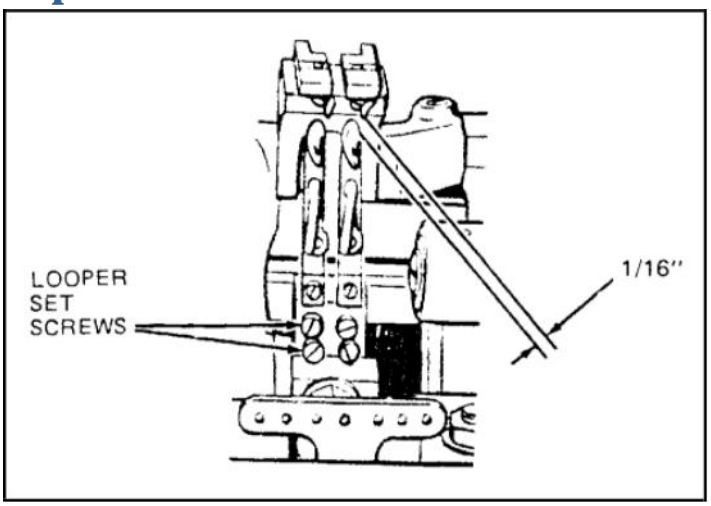
Fig. 24



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

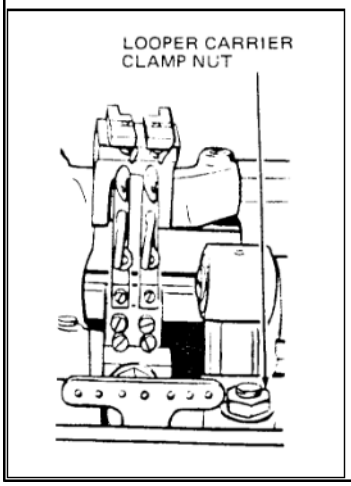
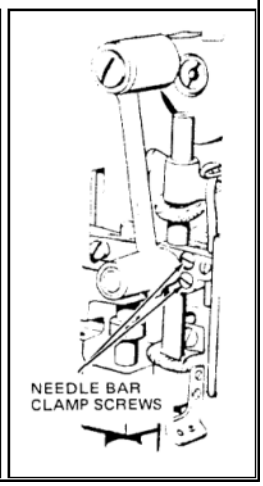


Fig. 28



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 needle 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).

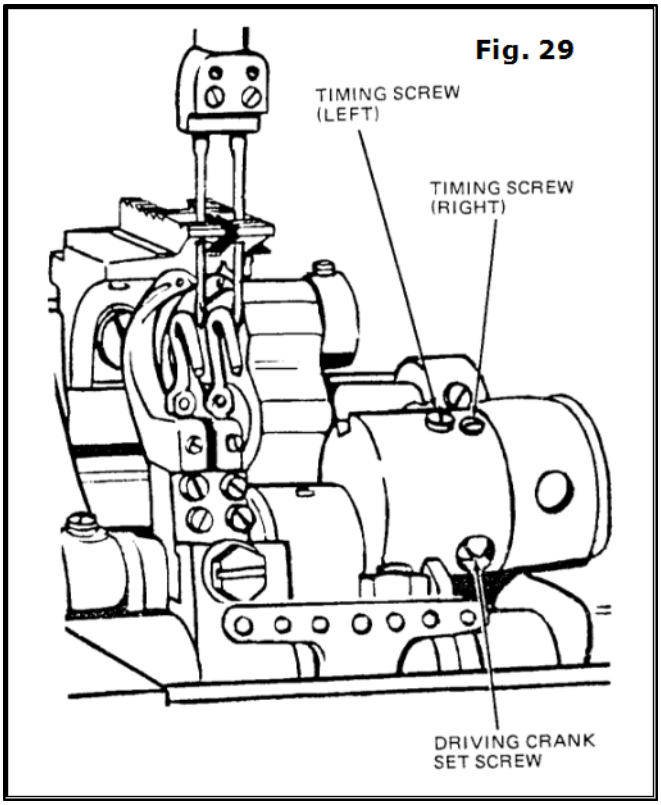


Fig. 29

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, 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.

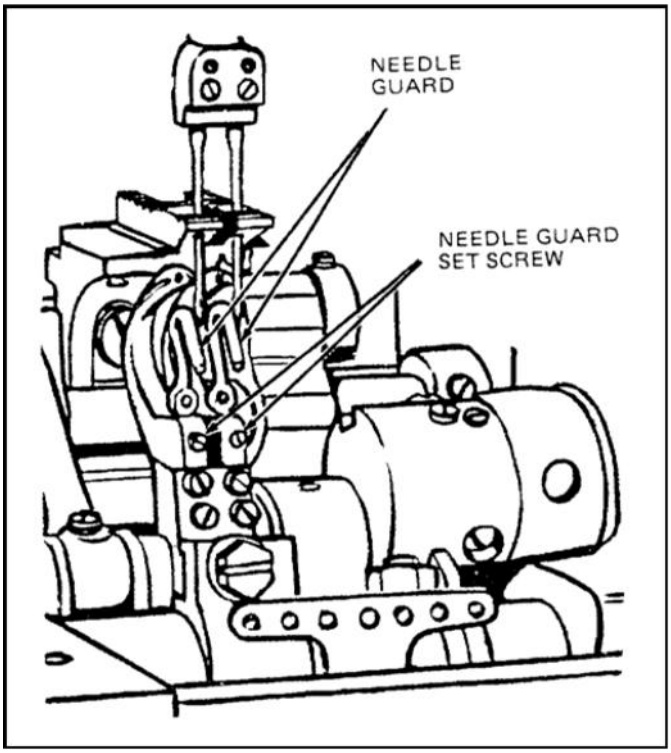


Fig. 30

Positioning Spreader

Fig 31

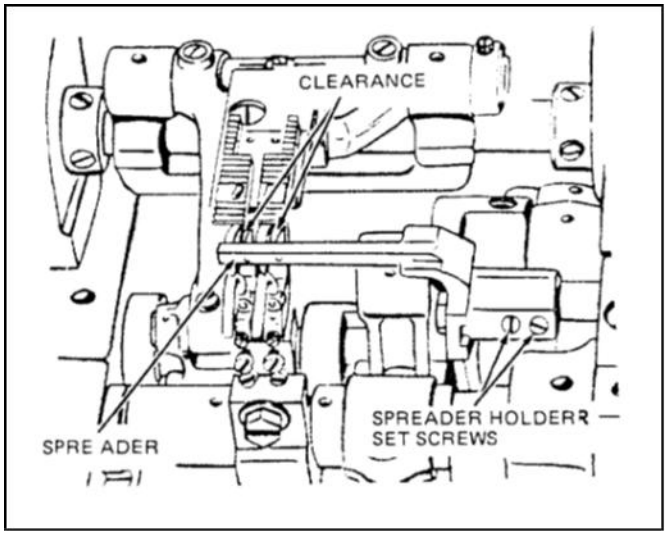
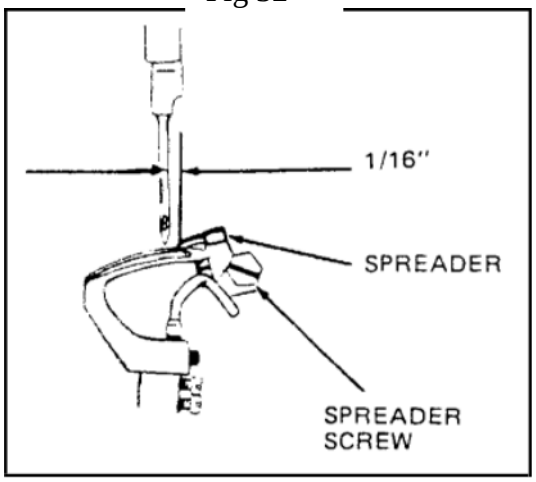


Fig 32



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.

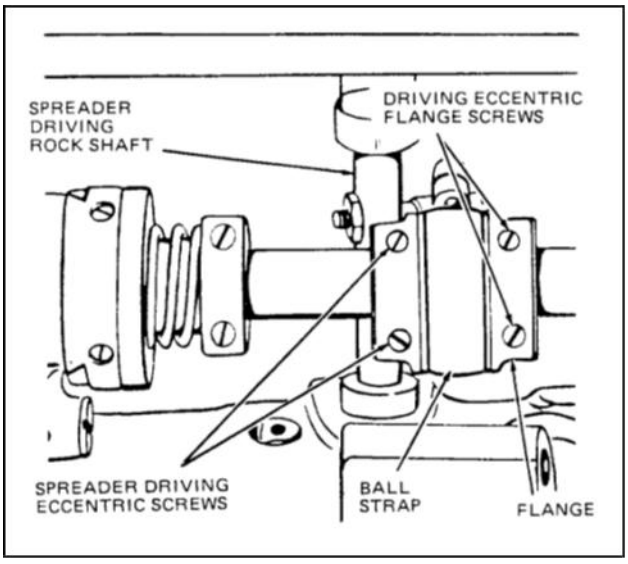
b) The clearance between the spreader point and the looper should be approximately the double thickness of ordinary paper.

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 screw, 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

Fig 34

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.

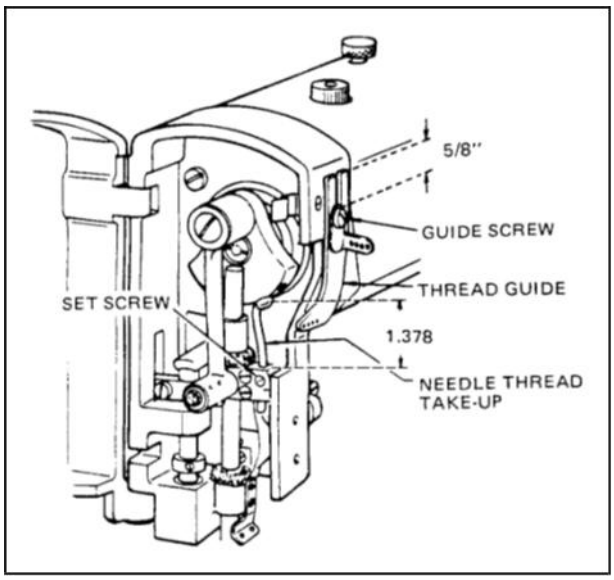


Fig 35

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.

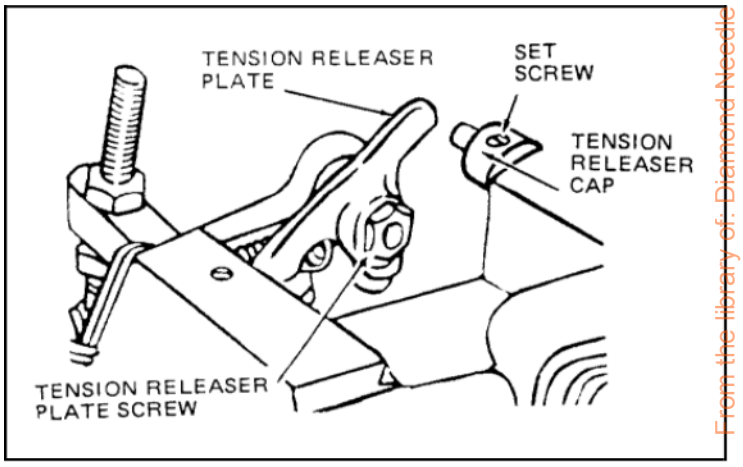
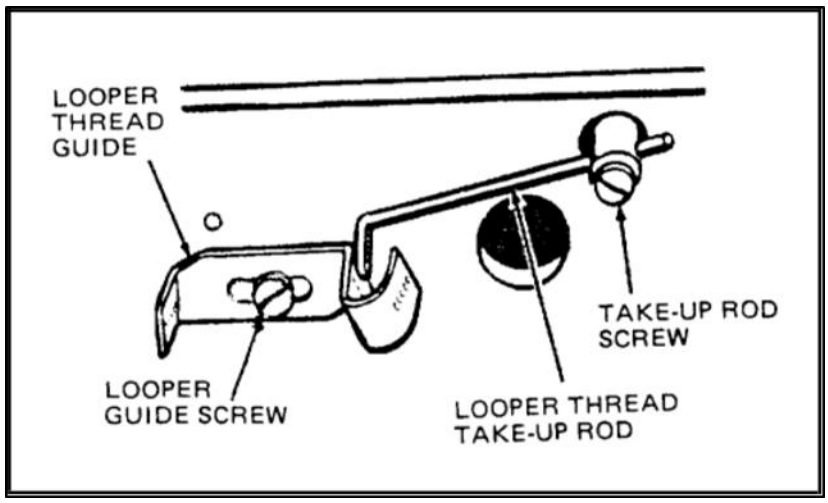


Fig 36

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.



Assembly Drawings & Parts Lists

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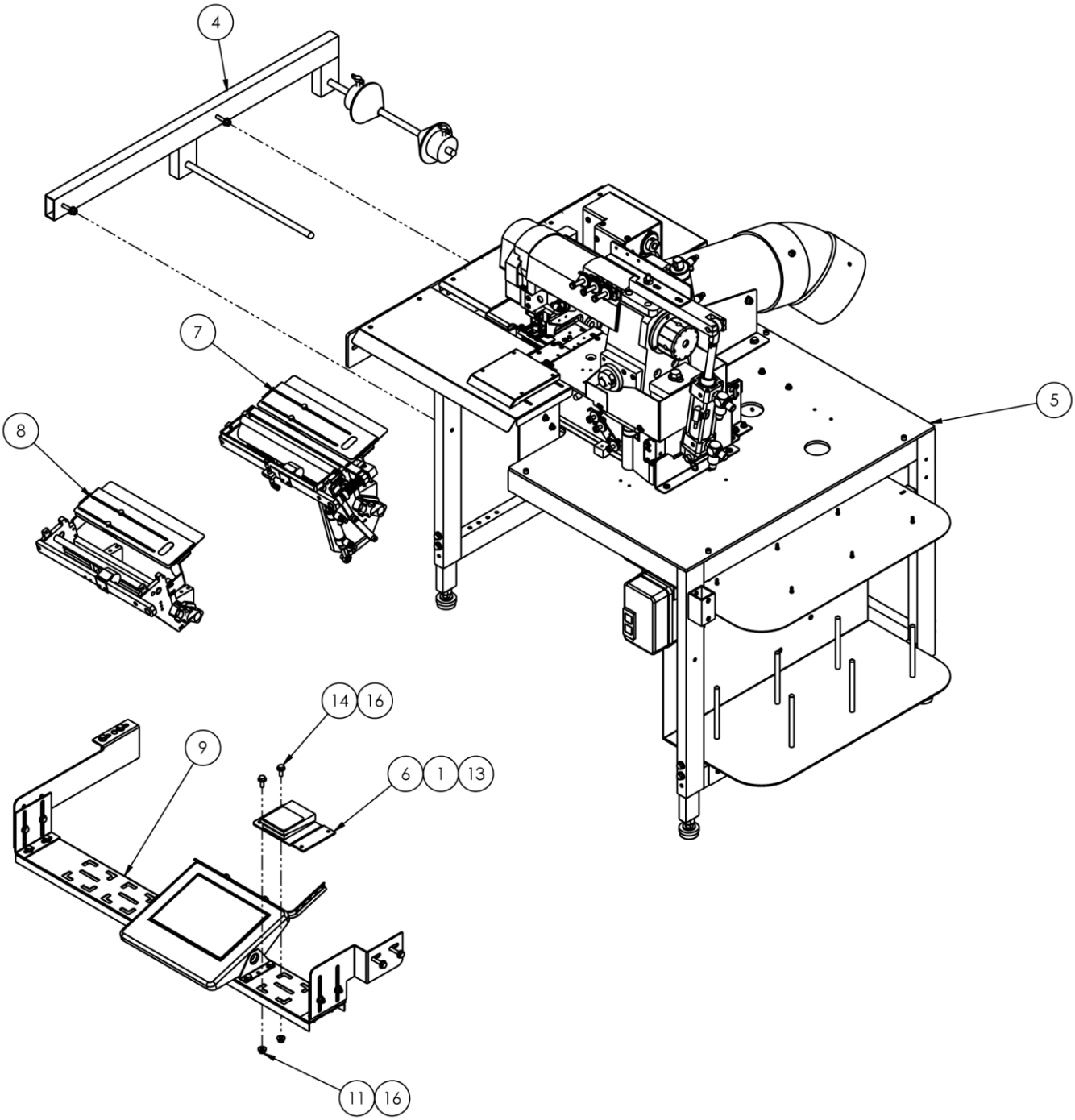
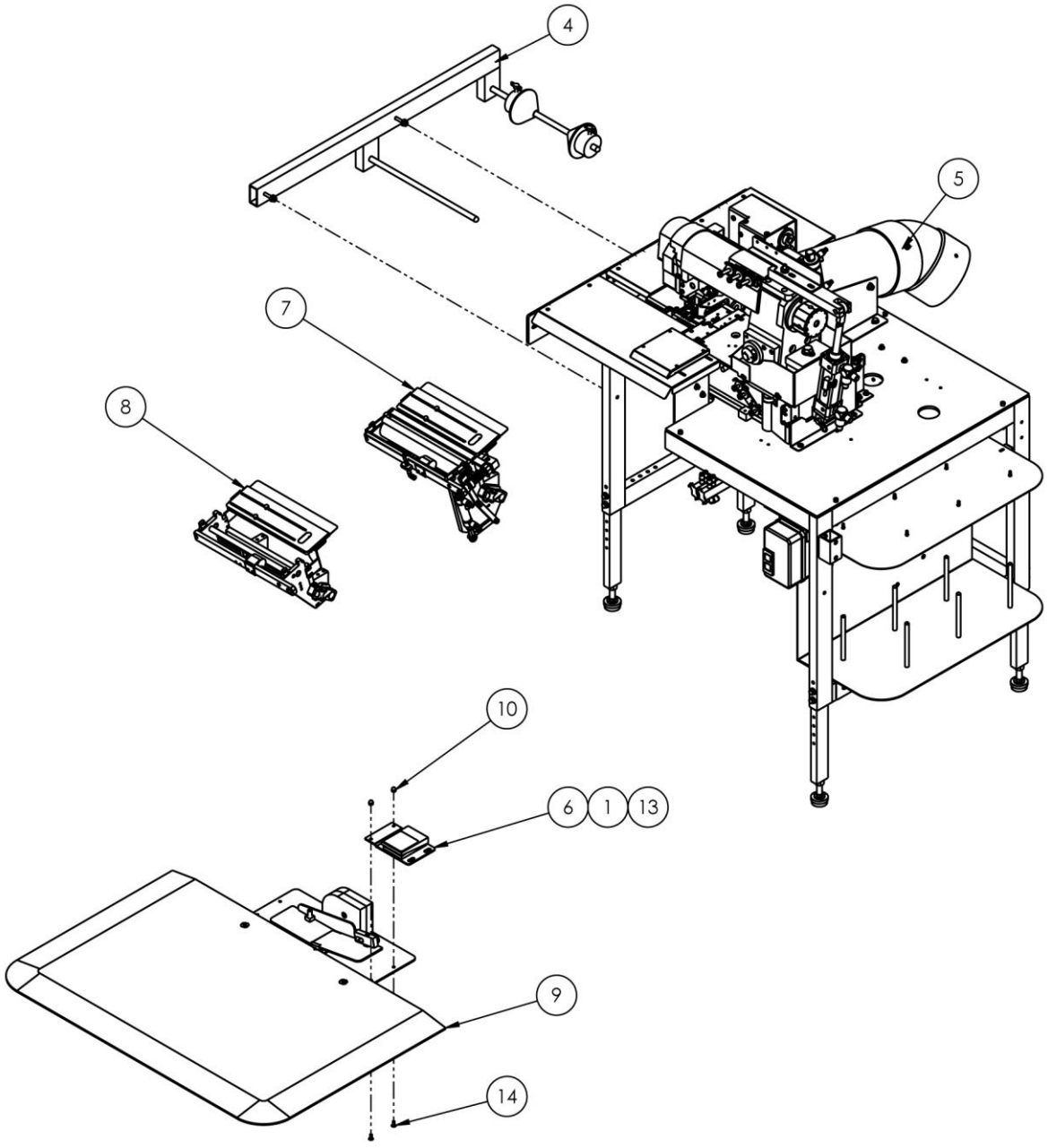


11317SAS48C Main Assembly

AAC Drawing Number 9000572 Rev0

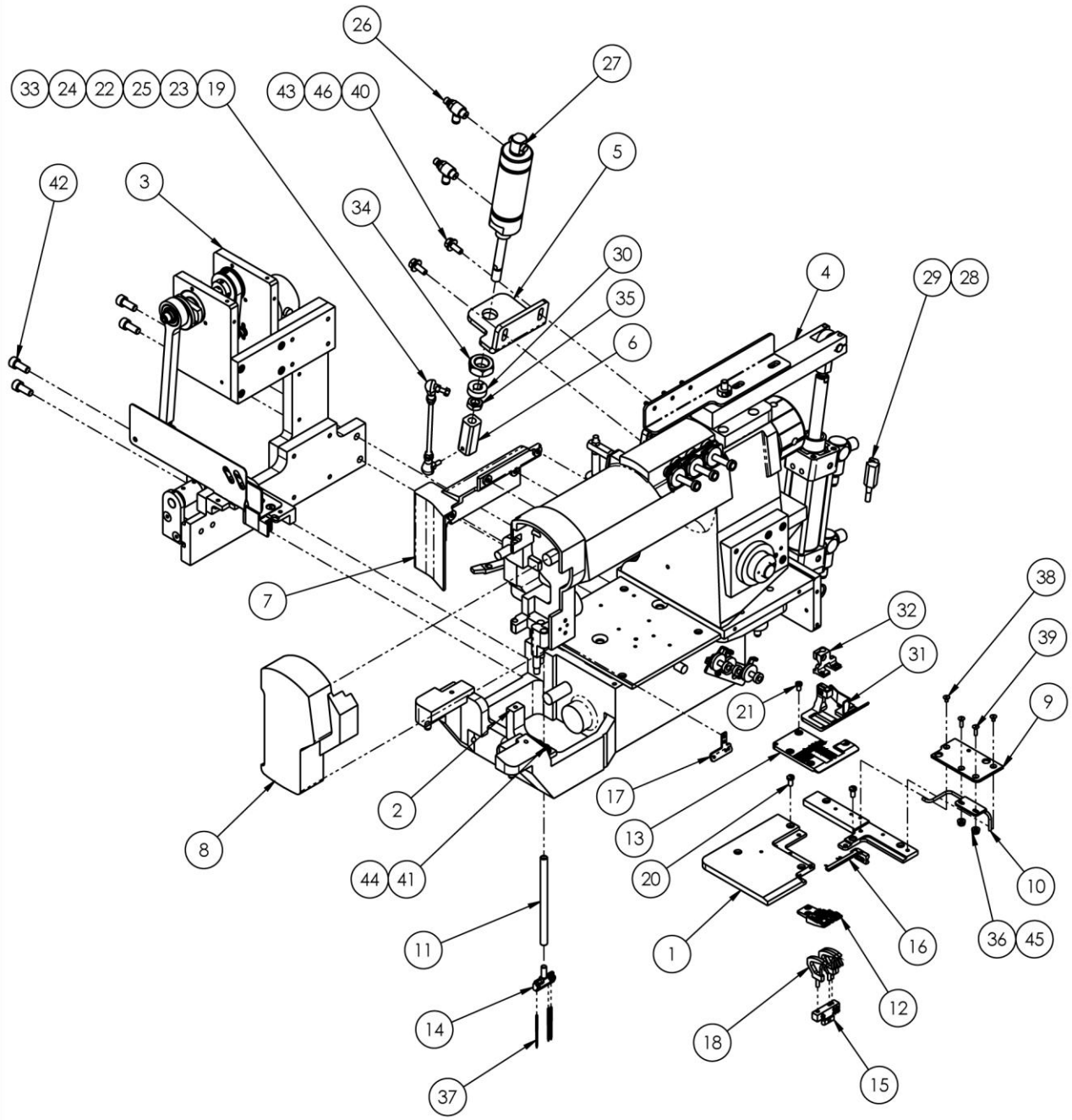
NO.	QTY	PART #	DESCRIPTION	
1	1	1278-6161	FOOT SWITCH MODIFICATION	
2	A/R*	1317-PD	PNEUMATIC DIAGRAM	Page 59
3	A/R*	1317-WD	WIRING DIAGRAM	Page 60
4	1	1317240	FLANGE ROLL HOLDER	Page 42
5	1	1317326	CONSOLE, FLANGER	Page 54
6	1	1317379	PLATE, MOUNT, FOOT PEDAL	
7	A/R*	1317400	FLANGE GUIDE, CUT/INSERT	Page 52
8	A/R*	1317410	FLANGE GUIDE ASSY.	Page 58
9	1	1337-1005A	TREADLE ASSY, SITDOWN	
10	2	NNH1/4-20	1/4-20 HEX NUT	
11	2	NNK1/4-20	KEP NUT, 1/4-20	
12	4	SSFC01048	1/4-20 X 3/4 FLAT ALLEN	
13	2	SSFC80024	#6-32 X 3/8 FLAT ALLEN	
14	2	SSHC01048	1/4-20 X 3/4 HEX HEAD	
15	2	SSHC01160	1/4-20 X 2-1/2 HEX HEAD	
16	8	WWFS1/4	WASHER FLAT, 1/4	
17	2	WWL1/4	1/4 LW	



11317SAS48CA Main Assembly

AAC Drawing Number 9000571 Rev0

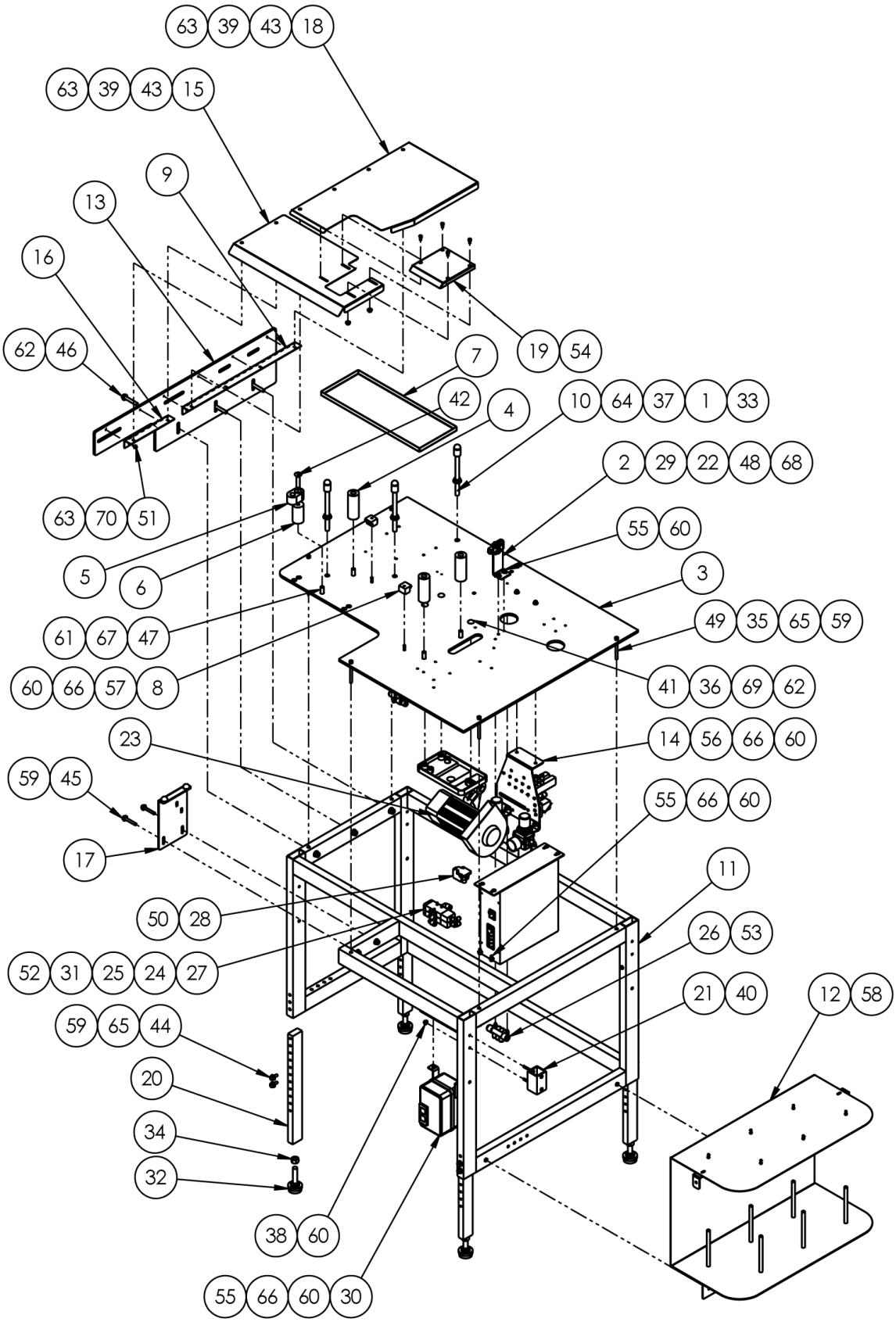
NO.	QTY	PART #	DESCRIPTION	
1	1	1278-6161	FOOT SWITCH MODIFICATION	
2	A/R*	1317-PD	PNEUMATIC DIAGRAM	Page 59
3	A/R*	1317-WD	WIRING DIAGRAM	Page 60
4	1	1317240	FLANGE ROLL HOLDER	Page 42
5	1	1317326	CONSOLE, FLANGER	Page 54
6	1	1317379	PLATE, MOUNT, FOOT PEDAL	
7	A/R*	1317400	FLANGE GUIDE, CUT/INSERT	Page 52
8	A/R*	1317410	FLANGE GUIDE ASSY.	Page 58
9	1	4059-FP301B	FOOT PEDAL ASSEMBLY,EFKA	
10	2	NNC10-32	NUT,CAP,10-32	
11	2	NNH1/4-20	1/4-20 HEX NUT	
12	4	SSFC01048	1/4-20 X 3/4 FLAT ALLEN	
13	2	SSFC80024	#6-32 X 3/8 FLAT ALLEN	
14	2	SSFC98032	#10-32 X 1/2 FLAT ALLEN	
15	2	SSHC01160	1/4-20 X 2-1/2 HEX HEAD	
16	4	WWFS1/4	WASHER FLAT, 1/4	
17	2	WWL1/4	1/4 LW	



1317125 Sew Head Assembly

AAC Drawing Number 1317125 Rev3

NO.	QTY	PART #	DESCRIPTION	
1	1	1317116	BED PLATE MOD.	
2	1	1317176	SUPPORT, CLOTH PLATE	
3	1	1317250	KNIFE ASSEMBLY	Page 46
4	1	1317270	HEAD SUB-ASSEMBLY	Page 48
5	1	1317306	BRACKET, CYLINDER	
6	1	1317307	CYLINDER END, FOOT LIFT	
7	1	1317309	BACK COVER, MOD.	
8	1	1317312	COVER,END	
9	1	1317323	PLATE, FILLER	
10	1	1317417	CUTTER AIR JET	
11	1	1830-11	NEEDLE BAR	
12	1	1830N32S48	FEED DOG 13/16X3/16	
13	1	1830N33S48	PLATE,THROAT,13/16X3/16	
14	1	1830N34S48	NEEDLE CHUCK,3/16 X 3/8 X	
15	1	1830N35S48	LOOPER HOLDER, 13/16X3/16	
16	1	1830N36S48	SPREADER BAR,3/16X3/16	
17	1	1830N38S48	GUIDE, NEEDLE THREAD	
18	2	281208	LOOPER,300U SINGER	
19	1	412373	JOINT,CONNECTION,RIGHT	
20	2	414508	SCREW,BED PLT	
21	1	414518	SCREW,THRT PLT FRNT	
22	1	414774	M5X0.8 HEX NUT -L	
23	1	541166-001	M5X0.8 HEX NUT -R	
24	1	559067	JOINT,CONNECTION,LEFT	
25	1	559068	FOOT LIFT ROD	
26	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"	
27	1	AAC5DP-2	AIR CYLINDER, SMC	
28	1	AAEDF59L	SWITCH,SOLID STATE,NPN	
29	1	AAENB1-150	MOUNT,SWITCH,TIE ROD CYL	
30	1	CCSCL7F	CLAMP COLLAR- 7/16	
31	1	M1S48-001A	FOOT, HOLDING	
32	1	M1S48-001B	FOOT, WALKING	
33	1	NNHM5X0.8	M5 X 0.8 HEX NUT	
34	1	NNJ3/4-16	3/4-16 HEX JAM NUT	
35	1	NNJ7/16-20	7/16-20 HEX JAM NUT	
36	2	NNK6-32	KEP NUT, 6-32	
37	3	SN62X8524	NEEDLE,SIZE 180/24	
38	2	SSFC80016	#6-32 X 1/4 FLAT ALLEN	
39	2	SSFC80032	#6-32 X 1/2 FLAT ALLEN	
40	2	SSHC01048	1/4-20 X 3/4 HEX HEAD	
41	2	SSM350267	SCREW,HEX SLOTTED	
42	4	SSSCM8X20	M8-1.25 X 20 SOC CAP	
43	2	WWFS1/4	WASHER FLAT, 1/4	
44	2	WWFS10	WASHER, FLAT #10	
45	2	WWFS6	WASHER, FLAT, #6	
46	2	WWL1/4	1/4 LW	



1317135 Stand Assembly

AAC Drawing Number 1317135 Rev1

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	3	11200B	BUMPER 7/16-20	36	6	NNH5/16-18	5/16-18 HEX NUT
2	1	1278-6689B	BRACKET, EYE MOUNT	37	6	NNJ7/16-20	7/16-20 HEX JAM NUT
3	1	1317079	TOP, TABLE	38	6	NNK10-32	KEP NUT, 10-32
4	3	1317112	STAND OFF, LONG	39	6	NNK6-32	KEP NUT, 6-32
5	1	1317113	STAND OFF EXTENSION	40	2	SSBC98096	#10-32 X 1-1/2 BUT HEAD
6	1	1317114	STAND OFF, SHORT	41	3	SSBK10096	BOLT, CARRAGE, 5/16X1.5
7	1	1317160	TRAY,OIL	42	1	SSFC25112	3/8-16 X 1-3/4 FLAT ALLEN
8	2	1317161	BLOCK,CLAMP	43	6	SSFC80032	#6-32 X 1/2 FLAT ALLEN
9	1	1317206	HINGE, CLOTH PLATE	44	8	SSHC01048	1/4-20 X 3/4 HEX HEAD
10	3	1317207	ROD,THREADED,7/16-20 X 6	45	2	SSHC01112	1/4-20 X 1-3/4 HEX HEAD
11	1	1317208	FRAME,MAIN	46	3	SSHC10128	5/16-18 X 2 HEX HEAD
12	1	1317230	THREAD STAND ASSY	47	4	SSHC25080	3/8-16 X 1-1/4 HEX HEAD
13	1	1317234	PLATE, CONSOLE MOUNT	48	2	SSPS70048	#4-40 X 3/4 PAN HD SLOT
14	1	1317238	PNEUMATIC PANEL	49	6	SSSC01176	1/4-20 X 2-3/4 SOC CAP
15	1	1317241	PLATE, FRONT CLOTH	50	2	SSSC70024	#4-40 X 3/8 SOC CAP
16	1	1317242	HINGE, CLOTH PLATE	51	6	SSSC80024	#6-32 X 3/8 SOC CAP
17	1	1317243	SUPPORT, CLOTH PLATE	52	2	SSSC80112	#6-32 X 1-3/4 SOC CAP
18	1	1317351	PLATE, REAR CLOTH	53	2	SSSC90064	#8-32 X 1 SOC CAP
19	1	1317355	COVER, WASTE BLOWER	54	4	SSSC98024	#10-32 X 3/8 SOC CAP
20	4	132556-273	LEG, 3/4 X 1-1/2 X 15 LG	55	8	SSSC98032	#10-32 X 1/2 SOC CAP
21	1	13453385	HOLDER, SCISSOR	56	2	SSSC98040	#10-32 X 5/8 SOC CAP
22	1	1975-412A	PLATE,NUT,4-40,.95CTC	57	2	SSSC98064	#10-32 X 1 SOC CAP
23	1	4059-DC50AB	MOTOR,DC W/ CNTRL'R	58	4	SSZS93032	SCREW, SHT.METAL 10 ZIP
24	4	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8	59	18	WWFS1/4	WASHER FLAT, 1/4
25	2	AAQME-5-8	QUICK MALE ELBOW	60	18	WWFS10	WASHER, FLAT #10
26	1	AAQMF-144	6-STATION AIR MANIFOLD	61	4	WWFS3/8	WASHER, FLAT, 3/8
27	2	AAV125B	PILOT VALVE	62	9	WWFS5/16	WASHER, FLAT, 5/16
28	1	AAVF51FM1B	AIR/ELEC PRESSURE SW	63	12	WWFS6	WASHER, FLAT, #6
29	1	FFSM312LVQ	EYE,ELECTRIC,10-30VDC	64	6	WWFS7/16	7/16 FW
30	1	K-CB600	MOTOR STARTER,ELEC	65	16	WWL1/4	1/4 LW
31	2	MM4554K11	PLUG, 1/8" PIPE	66	12	WWL10	#10 LW
32	4	MMFB4444	FOOT, RUBBER	67	4	WWL3/8	3/8 LW
33	5	MMSJ5017	BUMPER,3M SJ5017	68	2	WWL4	#4 LW
34	4	NNH1/2-13	1/2-13 HEX NUT	69	6	WWL5/16	5/16 LW
35	8	NNH1/4-20	1/4-20 HEX NUT	70	8	WWL6	WASHER,LOCK,6

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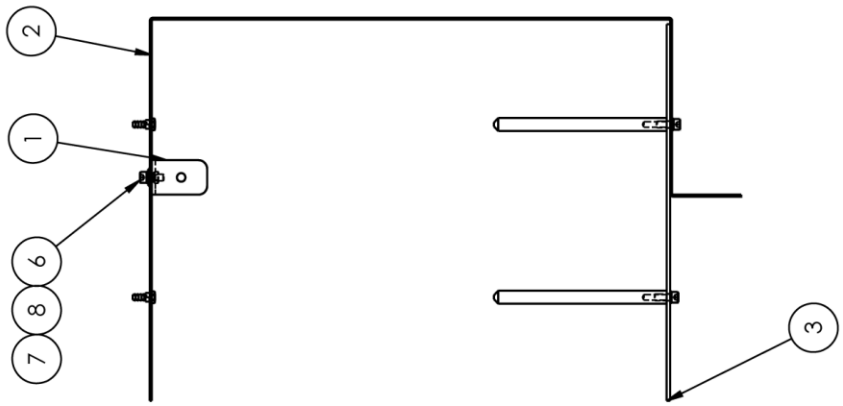
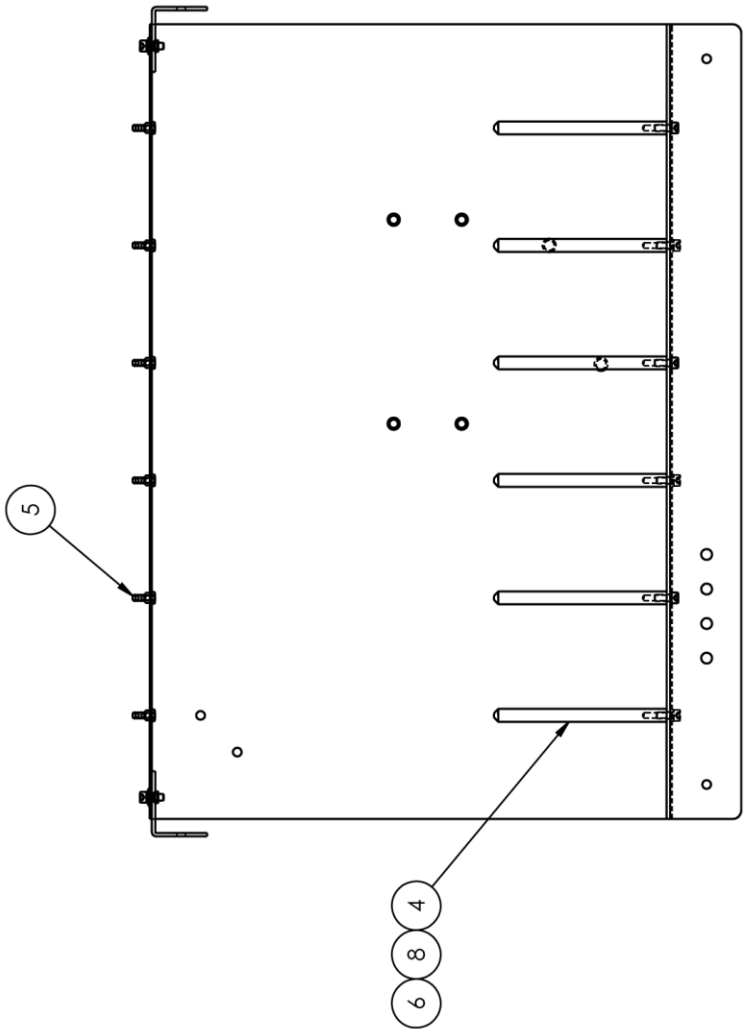
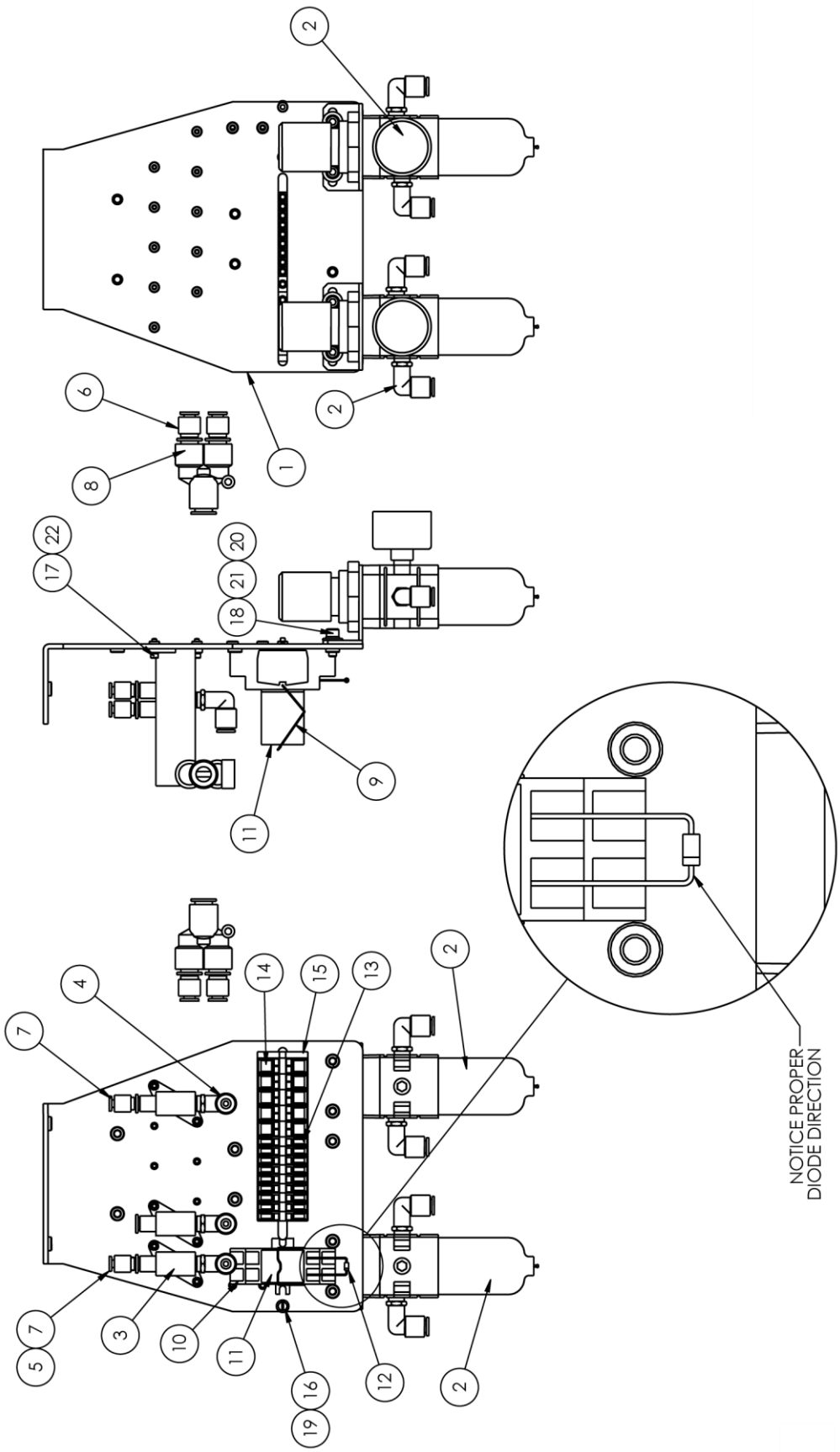




1317230 Thread Stand Assembly

AAC Drawing Number 1317230 Rev1

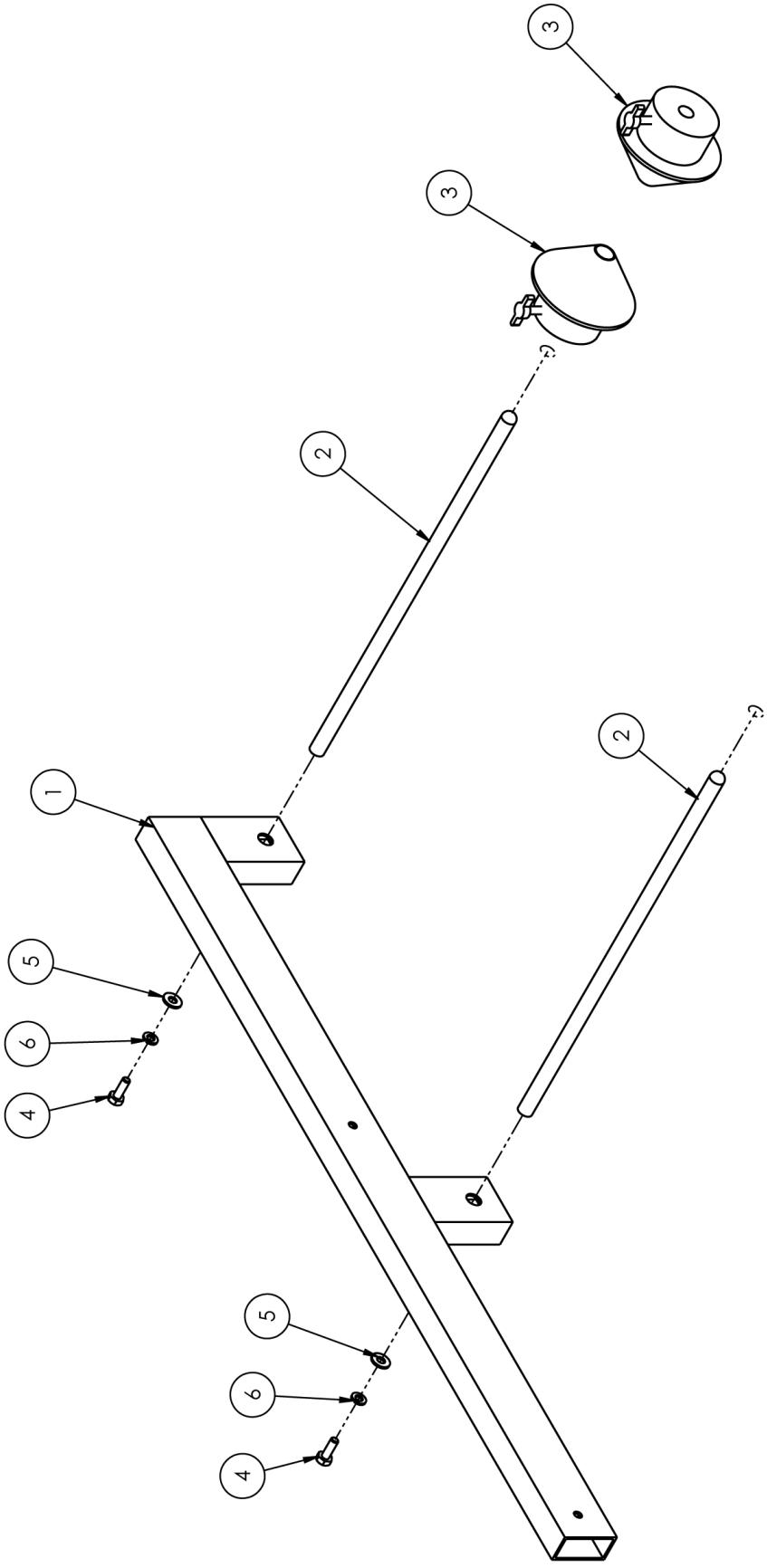
NO.	QTY	PART #	DESCRIPTION
1	2	1317192	THREAD STAND SUPPORT BRKT
2	1	1317228	THREAD GUIDE PLATE
3	1	1317229	THREAD SPOOL MOUNT
4	6	1337-4209	ROD, THREAD HOLDER
5	6	AAF11752-3	10-32 TO 1/8 BRASS
6	8	SSSC98032	#10-32 X 1/2 SOC CAP
7	2	WWFS10	WASHER, FLAT #10
8	8	WWL10	#10 LW



1317238 Pneumatic Panel Assembly

AAC Drawing Number 1317238 Rev1

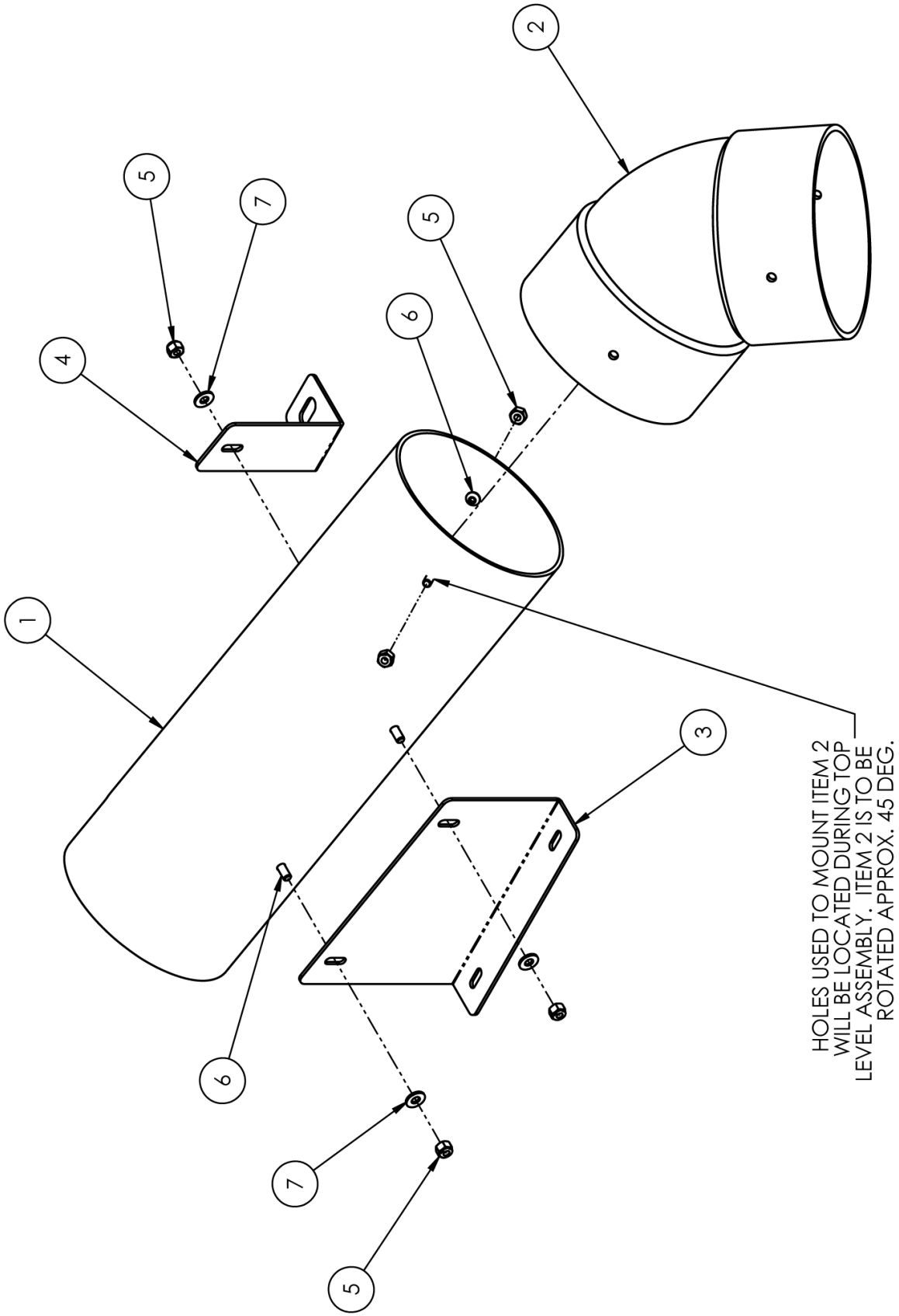
NO.	QTY	PART #	DESCRIPTION
1	1	1338-024	PANEL, PNEUMATIC
2	2	AA198-5102	REGULATOR W/GAUGE & NUT
3	3	AAEVQZ2121	VALVE, BODY PORTED
4	3	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8
5	1	AAQPP-07	QUICK PLUG 1/4
6	2	AAQPR-3-4	QUICK REDUCER 3/8-1/4
7	3	AAQPR-5-4	QUICK PLUG-IN REDUCER
8	1	AAQUY-3-3	QUICK UNION Y 3/8 X 3/8
9	1	EE20C297	RETAINING SPRING
10	1	EE27E487	SOCKET,SCREW TERMINAL
11	1	EEK10P11D1	RELAY,24VDC,DPD
12	1	FF1N4937	DIODE,FAST 200NS,1A
13	9	FF264-311	TERMBLK,WAGO,TOP,SINGLE,GRY
14	5	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
15	1	FF264-371	TERMBLK,WAGO,TOP,END
16	2	SSPS70032	#4-40 X 1/2 PAN HD SLOT
17	6	SSSC70024	#4-40 X 3/8 SOC CAP
18	4	SSSC98032	#10-32 X 1/2 SOC CAP
19	2	WWF4	WASHER, FLAT #4
20	4	WWFS10	WASHER, FLAT #10
21	4	WWL10	#10 LW
22	6	WWL4	#4 LW



1317240 Flange Roll Holder Assembly

AAC Drawing Number 1317240 Rev0

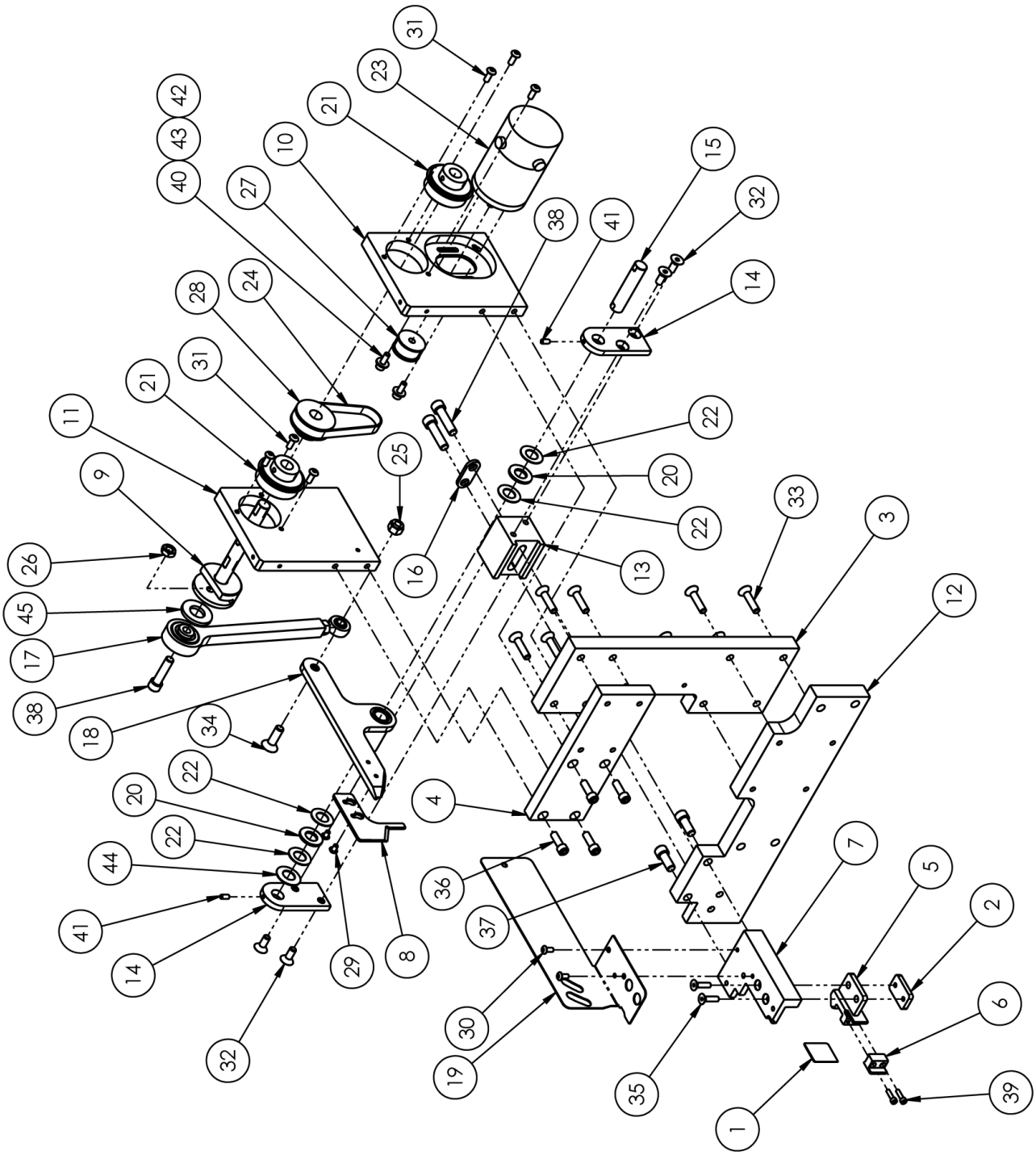
NO.	QTY	PART #	DESCRIPTION
1	1	1317362	FRAME, FLANGE HOLDER
2	2	1335-816	ROD,SS, 1/2 X 15.0 L
3	2	787-4A-032	CONE BEARING ASSY.
4	2	SSHC01048	1/4-20 X 3/4 HEX HEAD
5	2	WWFS1/4	WASHER FLAT, 1/4
6	2	WWL1/4	1/4 LW



1317324 Waste Tube Assembly

AAC Drawing Number 1317324 Rev0

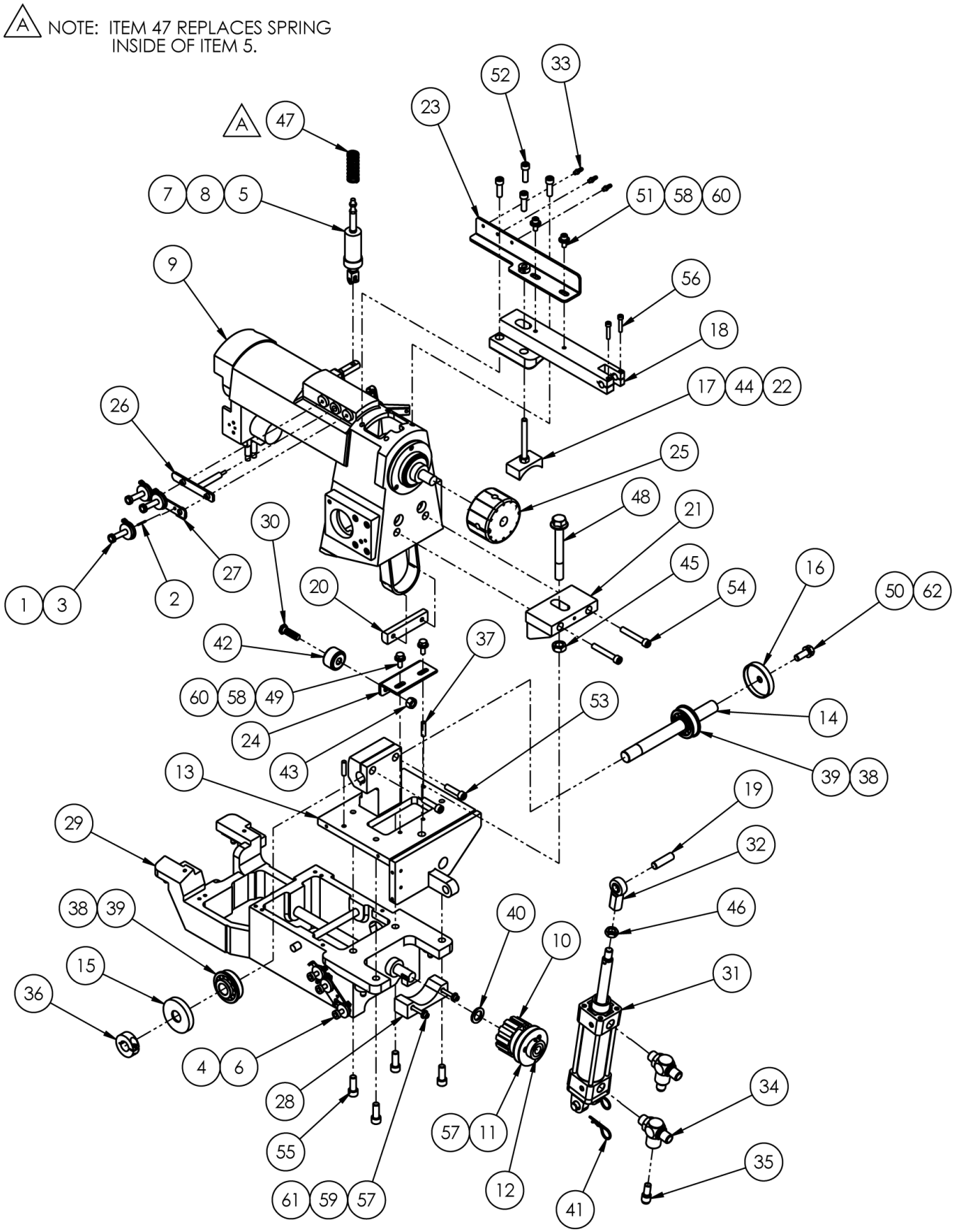
NO.	QTY	PART #	DESCRIPTION
1	1	1317319	TUBE, WASTE
2	1	1317320	ELOBOW, WASTE, 6" MOD
3	1	1317407	MOUNT, WASTE TUBE
4	1	1317418	MOUNT, WASTE TUBE
5	5	NNE1/4-20	NUT,ELASTIC LOCK,1/4-20
6	5	SSBC01040	1/4-20 X 5/8 BUT HEAD
7	3	WWFS1/4	WASHER FLAT, 1/4



1317250 Knife Assembly

AAC Drawing Number 131250 Rev3

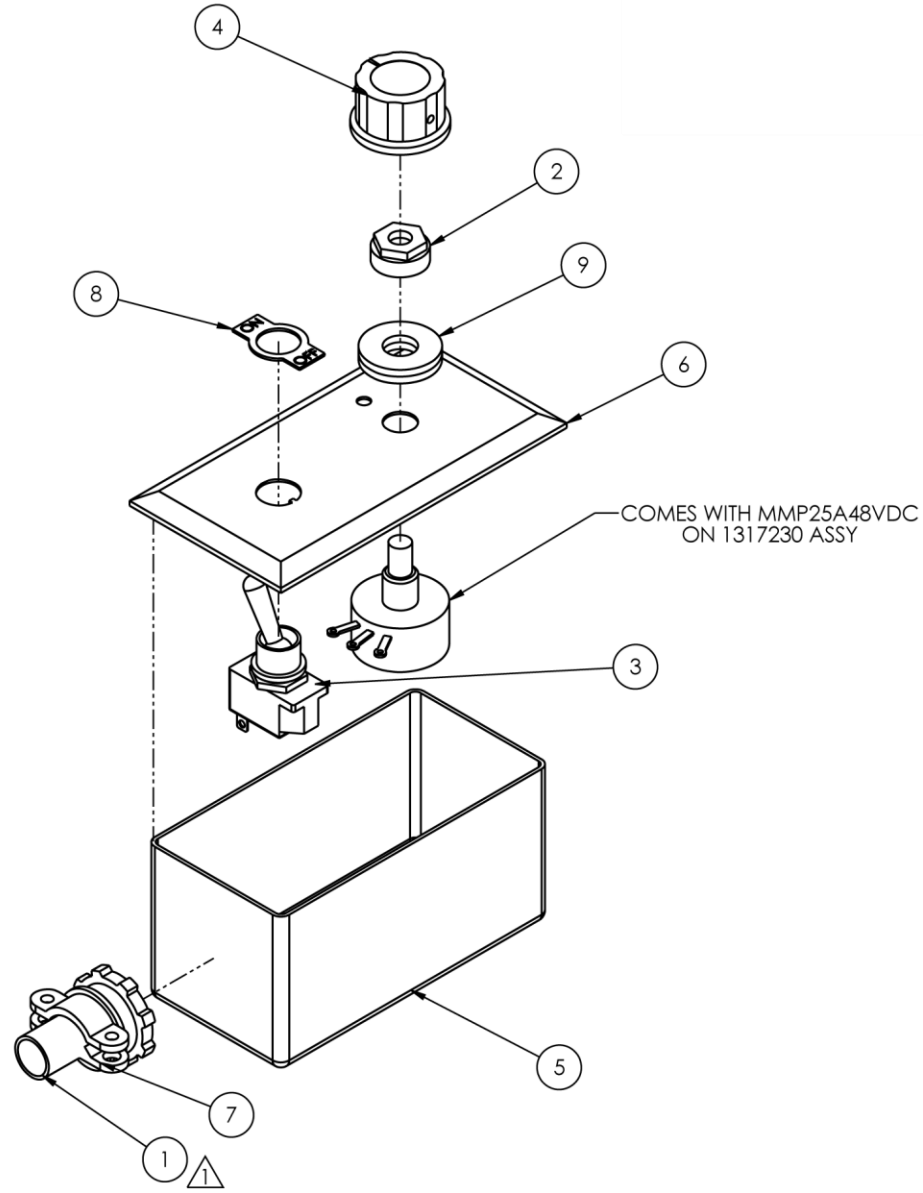
NO.	QTY	PART #	DESCRIPTION
1	1	1317247	CUTTER, LOWER
2	1	1317249	PLATE, NUT
3	1	1317255	PLATE, VERTICAL SUPPORT
4	1	1317317	PLATE, UPPER SUPPORT
5	1	1317369	BLOCK, LOWER CUTTER
6	1	1317370	CLAMP, LOWER CUTTER
7	1	1317372	MOUNT, LOWER CUTTER
8	1	1317402	BLADE, CUTTER
9	1	1317411	ECCENTRIC, CUTTER DRIVE
10	1	1317420	PLATE, MOTOR MOUNT
11	1	1317421	PLATE, DRIVE SUPPORT
12	1	1317423	PLATE, MOUNT, CUTTER ASSY
13	1	1317425	BLOCK, PIVOT MOUNT
14	2	1317426	PLATE, PIVOT SIDE
15	1	1317427	SHAFT, KNIFE PIVOT
16	1	1317428	PLATE, WASHER, 7/32 2PL
17	1	1317430	KNIFE DRIVE LINK ASSY.
18	1	1317431	DRIVER, KNIFE
19	1	1317439	DEFLECTOR, WASTE TRIM
20	2	BBNTA815	BEARING,THRUST,1/2BORE
21	2	BBS8701-88	BEARING,BALL,.50IDX1.75OD
22	4	BBTRA815	WASHER,THRUST,STEEL 1/2
23	1	EES23100H36V	MOTOR,SERVO,36V,5000RPM
24	1	GG90XL037	BELT,GEAR,1/5P,3/8W,9"L
25	1	NNE5/16-18	NUT,ELASTIC LOCK,5/16-18
26	1	NNJ5/16-24	5/16-24 HEX JAM NUT
27	1	PP16XL037M	PULLEY,GEAR,1/5P,16T,1/4B
28	1	PP24XLB37M	PULLEY, GEAR,1/5 PITCH
29	2	SSBC90016	#8-32 X 1/4 BUT HEAD
30	2	SSBC90024	#8-32 X 3/8 BUT HEAD
31	6	SSBC98032	#10-32 X 1/2 BUT HEAD
32	4	SSFC01040	1/4-20 X 5/8 FLAT ALLEN
33	8	SSFC01072	1/4-20 X 1-1/8 FLAT ALLEN
34	1	SSFC10064S	5/16-18 X 1" FLAT ALLEN, SST
35	2	SSFC98048	#10-32 X 3/4 FLAT ALLEN
36	4	SSSC01048	1/4-20 X 3/4 SOC CAP
37	2	SSSC20048	5/16-24 X 3/4 SOC CAP
38	3	SSSC20080	5/16-24 X 1-1/4 SOC CAP
39	2	SSSC85032	#6-40 X 1/2 SOC CAP
40	2	SSSCM5X14	SCREW,SOC CAP,M5-0.8 X 14
41	2	SSSS90024	#8-32 X 3/8 KNURL PT
42	2	WWFS10	WASHER, FLAT #10
43	2	WWL10	#10 LW
44	1	WWS9712K74	WASHER, SPRING
45	1	WWU5/8	WASHER,URETHANE



1317270 Sew Head Sub-Assembly

AAC Drawing Number 1317270 Rev1

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	54279	NEEDLE THRD TENSION GUIDE	32	1	1317438	ROD END, MODIFIED
2	2	226206	NDL TENSION RELEASE PIN	33	3	AAF11752-3	10-32 TO 1/8 BRASS
3	2	267971	NDL THREAD TENSION	34	2	AAFQP6S	FLOW CNTRL,3/8NPT,3/8TUBE
4	2	268333	LOOPER THD TENSION GUIDE	35	2	AAQPR-3-4	QUICK REDUCER 3/8-1/4
5	1	415106	PRESSER BAR SPRG HSG	36	1	CCCL12FT	CLAMP COLLAR- 3/4-16 THD
6	2	415294	LOOPER THREAD TENSION	37	2	IIS016X064HD	SPIRAL PIN,1/4 X 1
7	3	541198	PRESSER BAR HSG. NUT	38	2	MM09074	BEARING,CONE,TAPERED
8	1	559077	PRSSR BAR SPR HSG COLLAR	39	2	MM09195AB	BEARING,CUP,TAPERED
9	1	1317115	SINGER ARM 300U194A MOD.	40	1	MM98126A791	WASHER, SHIM .625/.636 ID
10	1	1317124	DRIVE PULLEY MOD.	41	2	MM98335A064	SPRING CLIP
11	1	1317155	PULLEY,DRIVE	42	1	MMCYR114S	FOLLOWER, CAM
12	1	1317156	COLLAR	43	1	NNH3/8-16	3/8-16 HEX NUT
13	1	1317275	BRACKET, PIVOT, WELDMENT	44	1	NNH5/16-18	5/16-18 HEX NUT
14	1	1317276	SHAFT, PIVOT	45	1	NNJ1/2-20	1/2-20 HEX JAM NUT
15	1	1317277	RETAINER, FRONT BEARING	46	1	NNJ7/16-20	7/16-20 HEX JAM NUT
16	1	1317278	RETAINER, REAR BEARING	47	1	RRLC085J-6	SPRING, COMP. .720OD 2.0
17	1	1317280	RETAINER, BELT, UPPER	48	1	SSFH46256	SCREW, FLANGE HEX CAP
18	1	1317287	TILT BRACKET WELDMENT	49	2	SSHC01048	1/4-20 X 3/4 HEX HEAD
19	1	1317288	PIN, PIVOT	50	1	SSHC25064	3/8-16 X 1 HEX HEAD
20	1	1317290	PLATE,NUT,5/16-18@2.5CTC	51	2	SSSC01040	1/4-20 X 5/8 SOC CAP
21	1	1317292	STOP WELDMENT	52	4	SSSC10064	5/16-18 X 1 SOC CAP
22	1	1317293	SUPPORT, BELT RETAINER	53	2	SSSC10080	5/16-18 X 1-1/4 SOC CAP
23	1	1317294	THD/BELT RET. SUPPORT	54	2	SSSC10128	5/16-18 X 2 SOC CAP
24	1	1317295	BRACKET, BELT TENSIONER	55	4	SSSC25064	3/8-16 X 1 SOC CAP
25	1	1317296	HANDWHEEL	56	2	SSSC98064	#10-32 X 1 SOC CAP
26	1	1317297	TENSION RELEASE PUSHER	57	5	SSSC98096	#10-32 X 1-1/2 SOC CAP
27	1	1317298	HOLDER, TENSION POST	58	4	WWFS1/4	WASHER FLAT, 1/4
28	1	1317304	BELT RETAINER, LOWER	59	2	WWFS10	WASHER, FLAT #10
29	1	1317332	MACHINE BASE, MODIFIED	60	4	WWL1/4	1/4 LW
30	1	1317366	3/8-16 X 1-1/4 HEX HEAD	61	2	WWL10	#10 LW
31	1	1317397	AIR CYLINDER, 1.5BX3.0S	62	1	WWL3/8	3/8 LW



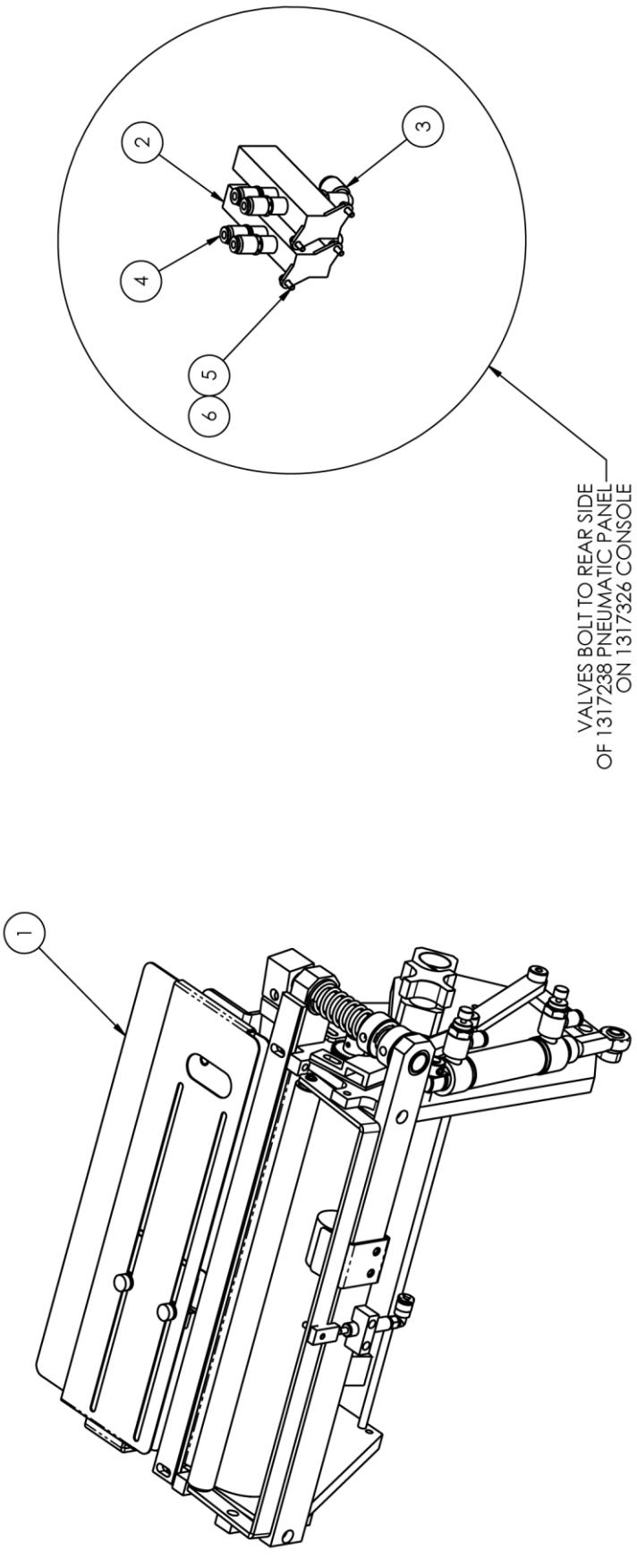
NOTES:

1. USED AS A SLEEVE. SPLIT DOWN THE SIDE OF AIRLINE AND WRAP AROUND WIRES THRU THE ROMEX CONNECTOR.

1317325 Motor Speed Control Box Assembly

AAC Drawing Number 1317325 Rev1

NO.	QTY	PART #	DESCRIPTION
1	1"	AATP3/8	3/8" OD POLYURETHANE
2	1	EESL110B	SHAFT LOCK,NYLON,1/4"
3	1	FF23F385	SWITCH,TOGGLE,SOL
4	1	FF274-416	KNOB,SPEED CONTROL
5	1	K-230	BOX,METAL, 2X4X2
6	1	K-231M1	COVER, 2X4, MOD
7	1	K-235	CONNECTOR,ROMEX,1/2"
8	1	W1061-1	PLATE,ON/OFF
9	2	WWF5/16	WASHER,FLAT,5/16



1317400 Flange Guide Cut/Insert Assembly

AAC Drawing Number 1317400 Rev0

NO.	QTY	PART #	DESCRIPTION
1	1	1317080	MATERIAL ADV. & CUTTER
2	2	AAEVQZ2121	VALVE, BODY PORTED
3	2	AAQME-4-8	ELBOW,QUICK MALE,1/4X1/8
4	4	AAQPR-5-4	QUICK PLUG-IN REDUCER
5	4	SSSC70024	#4-40 X 3/8 SOC CAP
6	4	WWL4	#4 LW

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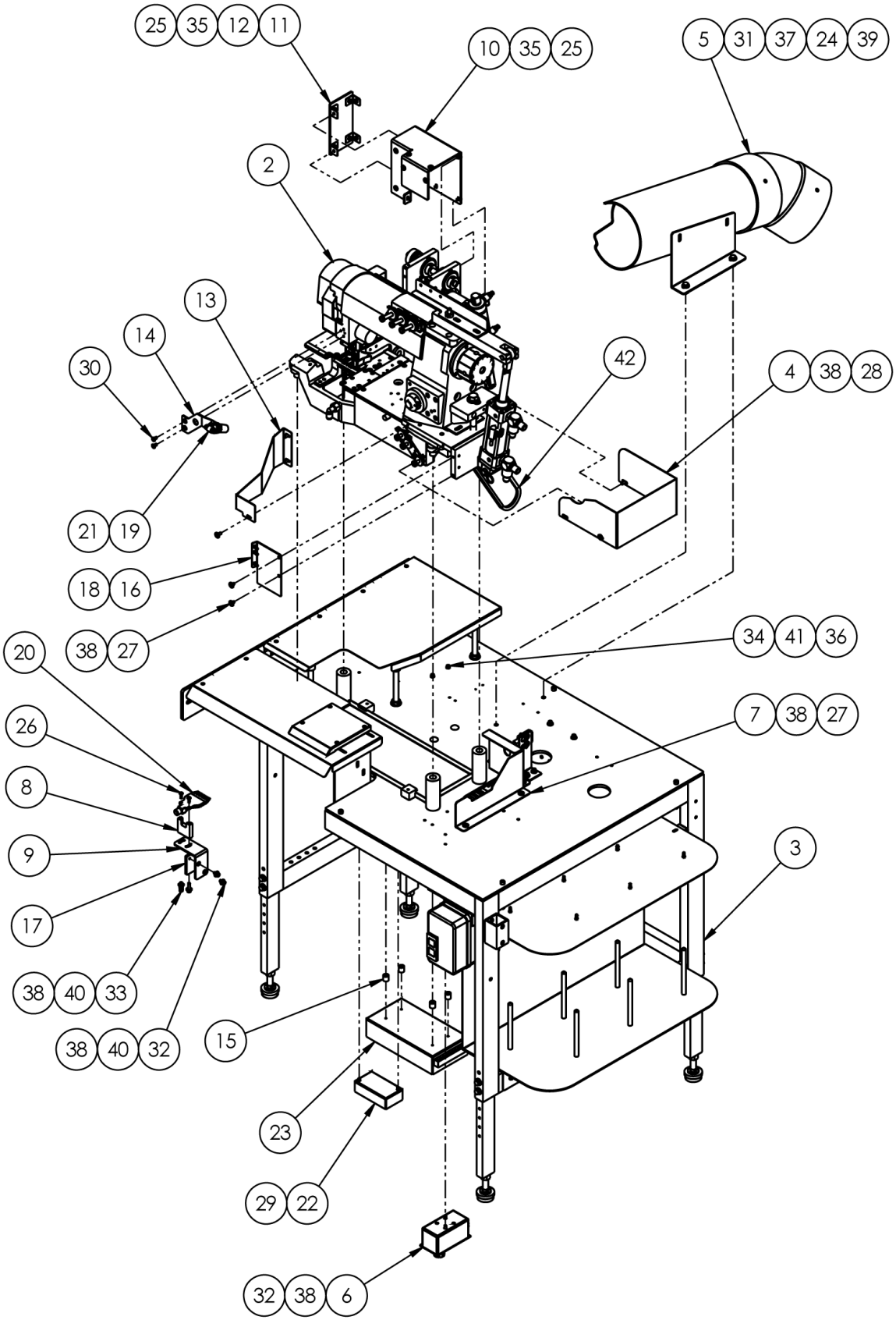
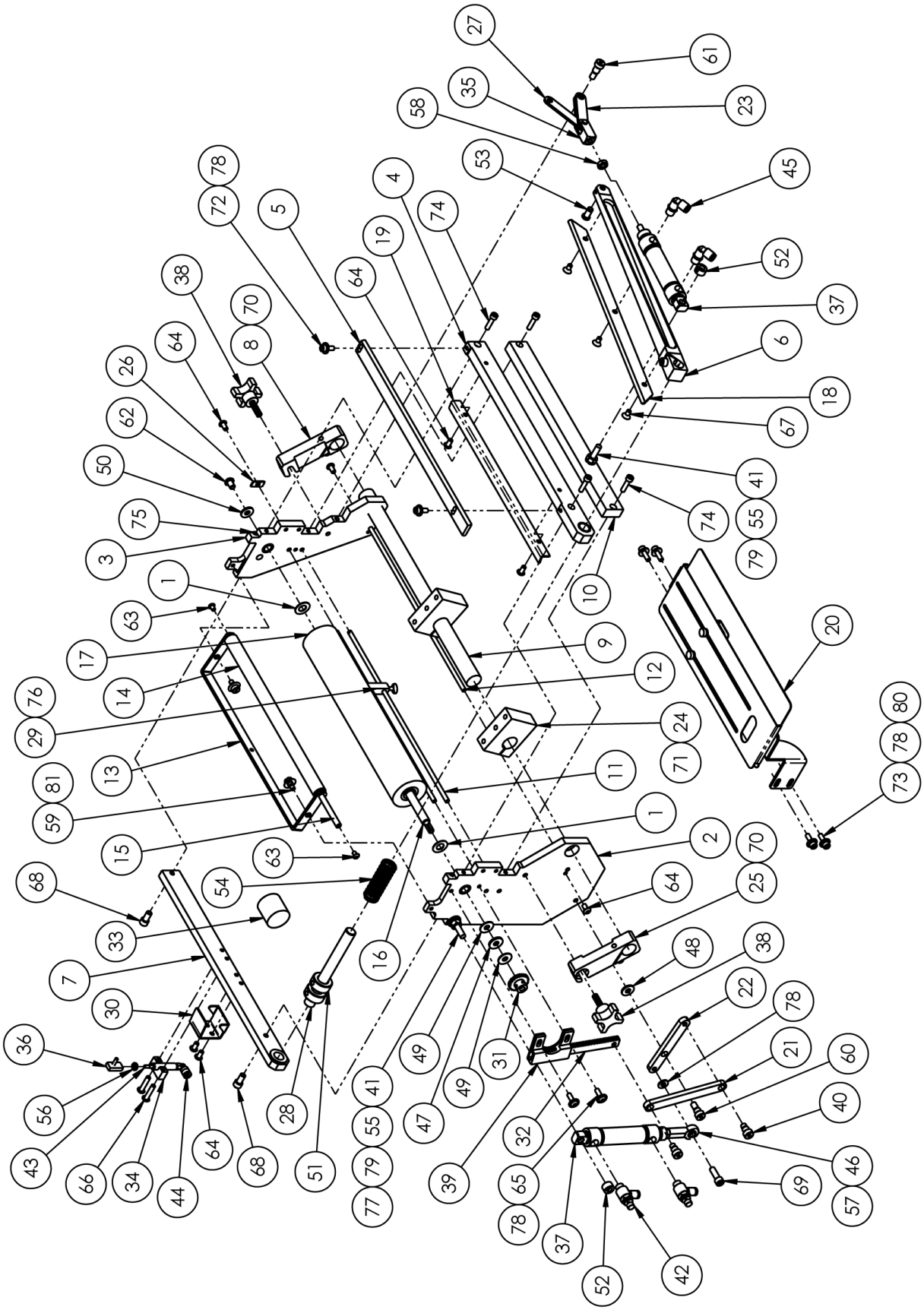


1317326 Console Assembly

AAC Drawing Number 1317326 Rev2

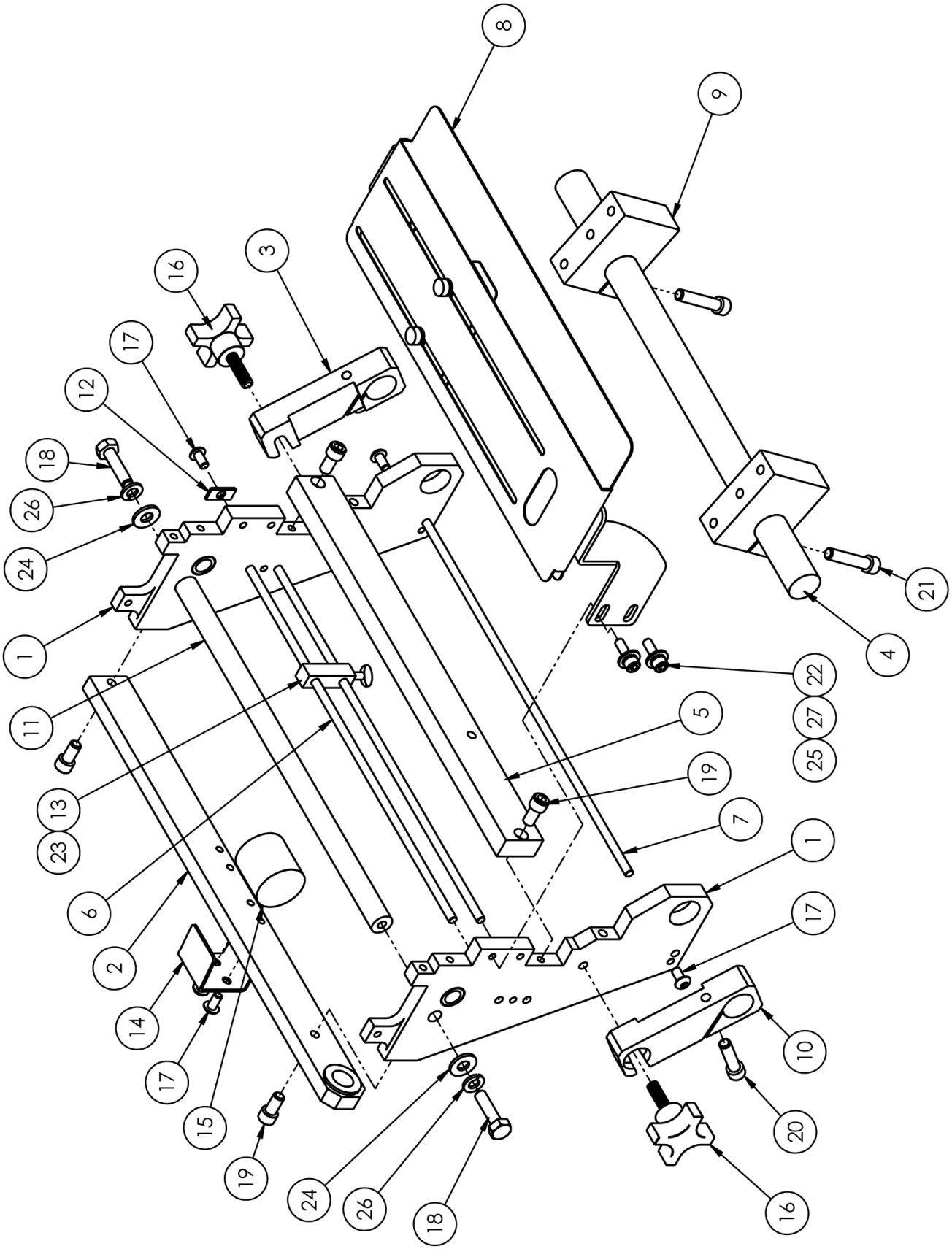
NO.	QTY	PART #	DESCRIPTION	
1	*1	1317-CAB	CABLE PACKAGE	
2	1	1317125	SEW HEAD ASSEMBLY	Page 34
3	1	1317135	STAND ASSEMBLY	Page 36
4	1	1317300	COVER, LOWER	
5	1	1317324	WASTE TUBE ASSEMBLY	Page 44
6	1	1317325	MOTOR SPEED CONTROL BOX	
7	1	1317333	GUARD, BELT	
8	1	1317353	MOUNT, WASTE BLOWER	
9	1	1317354	SUPPORT, BLOWER MOUNT	
10	1	1317433	COVER, KNIFE DRIVE	
11	1	1317434	COVER, END, KNIFE DRIVE	
12	4	1317435	BRACKET, CORNER	
13	1	1317436	DEFLECTOR, WASTE	
14	1	1317437	BRKT, AIR NOZZLE	
15	4	1317441	SPACER, POWER SUPPLY	
16	1	1317459	BRKT, LOOPER THREAD GUIDE	
17	1	1959-020	NUT PLATE, 10-32	
18	3	AAF11752-3	10-32 TO 1/8 BRASS	
19	2	AAQFE-4-4	QU. FEMALE EL 1/4X1/4NPT	
20	1	MM5329K21	AIR NOZZLE	
21	1	MM5329K62	AIR NOZZLE, PLASTIC, ROUN	
22	1	MMP25A48VDC	MOTOR SPEED CONTROL,48VDC	
23	1	MMPPSS320W48VDC	POWER SUPPLY,48VDC OUTPUT	
24	2	NNH1/4-20	1/4-20 HEX NUT	
25	17	SSBC90024	#8-32 X 3/8 BUT HEAD	
26	2	SSBC90032	#8-32 X 1/2 BUT HEAD	
27	6	SSBC98024	#10-32 X 3/8 BUT HEAD	
28	6	SSBC98032	#10-32 X 1/2 BUT HEAD	
29	2	SSFC98080	#10-32 X 1-1/4 FLAT ALLEN	
30	2	SSFCM5X10	M5-0.8X10 FLAT ALLEN	
31	2	SSHC01056	1/4-20 X 7/8 HEX HEAD	
32	4	SSSC98024	#10-32 X 3/8 SOC CAP	
33	2	SSSC98048	#10-32 X 3/4 SOC CAP	
34	4	SSSCM4X25	M4-0.7 X 25 SOC CAP	
35	17	WWF8	WASHER, FLAT #8	
36	4	WWFS1/4	WASHER FLAT, 1/4	
37	18	WWFS10	WASHER, FLAT #10	
38	2	WWL1/4	1/4 LW	
39	4	WWL10	#10 LW	
40	4	WWL8	#8 LW	
41	1	ZX3828	V BELT,3/8 X 28"	
42	4	WWFM4.3	WASHER, FLAT, M4	



1317080 Material Adv. & Cutter Assembly

AAC Drawing Number 1317080 Rev0

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	2	3517	WASHER,THRUST,BRONZE	42	2	AA198RA508	FLOW CONTROL,5/32 X 1/8"
2	1	1317081	PLATE, SIDE, LEFT	43	1	AACSM-6	CYLINDER,AIR
3	1	1317082	RIGHT SIDE PLATE ASSY.	44	1	AAQME-5-10	ELBOW, MALE,5/32X10-32
4	1	1317083	BRACES,TOP,BACK	45	2	AAQME-5-8	QUICK MALE ELBOW
5	1	1317084	KNIFE BKADE, FIXED	46	1	BBAW-4	BEARING,ROD END,FEMALE
6	1	1317085	BLADE HOLDER ARM	47	1	BBNTA411	BEARING,THRUST,.250B
7	1	1317086	BRACE,FRONT	48	1	BBTB410	BEARING,BRONZE,.250ID
8	1	1317087	CUTTER PIVOT LATCH, LEFT	49	2	BBTRA411	WASHER,THRUST,STEEL
9	1	1317088	ROD, CUTTER PIVOT	50	1	BBTT601	WASHER,THRUST,BRONZE
10	1	1317090	BRACE, CYL MNT, BACK	51	2	CC2X568	COLLAR,SET,1/2"
11	2	1317091	MATERIAL GUIDE ROD	52	2	CC2X735	COLLAR,LARGE,1/4"ID,
12	1	1317092	MATERIAL GUIDE ROD	53	1	MM92735A210	1/4"DX13/32 CLEVIS PIN W/
13	1	1317093	MATERIAL ROLLER ARM	54	1	MM9657K26	COMPRESSION SPRING 1.5"L
14	1	1317094	MATERIAL ROLLER	55	2	NNH1/4-20	1/4-20 HEX NUT
15	1	1317095	MATERIAL ROLLER ROD	56	1	NNH6-32	#6-32 HEX NUT
16	1	1317096	LARGE ROLLER ROD	57	1	NNJ1/4-20	1/4-20 HEX JAM NUT
17	1	1317097	LARGE ROLLER ASSY.	58	1	NNJ1/4-28	1/4-28 HEX JAM NUT
18	1	1317098	KNIFE BLADE, MOVING	59	2	SSAS016012	SHOULDER BOLT, 1/4 X 3/16
19	1	1317099	MATERIAL SLIDE	60	1	SSAS020016	SHOULDER BOLT 1/4 X 1/4L
20	1	1317100	MATERIAL CHUTE ASSY.	61	1	SSAS020024	SHOULDER BOLT 1/4 X 3/8L
21	1	1317102	LINKAGE,ROD	62	1	SSBC01024	1/4-20 X 3/8 BUT HEAD
22	1	1317103	LINKAGE,ROD	63	2	SSBC90016	#8-32 X 1/4 BUT HEAD
23	2	1317111	CUT ACTION PLATE	64	7	SSBC98024	#10-32 X 3/8 BUT HEAD
24	2	1317126	MOUNT, CUT & INSERT	65	2	SSBC98040	#10-32 X 5/8 BUT HEAD
25	1	1317146	CUTTER PIVOT LATCH RT.	66	2	SSBC98056	#10-32 X 7/8 BUT HEAD
26	1	1337066	MATERIAL GUIDE	67	3	SSFC95024	#10-24 X 3/8 FLAT ALLEN
27	1	1337067	CUT ACTION PLATE	68	2	SSSC01032	1/4-20 X 1/2 SOC CAP
28	1	1337073	PIVOT PIN	69	2	SSSC01048	1/4-20 X 3/4 SOC CAP
29	1	1337075	ROD SEPERATOR	70	2	SSSC01064	1/4-20 X 1 SOC CAP
30	1	1337077	PINCH ROLLER CONTAINER	71	2	SSSC01080	1/4-20 X 1-1/4 SOC CAP
31	1	1337082	GEAR,SPUR 48P,42T,20PA	72	2	SSSC98032	#10-32 X 1/2 SOC CAP
32	1	1337083	GEAR, RACK, MOD	73	4	SSSC98040	#10-32 X 5/8 SOC CAP
33	1	1337085	DELRIN FLOAT WHEEL	74	4	SSSC98048	#10-32 X 3/4 SOC CAP
34	1	1337102	CYLINDER CLAMP	75	2	SSSP98032	#10-32 X 1/2"L SET SCREW,
35	1	1337108	CLEVIS,AIR CYLINDER	76	1	SST090032	THUMB SCREW
36	1	1337109	CYLINDER LINK	77	1	WWFS1/4	WASHER FLAT, 1/4
37	2	1337113	CYLINDER, 3/4"X 1" STROKE	78	9	WWFS10	WASHER, FLAT #10
38	2	1337122	KNOB, 1/4-20 X 1.125L	79	2	WWL1/4	1/4 LW
39	1	1337128	RACK GEAR SLIDE	80	4	WWL10	#10 LW
40	2	1337131	SHOULDER BOLT 5/16 X 1/4L	81	2	WWS307-1	WASHER,SPRING,BELVEL
41	2	1337132	CYL PIVOT PIN.				

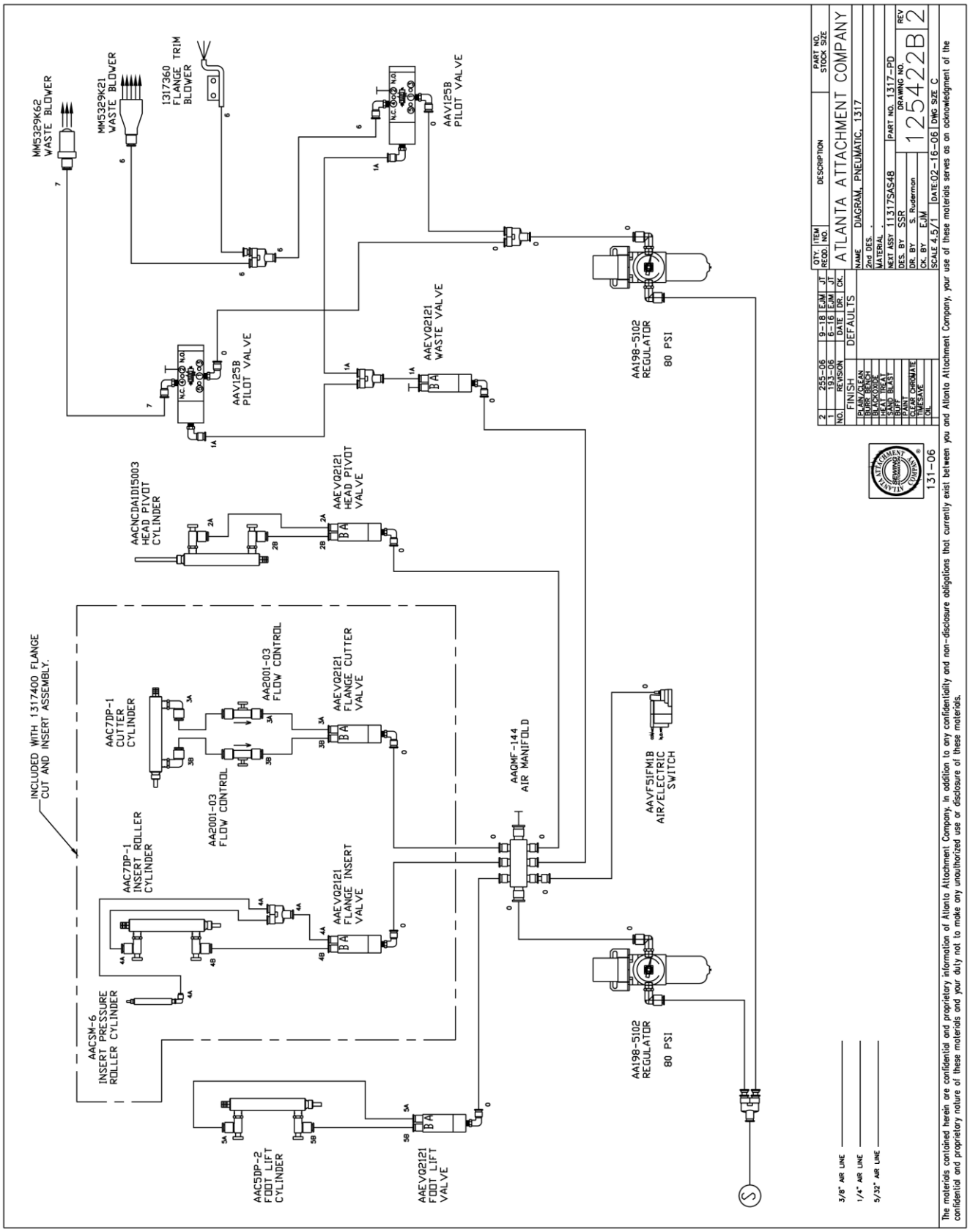


1317410 Flange Guide Assembly

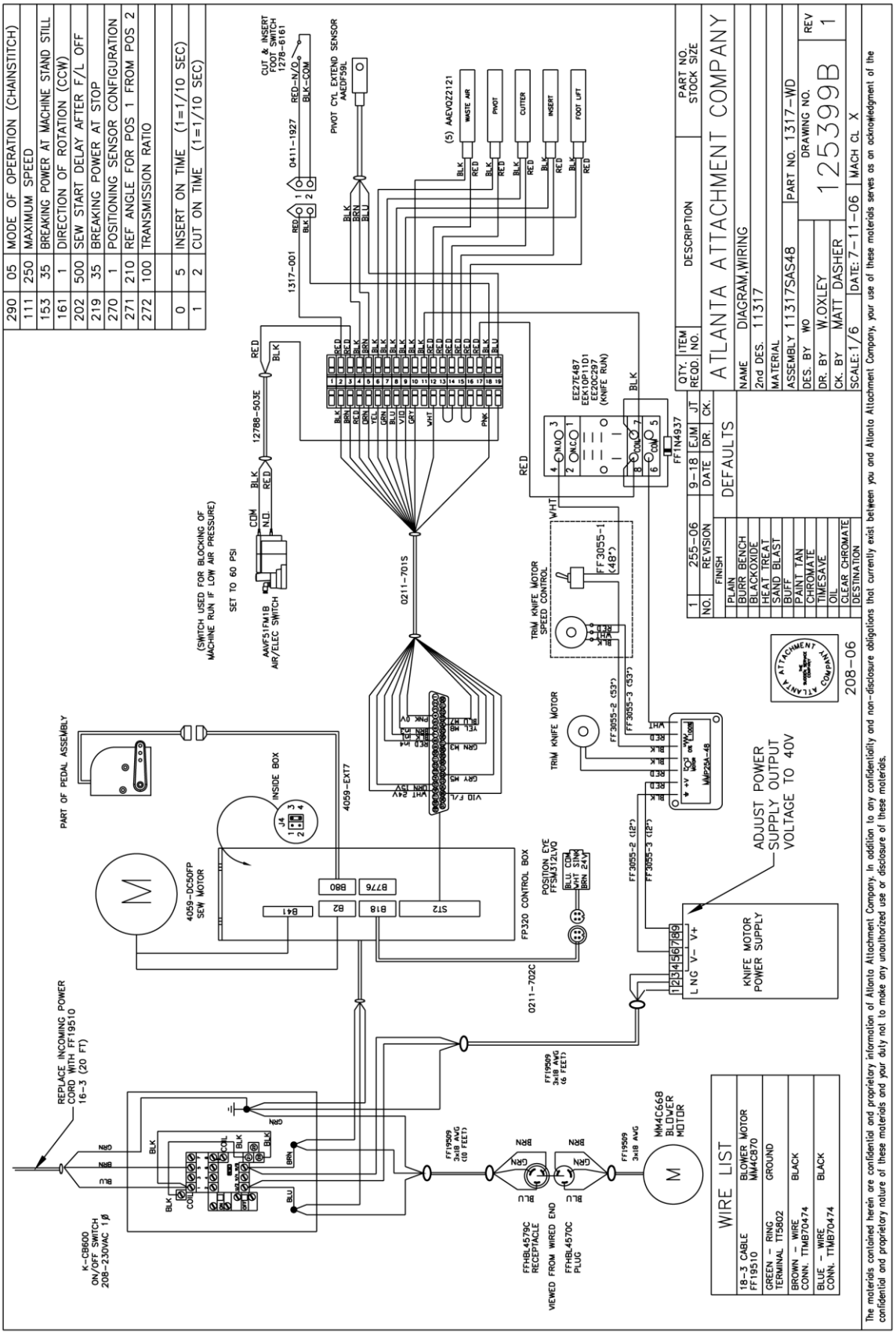
AAC Drawing Number 1317410 Rev0

NO.	QTY	PART #	DESCRIPTION
1	2	1317082	RIGHT SIDE PLATE ASSY.
2	1	1317086	BRACE,FRONT
3	1	1317087	CUTTER PIVOT LATCH, LEFT
4	1	1317088	ROD, CUTTER PIVOT
5	1	1317090	BRACE, CYL MNT, BACK
6	2	1317091	MATERIAL GUIDE ROD
7	1	1317092	MATERIAL GUIDE ROD
8	1	1317100	MATERIAL CHUTE ASSY.
9	2	1317126	MOUNT, CUT & INSERT
10	1	1317146	CUTTER PIVOT LATCH RT.
11	1	1317377	ROD, TIE
12	1	1337066	MATERIAL GUIDE
13	1	1337075	ROD SEPERATOR
14	1	1337077	PINCH ROLLER CONTAINER
15	1	1337085	DELRIN FLOAT WHEEL
16	2	1337122	KNOB, 1/4-20 X 1.125L
17	5	SSBC98024	#10-32 X 3/8 BUT HEAD
18	2	SSHC01064	1/4-20 X 1 HEX HEAD
19	4	SSSC01032	1/4-20 X 1/2 SOC CAP
20	2	SSSC01064	1/4-20 X 1 SOC CAP
21	2	SSSC01080	1/4-20 X 1-1/4 SOC CAP
22	4	SSSC98040	#10-32 X 5/8 SOC CAP
23	1	SST090032	THUMB SCREW
24	2	WWFS1/4	WASHER FLAT, 1/4
25	4	WWFS10	WASHER, FLAT #10
26	3	WWL1/4	1/4 LW
27	3	WWL10	#10 LW

1317-PD Pneumatic Diagram



1317-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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