



Model

1319

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Technical Manual & Parts Lists



From the library of: Diamond Needle Corp

Atlanta Attachment Company

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ATLANTA ATTACHMENT COMPANY, INC.

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IMPORTANT

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

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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 1319 Mattress Tufting Machine 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.

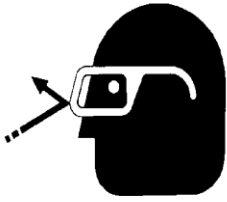
Signs on the Machine

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.

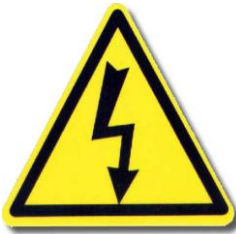
The following fire extinguishers may be used:

- 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.

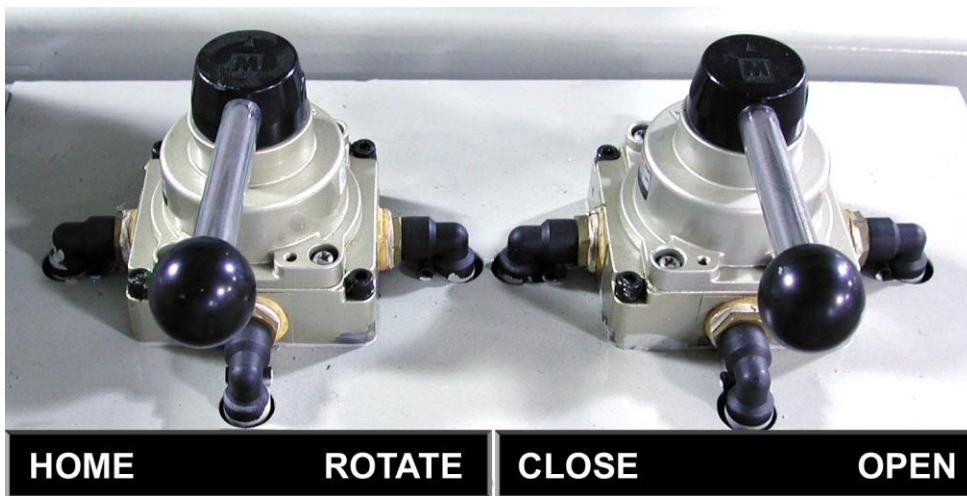
- ALWAYS keep safety shields and covers in place, except for servicing.
- ALWAYS operate equipment in daylight or with adequate working lights.
- Follow daily and weekly checklists, making sure hoses are tightly secured and bolts are tightened.
- ALWAYS watch and avoid holes or deep depressions.
- ALWAYS 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.

Technical Specifications

Production Time:	8-12 mattresses per hour
Maximum Mattress Size:	2000 mm x 1800 mm x 350 mm / 79 in x 71 in x 14 in
Air Pressure:	0.5-0.8MPa / 72-116 psi
Machine Dimensions:	3400 mm x 1800 mm x 1500 mm / 134 in x 71 in x 59 in
Machine Weight:	700 kg / 1543 lbs.

Installation and Setup

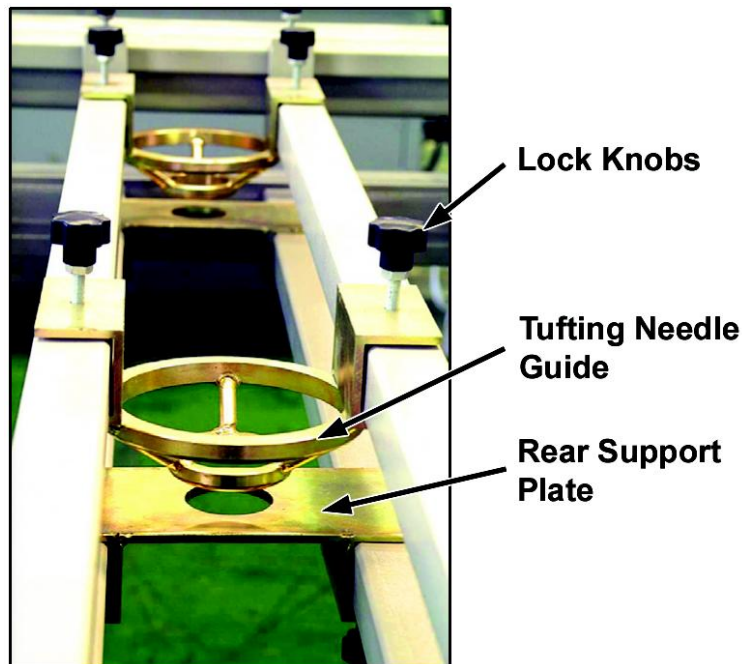
- Position the machine in a desired location on a level floor.
- Make sure there is sufficient lighting over the machine.
- Be sure all bolts are tight. Some may have loosened during shipping from the factory.



- Be sure the “Home/Rotate” valve is in the “Home” position and the “Close/Open” valve is in the “Close” position.
- Connect the main air supply.
- Set the air regulator between 0.5-0.8MPa and 72-116 psi.
- Position the tufting guides in the desired location. See “Adjusting the Tufting Needle Guides” on page 11.

Adjusting the Tufting Needle Guides

Use the scales to position the tufting needle guides in the desired location on the upper frame by loosening the Lock Knobs and sliding the guides along the frame members. Tighten the Lock Knobs. Use the same procedure to locate the Rear Support Plate directly in line with the needle guide on the lower frame.



Machine Operation

WARNING! Keep away from the rotating range of this machine.

- 1.) Turn the handle on the “Close/Open” valve to the “Open” position to raise the upper frame.
- 2.) Place one edge of the mattress on the roller and push the mattress into the machine between the upper and lower frames. One end of the mattress should be against the edge guide.
- 3.) Once the mattress is in its proper position, turn the handle on the “Open/Close” valve to the “Close” position until the mattress is clamped between the upper and lower frames.

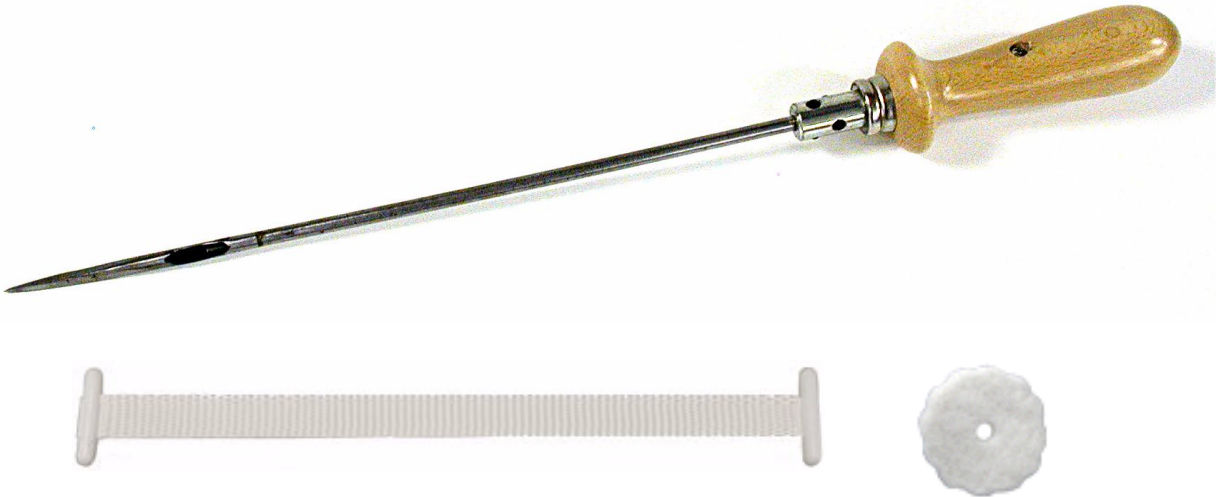
WARNING! Be sure nothing is obstructing the rotation path of the machine before proceeding.

- 4.) Turn the handle on the “Home/Rotate” valve to the “Rotate” position until the frames and mattress are vertical.
- 5.) Begin tufting as desired. See “Tufting Procedure” on page 12.
- 6.) When tufting is complete, turn the handle on the “Home/Rotate” valve to the “Home” position until the frames and mattress are back in the horizontal position.

Turn the handle on the “Open/Close Valve to the “Open” position to release the mattress. Pull the mattress out of the machine.

Tufting Procedure

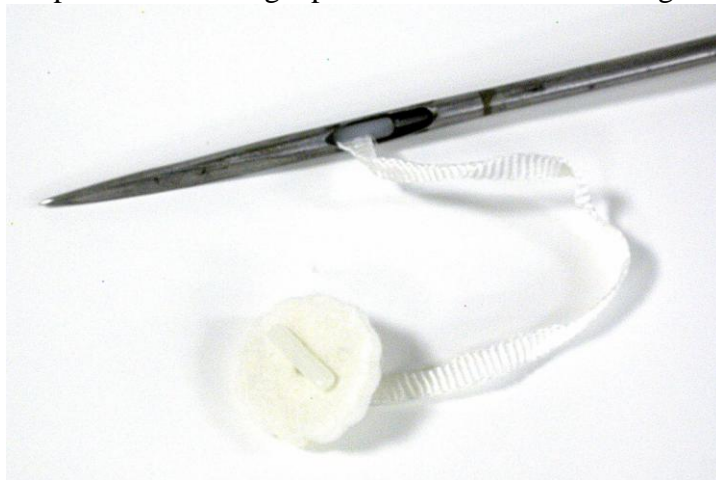
A tufting needle and some sample felt washers and tufting tape are included with this machine.



The tufting tape replaces the twine and buttons and makes tufting of futon mattress padding a faster, easier and more accurate operation.

The tufting process is very easy. Using the tufting needle;

- 1.) Insert one clip from the tufting tape into a felt washer.
- 2.) Insert the other clip from the tufting tape into the slot in the tufting needle.



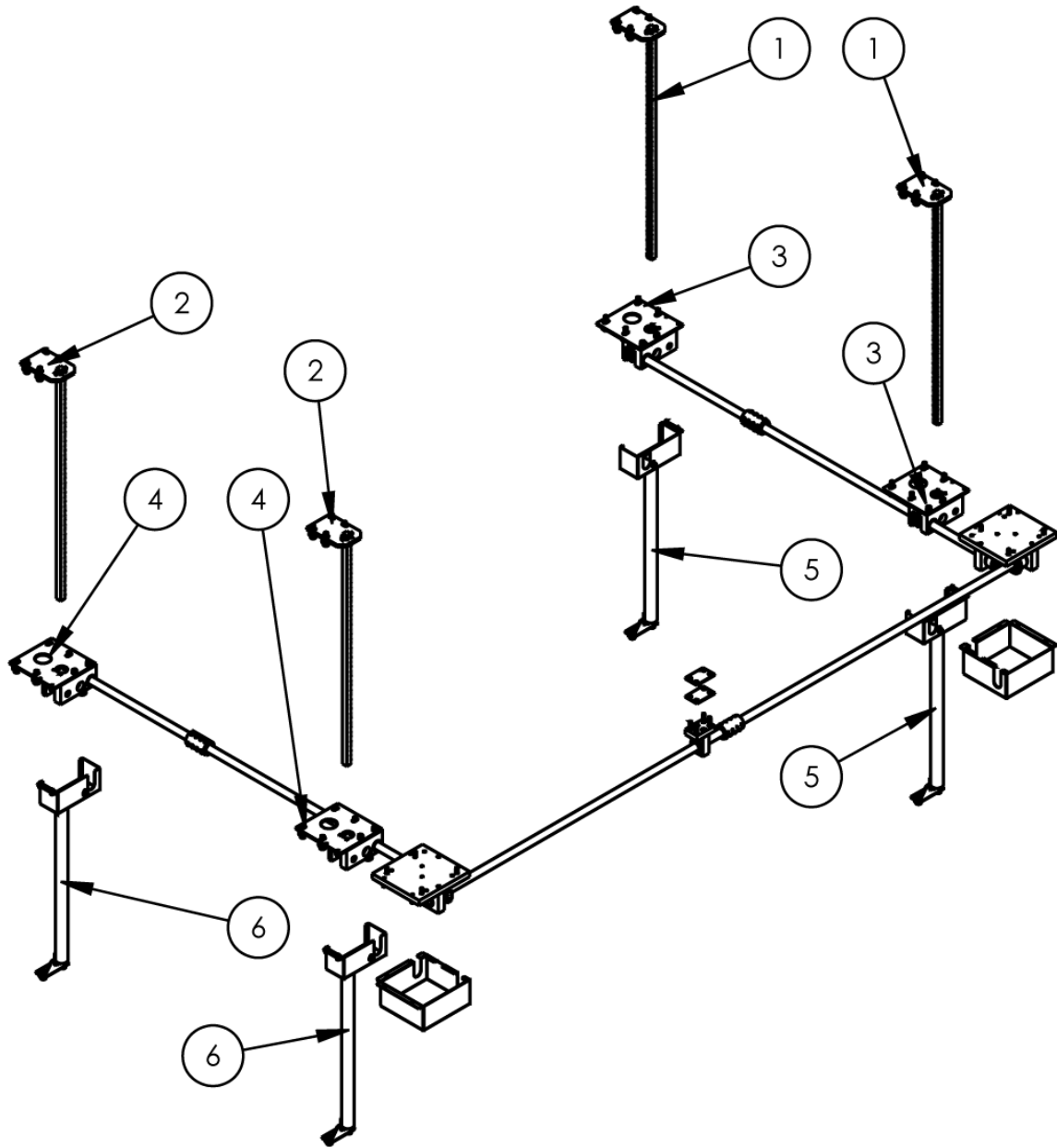
- 3.) Then push the needle through compressed mattress.
- 4.) Place another felt washer onto the needle and push it past the slot of the needle.
- 5.) Remove the clip from the needle.
- 6.) Pull the needle out of the mattress.

Assembly Drawings & Parts Lists

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1319-KIT02B

AAC Drawing Number 9003688 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	2	1319038	RACK ASBLY, RIGHT
2	2	1319039	RACK ASBLY, LEFT
3	2	1319096	DRIVE ASBLY, RIGHT
4	2	1319098	DRIVE ASBLY, LEFT
5	2	1319106	RIGHT RACK COVER ASBLY
6	2	1319110	LEFT RACK COVER ASBLY

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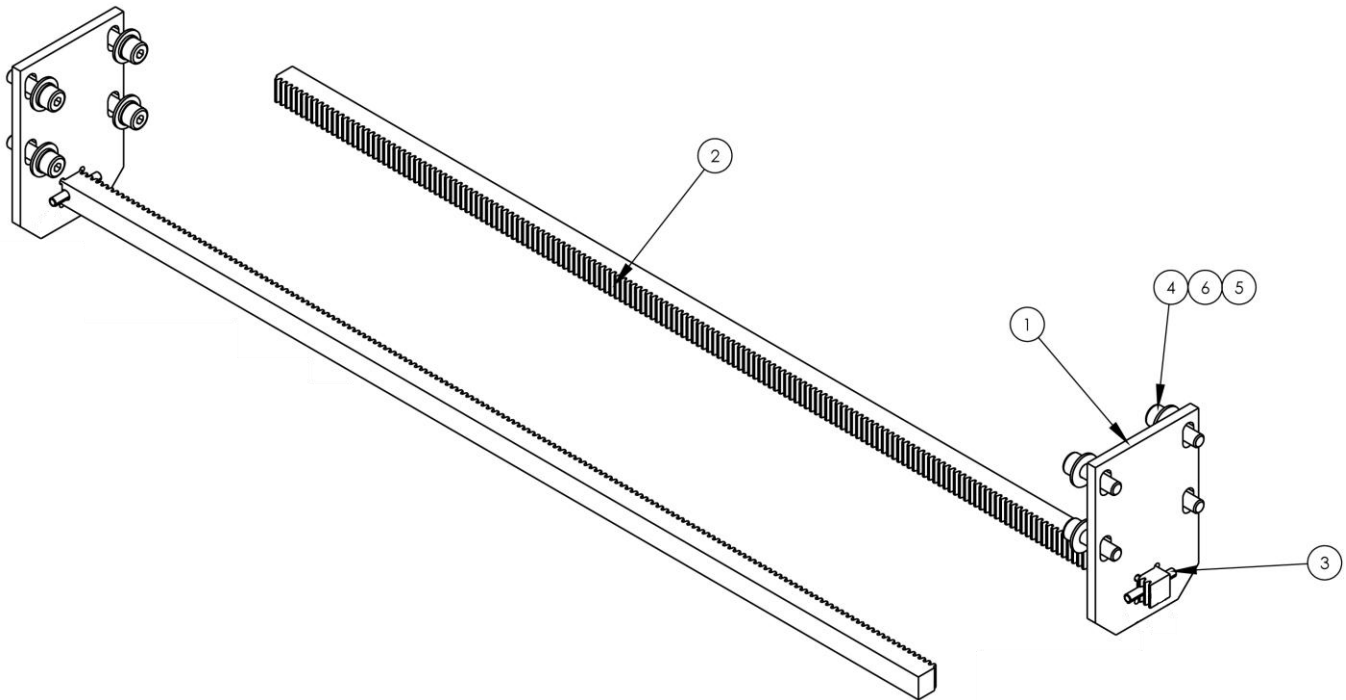
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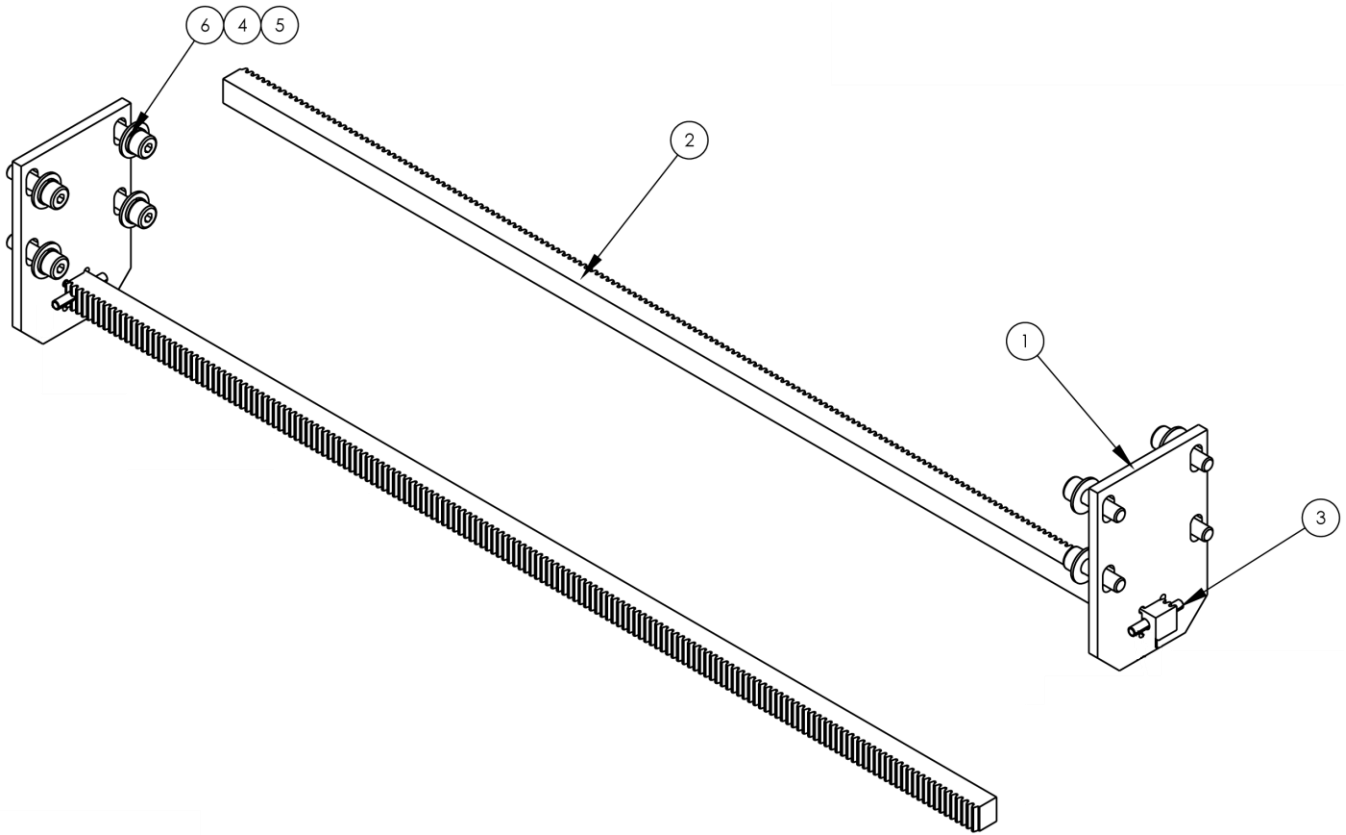


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1319038 Right Rack Assembly

AAC Drawing Number 1319038 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	1319021	RACK MOUNTING PLATE
2	1	1319022	GEAR RACK, 20 DEG P
3	2	IIISO16X112	SPRING PIN 1/4 X 1-3/4
4	4	SSSCM10X35	CAP SCREW 10MM X 35MM
5	4	WWFM10	WASHER, FLAT, M10 I.D.
6	4	WWLM10	M10 LOCK WASHER

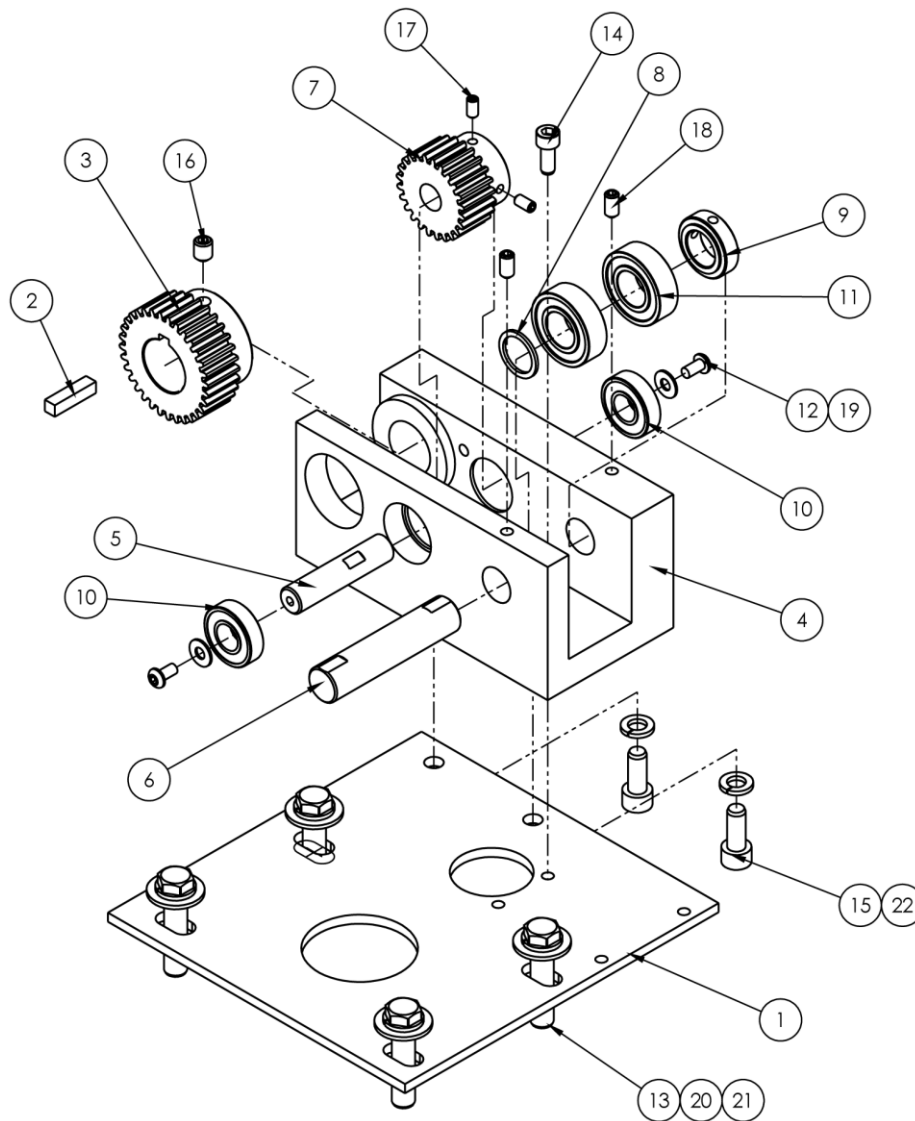


From the library of: Diamond Needle Corp

1319039 Left Rack Assembly

AAC Drawing Number 1319039 Rev 3

NO.	QTY	PART #	DESCRIPTION
1	1	1319021	RACK MOUNTING PLATE
2	1	1319022	GEAR RACK, 20 DEG P
3	2	IIS016X112	SPRING PIN 1/4 X 1-3/4
4	4	SSSCM10X35	CAP SCREW 10MM X 35MM
5	4	WWFM10	WASHER, FLAT, M10 I.D.
6	4	WWLM10	M10 LOCK WASHER

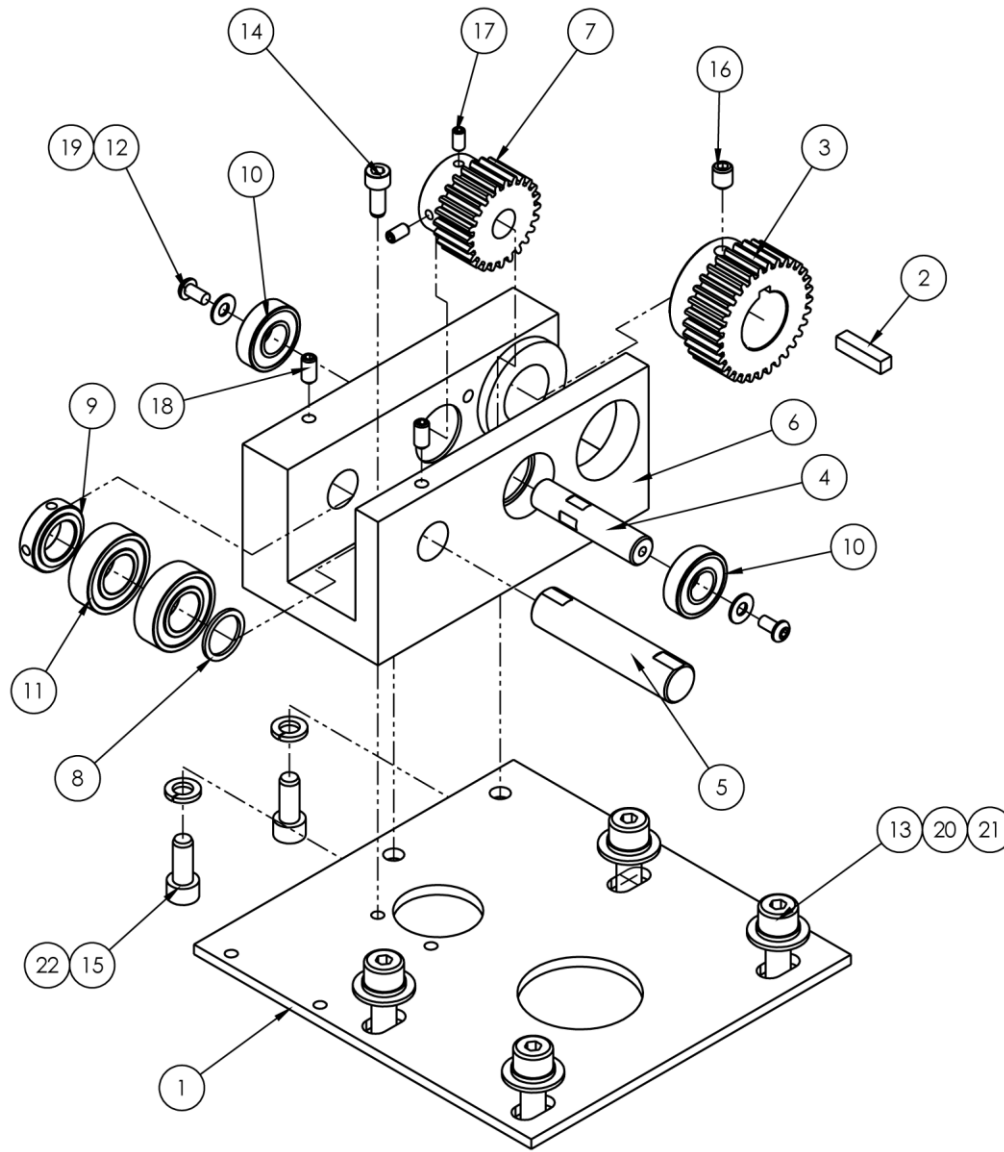


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1319096 Right Drive Assembly

AAC Drawing Number 1319096 Rev 3

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1319023	PLATE, RACK GUIDE	12	2	SSBC98024	10-32 X 3/8 BUTTON CAP SC
2	1	1319026	KEY, 6MM X 6MM X 25MM	13	4	SSHCM10X45	SCREW, HEX CAP M10X45
3	1	1319053	SPUR GEAR, 20 DEG	14	1	SSSCM6X15	M6X15 SOC CAP SCREW
4	1	1319097	BLOCK ASBLY, RIGHT	15	2	SSSCM8X20	M8X20 SOC CAP
5	1	1319099	SHAFT, .50 OD X 2.25 L	16	1	SSSS10024	SCREW, SET, 5/16-18X3/8
6	1	1319102	SHAFT, 17MM X 3"	17	2	SSSS98024	10-32X 3/8 SOC SET SC
7	1	1319104	GEAR, SPUR, 16P, 24T	18	2	SSSSM6X12	M6 SET SCREW, 12MM L
8	1	1319105	SPACER, 17MM X 7/8 X 16GA	19	2	WWF10	WASHER, FLAT, #10, COM
9	1	1388406	COLLAR, SPACER, 17MM	20	4	WWFM10	WASHER, FLAT, M10 I.D.
10	2	BB1L005	BEARING, BALL, .500D	21	4	WWLM10	M10 LOCK WASHER
11	2	BB60032RS	BEARING, 17MM ID, 35MM OD	22	2	WWLM8	M8 LOCK WASHER

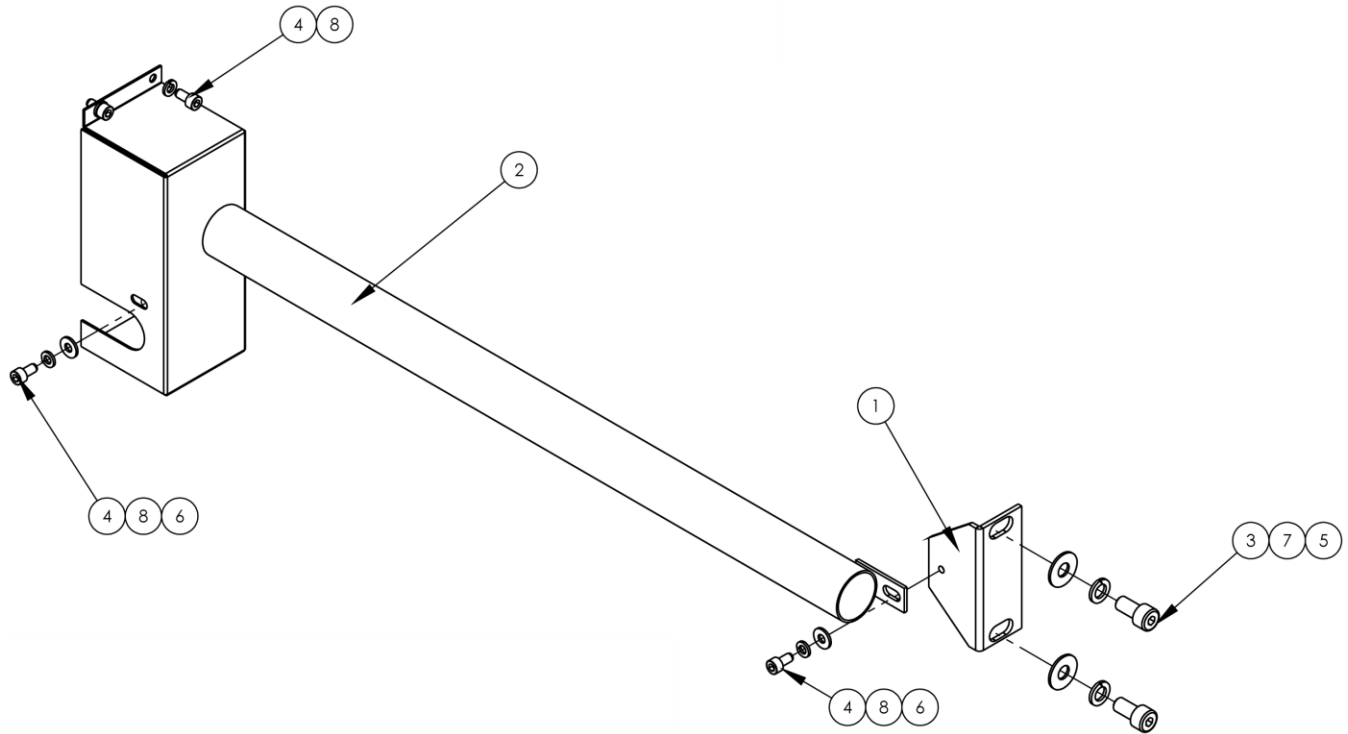


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1319098 Left Drive Assembly

AAC Drawing Number 1319098 Rev 1

NO.	QTY	PART #	DESCRIPTION	NO.	QTY	PART #	DESCRIPTION
1	1	1319023	PLATE, RACK GUIDE	12	2	SSBC98024	10-32 X 3/8 BUTTON CAP SC
2	1	1319026	KEY, 6MM X 6MM X 25MM	13	4	SSSCM10X35	CAP SCREW 10MM X 35MM
3	1	1319053	SPUR GEAR,20 DEG	14	1	SSSCM6X15	M6X15 SOC CAP SCREW
4	1	1319099	SHAFT, .50 OD X 2.25 L	15	2	SSSCM8X20	M8X20 SOC CAP
5	1	1319102	SHAFT, 17MM X 3"	16	1	SSSS10024	SCREW, SET, 5/16-18X3/8
6	1	1319103	BLOCK ASBLY, LEFT	17	2	SSSS98024	10-32X 3/8 SOC SET SC
7	1	1319104	GEAR,SPUR,16P,24T	18	2	SSSSM6X12	M6 SET SCREW, 12MM L
8	1	1319105	SPACER, 17MM X 7/8 X 16GA	19	2	WWF10	WASHER, FLAT, #10, COM
9	1	1388406	COLLAR, SPACER,17MM	20	4	WWFM10	WASHER, FLAT, M10 I.D.
10	2	BB1L005	BEARING,BALL,.500D	21	4	WWLM10	M10 LOCK WASHER
11	2	BB60032RS	BEARING,17MM ID, 35MMOD	22	2	WWLM8	M8 LOCK WASHER

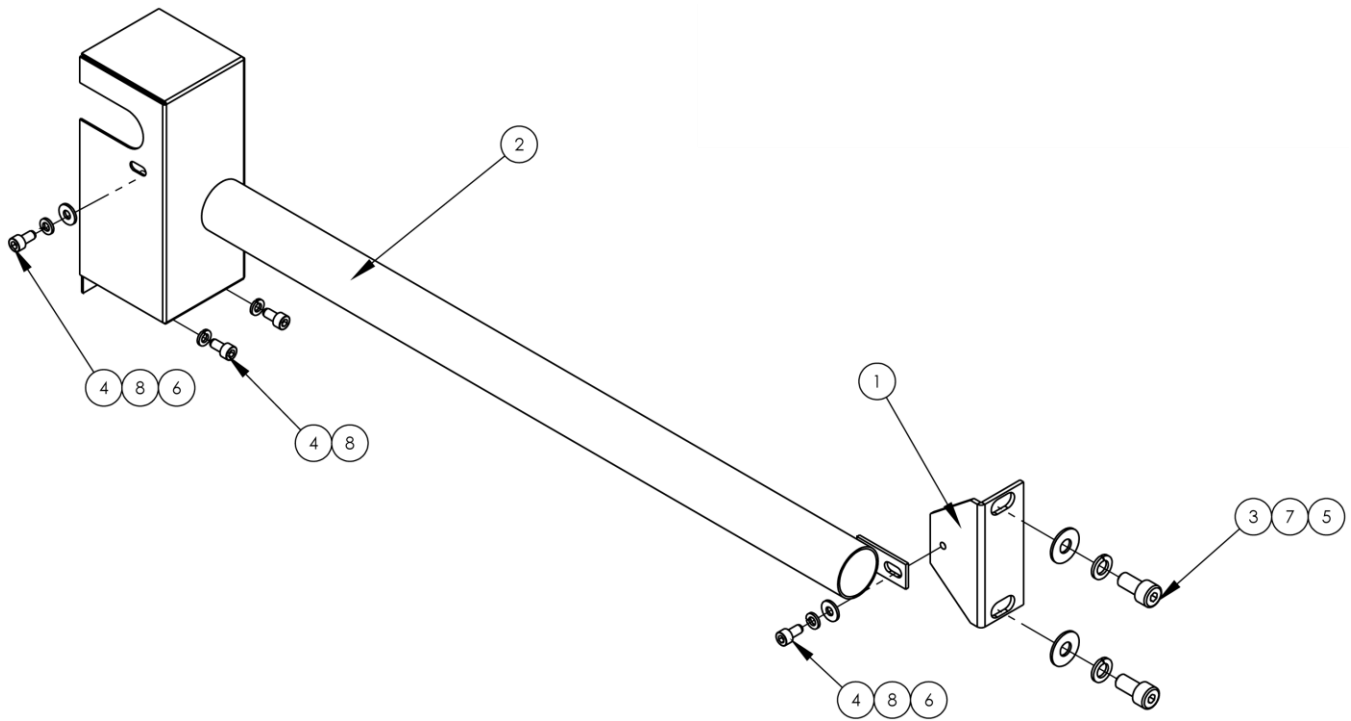


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1319106 Right Rack Cover Assembly

AAC Drawing Number 1319106 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1319051	TUBE ANCHOR
2	1	1319108	RIGHT RACK COVER WELDMENT
3	2	SSSCM10X20	CAP SCREW 10MM X 20MM
4	4	SSSCM6X12	M6X12 SOC CAP SCREW
5	2	WWF3/8	WASHER,FLAT,3/8 OR 10MM
6	2	WWFM6.1	WASHER, FLAT, M6, SAE
7	2	WWLM10	M10 LOCK WASHER
8	4	WWLM6	M6 LOCK WASHER

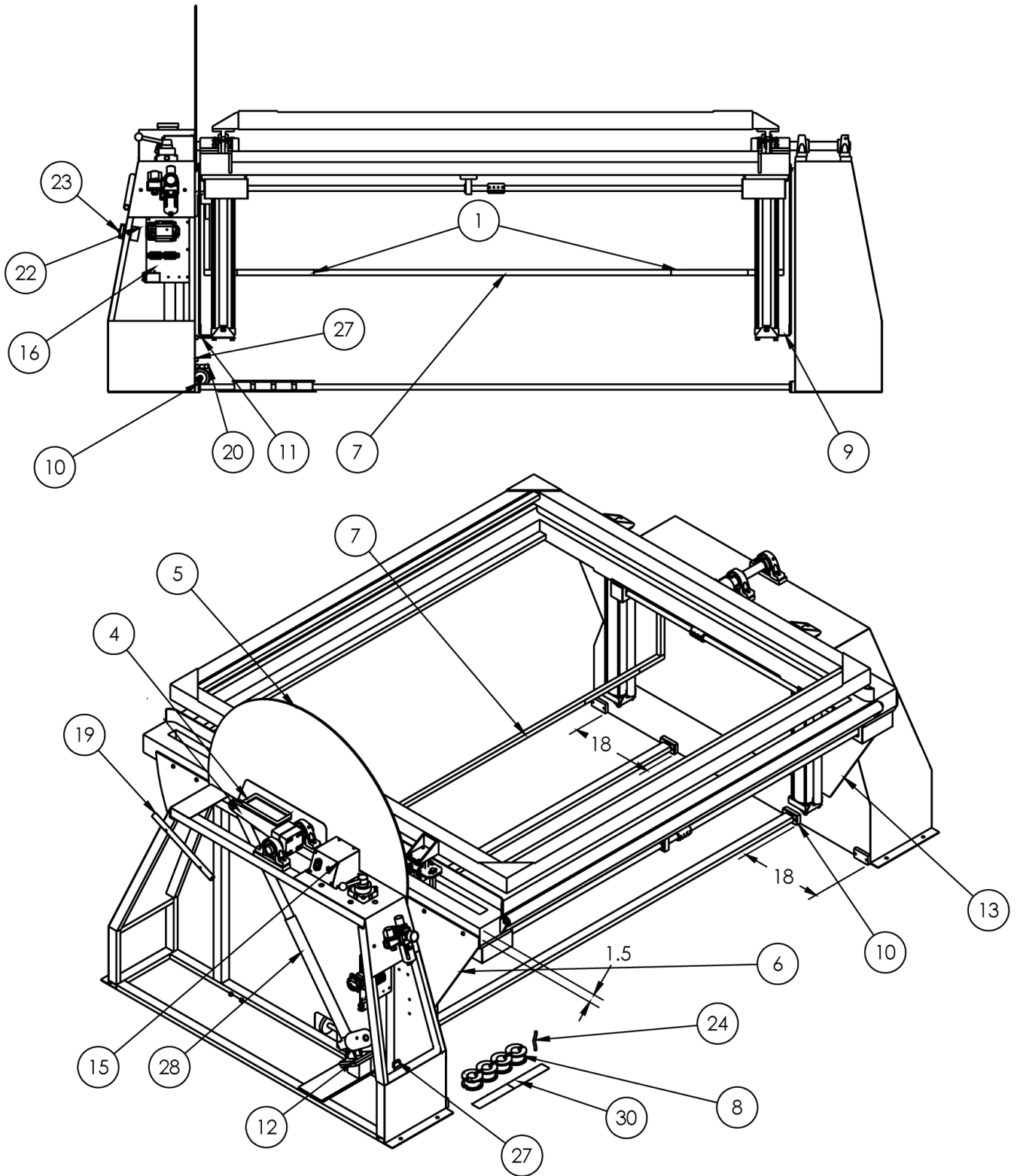


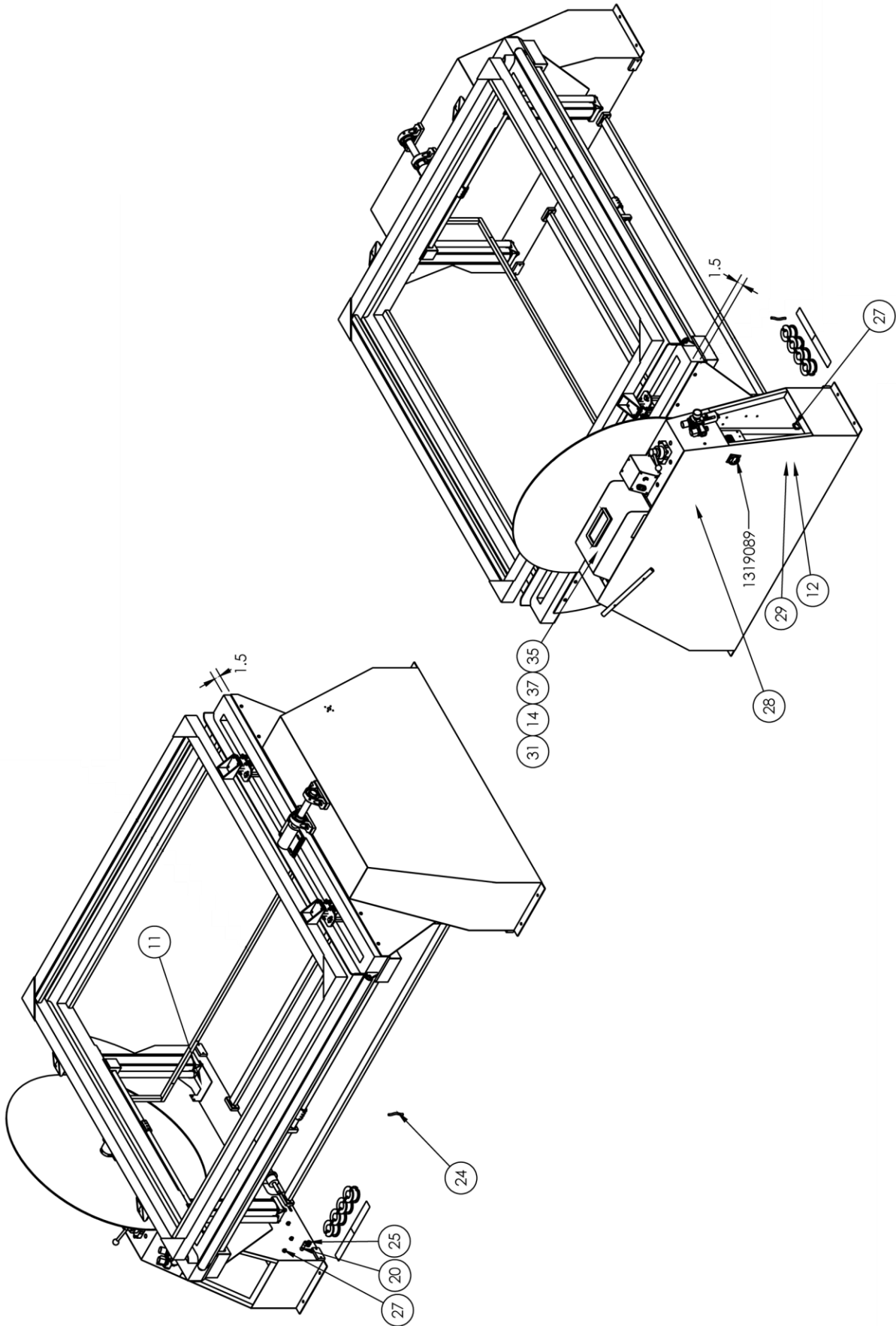
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1319110 Left Rack Cover Assembly

AAC Drawing Number 1319110 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1319051	TUBE ANCHOR
2	1	1319109	LEFT RACK COVER WELDMENT
3	2	SSSCM10X20	CAP SCREW 10MM X 20MM
4	4	SSSCM6X12	M6X12 SOC CAP SCREW
5	2	WWF3/8	WASHER, FLAT, 3/8 OR 10MM
6	2	WWFM6.1	WASHER, FLAT, M6, SAE
7	2	WWLM10	M10 LOCK WASHER
8	4	WWLM6	M6 LOCK WASHER





1319-KIT04 Safety Modifications

AAC Drawing Number 9002668 Rev 0

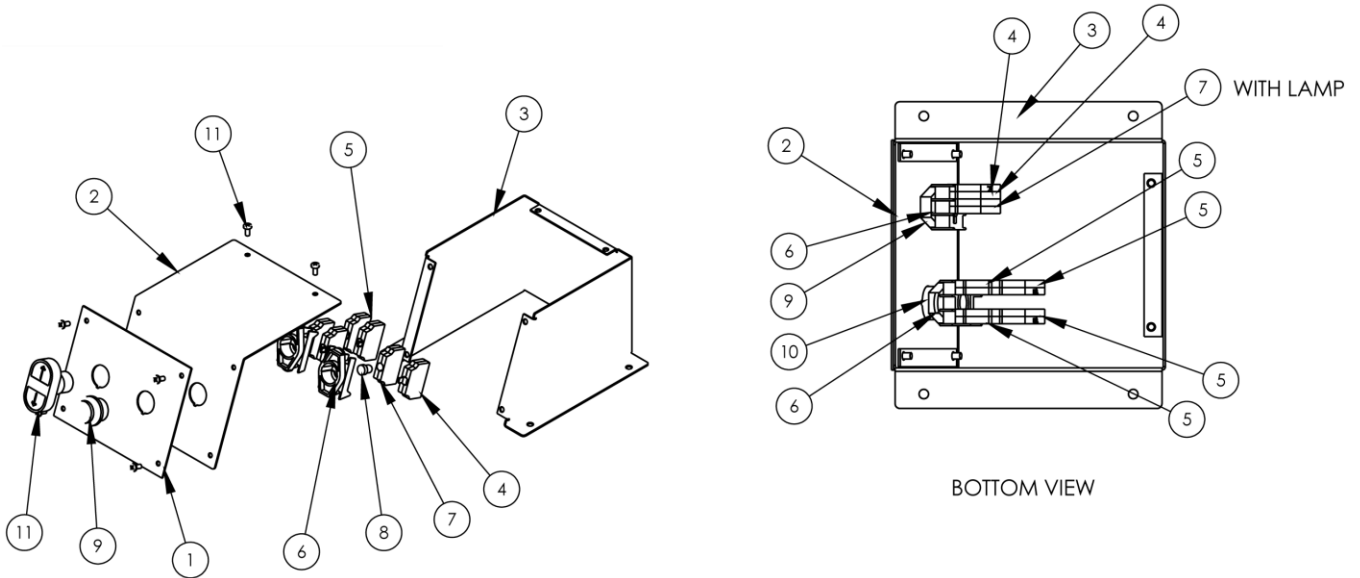
NO.	QTY	PART #	DESCRIPTION
1	2	1319-LAB6	LABELS,WARNING,SHARP NDLS
2	1	1319-PD1	DIAGRAM,PNEUMATIC,KIT04
3	1	1319-WD	DIAGRAM, WIRING
4	1	26151	TOOL TRAY, 1X3.5X9
5	1	1319012	GUARD, LEXAN, TOP RIGHT
6	1	1319013	GUARD, LEXAN, BOTTOM LEFT
7	1	1319014	KNEE GUARD
8	4	1319052	PLUG, 2" X 96MM DIA
9	3	1319054	MOUNT, GUARD, PLAIN
10	4	1319073	LOWER BRACE MOUNT
11	1	1319074	MOUNT, GUARD, OFFSET
12	1	1319079	ACTUATOR MOUNT WELDMENT
13	1	1319080	GUARD, LEXAN, RIGHT
14	1	1319082	BUSHING 18MM X .50 X .60
15	1	1319085	CONTROL PANEL
16	1	1319086	ELECTRICAL PANEL ASBLY
17	AR	1319088	BACK PLATE MOD FOR EYES
18	AR	1319089	FRONT PLT MOD,LOCK-OUT SW
19	1	1319090	HOLDER, TUFTING NEEDLE
20	1	AAVAKH11	VALVE,CHECK,3/8 TUBE
21	1	EE194A32PE	GROUNDING TERMINAL
22	1	EE194E251753	DISCONNECT,3 POLE,25A,IEC
23	1	EE194LHE6N175	DISCONNECT HANDLE,RED/YEL
24	10	FF19510	CABLE, 16X3 AWG INTL
25	1	FF3216	STRAIN RELIEF, LIQ TIGHT
26	3	FFRK44T-4	CABLE,EYE,12',NO END
27	3	FFSM312LVQ	EYE,ELECTRIC,10-30VDC
28	1	MM85199-20	ACTUATOR, ELEC. LINEAR
29	1	MM97245A718	CLEVIS PIN WITH SPG PIN
30	12	MMT9945	TAPE,REFLECTIVE,2" WIDE
31	1	NNH1/2-13	NUT,HEX,1/2-13
32	8	NNH5/16-18	5/16-18 HEX NUT
33	16	SSHC01048	1/4-20 X 3/4 HEX CAP
34	4	SSHC01064	1/4-20 X 1 HHCS
35	1	SSHC45128	1/2-13X2 HEX CAP
36	8	SSSC10192	SCREW, SOCKET CAP
37	1	WWFS1/2	WASHER,FLAT,SAE,1/2
38	20	WWFS1/4	WASHER,FLAT,SAE,1/4
39	8	WWFS5/16	WASHER,FLAT,SAE,5/16
40	1	WWL1/2	1/2 LOCK WASHER
41	4	WWL1/4	WASHER,LOCK,1/4
42	8	WWL5/16	WASHER, LOCK, 5/16

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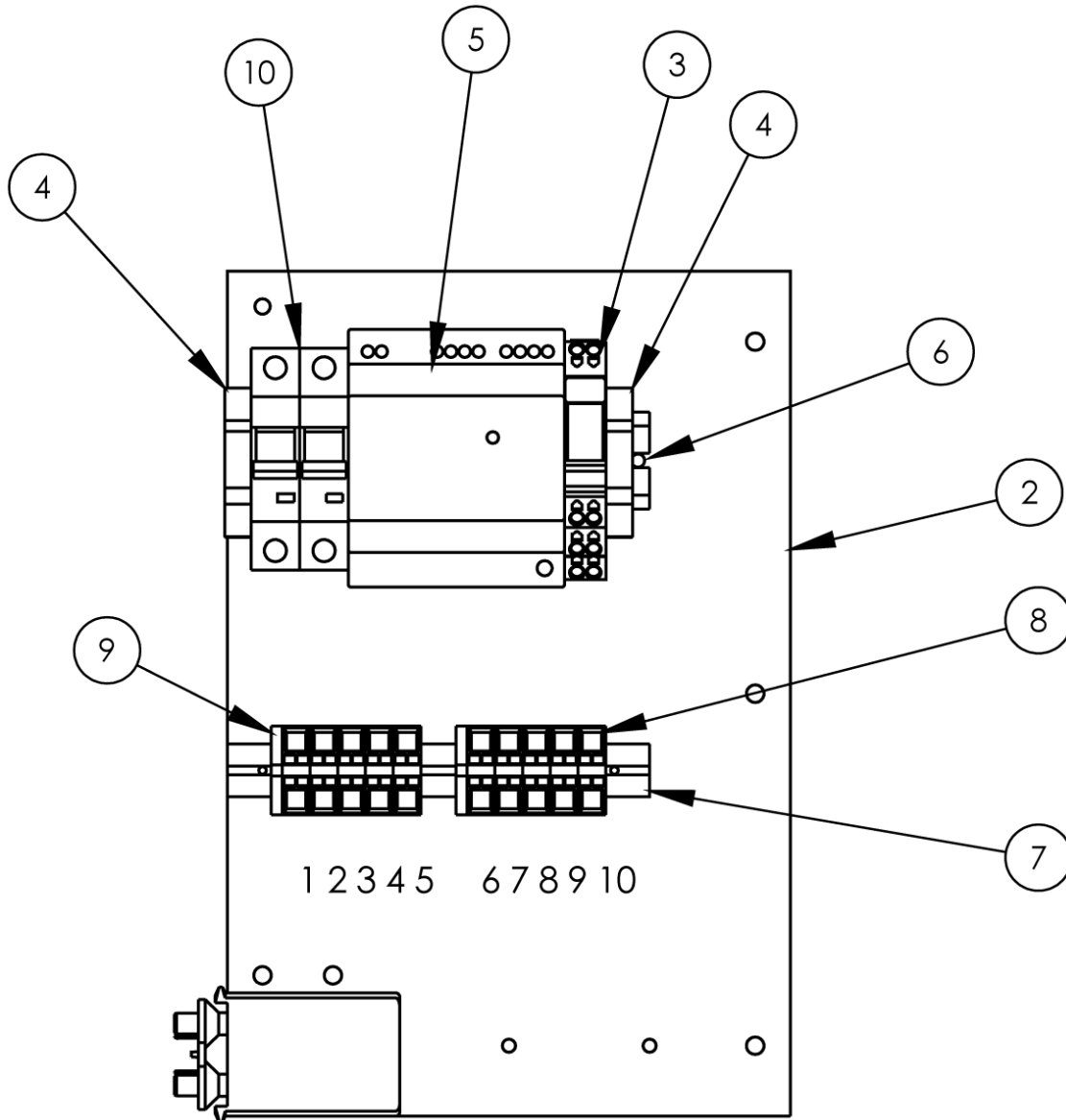
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1319085 Control Panel

AAC Drawing Number 1319085 Rev 0

NO.	QTY	PART #	DESCRIPTION
1	1	1319-LAB7	LABEL,ROTATE,SAFETY LOCK
2	1	1319083	PANEL, SWITCH, MAIN
3	1	1319084	SURROUND, CONTROL PANEL
4	1	EE3X01	BLOCK,P.B. CONTACT, N.C.
5	4	EE3X10	BLOCK,P.B. CONTACT, N.O.
6	2	EEA3L	LATCH,PUSH BUTTON
7	1	EED53D0	BLOCK, LAMP, 22MM P.B.
8	1	EED5N157	LAMP, INCONDECENT, BAYONET
9	1	EEPLE4	BUTTON, PUSH, RED, ILLUM
10	1	EEPU2A3	BUTTON, PUSH 22MM, 2X,G MOM FLUSH
11	6	SSPP90024	8-32X3/8 PAN PHLPS



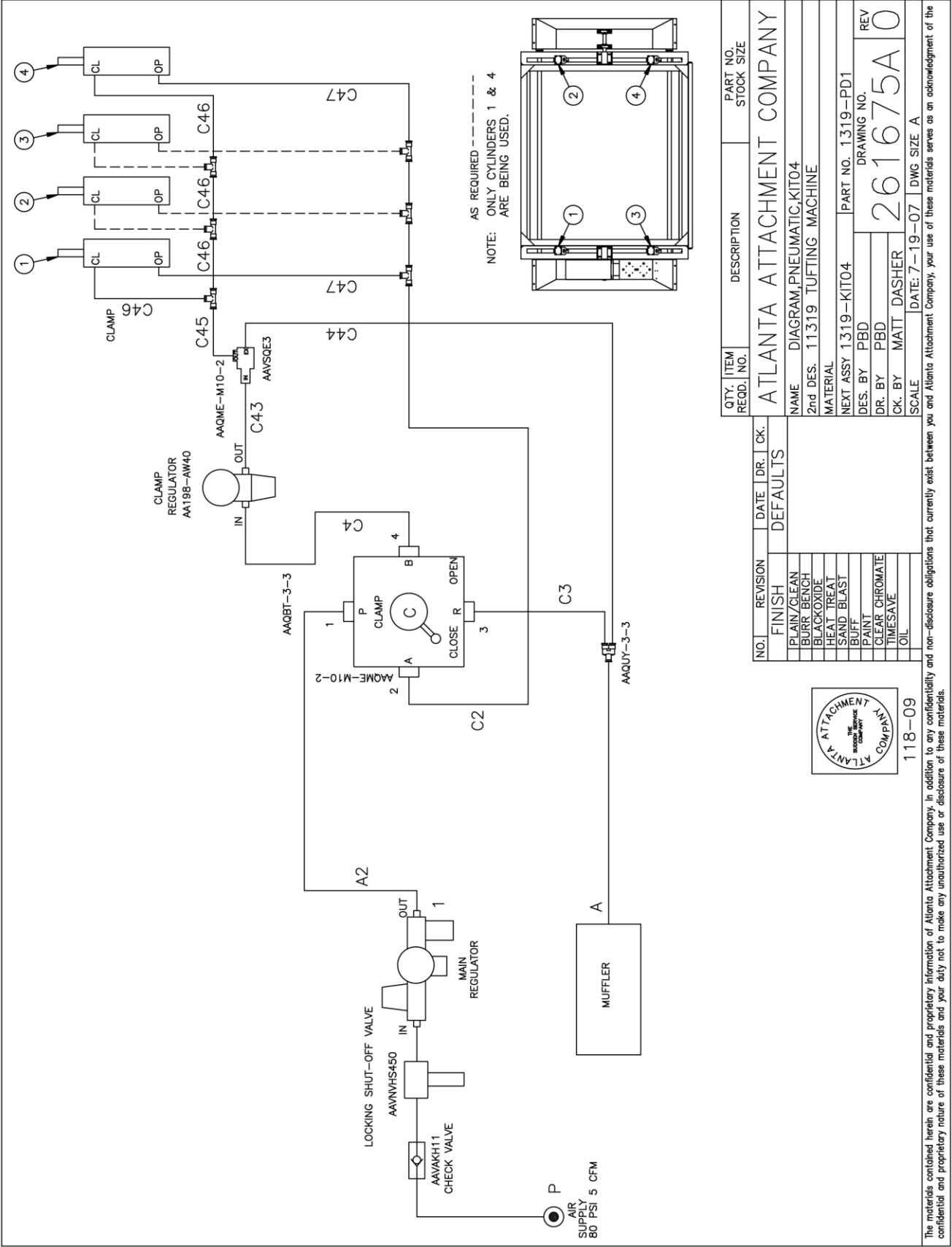
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1319086 Electrical Panel Assembly

AAC Drawing Number 1319086 Rev 1

NO.	QTY	PART #	DESCRIPTION
1	1	1319-WD	DIAGRAM, WIRING
2	1	1319087	PANEL, ELECTRICAL
3	1	EE788312	RELAY,24V,DPDT,WAGO
4	2	EECLIPFIX	ANCHOR,DIN RAIL
5	1	EEDR3024	POWER SUP,SWITCHER,24V
6	*6 IN	EETS35X7.5A	DIN RAIL-AMERICAN
7	1	FF264-3BKT6	MOUNT, WAGO TERMINAL
8	10	FF264-341	TERMBLK,WAGO,TOP,DUAL,GRY
9	2	FF264-371	TERMBLK,WAGO,TOP,END

1319-PD1 Pneumatic Diagram (Kit04)



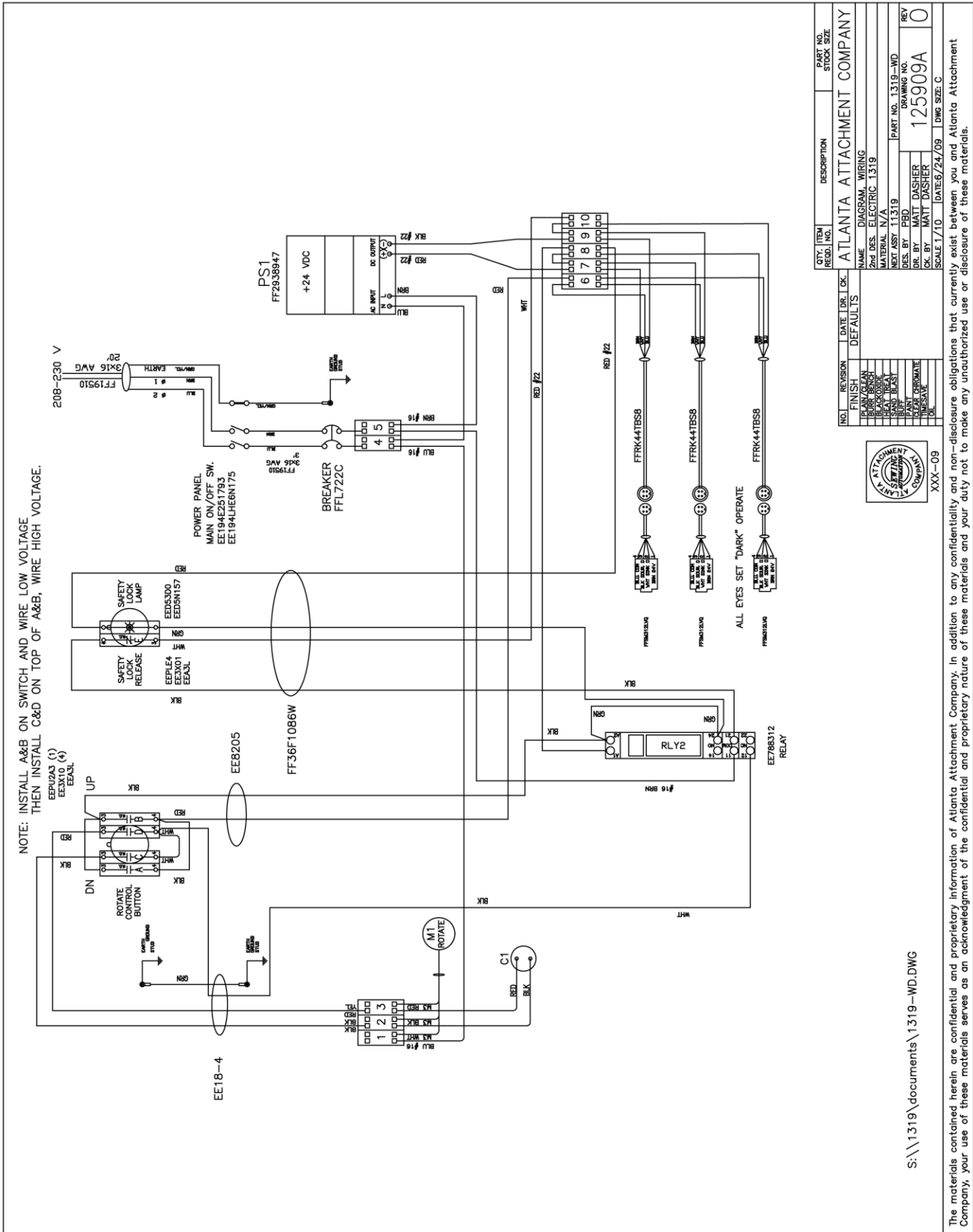
NO.	REVISION	DATE	DR.	CHK.	DESCRIPTION	PART NO.	STOCK SIZE
	FINISH				ATLANTA ATTACHMENT COMPANY		
	PLAIN/CLEAN				NAME DIAGRAM,PNEUMATIC,KIT04		
	BURR BENCH				2nd DES. 11319 TUFTING MACHINE		
	BLACKOXIDE				MATERIAL		
	HEAT TREAT				NEXT ASSY 1319-KIT04		
	SAND BLAST				DES. BY PBD		
	BUFF				DR. BY PBD		
	PAINT				CK. BY MATT DASHER		
	CLEAR CHROMATE				SCALE		
	TIMESAVE				DATE: 7-19-07		
	OIL				DWG SIZE A		



118-09

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1319-WD Wiring Diagram



QTY / ITEM	DESCRIPTION	PART NO.	STOCK SIZE
REC'D. NO.			
ATLANTA ATTACHMENT COMPANY			
NO. / REVISION	DATE / BY / CHK.	NAME	
	DEFAULTS	DIAGRAM, WIRING	
FINISH		2nd DES. ELECTRIC 1319	
BRN / GRN		MATERIAL N/A	
WHT / WHT		PART NO. 1319-WD	
BLK / BLK		DRAWING NO.	
RED / RED		REV	
SAFETY		DES. BY: PBD	
PAINT		CHK. BY: MATT DASHER	
CLEAR OPERATE		SCALE 1/10	
OK		DATE: 6/24/09	
		DWG. SIZE: C	



S: \\1319\documents\1319-WD.DWG

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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 Garantía

Productos Manufacturados

Atlanta Attachment Company garantiza que los productos de fabricación son libres de defectos de material 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 primero.
- 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 cualquier 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 periodo de ochocientas (800) horas.
- Componentes mecánicos que fallen por defectos de materiales o de fabricación que han sido manufacturados 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 neumáticas.
- 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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