

DELUXE STITCHER

C O M P A N Y I N C .

Head Serial Number : _____

Date Purchased : _____

Where Installed: _____

(make/model of machine)

G5 Stitcher Head

OPERATION AND MAINTENANCE MANUAL

Wire Sizes: 25-28 Ga. Round

Crown Sizes: 1/2" (12mm) and 13/64" (5 mm) Loop

Capacity: 2 sheets to 13/64" (5 mm)

Before using this Stitcher Head, all operators must study this manual and follow the safety warnings and instructions. Keep these instructions with the G5 Stitcher Head for future reference. If you have any questions, contact your local DeLuxe Stitcher Company Graphic Arts Representative or Distributor.

WARNING!

G5 Stitcher Head

Machine operators and others in the work area should always wear safety glasses to prevent serious eye injury from fasteners and flying debris when loading, operating, or unloading this machine.

Do not operate this stitcher head without all stitcher machine guards in place. Do not modify the guards in any way. Always disconnect the power supply before removing any guards for servicing.

Never operate the machine with wire feeding through the head unless there is stock above the clinchers, otherwise serious damage may result.

Always turn power off when making adjustments. Always disconnect the power cord before any disassembly work.

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Introduction

The DeLuxe Stitcher G5 Stitcher Head is the latest addition to the Company's side-feed stitcher head product line. This head along with a complete line of replacement parts are now available for current users of the DeLuxe 26/26D Heads. The G5 Head can also be used anywhere Hohner 48/5, 52/8 and 43/6, 55/7, Acme, Champion, Interlake, Magnatek, ISP and M2000 Stitcher Heads are used.

The G5HD251/2 has a stitching capacity from 2 sheets up to 5mm (13/64") and will accommodate wire sizes from 25-28 gauge round. The minimum center to center distance between heads is only 1-1/2" (39mm) at a 3/64" (1.0mm) capacity setting. This specification lends itself well to unique jobs requiring little space between stitches, such as CD and coupon booklets and all types of "two-up" work.

The G5 has a minimum distance of 3-7/16" (86mm) from its mounting surface to the face of the Head and so is ideal for low-profile collators. The smaller dimensioning of this Head make it perfect for special bindery applications. Watkiss Collators, which up until now, have not been able to use Side-Feed Heads, can accommodate the new G5.

Each of these heads weighs 5.4 lbs (2.5 kgs.) independently. The packaged shipping weight including the Wire Guide Spring, Clincher Plate assembly, tools for maintenance and the user manual is 7.4 lbs. (3.4 kgs.).

Always use a high quality Galvanized Wire so the plating does not peel during operation. Excessive peeling will cause clogging and the premature wear of many components.

Specifications

Weight

Shipping Weight 7.4 lbs (3.4 kg)

Physical Dimensions

Height 10-3/4" (26.3 cm)

Width 2" (5.1 cm)

Stitching Capacity Two Sheets to 5mm (13/64")

Wire Types 25 through 28 round

Crown Sizes 1/2" (12mm), 13/64" (5mm) Loop

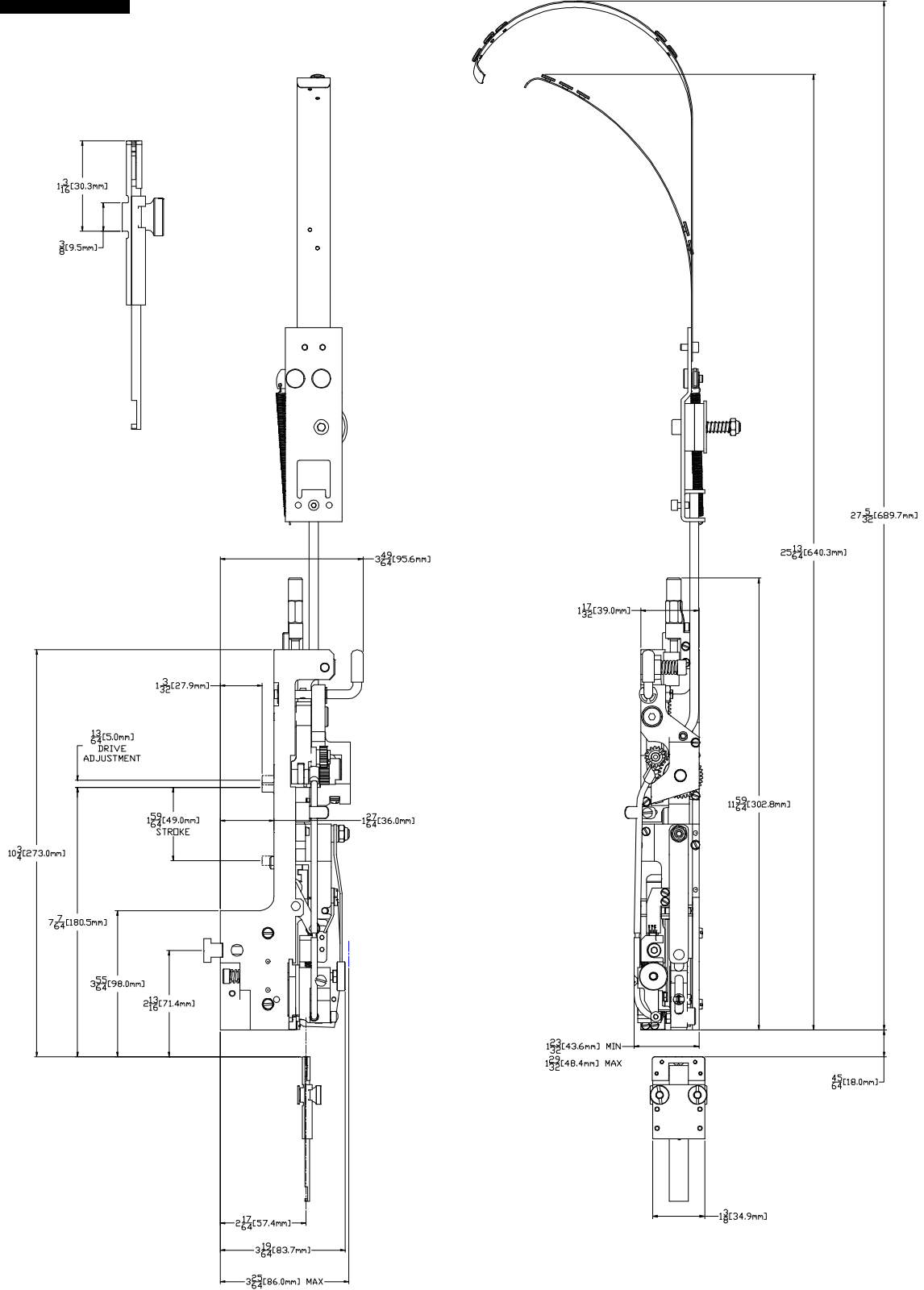
Minimum Head Center

..... 1-1/2" (39mm)

Stitches Per Hour 10,000

Replacement for: DeLuxe Stitcher 26/26D heads as well
as Hohner 43/6, 48/5, 52/8 and 55/7 heads
and Acme, Champion, Interlake, ISP and
Magnatek heads

Dimensions



Installation

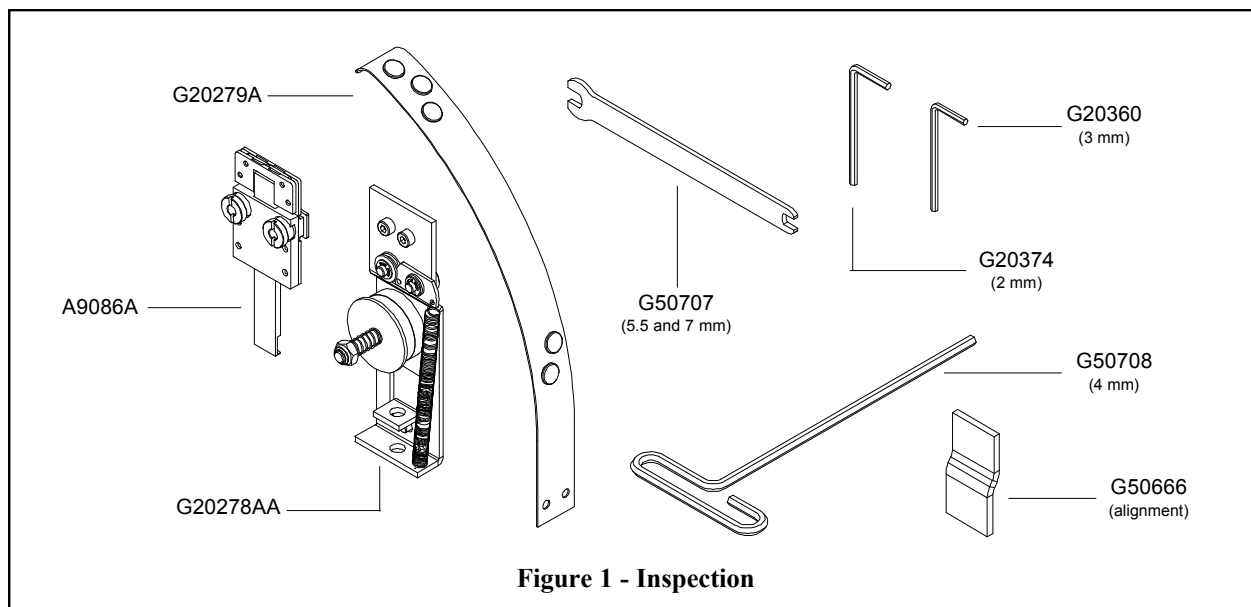
Pre-Inspection

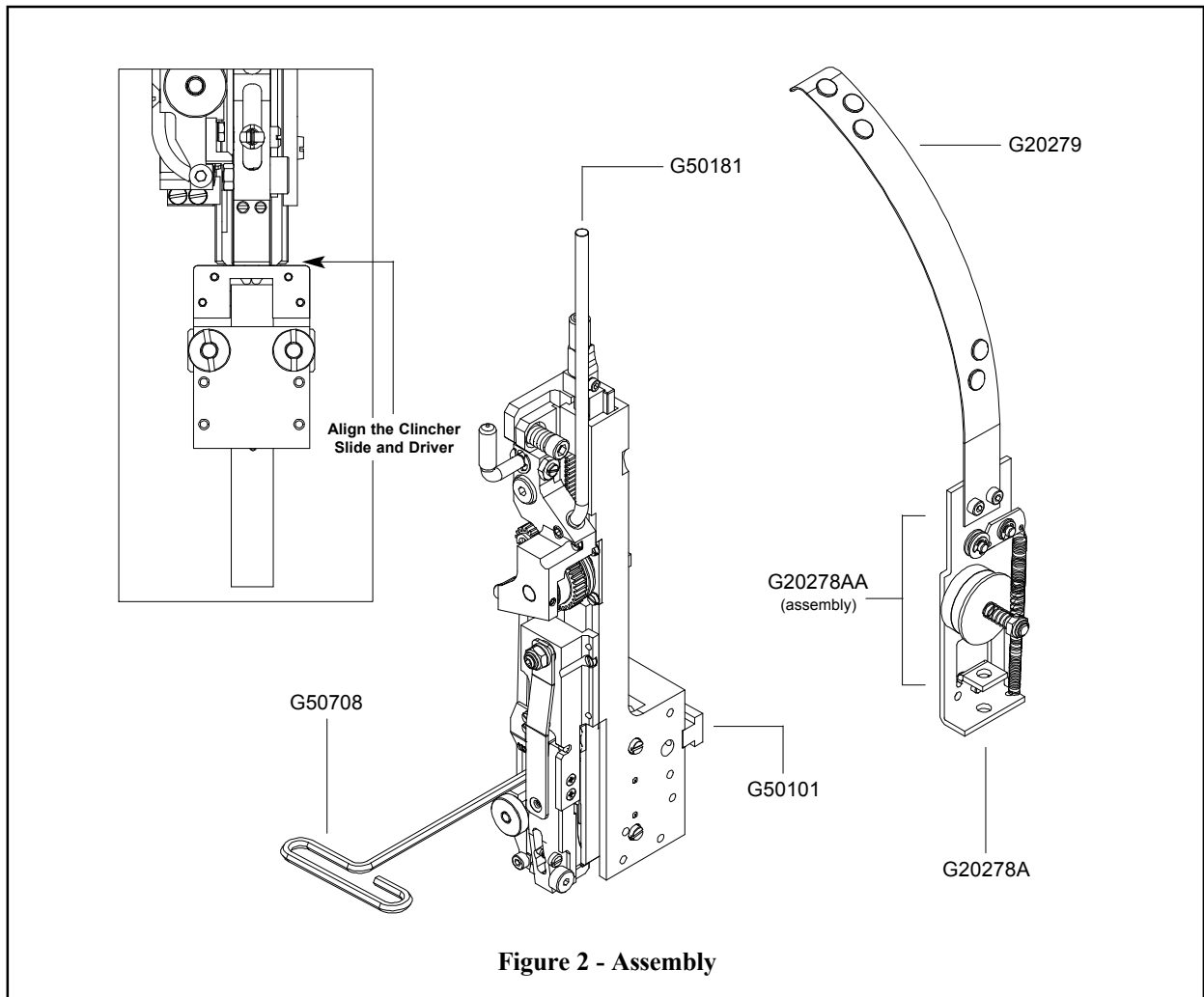
Carefully inspect the condition of the shipping container before unpacking your G5 Stitcher Head. If the container is broken or damaged and there is evidence that the stitcher head may be damaged, immediately notify the carrier who delivered the head and the DeLuxe Stitcher Graphic Arts Representative from whom the G5 Stitcher Head was purchased.

Inspection

As you carefully unpack the head, check to make sure all components were delivered and are in good working order. Refer to **Figure 1** in this manual for reference to the following pieces:

- G5 Manual
- Bag of tools; 2.0mm, 3.0mm, Double Open End Wrench (5.5mm and 7mm) and a Clincher Alignment Tool
- T-Handle Hex Head Wrench; 4mm
- Clamp Block and Cap Screw (for mounting)
- Wire Guide Spring and Spring Bracket Assemblies
- Clincher Plate, Points, Slide, Nuts and Studs
- Stitch Samples





Pre-Installation

Please take a few moments to fill out the registration card located on page 50 prior to beginning installation.

⚠ WARNING
 Always disconnect the power supply before making any adjustments or servicing the head.

Assembly (Figure 2)

Each new G5 Stitcher Head comes assembled with the exception of the Complete Wire Guide Spring Plate Assembly (G20278AA), the Upper Wire Tube (G50181), the Wire Guide Spring Assembly (G20279A) and the Clincher Plate Assembly. Install the Upper Wire Tube (G50181) in the Bonnet while the Wire Feed is on and secure the Tube with a Set Screw (G20522). Be careful not to jam the Tube into the Feed Gears, instead back the Tube out 1/32" (.5mm) before tightening the set screw. Slip the Wire Guide Spring Bracket onto the Wire Tube and rotate it until the wire is feeding into the Head in the most direct line possible. Tighten the Socket Head Cap Screw (G20288) to hold the Wire Guide Spring Bracket Assembly in place.

Attach the Clincher Plate Assembly to the clincher mounting rail of the stitcher machine using the Clincher Plate Nuts (G50710) and two (2) Clincher Plate Binder Bolts (9088) provided. Center the Clincher Slide (9093A) under the Driver Bar (G50151) and the Driver (G50152) of the G5. Tighten the Nuts once the correct position has been established. See **Figure 2**.

Mounting (Figure 3)

The quality and quantity of work that can be produced by the DeLuxe Stitcher Heads is dependent upon the operator making the various operating adjustments as accurately as possible. The following illustrated instructions are provided so that the operator will clearly understand how to make the various required operating adjustments.

***Note: The 4mm T-Handle Wrench will be required for mounting and removing the Stitcher Head**

The G5 Head Models come with a Clamp Block (G50101) and a long Socket Head Cap Screw (G50126) for use on stitchers with a T-Slot mounting rail. Refer to **Figures 2 & 3**. Loosen the Cap Screw until the Clamp Block can be removed from the Head. Slide the Clamp Block into the T-slot on the stitcher, as shown. Next, mount the Head onto the Clamp Block and against the stitcher machine. Visually, make sure the Head is as vertical as possible. Begin to tighten the Cap Screw (G50126) even before lining up the Driving Slide with the rail on the Stitcher Machine. Next, make sure the Driving Slide (G50162A) is positioned in its slot on the stitcher machine. Use a 4mm T-Handle Wrench, in the Cap Screw, to secure the G5 Head to the stitcher machine.

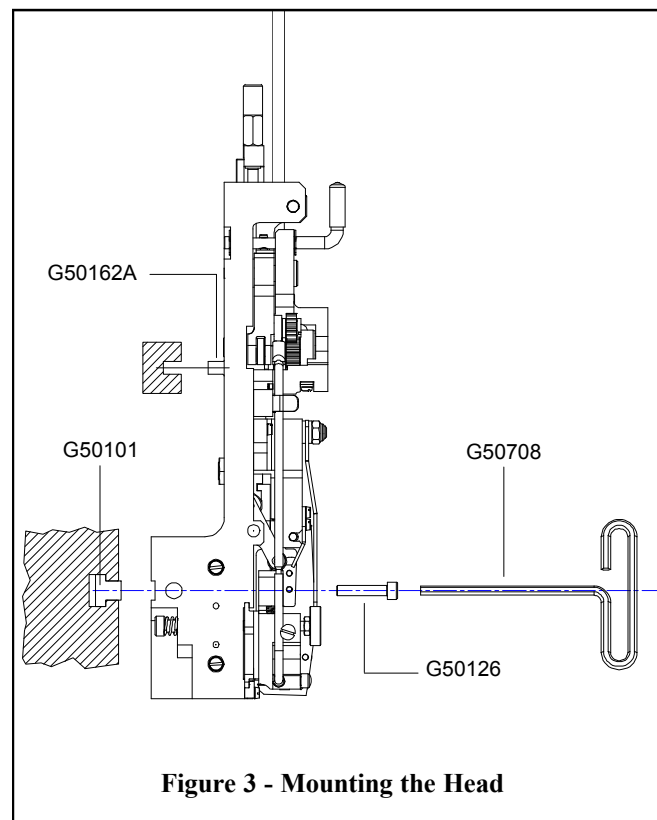


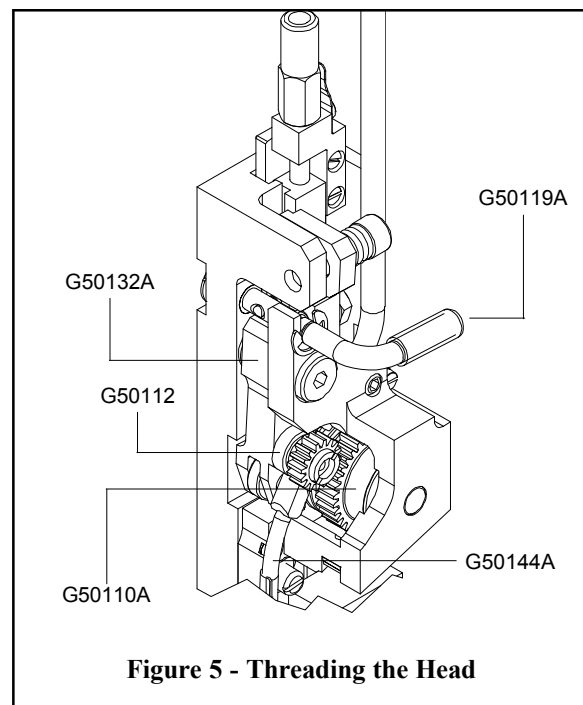
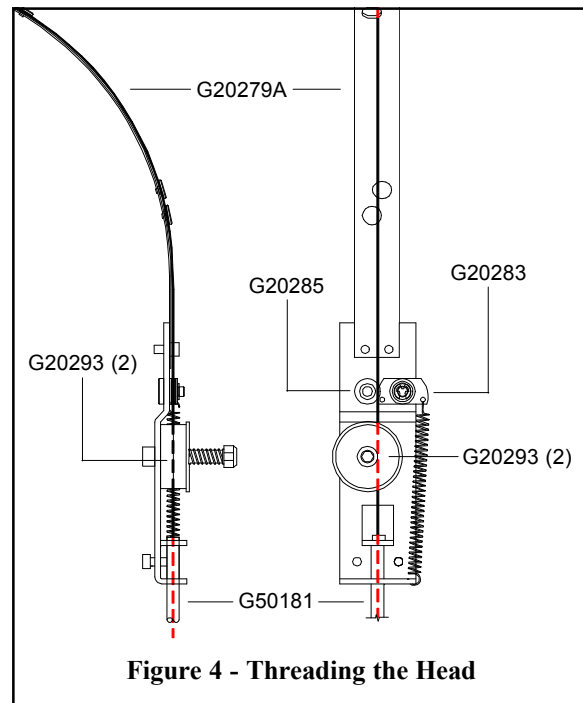
Figure 3 - Mounting the Head

Operation

Wire Threading (Figures 4 & 5)

1. Pass the wire from the Spool over the Wire Guide Spring Assembly (G20279A), between the Tension Pawl (G20283) and the Tension Pawl Roller (G20285), between the two (2) Wire Oiler Felts (G20293) and into the Upper Wire Tube (G50181).
2. Make sure the Feed Release Handle (G50119A) is turned horizontally so that the Small Feed Gear (G50112) on the Feed Lever Assembly (G50132A) is disengaged from the Large Feed Gear Assembly (G50110A). Use a pair of pliers to gently pull the wire off the Wire Spool and guide it through the Upper Wire Tube, between the Small and Large Feed Gears, into the Middle Wire Tube Assembly (G50144A). Turn the Feed Release Handle counter-clockwise so that the Small and Large Feed Gears are engaged.
3. Turn the stitcher machine on and trip it until the wire emerges from the Fixed Wire Cutter (G50200) in the Cutter Box Assembly (G50197A).

Note: Never operate the Stitcher Head with the Wire Holder Assembly (G50559A) in place unless there is stock above the Clincher Points.



Wire Straightening (Figure 6)

In order to ensure the stitches are loaded, driven and clinched properly in addition to ensuring continuous operation of the G5 style heads, it is important that the wire exits the Wire Holder Assembly (G50559A) in a reasonably straight vertical line. **Wire straightness is preset at the Factory and generally does not have to be changed.** If it does, the Wire Straightener (G50206) may not be set properly. Use the following steps for making the adjustments necessary to achieve relative wire straightness.

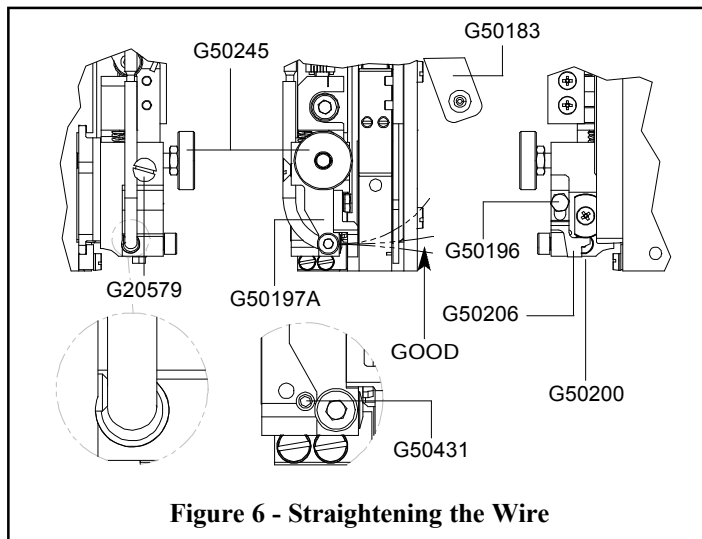


Figure 6 - Straightening the Wire

Horizontal Adjustment

Slide the Wire Holder Retaining Spring (G50183) over to the side and remove the Wire Holder Assembly (G50559A) from the Stitcher Head. Make sure the Small and Large Feed Gears are engaged by turning the Cutter Box Adjustment Knob (G50245) to a vertical position. Activate the stitcher and observe the wire exiting from the Fixed Wire Cutter (G50200) in the Cutter Box Assembly (G50197A). If the **wire curves upward severely**, loosen the Hex Head Cap Screw (G50196) which secures the Wire Straightener (G50206)

and move the Straightener down. Be sure to tighten the Screw again and continue to watch the wire exiting the Wire Cutter.

Note: Moving the Straightener too low may cause a kink to appear in the wire that will cause poor stitch quality.

If the **wire curves downward**, loosen the Cap Screw and move the Straightener up. Tighten the Cap Screw again and resume feeding wire through the Head. Adjust the Wire Straightener until the wire exits the Fixed Wire Cutter with a slight upward curve. Replace the Wire Holder and re-engage the Wire Holder Retaining Spring. Test the wire's straightness by activating the stitcher and loading a piece of wire into the Wire Holder.

Side-to-Side Adjustment

If the wire fails to feed past the Bender Bar or Wire Straightener, a slight side-to-side adjustment can be made. First loosen the Flat Head Machine Screw (G20579) securing the Lower Wire Tube (G50199) to the Cutter Box. Then turn the Socket Head Set Screw (G50431) counter-clockwise to move the Wire Tube toward the front of the Head or clockwise to move the Tube toward the back of the Head.

Adjusting the Length of the Stitch Leg (Figure 7)

The following instructions illustrate how to calibrate the G5 Stitcher Head the first time it is used after mounting it to the stitcher machine. It also illustrates how to adjust the Cutter Box when a different stitching capacity is required.

Adjust the compression setting on the stitcher machine for the capacity of work to be stitched if applicable. Make a few sample stitches and turn the stock away from you to look at the results.

The length of each staple leg should equal the other, meaning, the amount of wire on either side of the stitch gap should be the same. The gap position is controlled by the position of the Cutter Box Assembly (G50197A). As thicker work is stitched, the Cutter Box must be moved further from the Wire Holder Assembly in order to keep the legs of the stitch even and the gap centered.

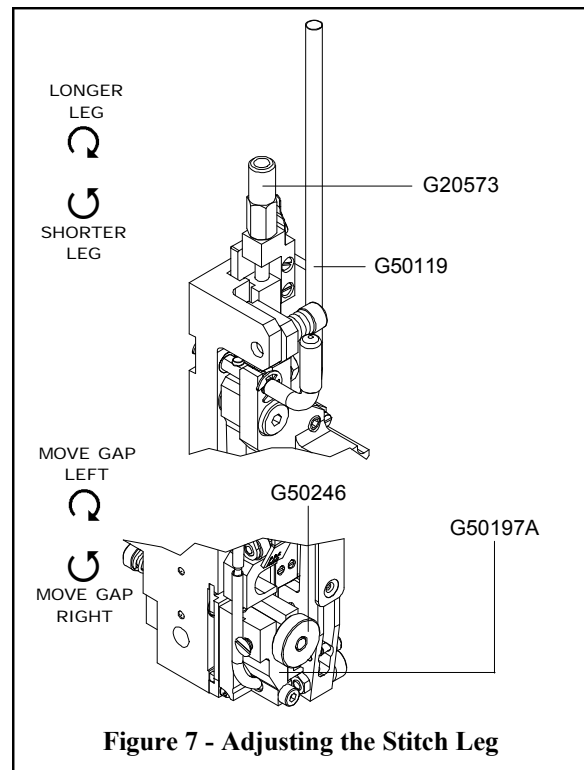


Figure 7 - Adjusting the Stitch Leg

Machines With Compression Adjustment

First, make sure the wire feeding is off by turning the Feed Release Handle (G50119A) clockwise so that the Small Feed Gear (G50112A) on the Feed Lever (G50132A) is disengaged from the Large Feed Gear Assembly (G50110A). Refer to **Figure 8**. To shorten the length of the left staple leg, lengthen the length of the right staple leg or move the gap between the legs to the left, adjust the compression of the machine to match the work being bound and turn the Cutter Box Adjustment Knob (G50245) clockwise. Return the Feed Release Handle to its original position and run a couple of stitches to test this setting.

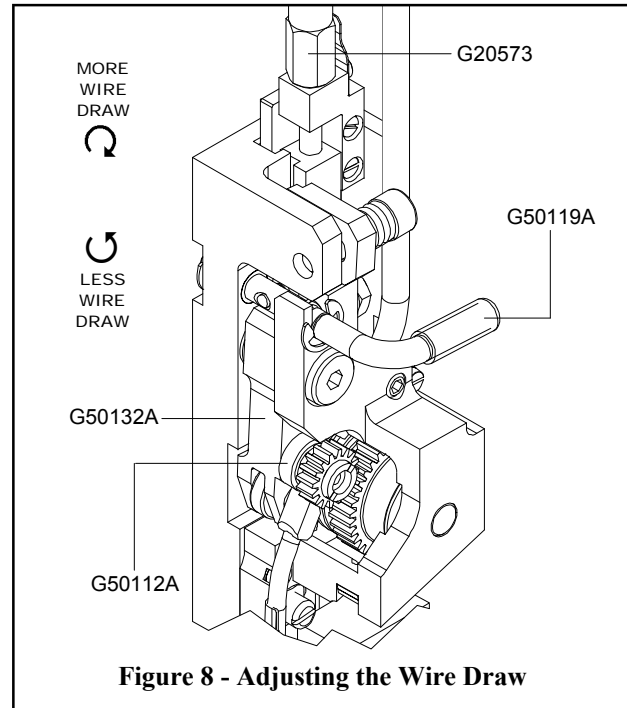
Once the gap is centered, make sure that it is the desired width. As the thickness of work being stitched increases, the length of wire required must also increase. The longer the length of wire required, the further up the Feed Rack has to be in comparison to the Feed Slide. The overall length of wire is correct when the gap between the staple legs allows only the edge of a fingernail to pass between them. If the gap is too large, increase the wire draw by turning the Feed Rack Adjustment Knob (G20573) clockwise. Alternatively, if the gap is too small, decrease the wire draw by turning the Feed Rack Adjustment Knob counter-clockwise.

To lengthen the length of the left staple leg, shorten the length of the right staple leg or move the gap between the legs to the right on these same machines: turn the Cutter Box Adjustment Handle counter-clockwise. If both legs are equal in length or if the gap between the legs is centered, no more adjustment is necessary. At thicker compression settings, fine adjustment of the Feed Rack Adjustment Knob may be necessary.

Machines Without Compression Adjustment

Similarly, when the G5 is mounted on a machine without a compression setting, turn the wire feeding off. Adjust the Cutter Box Adjustment Knob until the gap between the staple legs is centered. Next, turn the Feed Rack Adjustment Knob until the wire draw is correct and the length of the staple legs is satisfactory. Return the Feed Release Handle to its original position and run a couple of stitches to test this setting.

But unlike machines with compression adjustments, when there is a change in the material to be bound, both the Cutter Box Adjustment Knob and the Feed Rack Adjustment Knob have to be adjusted each time. Run a couple of stitches to test this setting.



Aligning the Wire Holder

The wire held in the Wire Holder (G50559A) must be positioned exactly under the grooves in the Bender Bar (G50147A) to properly form a stitch. This is set at the Factory but may need to be adjusted when installing replacement parts. To check this alignment use a mirror to see the Head from below. Checking alignment is easiest if a piece of wire is in place in the Wire Holder and the Bender Bar is just about to bend the wire. This test can also be performed on heads that are not currently mounted to a machine.

The Wire Holder is adjusted by loosening the Hex Nut (G20226) located on the side of the assembly using the Open End Wrench (G50707). Use the 3mm Hex Key Wrench (G20360) to turn the Eccentric Screw (G50665) clockwise until it is all the way in and then to turn it counter-clockwise until the proper position is reached. To lock in place, keep the Eccentric Screw in place using the Hex Key Wrench and tighten the Nut using the Open End Wrench.

Make sure all guards are in place before operating the stitcher head

WARNING

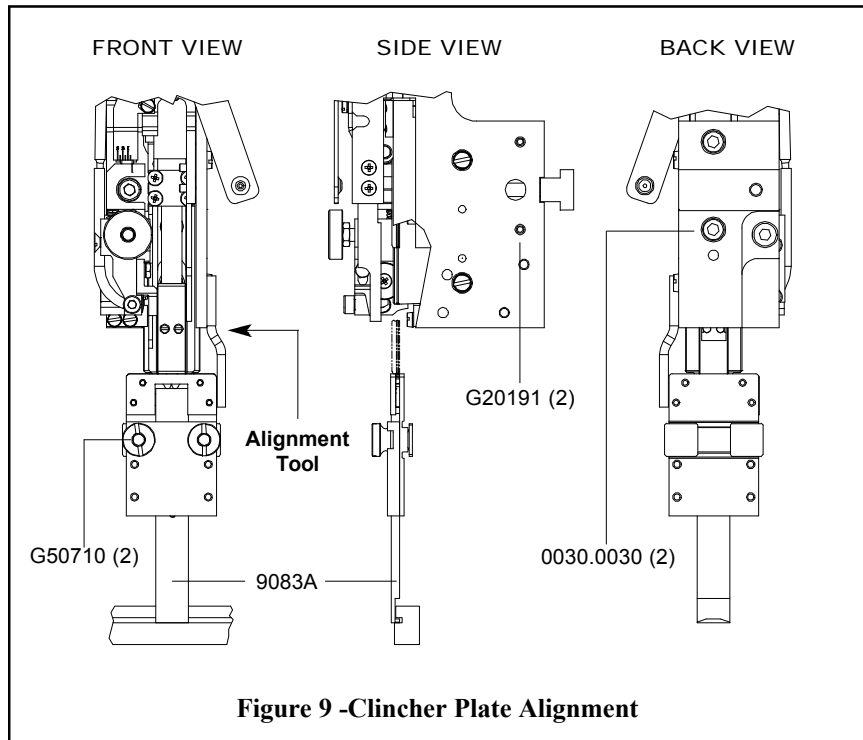
Aligning the Clincher Plate (Figure 9)

In order to produce properly clinched staples, the center of the Clincher Plate must be exactly in line with the Driver both left-to-right and front-to-back. The following are instructions for both types of adjustment.

Front-to-Back

Manually activate the G5 until the Stitcher Head is at the bottom of its stroke and the Driver is touching the top of the Clincher Plate. Looking from the side of the Stitcher Head, make sure the rib of the Driver is aligned with the center of the gap between the front and back plates of the Clincher Plate Assembly. All adjustments to this setting are made by adjusting the screws in the back of the G5 while the Head is removed from the Stitcher Machine. First, loosen the Set Screws (G20191) securing these Screws. If the Driver is positioned in back of the Clincher Plate then the lower Socket Head Cap Screw (0030.0030) must be turned counter-clockwise until the Screw sticks out slightly from the back of the Head, while the upper Screw remains under flush. If the Driver is positioned in front of the Clincher Plate then the upper Socket Head Cap Screw must be turned counter-clockwise until it sticks out slightly from the back of the Head, while the lower Screw remains under flush. Slight adjustments to the Set Screws make significant differences in position. Once the position is set, tighten the two (2) Socket Head Set Screws (G20191) in the side of the Stitcher Head.

***Note: In most cases, front-to-back adjustment will not be necessary.**



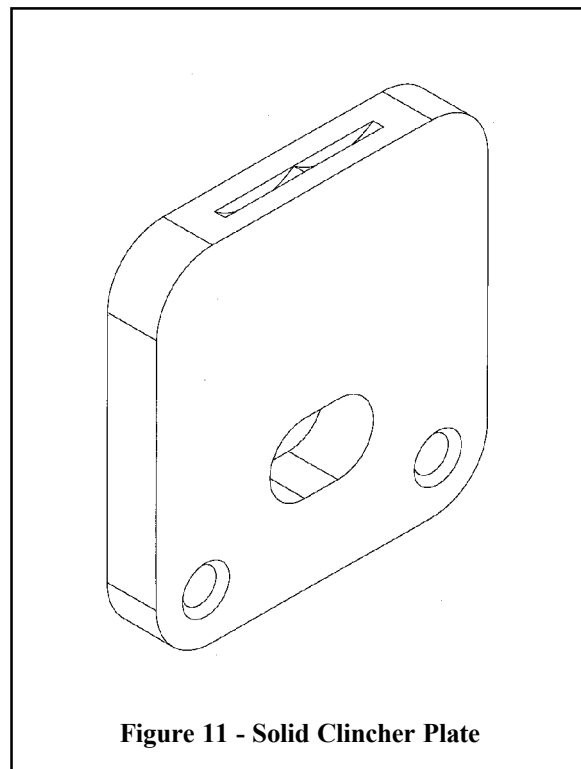
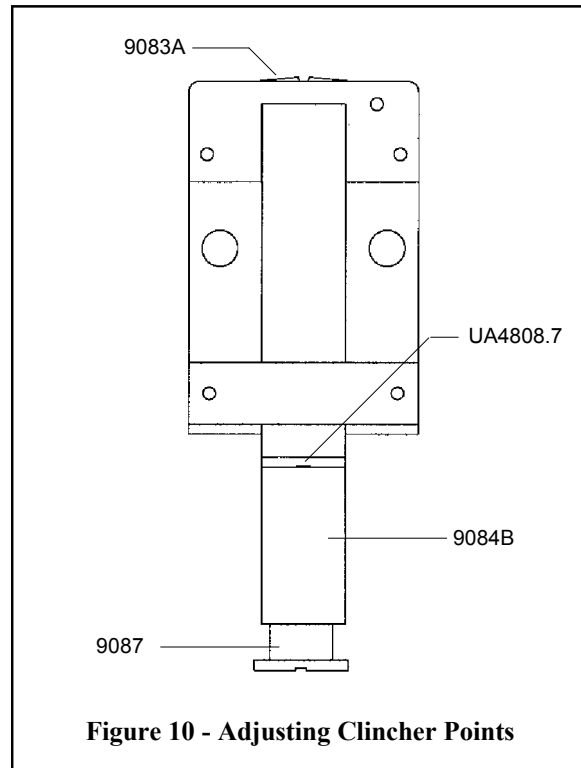
Adjusting the Clincher Points

Left-to-Right

Looking from the front of the Stitcher Head, make sure the Driver is centered directly above the Clincher Slide (9084B) while using the Clincher Plate Alignment Tool (G50702). If it is not, loosen the two (2) Clincher Plate Nuts (G50710) and move the entire Clincher Plate Assembly to the right or to the left. Secure this position while tightening the Screws.

The final position of the Clincher Points should be flush, or slightly above flush, with the Clincher Plate in order to achieve a quality stitch. The best way to see the position of the Clincher Points is to manually turn the stitcher machine over. When the Driver is at the lowest position of its stroke, the Clincher Points are at their highest position. Turn the stitcher machine just past this point to reveal the Clincher Points' position. Clincher Points that do not pivot high enough will produce a weak clinch, where Clincher Points that pivot too high will cause poor stitch quality or cut the stock being stitched.

If the clinch on the staple is not tight enough, the Clincher Points 9083A have to be raised, assuming the Stitcher machine's compression setting is correct. If the legs of the staple are being pushed back through the stock, the Clincher Points are set too high and have to be lowered. These adjustments are specific to each stitcher machine and cannot be fully explained in this manual, since many Machines have Clincher Lever adjustments built in. Consult the stitcher machine's operating manual for complete Clincher Point adjustment instructions. The G5 Head comes with an optional Adjustable Clincher Plate, as illustrated in **Figure 10** and so some adjustment can be made to the Clincher Points as follows. Loosen the Set Screw (UA4808.7) on



the top of the Clincher Slide (9084B). Turn the Clincher Slide Adjustment Screw (9087) clockwise to lower the Clincher Points and turn the Clincher Slide Adjustment Screw counter-clockwise to raise the Clincher Points. Once the Clincher Point height is set, tighten the Set Screw on the front of the Clincher Slide.

Some style stitcher heads do not utilize moving Clincher Points, but rather a solid Clincher Plate as shown in **Figure 11**. The legs of each stitch are bent when the wire is pushed through the stock and hits the Clincher Plate, as opposed to the Clincher Points in moveable Clincher Plates coming up to meet the wire. The resulting stitch will not lay as flat as one clinched with moving Clincher Points though. The only adjustment that can be made to a Solid Clincher Plate is to make sure it is centered below the Head's Driver and even that adjustment can only be made on multi-head stitcher machines.

The following, are examples of a flat clinch, made with moveable Clincher Points and of a solid clinch, made with a solid Clincher Plate. The only difference between the resulting staples is aesthetic.



FLAT CLINCH



SOLID CLINCH

Maintenance

Your G5 Stitcher Head has been fully lubricated at the factory, but to insure continuous superior operation and a longer life of the head, the operator should be sure that the G5 is lubricated regularly and carefully maintained. The operator should periodically inspect all moving parts for signs of wear and when required, replace the worn parts. Parts such as the Wire Cutters, the Clincher Points and the Driver are subject to wear and have been so designed to be reversible to provide multiple cutting and driving surfaces. If after continuous usage, the original cutting or gripping surfaces of any of these parts show signs of wear, their position in the head can be reversed, thereby providing a new surface and lengthening the life of the part. For a complete list of wear and replacement parts for your G5 style Stitcher Head, refer to page 50 in the back of this manual.

The following instructions are provided so that the operator will clearly understand how to lubricate the Stitcher Heads and how to identify and remove any of the parts which may need to be replaced.

Always disconnect the power supply before making any adjustments or servicing the head.

⚠ WARNING

Lubrication (Figure 12)

Use any standard S.A.E. #10 oil for lubricating the heads. Heads that are in constant operation (at speeds exceeding 6,000 stitches per hour) should be lubricated weekly or once every 250,000 stitches. Heads that are operated periodically should be lubricated every 120,000 stitches or every third five pound wire spool change, whichever comes first. Usually, only a drop of oil is required at each lubrication point. Care must be taken that those parts of the head that contact the work to be stitched are free of oil. Lubricate regularly instead of excessively. Excessive oiling will result in work becoming spotted with oil. Use one drop of oil in the following lubrication points:

- the top of the Bonnet (G50100) on either side of the Feed Slide (G50131).
- where the Wire Holder Assembly (G50559A) pivots in the Pivot Block (G50143).
- on the Cutter Slide (G50198)
- on the Wire Oiler Felts (G20293).
- under the Wire Holder Retaining Spring (G50183).
- in the oil cup of the Small Feed Gear Shaft Assembly (G50262A) securing the Small Feed Gear to the Feed Lever.

Cleaning (Figure 12)

In addition to proper lubrication, routine cleaning is important for the maintenance of your G5 Head. Blow off dust, dirt and build-up with compressed air at least once a month. The entire Head should be torn down and the following areas thoroughly cleaned every one million stitches:

- **Large Feed Gear Assembly (G50110A):** remove and wash in an petroleum-based, oil-dissolving solvent, dry and repack the Feed Gear with any general Lithium-based Grease.
- **Anywhere that dust, oil or pieces of wire and paper have built up** - for example: around the Clincher Points and by the Left and Right Forming Pin Cams (G50115L & G50115R). Remove the Wire Holder and blow clean with pressurized air

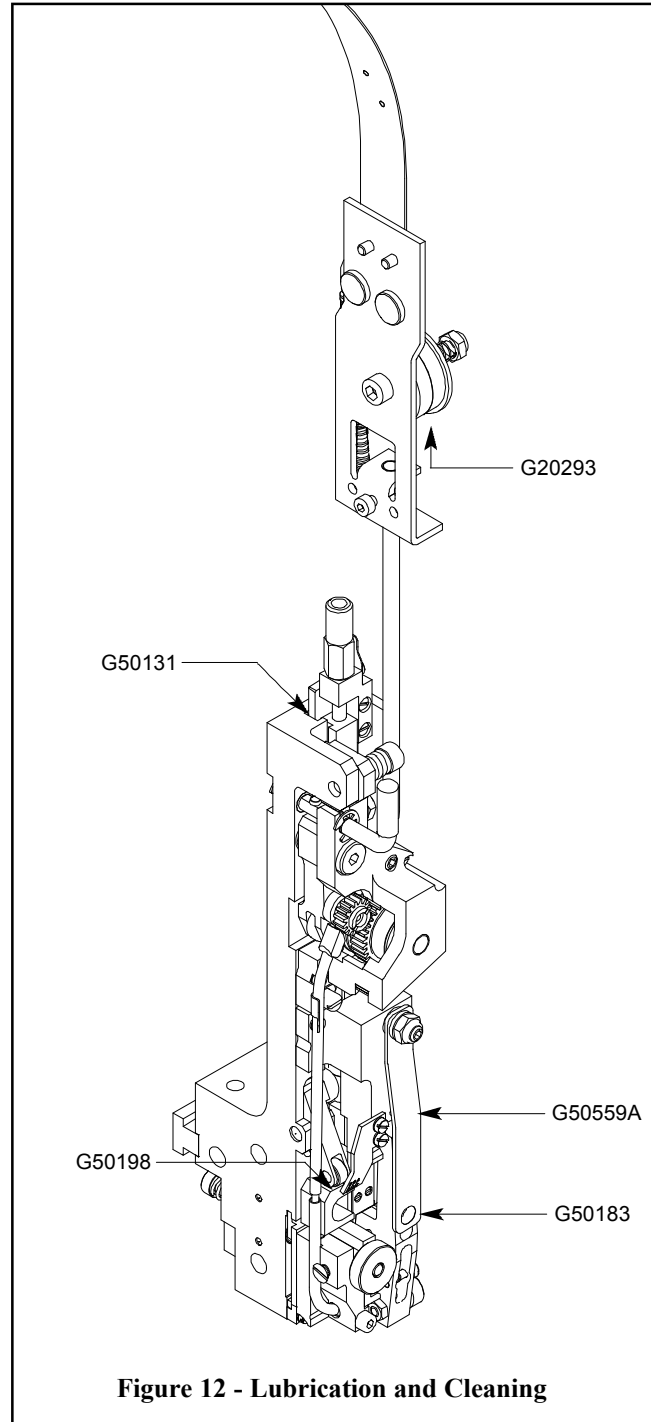


Figure 12 - Lubrication and Cleaning

Contact the DeLuxe Stitcher Graphic Arts Representative from whom your Stitcher Head was purchased and inquire about having a complete diagnostic evaluation performed on your G5.

Ordering Spare Parts

In time, you will need to replace some parts in your G5 style Stitcher Head. When this happens, first locate the needed part in one of the following diagrams. Then locate the DeLuxe Stitcher part number and contact your Graphic Arts Representative to order the part by the part number, description and quantity.

Always power down the stitcher machine before any maintenance or adjustments are made to the stitcher head.

CAUTION

Replacing Spare Parts (Figure 13)

The following are some of the more common wear parts which will need to be removed and replaced in your G5 style Stitcher Head. Some common replacement parts do not require the Stitcher Head to be removed from the stitcher machine. These parts will be addressed first, then a more specific explanation for disassembling and replacing wear parts for the G5 Head will follow.

Removing and Replacing the Clincher Points (Figure 14)

The Clincher Point (9083A) is double-sided so that when one side is worn, it can be reversed to provide a new clinching surface and increase the life of the part. A worn Clincher Point may cause poorly formed staple legs.

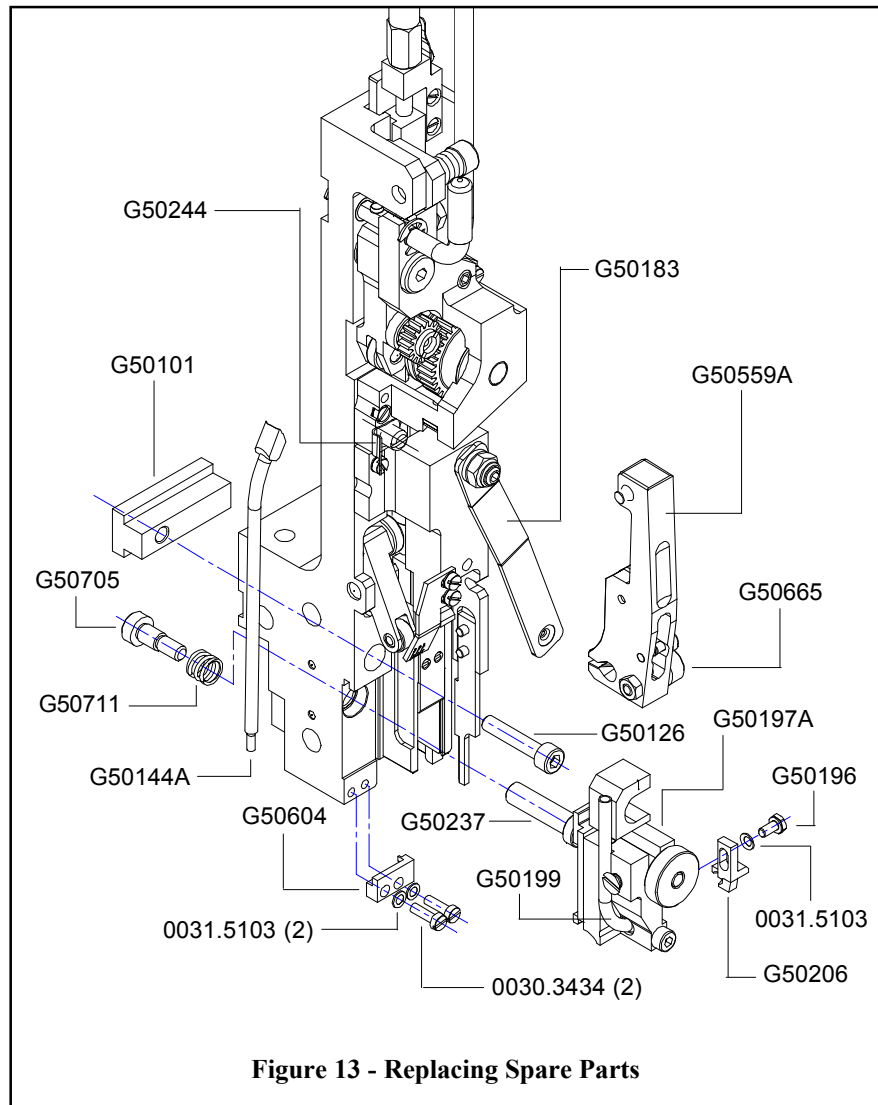


Figure 13 - Replacing Spare Parts

Loosen, but do not remove, the two (2) Clincher Plate Nuts (G50710) until the Clincher Slide (9084B) can be disengaged from the stitcher machine and slid out of the Clincher Plate Assembly (9086A) or down within it. Rotate the Clincher Points upwards until they can be pulled out. Reverse the Points when one of their sides is worn or chipped or replace them. Rotate the Clincher Points downward before replacing the Clincher Slide. Make sure the Points are engaged by the Slide before tightening the Clincher Plate Nuts.

Removing and Replacing the Driver Figure 15

Swing the Wire Holder Retaining Spring (G50183) out of the way and remove the Wire Holder Assembly (G50559A). Remove the Driver Retaining Screws (G50153) and slide the Driver (G50152) down and out of the Bender Bar Assembly (G50147A). Since the Driver is reverseable, it can be rotated and replaced or a new Driver can be inserted into the grooves in the Bender Bar until it stops against the edge of the Driver Bar (G50151). Replace the Driver Retaining Screws after applying a light duty locking compound to them, then replace the Wire Holder Assembly and Wire Holder Retaining Spring.

Disassembling the Stitcher Head (Figure 13)

Remove the G5 style Stitcher Head from the stitcher machine by loosening and removing the long Socket Head Cap Screw (G50126) securing it to the Clamp Block (G50101). Remove the Head from the stitcher machine and place it on a clean work area.

Swing the Wire Holder Retaining Spring (G50183) away from the G5 and remove the Wire Holder Assembly (G50559A). Snap the Middle Wire Tube (G50144A) out of the Middle Wire Tube Clip (G50244) and remove it from the Lower Wire Tube (G50199A) in the Cutter Box Assembly (G50197A).

Move the Cutter Box Assembly (G50197A) away from the Bonnet by turning the Cutter Box

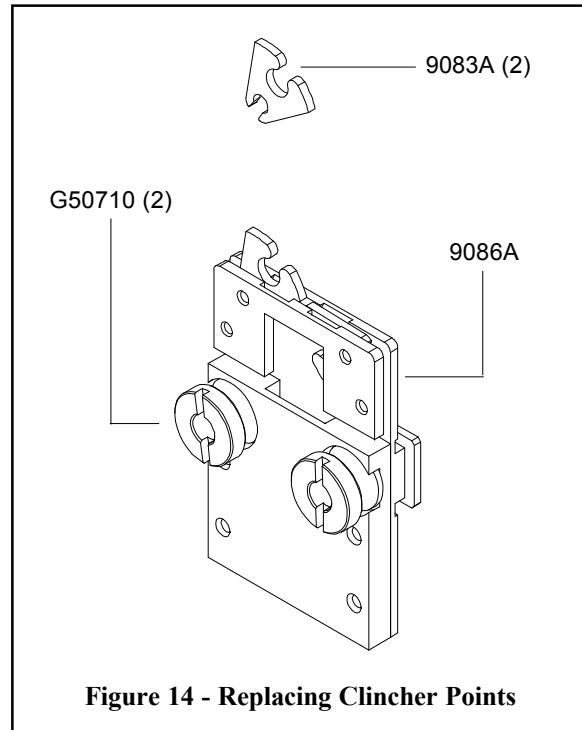


Figure 14 - Replacing Clincher Points

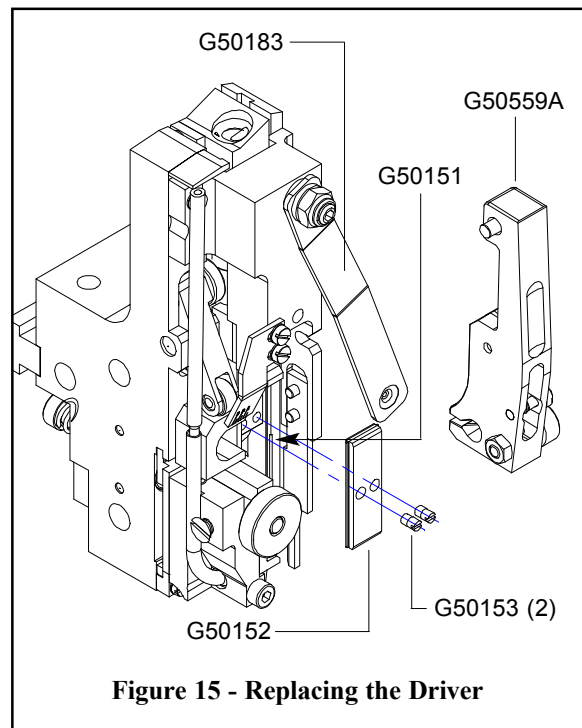


Figure 15 - Replacing the Driver

Adjustment Knob (G50245) counter-clockwise. Loosen and remove the two (2) Flat Head Cap Screws (G50399), securing the Cutter Box to the Cutter Box Mounting Plate (G50391). Turn the Hex Jam Nut (G50713), behind the Cutter Box Adjustment Knob, slightly clockwise to unlock the Knob. Continue to turn the Knob counter-clockwise to remove it from the Cutter Box Adjusting Eccentric (G50237). Remove the Hex Jam Nut as well. Pull the Cutter Box away from the Head. Loosen and remove the Hex Head Cap Screw (G50196) securing the Wire Straightener (G50206) to the Cutter Box.

Removing and Replacing the Wire Cutters Figures 16 and 17

The Moving Wire Cutter (G50145) has several cutting surfaces, each of which may be used by rotating the Cutter's position on the Cutter Operating Slide (G50198). Dull Cutters can cause poor stitch quality. To change or reverse the Moving Wire Cutter, first remove the complete Cutter Box Assembly (G50197A) from the stitcher head (see **previous instruction**) and the Wire Straightener (G50206) from the Cutter Box. Remove the Cutter Slide and the Cutter Operating Spring (G50210) from the Cutter Box. Loosen the Flat Head Machine Screw (G50383) securing the Cutter to the Slide and rotate the Cutter until a new cutting surface is exposed. If there are no more sharp edges available, remove the Screw completely and install a new Moving Cutter. Replace the Machine Screw and be sure to tighten it completely so that the Cutter does not rotate on the Slide.

Like the Moving Cutter, the Fixed Wire Cutter (G50200) can be rotated when the cutting surface is dull or replaced when no sharp surfaces are left. Loosen, but do not remove, the Socket Head Cap Screw (G20589) on the front of the Cutter Box which secures the Cutter. Rotate the Cutter until a new surface is exposed or replace it when completely worn. The Cutter can be rotated three or four times on each end before needing to be replaced. Once the Cutter has been rotated and before tightening the Cap Screw to secure the new position, make sure the Fixed Wire Cutter is aligned correctly within the Cutter Block.

Insert the Cutter Operating Spring (G50210) into

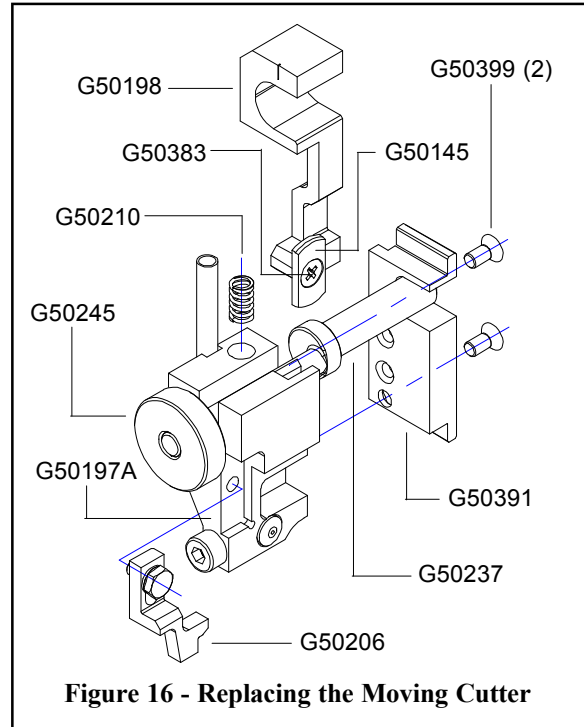


Figure 16 - Replacing the Moving Cutter

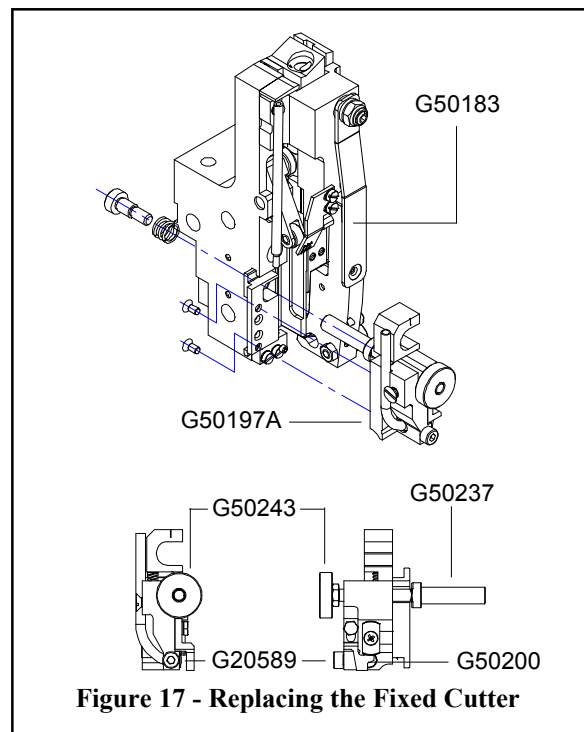


Figure 17 - Replacing the Fixed Cutter

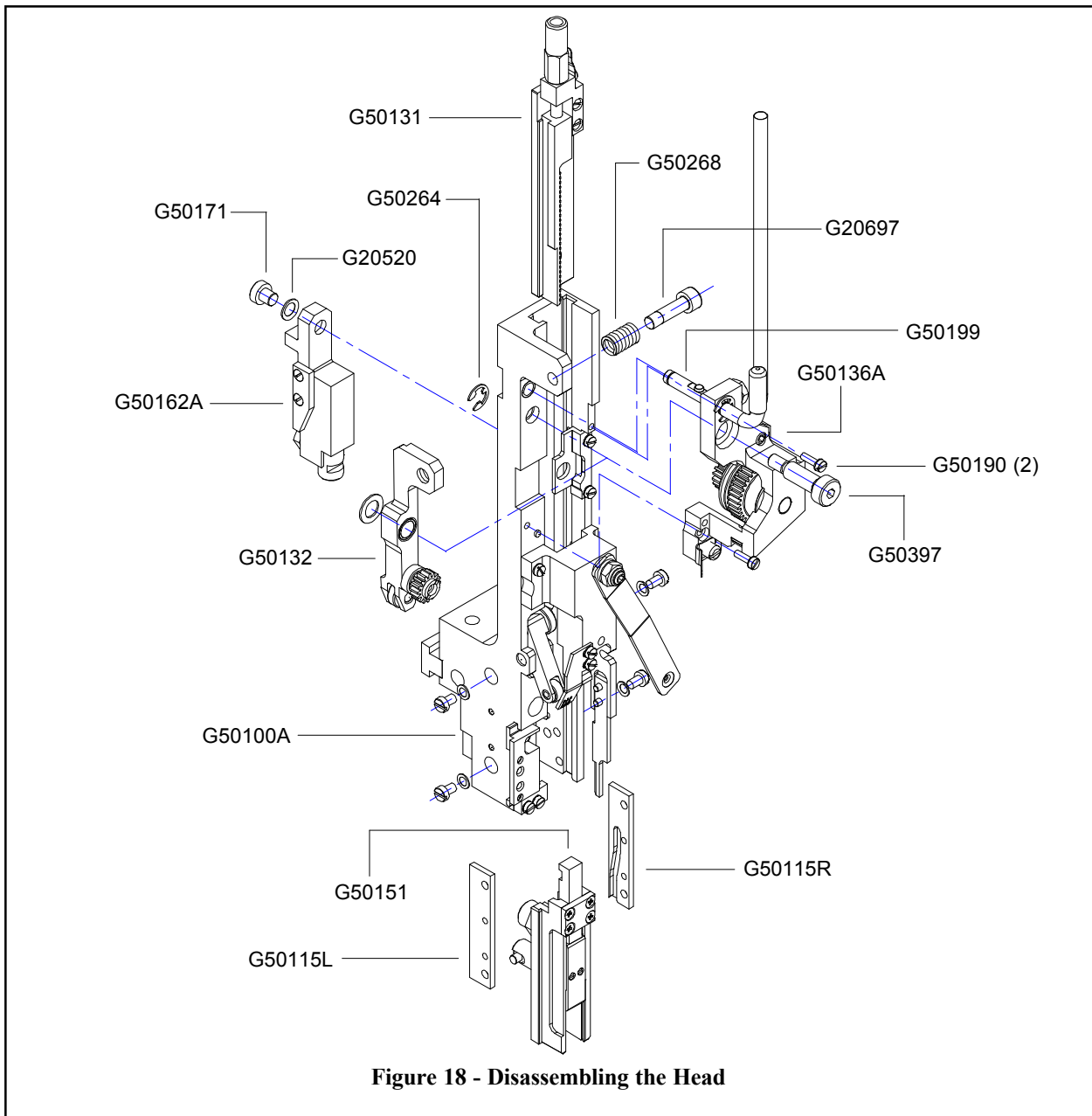


Figure 18 - Disassembling the Head

the slot in the top of the Cutter Block Assembly. Align the Cutter Slide along the groove in the Cutter Box. Compress the Cutter Operating Spring and return the Slide to its position in the Cutter Box Assembly. Slide the Cutter Box over the Cutter Box Adjusting Eccentric (G50237) and secure the Cutter Box to the Mounting Plate with the two (2) Machine Screws. Return the Hex Jam Nut and Adjustment Knob (G50245) to the end of the Adjusting Eccentric. Tighten the Hex Jam Nut (G50713) against the Knob to secure it in position.

In order to obtain a clean edge on the cut wire, there can be no gap between the Moving and Fixed Cutters. Compress the Cutter Operating Slide against the Cutter Operating Spring until the Moving

Cutter just passes the hole in the Fixed Cutter. While holding this position, push the Fixed Cutter against the Moving Cutter, using a small screwdriver as a lever. Tighten the Cap Screw to secure the position of the Fixed Cutter, but be sure to test it once before re-assembling the Cutter Block to the G5 by compressing the Cutter Operating Slide. The Moving Cutter must pass the Fixed Cutter freely and with no visible gap. Take special care not to put too much pressure between the Moving and Fixed Cutters as Cutter Slides may stick in the down position, causing wire jams.

Replace the Wire Straightener to the Cutter Box with the Hex Head Cap Screw through a Ribbed Lock Washer. Typically, the Wire Straighteners can be butted against the stop on the Cutter Box.

Continue to disassemble the G5, by loosening and removing the Socket Head Cap Screw (G20697) securing the Feed Lever Spring (G50268) to the Bonnet Assembly, as well as the Spring itself. **Refer to Figure 18.** Loosen and remove the Socket Head Cap Screw (G50171) securing the Driving Slide Assembly (G50162A) to the Feed Slide (G50131) while paying special attention to the Lock Washer (G20520). Disengage the Driving Slide from the Driver Bar (G50151) and remove the Slide from the back of the Bonnet. Slide the Feed Slide Assembly out the top of the Bonnet and the Bender Bar Assembly out the bottom. Move the Cutter Box all the way to the left to make room for the Bender Bar removal.

Loosen and remove the two (2) Cheese Head Machine Screws (0030.3434) and the Shoulder Bolt (G50397) securing the Feed Gear Bracket (G50136) to the Bonnet Assembly (G50100A). Once the E-Ring (G50264) is removed from the back of the Feed Release Handle (G50199A), the entire Feed Gear Bracket can be removed from the Head. Once the Bracket is removed, the Feed Lever Assembly (G50132A) will no longer be secured to the Bonnet and should be removed as well, along with the Washer (G50714).

Removing and Replacing the Bender Bar, the Friction Plate and the Forming Pin (Figure 19)

After removing the Bender Bar Assembly from the G5 Stitcher Head, remove the Forming Pin Assembly (G50331A) and inspect for wear or damage. Replace the Pin if necessary. Remove the Friction Plug Bushing (G50161), the Bender Bar Friction Spring (G50160) and the Friction Plug (G50159). The Driver Bar (G50151) and Driver (G50152) can be removed from the bottom of the Bender Bar now. Next, remove the four (4) Flat Head Machine Screws (G50383) that secure the Bender Bar Friction Plate (G50148) to the Bender Bar. Replace the existing Friction Plate with a new one and secure it with the four (4) existing Flat Head Machine Screws. Lastly, inspect the Bender Bar for signs of wear or damage. If the Bender Bar itself is worn or broken, replace it with a new one.

Slide the Driver Bar and Driver in through the bottom of the Bender Bar and secure it by replacing the Friction Plug, Friction Plug Spring and Friction Bushing in the back of the Assembly.

Re-assembling the Stitcher Head (Figure 18)

Any of these assemblies can now be taken apart for cleaning or repair. The Bonnet itself can also be cleaned or checked for damage. Reassembling the Head is as simple as reversing the method used to disassemble the Head. Always turn the machine over manually anytime repairs or adjustments are

made for the safety of both the operator and the Stitcher Head.

1. Position the Feed Lever Assembly over the hole in the Bonnet so the Shoulder Bolt in the Feed Gear Bracket can secure both assemblies to the G5.

2. Assemble the Feed Gear Bracket Assembly to the Bonnet by fitting the Feed Gear Bracket over the Dowel Pin located on the Bonnet, lining up the hole in the Feed lever with the hole in the top left corner of the Bracket. Also line up the Feed Gear Shaft (G50114) with the hole in the Feed Gear Plate (G50182). Secure the Feed Gear Bracket with two (2) Machine Screws and one (1) Shoulder Bolt. The teeth of the Feed Pinion Assembly (G50111A) may have to be lined up manually with the teeth of the Feed Rack (G50127).

3. Slide the Feed Slide Assembly into the Bonnet from the top. Make sure the Slide moves freely within the Bonnet but has minimal side-to-side play. Slide the Bender Bar Assembly into the Bonnet from the bottom.

4. Turn the Bonnet over and position the Driving Slide Assembly so that the Driving Slide Plunger (G50164) rests in the notch of the Driver Bar and secure this position with the Cap Screw tightened completely.

5. Slide the Cutter Box over the Cutter Box Adjusting Eccentric and secure the Cutter Box to the Mounting Plate with the two Machine Screws.

Return the Hex Jam Nut and Adjustment Knob to the end of the Adjusting Eccentric and tighten the Hex Jam Nut against the Knob to secure it in position. Make sure the Cutter Box moves freely under the Cutter Box Guide Plate by turning the Adjustment Knob clockwise and counter-clockwise. If it does not, loosen the screws securing the Plate to the Bonnet and readjust them.

6. Return the Wire Holder Assembly to its position under the Wire Holder Retaining Spring and the Middle Wire Tube to its position by inserting it into the Lower Wire Tube and snapping it into place in the Middle Wire Tube Clip.

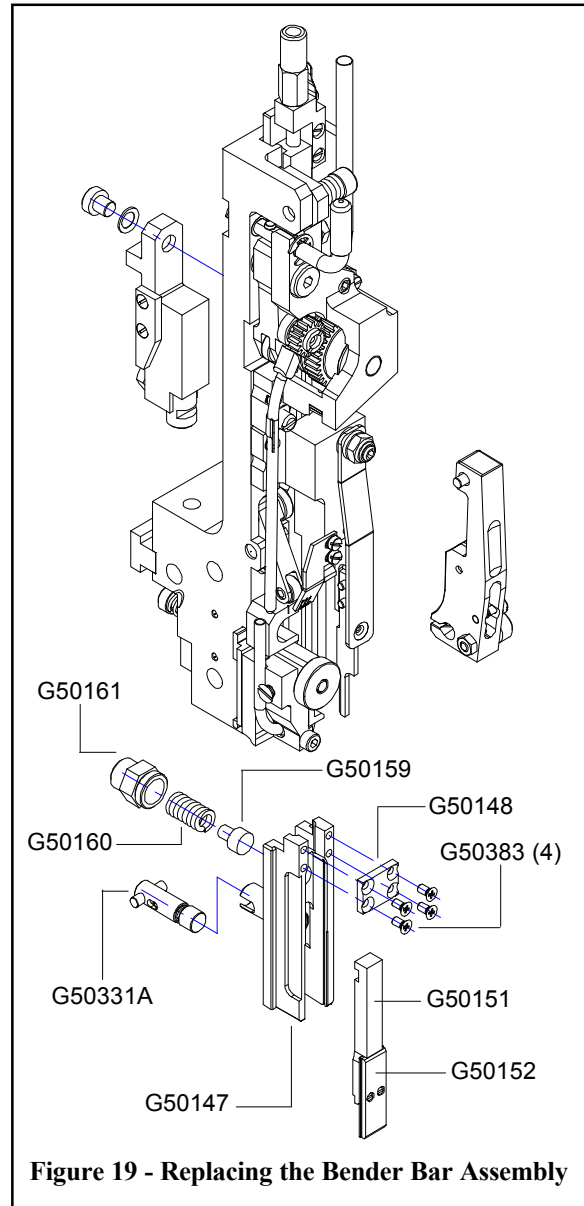


Figure 19 - Replacing the Bender Bar Assembly

Troubleshooting (Figure 20)

The quality and quantity of work that can be produced with the G5 Stitcher Head is dependent upon the operator making all adjustments as accurately as possible and carefully maintaining the head. The cause of staple imperfections usually can be traced to inaccurate settings or normal wear of moving parts. In the event of trouble of this nature occurring, the operator can, by referring to the following troubleshooting chart, quickly locate and remedy the cause or causes of the trouble.

The following is a brief list of problems and solutions which should cover the majority of situations encountered when stitching with the G5 Stitching Head. The cause of staple imperfections usually can be traced to inaccurate settings or normal wear of moving parts. In the event of problems of this nature occurring, the operator can, by referring to the following troubleshooting chart, quickly locate the solutions.




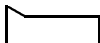

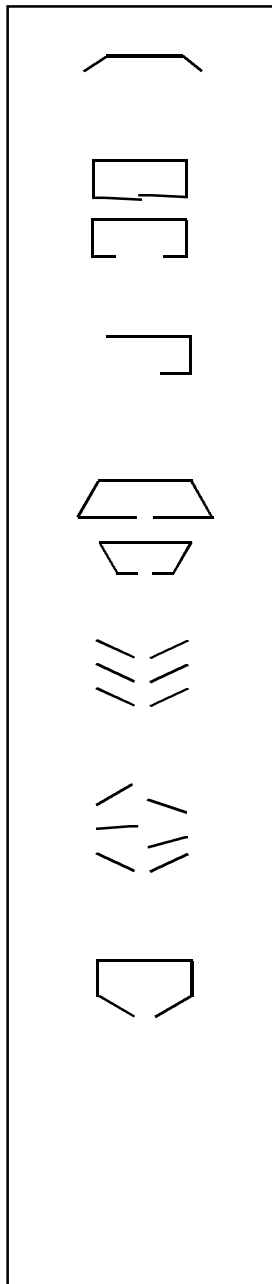
	PROBLEM: Gap Out of Center
	SOLUTION: Lengthen the left leg by adjusting the Cutter Box. (See page 12)
	PROBLEM: Gap Too Big
	SOLUTION: Increase wire draw with the Feed Rack Adjustment Knob, then center stitch gap as described above.. (See page 12)
	PROBLEM: Corner Buckled
	SOLUTION: Check the Driver (G50152) for a chipped corner and rotate or replace it if needed. (See page 20) Check the tensile strength of the wire or use thicker wire.
	PROBLEM: Leg(s) Buckled
	SOLUTION: If the ends of an unformed piece of wire are not smooth, the Wire Cutters (G50145 or G50200) are worn. Check for wear and rotate or replace if needed. (See page 21) Make sure the correct wire size is being used and that the wire is reasonably straight. Wire that is too weak or thin may cause this problem.

Figure 20 - Troubleshooting



PROBLEM: Partially Formed Stitches

SOLUTION: Replace the worn Forming Pin (G50331A). (See page 23)

PROBLEM: Staple Legs Too Long or Too Short

SOLUTION: Correct the overall wire draw by repositioning the Feed Rack within the G5 Head. (See page 12)

PROBLEM: Left Leg Missing

SOLUTION: Straighten the wire. (See page 11) The Wire Holder Assembly is not aligned properly. Align it with the groove in the Bender Bar. (See page 13)

PROBLEM: Legs are Spread or Contracted

SOLUTION: Straighten the wire. (See page 11) Check wire cut-off.

PROBLEM: Legs Stray Forward or Backward Consistently

SOLUTION: The Stitcher Head is not aligned properly front to back. (See page 14) Straighten the wire. (See page 11)

PROBLEM: Stitch Stray Randomly In and Out and Front to Back

SOLUTION: Straighten the wire. (See page 11) Make sure the Cutters are aligned properly. (See page 21) Check the tensile strength of the wire or use thicker wire.

PROBLEM: Loose Clinch

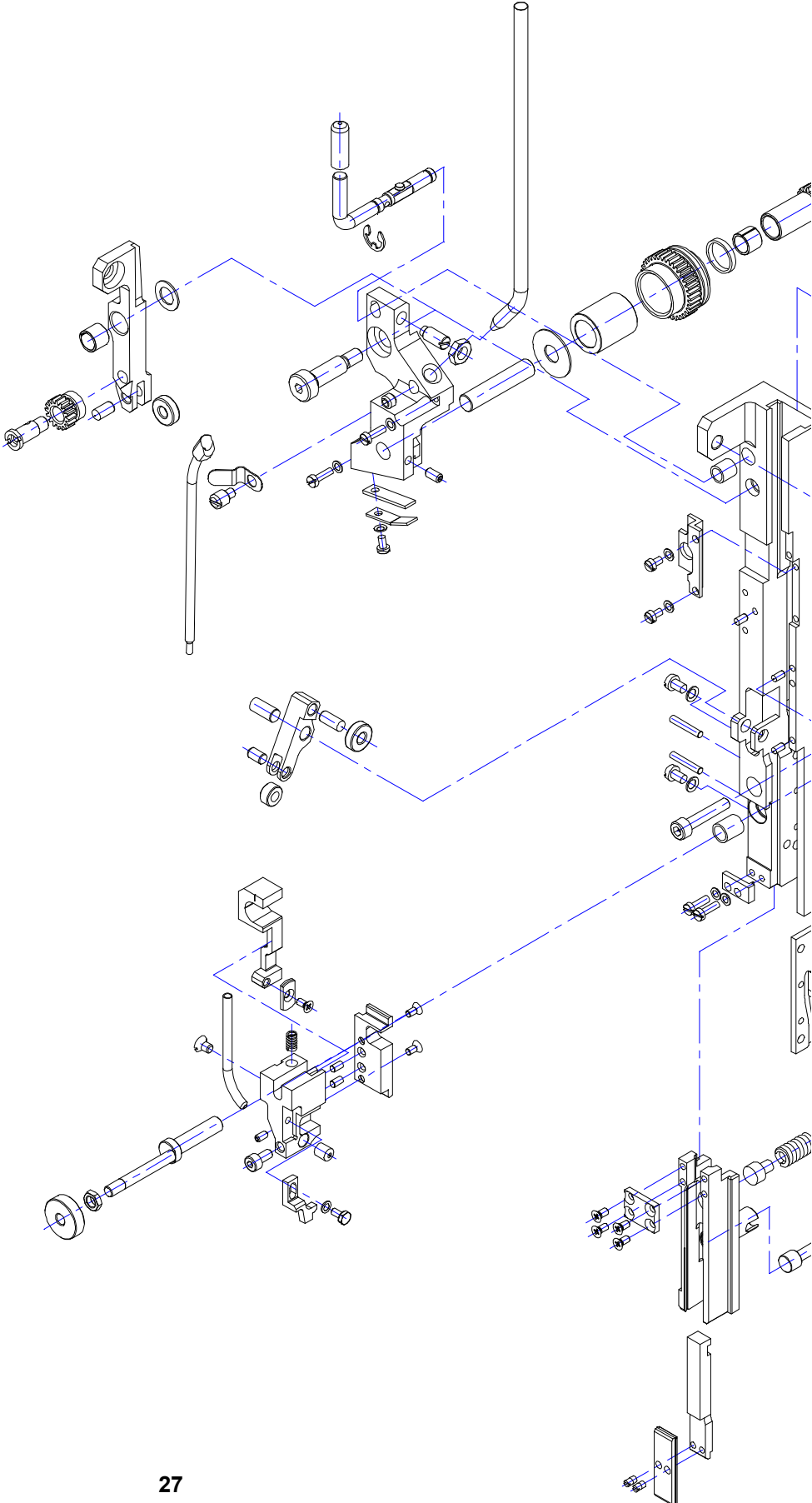
SOLUTION: The Clincher Points are too low and need adjusting. (See page 15) The compression of the stitcher machine is insufficient and needs to be increased.

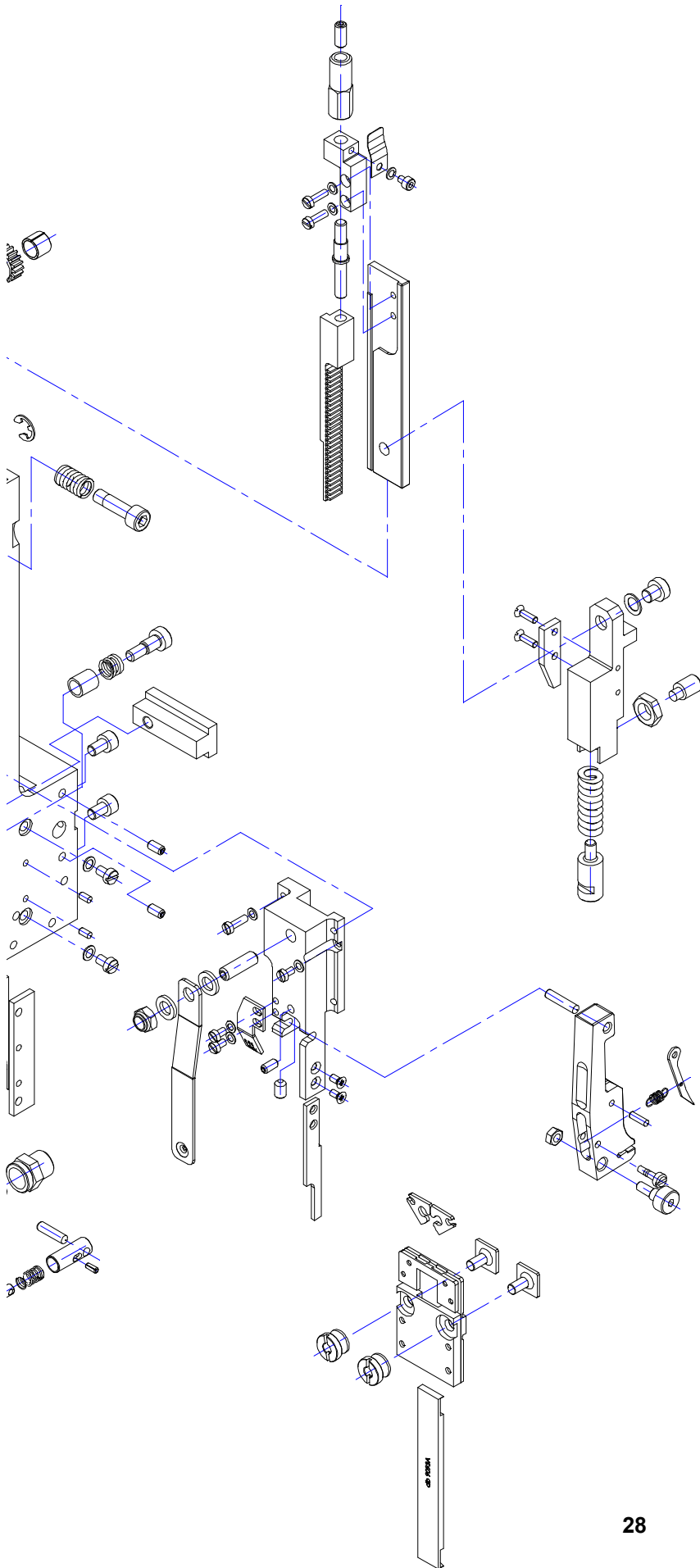
PROBLEM: No wire being drawn

SOLUTION: Make sure the Feed Release Handle is turned to the “on” position and the Feed Gears engaged. (See page 10)

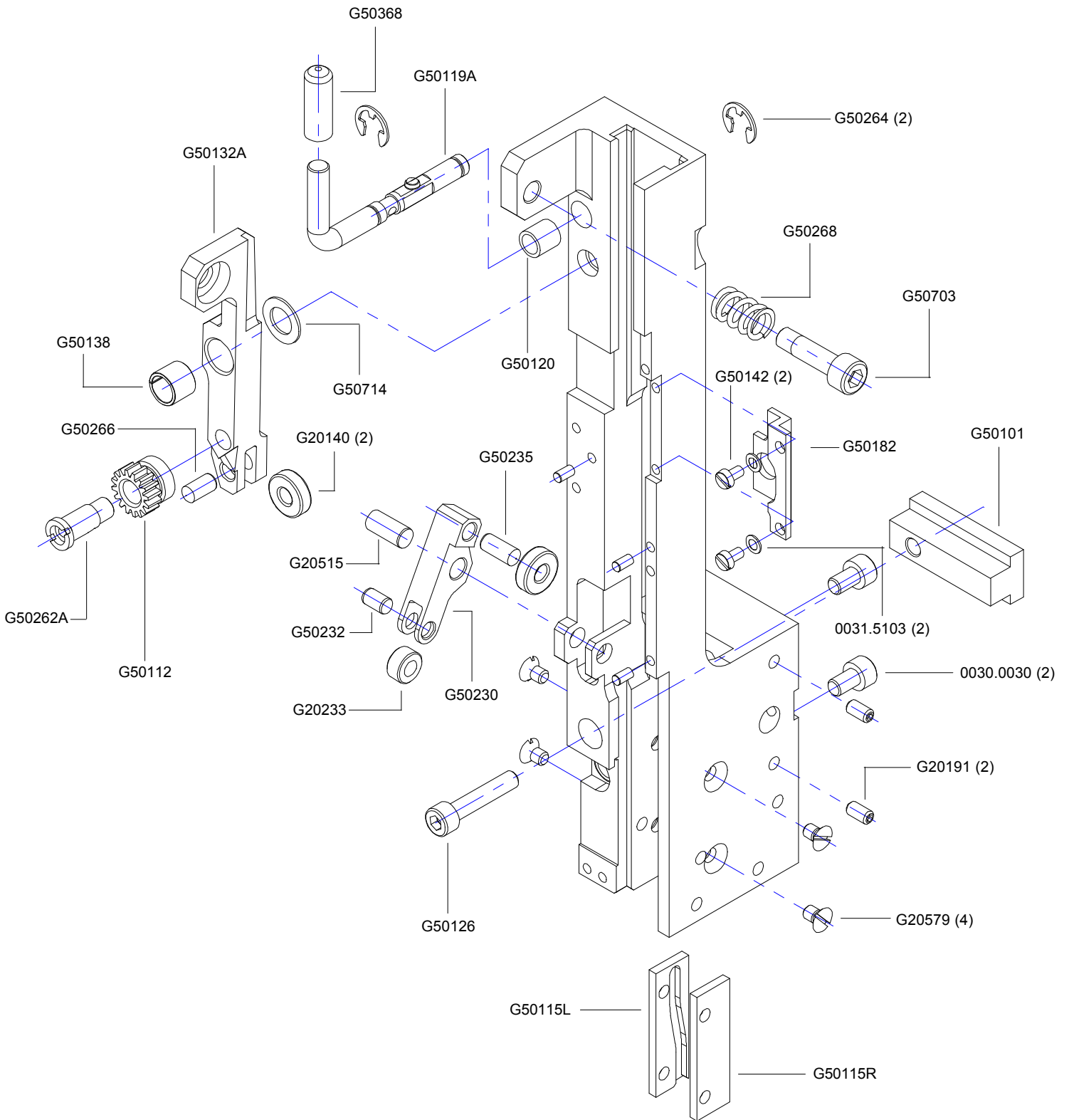
Figure 20 - Troubleshooting

The G5 Stitcher Head





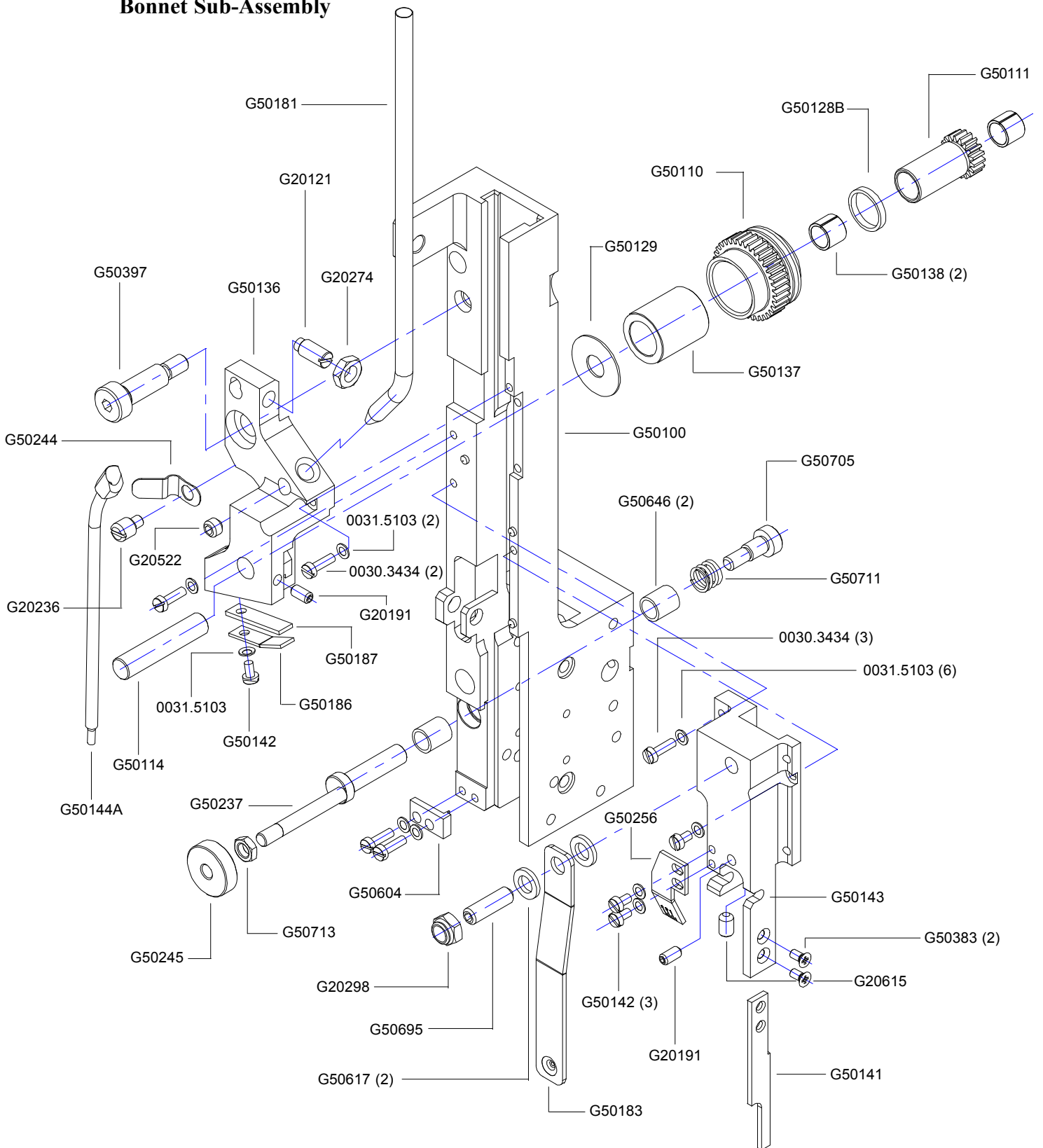
Bonnet Sub-Assembly



Bonnet Sub-Assembly

ITEM No.	DESCRIPTION	QUANTITY
0030.0030	Screw, M5x.8x8 SHCS	2
0031.5103	Lock Washer Ribbed	2
G20140	Follower Ball Bearing	2
G20191	Screw, M4x.7x8, SHSS	2
G20233	Cutter Operating Lever Roller	1
G20515	Dowel Pin M6x14	1
G20579	Screw M4x0.7x6 FHMS	4
G50101	Clamp Block	1
G50112	Small Feed Gear	1
G50115L	Forming Pin Cam, Left	1
G50115R	Forming Pin Cam, Right	1
G50119A	Feed Release Handle Assembly	1
G50120	Feed Release Handle Bushing	1
G50126	Screw, M5x.8x25	1
G50132A	Feed Lever Assembly	1
G50138	Feed Pinion Bearing	1
G50142	Screw, M3x0.5x5, CHMS	2
G50182	Feed Gear Plate	1
G50223	Dowel Pin, M3x6	3
G50230	Cutter Operating Lever	1
G50232	Dowel Pin	1
G50235	Dowel Pin M5 x 12	1
G50262A	Small Feed Gear Shaft Assembly	1
G50264	E-Ring 6mm	2
G50266	Dowel, M5x10	1
G50268	Feed Lever Spring	1
G50368	Feed Release Handle Cap	1
G50703	Feed Lever Spring Screw	1
G50714	Feed Lever Spacer	1

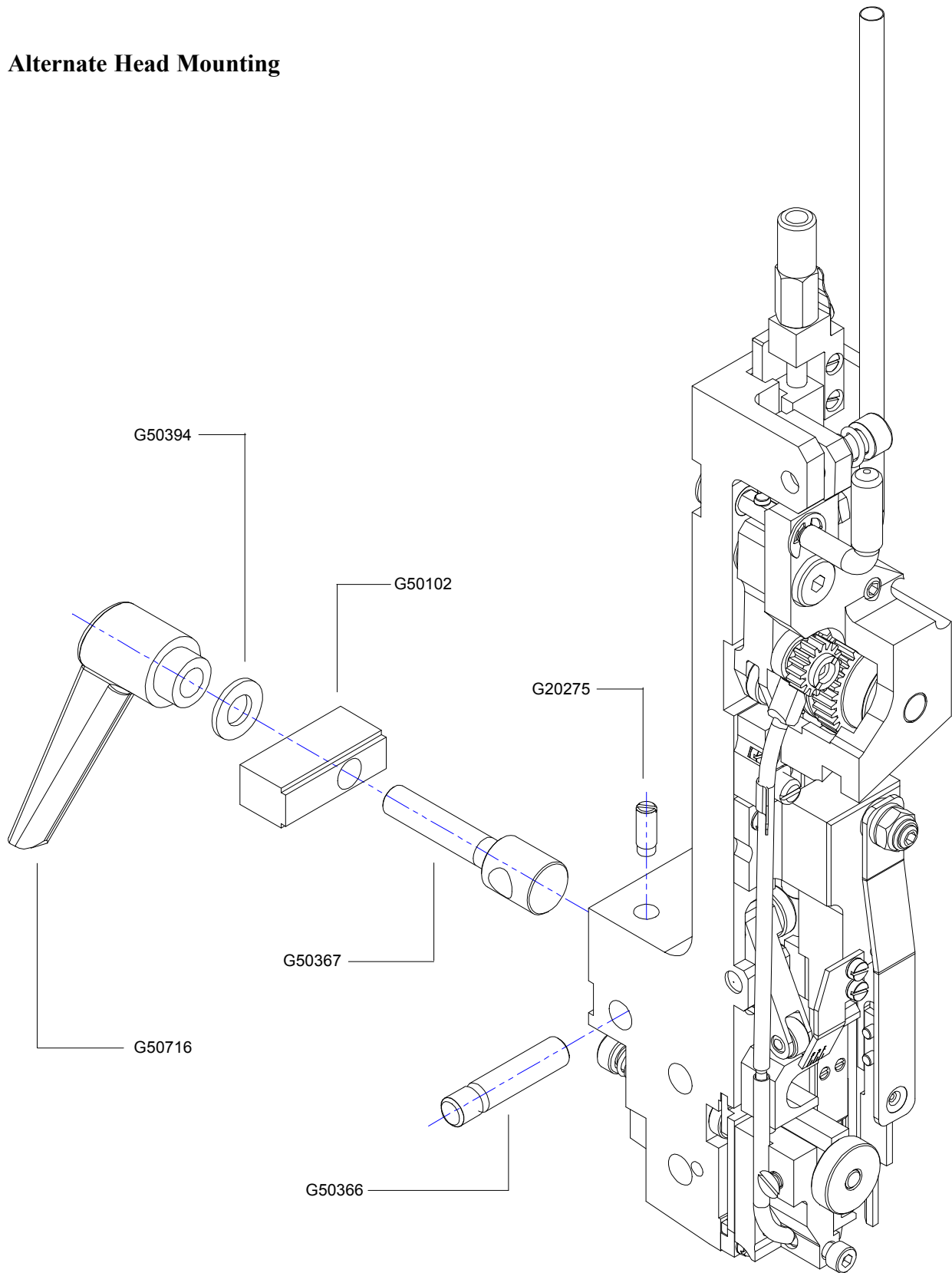
Bonnet Sub-Assembly



Bonnet Sub-Assembly

ITEM No.	DESCRIPTION	QUANTITY
0030.3434	Screw M3x.5x10, CHMS	5
0031.5103	Lock Washer Ribbed	9
G20121	Feed Release Plunger	1
G20191	Screw, M4x.7x8, SHSS	2
G20236	Tube Pivot Screw	1
G20274	Hex Jam Nut, M6x1	1
G20298	Nylock Lock Nut, M6x1	1
G20522	Screw M6x1.0x5	1
G20615	Screw M5x0.8x8	1
G50100	Bonnet	1
G50110	Large Feed Gear	1
G50111	Feed Pinion	1
G50114	Feed Gear Pin	1
G50128B	Rear Feed Gear Spacer	1
G50129	Large Feed Gear Washer	1
G50136	Feed Gear Bracket	1
G50137	Feed Gear Clutch	1
G50138	Feed Pinion Bearing	2
G50141	Wire Guide Bar	1
G50142	Screw, M3x0.5x5, CHMS	4
G50143	Pivot Block	1
G50144A	Middle Wire Tube Assembly	1
G50181	Upper Wire Tube	1
G50183	Wire Holder Retaining Spring	1
G50186	Feed Gear Friction Spring	1
G50187	Feed Gear Friction Pad	1
G50215	Screw, M3x.7x4, FHMS	1
G50237	Cutter Box Adjusting Eccentric	1
G50244	Tube Clip	1
G50245	Cutter Box Adjustment Knob	1
G50256	Scale	1
G50383	Screw M3x.5x6, FHMS	2
G50397	Shoulder Bolt, M8x20	1
G50604	Cutter Box Guide Plate	1
G50617	Wire Holder Retaining Spring Washer	2
G50646	Cutter Box Eccentric Bearing	2
G50695	Screw, M6x1.0x20	1
G50705	Shoulder Screw, M6x8 Long	1
G50711	Cutter Box Eccentric Screw Spring	1
G50713	Hex Jam Nut, M5	1

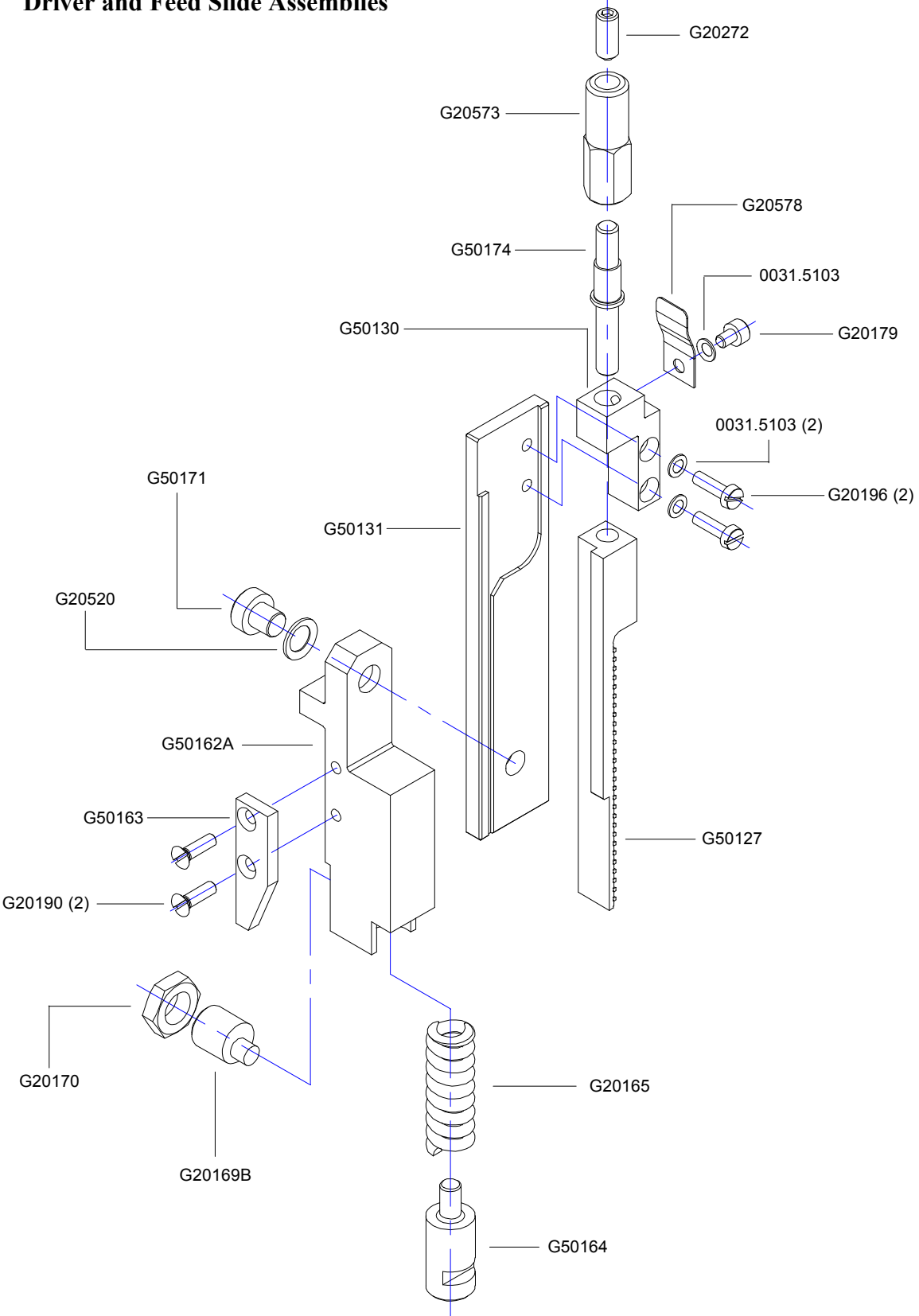
Alternate Head Mounting



Alternate Head Mounting

ITEM No.	DESCRIPTION	QUANTITY
G20275	Ball Spring Plunger	1
G50102	Mounting Block	1
G50366	Bonnet Clamp Pin	1
G50367	Rear Head Mounting Bolt	1
G50394	Flat Washer, M8	1
G50716	Mounting Block Handle	1

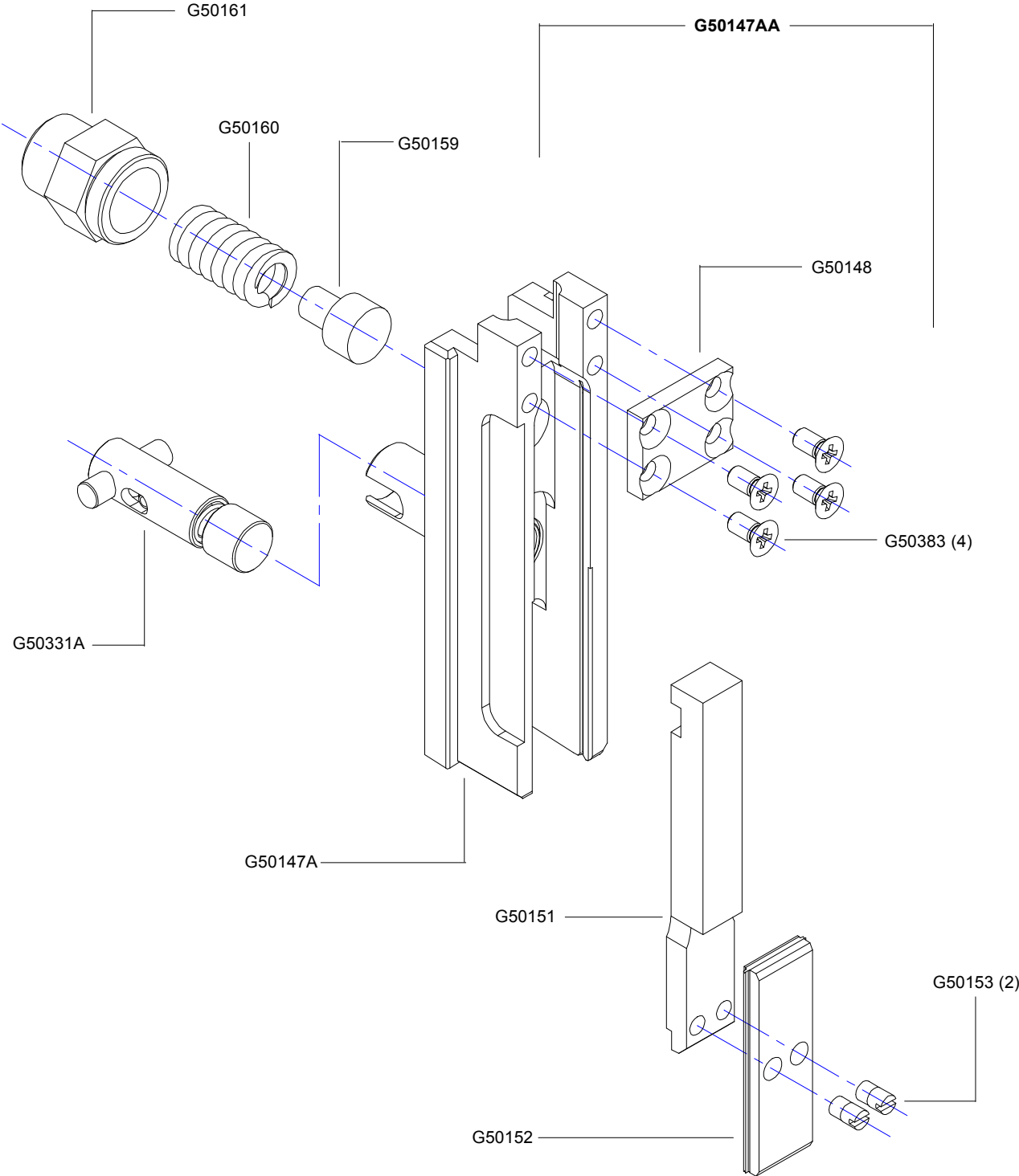
Driver and Feed Slide Assemblies



Driver and Feed Slide Assemblies

ITEM No.	DESCRIPTION	QUANTITY
G20165	Driving Slide Spring	1
G20169B	Driving Slide Plunger Screw Ecc	1
G20170	Hex Jam Nut M8x1.25	1
G20179	Screw M3x.5x4, SHCS	1
G20190	Screw M3x.5x10	2
G20196	Screw M3x.5x6 SHCS	2
G20272	Screw M4x.7x12 SHSS	1
G20520	Lock Washer M6x10	1
G20573	Feed Rack Adjustment Knob	1
G20578	Rack Adjustment Knob Detent	1
G50127	Feed Rack	1
G50130	Feed Adjustment Block	1
G50131	Feed Slide	1
G50162A	Driving Slide Assembly	1
G50163	Cutter Operating Cam	1
G50164	Plunger	1
G50171	Screw, M6X1.0X6 SHCS Low-Head	1
G50174	Feed Rack Adjustment Stud	1
0031.5103	Lock Washer, Ribbed- M3	3

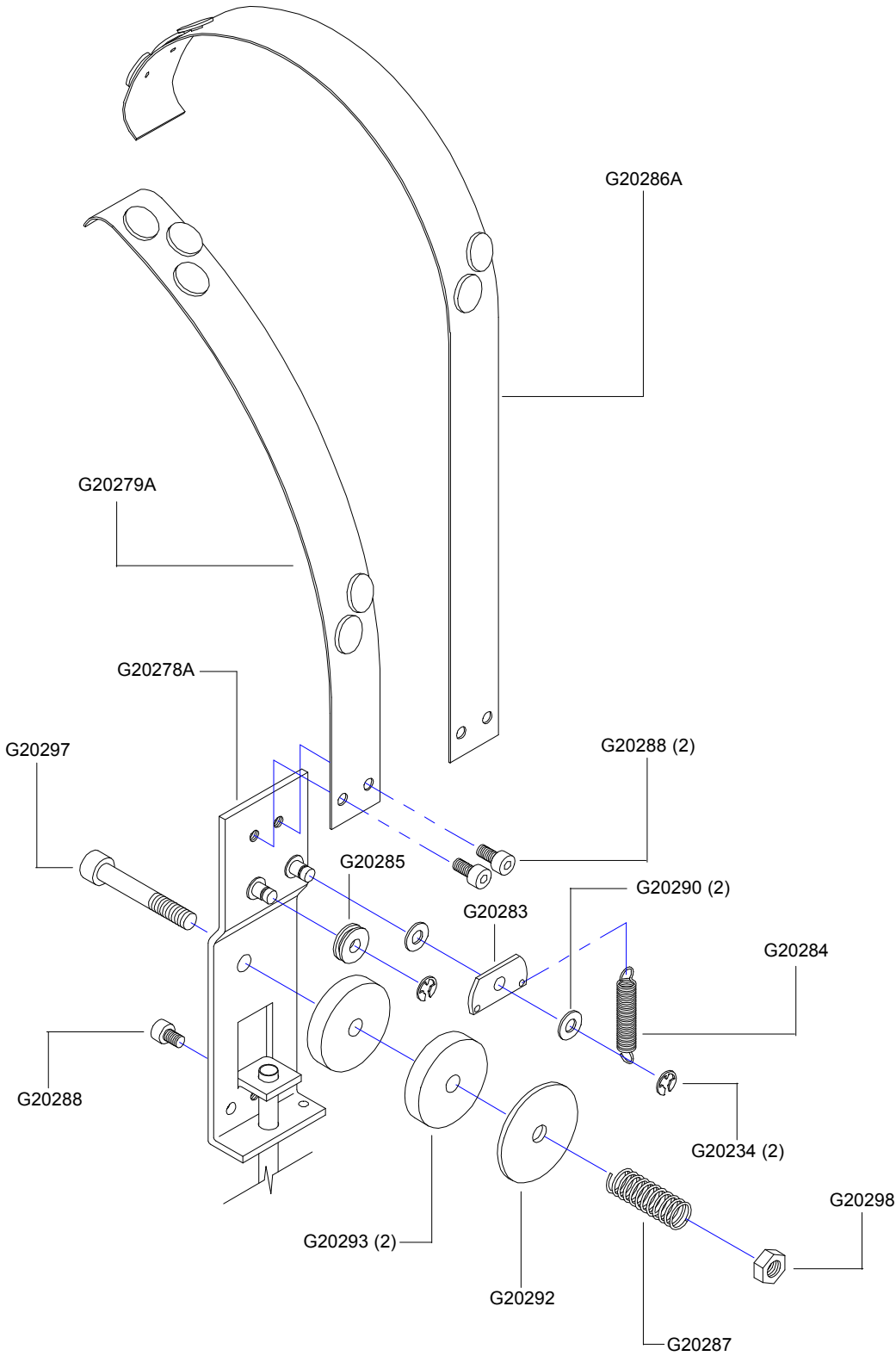
Driver and Bender Bars



Driver and Bender Bars

ITEM No.	DESCRIPTION	QUANTITY
G50147A	Bender Bar - 25 Gauge Wire	1
G50147AA	Bender Bar Assembly	1
G50148	Bender Bar Friction Plate	1
G50151	Driver Bar	1
G50152	Driver - 25 Gauge Wire	1
G50153	Driver Retaining Screw	2
G50159	Friction Plug	1
G50160	Bender Bar Friction Spring	1
G50161	Friction Plug Bushing	1
G50331A	Forming Pin	1
G50383	Screw M3x.5x5 FHMS	4

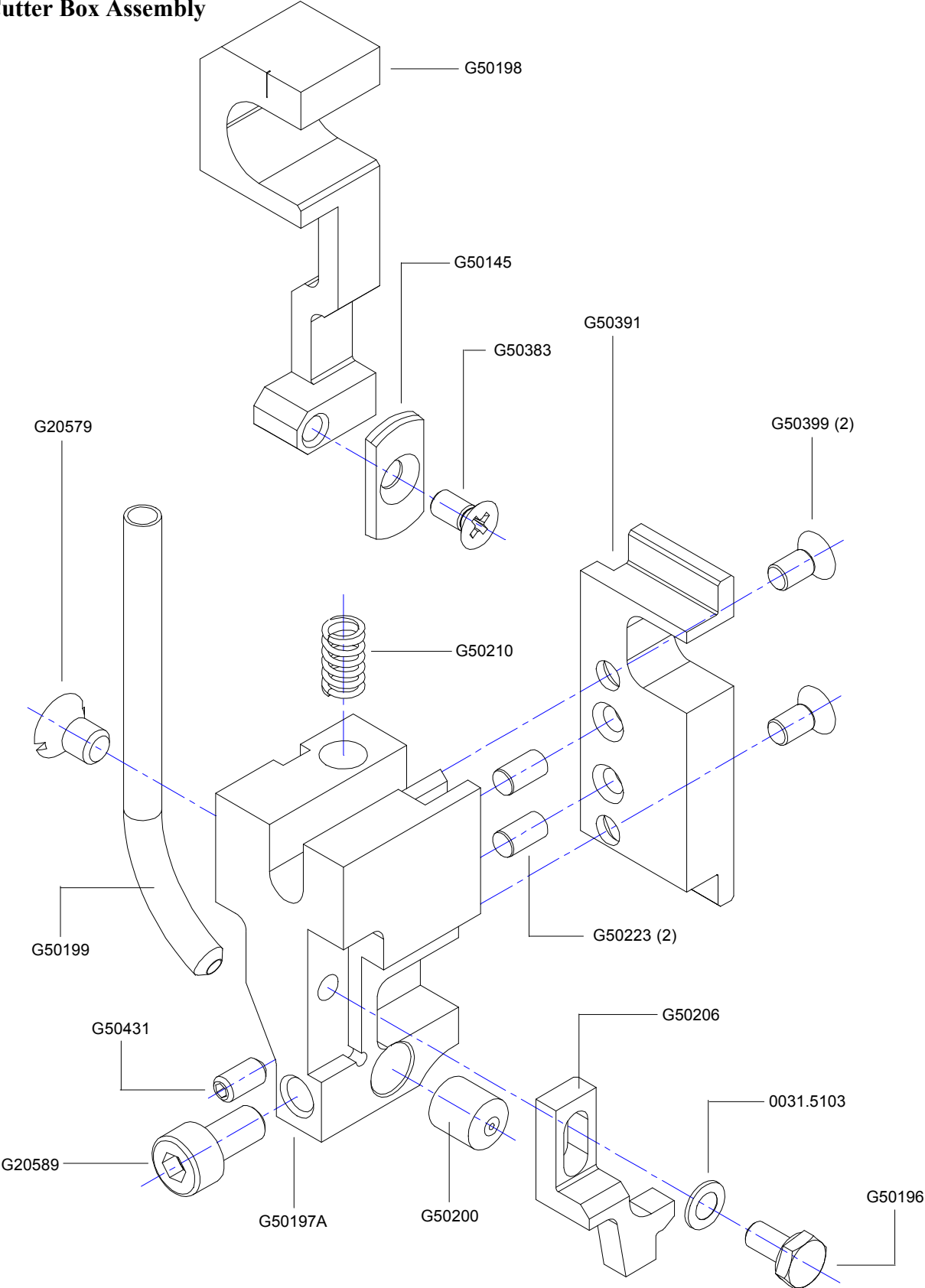
Wire Guide Bracket and Spring



Wire Guide Bracket, Spring and Clincher Plate

ITEM No.	DESCRIPTION	QUANTITY
G20234	E-Ring 3/16"	2
G20278A	Wire Guide Spring Plate Assembly	1
G20279A	Wire Guide Spring Assembly - Short	1
G20283	Tension Pawl	1
G20284	Tension Pawl Spring	1
G20285	Tension Pawl Roller	1
G20286A	Wire Guide Spring Assembly - Long	1
G20287	Wire Oiler Felt Spring	1
G20288	Screw, M4x0.7x8, SHCS	3
G20290	Flat Washer, M5	2
G20292	Wire Oil Felt Washer	1
G20293	Wire Oiler Felt	2
G20297	Screw, M6x1x40	1
G20298	Nylock Lock Nut, M6x1	1

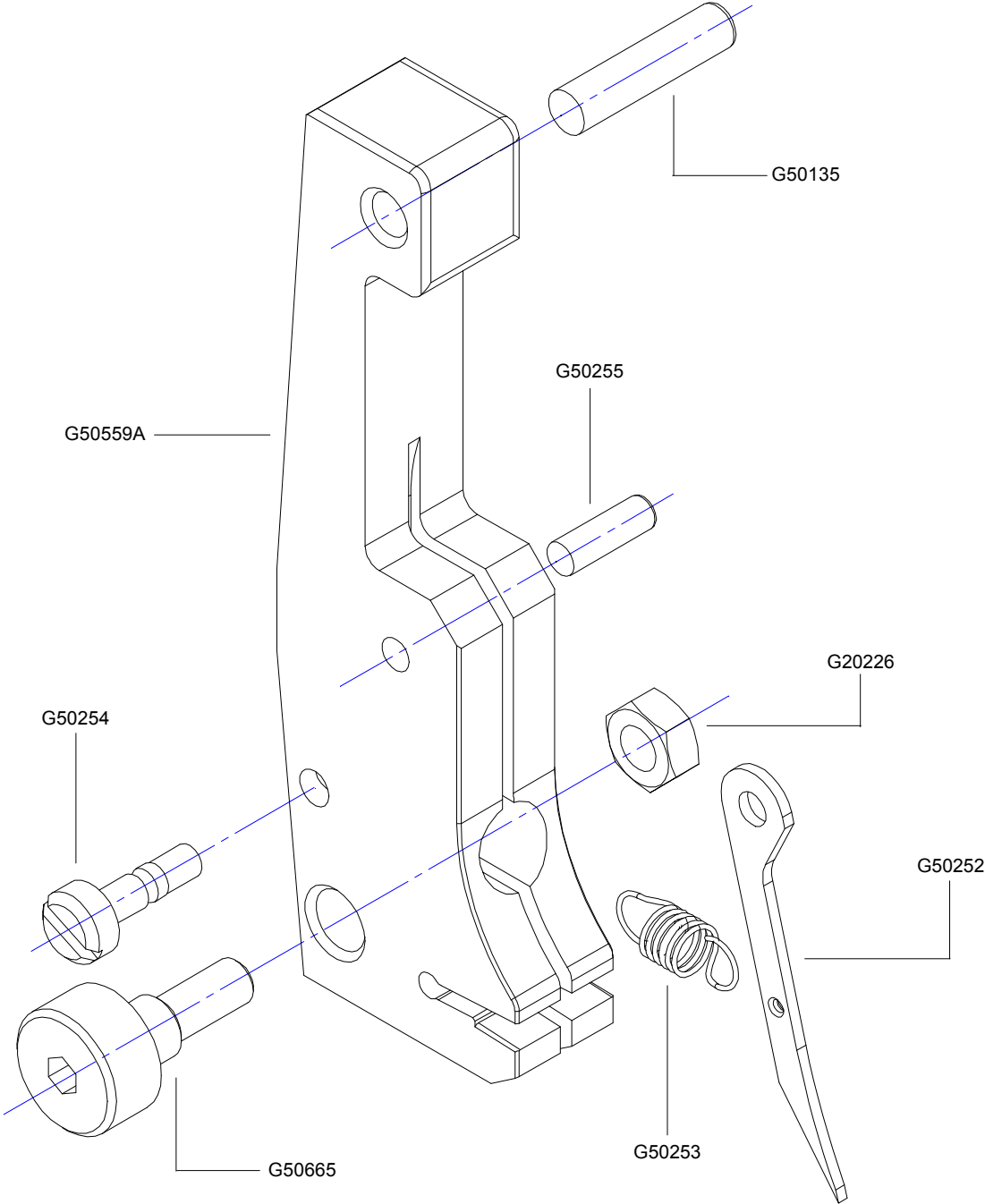
Cutter Box Assembly



Cutter Box Assembly

ITEM No.	DESCRIPTION	QUANTITY
0031.5103	Lock Washer, Ribbed- M3	1
G20579	Screw M4x0.7x6	1
G20589	Screw, M4x0.7x10 SHCS	1
G50145	Moving Cutter	1
G50196	Screw M3x.5x6 HHCS - Long	1
G50197A	Cutter Box Assembly	1
G50198	Cutter Slide	1
G50199	Lower Wire Tube	1
G50200	Fixed Wire Cutter	1
G50206	Wire Straightener Eccentric	1
G50210	Cutter Operating Spring	1
G50223	Dowel Pin, M3x6	2
G50383	Screw M3x.5x5	1
G50391	Cutter Box Mounting Plate	1
G50399	Screw, M3x.5x8 FHCS	2
G50431	Screw, M3x0.5x6 Long SHSS	1

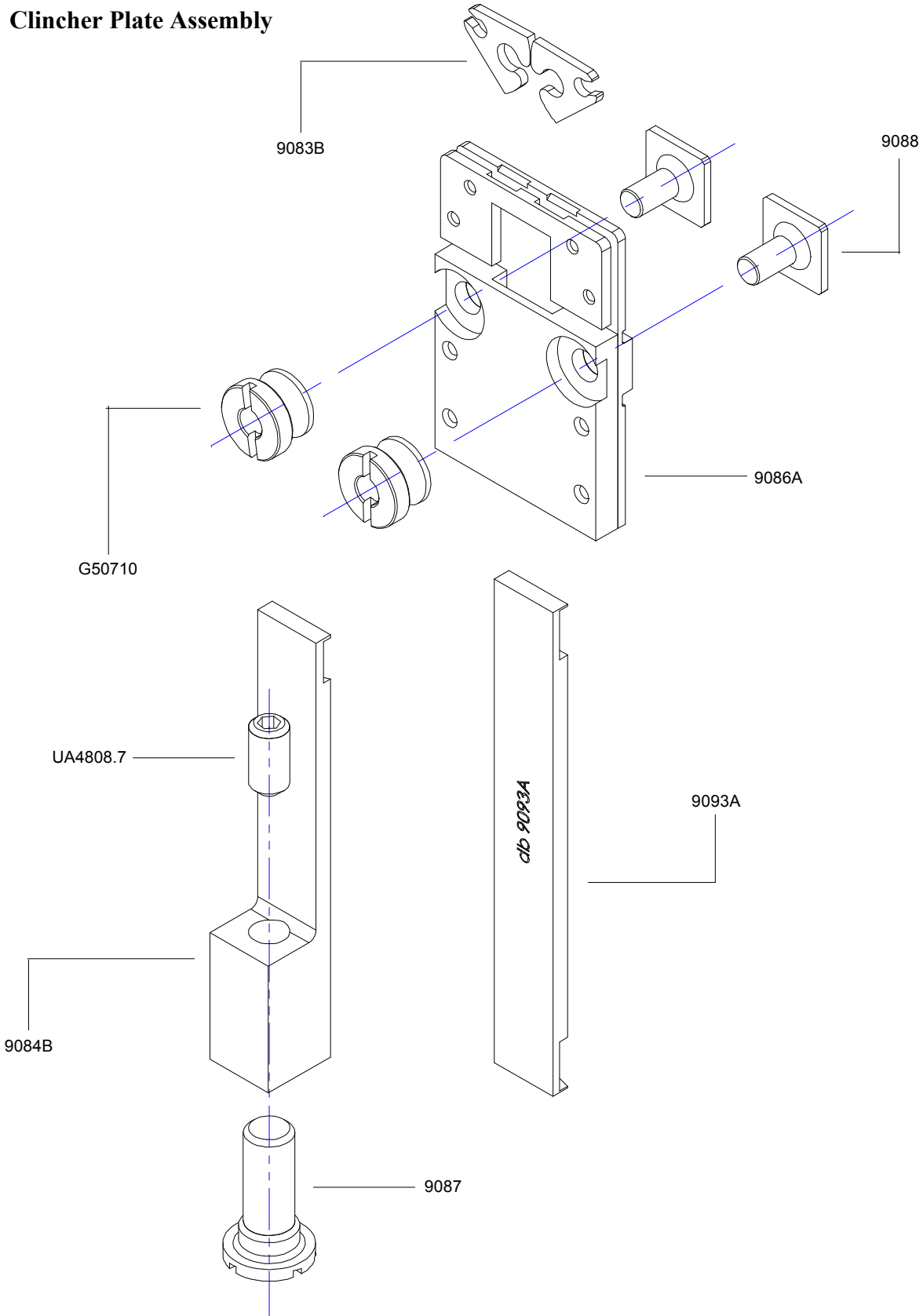
Wire Holder Assembly



Wire Holder Assembly

ITEM No.	DESCRIPTION	QUANTITY
G20226	Hex Nut M4x.7	1
G50135	Wire Holder Pivot Pin	1
G50252	Wire Holder Hook	1
G50253	Wire Hook Spring, G5	1
G50254	Wire Holder Spring Screw	1
G50255	Dowel Pin M3x10	1
G50559A	Wire Holder Assembly	1
G50665	Wire Holder Adjustment Screw	1

Clincher Plate Assembly



Clincher Plate Assembly

ITEM No.	DESCRIPTION	QUANTITY
9083A	Clincher Point - Thick, Round	2
9084B	Adjustable Clincher Slide	1
9086A	Clincher Plate - Thick	1
9087	Clincher Slide Adjustment Screw	1
9088	Clincher Plate Binder Bolt	2
9093A	Clincher Slide - Thick	1
G50710	Clincher Plate Nut	2
UA4808.7	Screw, 1/4-28 x 1/4, SHSS	1

Part Number / Description Cross-Reference

0030.0030	Screw, M5x.8x8 SHCS	2	G20285	Tension Pawl Roller	1
0030.3434	Screw M3x.5x10, CHMS	7	G20287	Wire Oiler Felt Spring	1
0031.5103	Lock Washer Ribbed	15	G20288	Screw, M4x0.7x8, SHCS	3
0031.5104	Lock Washer Ribbed, M4	4	G20290	Flat Washer, M5	2
9088	Clincher Plate Binder Bolt	2	G20292	Wire Oil Felt Washer	1
9091	Clincher Slide Strap Rivet	2	G20293	Wire Oiler Felt	2
87922	Oil Hole Cover	1	G20296	Wire Guide Spring Guide Stud	5
9083A	Clincher Point - Thick, Round	2	G20297	Screw, M6x1.0x40	1
9086A	Clincher Plate - Thick	1	G20298	Nylock Lock Nut, M6x1	1
9086BA	Clincher Back Plate - Thick	1	G20298	Nylock Lock Nut, M6x1	1
9093A	Clincher Slide - Thick	1	G20360	Hex Key Wrench 3.0mm	1
G20121	Feed Release Plunger	1	G20515	Dowel Pin M6x14	1
G20140	Follower Ball Bearing	1	G20520	Ribbed Lock Washer-M6	1
G20140	Follower Ball Bearing	1	G20522	Screw M6x1.0x5	1
G20165	Driving Slide Spring	1	G20573	Feed Rack Adjustment Knob	1
G20169B	Driving Slide Plunger Screw Eccentric	1	G20578	Rack Adjustment Knob Detent	1
G20170	Hex Jam Nut M8x1.25	1	G20579	Screw M4x0.7x6	1
G20179	Screw M3x.5x4, SHCS	1	G20589	Screw, M4x0.7x10, SHCS	1
G20190	Screw M3x.5x10, FHMS	2	G20615	Screw M5x0.8x8	1
G20191	Screw, M4x.7x8, SHSS	4	G50100A	Bonnet Assembly	1
G20226	Hex Nut M4x.7	1	G50101	Clamp Block	1
G20233	Cutter Operating Lever Roller	1	G50110	Large Feed Gear	1
G20234	E-Ring 3/16"	2	G50110A	Large Feed Gear Assembly	1
G20236	Tube Pivot Screw	1	G50111	Feed Pinion	1
G20272	Screw M5x0.8x12	1	G50111A	Feed Pinion Assembly	1
G20274	Hex Jam Nut, M6x1	1	G50112	Small Feed Gear	1
G20278	Wire Guide Spring Plate	1	G50114	Feed Gear Pin	1
G20278A	Wire Guide Spring Plate Assembly	1	G50115L	Forming Pin Cam, Left	1
G20278AA	W/G Spring Plate Asy - Complete	1	G50115R	Forming Pin Cam, Right	1
G20279	Wire Guide Spring - Short	1	G50118	Feed Release Cam	1
G20279A	Wire Guide Spring Assembly - Short	1	G50119	Feed Release Handle	1
G20282	Tension Pawl Pivot Pin	2	G50120	Feed Release Handle Bushing	1
G20283	Tension Pawl	1	G50126	Screw, M5x.8x25	1
G20284	Tension Pawl Spring	1	G50127	Feed Rack	1

Part Number / Description Cross-Reference

G50128	Pinion Washer	1	G50183	Wire Holder Retaining Spring	1
G50129	Large Feed Gear Washer	1	G50186	Feed Gear Friction Spring	1
G50130	Feed Adjustment Block	1	G50187	Feed Gear Friction Pad	1
G50131	Feed Slide	1	G50196	Screw M3x.5x6, HHCS	1
G50132	Feed Lever	1	G50197A	Cutter Box Assembly	1
G50132A	Feed Lever Assembly	1	G50198	Cutter Slide	1
G50135	Wire Holder Pivot Pin	1	G50199	Lower Wire Tube	1
G50136	Feed Gear Bracket	1	G50200	Fixed Wire Cutter	1
G50137	Feed Gear Clutch	1	G50206	Wire Straightener	1
G50138	Feed Pinion Bearing	2	G50210	Cutter Operating Spring	1
G50138	Feed Pinion Bearing	1	G50223	Dowel Pin, M3x6	5
G50141	Wire Guide Bar	1	G50223	Dowel Pin, M3x6	2
G50142	Screw, M3x0.5x5, CHMS	6	G50230	Cutter Operating Lever	1
G50143	Pivot Block	1	G50230A	Cutter Operating Lever Assembly	1
G50144	Middle Wire Tube	1	G50232	Dowel Pin	1
G50144A	Middle Wire Tube Assembly	1	G50235	Dowel Pin M5 x 12	1
G50145	Moving Cutter	1	G50237	Cutter Box Adjusting Eccentric	1
G50147AA	Bender Bar Assembly	1	G50244	Tube Clip	1
G50148	Bender Bar Friction Plate	1	G50245	Cutter Box Adjustment Knob	1
G50149	Dowel Pin M4 x 16	1	G50252	G5 Wire Hook	1
G50151	Driver Bar	1	G50253	Wire Hook Spring, G5	1
G50152	Driver - 25 Gauge Wire	1	G50254	Wire Holder Spring Screw	1
G50153	Driver Retaining Screw	2	G50255	Dowel Pin, M3 x 10	1
G50159	Friction Plug	1	G50256	Scale	1
G50160	Bender Bar Friction Spring	1	G50258	Wire Tube Sleeve	1
G50161	Friction Plug Bushing	1	G50262	Small Feed Gear Shaft	1
G50162	Driving Slide	1	G50262A	Small Feed Gear Shaft Assembly	1
G50162A	Driving Slide Assembly	1	G50264	E-Ring 6mm	2
G50163	Cutter Operating Cam	1	G50266	Dowel, M5x10	1
G50164	Plunger	1	G50268	Feed Lever Spring	1
G50171	Screw, M6x1.0x6, SHCS- Low	1	G50331	Forming Pin	1
G50174	Feed Rack Adjustment Stud	1	G50332	Forming Pin Insert	1
G50181	Upper Wire Tube	1	G50333	Bushing	1
G50182	Feed Gear Plate	1	G50335	Spring, Internal	1

Part Number / Description Cross-Reference

G50337	Spring Pin, M2.5 x 6	1
G50368	Feed Release Handle Cap	1
G50383	Screw M3x.5x6, FHMS	4
G50383	Screw M3x.5x6, FHMS	5
G50391	Cutter Box Mounting Plate	1
G50397	Shoulder Bolt, M8x20	1
G50431	Screw, M3x0.5x6	1
G50559	Wire Holder	1
G50559A	Wire Holder Assembly	1
G50604	Cutter Box Guide Plate	1
G50617	Wire Holder Retaining Spring Washer	2
G50646	Cutter Box Eccentric Bearing	2
G50665	Wire Holder Adjustment Screw	1
G50695	Screw, M6x1.0x20	1
G50703	Feed Lever Spring Screw	1
G50705	Shoulder Screw, M6x8 Long	1
G50707	Double Open End Wrench - 5.5 & 7mm	1
G50708	T-Handle Hex Key Wrench - 4mm	1
G50711	Cutter Box Eccentric Screw Spring	1
G50712	Dowel Pin, M3 x 18 Lg	2
G50713	Hex Jam Nut, M5	1
G50714	Feed Lever Spacer	1
G50715	Screw, M4x.7x6, CHMS	4
G5HD251/2	Stitcher Head Assembly	1

REGISTRATION

To better service your wire stitching needs, please take a moment to fill out and return this registration card.

CUSTOMER

Name : _____
(First) _____ (Middle Initial) _____ (Last)
Company : _____
Street Address : _____
City : _____ State/Province : _____ Zip : _____
Country : _____
Phone : _____ Fax : _____ E-mail : _____

PRODUCT

Machine(s) Purchased : _____
Serial Number(s) : _____
With Head(s) : _____
(Type/Quantity Purchased)
Serial Number(s) : _____
Head(s) Purchased : _____
Serial Number(s) : _____

DEALER

Date Received : _____
Dealer Name : _____
Dealer Street Address : _____
City : _____ State/Province : _____ Zip : _____
Country : _____
Dealer Phone : _____

Other Bindery Products Used : _____

Would you like information sent to you about new products that would benefit your company? Yes No

Please take a moment to fill out the attached card and mail it to DeLuxe Stitcher Company. In addition, duplicate the information for your records to assist when making further inquiries.

PRODUCT

Machine(s) Purchased : _____
Serial Number(s) : _____
With Head(s) : _____
(Type/Quantity Purchased)
Serial Number(s) : _____
Head(s) Purchased : _____
Serial Number(s) : _____

DE LUXE STITCHER GRAPHIC ARTS REPRESENTATIVE

Date Received : _____
Dealer Name : _____
Dealer Street Address : _____
City : _____ State/Province : _____ Zip : _____
Country : _____
Dealer Phone : _____

Common Replacement Parts for 1/2" Crown

Below is a list of the most common wear/replacement parts for the G5 Stitcher Head. This guide should help you when ordering replacement parts. If the part you need is not listed below, please refer to the more detailed parts list on pages 48-49 in this manual.

Description	Item Number
Clincher Point - Thick, Round	9083B
Adjustable Clincher Slide	9084B
Clincher Plate - Thick	9086A
Follower Ball Bearing	G20140
Cutter Operating Lever Roller	G20233
Large Feed Gear Assembly	G50110A
Feed Pinion Assembly	G50111A
Small Feed Gear	G50112
Forming Lever	G50116
Feed Lever	G50132
Wire Guide Bar	G50141
Moving Cutter	G50145
Bender Bar Assembly	G50147A
Driver - 25 Gauge Wire	G50152
Friction Plug	G50159
Bender Bar Friction Spring	G50160
Wire Holder Retaining Spring	G50183
Feed Gear Friction Spring	G50186
Feed Gear Friction Pad	G50187
Fixed Wire Cutter	G50200
Wire Holder Hook	G50252
Wire Hook Spring	G50253
Former Spring	G50344
Wire Holder	G50559

**PLAC:
STAM
HERE**

**DELUXE STITCHER
COMPANY INC.**
6635 West Irving Park Road
Chicago, Illinois 60634-2410 U.S.A.
Attn: Customer Service

LIMITED WARRANTY

DeLuxe Stitcher Company warrants to the original retail purchaser that this product is free from defects in material and workmanship and agrees to repair or replace, at DeLuxe Stitcher's option, any defective product within 90 days from the date of purchase. This warranty is not transferable. It covers damage resulting only from defects in material or workmanship and does not cover conditions or malfunctions resulting from normal wear, neglect, abuse or accident.

This warranty is in lieu of all other express warranties. Any warranty of merchantability or fitness for a particular purpose is limited to the duration of this warranty. DeLuxe Stitcher shall not be liable for any incidental or consequential damages.

Some states do not allow limitations on how long an implied warranty lasts, or the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you. This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

To obtain warranty service you must return the product, at your expense, together with proof of purchase to an authorized DeLuxe Stitcher Company Graphic Arts Dealer.

Always use genuine DeLuxe Stitcher parts. When ordering parts, please identify the part number, the part name, the wire size and crown size of your Stitcher.

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Chicago, Illinois 60634-2410
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