

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 Ga. Round (0.52 mm)

Crown Sizes: 1/2" (12.7 mm) and 5/8" (15.9 mm)

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 Graphic Arts Representative or Distributor.

Specifications

Weight

Shipping Weight4.7 lbs (3.4 kg)

Physical Dimensions

Height 0-3/4" (26.3 cm)

Width.....2" (5.1 cm)

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

Wire Type25 round (0.52 mm max)
21x25 flat

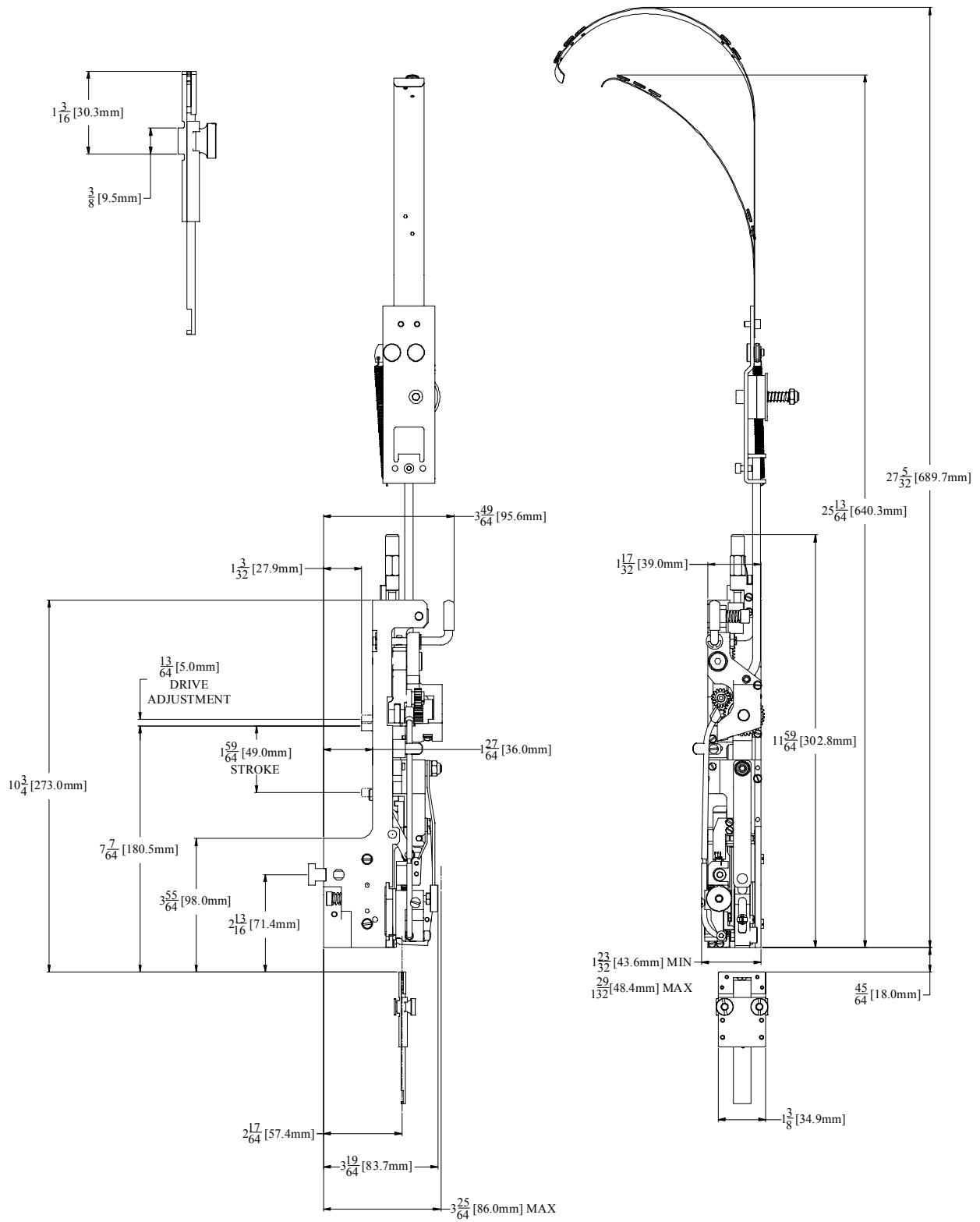
Crown Sizes 1/2" (12mm), 13/64" (5mm) Loop

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

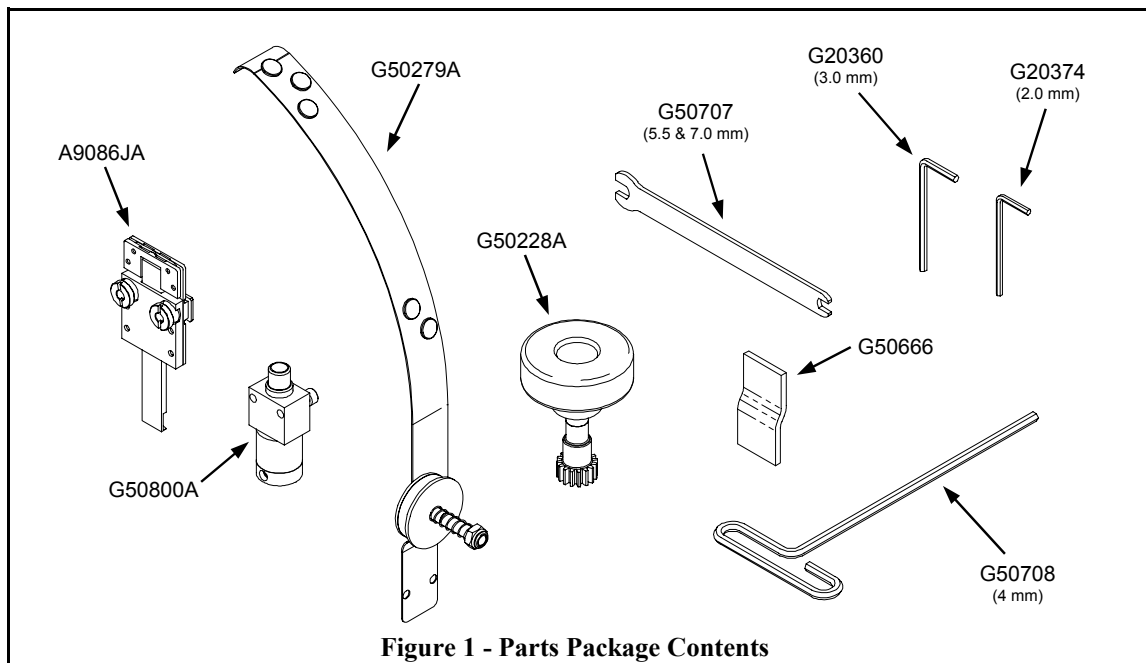
Dimensions



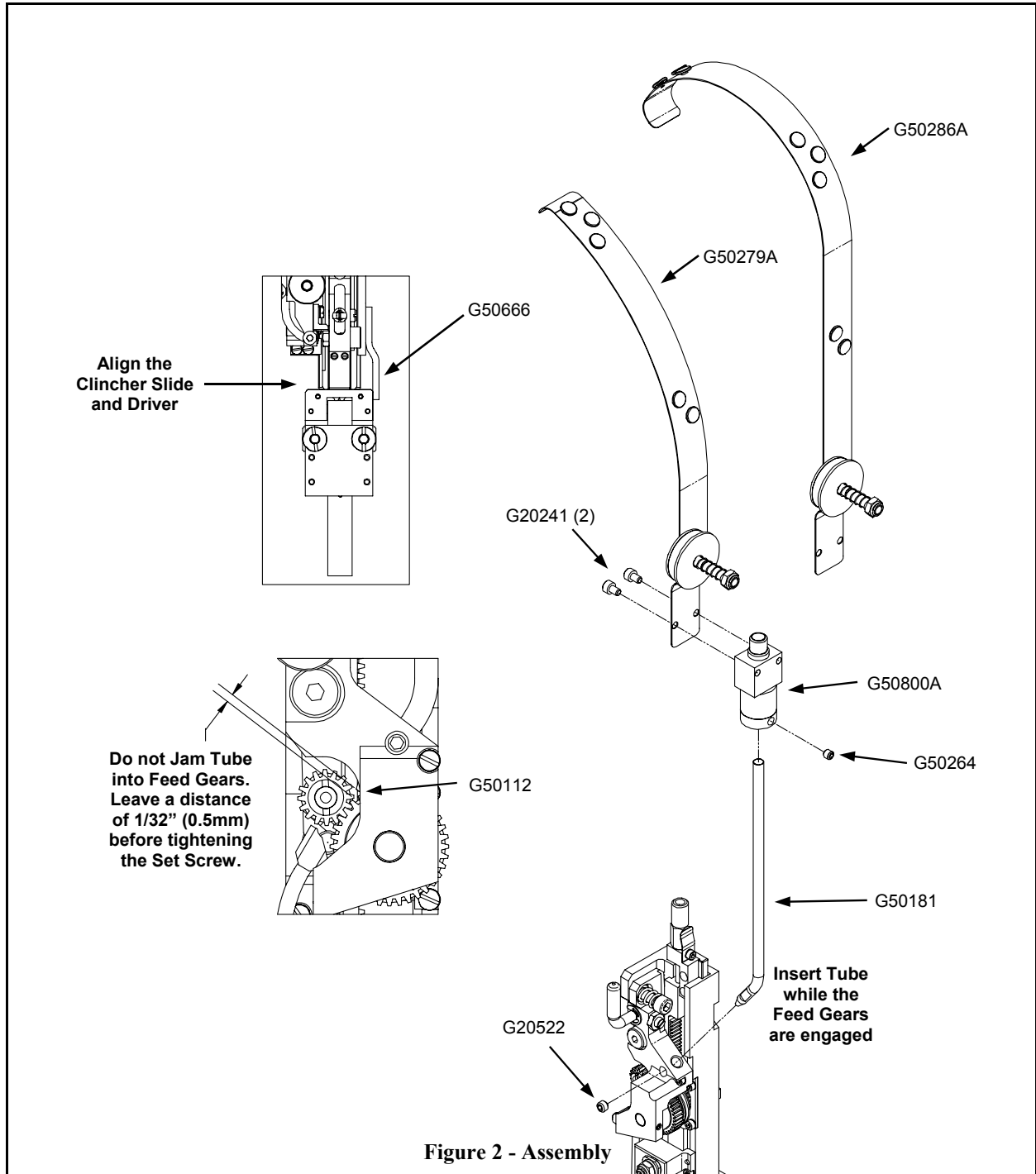
Installation

Contents

- G5 Manual
- Bag of Tools with 2.0 mm, 3.0 mm & Double Open End Wrench - (5.5 mm & 7 mm)
- T-Handle Hex Head Wrench - 4 mm
- Head Mounting Accessories
 - Front Mount: Clamp Block (G50101), Screw M5x0.8x25 (G50126)
 - Bolt Mount: Head Mounting Bolt, M8 (G50367), Mounting Block - Keyed (G50102), Bonnet Clamp Pin (G50366), Mounting Block Handle (G50716) & Flat Washer M8 (G50394)
- Complete Wire Guide Spring Plate Assembly (G20278AA)
- Adjustment Handle Assembly (G20628A)
- Short (G20679A), Medium (G20279A) or Long (G20286A) Wire Guide Spring Assembly
- Clincher Plate, Points, Slide, Nuts & Studs
- Clincher Alignment Gauge
- Wire Guide Spring and Wire Anti-Backup Unit
- Manual Feed Gear Tool
- Stitch Samples



Assembly (Figures 2 - 4)



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

⚠ WARNING

Mounting (Figures 3)

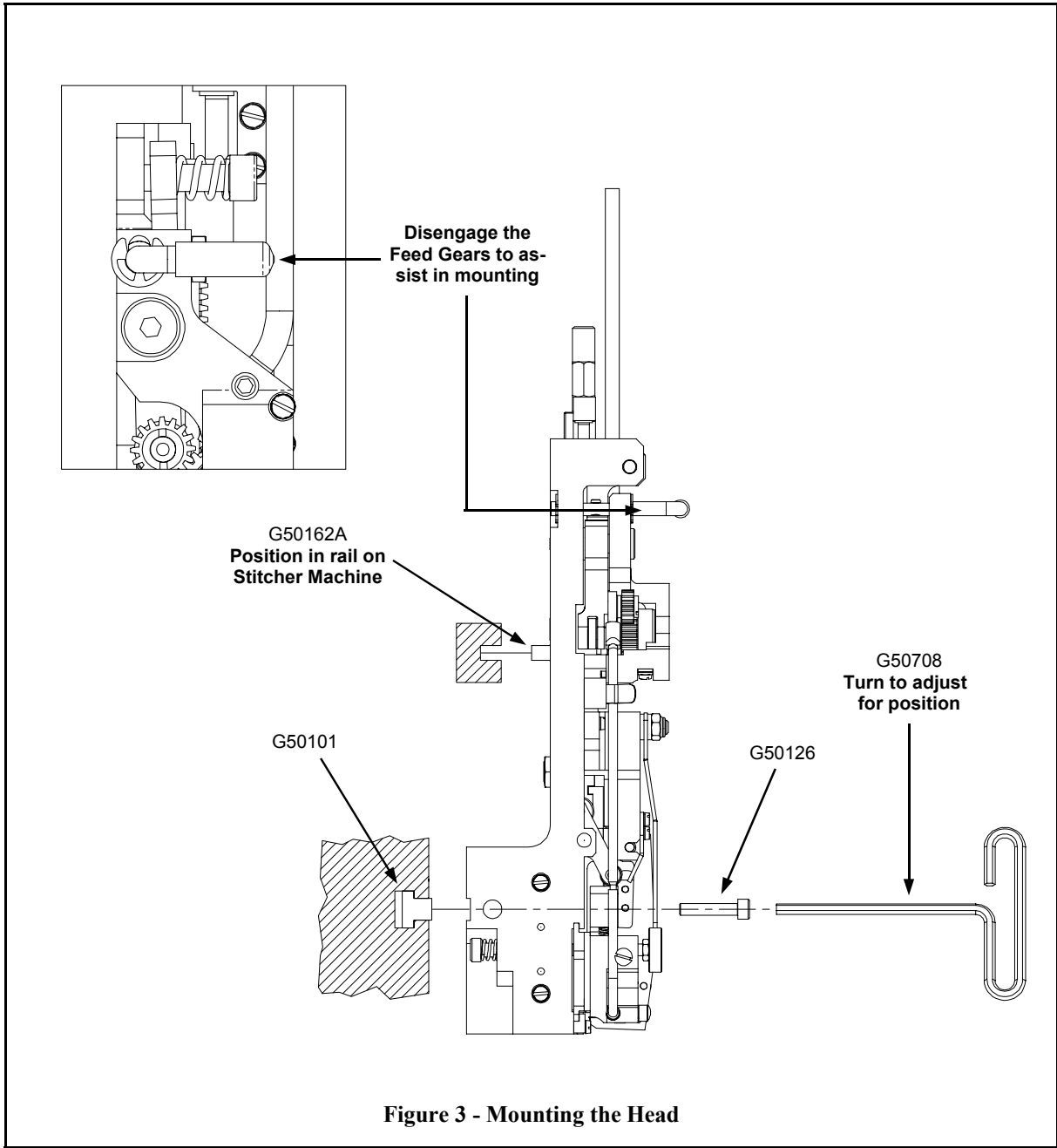
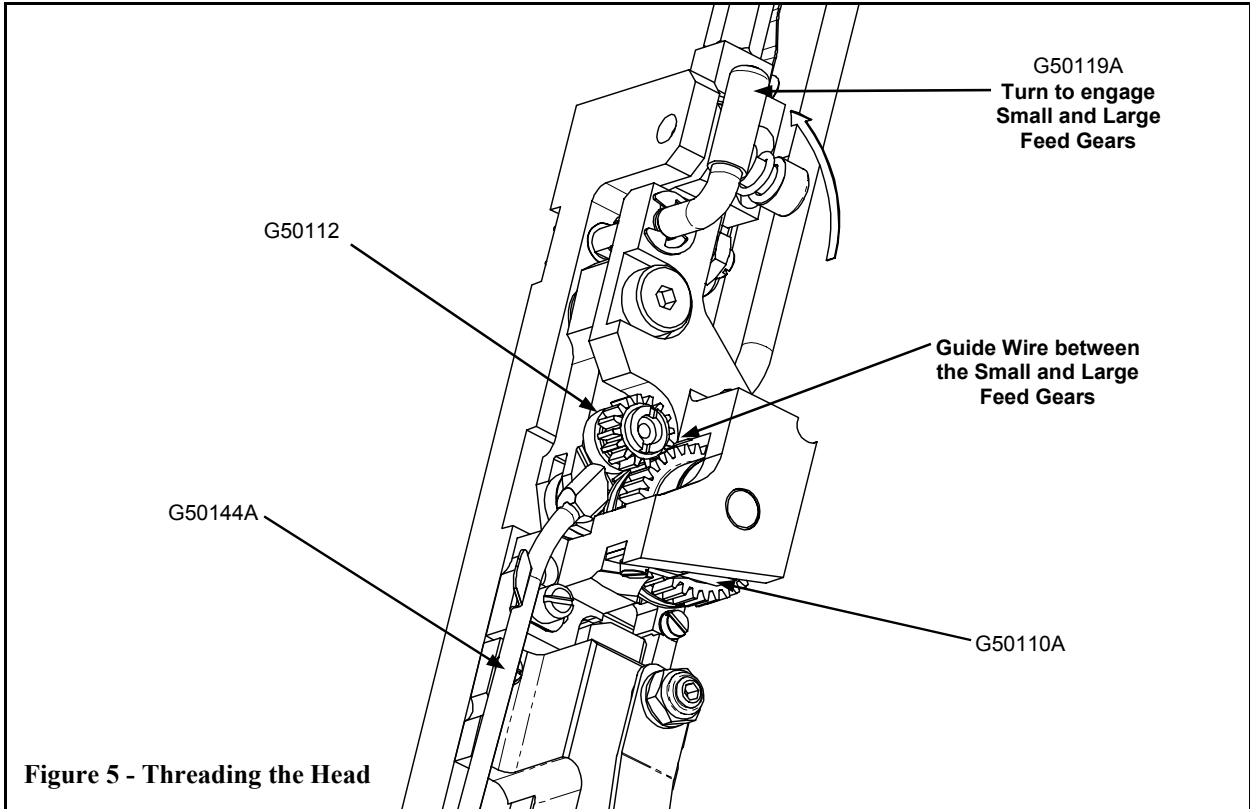
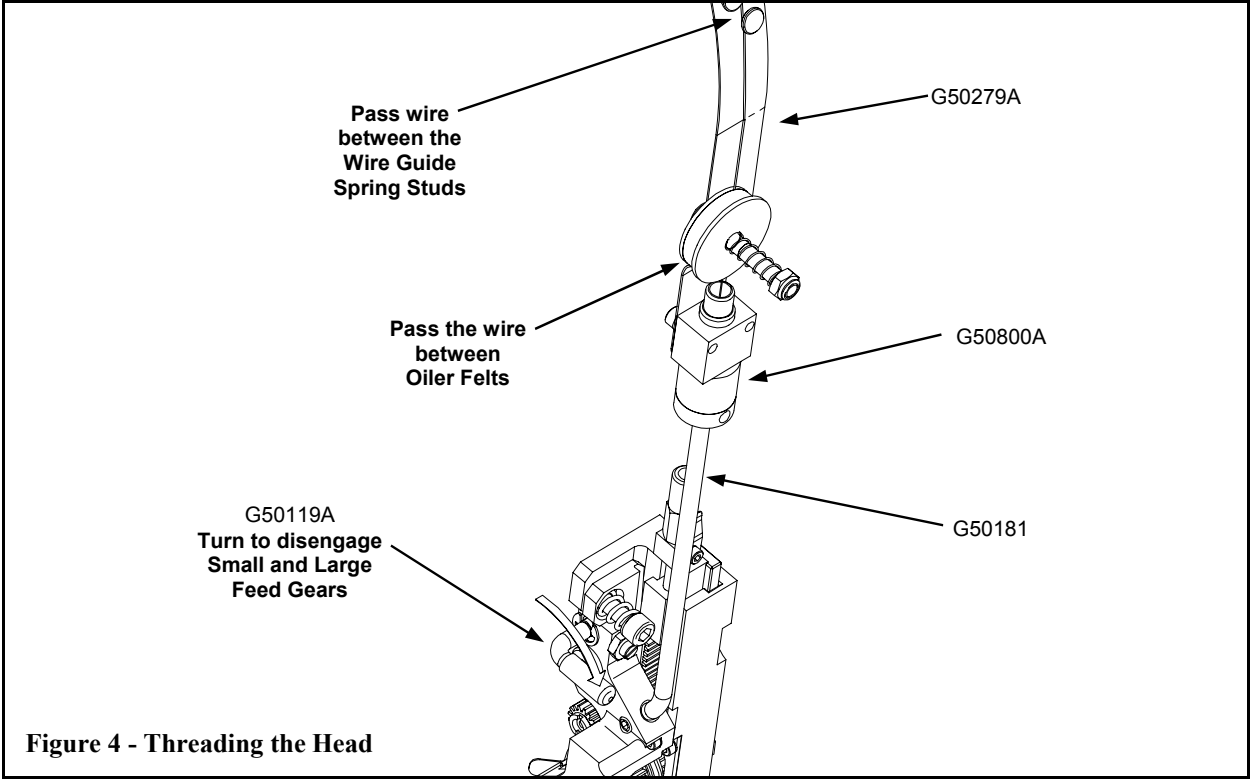


Figure 3 - Mounting the Head

Wire Threading (Figures 4 & 5)



Adjust the Length of the Stitch Leg (Figure 6)

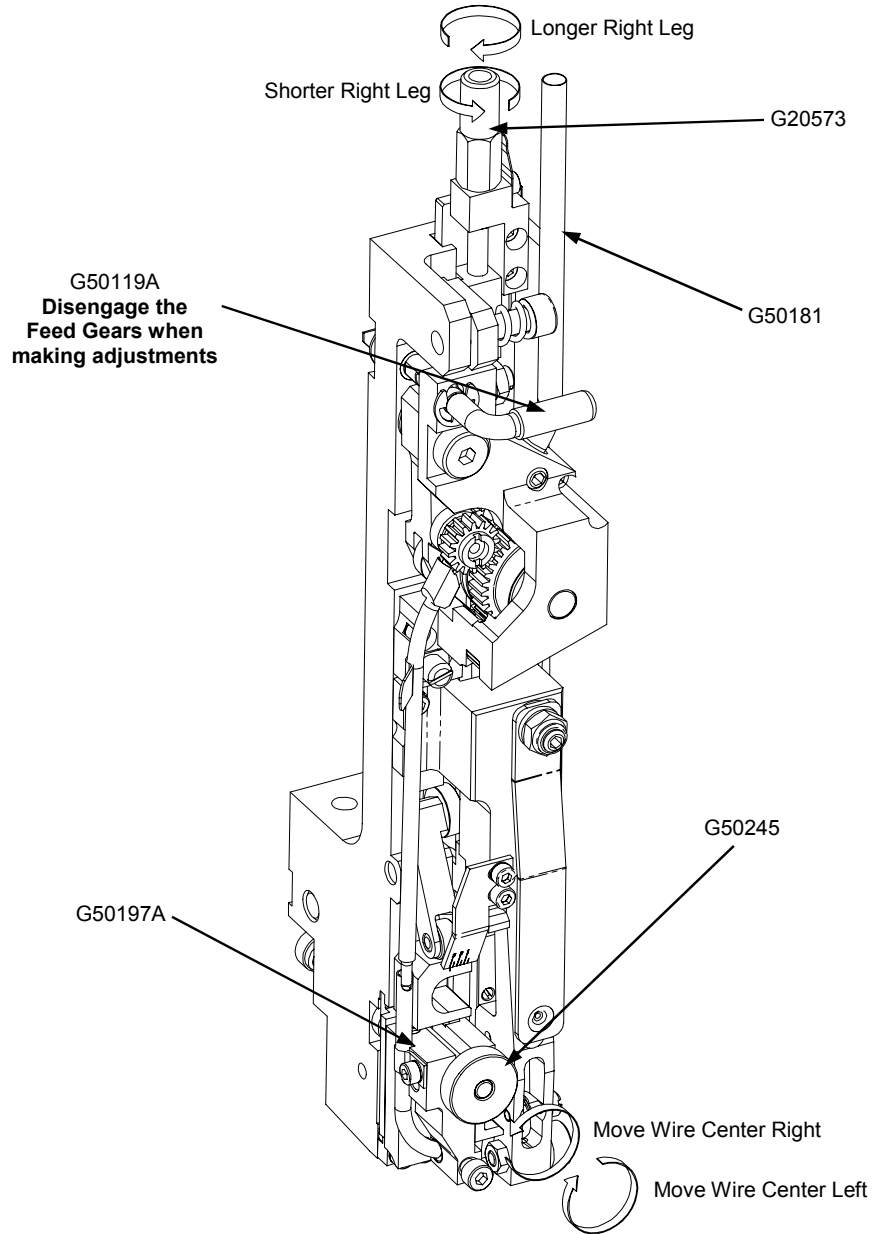
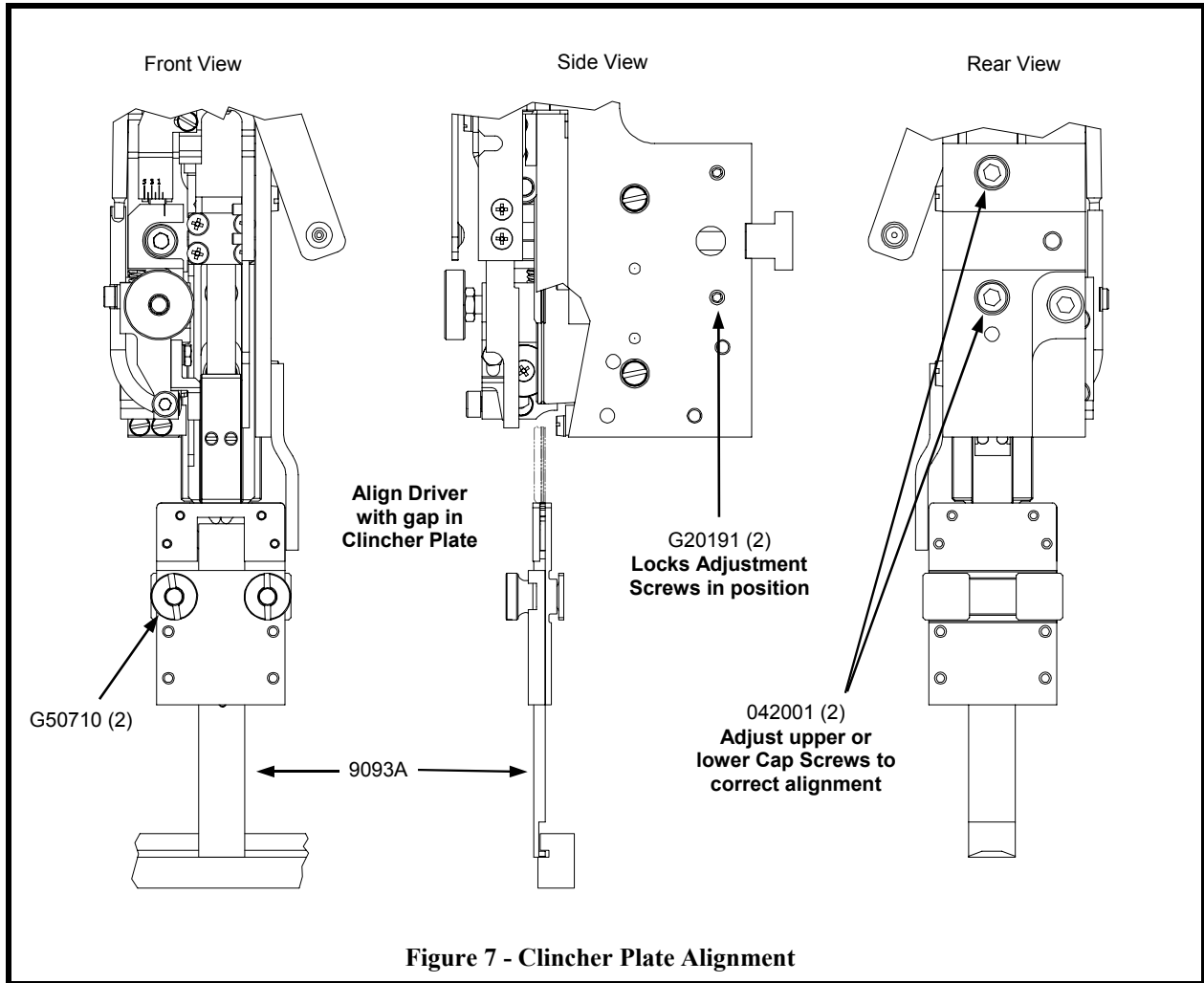


Figure 6 - Adjusting the Stitch Leg

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

⚠ WARNING

Aligning the Clincher Plate (Figure 7)



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

⚠ WARNING

Lubrication (Figures 8)

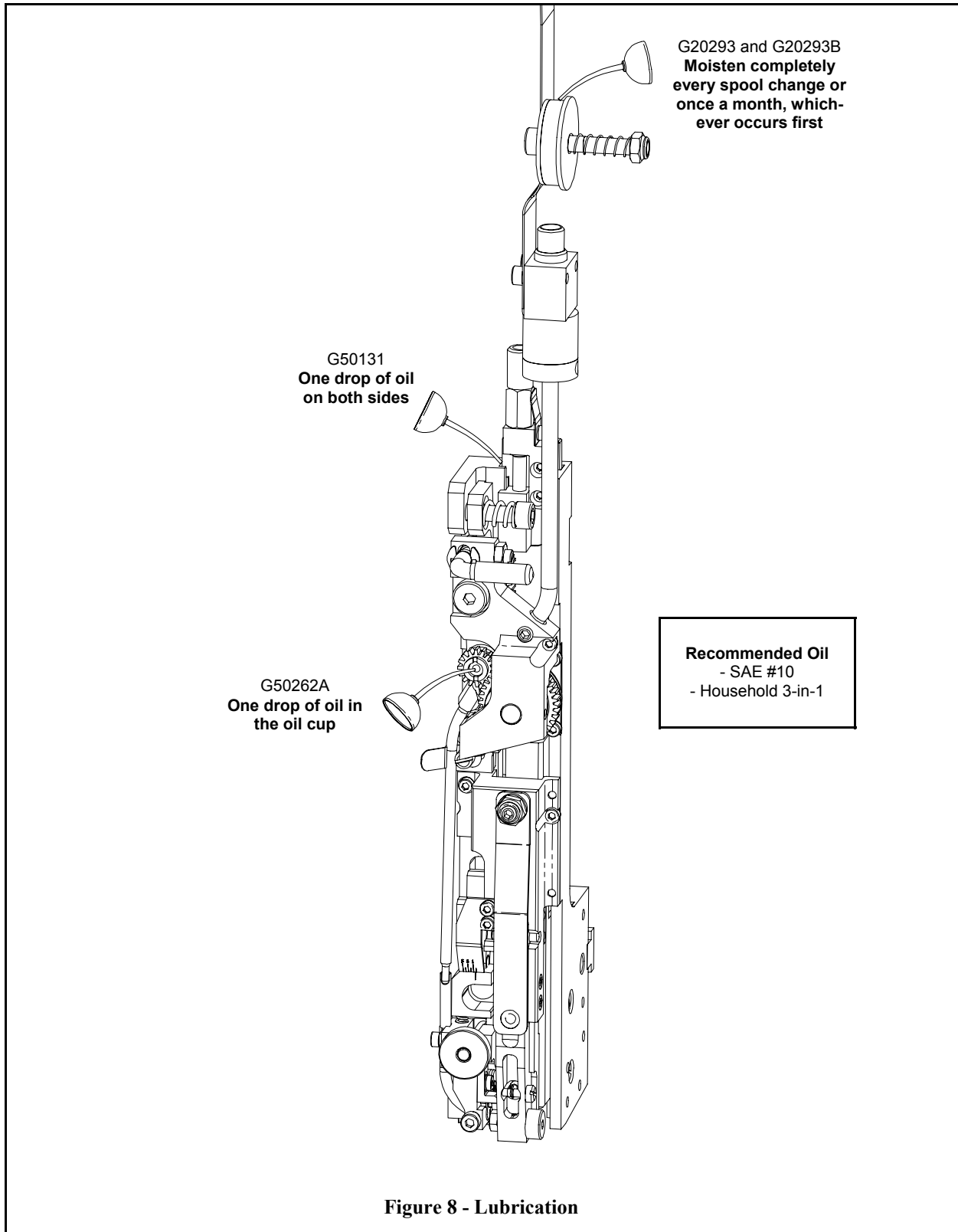
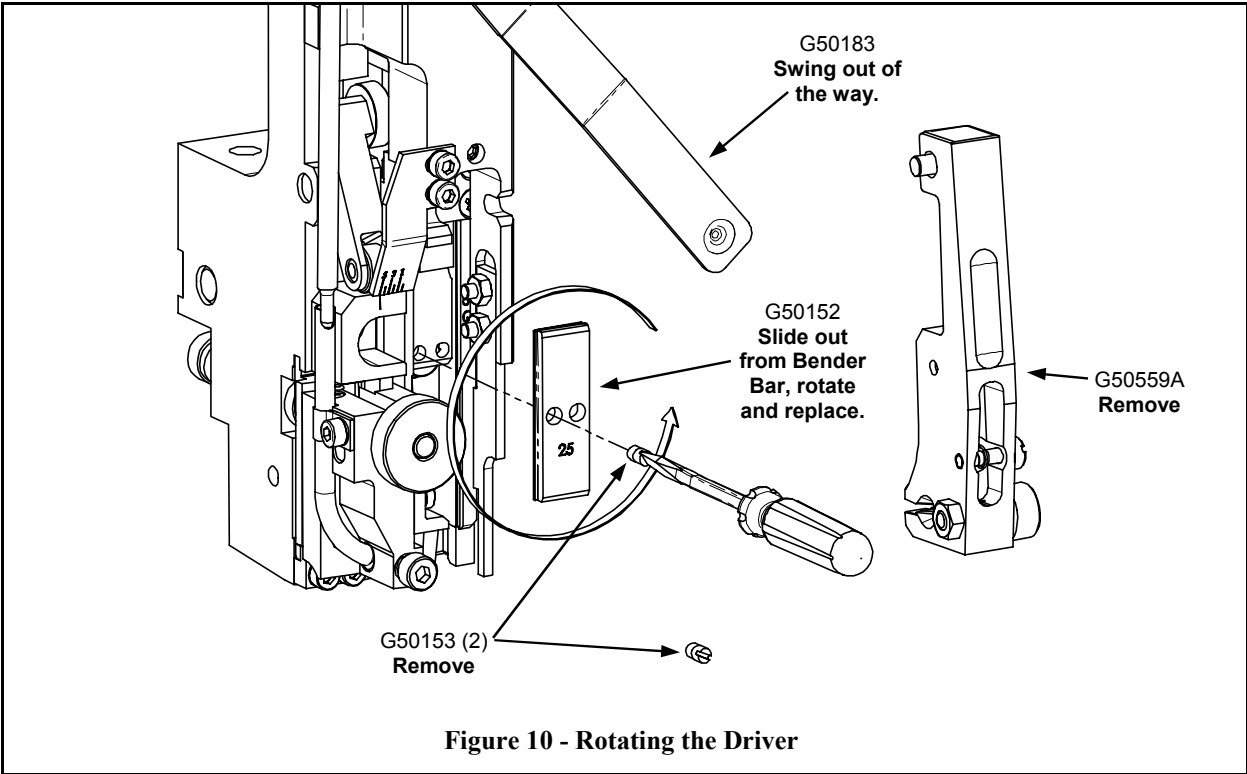
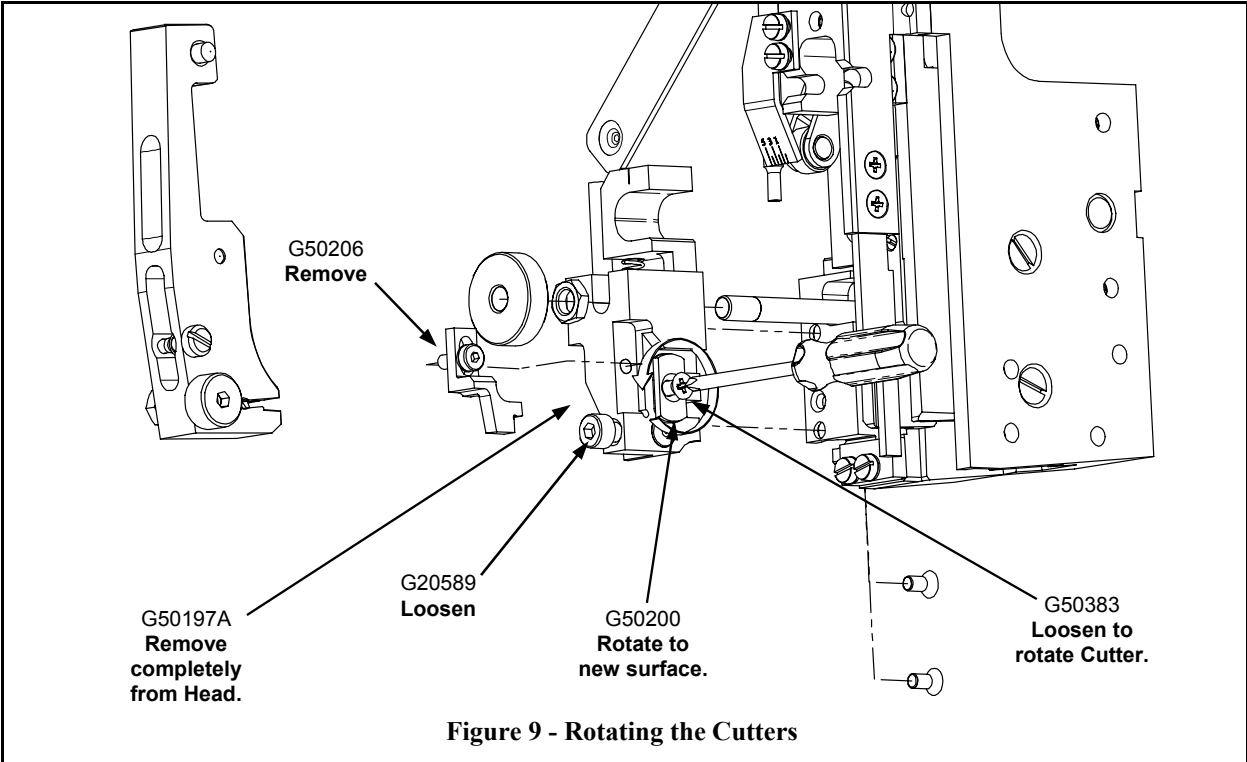


Figure 8 - Lubrication

Rotating Replacement Parts (Figures 9 & 10)



Cleaning

Routine cleaning is important for the maintenance of your G5 Head. Blow off dust, dirt and build-up with compressed air at least during Spool changes. The Head should be refurbished every one million stitches:

- Large Feed Gear Assembly (G50110A):
Remove and wash in a petroleum-based, oil-dissolving solvent, dry and repack the Feed Gear with any general Lithium-based light weight Grease.
- Anywhere that dust, oil, pieces of wire and/or paper have built up:
For example, around the Clincher Points and by the Forming Pin Cam (G50117). Remove the Wire Holder and blow clean with pressurized air.

Troubleshooting (Figure 22)



PROBLEM: Leg[s] Buckled

SOLUTION: If the ends of an unformed piece of wire are not smooth, the Wire Cutters are worn. Check for wear and rotate or replace if needed. (See page) Make sure the Cutters are aligned properly. (See page) Make sure the correct wire size is being used and that the wire is straight. (See page 9).



PROBLEM: Corner Buckled

SOLUTION: Check the Driver for a chipped corner and rotate or replace it if needed. (See page) Align the Wire Holder. (See page) Straighten wire. (See page) Check the tensile strength of the wire or use thicker wire.



PROBLEM: Clinch Too Loose

SOLUTION: The Clincher Points are too low and need adjusting. (See page) The compression of the stitcher machine is insufficient and needs to be increased. The eccentric on the Driving Slide Assembly needs to be adjusted.



PROBLEM: Left Leg Too Short / Right Leg Too Long

SOLUTION: Adjust the position of the Cutter Block Assembly by moving it away from the Head. (See page)



PROBLEM: Left Leg Too Long / Right Leg Too Short

SOLUTION: Adjust the position of the Cutter Block Assembly by moving it away toward the Head. (See page)



PROBLEM: Staple Legs Too Long or Too Short

SOLUTION: Correct the overall wire draw by repositioning the Feed Slide within the G20 Head. (See Page)



PROBLEM: Legs are Spread or Contracted

SOLUTION: Straighten the wire. (See page 13) Replace worn Bender Inserts. (See page 23)



PROBLEM: Legs Stray Forward or Backward Consistently

SOLUTION: The Clincher Points are not aligned properly front to back. (See page 17) Straighten the wire. (See page 13)



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

SOLUTION: Straighten the wire. (See page 13) Make sure the Cutters are aligned properly. (See page 21) Check the tensile strength of the wire or use thicker wire.



PROBLEM: Weak crown, crown breaks off after stitch

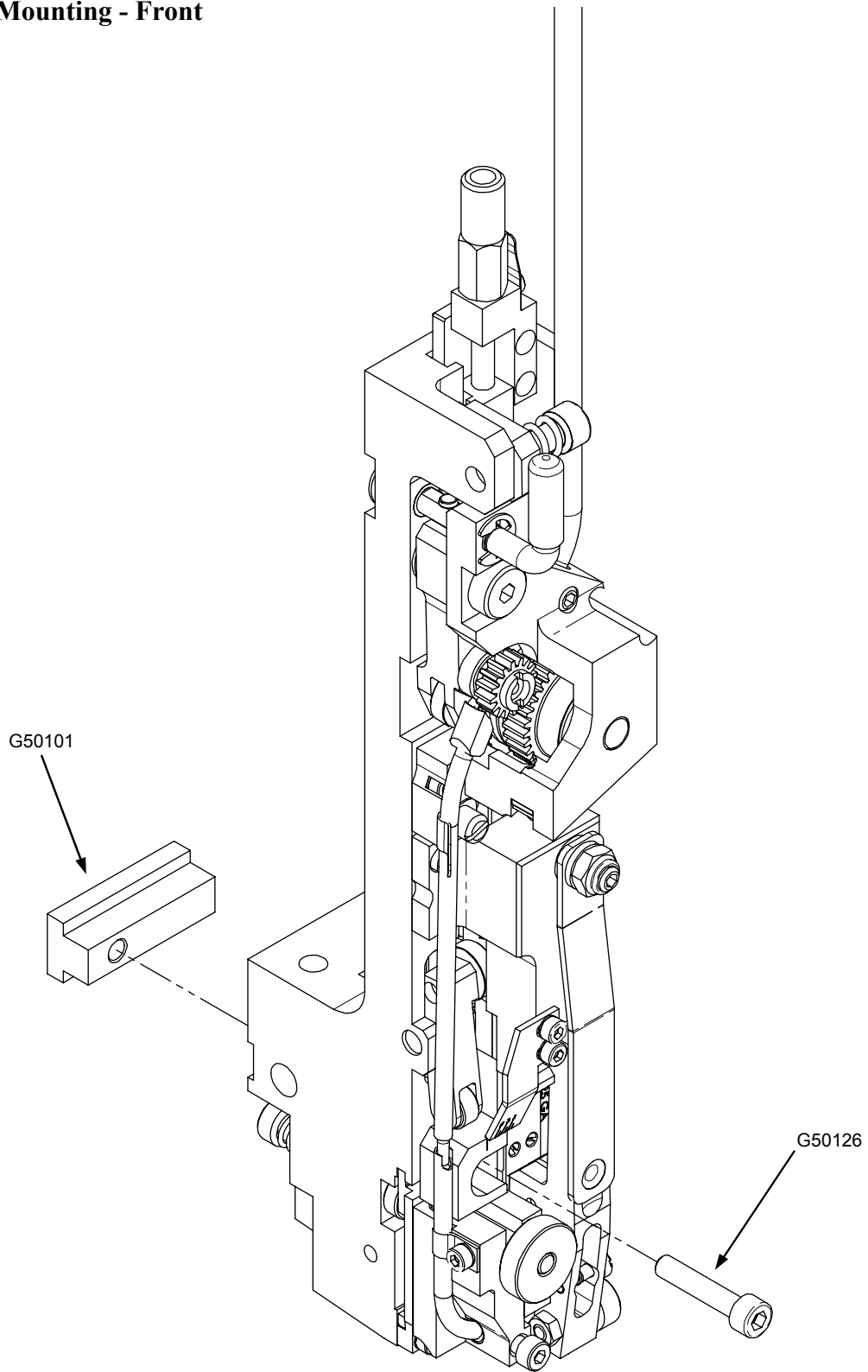
SOLUTION: Align the Wire Holder with the grooves in the Bender Bar (See page 13). Check the tensile strength and size of the wire being used.



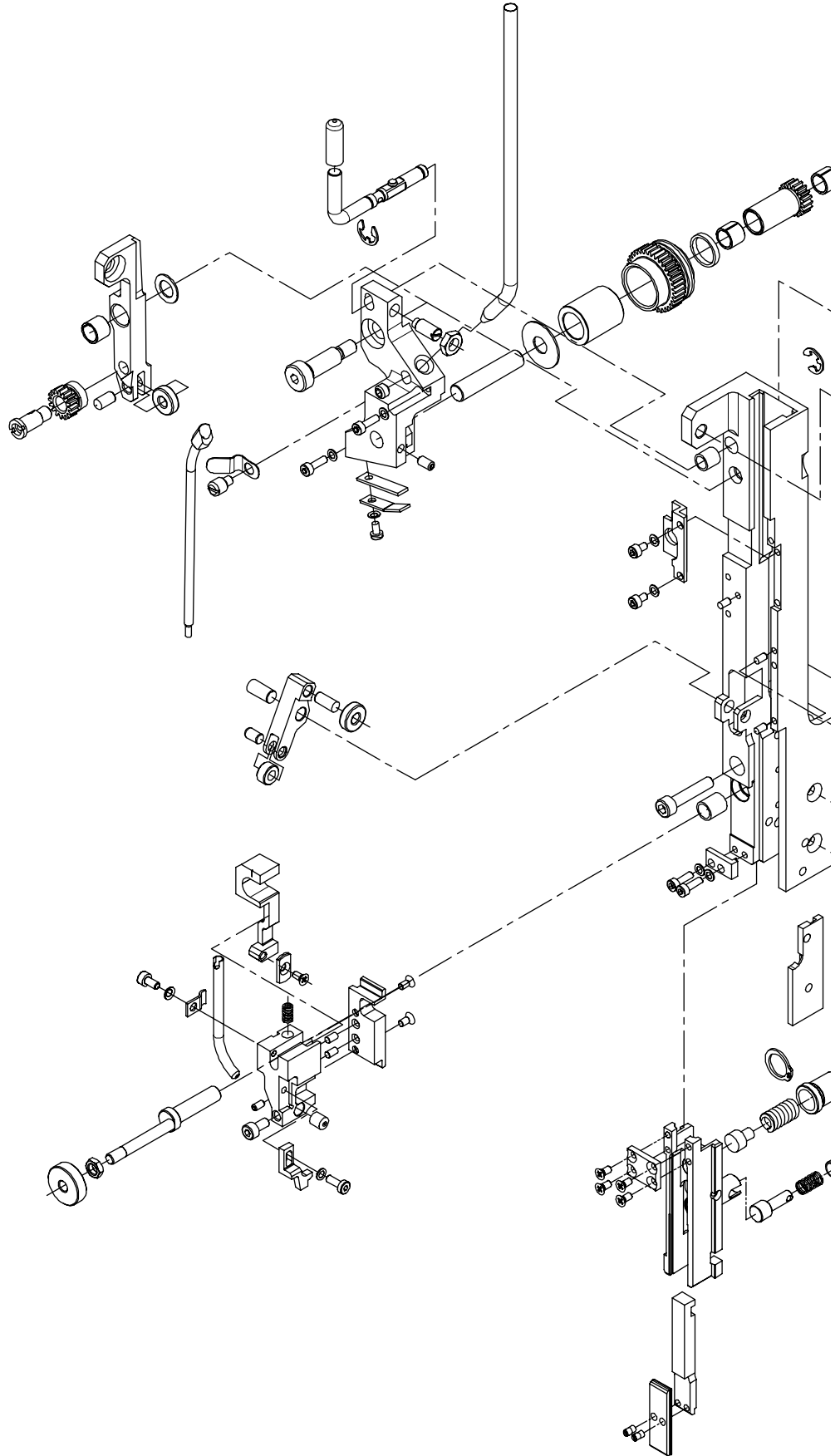
PROBLEM: No wire being drawn

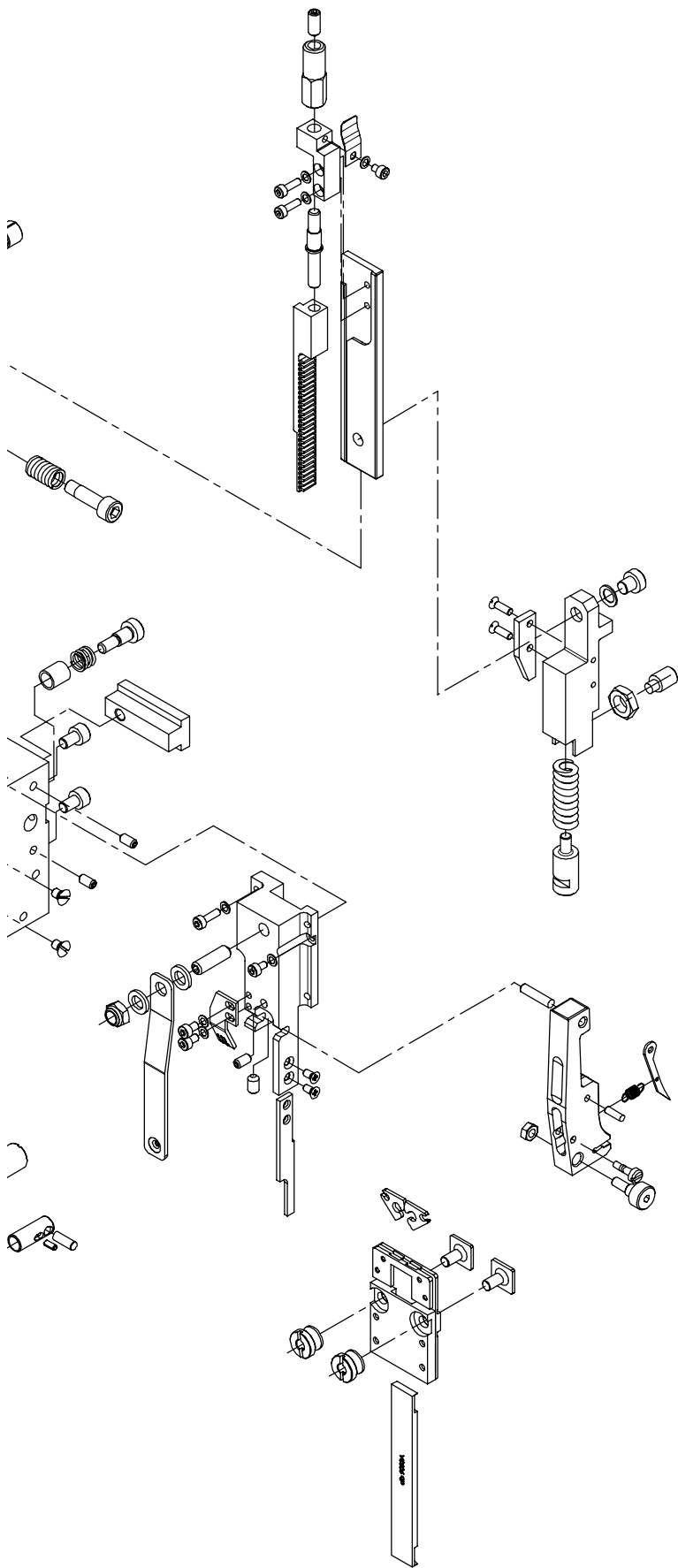
SOLUTION: Make sure the Feed Release Cam is turned to the “on” position and the Feed Gears engaged. (See page 12)

Head Mounting - Front

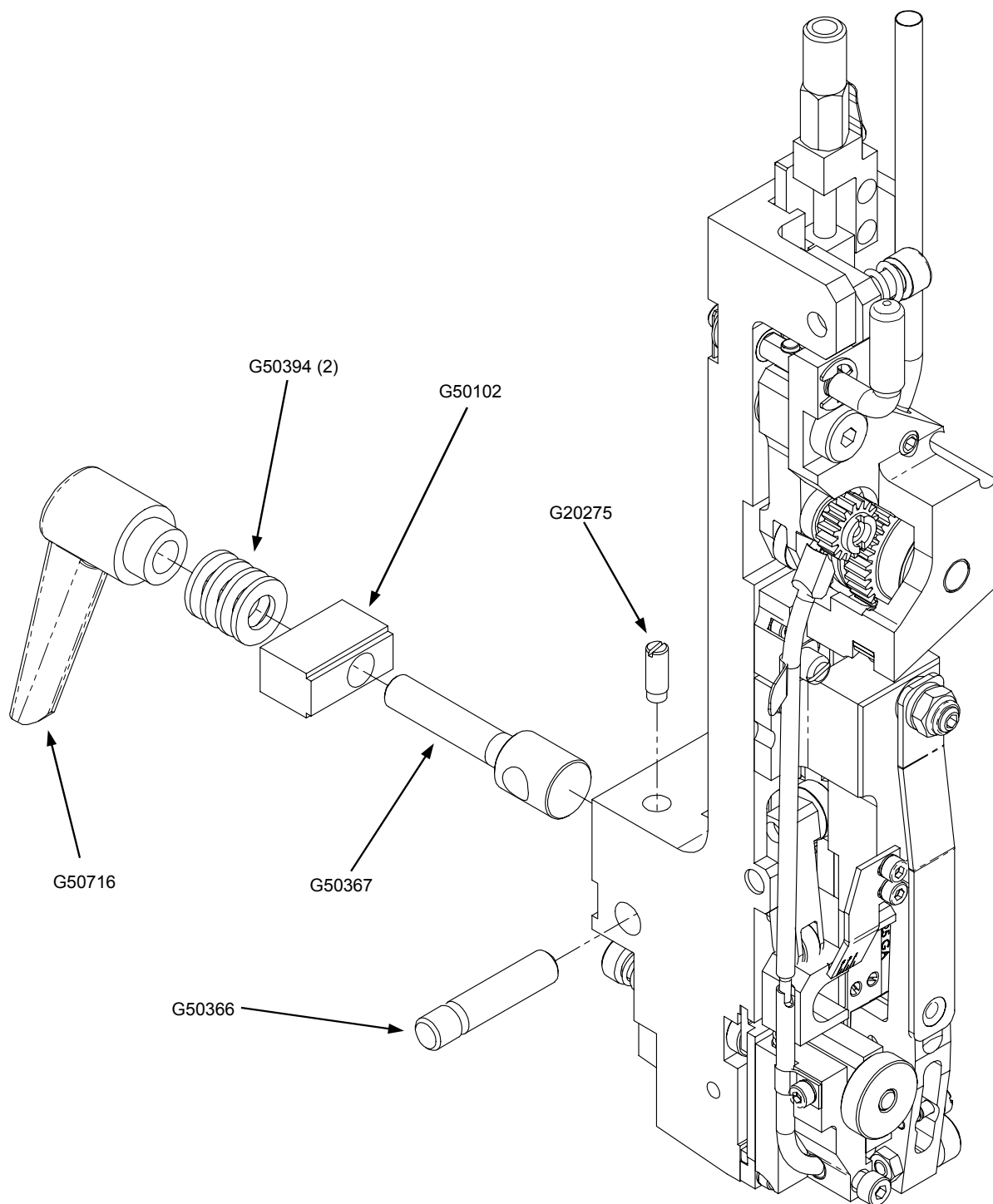


Head Mounting - Front

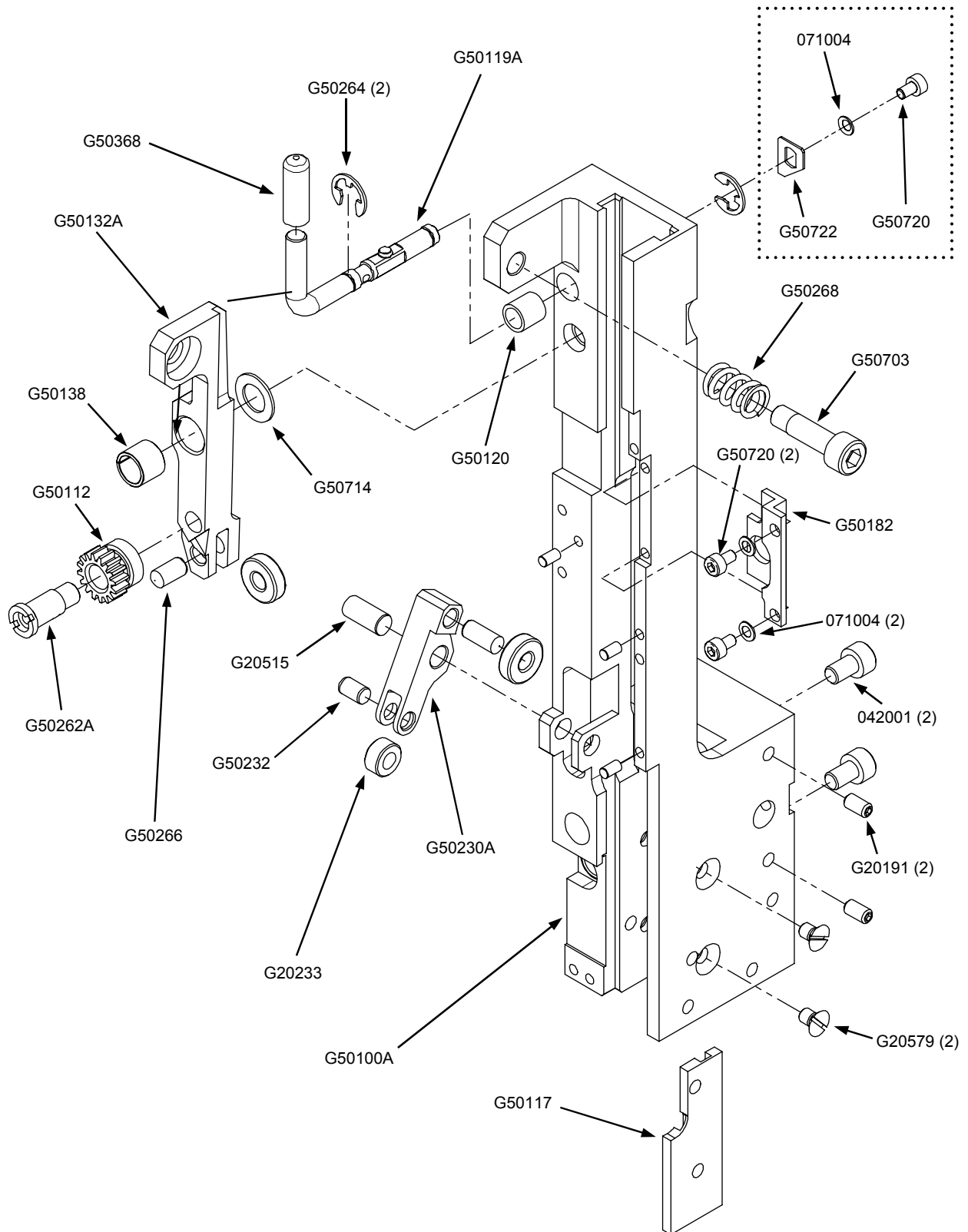




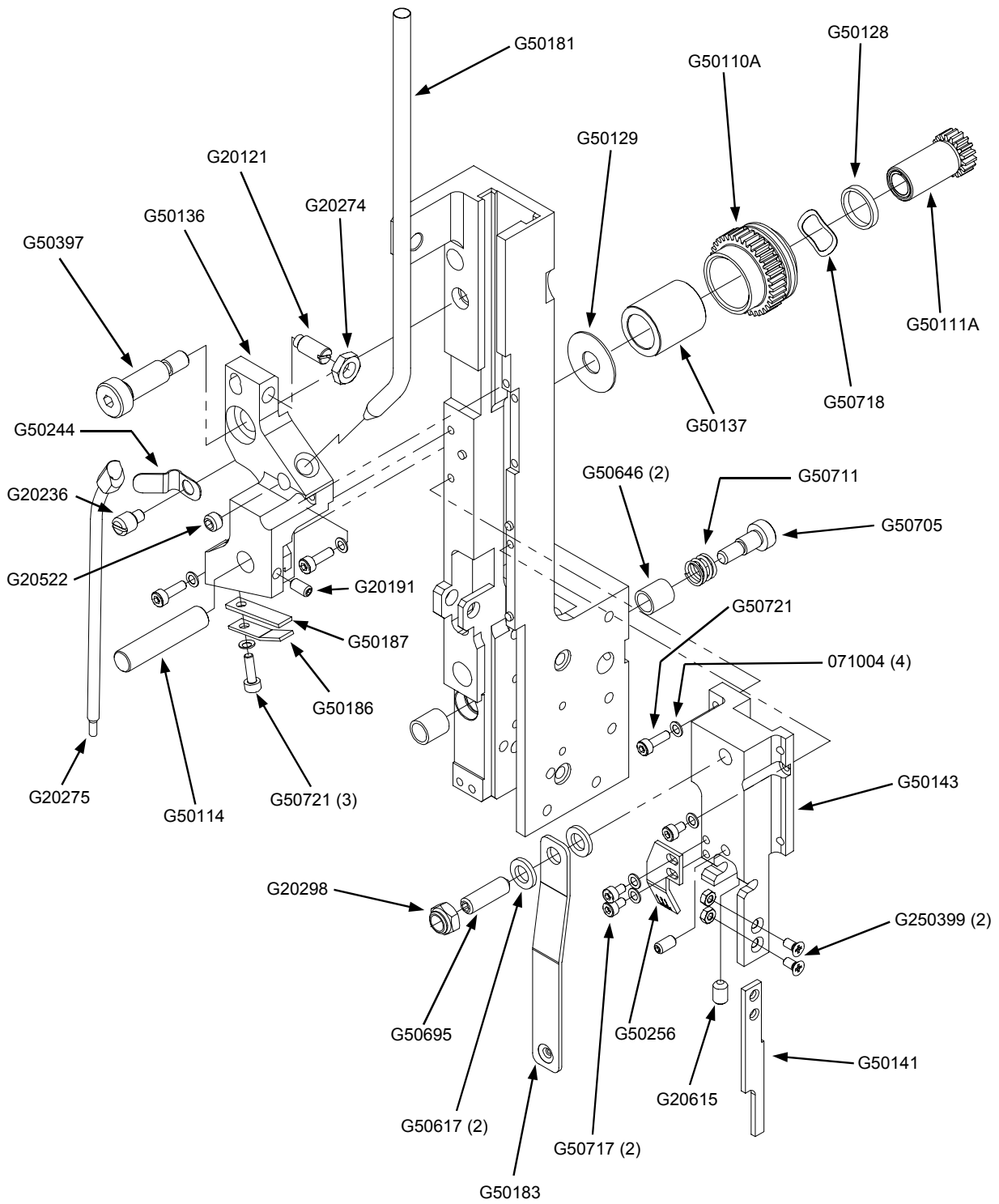
Alternate Head Mounting - Rear



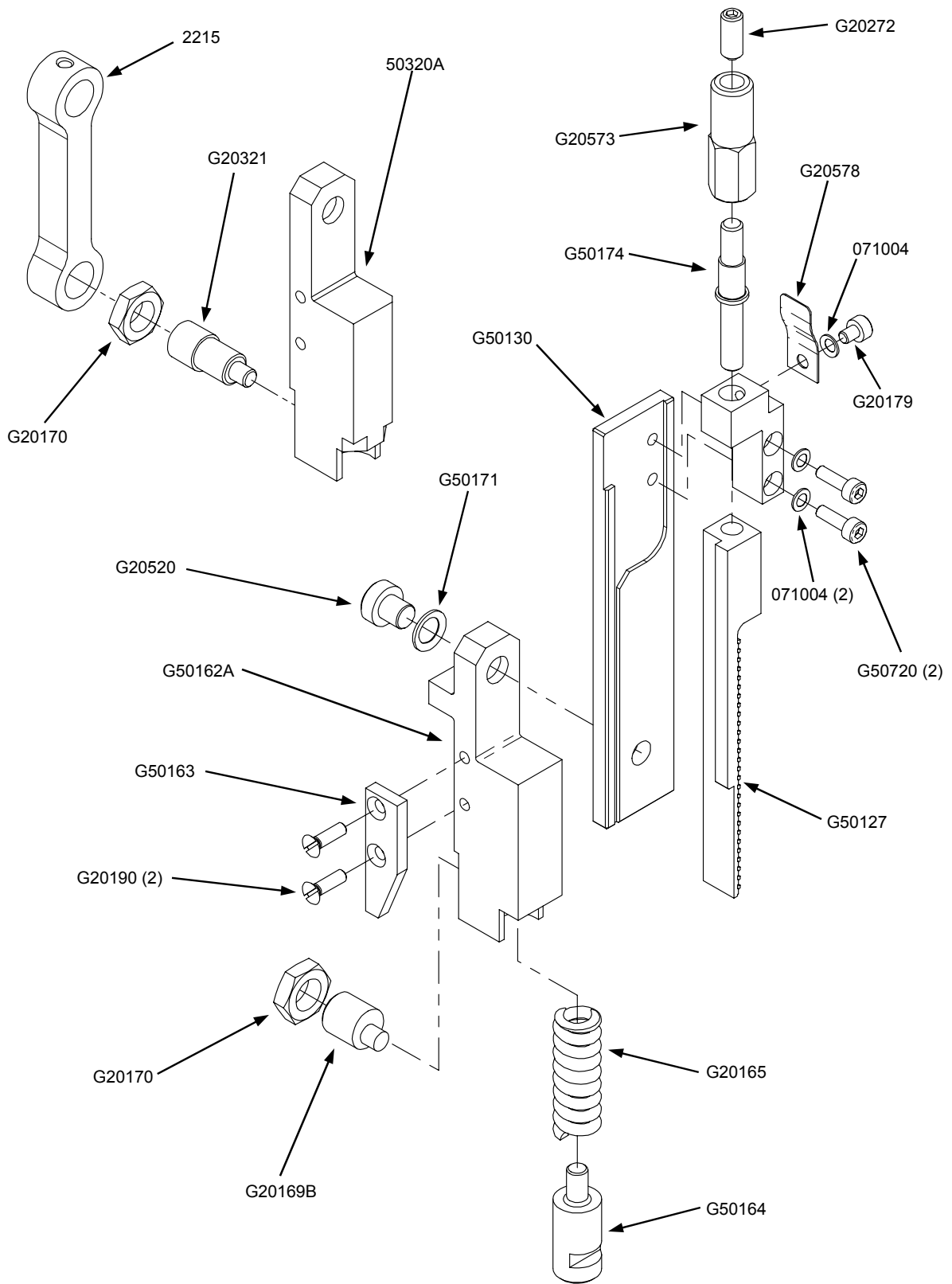
Bonnet—Sub-Assembly #1



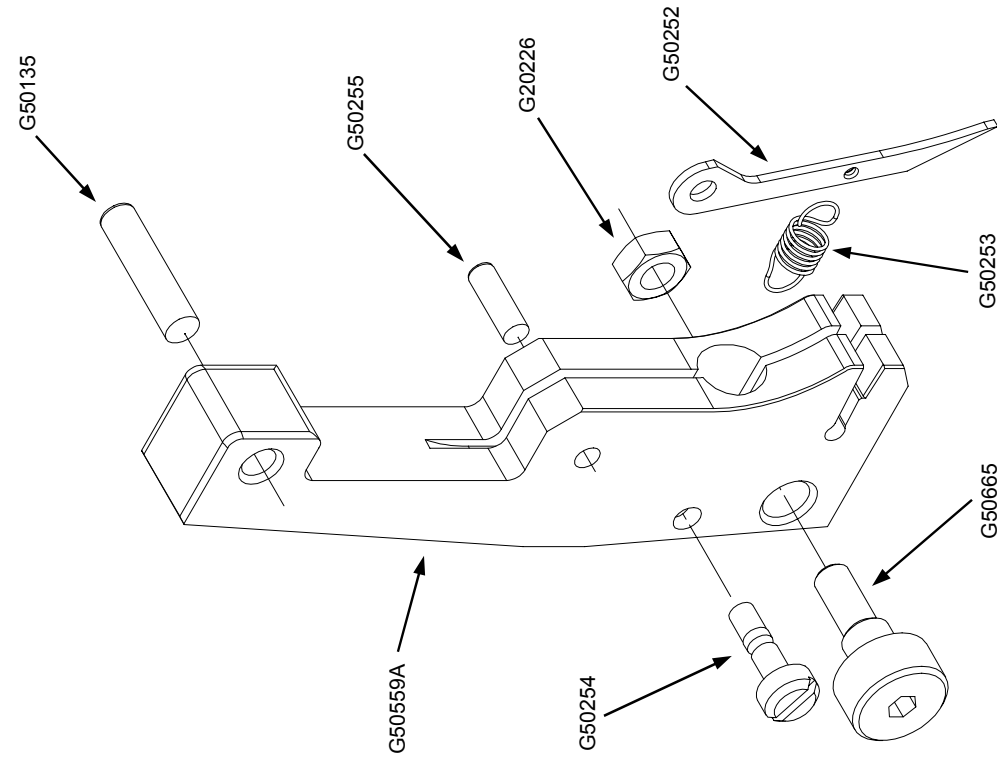
Bonnet—Sub-Assembly #1



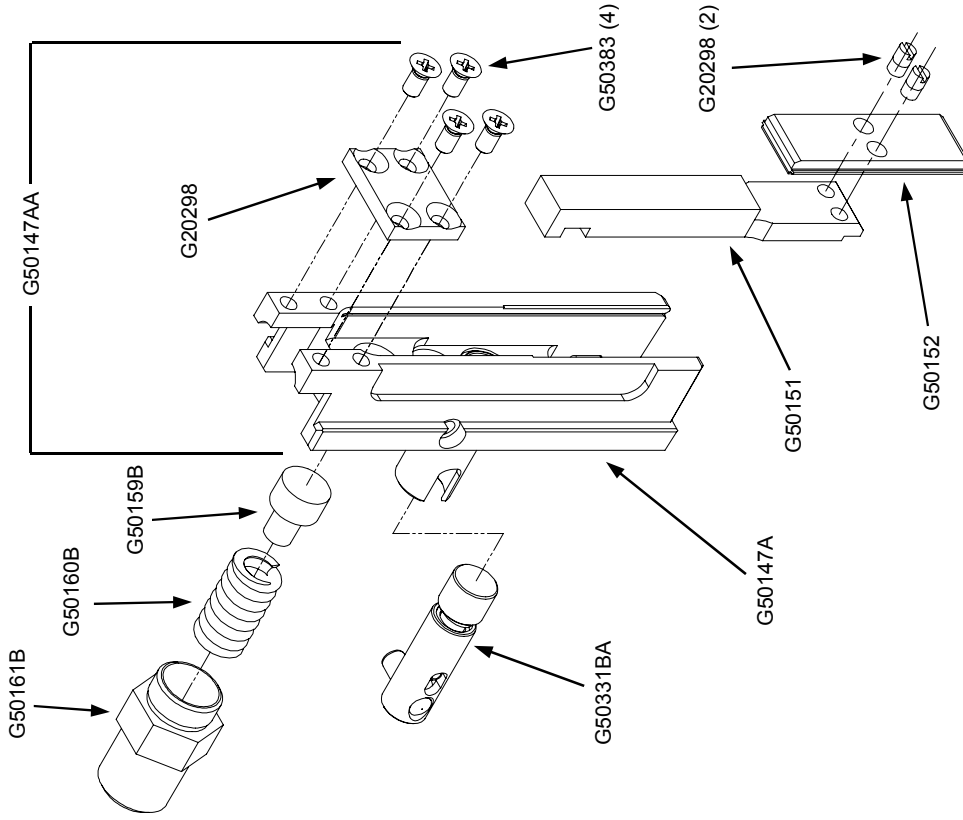
Driver and Feed Slide Assemblies



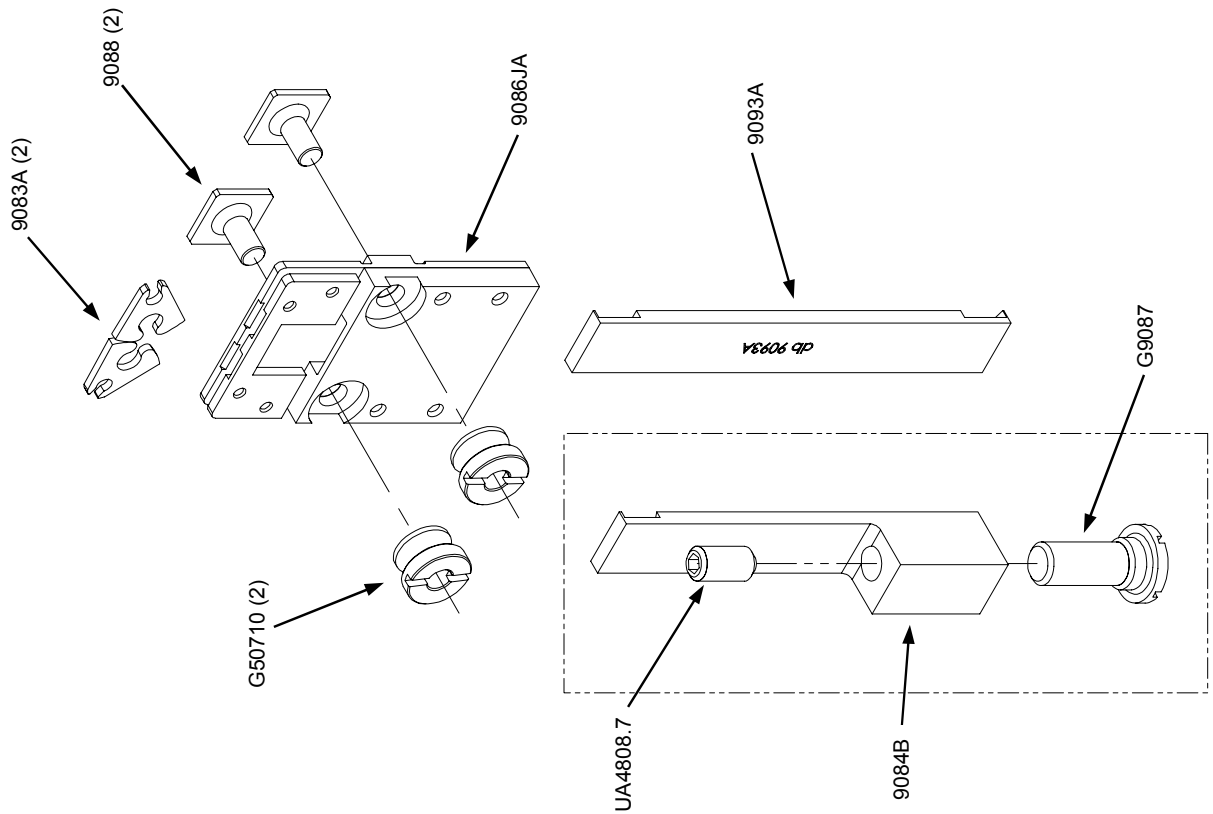
Wire Holder Assembly



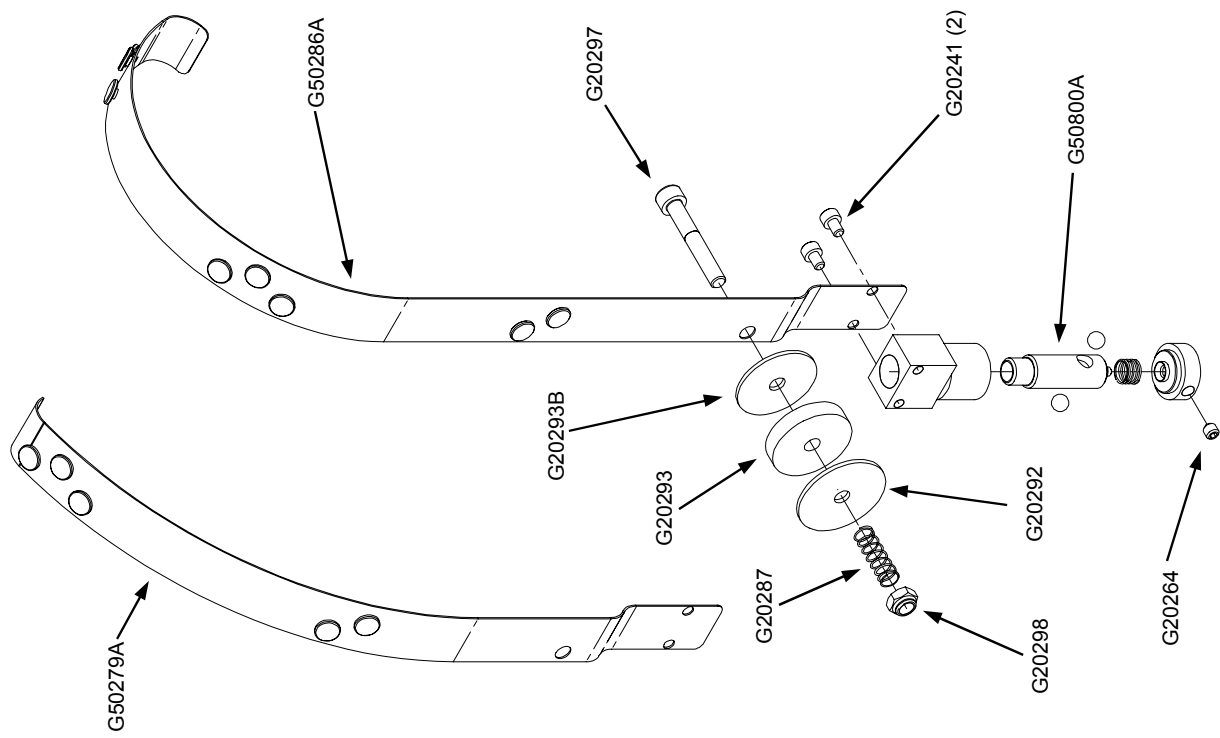
Driver and Bender Bars



Clincher Plate Assembly



Wire Guide Bracket and Spring



Part / Number Description Cross-Reference

G20121	Feed Release Plunger	1	G50101	Clamp Block	1
G20140	Follower Ball Bearing	2	G50102	Mounting Block - Keyed	1
G20165	Driving Slide Spring	1	G50110	Large Feed Gear	1
G20169B	Driving Slide Plunger Screw Ecc.	1	G50110A	Large Feed Gear Assembly	1
G20170	Hex Jam Nut M8x1.25	1	G50111A	Feed Pinion Assembly	1
G20179	Screw M3x0.5x4	1	G50112	Small Feed Gear	1
G20190	Screw M3x0.5x10	2	G50114	Feed Gear Pin	1
G20191	Screw M4x0.7x8	4	G50117	Forming Pin Cam	1
G20226	Hex Nut M4x.7	1	G50119A	Feed Release Handle Assembly	1
G20233	Cutter Operating Lever Roller	1	G50120	Feed Release Handle Bushing	1
G20236	Tube Pivot Screw	1	G50126	Screw M5x0.8x25	1
G20241	Screw M4x0.7x6	2	G50127	Feed Rack	1
G20272	Screw M5x0.8x12	1	G50128	Pinion Washer	1
G20274	Hex Jam Nut, M6x1	1	G50129	Large Feed Gear Washer	1
G20275	Ball Spring Plunger	1	G50130	Feed Adjustment Block	1
G20287	Wire Oiler Felt Spring	1	G50131	Feed Slide	1
G20290	Flat Washer, M5	2	G50132A	Feed Lever Assembly	1
G20292	Wire Oil Felt, Washer	1	G50135	Wire Holder Pivot Pin	1
G20293	Wire Oiler Felt	1	G50136	Feed Gear Bracket	1
G20293B	Wire Oiler Felt, Thin	1	G50137	Feed Gear Clutch	1
G20297	Screw M6x1.0x40	1	G50138	Feed Pinion Bearing	1
G20298	Nylock Lock Nut, M6x1	2	G50141	Wire Guide Bar	1
G20360	Hex Key Wrench 3.0mm	1	G50142	Screw M3x0.5x6	1
G20374	Hex Key Wrench 2.0mm	1	G50143	Pivot Block	1
G20515	Dowel Pin M6x14	1	G50144A	Middle Wire Tube Assembly	1
G20520	Ribbed Lock Washer M6	1	G50145B	Moving Cutter	1
G20522	Screw M6x1.0x5, Nylon	1	G50147A	Bender Bar	1
G20573	Feed Rack Adjustment Knob	1	G50147AA	Bender Bar Assembly	1
G20578	Rack Adjustment Knob Detent	1	G50148	Bender Bar Friction Plate	1
G20579	Screw M4x0.7x6	2	G50151	Driver Bar	1
G20589	Screw M4x0.7x10	1	G50152	Driver - 25 Wire	1
G20615	Screw M5x0.8x8	1	G50153	Driver Retaining Screw	2
G50100A	Bonnet Assembly - G5	1	G50159B	Friction Plug	1

Part / Number Description Cross-Reference

G50160B	Bender Bar Friction Spring	1	G50264	E-Ring 6mm	2
G50161B	Friction Plug Bushing	1	G50266	Dowel M5x10	1
G50162A	Driving Slide Assembly	1	G50268	Feed Lever Spring	1
G50163	Cutter Operating Cam	1	G50279A	Wire Guide Spring Asy - 90 Deg	1
G50164	Plunger	1	G50286A	Wire Guide Spring Asy-180 Deg	1
G50171	Screw M6x1.0x6	1	G50320A	Driving Slide Assembly-Crank Drive	1
G50174	Feed Rack Adjustment Stud	1	G50321	Crank Link Screw	1
G50181	Upper Wire Tube	1	G50331BA	Forming Pin Assembly	1
G50182	Feed Gear Plate	1	G50366	Bonnet Clamp Pin	1
G50183	Wire Holder Retaining Spring	1	G50367	Head Mounting Bolt, M8	1
G50186	Feed Gear Friction Spring	1	G50368	Feed Release Handle Cap - Grey	1
G50187	Feed Gear Friction Pad	1	G50383	Screw M3x0.5x6	7
G50189	Screw M3x0.5x10	1	G50391	Cutter Box Mounting Plate	1
G50197A	Cutter Box Assembly	1	G50394	Flat Washer M8	4
G50198	Cutter Operating Slide	1	G50397	Shoulder Bolt M8x20	1
G50199	Lower Wire Tube	1	G50399	Screw M3x0.5x8	2
G50200	Fixed Wire Cutter	1	G50431	Screw M3x0.5x6	1
G50206	Wire Straightener	1	G50559A	Wire Holder Assembly	1
G50210	Cutter Operating Spring	1	G50604	Cutter Box Guide Plate	1
G50223	Dowel Pin M3x6	7	G50617	Wire Holder Retain. Spring Washer	2
G50228A	Manual Feed Gear Tool	1	G50646	Cutter Box Eccentric Bearing	2
G50230A	Cutter Operating Lever Assembly	1	G50665	Wire Holder Adjustment Screw	1
G50232	Dowel Pin	1	G50666	Clincher Alignment Gage, G5	1
G50235	Dowel Pin M5x12	1	G50695	Screw M6x1.0x20	1
G50237	Cutter Box Adjusting Eccentric	1	G50703	Feed Lever Spring Screw	1
G50244	Tube Clip	1	G50705	Shoulder Screw M6x8	2
G50245	Cutter Box Adjustment Knob	1	G50707	Dbl. Open End Wrench - 5.5 & 7mm	1
G50252	Wire Hook	1	G50708	T-Handle Hex Key Wrench	1
G50253	Wire Hook Spring	1	G50710	Clincher Plate Nut	2
G50254	Wire Holder Spring Screw	1	G50711	Cutter Box Ecc. Screw Spring	2
G50255	Dowel Pin M3x10	1	G50713	Hex Jam Nut M5	1
G50256	Scale	1	G50714	Feed Lever Spacer	1
G50262A	Small Feed Gear Shaft Assembly	1	G50716	Mounting Block Handle	1

Part / Number Description Cross-Reference

G50717	Hex Nut M3x0.5	2	071004	Lock Washer Ribbed	17
G50718	Feed Gear Spring	1	2215	Driving Shaft Connector	1
G50719	Lower Tube Clip	1	9083A	Clincher Point - Thick, Round	2
G50720	Screw M3x0.5x6	9	9084B	Adjustable Clincher Slide	1
G50721	Screw M3x0.5x10	6	9086JA	Clincher Plate - Thick, G5	1
G50722	Feed Release Handle Stop	1	9087	Clincher Slide Adjustment Screw	1
G50800A	Wire Anti-Back Up Unit - M6 Tube	1	9088	Clincher Plate Binder Bolt	2
UA4808.7	Screw 1/4-28 x 1/4	1	9093A	Clincher Slide - Thick	1
042001	Screw M5x0.8x8	2			

NOTES:



THANK YOU FOR
CHOOSING THE
G5 STITCHER HEAD
FOR YOUR BINDING
NEEDS.



Limited

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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Warranty

