

DELUXE STITCHER

C O M P A N Y I N C .

Head Serial Number : _____

Date Purchased : _____

Where Installed: _____

(make/model of machine)

G8 Stitcher Head

OPERATION AND MAINTENANCE MANUAL

Wire Sizes: 23-28 Ga. Round, 20x24 and 21x25 Flat

Crown Size: 1/2" (13.5 mm)

Capacity: 2 sheets to 5/16" (8 mm) Standard

2 sheets to 5/32" (4 mm) Loop

Before using this Stitcher Head, all operators must study this manual and follow the safety warnings and instructions. Keep these instructions with the G8 Stitcher Head for future reference. If you have any questions, contact your local DeLuxe Stitcher Company Graphic Arts Representative or Distributor.

WARNING!

G8 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

Each Head in the G8 Stitcher Head Series is basically identical with respect to operation. The style variations in the Heads mentioned below, occur in some of the component parts used for adaptation to single stitch or gang stitch machines. As model design changes are made, part numbers also change.

These Heads were designed with a side-feed element to eliminate the need for a Swivel and to increase their reliability. Well suited for all makes and models of stitcher machines and collators, the G8-style Stitcher Head is user-friendly.

Typical Style Uses:

G8BHDNo. 2 and M2 Wire Stitchers
G8MHDNo. 17 and M17 Wire Stitchers
G8HDAutomatic Saddle-Stitchers,
.....Gang-Stitchers, Multibinders and Others

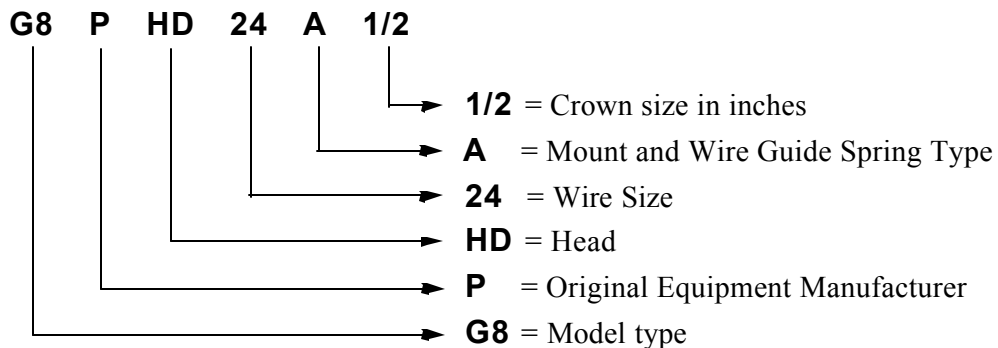
Examples of Replacement Heads for OEM Users*:

AM Graphics / Harris / Heidelberg / Sheridan
455, 562, 690 G8HD24A
AM Graphics / Harris / Heidelberg / Sheridan 705 G8HD24A
Bourg G8HD24D
Christensen G8HD24A
Horizon SP, SPF G8HD24D
Macey MultibinderG8HD24B
McCain..... G8HD24A
RosbackG8HD24B

* These are just a few examples of the replacement heads available for these OEM's.

Part Number Definition

The part number for each Stitcher Head can be used to define the stitcher head itself, in most cases. The Head's model type, mounting style, nominal wire size and crown size can all be determined from the part number.

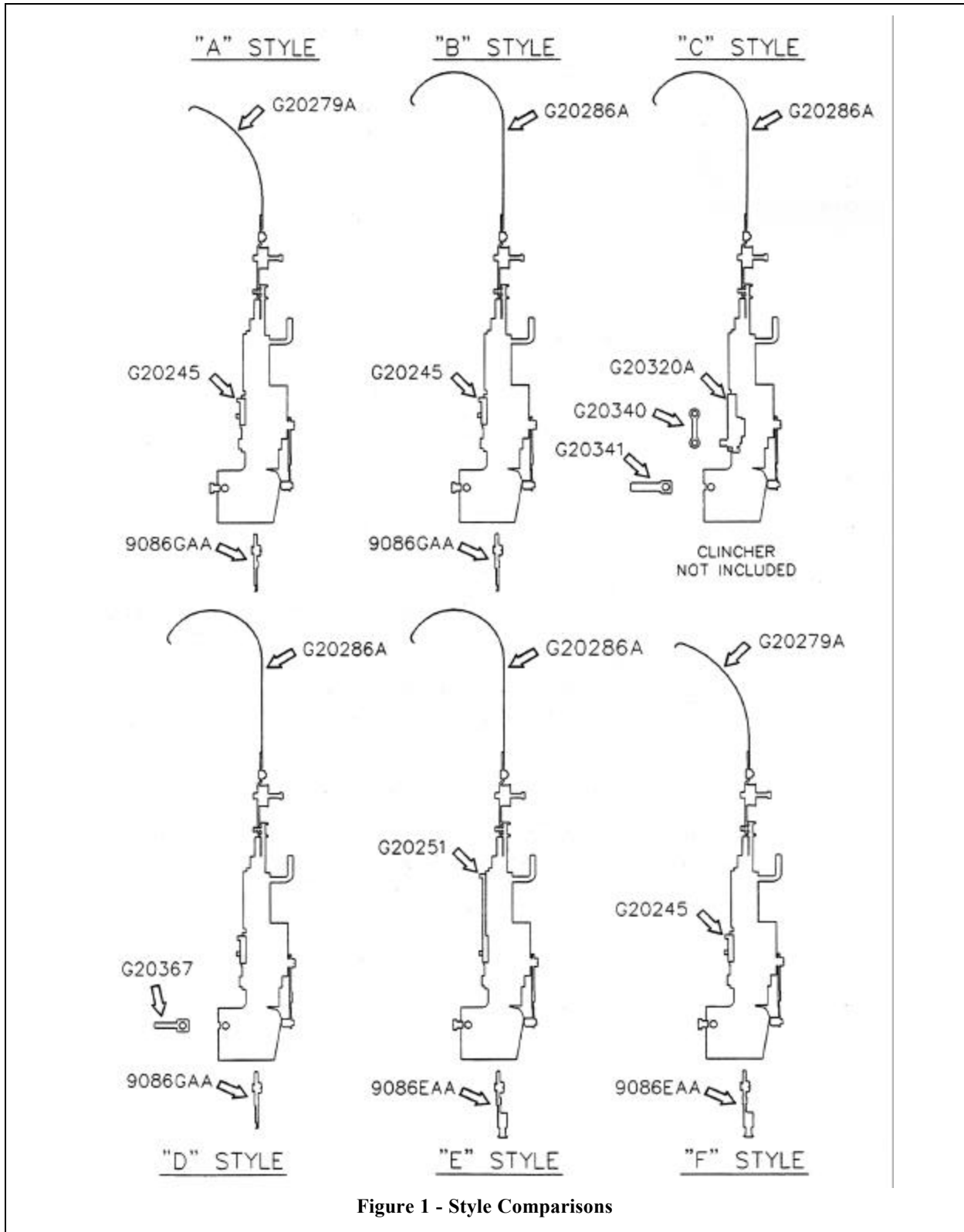


Model Differences

Generally speaking, the following part numbers indicate which Stitcher Heads can be used as replacement heads for your Stitcher Machine or collating system*. Refer to Figure 1 for more information.

- Style “A” - Models G8HD24A, G8HD24AL, G8HD2125A and G8HD23A. These Heads come with a Short Wire Guide Spring Assembly (G20279A), Upper Cutter Adjustment Bar (G20245) and a Thick, Round Clincher Plate Assembly (A9086A).
- Style “B” - Models G8HD24B, G8HD2125B, G8HD24BL. These Heads come with a Long Wire Guide Spring Assembly (G20286A), a shorter Upper Cutter Adjustment Bar (G20245) and a Thick, Round Clincher Plate Assembly (A9086A)
- Style “C” - Models G8HD24C, G8HD24CL, G8HD2125C. These Heads are for use on Bolt-Mount / Crank-Driven Stitchers. They come with a Long Wire Guide Spring Assembly (G20286A), Rear Mounting Bolt (G20341), Crank Drive Link (G20340), Driving Slide Assembly (G20320A) but no Adjustment Rail or Clincher Plate Assembly.
- Style “D” - Models G8HD24D, G8HD24DL, G8HD2125D. These Heads come with a Long Wire Guide Spring Assembly (G20286A), a Thick, Round Clincher Plate Assembly (A9086A) and a Rear Mounting Bolt (G20367) but no Adjustment Bar.
- Style “E” - Models G8HD24E, G8HD24EL, G82125E. These Heads come with a Long Wire Guide Spring (G20286A), a Long Adjustment Bar (G20251) and a Clincher Plate Assembly (9086EAA)
- Style “F” - Models G8HD24F, G8HD24FL, G8HD2125F. These Heads are identical to Style “A” Heads except they come with a Thick Adjustable Clincher Slide Assembly (9193A).

* These are just examples and should be used as reference only.



Specifications

Weight

Shipping Weight 11 lbs (5 kg)

Physical Dimensions

Height 13-9/16" (345 mm)

Width 2-3/4" (70 mm)

Stitching Capacity Two Sheets to 5/16" (8 mm)

..... Two Sheets to 5/32" (4 mm) Loop

(stitching capacities are highly dependent on wire and paper type, tensile strength and machine capacity)

Wire Types 23 through 28 round or

..... 20x24 and 21x25 flat

(24 gauge round standard)

Crown Sizes 17/32" (14mm)

..... 13/64" (5mm) Loop

Minimum Head Centers

..... 2-3/64" (52mm) at two sheets to

..... 1/16" (1.5mm) material thickness

..... loop = 56mm at two sheets to 2mm

Stitches Per Hour 20,000 or 12,000 with Loop Head

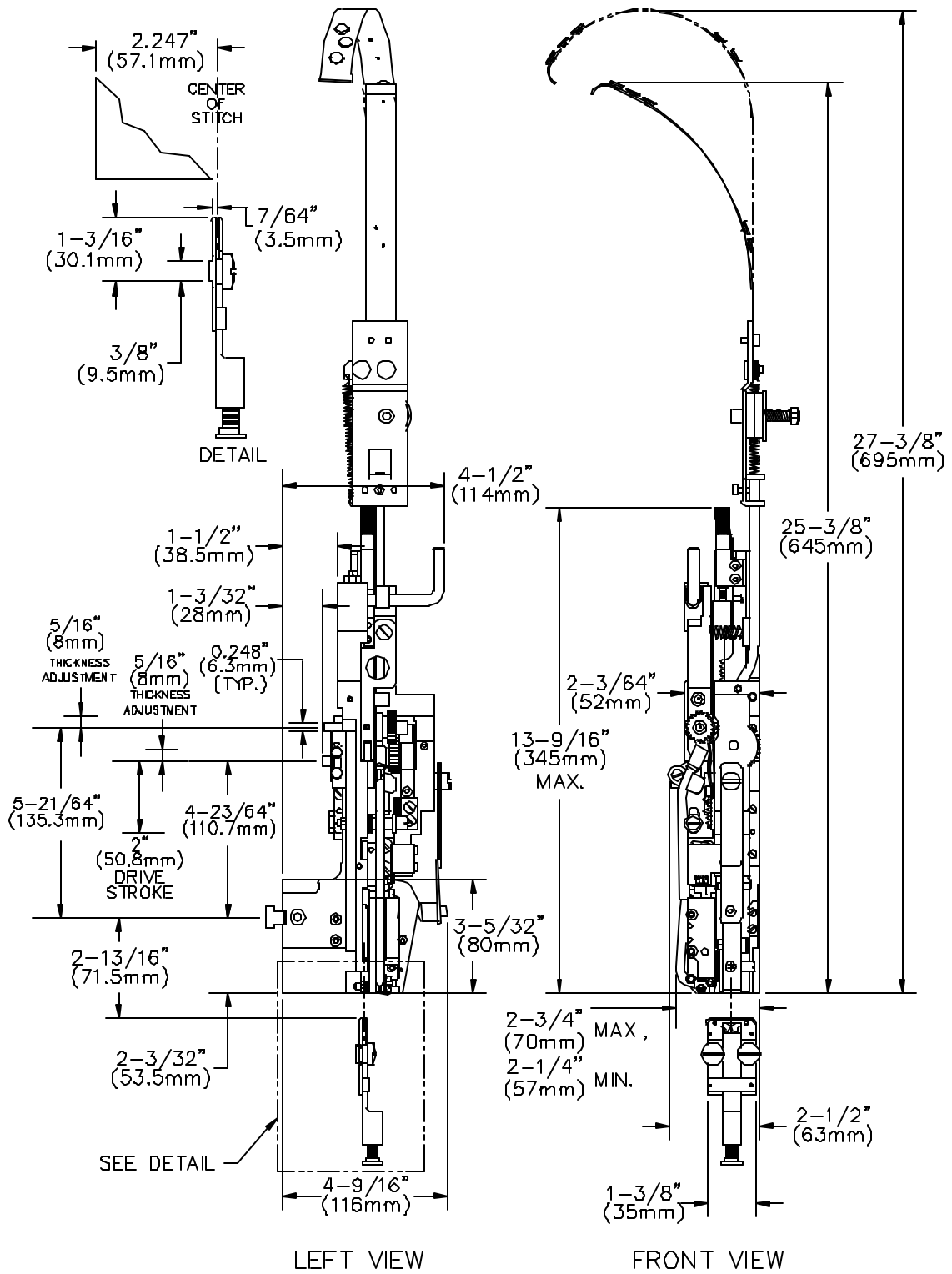
Replacement for: Interlake/Acme/Champion/

..... Magnatek/M2000 heads,

..... 26/26D Model Heads, or Hohner

..... 52/8, 55/7, 43/6 and 48/5 Heads

Dimensions



Installation

Pre-Inspection

Carefully inspect the condition of the shipping container before unpacking your G8 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 G8 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 2** in this manual for reference to the following pieces:

- G8 Manual
- 2.0mm Hex Key Wrench (G20374)
- 2.5mm Hex Key Wrench (G20361)
- 3.0mm Hex Key Wrench (G20360)
- 5.0mm Hex Key Wrench (G20362)
- 7.0mm Open End Wrench (G20364)
- Complete Wire Guide Spring Plate Assembly (G20278AA)
- Adjustment Knob Assembly (G20228A)
- Short (G20279A) or Long (G20286A) Wire Guide Spring Assembly
- Clincher Plate Assembly - Thick (9086A)
- Round (9083A) or Flat (9083C) Thick Clincher Points
- Clamp Block (9002) and Clamp Block Eccentric (G20124) or Rear Clamp Pin (G20366) and Rear Mounting Bolt (G20367 or G20341)
- Either Clincher Plate Binder Nut (2091), Bolt (9088) and Thick Clincher Slide (9093A) or Clincher Plate Binder Nut (2091), Bolt (9088), Adjustable Clincher Slide (9084B), Clincher Slide Adjusting Screw (9087) and Clincher Slide Adjusting Lock Screw (UA4808.7).
- Stitch Samples

*** Note: the accessories included with the G8 will vary with the style of Head purchased**

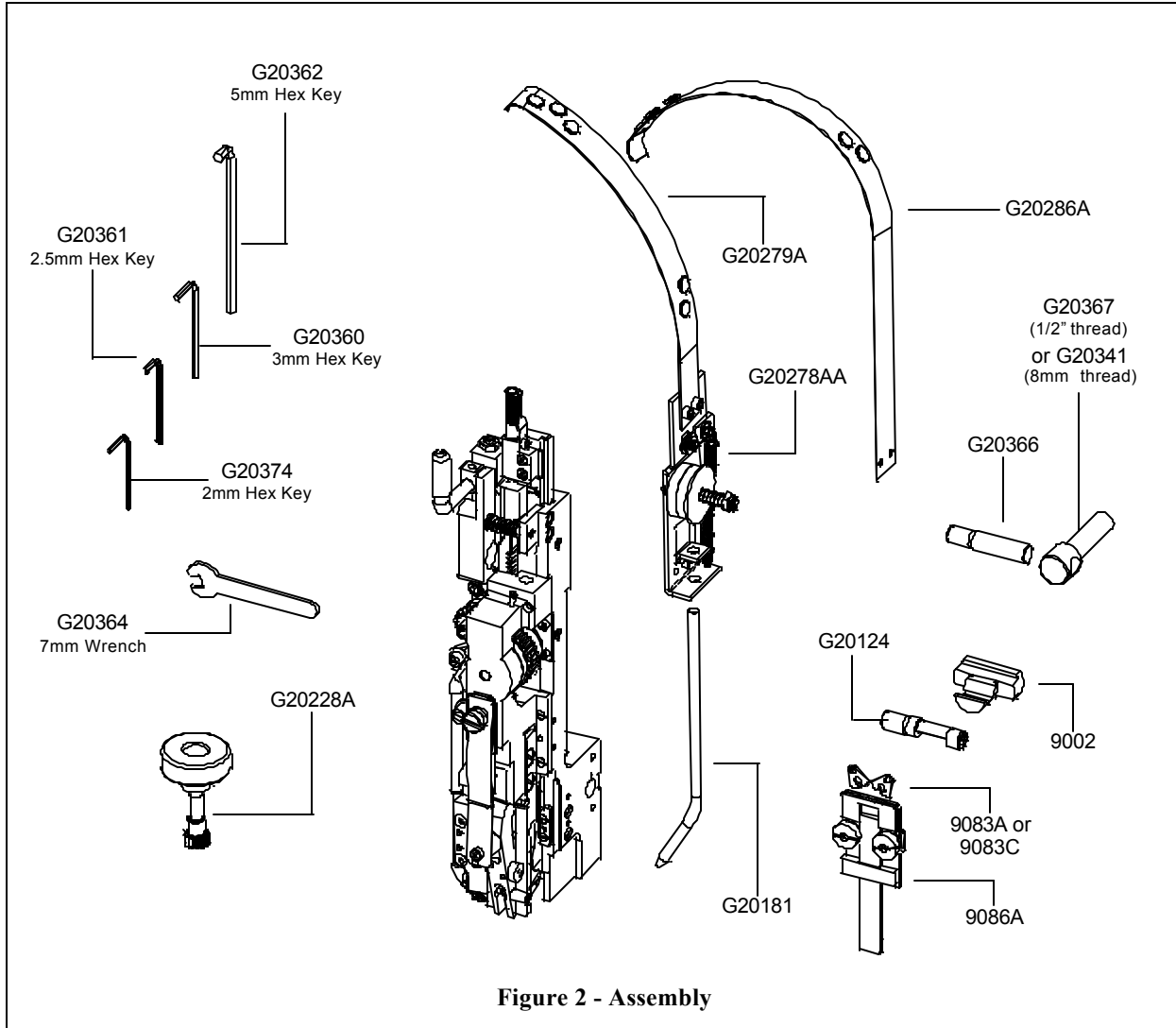


Figure 2 - Assembly

Pre-Installation

Please take a few moments to fill out the registration card located on page 56 prior to beginning installation.

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

Assembly

Each new G8 Stitcher Head comes fully assembled with the exception of the Complete Wire Guide Spring Plate Assembly (G20278AA), the Wire Guide Spring (G20279A or G20286A) and the Clincher Plate Assembly (9086A). Slip the Wire Guide Spring Bracket onto the Upper Wire Tube (G20181) and rotate until the Bracket accommodates the wire payoff of the stitcher machine. Tighten the Socket Head Cap Screw (G20288) to hold the Wire Guide Spring Bracket Assembly in place.

Attach the Clincher Plate Assembly (9086A) to the clincher mounting rail of the stitcher machine using the Binder Nuts (2091) and Binder Bolts (9088) provided. Center the Clincher Slide (9084B or 9093A) under the Driver Bar (G20151) and Driver (G20152, G20352 or G20358) of the G8 and leave the Bolts loose until the Head is firmly positioned. (See **Figure 11**).

Mounting

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.

G8HD24A, G8HD24B, G8HD24E and G8HD24F (Slot Mount/Rail Drive)

These G8 Head Models come with a Bonnet Clamp Block (9002) and Clamp Block Eccentric (G20124) for use on stitchers with a T-Slot mounting rail. Refer to **Figure 3**. Slide the Clamp Block into the T-slot on the stitcher, as shown. Align the marks on the Eccentric with those on the Bonnet. Next, slide the Head onto the Clamp Block and against the stitcher machine. Make sure the Driving Slide (G20162BA) and the Adjustment Bar (G20245 or G20251) are in their respective slots on the stitcher machine. Rotate the 5mm Hex Key Wrench (G20362), in the Eccentric as shown, to secure the G8 Head to the stitcher machine.

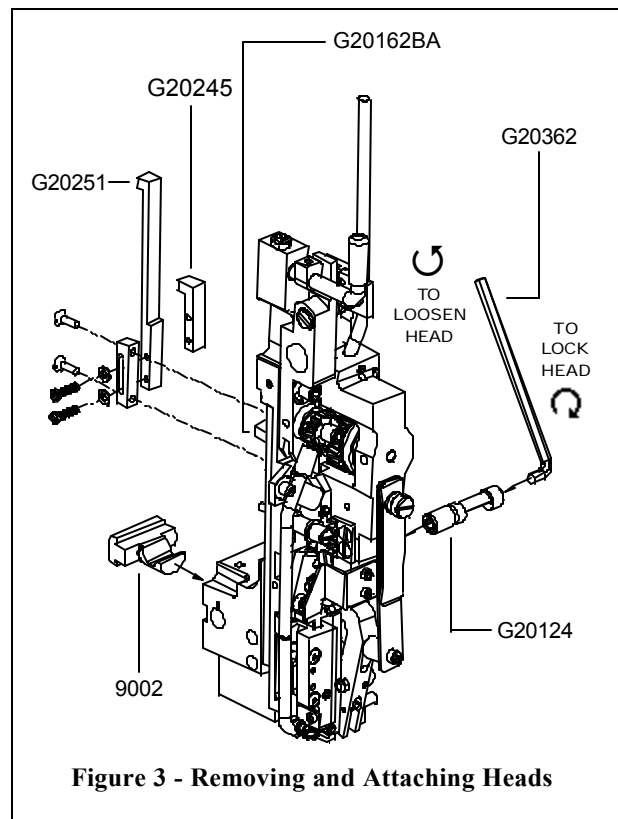


Figure 3 - Removing and Attaching Heads

NOTE: For stitcher machines with no adjustment rail, remove the Cutter Block Adjustment Bar (G20245 or G20251) and the Cutter Block Adjustment Connector (G20246).

G8HD24C (Bolt Mount/Crank Drive)

This G8 Head comes with a Rear Mounting Bolt (G20341 or G20367), a Rear Clamp Pin (G20366) and a Bonnet Stud Nut (HN1213) for mounting. The G8HD24C also comes with a Crank Drive Link (G20340) and Driving Slide Assembly (G20320A) for driving the Head. **Refer to Figure 4.**

NOTE: Instructions may vary with other types of Bolt Mount/Crank Drive machines.

Insert the Rear Mounting Bolt into the hole of the Bonnet casting and secure it with the Rear Clamp Pin. Engage the Crank Drive Link (G20340) with the Driving Slide Assembly (G20320A) on the back of the stitcher head. The Driving Slide Pin must be inserted in the lower hole of the Link. (The lower hole of the Link is the one opposite of the oil hole.) With the Link held in a vertical position, line the head up with the machine. Engage the machine's Crank Pin in the upper hole of the Driving Shaft Connecting Link.

G8HD24D (Bolt Mount/Rail Drive for Bourg and Horizon)

This G8 Head comes with a Rear Mounting Bolt (G20367), a Rear Clamp Pin (G20366) and a Mounting Block Handle (G50716) for mounting. **Refer to Figure 4.**

NOTE: Instructions may vary with other types of Bolt Mount/Rail Drive machines.

Insert the Rear Mounting Bolt into the hole of the Bonnet casting and secure it with the Rear Clamp Pin. Position the Driving Slide Assembly Eccentric (G20162BA) approximately where it will meet up with the rails of the stitcher machine or a little lower. Line the Rear Mounting Bolt up with the mounting hole in the stitcher machine and loosely secure the Bolt with the Hex Jam Nut. Push on the Head's Bender Bar until the cam on the Driving Slide Assembly lines up with the rail of the stitcher machine.

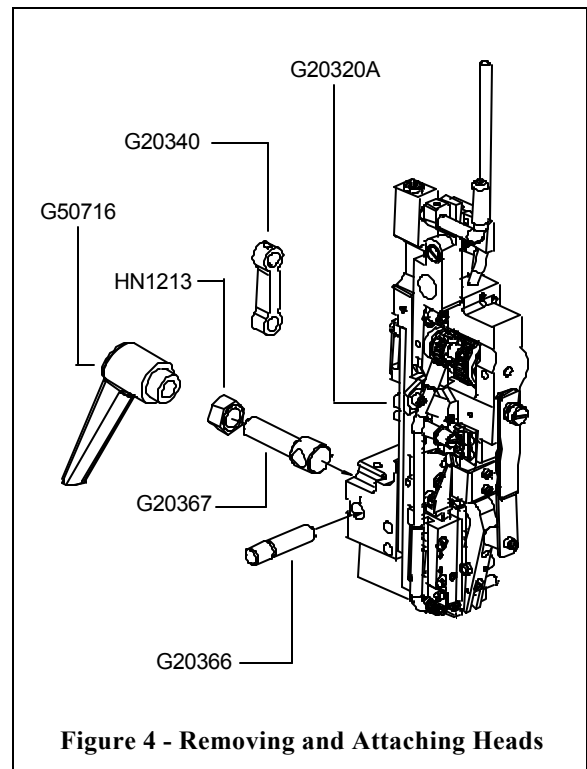


Figure 4 - Removing and Attaching Heads

Always cycle the stitcher machine manually after mounting a head and before running under power

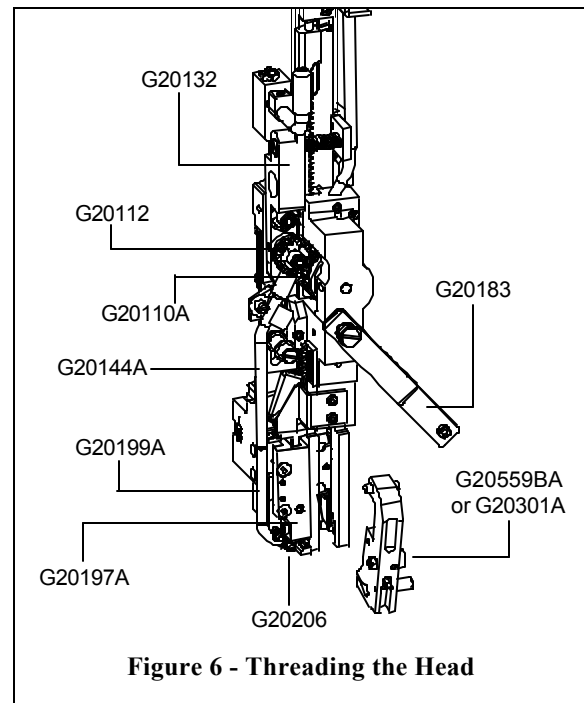
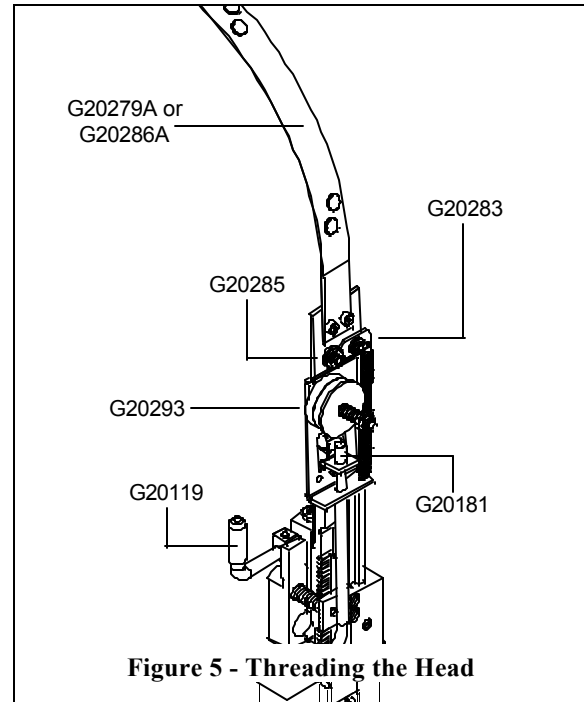
⚠ WARNING

Operation

Wire Threading (Figures 5 & 6)

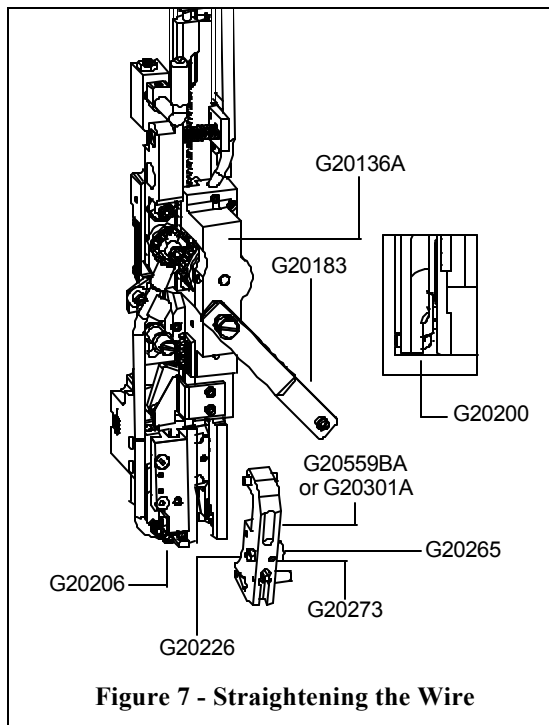
1. Slide the Wire Holder Retaining Spring (G20183) over to the side and remove the Wire Holder Assembly (G20559BA or G20301A) from the Stitcher Head.
2. Pass the wire from the Spool over the Wire Guide Spring Assembly (G20279A or G20286A), between the Tension Pawl (G20283) and the Tension Pawl Roller (G20285), between the two (2) Wire Oiler Felts (G20293) and into the Upper Wire Tube (G20181).
3. Turn the Feed Release Handle (G20119) clockwise so that the Small Feed Gear (G20112) on the Feed Lever (G20132) is disengaged from the Large Feed Gear Assembly (G20110A). 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 (G20144A). Turn the Feed Release Handle vertically so that the Small and Large Feed Gears are engaged.
4. Turn the stitcher machine on and trip it until the wire emerges from the Lower Wire Tube (G20199A) in the Cutter Block Assembly (G20197A). If the wire does not emerge, turn the Wire Straightener Eccentric (G20206) counter-clockwise to allow the wire to pass freely. Make sure the wire is leaving the Head completely straight (horizontally) and that it is not touching either the Left or Right Wire Guide Bar (G20142) as it passes. Complete wire straightening instructions can be found on page 14.

Note: Never operate the Stitcher Head with the Wire Holder Assembly (G20559BA) in place unless there is stock above the Clincher Points.



Wire Straightening (Figure 7)

In order to ensure the stitches are loaded, driven and clinched properly in addition to ensuring continuous operation of the G8 style heads, it is important that the wire leaves the Cutter Block Assembly (G20197A) in a straight horizontal line. Wire straightness is the single biggest factor for ensuring good stitches and stitcher head reliability. Although straightness is set at the factory, every roll of wire has varying degrees of twist which make it necessary for the user to properly straighten the wire prior to production **as well as during normal production**. Follow the steps for straightening wire listed below.



Horizontal Adjustment

Slide the Wire Holder Retaining Spring (G20183) over to the side and remove the Wire Holder Assembly (G20559BA or G20301A) from the Stitcher Head. Make sure the Small and Large Feed Gears are engaged. Activate the stitcher and observe the feeding of the wire from the Cutter Block Assembly and take note of the direction the wire is moving. Use a slotted head screwdriver in the Wire Straightener Eccentric (G20206) on the Cutter Block to adjust the wire. If the wire is feeding upwards, turn the Wire Straightener Eccentric clockwise. If the wire is feeding downward, turn the Eccentric counter-clockwise.

Front-to-Back Adjustment

If the Left or Right Wire Guide Bars (G20141 or G20142) are not properly positioned, the wire will rub against them as it exits the Cutter Block. Look at the G8 Head from the side past both the Right and Left

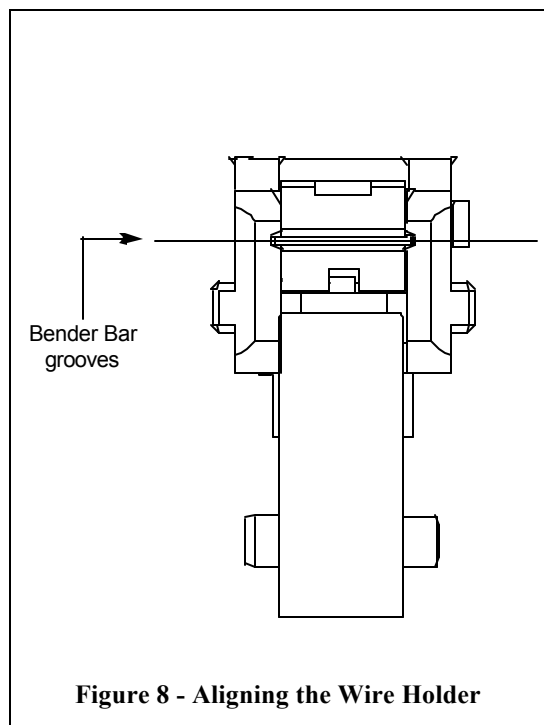
Wire Guide Bars. Make sure there is a clear view of the opening in the Fixed Wire Cutter (G20200) from the side of the G8 Head. If there is not, loosen the Flat Head Machine Screws (G20215) securing the Wire Guide Bars to the Feed Gear Bracket Assembly (G20136A) and move them out of the path of the wire. Tighten the Screws after making sure the Wire Guide Bars are even with each other. Replace the Wire Holder and re-engage the Wire Holder Retaining Spring.

Aligning the Wire Holder (Figure 8)

In order to form a quality stitch, the Wire Holder has to be in alignment with the Bender Bar. Specifically, the cut piece of wire held in the Wire Holder has to line up with the grooves in the Bender Bar. If this alignment is not established the corners of the staple could buckle, the staple's crown could be weak or break off completely or one or both of the staple's legs could shear off. This alignment should be established at the Factory but if any of the previously mentioned problems arise, the following steps should be followed:

Load a piece of wire into the Wire Holder. Using a mirror, check to make sure the wire in the Wire Holder is lined up with the grooves in the Bender Bar Assembly (G20147BA, G20347BA or G20357BA). If it is not, loosen the Socket Head Set Screw (G20273) in the front of the Wire Holder and the Hex Nut (G20226) securing the Wire Holder Adjustment Screw (G20265). Turn the Adjustment Screw until the wire is aligned with the grooves in the Bender Bar. Tighten the Hex Nut and Set Screw to secure this setting.

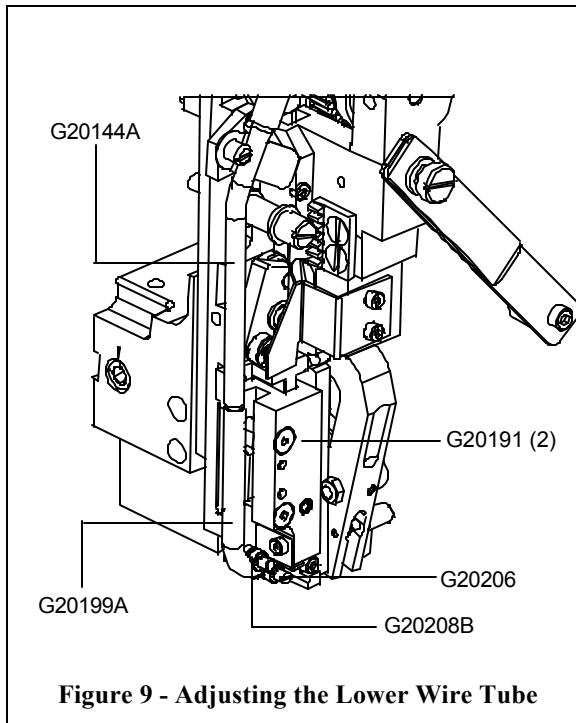
Remove the wire in the Wire Holder and load another piece in the Stitcher Head. Verify that the setting established is accurate by again checking the piece of wire with the mirror.



Adjusting the Lower Wire Tube (Figure 9)

In order to ensure the proper feeding of wire through the G8 Stitcher Head ensuring its continuous operation, it is important that the wire leaves the Lower Wire Tube Assembly (G20199A) in a straight horizontal line and enters the Cutter Block Assembly without assistance. Follow the steps listed below for aligning the Lower Wire Tube.

If the wire coming out of the Lower Wire Tube hits the side of the Wire Straightener Roller (G20208B) instead of passing over it, the groove in the Wire Tube has to be aligned with the groove in the Roller. Turn the Wire Straightener Eccentric (G20206) so that the maximum amount of space is allowed for the wire between the two (2) Wire Straightener Rollers. Loosen, but do not remove, the two (2) Socket Head Set Screws (G20191) in the Cutter Block Assembly.



Once these Screws have been loosened, the Tube can be moved up or down. Make sure the Wire Tube is close enough to the Wire Straightener Roller to ensure continuous feeding of the wire, but not pressed against the Roller, which will stop the wire completely. Leaving a 0.010" (.025mm) space between the Tube and the Wire Straightener Roller is a good gauge. Tighten the two (2) Set Screws at this point and double check the space between the Tube and the Roller before proceeding.

Once the wire is successfully feeding between the two (2) Wire Straightener Rollers, turn the Feed Release Handle (G20119) to the off position, remove the Middle Wire Tube (G20144A) enough to cut the wire as it exits from between the Large Feed Gear Assembly (G20110A) and the Small Feed Gear (G20112) and remove the wire. Turn the Feed Release Handle to the on position again and activate the stitcher head until the wire feeds out of the Lower Wire Tube. Make sure that the wire feeds between the Wire Straightener Rollers without assistance, or make adjustments to the Lower Wire Tube until it does.

If the wire still does not automatically thread into the Cutter Box, tilt the Wire Tube toward or away from the Cutter Block. If the wire feeding out of the Cutter Block is curving up then tilt the Wire Tube toward the Cutter Block Assembly. If the wire is curving down then tilt the Wire Tube away from the Cutter Block Assembly. Before tightening the Set Screws, verify that there is still at least a 0.010" clearance between the Lower Wire Tube and the Wire Straightener Roller.

Adjusting the Length of the Stitch Leg (Figure 10)

The following instructions illustrate how to calibrate the G8 Stitcher Head the first time it is used after mounting it to the stitcher machine. It also illustrates how to manually adjust the Cutter Block each time a different stitching capacity is required.

Adjust the compression setting on the stitcher machine for the capacity of work to be stitched, if this option is available. Make a few sample stitches and turn the stock away from you to look at the results. Machines with Adjuster Rails and compression adjustment capabilities will automatically draw extra wire and center each stitch, once they are initially aligned. Machines without any built-in adjustment capabilities will have to be adjusted each time a new job is set up.

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 Block Assembly (G20197A). As thicker work is stitched, the Cutter Block must be moved further from the Wire Holder Assembly in order to keep the legs of the stitch even and the gap centered.

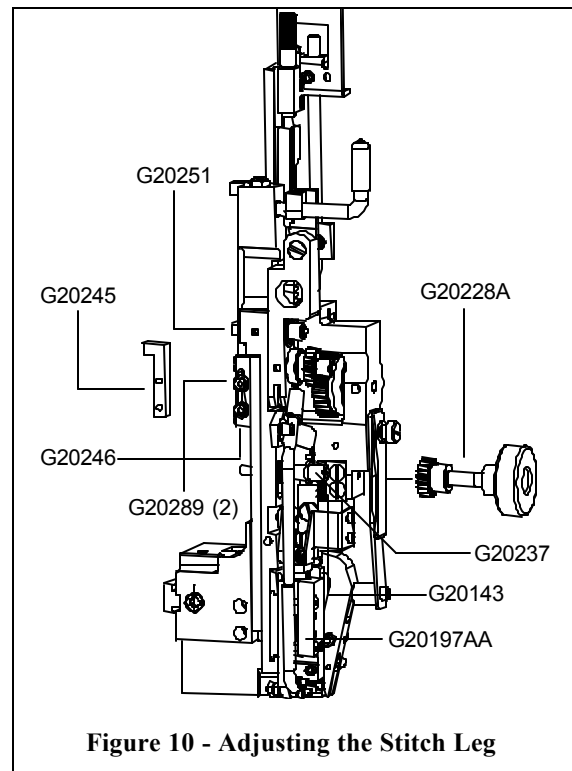


Figure 10 - Adjusting the Stitch Leg

For **G8 Heads mounted to a machine with an adjuster rail**, first loosen the two (2) Hex Head Screws (G20289) securing the Lower Cutter Block Adjustment Bar and Cutter Block Adjustment Connector (G20246) to the Upper Cutter Block Adjustment Bar (G20245 or G20251). **For all G8 style Heads**, place the Adjustment Knob (G20228A) over the Cutter Adjustment Stud (G20237) and engage the teeth of the Cutter Block Adjustment Rack (G20143). 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: turn the Adjustment Knob counter-clockwise. Run a couple of stitches to test this setting. 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: turn the Adjustment Knob clockwise. If both legs are equal in length or if the gap between the legs is centered, no more adjustment is necessary. Make sure to tighten the two (2) Hex Head Screws securing the Lower Cutter Block Adjustment Bar and the Cutter Block Adjustment Connector to the Upper Cutter Block Adjustment Bar.

If more adjustment is necessary, continue to move the Cutter Block Assembly towards or away from the body of the G8 Stitcher using the Adjustment Knob and test after each adjustment.

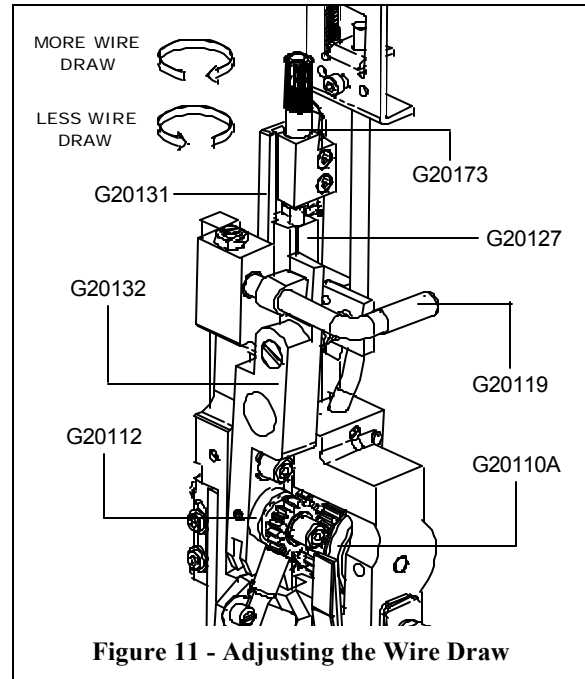
Adjusting the Wire Draw

To change the overall wire draw, the position of the Feed Rack (G20127) has to be changed within the Stitcher Head. (Figure 11).

First, make sure the wire feeding is off by turning the Feed Release Handle (G20119) horizontally so that the Small Feed Gear (G20112) on the Feed Lever (G20132) is disengaged from the Large Feed Gear Assembly (G20110A).

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 your stitcher machine has a built-in stroke adjustment, no further adjustments will be required, even when changing stitching capacities. If the stitcher has no automatic stroke adjustment then the length of wire has to be adjustment manually every time the capacity changes.

In order to increase the wire draw or lengthen the legs of the stitch and decrease the gap size, turn the Feed Release Handle (G20119) to the off position and the Feed Rack Adjustment Knob clockwise. Inversely, to decrease the wire draw or shorten the legs of the stitch and increase the gap size, turn the Feed Rack Adjustment Knob counter-clockwise.



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

WARNING

Aligning the Clincher Plate (Figures 12 & 13)

In order to produce properly clinched staples, the center of the Clincher Plate* (round or flat, thick or thin) must be exactly in line with the Driver* (depending on the wire gauge being used) both left-to-right and front-to-back. The following are instructions for both types of adjustment.

Front-to-Back

Manually activate the G8 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 are made to the screws in the back of the G8 while the Stitcher Head is removed from the Stitcher Machine. Loosen the two (2) Socket Head Set Screws (G20191) in the side of the Head. If the Driver is positioned in front of the Clincher Plate then the upper Socket Head Set Screw (G20229) must be turned counter-clockwise until the Screw sticks out slightly from the back of the Head, while the lower Screw remains under flush. If the Driver is positioned in back of the Clincher Plate then the lower Socket Head Set Screw must be turned counter-clockwise until it sticks out slightly from the back of the Head, while the upper 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.

Left-to-Right

Looking from the front of the Stitcher Head, make sure the Driver is centered directly above the Clincher Slide (9093A or 9084B). If it is not, loosen the two (2) Clincher Plate Nuts (2091) and move the entire Clincher Plate Assembly to the right or to the left. Secure this position while tightening the Nuts again.

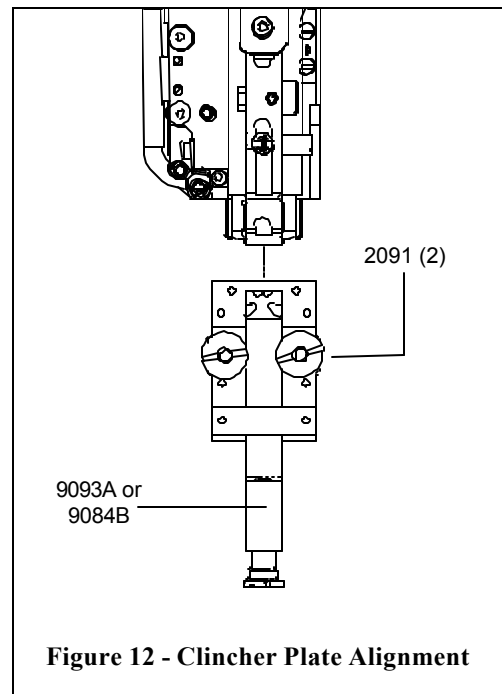


Figure 12 - Clincher Plate Alignment

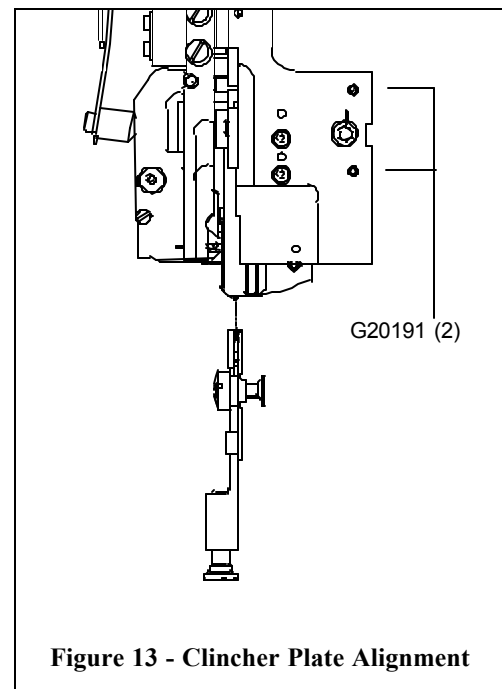


Figure 13 - Clincher Plate Alignment

* For a complete list of wear parts and replacement parts based on wire gauge and crown size, see page 51 of this manual.

Adjusting the Clincher Points

The final position of the Clincher Points* (round or flat) should be flush, or slightly above flush, with the Clincher Plate* (round or flat) 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* (depending on the wire gauge being used) 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 or 9083C) 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 when using non-adjustable Clincher Plates. If the machine is using an Adjustable Clincher Slide, like the one shown in **Figure 14**, adjust 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.

Refer to the complete list of wear parts for the G8 style Stitcher Head, found in the back of this manual on page 47. The Clincher Points and Clincher Plates necessary for a quality stitch are specific to the crown size and wire gauge size used in each stitcher head.

Some style stitcher heads do not utilize moving Clincher Points, but rather a solid Clincher Plate as shown in **Figure 15**. 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.

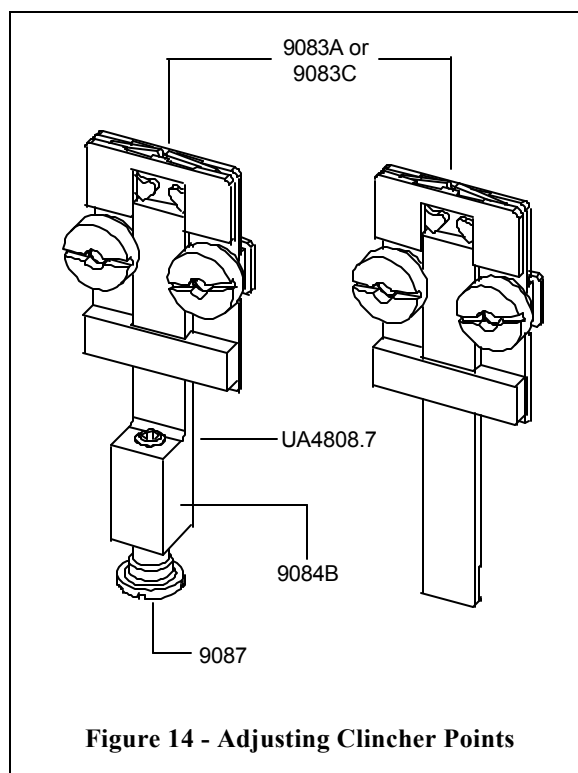
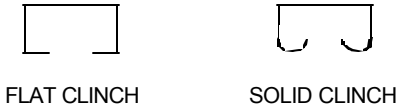


Figure 14 - Adjusting Clincher Points

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.



Adjusting the Bender Bar Stop

Like other G8 Stitcher Head settings, the Bender Bar Stop is set at the factory. The Stop controls the position of the Bender Bar Latch (G20149) at the top of the stitcher head's stroke. If the Latch does not fall within the proper area of the Driver Bar (G20151), partially formed stitches will result or the wire feeding through the G8 will jam.

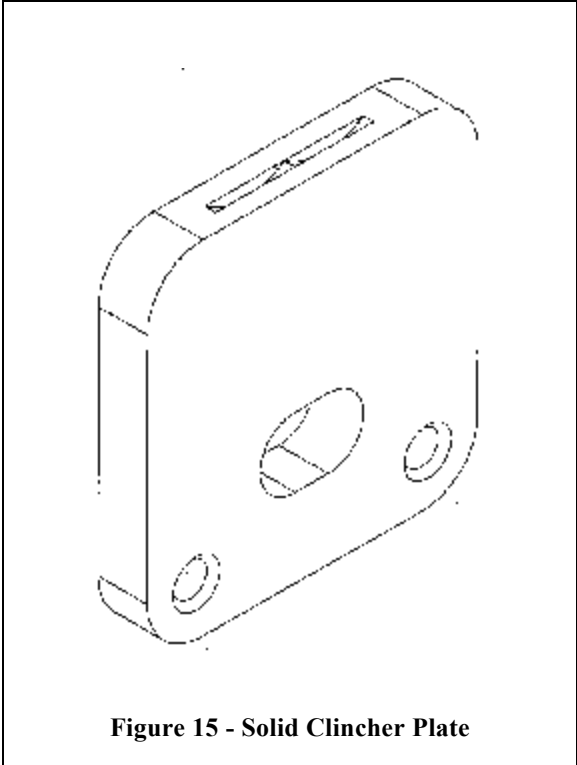


Figure 15 - Solid Clincher Plate

The right edge of the Bender Bar Latch should stick out from the Bender Bar at least 3/32" (2.5mm) when the G8 reaches the top of its stroke. If the Latch does not protrude this far then the Bender Bar Stop Screw (G20229) is set too high. If the Stop Screw is set too low then the wire will hit the Bender Bar rather than feeding below it for forming.

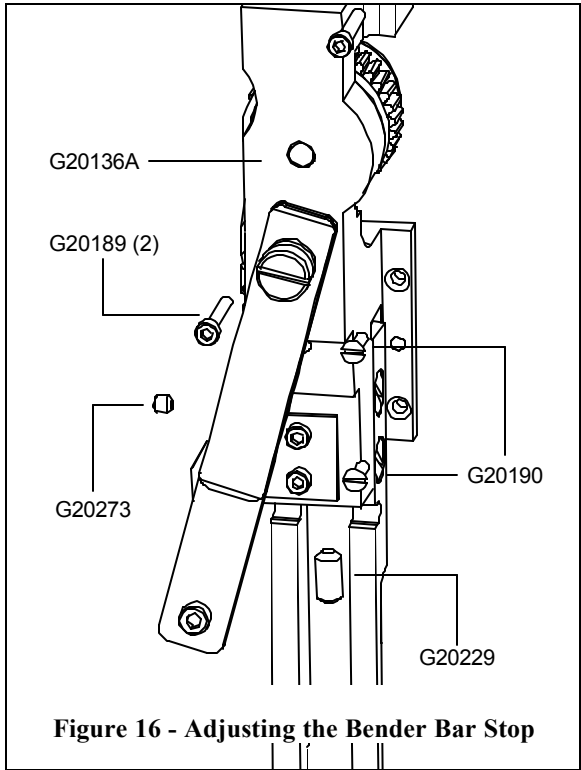


Figure 16 - Adjusting the Bender Bar Stop

Remove the four (4) Screws securing the Feed Gear Bracket Assembly (G20136A) to the G8; the two (2) Socket Head Cap Screws (G20189) and the two (2) Flat Head Machine Screws (G20190). Remove the entire Bracket Assembly. Loosen, but do not remove, the Set Screw (G20273) securing the Stop Screw in the Bracket. Turn the Stop Screw according to the adjustment necessary; clockwise to raise the Bender Bar's position within the Head and counter-clockwise to lower the Bender Bar's position. The normal position is about 1/8" or 3mm out from the Feed Gear Bracket.

Replace the Bracket Assembly on the G8 making sure to align its Locating Pins with the holes in the Bonnet Assembly (G20000A). Manually turn the Large Feed Gear (G20110A) if its teeth are not aligned with those on the Feed Rack (G20127). Replace the Screws.

Maintenance

Your G8 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 G8 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 duplicate 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 G8 style Stitcher Head, refer to page 51 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.

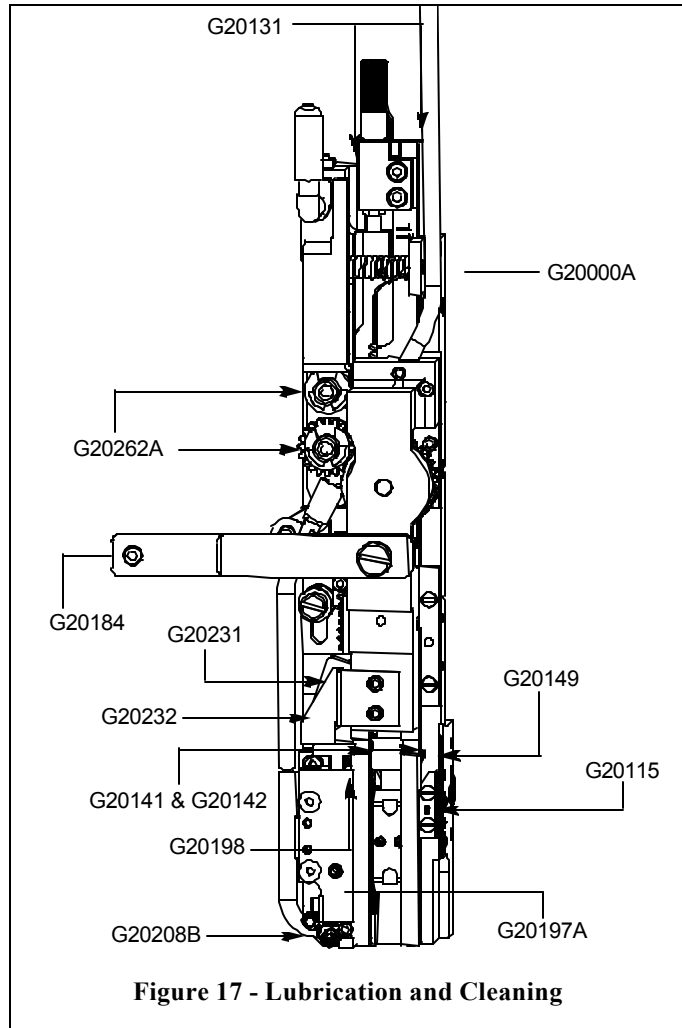
Always disconnect the power supply before making any adjustments or servicing the head.

⚠ WARNING

Lubrication (Figure 17)

Use any standard S.A.E. #10 oil for lubricating the heads. Heads that are in constant operation should be lubricated daily. Heads that are operated periodically should be lubricated every five pound wire spool change or every month, 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:

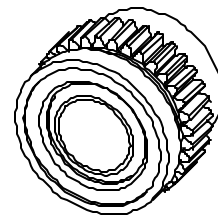
- the top of the Bonnet (G20000A) on either side of the Feed Slide (G20131).
- the fittings on the Feed Lever Pivot Pin and the Small Feed Gear Pin (G20262A).
- the Cutter Operating Lever Pivot Pin (G20231) and Roller Pin (G20232).
- the Wire Straightening Rollers (G20208B) in the Cutter Block Assembly (G20197A).
- on the Wire Holder Assembly under the Wire Holder Retaining Spring Foot (G20184).
- where the Wire Holder Assembly (G20559BA) pivots in the Left and Right Wire Guide Bars (G20141 and G20142).
- on the Bender Bar Latch (G20149) and the Latch Release Cam (G20115).
- in the Cutter Block Assembly, along side the Cutter Operating Slide (G20198).



Cleaning

In addition to proper lubrication, routine cleaning is important for the maintenance of your G8 Head. The entire Head should be torn down and rebuilt every three to six months and the following areas should be cleaned once every three months:

- **Large Feed Gear (G20110A):** remove and wash in an oil-dissolving solvent, like Aeroshell 14 (G20824). Dry and relubricate.
- **Anywhere that dust, oil or pieces of wire and paper have built up** - for example: around the Clincher Points and around the Wire Straightener Rollers.



Ordering Spare Parts

In time, you will need to replace some parts in your G8 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.

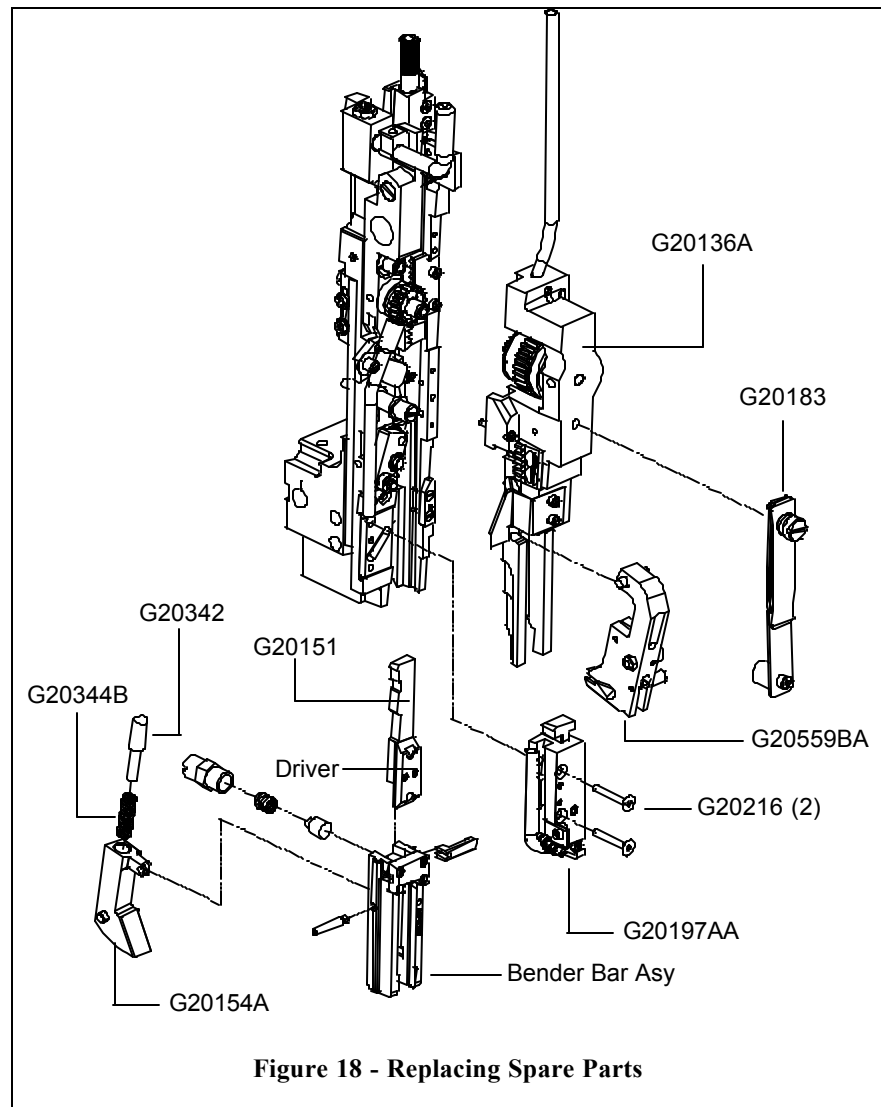
CAUTION

Replacing Spare Parts (Figure 18)

The following are some of the more common wear parts which will need to be removed and replaced in your G8 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 G8 Stitcher Head will follow.

Removing and Replacing the Wire Cutters Figure 18

The Moving Wire Cutter (G20145) has several cutting surfaces, each of which may be used by rotating the Cutter's position on the Cutter Operating Slide (G20198). Worn Cutters can cause



poor stitch quality. To change or reverse the Moving Wire Cutter, first remove the complete Cutter Block Assembly (G20197A) from the stitcher head. Loosen and remove the two (2) Socket Flat Head Screws (G20216) on the front of the assembly and pull the Cutter Block away from the G8 Head. Be careful, the Cutter Operating Slide may spring out from the Cutter Block Assembly. Loosen the Flat Head Machine Screw (G20214) 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.

Make sure the Cutter Operating Spring (G20210) is resting against the Spirol Pin (G20217) in the Cutter Block Assembly. Compress the Spring with the edge of the Cutter Operating Slide and return the Slide to its position in the Cutter Block Assembly. Support the Operating Slide by holding the back of the Cutter Block and line up the two (2) Dowel Pins (G20223) in the back of the Assembly with the Cutter Block Slide Plate (G20202). Replace the two (2) Socket Flat Head Screws and make sure there is little or no play in the Assembly.

Like the Moving Cutter, the Fixed Wire Cutter (G20200) can be rotated when the cutting surface is worn or replaced when no sharp surfaces are left. The complete Cutter Block Assembly has to be removed from the Stitcher Head again by removing the two (2) Flat Head Cap Screws. Remove the Cutter Operating Slide from the Cutter Block to reveal the Fixed Cutter. Loosen, but do not remove, the Socket Head Cap Screw (G20196) on the front of the Cutter Block which secures the Cutter. Rotate the Cutter until a new surface is exposed or replace it completely worn. The Cutter can be rotated three or four times 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.

In order to obtain a clean edge on the cut wire, there can be no gap between the Moving and Fixed Cutters. Replace the Cutter Operating Slide and compress it 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 G8 by compressing the Cutter Operating Slide. The Moving Cutter must pass the Fixed Cutter freely and with no visible gap.

Attach the Cutter Block Assembly on the G8 by aligning the Cutter Block with the Slide Plate and replacing the two (2) Socket Head Flat Screws, being careful to support the Cutter Operating Slide.

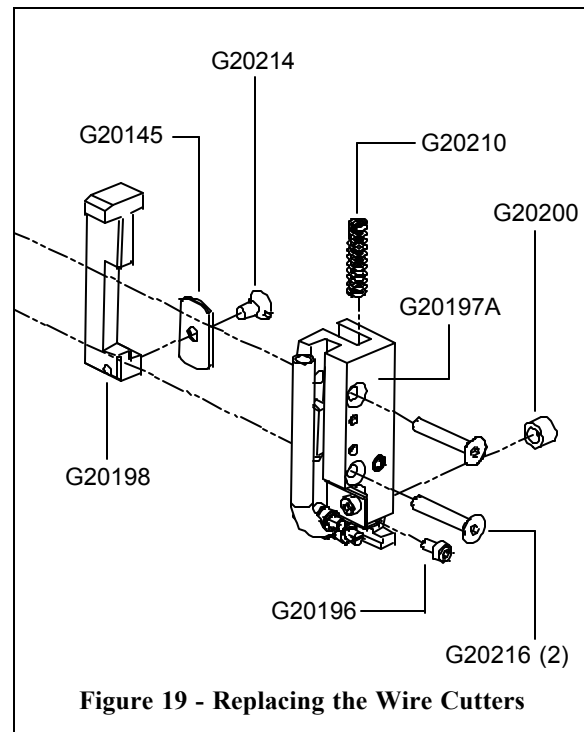


Figure 19 - Replacing the Wire Cutters

Removing and Replacing the Driver (Figure 20)

If the staples produced have crowns that are buckled or corners that stick up, or if wire is jamming between the Driver and Driver Bar, the Driver may have to be reversed or replaced. Swing the Wire Holder Retaining Spring (G20183) off of the Wire Holder Assembly (G20559BA) and out of the way. Remove the two (2) Driver Retaining Screws (G20153) securing the Driver* to the Driver Bar (G20151) and slide the Driver out of the Bender Bar.* The ends of the Driver are identical so when one end is worn or chipped, it can be reversed. If both ends are worn, replace the existing Driver with a new one. Add a little threadlocker to the Screws before returning them to the Driver Bar. Replace the Wire Holder Assembly and Wire Holder Retaining Spring.

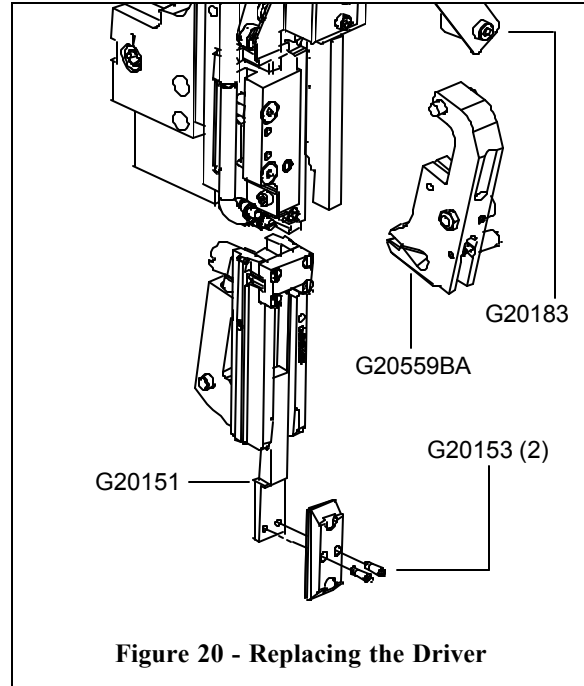


Figure 20 - Replacing the Driver

Removing and Replacing the Latch and Latch Spring (Figure 21)

If multiple pieces of wire are being loaded in the Wire Holder Assembly (G20559BA) and not being formed, the Latch (G20149) and/or Latch Spring may have to be replaced. Remove the Cap Screw (G20171) on the back of the G8 Stitcher Head to release the Driving Slide Assembly (G20162A or G20320A). Once the Slide has been released, swing the Wire Holder Retaining Spring out of the way and remove the Wire Holder Assembly. Use the Adjustment Knob Assembly (G20228A) to move the Cutter Block out slightly so the Bender Bar Assembly can be removed from the bottom of the head. Remove the Bender Bar Friction Bushing (G20161), the Bender Bar Friction Spring (G20160B) and the Bender Bar Friction Plug (G20159) from the back of the Bender Bar. Loosen the Set Screw (G20156) in the front of the Bender Bar and remove the Supporter Pivot Pin (G20155) and Supporter Assembly (G20154A). Compress the Latch and slide the Driver Bar (G20151) out the bottom of the Assembly. Remove the Machine Screw (G20224) securing the Bender Bar Latch Spring (G20150) and remove the Spring. Slide the Latch out of the Assembly as well.

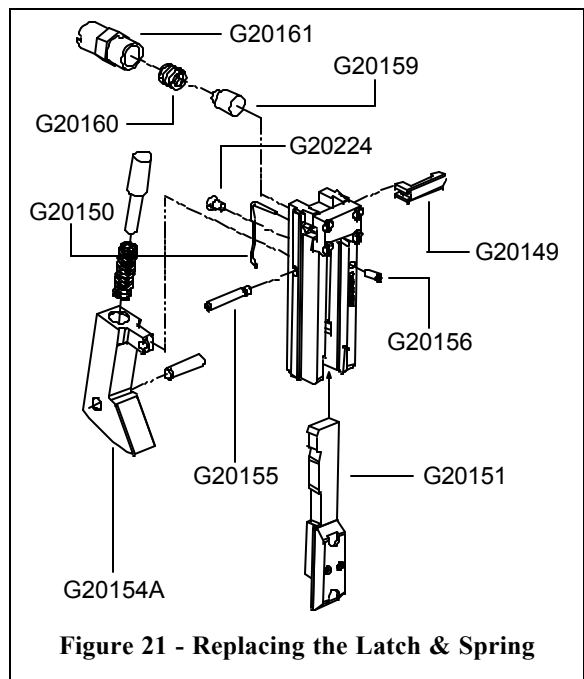


Figure 21 - Replacing the Latch & Spring

Replace the Latch Spring and Machine Screw. Slide the Latch in through the right side of the Latch

Housing and compress it against the Spring. Insert the Driver Bar from the bottom of the Assembly until the Latch drops into the profile slot in the Driver Bar. Assemble the Supporter to the Bender Bar with the Supporter Pivot Pin inserted from the left side. Secure the Pivot Pin with the Set Screw, making sure there is free movement between the Supporter and Bender Bar. Replace the Friction Plug and Spring into the Bushing, compress the Supporter Spring Plunger (G20342) and screw the Bushing into the Bender Bar securely.

Removing and Replacing the Clincher Points (Figure 22)

The Clincher Point (9083A or C) 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. Loosen, but do not remove, the two (2) Clincher Plate Nuts (2091) until the Clincher Slide (9084B or 9093A) 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 could 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.

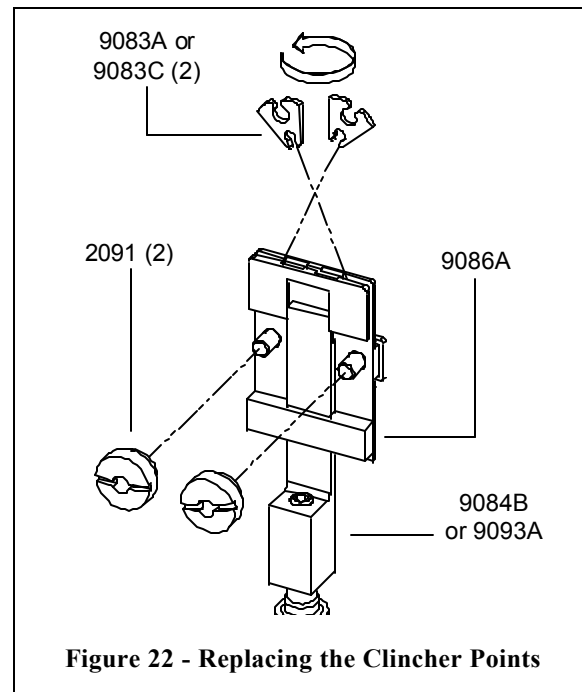


Figure 22 - Replacing the Clincher Points

Disassembling the Stitcher Head (Figure 23)

Remove the G8 style Stitcher Head from the stitcher machine. On Clamp-mount style heads, loosen the Clamp Block Eccentric (G20124) and remove the Stitcher Head from the Bonnet Clamp Block (9002). On Bolt-mount style heads, loosen and remove the Bonnet Stud Nut (HN1213 or G20170) while supporting the Head. Remove the Head from the stitcher machine and place it on a clean work area.

Swing the Wire Holder Retaining Spring (G20183) away from the G8 and remove the Wire Holder Assembly (G20559BA). Snap the Middle Wire Tube (G20144A) out of the Middle Wire Tube Clip (G20244) and remove it from the Lower Wire Tube (G20199A) in the Cutter Block Assembly (G20197AA). Remove the two (2) Cap Screws (G20189) and the two (2) Machine Screws (G20190) securing the Feed Gear Bracket Assembly (G20136A) to the Bonnet Assembly (G20000A) and remove the Feed Gear Bracket. Remove the two (2) Flat Head Screws (G20216) securing the Cutter Block Assembly to the Bonnet and remove the Cutter Block. Remove the Cap Screw (G20171) from the back of the G8 securing the Driving Slide Assembly (G20162A or G20320A) to the Feed Slide (G20131) and remove both from the Bonnet Assembly. The Bender Bar Assembly* can also be slid

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.

Re-assembling the Stitcher Head (Figure 23)

1. 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. If there is too much play, adjust the two (2) Feed Slide Retaining Screw Assembly (G20122A) after loosening the two (2) Screw M4x.7x4, Nylon (G20273) located on the back of the Head. Slide the Bender Bar Assembly into the Bonnet from the bottom, compress the Bender Bar Latch and press down the Supporter Assembly to completely position the Bender Bar within the Bonnet.
2. Turn the Bonnet over and position the Driving Slide Assembly so that the Driving Slide Plunger (G20164) rests in the notch of the Driver Bar and secure this position with the Cap Screw tightened completely.
3. Assemble the Feed Gear Bracket Assembly to the Bonnet by first lining up the three (3) pins in the Bracket with the holes in the Bonnet. Secure the Feed Gear Bracket with two (2) Cap Screws and two (2) Machine Screws. The teeth of the Feed Pinion Assembly (G20111A) may have to be lined up manually with the teeth of the Feed Rack (G20127).
4. Re-assemble the Feed Lever Assembly to the Bonnet with the Feed Lever Pin (G20262A), making sure the oil hole in the pin is facing downward. Secure the Pin by tightening the Set Screw (G20264) in the side of the Bonnet. Replace the Feed Lever Spring through the Feed Lever and secure it with the Feed Lever Spring Bushing (G20267).
5. Assemble the Cutter Block Assembly to the Cutter Block Slide Plate (G20202) with two (2) Flat Head Screws. There should be little or no play once the Block is secure, but if there is any movement, remove both the Cutter Block and the Slide Plate. Re-assemble the Slide Plate to the Bonnet so that it slides side to side but not up and down.
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.

Troubleshooting (Figure 24)

The quality and quantity of work that can be produced with the G8 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 G8 Stitching Head. In the event of problems of this nature occurring, the operator can, by referring to the following troubleshooting chart, quickly locate the solutions.

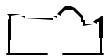
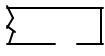
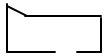
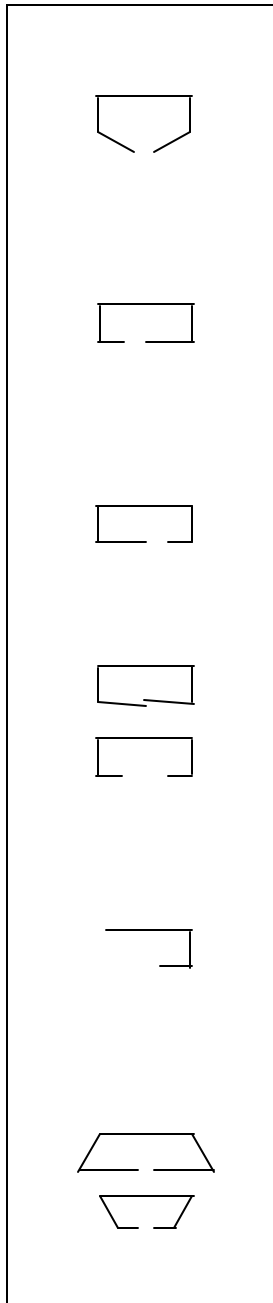
	<p>PROBLEM: Crown Not Straight SOLUTION: Straighten the wire. (See page 14) Align the Clincher Points. (See page 19) Reverse or replace the worn or broken Driver. (See page 26) Make sure the Cutters are aligned and not dull. (See page 24) Check for correct wire size and strength being used. Check for correct work thickness setting. Check the quality of the wire being used, change spools.</p>
	<p>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 24) Make sure the Cutters are aligned properly. (See page 24) Make sure the correct wire size is being used and that the wire is straight. (See page 14). Check the quality of the wire being used, change spools.</p>
	<p>PROBLEM: Corner Buckled SOLUTION: Check the Driver for a chipped corner and rotate or replace it if needed. (See page 26) Align the Wire Holder. (See page 15) Check the tensile strength of the wire or use thicker wire.</p>

Figure 24 - Troubleshooting



PROBLEM: Clinch Too Loose

SOLUTION: The Clincher Points are too low or too high and need adjusting. (See page 19) The compression of the stitcher machine is insufficient and needs to be increased.

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 17)

PROBLEM: Left Leg Too Long / Right Leg Too Short

SOLUTION: Adjust the position of the Cutter Block Assembly by moving it toward the Head. (See page 17)

PROBLEM: Staple Legs Too Long or Too Short

SOLUTION: Correct the overall wire draw by repositioning the Feed Rack within the G8 Head. (See Page 18)

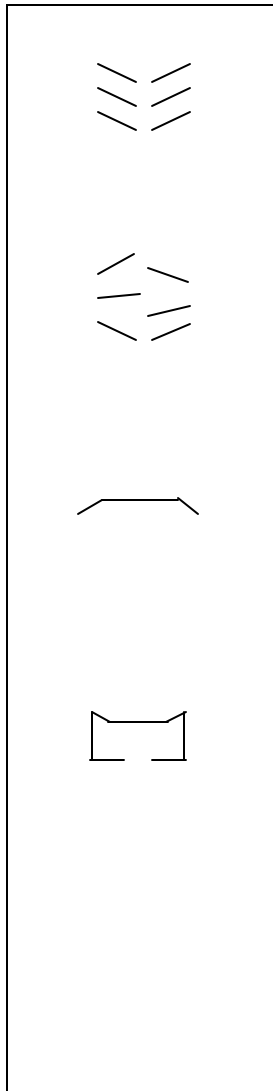
PROBLEM: Left Leg Missing

SOLUTION: Straighten the wire. (See page 14) The Wire Holder Assembly is not aligned properly with the groove in the Bender Bar.

PROBLEM: Legs are Spread or Contracted

SOLUTION: Straighten the wire. (See page 14) Weak wire or wrong gauge being used, change spools.

Figure 24 - Troubleshooting



PROBLEM: Legs Stray Forward or Backward Consistently
 SOLUTION: The Clincher Points are not aligned properly front to back.
 (See page 19)

PROBLEM: Stitch Stray Randomly In and Out and Front to Back
 SOLUTION: Straighten the wire. (See page 14) Make sure the Cutters are aligned properly. (See page 24) Check the tensile strength of the wire or use thicker wire. Verify correct wire gauge is being used, change spools.

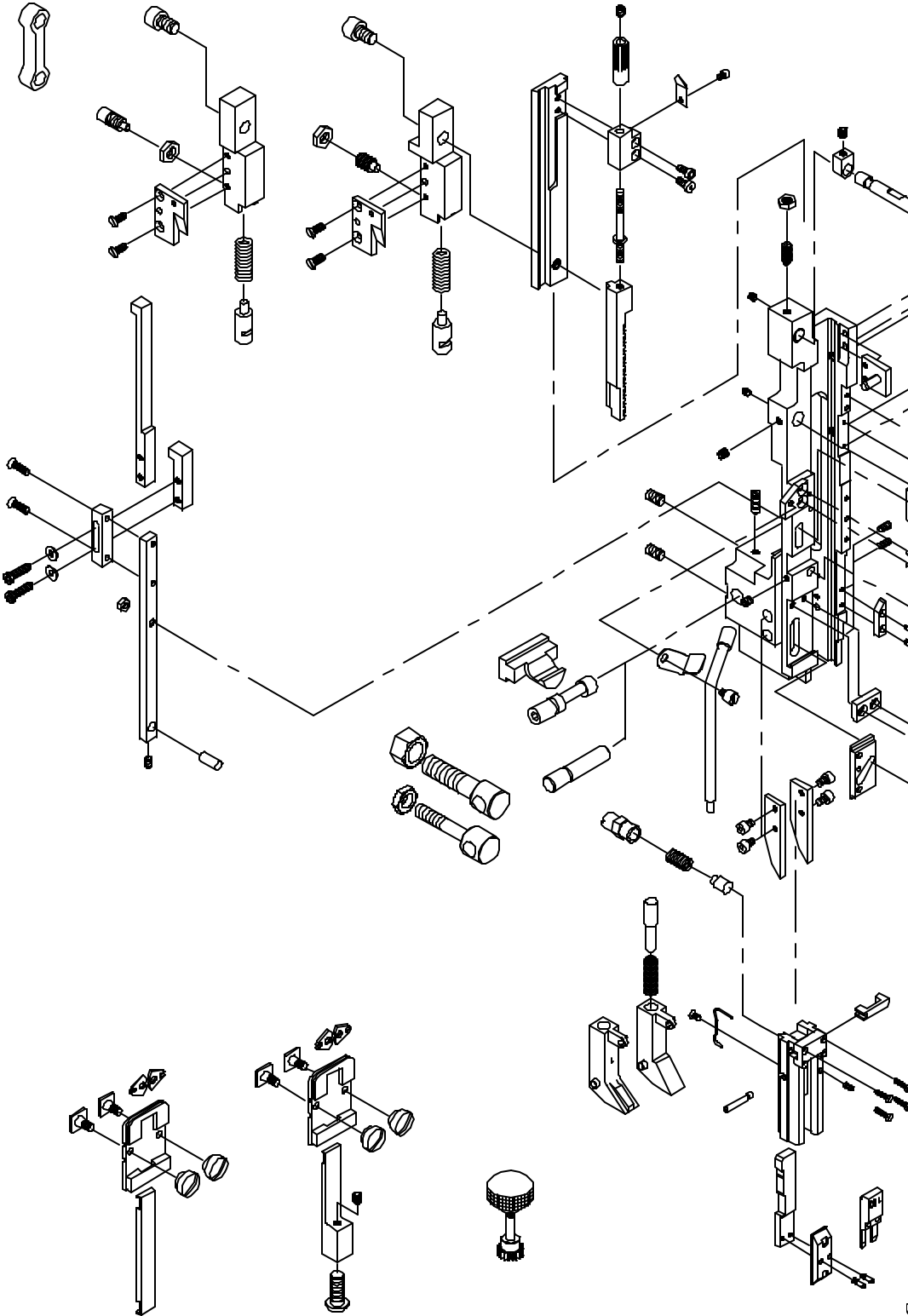
PROBLEM: Partially Formed Stitches
 SOLUTION: The Bender Bar Latch is not engaging with the Driver Bar, either may be worn. The Bender Bar Stop Screw is set too low. (See page 21). Broken Latch or Latch Spring, replace. (See page 26)

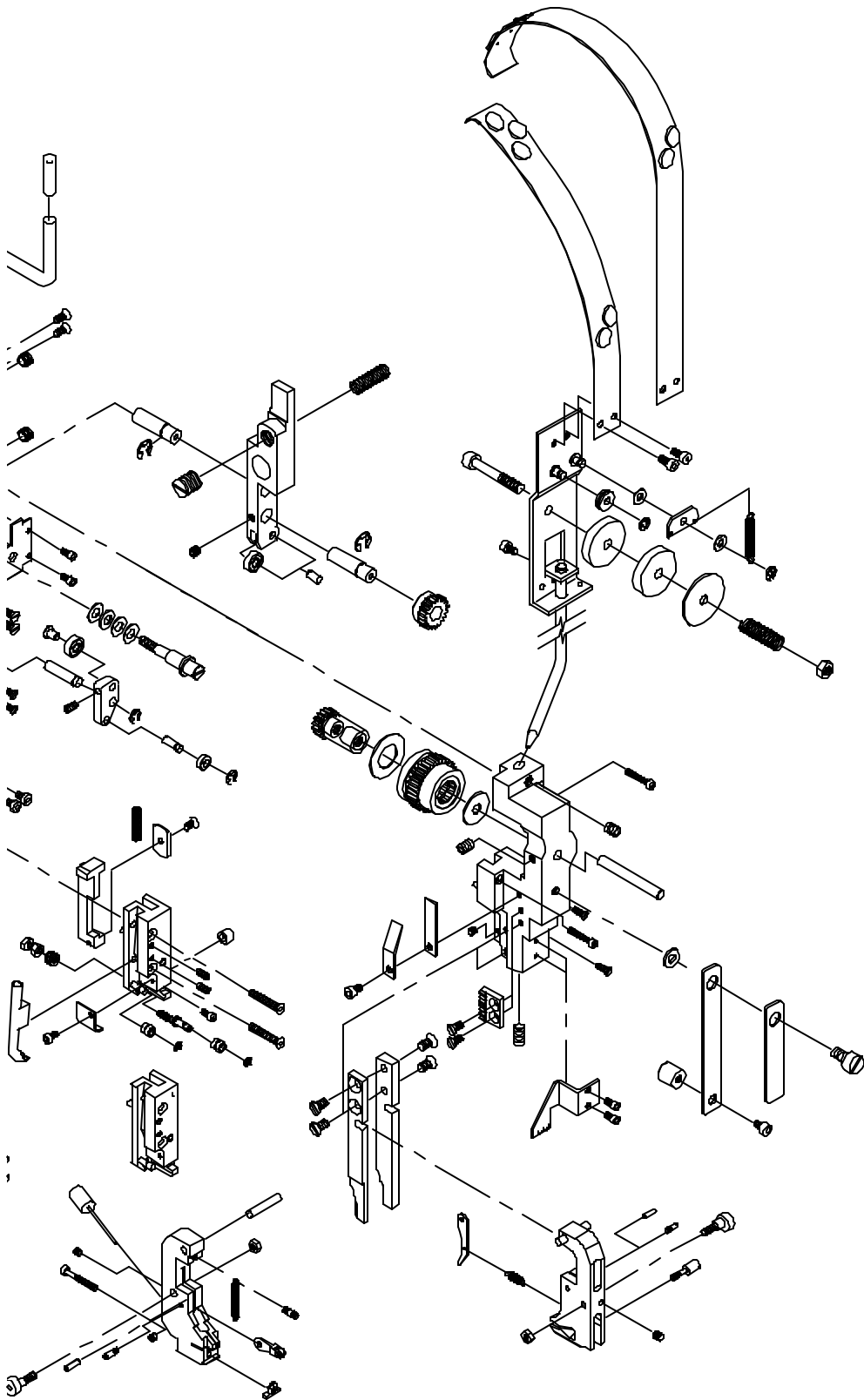
PROBLEM: Weak crown, crown breaks off after stitch
 SOLUTION: Align the Wire Holder with the grooves in the Bender Bar
 (See page 15). Check the tensile strength and size of the wire being used.

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 13)

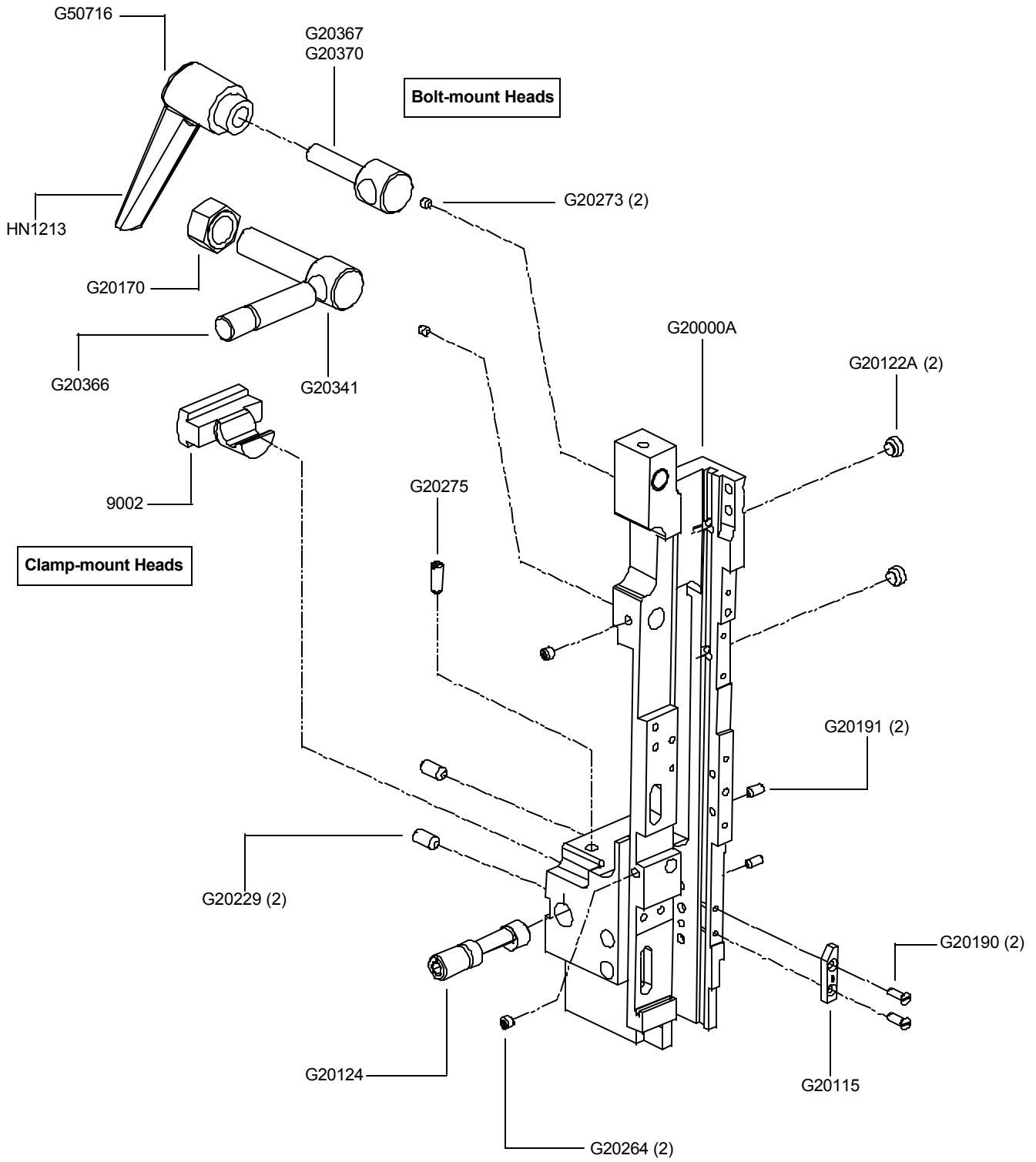
Figure 24 - Troubleshooting

The G8 Stitcher Head





Bonnet Sub-Assembly



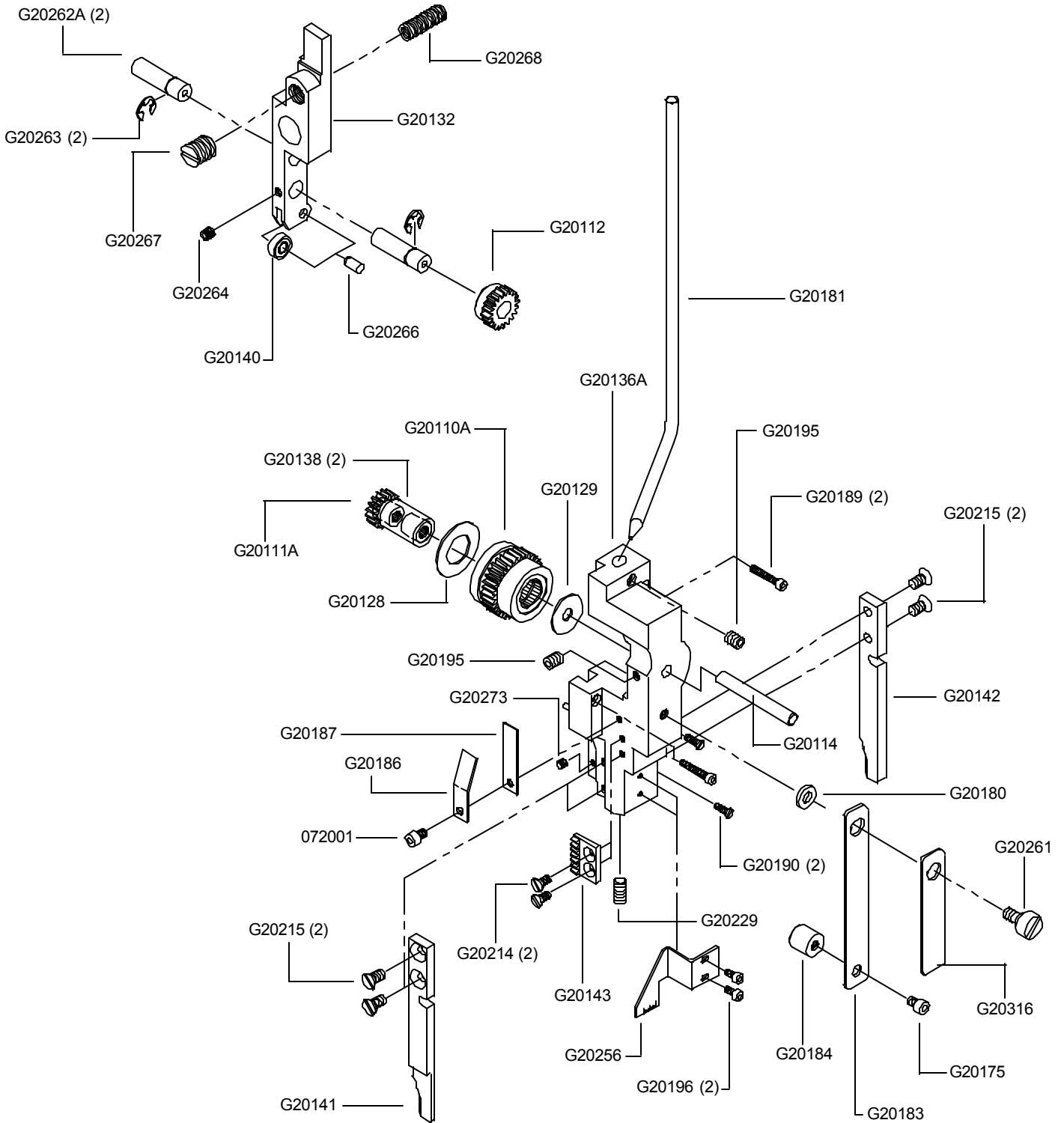
Bonnet Sub-Assembly

PART No.	DESCRIPTION	QUANTITY
9002	Bonnet Clamp Block	1
G20115	Latch Release Cam	1
G20122A	Feed Slide Retaining Screw Assembly	2
G20124	Bonnet Clamp Eccentric	1
G20170	Hex Jam Nut M8x1.25	1
G20190	Screw M3x.5x10- FHMS - Slotted	2
G20191	Screw, M4x.7x8 SHSS	2
G20000A	Bonnet Assembly - G8	1
G20229	Set Screw M6x1x12	2
G20264	Screw M5x.8x5 SHCS	2
G20273	Screw M4x.7x4 SHSS	2
G20275	Ball Spring Plunger	1
G20341	Rear Mounting Bolt	1
G20366	Rear Clamp Pin	1
G20367	Rear Mounting Bolt	1
G20370	Rear Mounting Bolt - M8	1
G50716	Mounting Block Handle	1
HN1213	Bonnet Stud Nut	1

Bonnet Sub-Assembly

PART No.	DESCRIPTION	QUANTITY
G20113	Supporter Guide Plate	2
G20118	Feed Release Handle Cam	1
G20119	Feed Release Handle	1
G20121	Feed Release Plunger	1
G20126	Tube Pivot Plate	1
G20133A	Feed Release Spring Block Assembly	1
G20140	Follower Ball Bearing	1
G20167	Screw, M4x.7x10 FHCS	2
G20175	Screw M4x.7x6 SHCS	2
G20182	Feed Gear Shaft Plate	1
G20191	Screw, M4x.7x8 SHSS	1
G20196	Screw M3x.5x6 SHCS	2
G20202	Cutter Block Slide Plate	1
G20204	Upper Cutter Block Guide	1
G20214	Screw M4x0.7x8 FHMS	2
G20220	Hex Nut M5x.8	1
G20230A	Cutter Operating Lever Assembly	1
G20231	Cutter Operating Lever Pivot Pin	1
G20232	Cutter Operating Lever Roll Pin	1
G20233	Cutter Operating Lever Roller	1
G20234	E-Ring- 3/16"	2
G20235	Follower Bearing Shaft	1
G20236	Tube Pivot Screw	1
G20237	Cutter Block Adjustment Stud	1
G20239	Disc Washer Spring	2
G20240	Cutter Block Adjustment Washer	2
G20241	Screw M4x0.7x6 SHCS	4
G20242	Cutter Adjustment Bar - Lower	1
G20243	Dowel Pin 1/4x9/16	1
G20244	Tube Pivot Clip	1
G20245	Cutter Adjustment Bar - Upper	1
G20246	Cutter Block Adjustment Connect	1
G20249	Cutter Block Washer	2
G20250	Screw M4x.7x14	2
G20251	Cutter Adjustment Bar - Upper	1
G20264	Screw M5x.8x5 SHCS	1
G20269	Spirol Pin 3/16x5/8	1
G20274	Hex Jam Nut, M6x1	1
G20289	Screw M4x.7x16	2
G20368	Feed Release Handle Cap	1

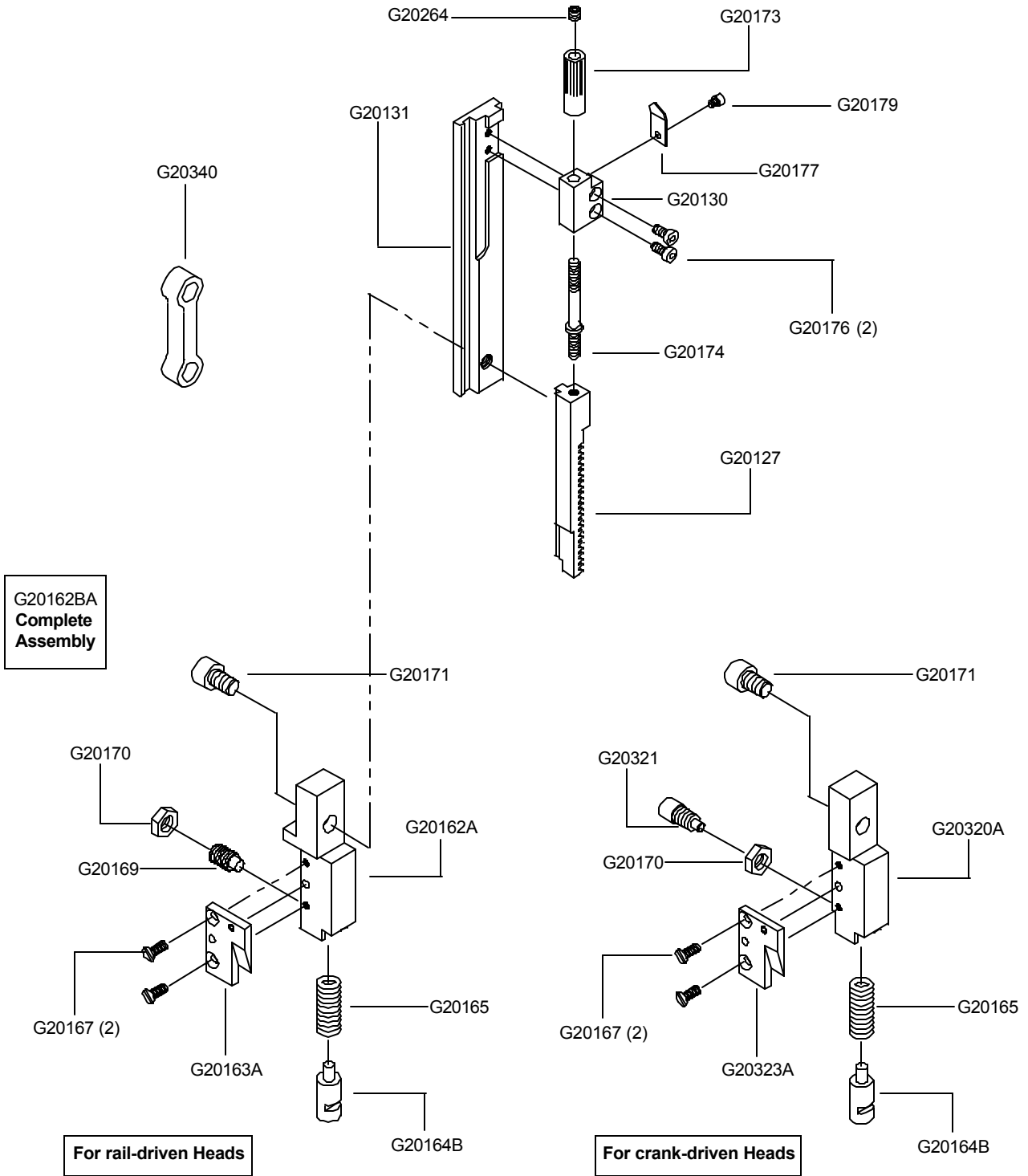
Feed Lever and Feed Gear Assemblies



Feed Lever and Feed Gear Assemblies

PART No.	DESCRIPTION	QUANTITY
G20110A	Large Feed Gear Assembly	1
G20111A	Feed Pinion Assembly	1
G20112	Small Feed Gear	1
G20114	Feed Pinion Shaft	1
G20128	Large Feed Gear Washer	1
G20129	Small Feed Gear Washer	1
G20132	Feed Lever	1
G20136A	Feed Gear Bracket Assembly	1
G20138	Feed Pinion Bearing	2
G20140	Follower Ball Bearing	1
G20141	Wire Guide Bar-Left	1
G20142	Wire Guide Bar-Right	1
G20143	Cutter Block Adjustment Rack	1
G20175	Screw M4x.7x6 SHCS	1
G20180	Flat Washer M6	1
G20181	Upper Wire Tube	1
G20183	Wire Holder Retaining Spring - Long	1
G20184	Wire Holder Retaining Spring Foot	1
G20186	Feed Gear Friction Spring	1
G20187	Feed Gear Friction Strip	1
G20189	Screw M3x.5x20	2
G20190	Screw M3x.5x10- FHMS- Slotted	2
G20195	Screw M6x1.0x8	2
G20196	Screw M3x.5x6 SHCS	2
G20214	Screw M4x0.7x8 FHMS	2
G20215	Screw M5x.8x10, FHMS	4
G20229	Set Screw M6x1x12	1
G20256	Cutter Block Scale	1
G20261	Wire Holder Retaining Spring Screw	1
G20263	Feed Lever E-Ring	2
G20264	Screw M5x.8x5 SHCS	1
G20266	Follower Bearing Pin	1
G20267	Feed Lever Bushing	1
G20273	Screw M4x.7x4 SHSS	1
G20316	Wire Holder Retaining Spring - Short	1
072001	Screw M4x0.7x8	1

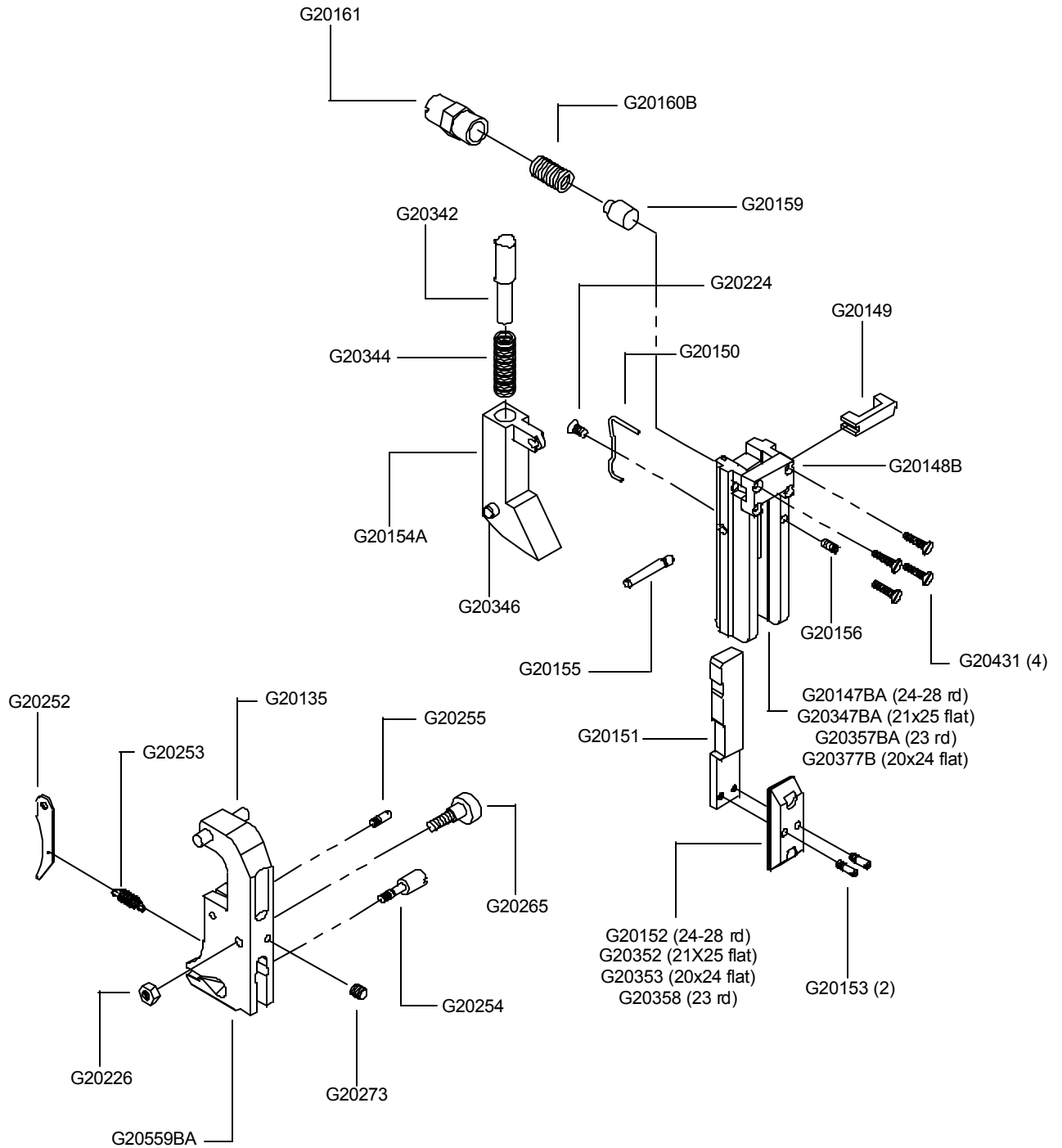
Driving and Feed Slide Assemblies



Driving and Feed Slide Assemblies

PART No.	DESCRIPTION	QUANTITY
G20127	Feed Rack	1
G20130	Feed Adjustment Block	1
G20131	Feed Slide	1
G20162A	Driving Slide Assembly	1
G20162BA	Driving Slide Assembly Eccentric	1
G20163A	Cutter Operating Ramp Assembly	1
G20164B	Driving Slide Plunger Eccentric	1
G20165	Driving Slide Spring	1
G20167	Screw, M4x.7x10 FHCS	2
G20169	Driving Slide Plunger Screw	1
G20170	Hex Jam Nut M8x1.25	1
G20171	Screw M8x1.25x12	1
G20173	Feed Rack Knob - Knurled	1
G20174	Feed Rack Adjustment Stud	1
G20176	Screw M4x.7x12 SHCS Low Head	2
G20177	Feed Rack Adj Knob Pointer	1
G20179	Screw M3x.5x4, SHCS	1
G20264	Screw M5x.8x5 SHCS	1
G20320A	Driving Slide Assembly - Crank Drive	1
G20321	Crank Link Screw	1
G20323A	Cutter Operating Ramp Assembly	1
G20340	Crank Drive Link	1

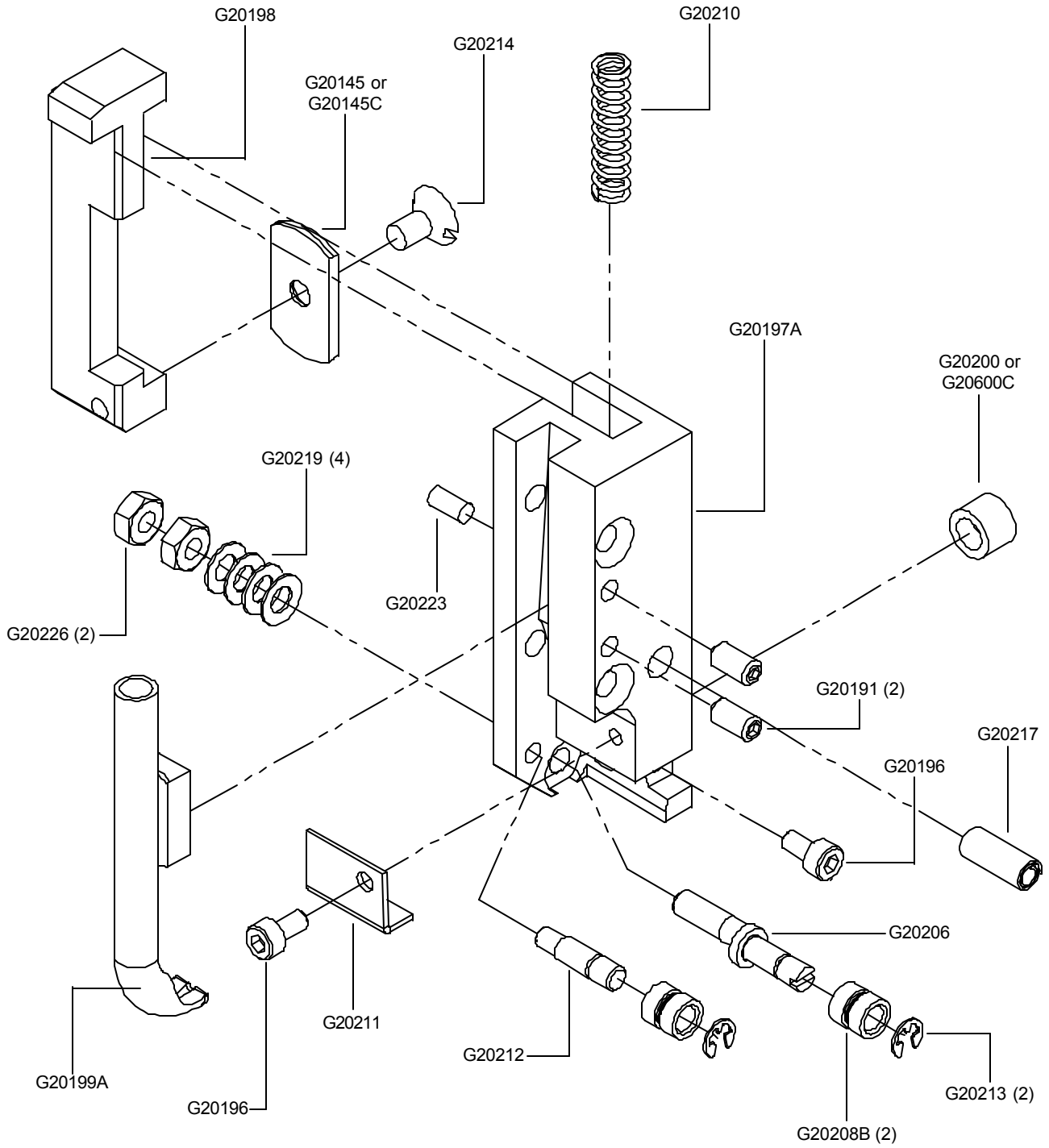
Bender Bar and Wire Holder Assemblies



Bender Bar and Wire Holder Assemblies

PART No.	DESCRIPTION	QUANTITY
G20135	Dowel Pin M5x24	1
G20147BA	Bender Bar Assembly, 24W	1
G20148B	Latch Housing Removable	1
G20149	Bender Bar Latch	1
G20150	Bender Bar Latch Spring	1
G20151	Driver Bar	1
G20152	Driver, 24W	1
G20153	Driver Retaining Screw	2
G20154A	Supporter Assembly	1
G20155	Supporter Pivot Pin	1
G20156	Supporter Pivot Pin Screw	1
G20159	Bender Bar Friction Plug	1
G20160B	Bender Bar Friction Spring	1
G20161	Bender Bar Friction Bushing	1
G20224	Bender Bar Latch Spring Screw	1
G20226	Hex Nut M4x.7	1
G20252	Wire Hook	1
G20253	Wire Hook Spring	1
G20254	Wire Hook Spring Screw	1
G20255	Hook Pivot Pin	1
G20265	Wire Holder Eccentric Adjustment Screw	1
G20273	Screw M4x.7x4 SHSS	1
G20342	Supporter Spring Plunger	1
G20344	Supporter Spring	1
G20344B	Supporter Spring - Heavy	1
G20346	Supporter Guide Pin	1
G20347BA	Bender Bar Assembly, 21x25	1
G20352	Driver, 21x25W	1
G20353	Driver 20x24 Wire	1
G20357BA	Bender Bar Assembly, 23W	1
G20358	Driver, 23W	1
G20377B	Bender Bar 20x24	1
G20431	Screw, M2.5x.45x12	4
G20559BA	Wire Holder Assembly 1/2	1

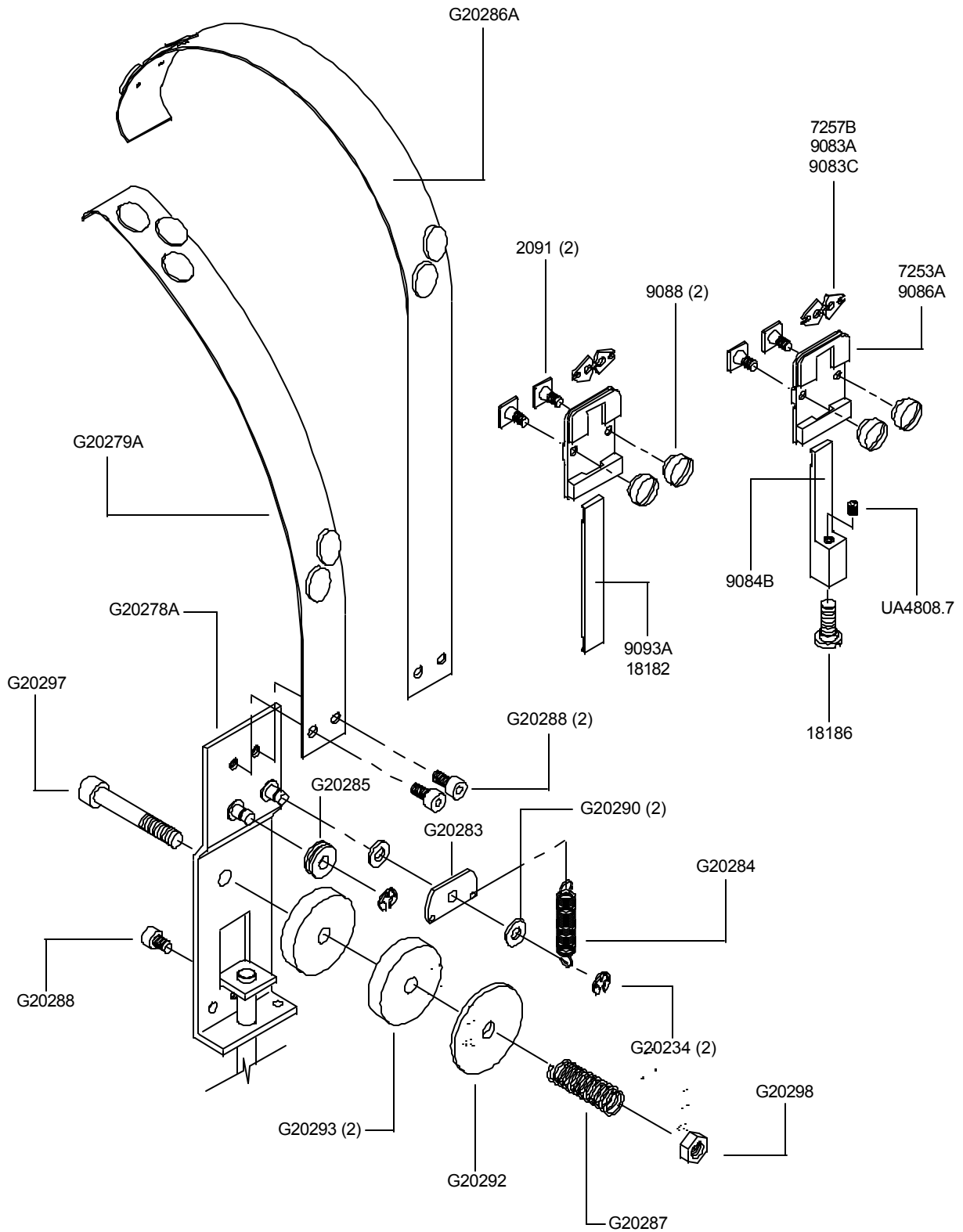
Cutter Block Assembly



Cutter Block Assembly

PART No.	DESCRIPTION	QUANTITY
G20145	Moving Wire Cutter	1
G20145C	Moving Cutter - Carbide	1
G20191	Screw, M4x.7x8 SHSS	2
G20196	Screw M3x.5x6 SHCS	2
G20197A	Cutter Block Assembly	1
G20198	Cutter Operating Slide	1
G20199A	Lower Wire Tube Assembly	1
G20200	Fixed Wire Cutter	1
G20206	Wire Straightener Eccentric	1
G20208B	Wire Straightener Roller	2
G20210	Cutter Operating Spring	1
G20211	Cutter Wire Shield	1
G20212	Wire Straightener Roll Stud	1
G20213	Wire Straightener Roll Clip	2
G20214	Screw M4x0.7x8 FHMS	1
G20217	Spirol Pin M5x12	1
G20219	Wire Straightener Disc Spring	4
G20223	Dowel Pin 1/8x1/4	1
G20226	Hex Nut M4x.7	2
G20600C	Fixed Cutter - Carbide	1

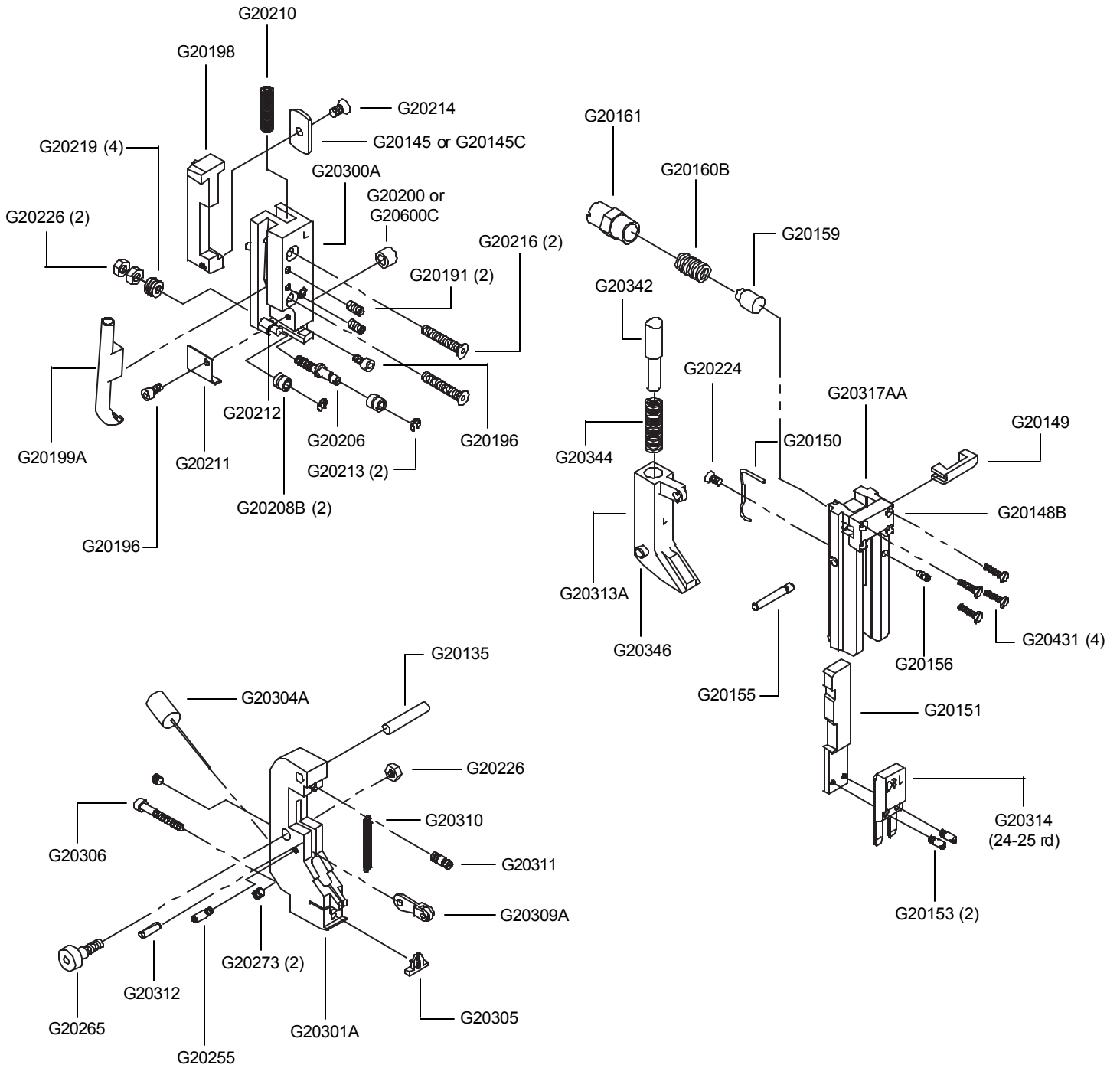
Wire Guide Bracket, Spring and Clincher Plate Assemblies



Wire Guide Bracket, Spring and Clincher Plate Assemblies

PART No.	DESCRIPTION	QUANTITY
A9086A	Clincher Plate Assembly - Tk, Round	1
G20234	E-Ring- 3/16"	2
G20278A	Wire Guide Spring Plate Assembly	1
G20278AA	W/Guide Spring Plate Asy - Complete	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, M4x.7x8 SHCS	3
G20290	Flat Washer, M5	2
G20292	Wire Oil Felt Washer	1
G20293	Wire Oiler Felt	2
G20297	Screw, M6x1x40 SHCS	1
G20298	Nylon Lock Nut, M6x1	1
UA4808.7	Screw 1/4-28 x 1/4	1
18182	Clincher Slide	1
18186	Clincher Slide Adjustment Screw	1
2091	Clincher Plate Binder Nut	2
7253A	Clincher Plate Assembly 1/2	2
7257B	Clincher Point 1/2 - Round	2
9083A	Clincher Point - Thick, Round	2
9083C	Clincher Point - Thick, Flat	2
9086A	Clincher Plate - Thick	1
9088	Clincher Plate Binder Bolt	2
9093A	Clincher Slide - Thick	2
9084B	Adjustable Clincher Slide	2
9093A	Adjustable Clincher Plate Asy - Tk	1

Loop Stitch Assemblies



Loop Stitch Assemblies

PART No.	DESCRIPTION	QUANTITY
G20135	Dowel Pin M5x24	1
G20145	Moving Wire Cutter	1
G20148B	Latch Housing, Removable	1
G20149	Bender Bar Latch	1
G20150	Bender Bar Latch Spring	1
G20151	Driver Bar	1
G20153	Driver Retaining Screw	2
G20155	Supporter Pivot Pin	1
G20156	Supporter Pivot Pin Screw	1
G20159	Bender Bar Friction Plug	1
G20160B	Bender Bar Friction Spring	1
G20161	Bender Bar Friction Bushing	1
G20191	Screw, M4x.7x8	2
G20196	Screw, M3x.5x6 SHCS	2
G20198	Cutter Operating Slide	1
G20199A	Lower Wire Tube Assembly	1
G20200	Fixed Wire Cutter	1
G20206	Wire Straightener Eccentric	1
G20208B	Wire Straightener Roller	2
G20210	Cutter Operating Spring	1
G20211	Cutter Wire Shield	1
G20212	Wire Straightener Roll Stud	1
G20213	Wire Straightener Roll Clip	2
G20214	Screw, M4x0.7x8 FHMS	1
G20216	Screw, M4x.7x25 SFHS	2
G20219	Wire Straightener Disc Spring	4
G20224	Bender Bar Latch Spring Screw	1
G20226	Hex Nut, M4x.7	3
G20255	Hook Pivot Pin	1
G20265	Wire Holder Eccentric Adjustment Screw	1
G20273	Screw, M4x.7x4 SHSS	2
G20300A	Cutter Block Assembly - Loop	1
G20301A	Wire Holder Assembly - Loop	1
G20304A	Wire Hook Assembly - Loop	1
G20305	Anvil - Loop	1
G20306	Screw, M3x.5x25 SHCS	1
G20309A	Wire Holder Lever Assembly - Loop	1
G20310	Wire Holder Roller Lever Spring	1
G20311	Spring Anchor Screw	1
G20312	Spirol Pin, M3x12	1
G20313A	Supporter Assembly - Loop	1
G20314	Driver - Loop	1
G20317AA	Bender/Driver Assembly - Loop	1
G20342	Supporter Spring Plunger	1
G20344	Supporter Spring	1
G20344B	Supporter Spring - Heavy	1
G20346	Supporter Guide Pin	1
G20347BA	Bender Bar Assembly, 23W	1
G20357BA	Bender Bar Assembly, 23W	1
G20431	Screw, M2.5x.45x12	4

Part Number / Description Cross-Reference

G20000A	Bonnet Assembly - G8	1	G20150	Bender Bar Latch Spring	1
G20110A	Large Feed Gear Assembly	1	G20151	Driver Bar	1
G20111A	Feed Pinion Assembly	1	G20152	Driver, 24W	1
G20112	Small Feed Gear	1	G20153	Driver Retaining Screw	2
G20113	Supporter Guide Plate	2	G20154A	Supporter Assembly	1
G20114	Feed Pinion Shaft	1	G20155	Supporter Pivot Pin	1
G20115	Latch Release Cam	1	G20156	Supporter Pivot Pin Screw	1
G20118	Feed Release Handle Cam	1	G20159	Bender Bar Friction Plug	1
G20119	Feed Release Handle	1	G20160	Bender Bar Friction Spring	1
G20121	Feed Release Plunger	1	G20161	Bender Bar Friction Bushing	1
G20122A	Feed Slide Retaining Screw Asy	2	G20162	Driving Slide	1
G20124	Bonnet Clamp Eccentric	1	G20162BA	Driving Slide Assembly Eccentric	1
G20126	Tube Pivot Plate	1	G20163A	Cutter Operating Ramp Assembly	1
G20127	Feed Rack	1	G20164B	Driver Slide Plunger Eccentric	1
G20128	Large Feed Gear Washer	1	G20165	Driving Slide Spring	1
G20129	Small Feed Gear Washer	1	G20167	Screw, M4x.7x10 FHCS	2
G20130	Feed Adjustment Block	1	G20169B	Driving Slide Plunger Screw Ecc	1
G20131	Feed Slide	1	G20170	Hex Jam Nut M8x1.25	1
G20132	Feed Lever	1	G20171	Screw M8x1.25x12	1
G20133A	Feed Release Spring Block Assembly	1	G20173	Feed Rack Knob - Knurled	1
G20135	Dowel Pin M5x24	1	G20174	Feed Rack Adjustment Stud	1
G20136A	Feed Gear Bracket Assembly	1	G20175	Screw M4x.7x6 SHCS	3
G20138	Feed Pinion Bearing	2	G20176	Screw M4x.7x12 SHCS Low Head	2
G20140	Follower Ball Bearing	1	G20177	Feed Rack Adj Knob Pointer	1
G20141	Wire Guide Bar-Left	1	G20179	Screw M3x.5x4, SHCS	1
G20142	Wire Guide Bar-Right	1	G20180	Flat Washer M6	1
G20143	Cutter Block Adjustment Rack	1	G20181	Upper Wire Tube	1
G20144A	Middle Wire Tube Assembly	1	G20182	Feed Gear Shaft Plate	1
G20145	Moving Wire Cutter	1	G20183	Wire Holder Retaining Spring - Long	1
G20145C	Moving Cutter - Carbide	1	G20184	Wire Holder Retaining Spring Foot	1
G20147BA	Bender Bar Assembly, 24W	1	G20186	Feed Gear Friction Spring	1
G20148B	Latch Housing, Removable	1	G20187	Feed Gear Friction Strip	1
G20149	Bender Bar Latch	1	G20189	Screw M3x.5x20	2

Part Number / Description Cross-Reference

G20190	Screw M3x.5x10- FHMS- Slotted	4	G20236	Tube Pivot Screw	1
G20191	Screw, M4x.7x8 SHSS	5	G20237	Cutter Block Adjustment Stud	1
G20195	Set Screw M6x1x8	2	G20239	Disc Washer Spring	2
G20196	Screw M3x.5x6 SHCS	6	G20240	Cutter Block Adjustment Washer	2
G20197A	Cutter Block Assembly	1	G20241	Screw M4x0.7x6 SHCS	5
G20198	Cutter Operating Slide	1	G20242	Cutter Adjustment Bar - Lower	1
G20199A	Lower Wire Tube Assembly	1	G20243	Dowel Pin 1/4x9/16	1
G20200	Fixed Wire Cutter	1	G20244	Tube Pivot Clip	1
G20202	Cutter Block Slide Plate	1	G20245	Cutter Adjustment Bar - Upper	1
G20204	Upper Cutter Block Guide	1	G20246	Cutter Block Adjustment Connect	1
G20206	Wire Straightener Eccentric	1	G20249	Cutter Block Washer	1
G20208	Wire Straightener Roll	2	G20250	Screw M4x.7x14	2
G20208B	Wire Straightener Roller	2	G20251	Cutter Adjustment Bar - Upper	1
G20210	Cutter Operating Spring	1	G20252	Wire Hook	1
G20211	Cutter Wire Shield	1	G20253	Wire Hook Spring	1
G20212	Wire Straightener Roll Stud	1	G20254	Wire Hook Spring Screw	1
G20213	Wire Straightener Roll Clip	2	G20255	Hook Pivot Pin	1
G20214	Screw M4x0.7x8 FHMS	5	G20256	Cutter Block Scale	1
G20215	Screw M5x.8x10, FHMS	4	G20261	Wire Holder Retaining Spring Screw	1
G20216	Screw M4x.7x25 SFHS	2	G20262A	Feed Lever Pin Assembly	2
G20217	Spirol Pin M5x12	1	G20263	Feed Lever E-Ring	2
G20219	Wire Straightener Disc Spring	4	G20264	Screw M5x.8x5 SHCS	5
G20220	Hex Nut M5x.8	1	G20265	Wire Holder Eccentric Adj Screw	1
G20223	Dowel Pin 1/8x1/4	1	G20266	Follower Bearing Pin	1
G20224	Bender Bar Latch Spring Screw	1	G20267	Feed Lever Bushing	1
G20226	Hex Nut M4x.7	2	G20268	Feed Lever Spring	1
G20228A	Adjustment Handle Assembly	1	G20269	Spirol Pin 3/16x5/8	1
G20229	Set Screw M6x1x12	2	G20273	Screw M4x.7x4 SHSS	2
G20230A	Cutter Operating Lever Assembly	1	G20274	Hex Jam Nut, M6x1	1
G20231	Cutter Operating Lever Pivot Pin	1	G20275	Ball Spring Plunger	1
G20232	Cutter Operating Lever Roll Pin	1	G20278A	Wire Guide Spring Plate Assembly	1
G20233	Cutter Operating Lever Roller	1	G20278AA	Complete W/G Spring Plate Asy	1
G20234	E-Ring- 3/16"	1	G20279A	Wire Guide Spring Assembly - Short	1

Part Number / Description Cross-Reference

G20283	Tension Pawl	1	G20346	Supporter Guide Pin	1
G20284	Tension Pawl Spring	1	G20347BA	Bender Bar Assembly,21x25	1
G20285	Tension Pawl Roller	1	G20352	Driver, 21x25W	1
G20286A	Wire Guide Spring Assembly - Long	1	G20357BA	Bender Bar Assembly, 23W	1
G20287	Wire Oiler Felt Spring	1	G20358	Driver, 23W	1
G20288	Screw, M4x.7x8 SHCS	3	G20360	Hex Key Wrench 3.0mm	1
G20289	Screw M4x.7x16	2	G20361	Hex Key Wrench 2.5mm	1
G20290	Flat Washer, M5	2	G20362	Clamp Wrench 5.0mm	1
G20292	Wire Oil Felt Washer	1	G20364	Open End Wrench	1
G20293	Wire Oiler Felt	2	G20366	Rear Clamp Pin	1
G20297	Screw, M6x1x40 SHCS	1	G20367	Rear Mounting Bolt	1
G20298	Nylock Lock Nut, M6x1	1	G20368	Feed Release Handle Cap	1
G20300A	Cutter Block Assembly - Loop	1	G20374	Hex Key Wrench 2.0mm	1
G20301A	Wire Holder Assembly - Loop	1	G20431	Screw, M2.5x.45x12	4
G20304A	Wire Hook Assembly - Loop	1	G20559BA	Wire Holder Assembly 1/2	1
G20305	Anvil - Loop	1	G20600C	Fixed Cutter - Carbide	1
G20306	Screw M3x.5x25- SHCS	1	HN1213	Bonnet Stud Nut	1
G20309A	Wire Holder Lever Assembly - Loop	1	PW516	Washer 5/16	1
G20310	Wire Holder Roller Lever Spring	1	072001	Screw M4x0.7x8	1
G20311	Spring Anchor Screw	1	18182	Clincher Slide	1
G20312	Spirol Pin M3x12	1	18183	Clincher Slide Adjustment Block	1
G20313A	Supporter Assembly - Loop	1	18184	Clincher Slide Block Clamp	1
G20314	Driver - Loop	1	18186	Clincher Slide Adjustment Screw	1
G20316	Wire Holder Retaining Spring - Short	1	2091	Clincher Plate Binder Nut	2
G20320	Driving Slide - Crank Drive	1	7024B	Clincher Point Flat - 1/2	2
G20320A	Driving Slide Assembly	1	7253A	Clincher Plate Assembly - 1/2	1
G20321	Crank Link Screw	1	9002	Bonnet Clamp Block	1
G20323A	Cutter Operating Ramp Assembly	1	9083A	Clincher Point - Thick, Round	2
G20340	Crank Drive Link	1	9086A	Clincher Plate - Thick	1
G20341	Rear Mounting Bolt	1	9088	Clincher Plate Binder Bolt	2
G20342	Supporter Spring Plunger	1	9093A	Clincher Slide - Thick	1
G20344	Supporter Spring	1			
G20344B	Supporter Spring - Heavy	1			

Optional Equipment

In addition to the standard features offered with the G8 Stitcher Head, optional equipment items can be purchased to better accommodate your stitching needs. The following kits can be purchased from your Graphic Arts Representative.

G8KC

The G8 Crank Drive Kit is available to owners of all styles of rail-driven G8 Heads who need to convert, for whatever reason, their existing G8 head to a crank-driven model. Included in this Kit are the Rear Clamp Pin, Rear Mounting Bolt, Bonnet Stud Nut, the Crank Drive Link and a complete assembly of the Link-Driven Driving Slide.

For more information about purchasing the G8KC or for technical support when making the conversion from rail-driven to crank-driven, contact your local Graphic Arts Representative.

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

WARNING

G8KL (Figure 24)

The standard G8 Head with 24 gauge wire can be converted to a Loop style by exchanging the following three sub-assemblies: the Wire Holder Assembly, the Cutter Block Assembly and the Bender Bar Assembly. Refer back to pages 23 through 28 for complete disassembly and reassembly instructions.

Contact your DeLuxe Stitcher Graphic Arts Representative or the DeLuxe Stitcher Customer Service Department for ordering information or for additional technical information on other wire sizes available in Loop Stitch.

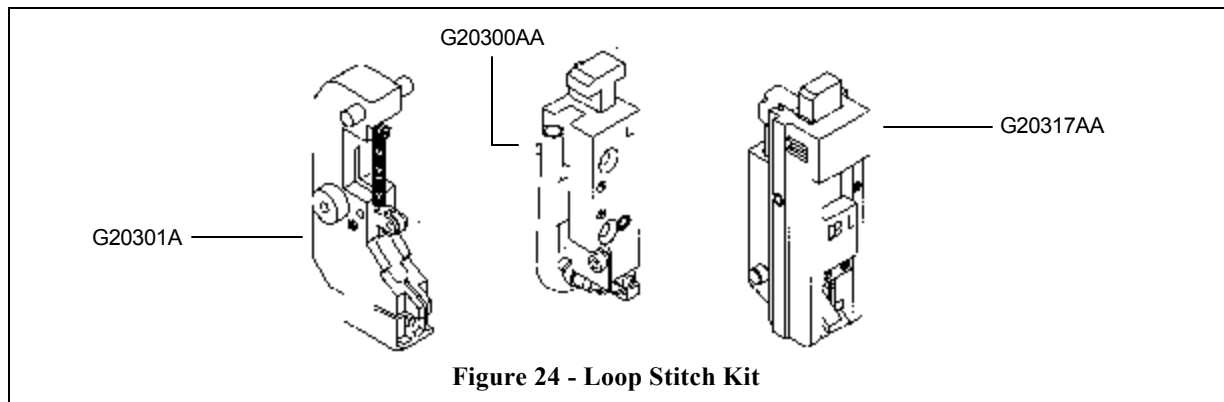


Figure 24 - Loop Stitch Kit

G8KS

The G8 Stop Stitch Kit is another optional purchase for the G8 Stitcher Head owner. It is designed for use with the DeLuxe Stitcher G8 series Heads. The G8KS mounts on the Adjustment Rail of McCain Saddle Stitchers. This kit stops the feeding of wire through the Stitcher Heads by pushing open the Feed Release Handles (thereby stopping the stitch) when it receives a signal from the calipers of the Stitcher.

The G8KS Stop Stitch Kit comes complete with all the components necessary for converting your existing stitcher machine, along with fully illustrated instructions. Call your Graphic Arts Representative for more information.

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



G8KT

The G8KT is a Stop Stitch Toggle Kit specifically designed for users of McCain Stitchers using both 26/26D and G8 Stitcher Heads.

The Electrical Box, Box Cover and Toggle Switch replace your machine's existing equipment to make switching between the two styles of Stitcher Heads easier. This Kit comes complete with a wiring diagram and replacement electrical box. But for more information or for more technical support, contact your local Graphic Arts Representative.

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, Inc. 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 G8 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 47-49 in this manual.

Description	Item Number
Clincher Point - Thick, Round	9083A
Latch Release Cam	G20115
Feed Slide Retain Screw Assy	G20122A
Follower Ball Bearing	G20140
Moving Wire Cutter	G20145
Bender Bar Latch	G20149
Bender Bar Latch Spring	G20150
Driver Bar	G20151
Driver, 24W	G20152
Driver Retaining Screw	G20153
Bender Bar Friction Plug	G20159
Bender Bar Friction Spring	G20160
Wire Holder Retain Spring - Long	G20183
Wire Holder Retaining Spring Foot	G20184
Feed Gear Friction Strip	G20187
Fixed Wire Cutter	G20200
Screw M4x0.7x6 SHCS	G20241
Wire Hook	G20252
Hook Pivot Pin	G20255
Tension Pawl	G20283
Supporter Spring Plunger	G20342

**PLAC:
STAM
HERE**

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

* You can purchase the G8EPK which includes these and other common replacement parts

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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