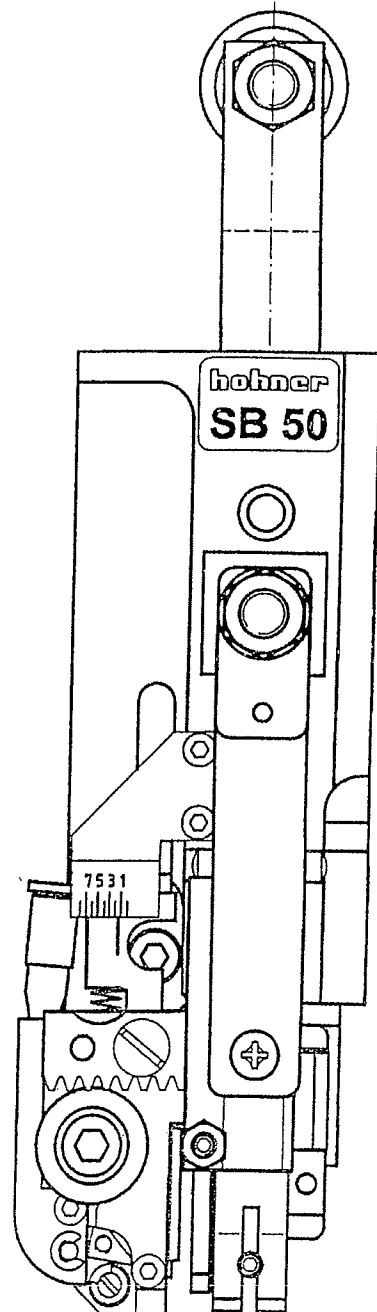


hohner

SB 50

Wire Stitching head



CAUTION

1. Prior to commissioning the narrow stitching head or to working on the machine, it is absolutely necessary to read the hohner operating manual and to observe the warnings on the machine. Non-compliance with these instructions may lead to severe injuries.
2. Do not operate the machine before all protective systems, locking and other safety devices are activated or installed on the machine
3. Prior to executing repair and assembling work, interrupt power supply and set safety switch (main switch) onto 0.
4. The right to claim under guarantee only applies if there is a number label (number label on the stitching head casing).

The user is liable for the safe functioning of the machine at all times as well as for the operator following the instructions mentioned in this operating manual. For all questions concerning the safe operation of the stitching head, please consult your superior, your nearest **hohner**-representative or contact directly:

hohner Maschinenbau GmbH

Street:	Gänsäcker 19
Town:	D-78532 Tuttlingen
Telephone:	+49 7462 / 9468-0
Telefax:	+49 7462 / 9468-20
E-Mail:	info@hohner-gmbh.de
Internet:	www.hohnerstiching.com
Internet:	www.hohnerstiching.com

Obtaining spare parts / customer service

Service-Telephone: + 49 7462 / 9468-23

- Subject to technical alterations -

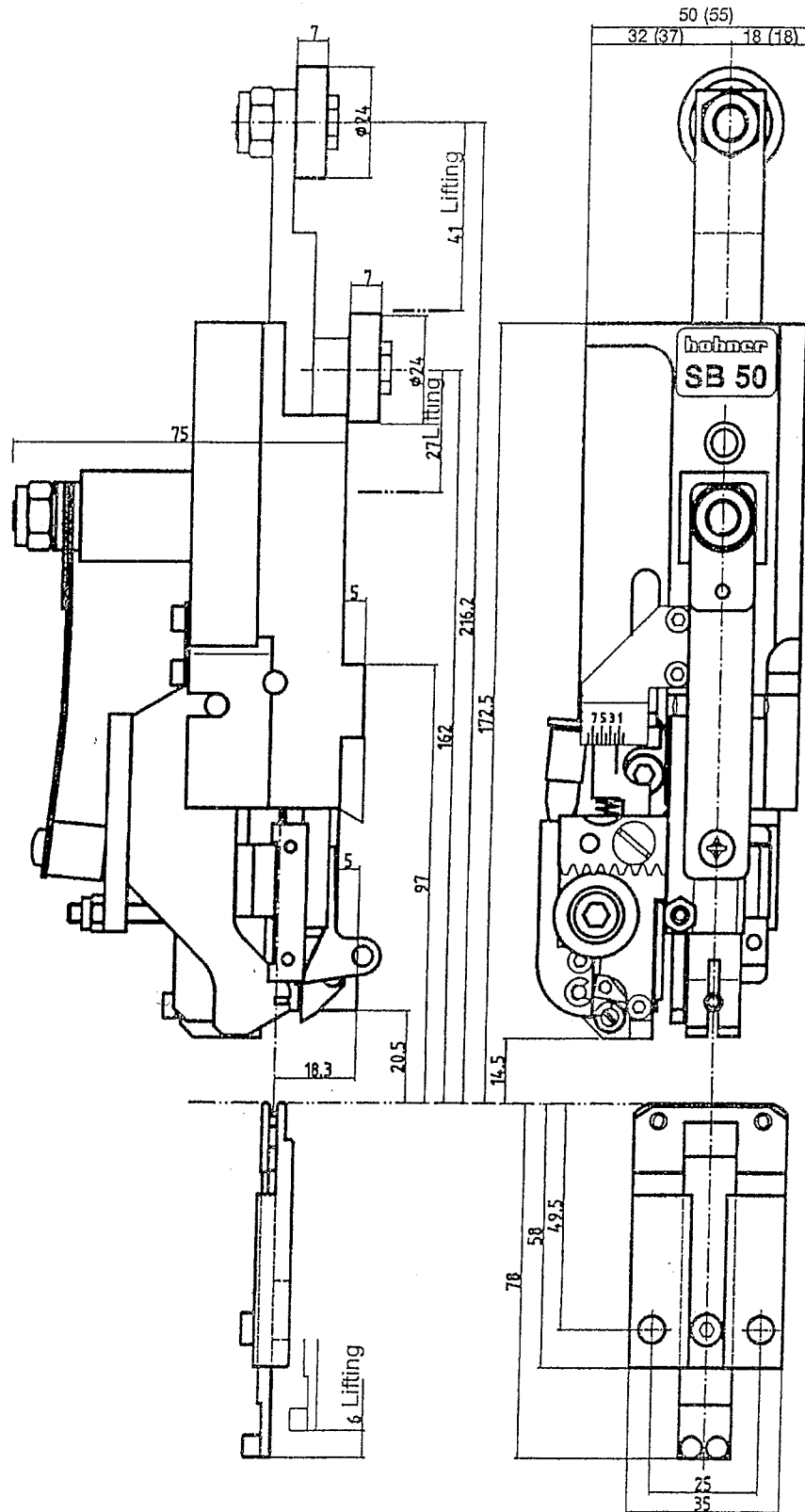
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GENERAL INFORMATION AND OPERATION


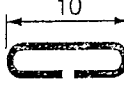
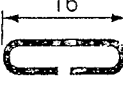
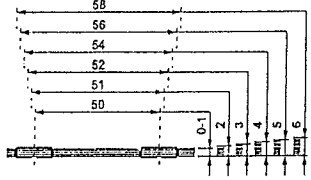
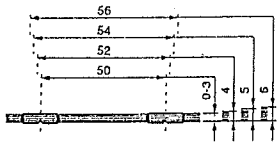
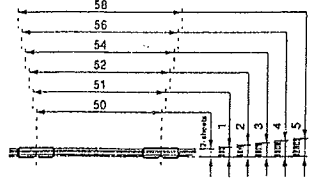
1 GENERAL INFORMATION AND OPERATION

1.1 Dimension sheet





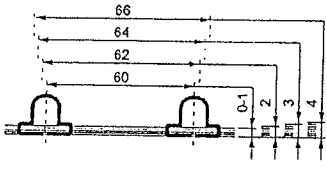
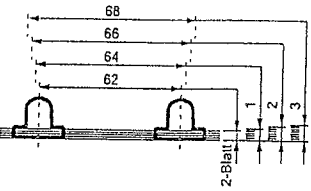
1.2 Technical data

1.2.1 Normal stitching

			
	Normal stitching	Normal stitching N10	Normal stitching N16
Length of the clamp back	14 mm 0.55 inch.	10 mm 0.39 inch.	16 mm 0.63 inch.
Max. stitching strength Stitching clamp flipped over	6 mm 0.24 inch.	6 mm 0.24 inch.	5 mm 0.2 inch.
Stiching wire-Ø	<u>Nr. 21 - 23</u> 0,80 - 0,70 mm 0.031 - 0.027 inch. <u>Nr. 24 - 28</u> 0,60 - 0,50 mm 0.024 - 0.016 inch. <u>Nr. 26 - 30</u> 0,50 - 0,35 mm 0.020 - 0.014 inch.	<u>Nr. 24 - 28</u> 0,60 - 0,40 mm 0.024 - 0.016 inch.	<u>Nr. 21 - 23</u> 0,80 - 0,70 mm 0.031 - 0.027 inch. <u>Nr. 24 - 28</u> 0,60 - 0,50 mm 0.024 - 0.016 inch.
Clamp intervals and stitching thickness			
<p>With a centering device, the clamp intervals change by: centering device, narrow approx. 12 mm centering device, large approx. 18 mm</p>			

GENERAL INFORMATION AND OPERATION

1.2.2 Loop stitching

		
	Standard loop stitching	8 mm loop stitching
Length of the clamp back	14 mm / 0.55 inch.	16 mm / 0.63 inch.
Ring eye-Ø	Ø 6 mm / Ø 0.23 inch.	Ø 8 mm / Ø 0.31 inch.
Max. stitching strength Stitching clamp flipped over	4 mm / 0.16 inch.	3 mm / 0.12 inch.
Stiching wire-Ø	Nr. 24 - 26 0,60 - 0,50 mm 0.024 - 0.020 inch.	Nr. 24 - 26 0,60 - 0,50 mm 0.024 - 0.020 inch.
Clamp intervals and stitching thickness	 <p>With a centering device, the clamp intervals change by narrow approx. 12 mm</p>	 <p>With a centering device, the clamp intervals change by narrow approx. 12 mm</p>

Net weight of the wire stitching head approx. 1.3 kg
 Wire stitching head with complete packaging approx. 2.0 kg

Important: Please use only the stitching wire types recommended by the manufacturer, because in wire types with strong abrasive wear, the wire guiding components may become blocked!

1.3 Accessories

The following items are supplied with every new stitching head SB-50:

1.3.1 Equipment

- Cat. No 39 59 337 1 Torsion spring
- Cat. No 99 59 070 1 Clincher box, complete
- Cat. No 99 59 077 1 Centering device set (for normal stitching)
- Cat. No 99 59 660 1 Centering pusher set, complete (for loop stitching)
- Cat. No 99 63 180 1 Clamp, complete

1.3.2 Tool

- Cat. No 94 59 210 1 Adjustment grip

1.3.3 Additional equipment, optional

- Cat. No 31 59 014 1 Tenon block strip
- Cat. No 31 59 414 1 Terminal strip
- Cat. No 46 000 33 1 T-grip SW4 x 150

1.4 Lubrication instructions

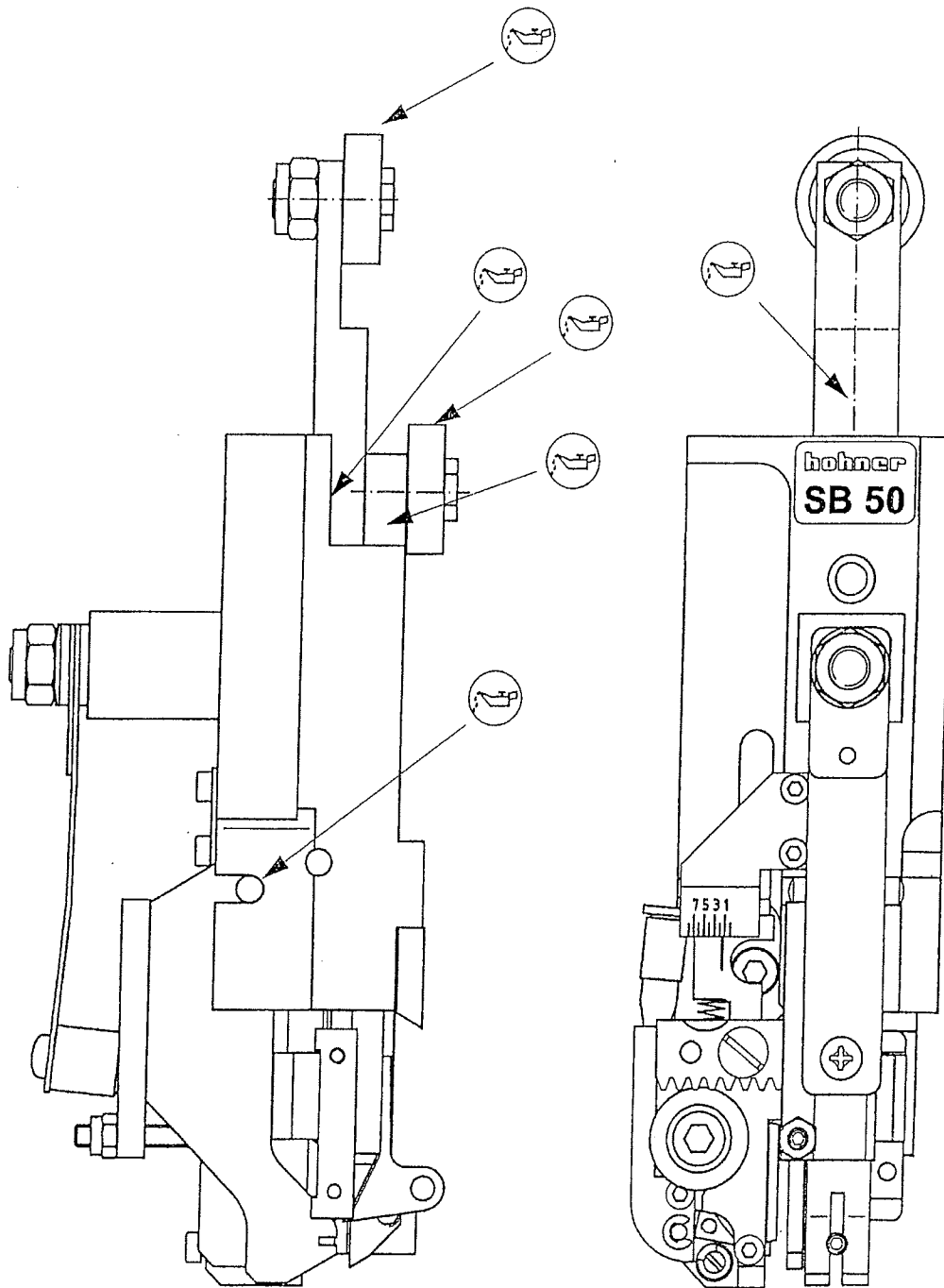
Please use only good mineral oil that is not too thick.

Works recommendation:

Slideway oil of viscosity class 65-70 (ISO-viscosity class according to DIN 51 519).

How often is lubrication required?

If necessary (approx. every 16 hours of operation). The bobs of the wire guiding spring need to be slightly lubricated as well from time to time (see machine operating instructions/transport box). All these instructions must be followed exactly to ensure necessary industrial safety.

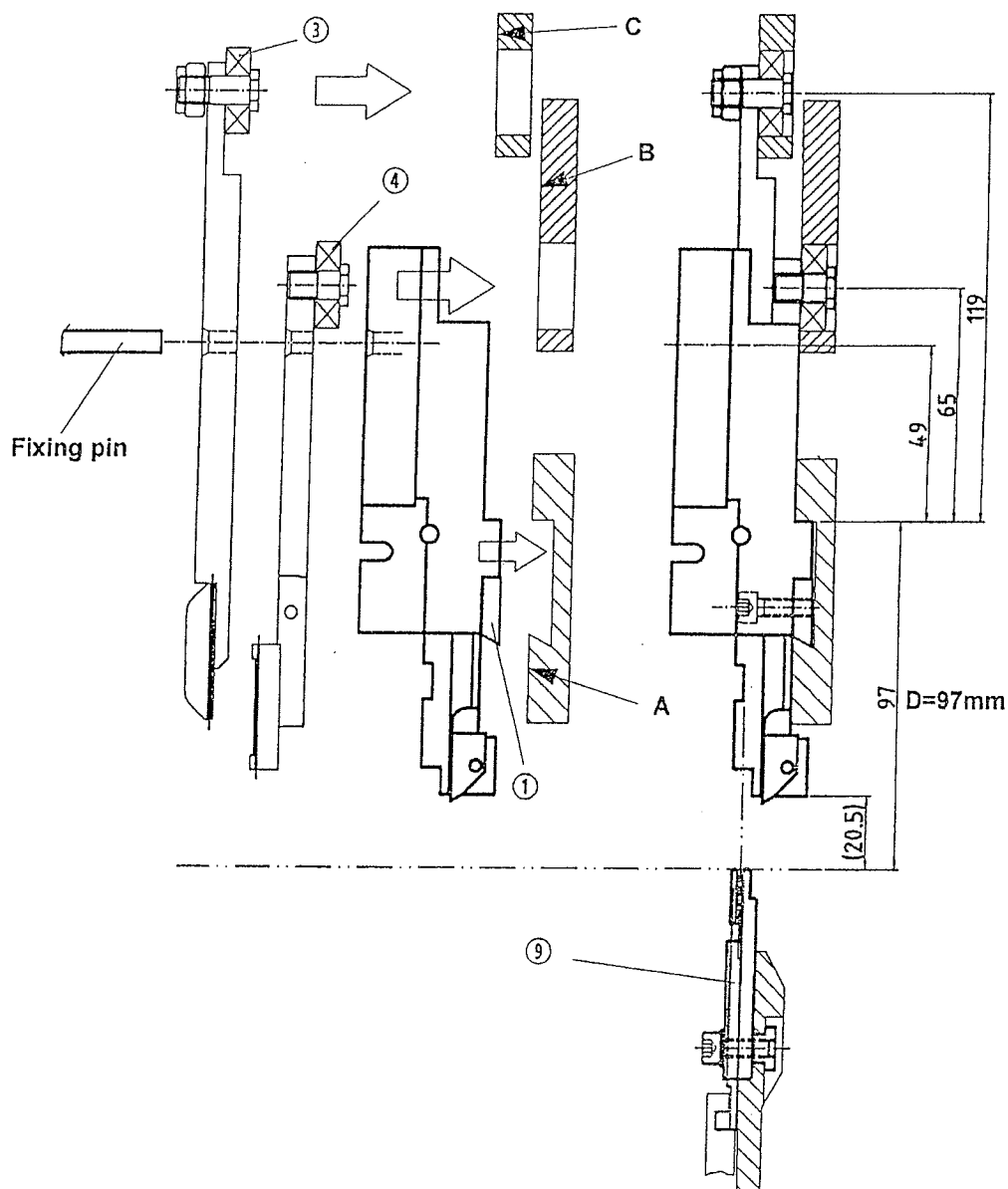


GENERAL INFORMATION AND OPERATION

1.5 Assembling and Adjustment of the stitching head

Prior to commissioning the stitching head, adjustment of the stitching carriage is to be checked according to the operating instructions of the stitching machine, with particular emphasis on executing the following control measurements:

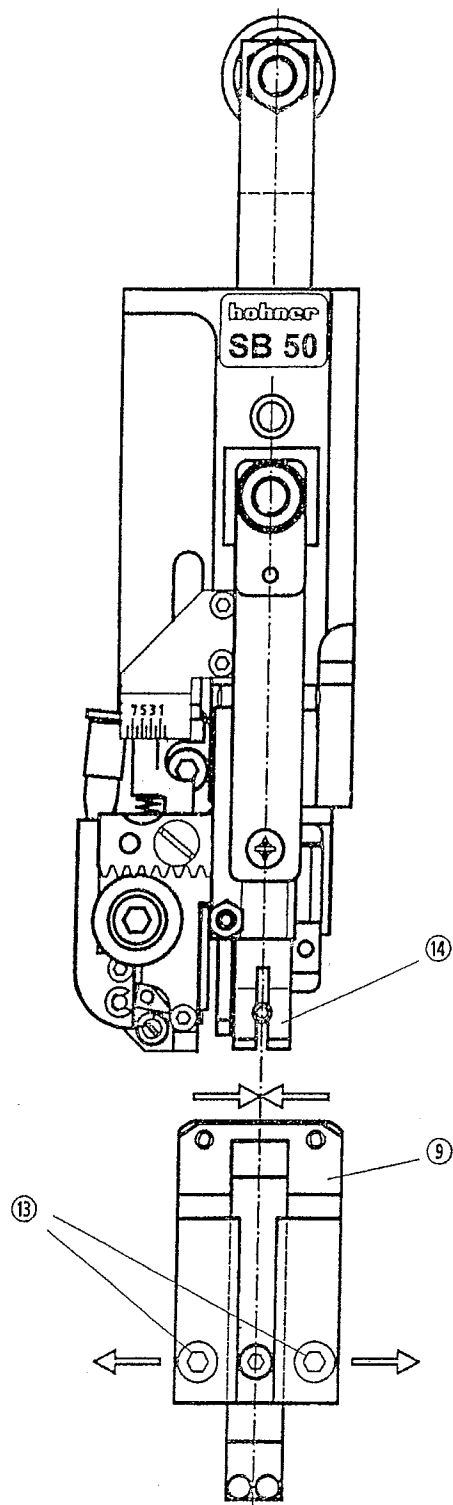
- Check parallelism (=) B and (=) C to stop surface A
- The clincher boxes 9 should be tightened up to the stitching carriage as far apart as possible and brought into upper position. The control dimensions D must be 97 mm.
- Loosen the tenon block 1 on the wire stitching head and insert it into the stitching machine, screw the stitching head tightly and at the same time take care that the holders 3 and 4 sit correctly in the notches of the stitching machine.
- To help assembling, a rubber-like fixing pin is used to fix the stitching case to the respective slides. For that purpose, the generating unit must be brought into the stitching head changing position. This fixing pin **must be pulled out** and put in a safe place prior to commissioning.



1.6 Fine adjustment of the clincher box

Loosen fastening screw 13. Adjust clincher box 9 by shifting it sideways on the stitching head.

The centre of the former 14 must be in exact alignment with the centre of the clincher box 9.

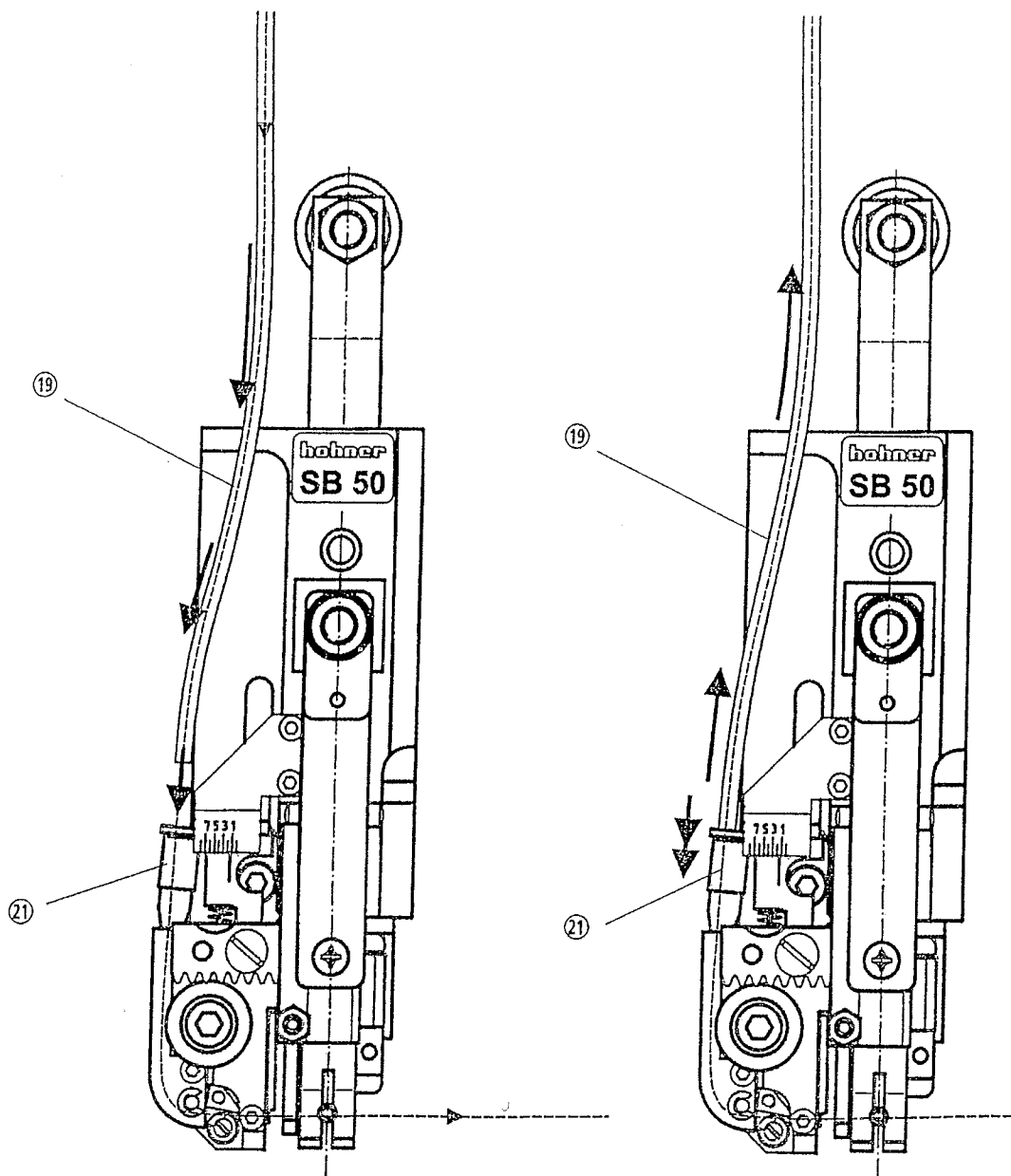


1.7 Insertion / Removal of the stitching wire

To insert the stitching wire, insert the wire guiding tube 19 in the adapter 21 of the central pipe and push it in as far as possible. Let the transport box run in inching mode, so the stitching wire be pushed into the stitching head (see machine operating instructions).

To remove the stitching wire, release the wire guiding tube 19 by "pressing down" the collar ring of the adapter 21 and pull out the wire guiding tube 19 towards the top.

Please note: It is most important that the wire guide sleeve to the top end of the transport box should be removed (see machine operating instructions).

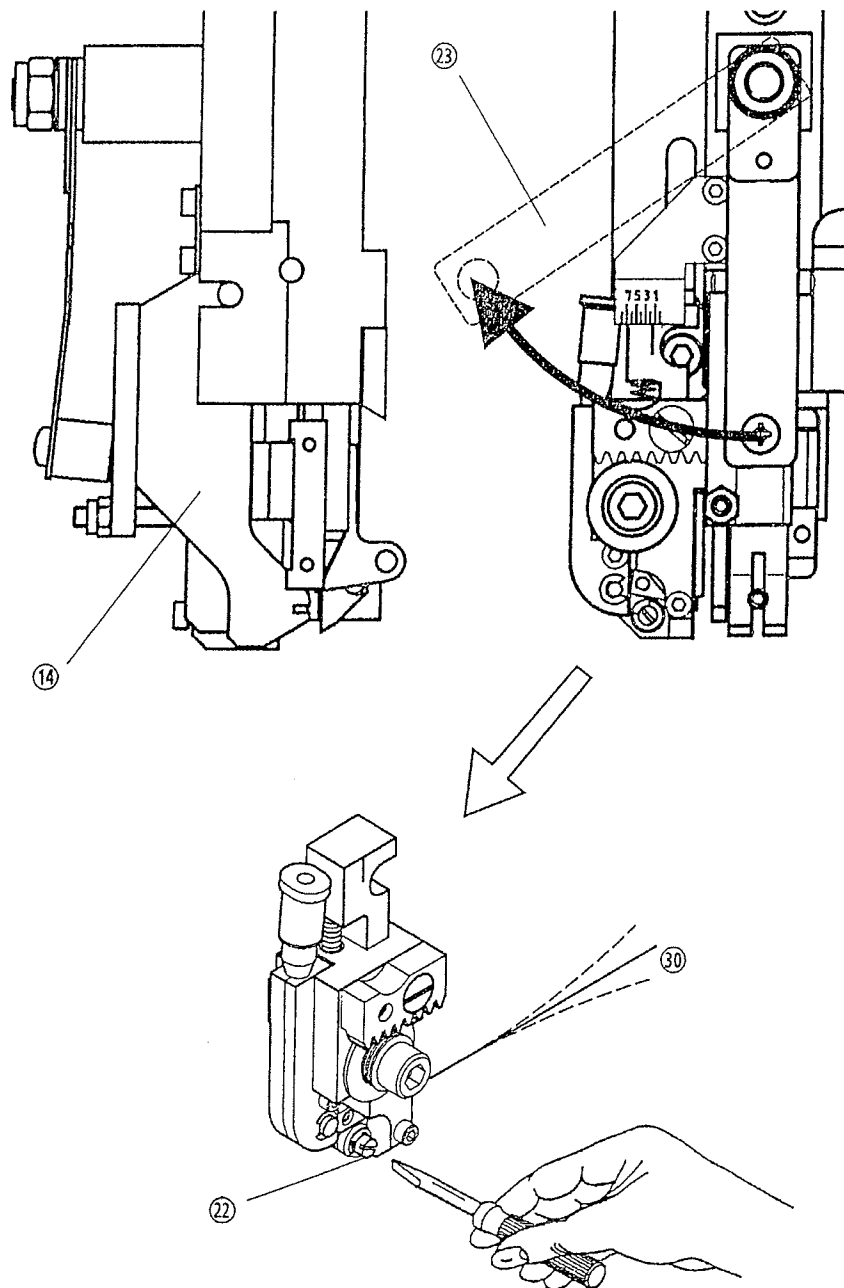


1.8 Alignment of the stitching wire

The stitching wire must be kept in a straight position during processing. If this is not the case, or should any disturbances occur because of this, you should try to change the wire direction by slightly turning the wire alignment tongue **22** with the help of a screw driver.

Should this brief attempt not be successful, the former **14** should be removed. This can be done by swinging the laminated spring **23** sideways. Then the former can be taken out towards the front. Carry on transporting the stitching wire by operating the transport box in inching mode. Now you can see whether the stitching wire **30** is moving forward in a straight or bent position. Should the stitching wire not come out in a straight position, then carry on adjusting the wire levelling eccentric **22** until the right setting is found. Put back former **14** and swing laminated spring **23** into position.

Note: In the position of the slot in the wire levelling eccentric **22** shown below, the eccentric is in the bottom position. This means that it is essential that the wire is levelled. The wire levelling eccentric is adjusted in the factory to the size of the specified test wire



GENERAL INFORMATION AND OPERATION

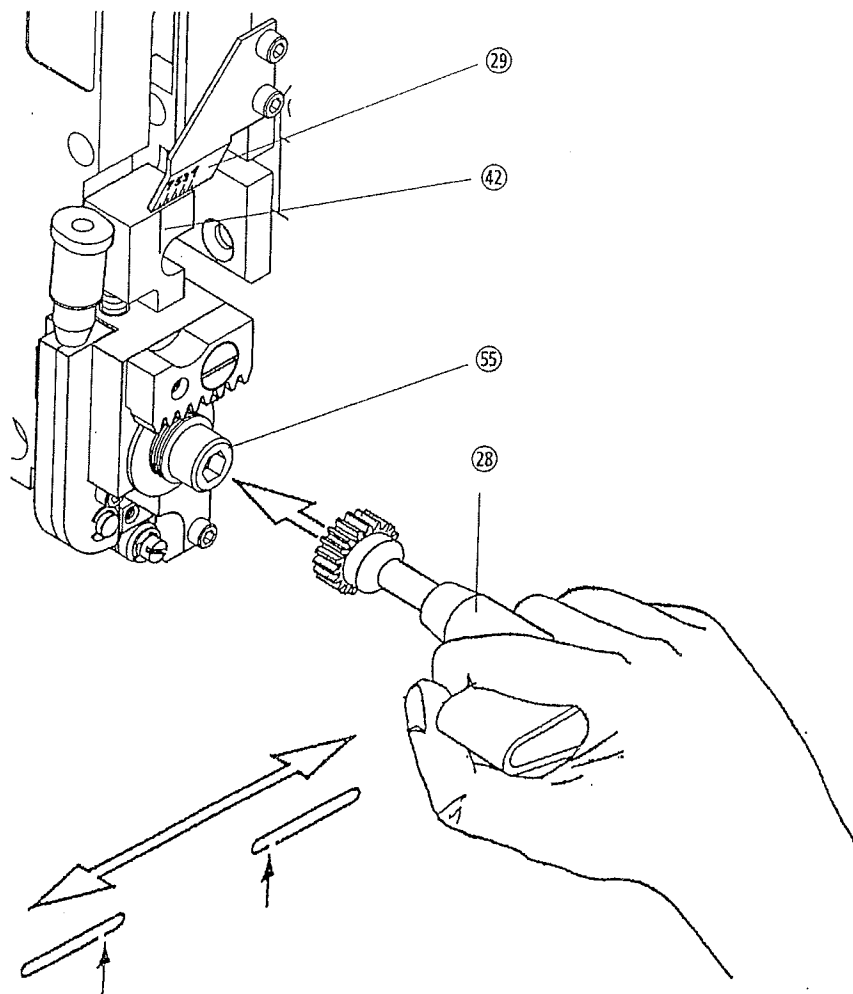
1.9 Adjustment of the wire length

- see relevant chapter about transport box in the machine operating instructions -

1.10 Adjustment of side length

The length of the wire piece for a complete staple is determined by the thickness of the sheets to be stitched (**thickness of sheets to be stitched = 1/2 product thickness**). Prior to this, the stitching generating unit must be adjusted to the required thickness of sheets to be stitched (for this, see relevant machine operating instructions).

Place the supplied adjustment grip 28 on the screw 55, and adjust the marking line of the cutting slide 42 to the required stitching thickness on scale 29.

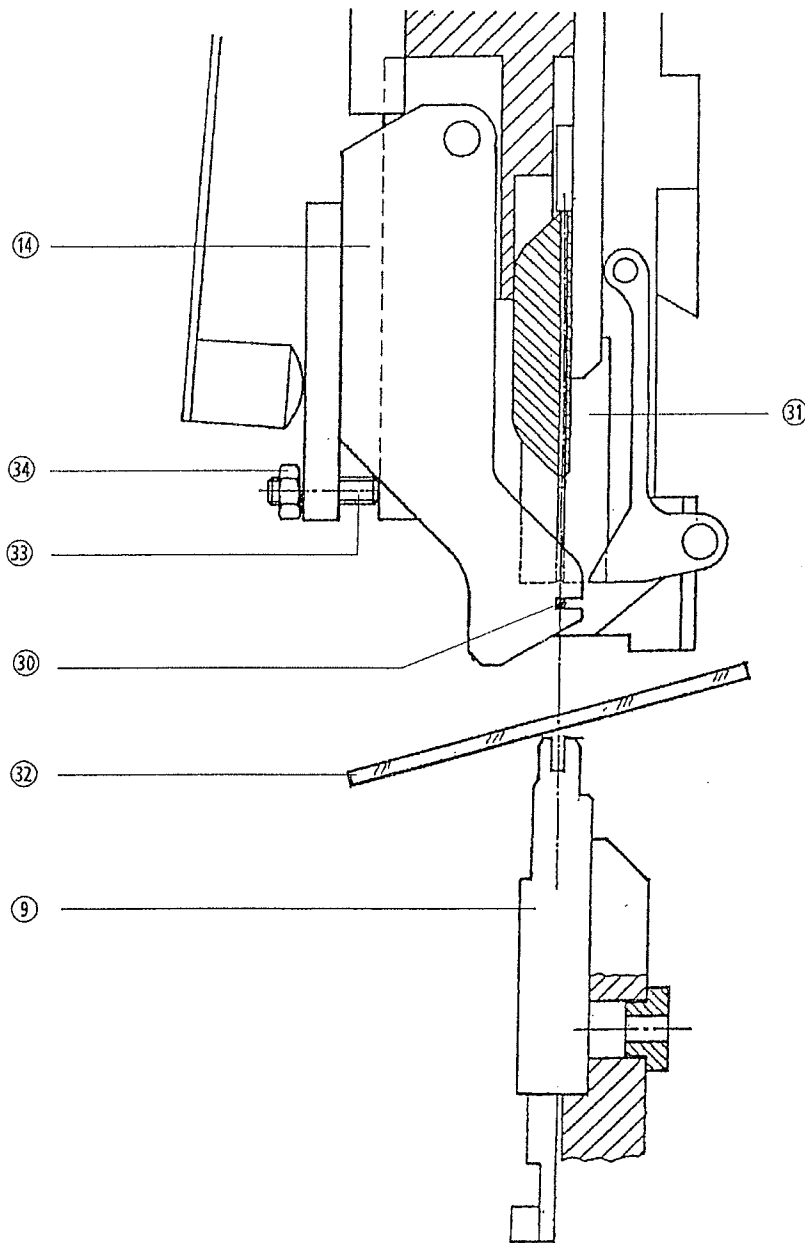


1.11 Adjustment of the former

Perfect stitching can only be ensured if the former 14 swings into such a far position that the stitching wire 30 comes exactly under the groove centre of the bender 31. This can be controlled exactly by putting a mirror 32 on the clincher box 9. The former or wire position with respect to the bender groove can then be seen clearly. Any necessary adjustment can be achieved by turning the threaded pin 33.

Important:

After adjusting, tighten up carefully the hexagonal screw nut 34 again.



1.12 Replacement of the knives

The stitching quality depends to a large extent on the quality of the knives. In case of wear and tear, the knives can be used several times: if necessary, adjust by a few degrees.

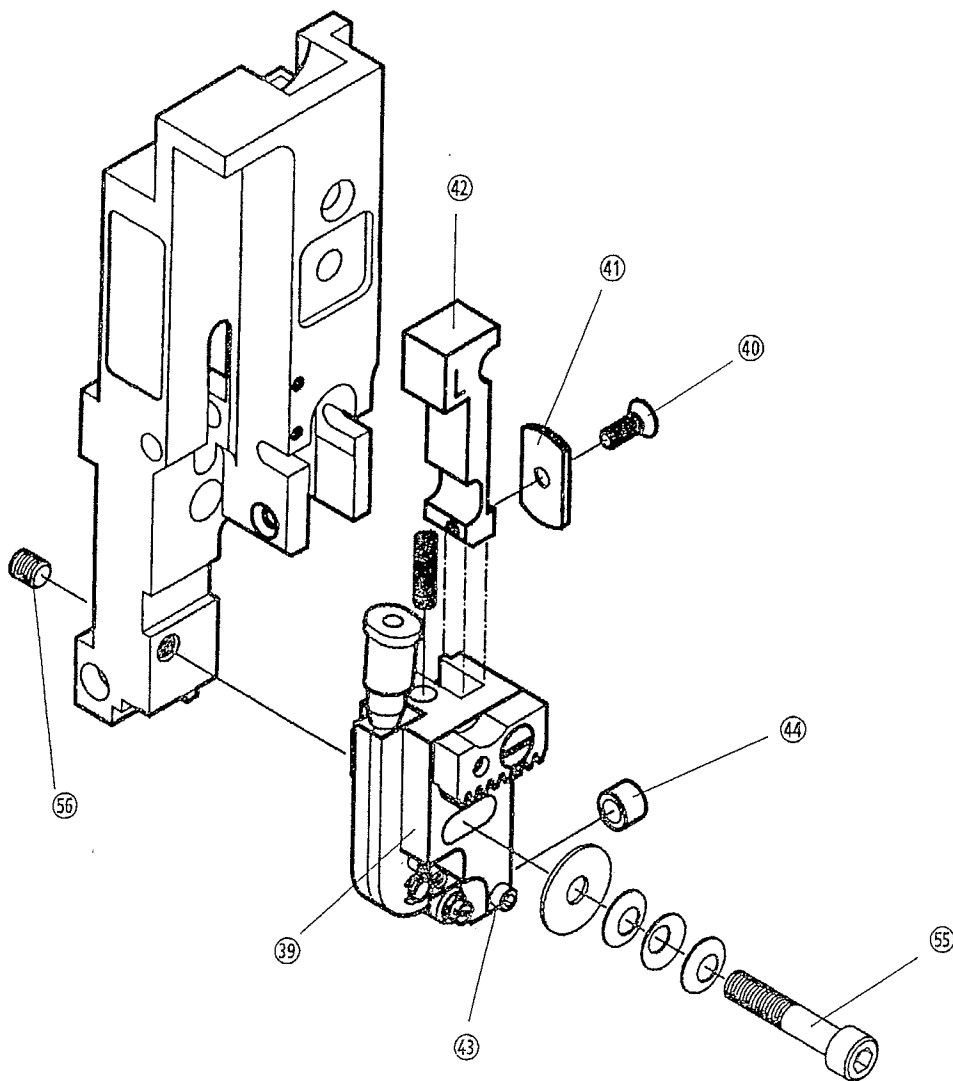
a) Replacement of flat knife 41

Remove cutting block 39. Loosen vertical screw 40 and replace flat knife 41. Installation occurs in reverse order.

b) Replacement of round knife 44

Remove cutting block 39. Squeeze out cutting slide 42 carefully towards the back (built-in compression spring is tightened). Loosen allen screw 43, then squeeze out flat knife 44. Replace round knife. Installation occurs in reverse order. When installing, take care that the round knife 44 is placed so far to the front, that an absolute cutting effect be reached with the counterblade of the flat knife. Place new round knife as close to the depressed flat knife 41 as possible (gently press the round knife in the opposite direction from the funnel side with the help of a small screw driver.). Tighten up allen screw 43.

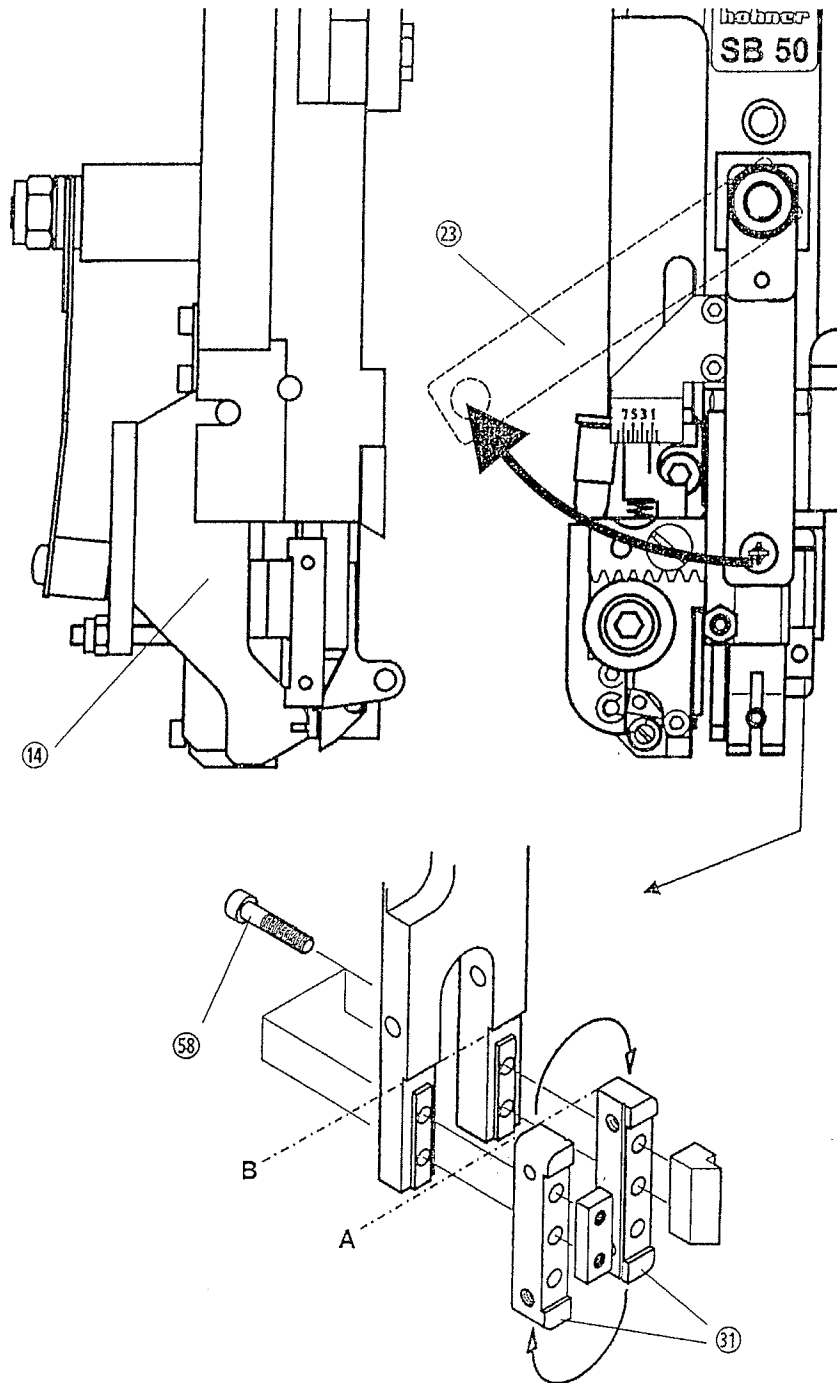
Take care that the cutting slide 42 can be moved in cutting block 39, otherwise adjust the position of the round knife to the flat knife.



1.13 Replacement of the bender

Remove the stitching head completely, then swivel laminated spring 23 and take out former 14 towards the front. Unscrew the four cylinder screws 58 and pull down the benders 31. Installation occurs in reverse order. Take special care that the upper edges A of the bender 31 lie against the pressure edges B of the main slide without interval.

If necessary, the benders can be re-used in reverse position.

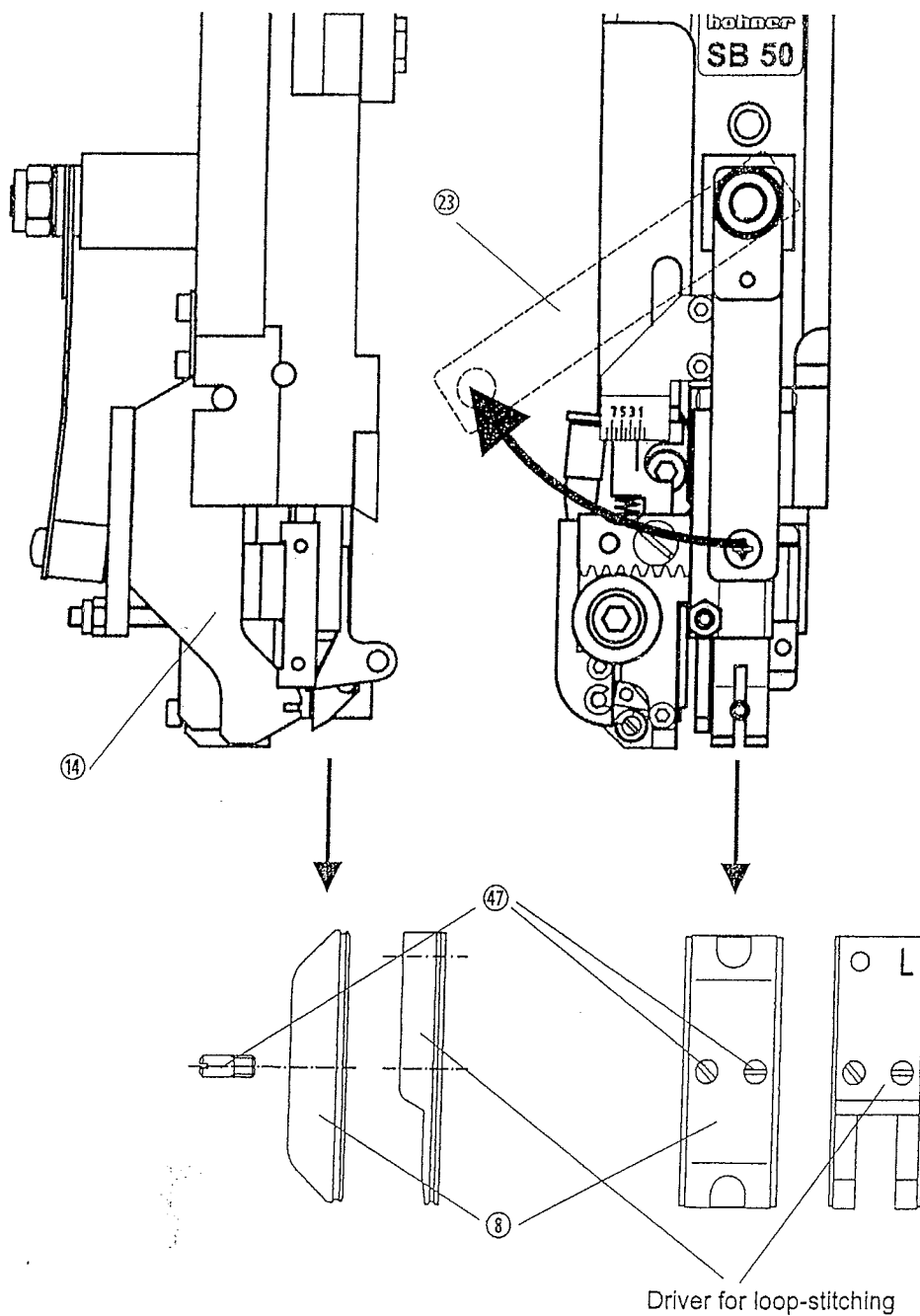


GENERAL INFORMATION AND OPERATION

1.14 Replacement of the driver

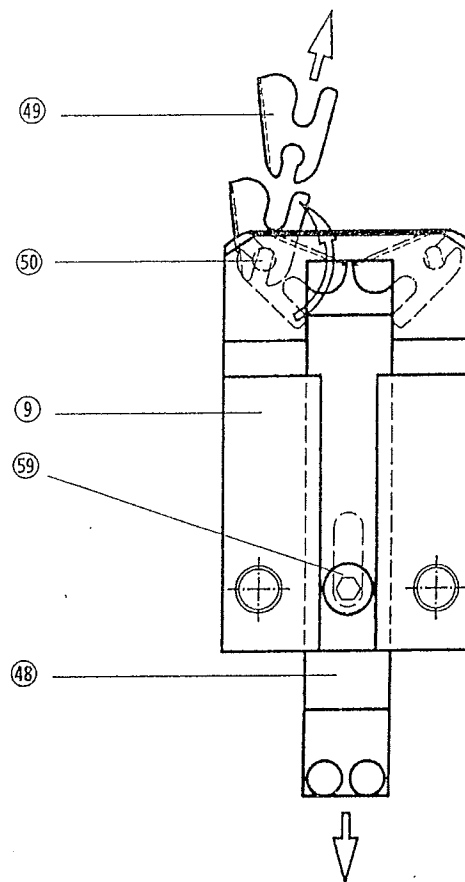
Swivel laminated spring 23 and remove former 14 towards the front. Unscrew both threaded bolts 47 in driver 8 and pull down. Installation occurs in reverse order.

In case of wear of the lower driver edge, the driver can be re-used in reverse position.



1.15 Replacement of the clincher

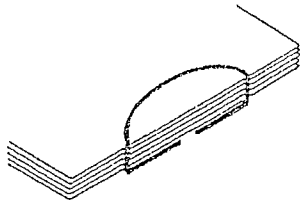
Unscrew screw 59. Take out clincher tappet 48 by pulling it downwards. Twist clincher 49 upwards in clincher box 9 and take it out of the retention pin 50. Push new clincher onto the retention pin 50 and twist it to the centre of the clincher box. Re-insert the clincher tappet 48. Tighten up screw 59.



REMEDY IN CASE OF FAULTS

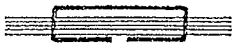
2 REMEDY IN CASE OF FAULTS

In the following section, you will find a few examples of faults with indication of their possible cause. If they can be ascribed to several causes, sometimes several suggestions are mentioned as remedy: you should not comply with all of them and then test out the results, rather proceed accordingly in a stepwise manner with a test in-between. Worn parts should always be replaced.



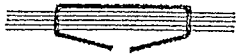
Clamp back is bent in banana-like form:

- Weaker or softer wire
- Wire not aligned: siehe Kap. 1.8
- Round or flat knife worn, siehe Kap. 1.12
- Pressure of the shoe tongue too weak: remove blocking wire pieces or replace compression spring in shoe tongue.
- Wire groove in driver soiled, worn or broken off: remove driver, siehe Kap. 1.15
- Cleanse driver groove or replace driver



Clamp back is not tight:

- Too little pressure on stitching: adjust stitching generating unit to stitching thickness



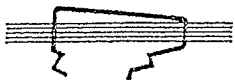
Clamp sides are not sufficiently flipped over:

- Stitching too little pressed: adjust stitching generating unit to stitching thickness
- Clinchers do not come far enough to the top: Adjust pressure for clincher lifting on the stitching generating unit
- Time sequence of clincher operation does not tally with the movement of the lifting: Sticking generating unit must be adjusted by the manufacturer.



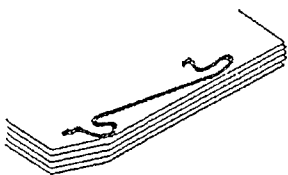
Clamp back is not tight and is bent in saddle-form:

- Too little pressure on stitching: adjust stitching generating unit to stitching thickness
- Weaker or softer wire
- Pressure of the shoe tongue too weak: remove blocking wire pieces or replace compression spring in shoe tongue.



Clamp sides squashed and not correctly flipped over:

- Weaker or softer wire
- Wire is not aligned: siehe Kap. 1.8
- Align clincher box: siehe Kap. 1.6
- Various side lengths: siehe Kap. 1.10
- Overall piece of wire too short: siehe Kap. 1.9
- Worn or flat knives: siehe Kap. 1.12



Wire does not pierce through properly, hence formation of eyes:

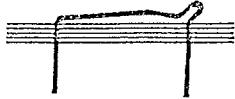
- Weaker or softer wire
- Bender groove blocked by piece of wire
- Worn round or flat knives: siehe Kap. 1.12
- Wire groove in driver soiled, worn or broken off: remove driver, siehe Kap. 1.14
- Cleanse driver groove or replace driver
- Pressure of the shoe tongue too weak: remove blocking wire pieces or replace compression spring in shoe tongue:
- Align clincher box: siehe Kap. 1.6



Clamp sides break off:

- Wire too brittle: use another wire quality
- Former blocked by wire pieces: remove pieces of wire, if necessary remove former
- Grip spring or grip in former defective
- Strap spring in binding unit defective
- Wire gauge does not match wire guiding components (bender and driver)
- Adjust former to bender groove

Knobs at clamp edge:



- Weak or soft wire
- driver broken off:
- Worn round and flat knives:

siehe Kap. 1.14

siehe Kap. 1.12

Clamp sides run together or apart:



- Wire not aligned: see chapter
- Worn round and flat knives:

siehe Kap. 1.8

siehe Kap. 1.12

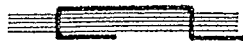


Side ends not correctly flipped over:

- Wire not aligned:
- Aign clincher box:

siehe Kap. 1.8

siehe Kap. 1.6



One side or both sides are flipped over diagonally:

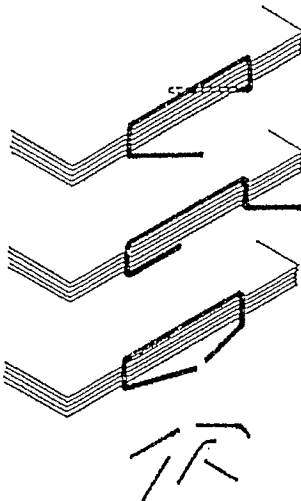
- Weaker or softer wire
- Wire not aligned:
- Worn round or flat knives:
- Clincher broken off:
- Adjustment of the clincher box holder to stitching head holder,

siehe Kap. 1.8

siehe Kap. 1.12

siehe Kap. 1.15

siehe Kap. 1.5



Clamp sides are flipped over diagonally on the same side:

- Wire not aligned:
- Adjustment of the clincher box holder to stitching head holder,

siehe Kap. 1.8

siehe Kap. 1.5

Slightly bent wire pieces are falling out:

- wire not aligned:
- strap spring in bender defective or worn bender

siehe Kap. 1.8

Wire loop between transportation wheels

(see machine operating instructions / transport box):

- Wire not aligned:
- Cutting slide jams: round knife too strongly leaning onto flat knife:
- Cutting seesaw blocked, compression spring in cutting block defective
- Lower wire pipe in cutting block deformed: slight move upward or downward
- Former not correctly adjusted:

siehe Kap. 1.8

siehe Kap. 1.12

siehe Kap. 1.11



Remedy in case of faults: loop stitching

You will find most faults and their cause in the previous section

Straight wire pieces falling out:

- Wire not aligned:
- Former not correctly adjusted:

siehe Kap. 1.8

siehe Kap. 1.11

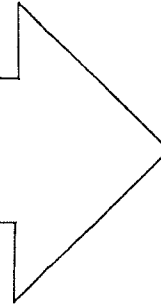


- Technische Änderungen vorbehalten -
- modifications reserved -
- changements réservés -

ERSATZTEILELISTE

SPARE PARTS LIST

LISTE DES PIECES DE RECHANGE



Wichtig: Bei Bestellung bitte angeben:
- Menge
- Art.-Nummer
- Maschinen-Nummer

Attention: In case of order please indicate:
- Quantity
- Art.-Number
- Machine-Number

Attention: En cas de commande veuillez s.v.p. indiquer:
- Quantité
- No. d'article
- No. de la machine

BITTE NUR ORIGINAL HOHNER ERSATZTEILE VERWENDEN

Bei Gebrauch von nicht Original hohner-Ersatzteilen erlischt der Garantieanspruch, sowohl die Verfügbarkeit und die Qualität leidet. Der Einsatz von Original hohner-Ersatzteilen garantiert ein einwandfreies Funktionieren.

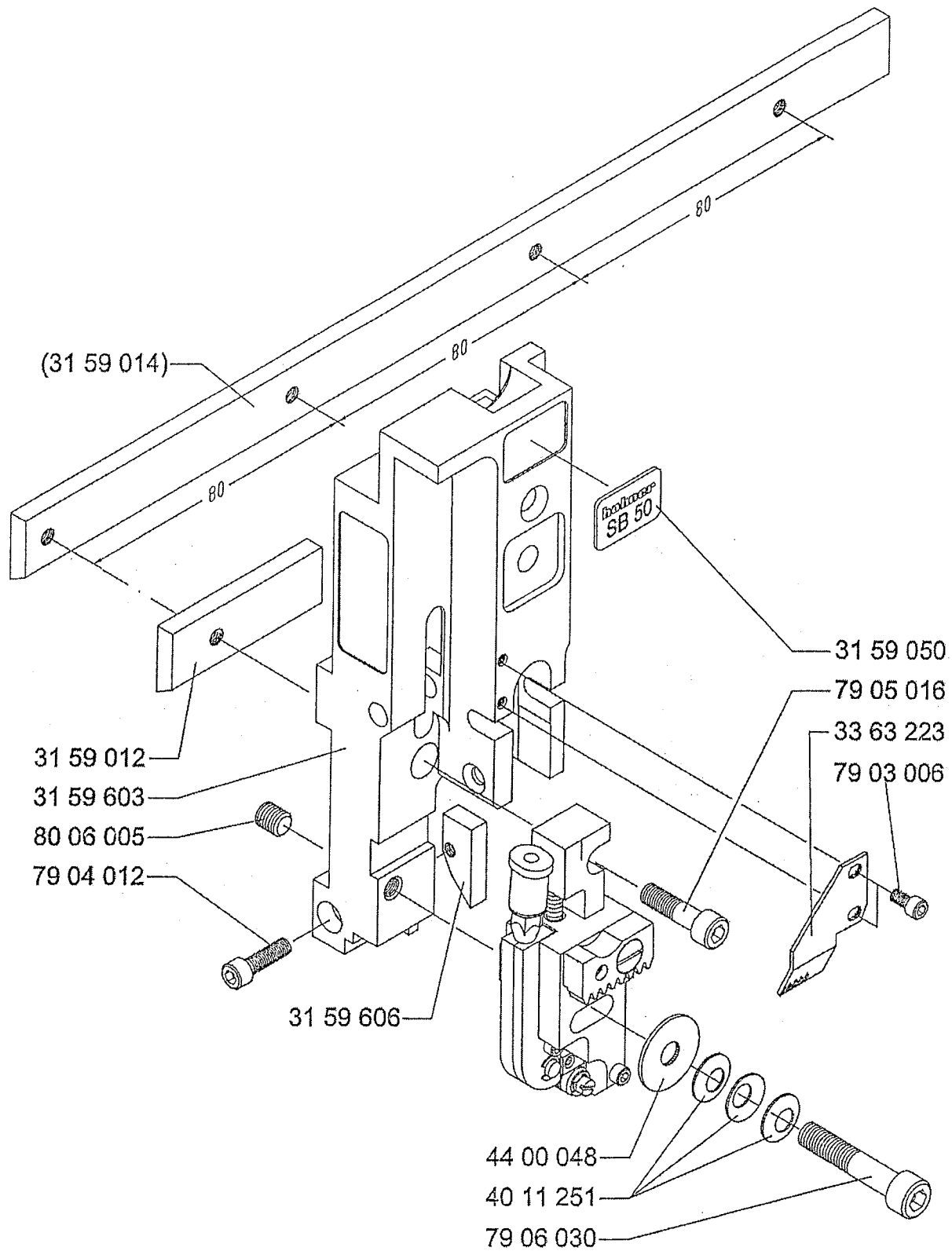
ALWAYS INSIST ON GENUINE HOHNER REPLACEMENT PARTS

Use of non-hohner replacement parts will unconditionally void our factory warranty and may deteriorate the products performance and reliability. Use of genuine hohner parts will insure performance according to specifications and extend the live of associated components.

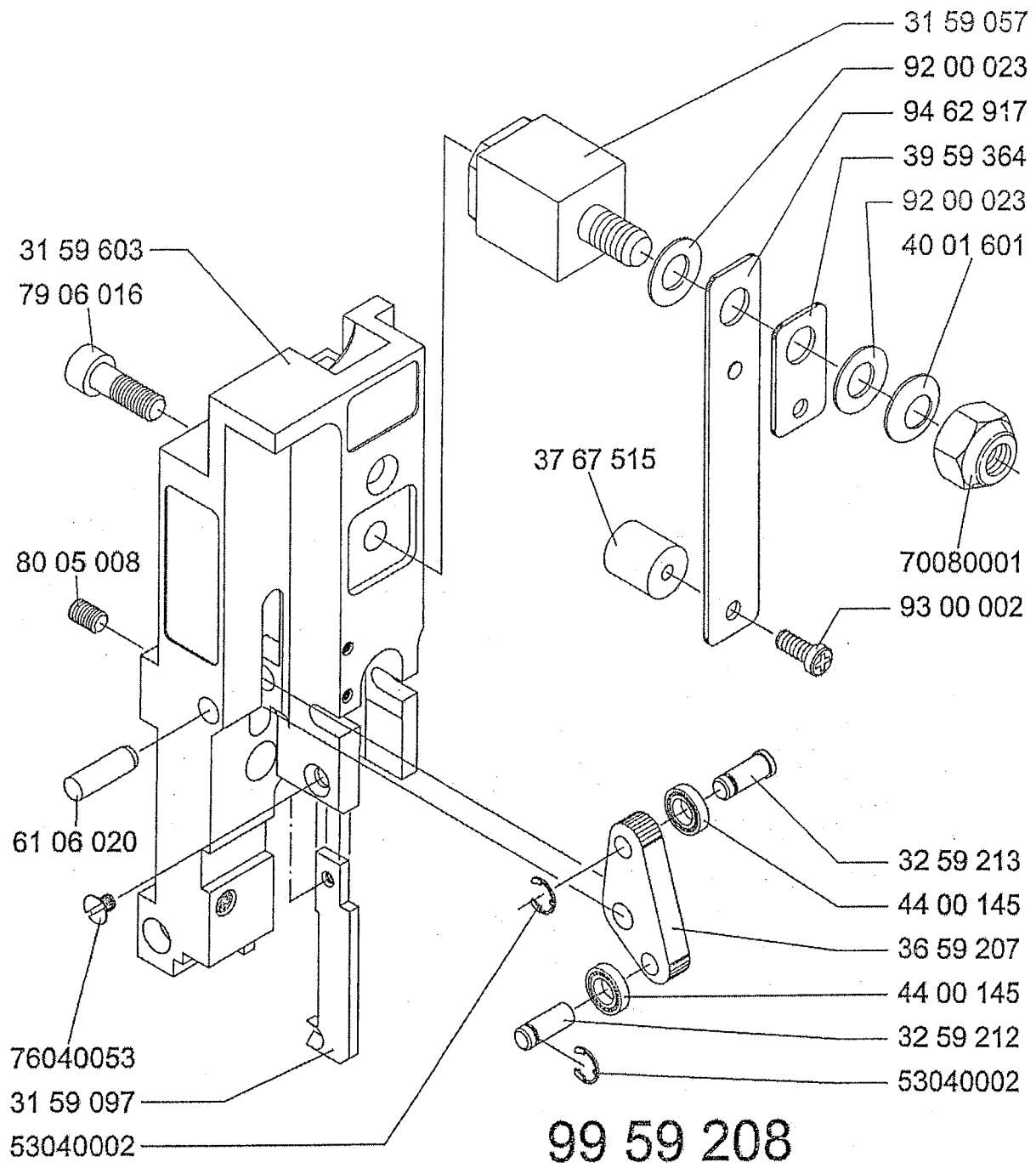
UTILISER UNIQUEMENT PIECES DE RECHANGE ORIGINAL-HOHNER

A l'usage des pièces de rechange qui ne sont pas de l'origine hohner la garantie s'éteint et la disponibilité et la qualité souffrent. Seulement l'utilisation des pièces de rechange hohner-original garantie un fonctionnement parfait.

Art.-No.	Bezeichnung	Description
31 59 012	Nutenstein	mounting block
31 59 014	Nutensteinleiste	mounting bracket
31 59 050	Typenschild SB-50	name plate SB-50
31 59 603	Gehäuse	housing
31 59 606	Schuhzungenkurve	shoe tongue curve
33 63 223	Schildhalter	etikett-holder
40 11 251	Tellerfeder	disc spring
44 00 048	Scheibe	washer
79 03 006	Inbusschraube	hexagon socket head cap screw
79 04 012	Inbusschraube	hexagon socket head cap screw
79 05 016	Inbusschraube	hexagon socket head cap screw
79 06 030	Inbusschraube	hexagon socket head cap screw
80 06 005	Gewindestift	hexagon socket set screw



Art.-No.	Bezeichnung	Description
31 59 057	Distanzbolzen	distance bolt
31 59 097	Führungslasche	guiding bracket
31 59 603	Gehäuse SB-50	housing
32 59 212	Rollenbolzen	roller bolt
32 59 213	Bundbolzen	collar bolt
36 59 207	Abschneiderwippe	cutting rocker
37 67 515	Druckbolzen	pressure bolt
39 59 364	Doppelfeder, kurz	leaf spring, short
40 01 601	Tellerfeder	disc spring
44 00 145	Kugellager	ball bearing
53 04 000 2	Sicherungsring	retaining ring for shafts
61 06 020	Zylinderstift	straight pin
70 08 000 1	Sechskantmutter	hexagon nut
76 04 005 3	Senkschraube	countersunk screw
79 06 016	Inbusschraube	hexagon socket head cap screw
80 05 008	Gewindestift	hexagon socket set screw
92 000 23	Scheibe	washer
93 00 002	Blechschrabe	cross recessed pan head tapping screw
94 62 917	Formerfeder	leaf spring, former
99 59 208	Abschneidewippe, kpl.	cutting rocker, cpl.

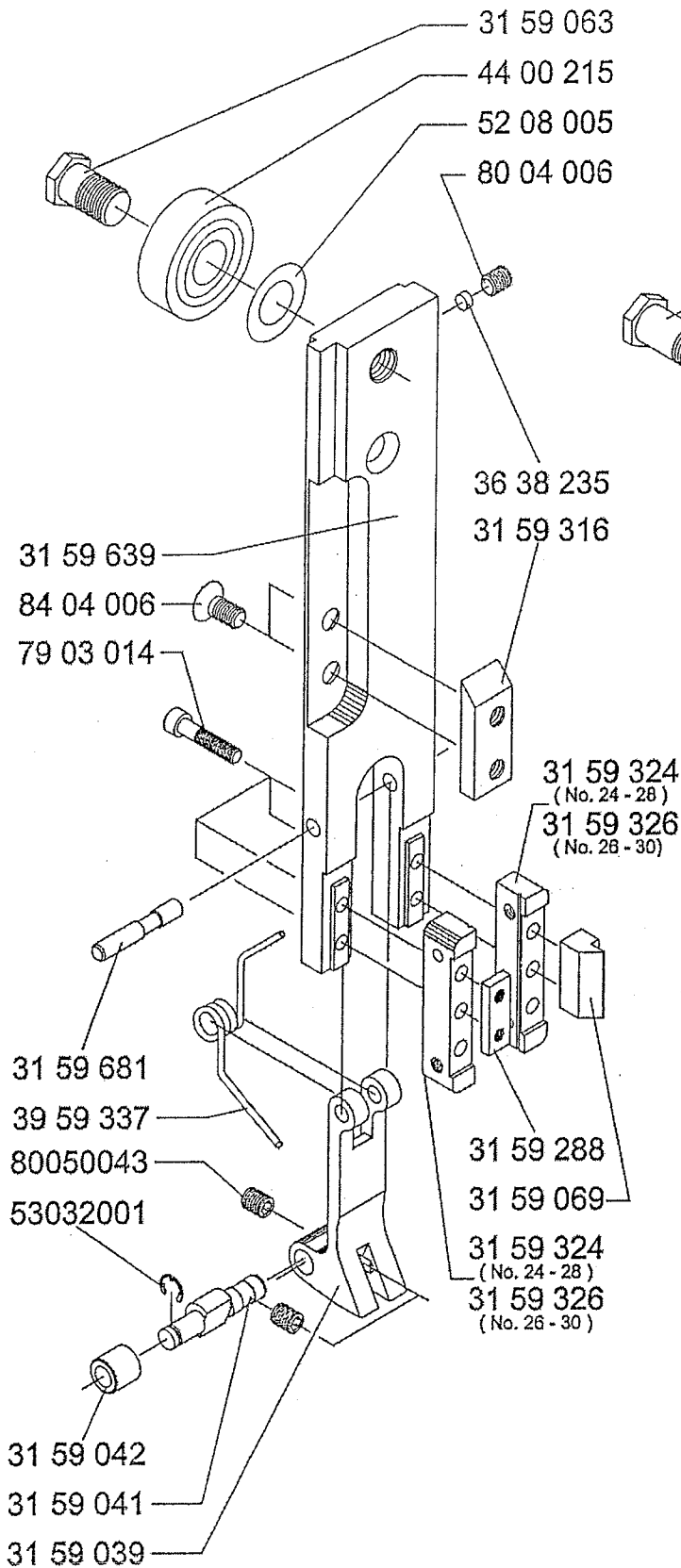


Art.-No.	Bezeichnung	Description
31 59 039	Schuhzunge	shoe tongue
31 59 041	Rollenbolzen	roller bolt
31 59 042	Kurvenrolle	curve roller
31 59 063	Schraube, kurz	screw, short
31 59 064	Treiber (24-28)	Driver (24-28)
31 59 068	Schraube, lang	screw, long
31 59 069	Drahtführung	wire guide
31 59 288	Klemmlasche	clamping bracket
31 59 316	Schaltrampe	actuating rampe
31 59 324	Umbieger (24-28)	bender (24-28)
31 59 326	Umbieger (26-30)	bender (26-30)
31 59 331	Gewindebolzen	threaded bolt
31 59 639	Hauptschieber	main slide bar
31 59 643	Mittelschieber	center slide bar
31 59 644	Treiberlasche	driver bracket
31 59 646	Treiber (26-30)	driver (26-30)
31 59 681	Schuhzungenachse	shoe tongue axle
36 38 235	Druckbolzen	pressure bolt
39 59 337	Drehfeder	torsion spring
44 00 215	Kugellager	ball bearing
52 08 002	Paßscheibe	shim ring
52 08 005	Paßscheibe	shim ring
53 03 200 1	Sicherungsscheibe	retaining washer for shafts
62 04 008	Spannstift	spring type straight pin
70 08 000 1	Sechskantmutter	hexagon nut
79 03 014	Inbusschraube	hexagon socket head cap screw
80 04 006	Gewindestift	hexagon socket set screw
80 05 004 3	Gewindestift	hexagon socket set screw
84 04 006	Senkschraube	countersunk screw
84 04 008 1	Senkschraube	countersunk screw
99 59 043	Hauptschieber (26 - 30)	main slide bar (26 - 30)
99 59 060	Hauptschieber (24 - 28)	main slide bar (24 - 28)
99 59 065	Mittelschieber (24 - 28)	center slide bar (24 - 28)
99 59 647	Mittelschieber (26 - 30)	center slide bar (26 - 30)

99 59 043 / 99 59 060

(No. 26 - 30)

(No. 24 - 28)

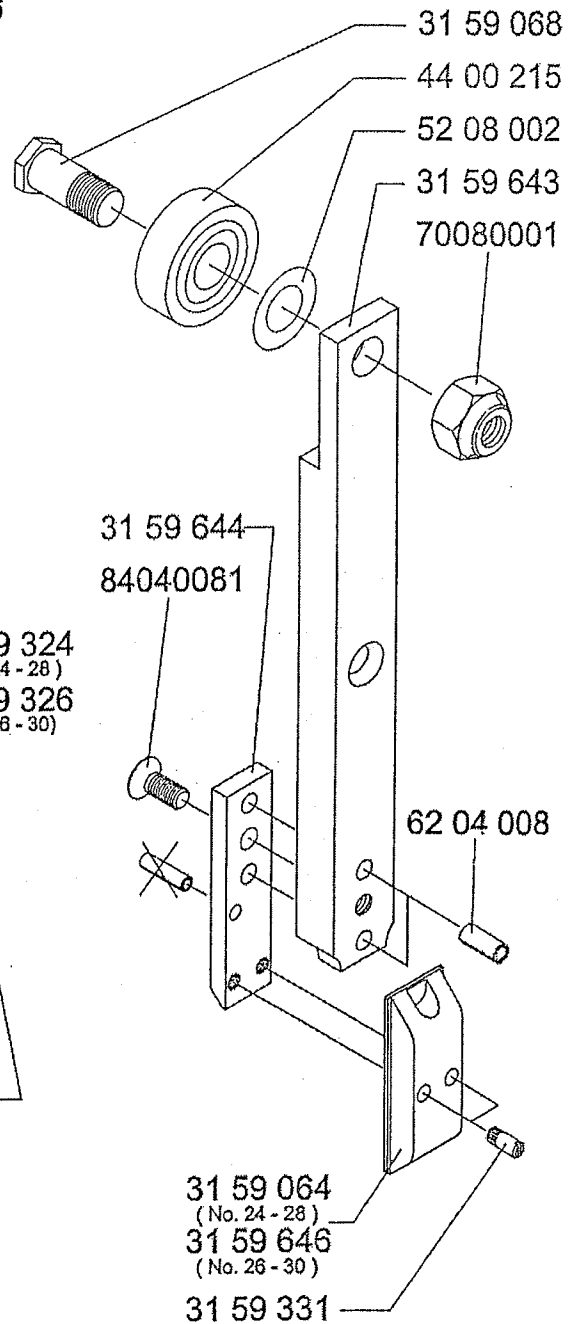


99 59 065

(No. 24 - 28)

99 59 647

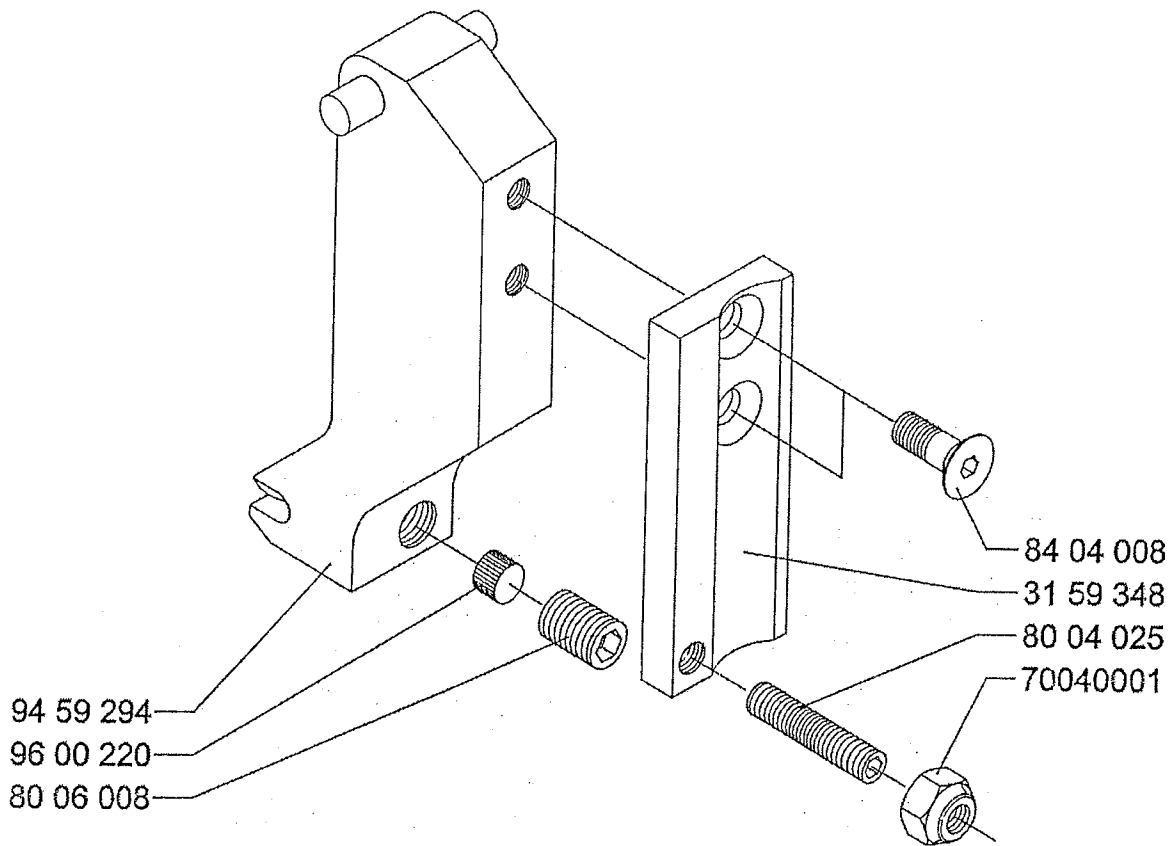
(No. 26 - 30)



Art.-No.	Bezeichnung	Description
31 59 348	Formerrücken	former back
70 04 000 1	Sechskantmutter	hexagon nut
80 04 025	Gewindestift	hexagon socket set screw
80 06 008	Gewindestift	hexagon socket set screw
84 04 008	Senkschraube	countersunk screw
94 59 294	Former	former
96 00 220	Scheibenmagnet	magnet
99 59 295	Former, komplett	former, complete

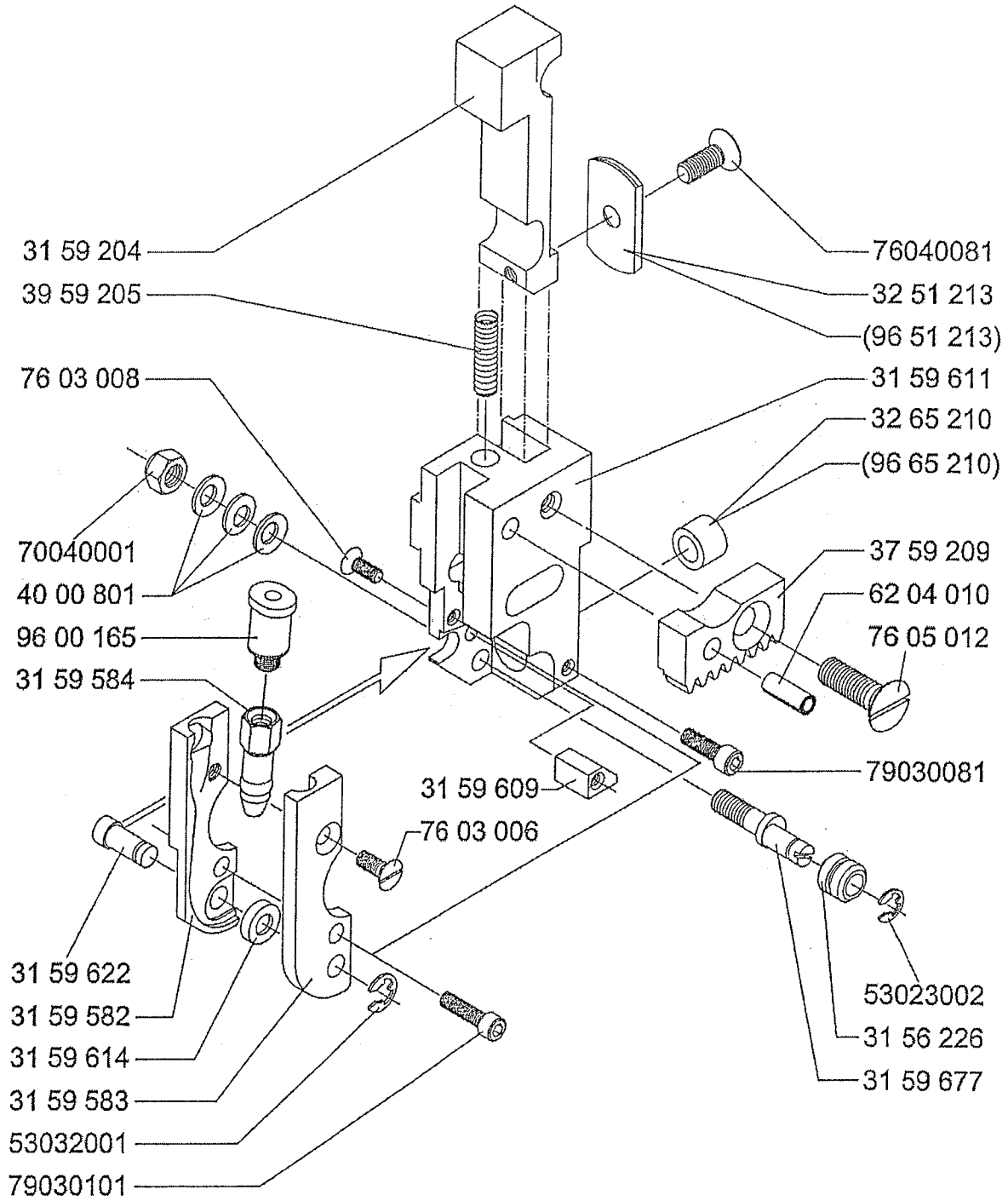
	Option	optional feature
31 59 348	Formerrücken	former back
31 59 363	Greifer	gripper
31 59 366	Greiferrampe	gripper ramp
32 51 415	Greiferachse	gripper axle
32 51 417	Greiferbolzen Ø 8	gripper bolt Ø 8
39 63 177	Zugfeder	extension spring
70 04 000 1	Sechskantmutter	hexagon nut
72 03 508	Zylinderschraube	slotted cheese head screw
75 03 008	Gewindestift	slotted set screw cone point
80 04 025	Gewindestift	hexagon socket set screw with flat point
84 04 020	Senkschraube	hexagon socket countersunk head screw
94 59 357	Former	former
99 59 360	Former, kpl. - Greiferausführung -	former, cpl. - with gripper -
99 59 367	Greiferausführung Satz kpl.	execution with gripper set cpl.

99 59 295



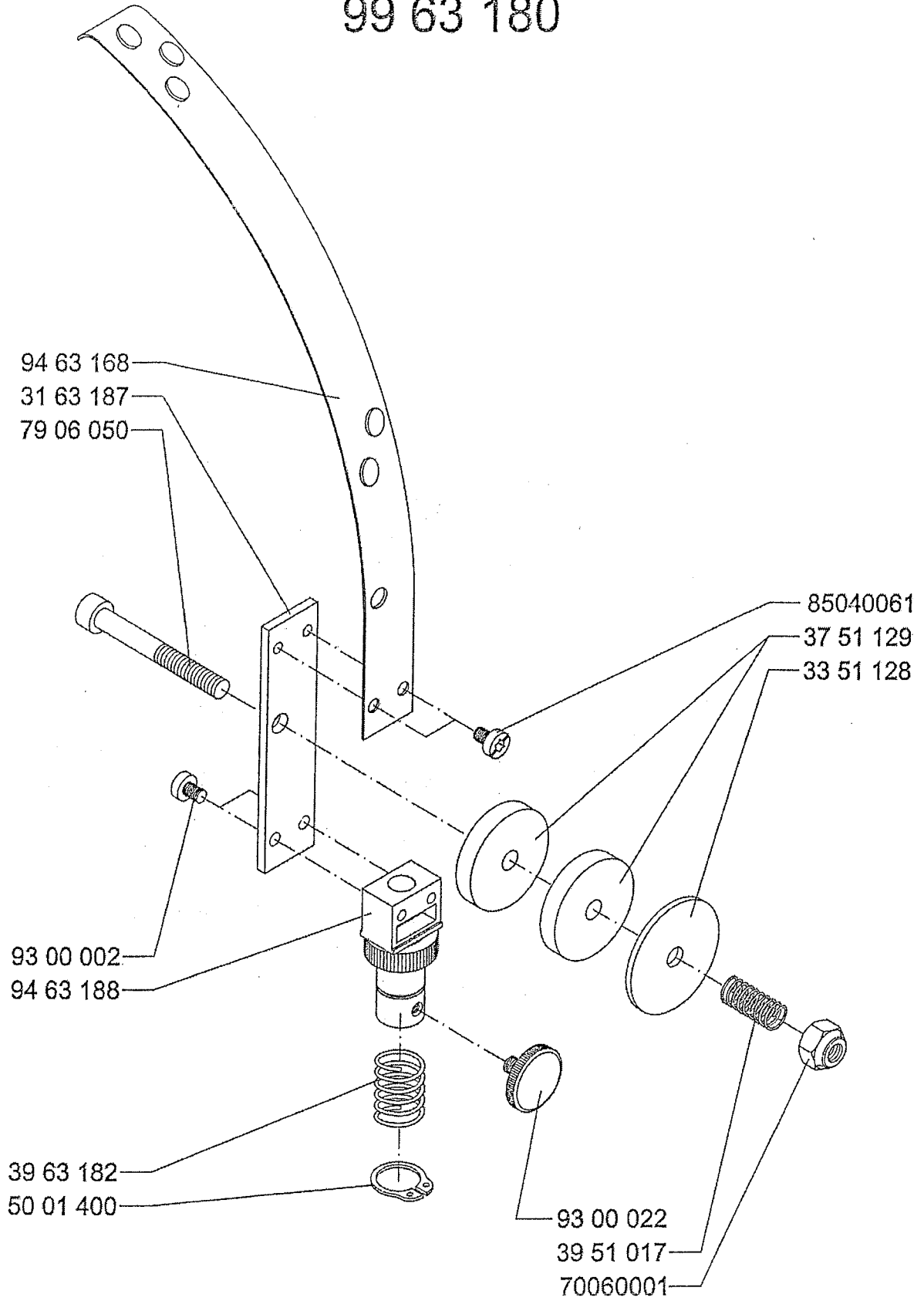
Art.-No.	Bezeichnung	Description
31 56 226	Justierrolle,fein	adjusting roll,fine
31 59 204	Abschneideschieber	cutting pusher
31 59 582	Unterplatte	lower plate
31 59 583	Oberplatte	upper plate
31 59 584	Anschlußstück	connecting piece
31 59 609	Anlaufstück	guide plate
31 59 611	Messerkasten	cutting box
31 59 614	Justier-Rolle	adjusting roll
31 59 622	Rollenachse	roll axle
31 59 677	Drahtrichtexzenter	wire adjusting eccentric
32 51 213	Schermesser	flat knife
32 65 210	Rundmesser	round knife
37 59 209	Zahnstange	tooth rack
39 59 205	Druckfeder	compression spring
40 00 801	Tellerfeder	disc spring
53 02 300 2	Sicherungsscheibe	retaining washer for shafts
53 03 200 1	Sicherungsscheibe	retaining washer for shafts
62 04 010	Spiralspannstift	spiral pin
70 04 000 1	Sechskantmutter	hexagon nut
76 03 006	Senkschraube	countersunk screw
76 03 008	Senkschraube	countersunk screw
76 04 008 1	Senkschraube	countersunk screw
76 05 012	Senkschraube	countersunk screw
79 03 008 1	Inbusschraube	hexagon socket head cap screw
79 03 010 1	Imbusschraube	hexagon socket head cap screw
96 00 165	Kupplung	clutch
96 51 213	Schermesser - Hartmetall	flat knife – hard metal
96 65 210	Rundmesser - Hartmetall	round knife – hard metal
99 59 610	Messerkasten,kpl.	cutting box cpl.

99 59 610



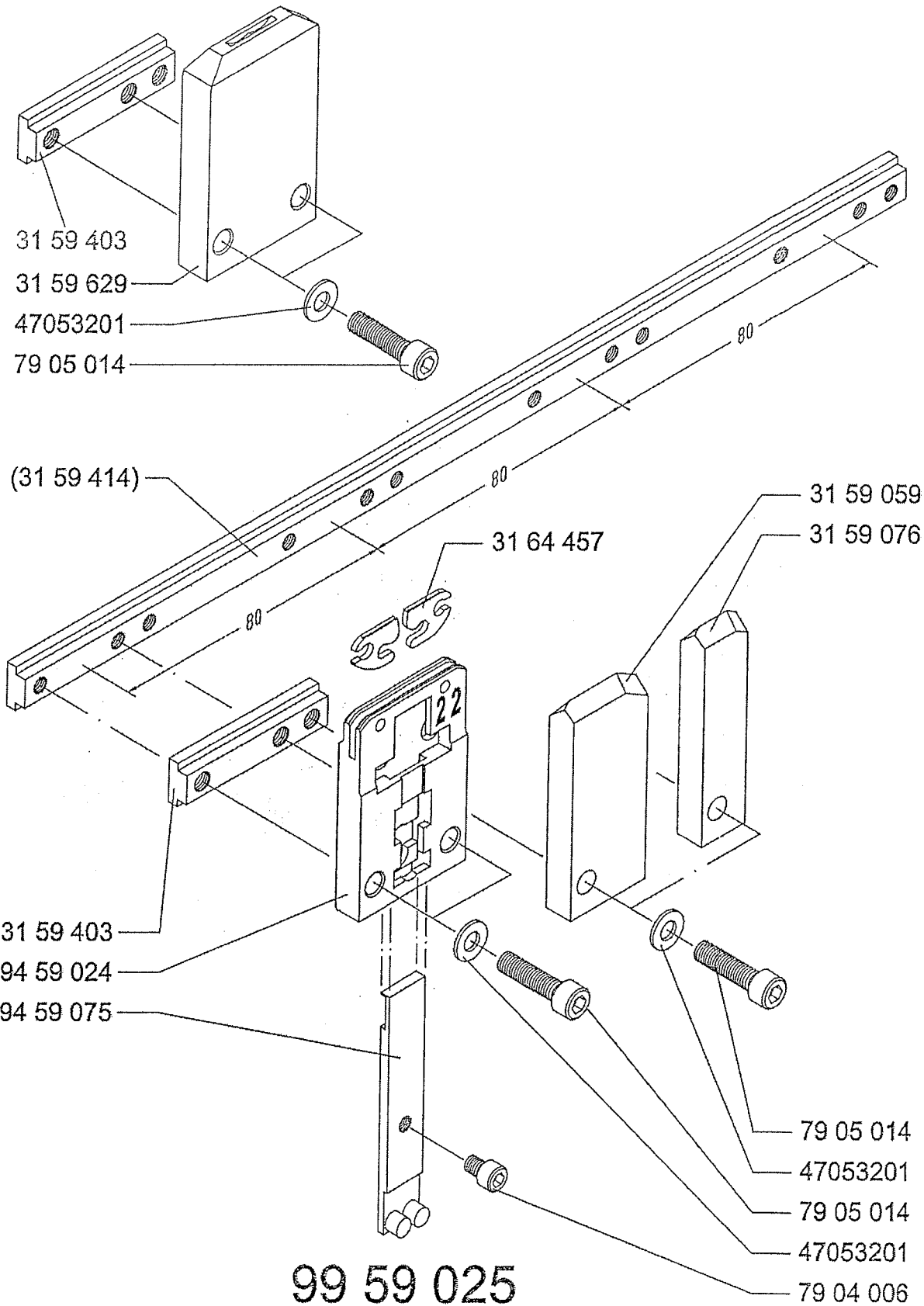
Art.-No.	Bezeichnung	Description
31 63 187	Zwischenlasche	intermediate bracket
33 51 128	Scheibe	washer
37 51 129	Filzscheibe	felt disc
39 51 017	Druckfeder	compression spring
39 63 182	Druckfeder	compression spring
50 01 400	Sicherungsring	retaining ring for shafts
70 06 0001	Sechskantmutter selbstsichernd	prevailing torque type hexagon nut
79 06 050	Inbusschraube	hexagon socket head cap screw
85 04 0061	Schraube selbstschneidend	tapping screw
93 00 002	Linsen-Blechschaube	cross recessed pan head tapping screw
93 00 022	Rändelschraube	knurled screw
94 63 168	Federbügel	spring bow
94 63 188	Bremskörper, komplett	brake buffer, cpl.
99 63 180	Drahtbügel, komplett	wire bow, cpl.

99 63 180



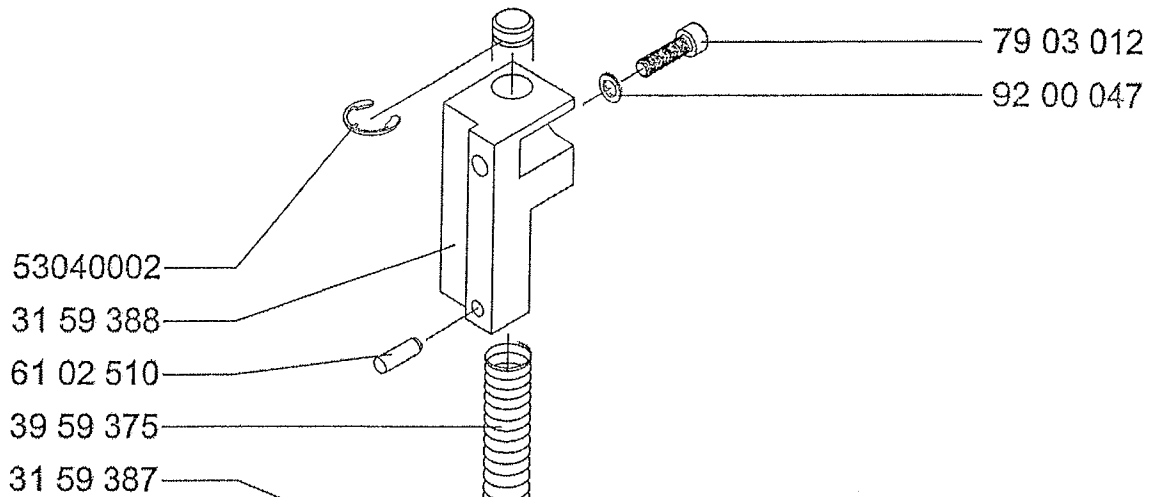
Art.-No.	Bezeichnung	Description
31 59 059	Reiter, breit	guiding cam, wide
31 59 076	Reiter, schmal	guiding cam, small
31 59 403	Nutenstein	mounting block
31 59 414	Klemmleiste	connector block
31 59 629	Pfannenblock	socket block
31 64 457	Klinscher -22-	clincher -22-
47 05 320 1	Scheibe	Washer
79 04 006	Inbusschraube	hexagon socket head cap screw
79 05 014	Inbusschraube	hexagon socket head cap screw
94 59 024	Klinscherkasten -22-	clincher box -22-
94 59 075	Klinscherstößel SB-50	clincher pusher
99 59 025	Klinscherkasten -22- kpl.	clincher box -22- cpl.
99 59 628	Pfanmnenumlage, kpl.	socket block, cpl.

99 59 628

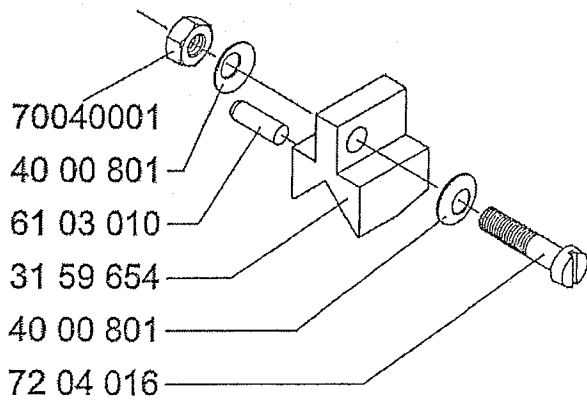
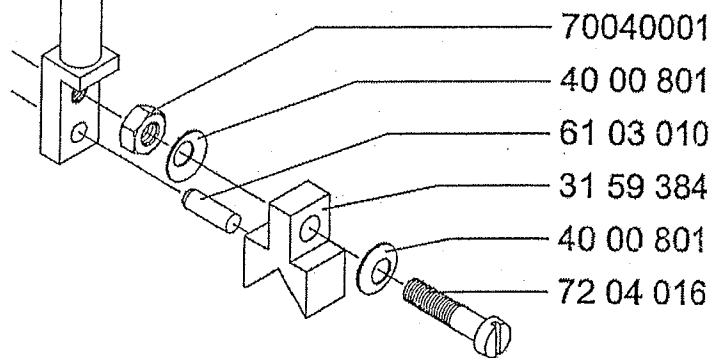


Art.-No.	Bezeichnung	Description
31 59 384	Zentrierbacken, schmal	centering cheeks, small
31 59 387	Führungsstift	guiding pin
31 59 388	Lagerbock	pedestal
31 59 654	Zentrierstück, breit	centering piece, wide
39 59 375	Druckfeder	compression spring
40 00 801	Tellerfeder	disc spring
53 04 000 2	Sicherungsscheibe	retaining washer for shafts
61 02 510	Zylinderstift	parallel pin
61 03 010	Zylinderstift	parallel pin
70 04 000 1	Sechskantmutter, selbstsichernd	prevailing torque type hexagon nut
72 04 016	Zylinderschraube m.Schlitz	slotted cheese head screw
79 03 012	Inbusschraube	hexagon socket head cap screw
92 00 047	Sicherungsscheibe S3	retaining washer S3
99 59 077	Niederhaltersatz SB-50	centering device, cpl.
99 59 384	Zentrierstück, schmal kpl.	centering piece, small cpl.
99 59 389	Zentrierstück, breit kpl.	centering piece, wide, cpl.

99 59 077

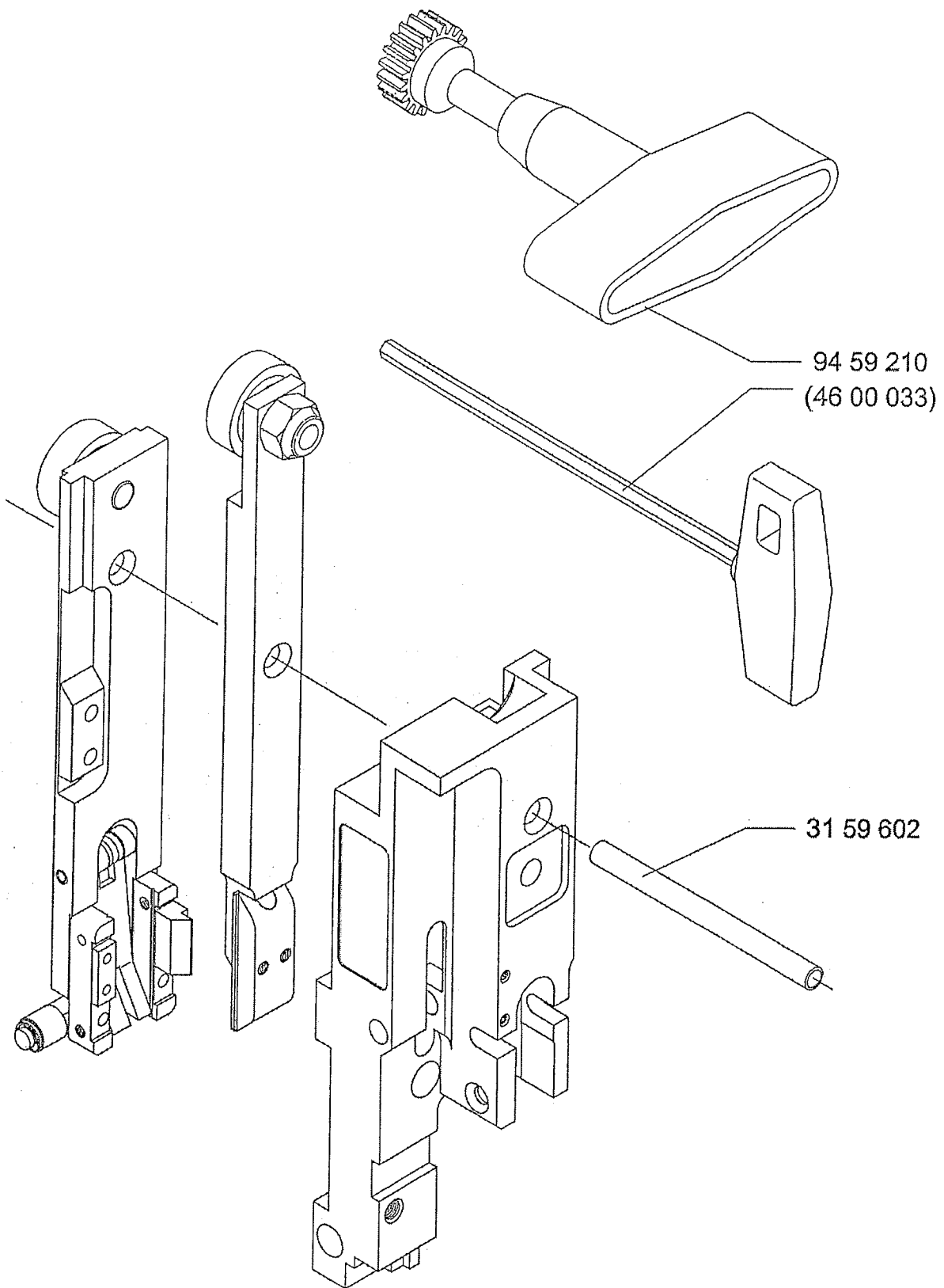


99 59 384



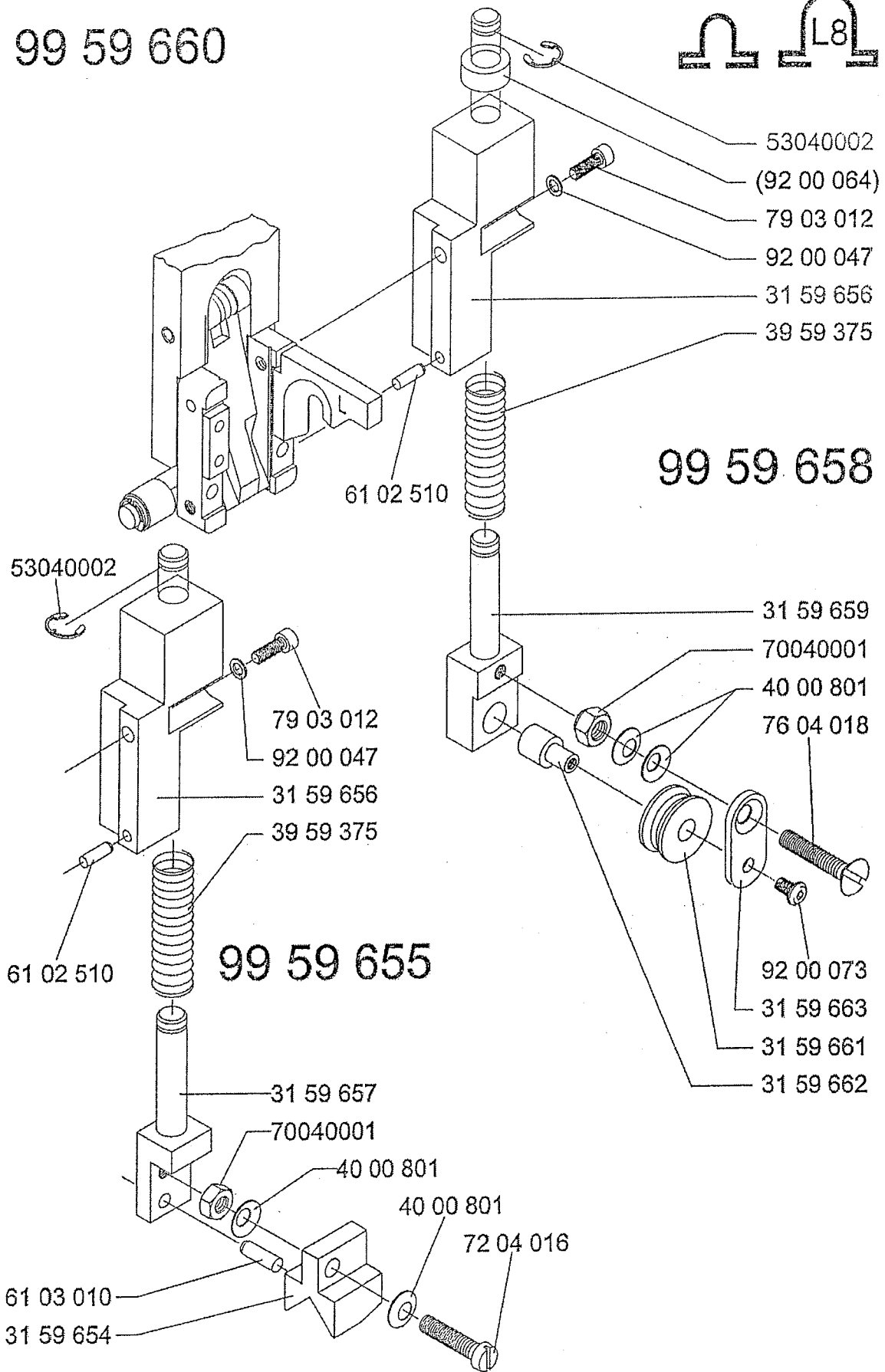
99 59 389

Art.-No.	Bezeichnung	Description
31 59 602	Fixierstück	fixing tool
46 00 033	Inbusschlüssel T-Griff	allen-type wrench
94 59 210	Verstellgriff	adjusting handle



Art.-No.	Bezeichnung	Description
31 59 654	Zentrierstück,breit	centering piece,wide
31 59 656	Lagerklotz	pedestal
31 59 657	Druckstift	compression pin
31 59 659	Führungsstift	guiding pin
31 59 661	Rolle	roll
31 59 662	Rollenstift	roll pin
31 59 663	Frontlasche	bracket
39 59 375	Druckfeder	compression spring
40 00 801	Tellerfeder	disc spring
53 04 000 2	Sicherungsscheibe	retaining washer
61 02 510	Zylinderstift	parallel pin
61 03 010	Zylinderstift	parallel pin
70 04 000 1	Sechskantmutter, selbstsichernd	prevailing torque type hexagon nut
76 04 018	Senkschraube	countersunk screw
79 03 012	Inbusschraube	hexagon socket head cap screw
92 00 047	Sicherungsscheibe S3	retaining washer S3
92 00 064	Distanzhülse	distance sleeve
92 00 073	Linsenkopfschraube	button head socket screw
99 59 655	Falzdrücker,breit kpl.	centering pusher,wide cpl.
99 59 658	Zentrierrolle, kpl.	centering roll,cpl.
99 59 660	Falzdrücker-Satz kpl.	centering pusher-set cpl.

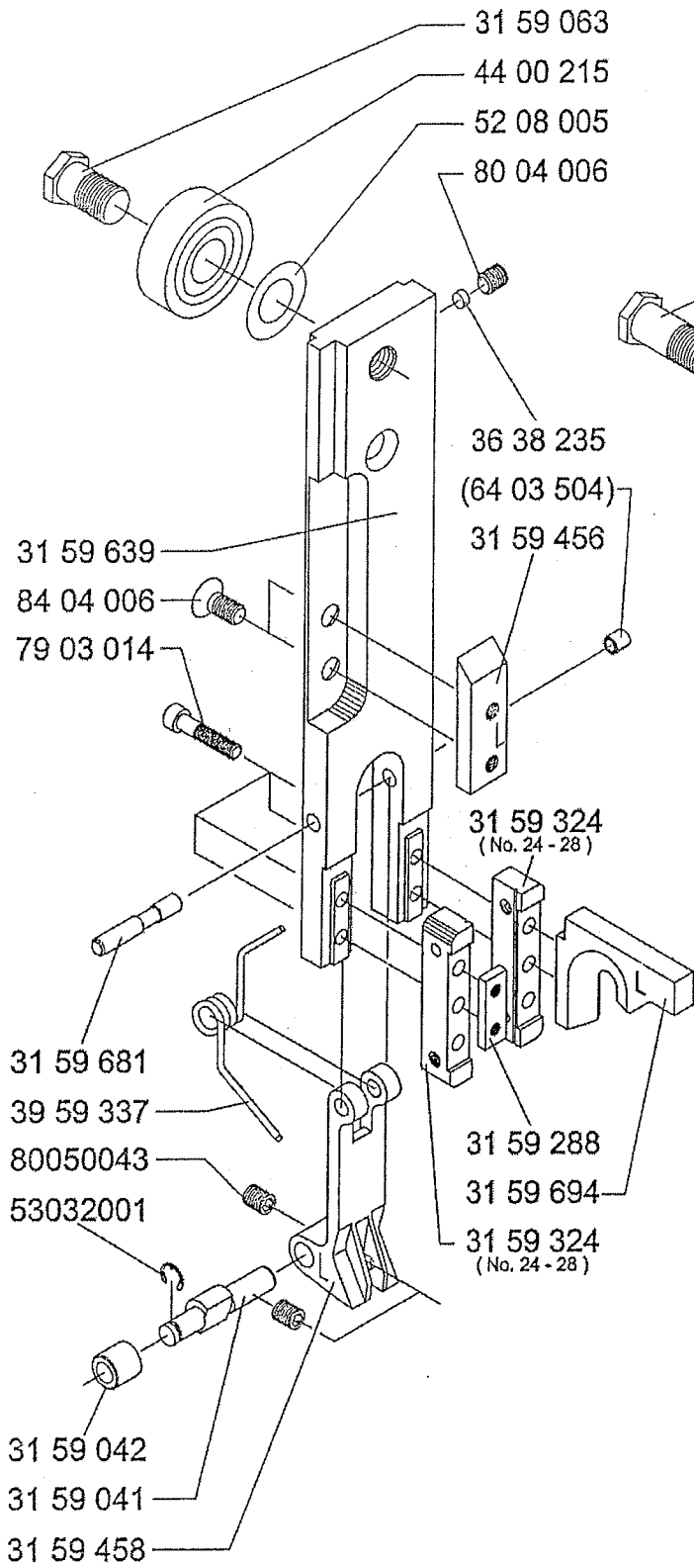
99 59 660



Art.-No.	Bezeichnung	Description
31 59 041	Rollenbolzen	roll bolt
31 59 042	Kurvenrolle	curve roller
31 59 063	Schraube, kurz	screw, short
31 59 068	Schraube, lang	screw, long
31 59 084	Treiber – Ringösen	driver – loop-stitching
31 59 288	Klemmlasche	clamping bracket
31 59 324	Umbieger (Nr 24-28)	bender (Nr 24-28)
31 59 331	Gewindebolzen	threaded bolt
31 59 456	Abschneiderampe - Ringösen -	cutting ramp - loop stitching -
31 59 458	Schuhzunge - Ringösen -	shoe tongue - loop-stitching -
31 59 639	Hauptschieber	main slide bar
31 59 643	Mittelschieber	center slide bar
31 59 644	Treiberlasche	driver bracket
31 59 681	Schuhzungenachse	shoe tongue axle
31 59 694	Greiferrampe - Ringösen -	gripper ramp - loop stitching -
36 38 235	Druckbolzen	pressure bolt
39 59 337	Drehfeder	torsion spring
44 00 215	Kugellager	ball bearing
52 08 002	Paßscheibe	shim ring
52 08 005	Paßscheibe	shim ring
53 03 200 1	Sicherungsscheibe	retaining washer for shafts
62 03 010	Spannstift	spring type straight pin
62 04 008	Spannstift	spring type straight pin
64 03 504	Spannstift	spring type straight pin
70 08 000 1	Sechskantmutter	hexagon nut
79 03 014	Inbusschraube	hexagon socket head cap screw
80 04 006	Gewindestift	hexagon socket set screw
80 05 004 3	Gewindestift	hexagon socket set screw
84 04 006	Senkschraube	countersunk screw
84 04 008 1	Senkschraube	countersunk screw
99 59 061	Hauptschieber - Ringösen kpl.	main slide bar loop-stitching cpl.
99 59 066	Mittelschieber - Ringösen kpl.	center slide bar loop-stitching cpl.

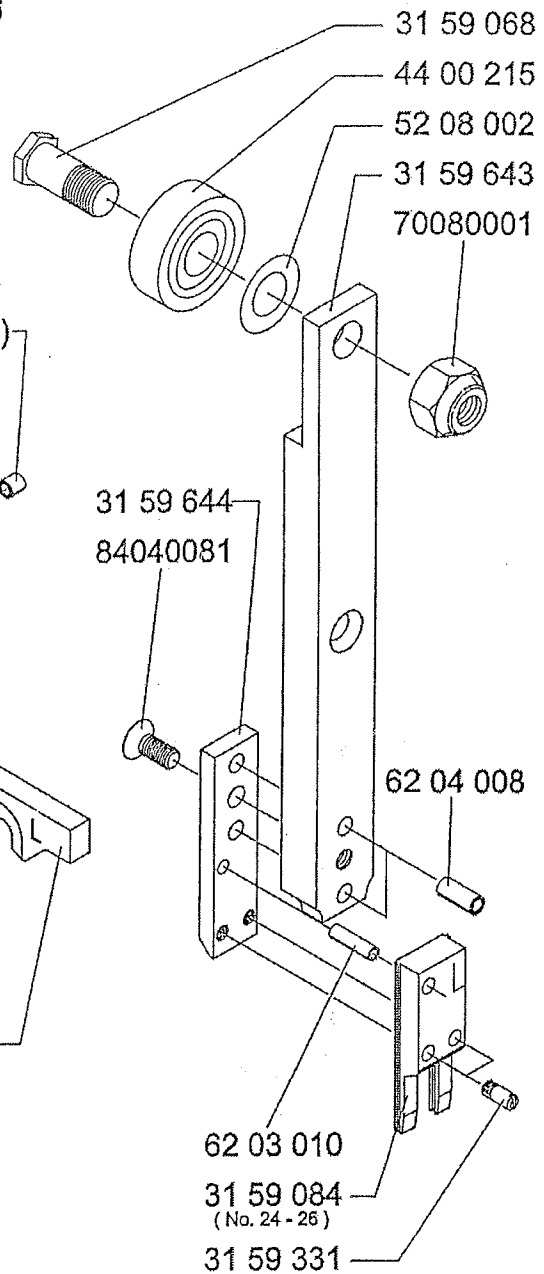
99 59 061

(No. 24 - 26)



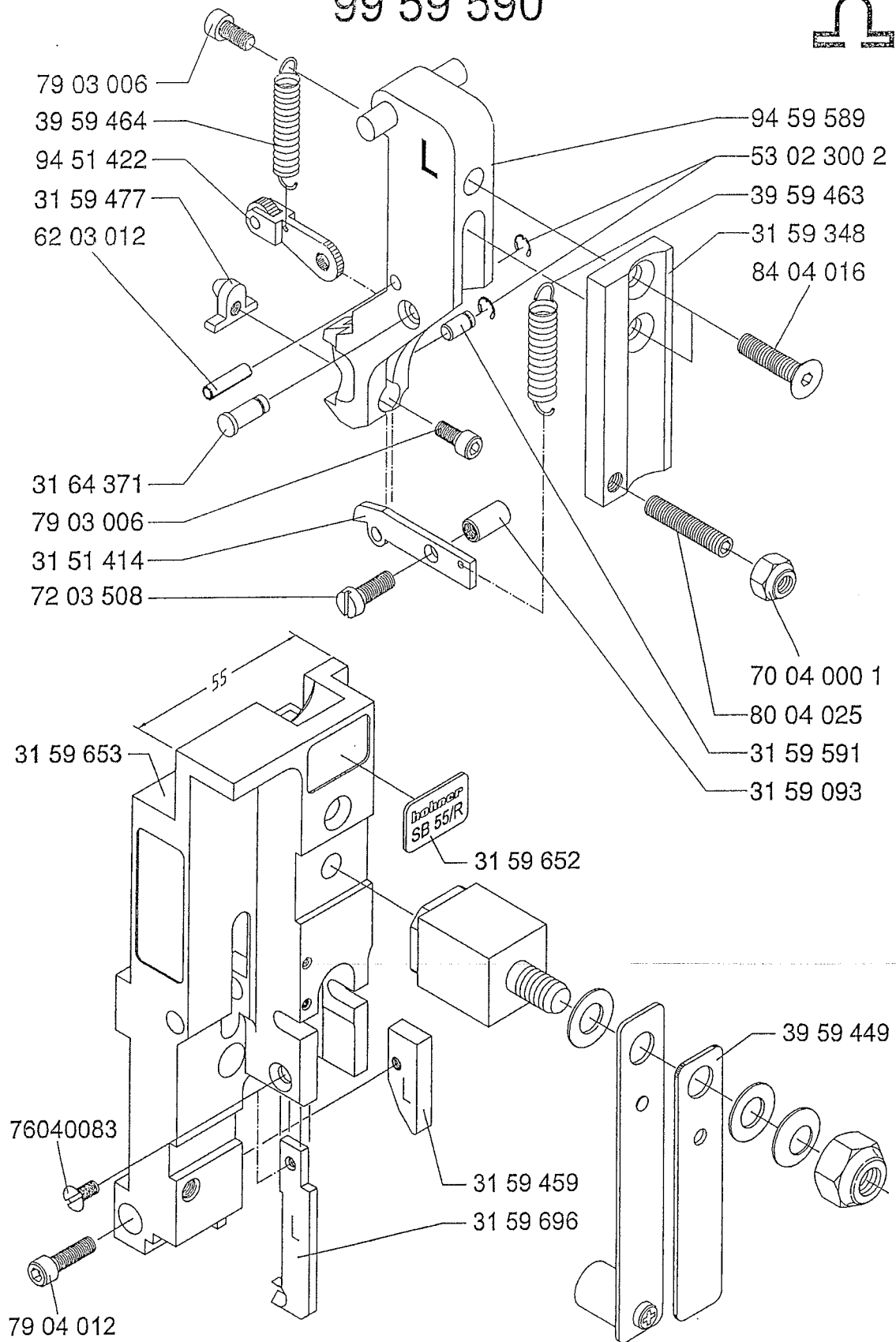
99 59 066

(No. 24 - 26)



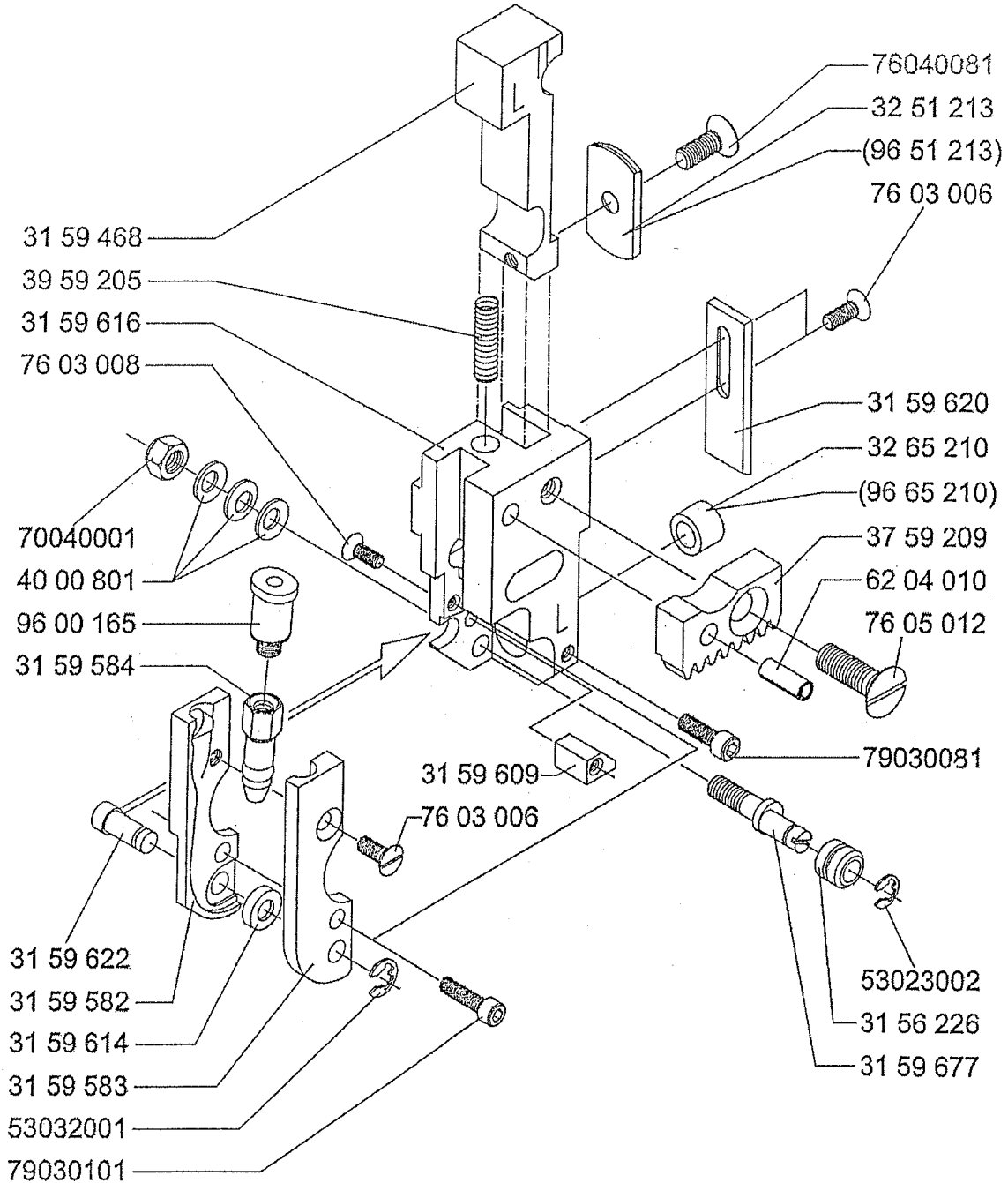
Art.-No.	Bezeichnung	Description
31 51 414	Greifer	gripper
31 59 093	Schaltrolle	actuating roller
31 59 348	Formerrücken	former back
31 59 459	Schuhzungenkurve - Ringösen -	shoe tongue curve - loop-stitching -
31 59 477	Formernase	former nose
31 59 591	Greiferachse	gripper axle
31 59 652	Typenschild SB 55/R	name plate SB 55/R
31 59 653	Gehäuse Ringösenheftung	housing - loop-stitching -
31 59 696	Führungslasche	guiding bracket
31 64 371	Greiferachse	gripper axle
39 59 449	Doppelfeder, lang	leaf spring , long
39 59 463	Zugfeder	extension spring
39 59 464	Zugfeder	extension spring
53 02 300 2	Sicherungsscheibe	retaining washer for shafts
62 03 012	Spiralspannstift	spiral pin
70 04 000 1	Sechskantmutter	hexagon nut
72 03 508	Zylinderschraube mit Schlitz	slotted cheese head screw head screw
76 04 008 3	Senkschraube	countersunk screw
79 03 006	Inbusschraube	hexagon socket head cap screw
79 04 012	Inbusschraube	hexagon socket head cap screw
80 04 025	Gewindestift	hexagon socket set screw screw with flat point
84 04 016	Senkschraube mit Innensechskant	hexagon socket counter- sunk head screw
94 51 422	Rollenhebel	roller lever
94 59 589	Former - Ringösen -	former - loop-stitching -
99 59 590	Former, kpl. - Ringösen -	former cpl. - loop-stitching -

99 59 590



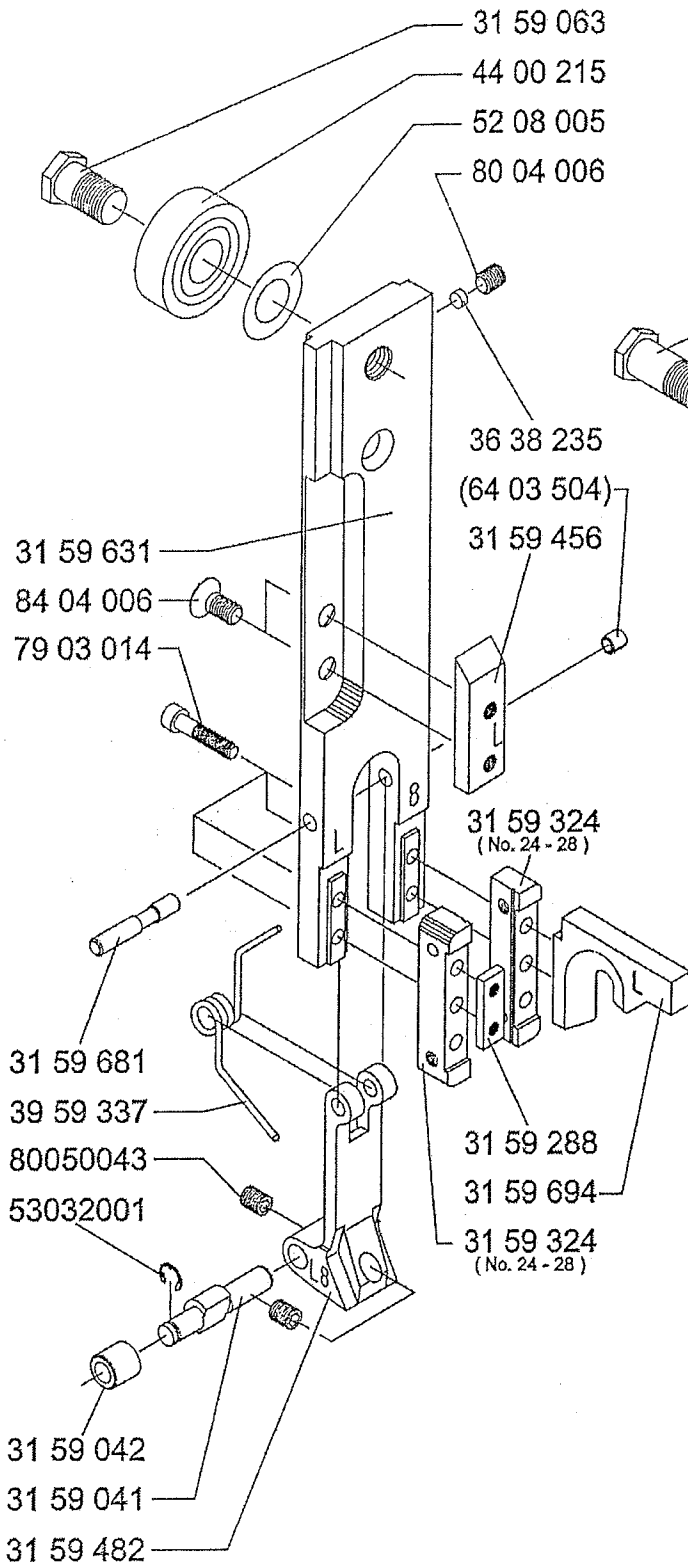
Art.-No.	Bezeichnung	Description
31 56 226	Justierrolle,fein	adjusting roll,fine
31 59 468	Abschneideschieber - Ringösen -	cutting pusher - loop stitching -
31 59 582	Unterplatte	lower plate
31 59 583	Oberplatte	upper plate
31 59 584	Anschlußstück	connecting piece
31 59 609	Anlaufstück	guide plate
31 59 614	Justier-Rolle	adjusting roll
31 59 616	Messerkasten, - Ringösen -	cutting box, - loop stitching -
31 59 620	Anlauf-Lasche	guiding bracket
31 59 622	Rollenachse	roll axle
31 59 677	Drahtrichtexzenter	wire adjusting eccentric
32 51 213	Schermesser	flat knife
32 65 210	Rundmesser	round knife
37 59 209	Zahnstange	tooth rack
39 59 205	Druckfeder	compression spring
40 00 801	Tellerfeder	disc spring
53 02 300 2	Sicherungsscheibe	retaining washer for shafts
53 03 200 1	Sicherungsscheibe	retaining washer for shafts
62 04 010	Spiralspannstift	spiral pin
70 04 000 1	Sechskantmutter	hexagon nut
76 03 006	Senkschraube	countersunk screw
76 03 008	Senkschraube	countersunk screw
76 04 008 1	Senkschraube	countersunk screw
76 05 012	Senkschraube	countersunk screw
79 03 008 1	Imbusschraube	hexagon socket head cap screw
79 03 010 1	Imbusschraube	hexagon socket head cap screw
96 00 165	Kupplung	clutch
96 51 213	Schermesser - Hartmetall	flat knife – hard metal
96 65 210	Rundmesser - Hartmetall	round knife – hard metal
99 59 615	Messerkasten, - Ringösen,kpl. -	cutting box, - loop stitching,cpl. -

99 59 615

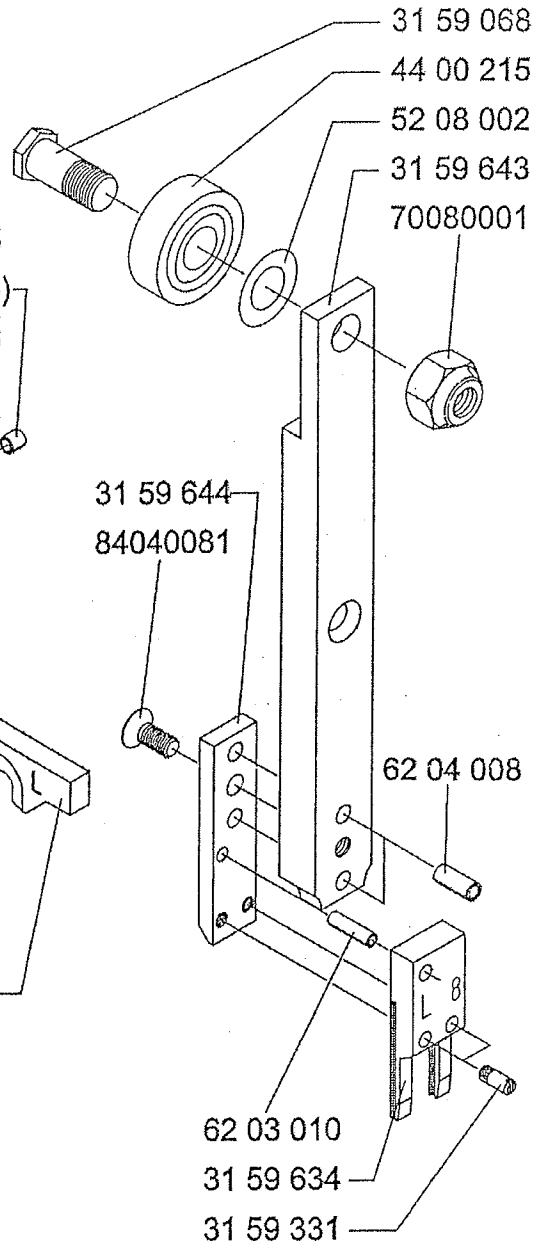


Art.-No.	Bezeichnung	Description
31 59 041	Rollenbolzen	roll bolt
31 59 042	Kurvenrolle	curve roller
31 59 063	Schraube, kurz	screw, short
31 59 068	Schraube, lang	screw, long
31 59 288	Klemmlasche	clamping bracket
31 59 324	Umbieger (Nr 24-28)	bender (Nr 24-28)
31 59 331	Gewindebolzen	threaded bolt
31 59 456	Abschneiderampe - Ringösen -	cutting ramp - loop stitching -
31 59 482	Schuhzunge - Ringösen - L8 -	shoe tongue - loop-stitching - L8 -
31 59 631	Hauptschieber - L8 -	main slide bar - L8 -
31 59 634	Treiber - L8 -	driver - L8 -
31 59 643	Mittelschieber	center slide bar
31 59 644	Treiberlasche	driver bracket
31 59 681	Schuhzungenachse	shoe tongue axle
31 59 694	Greiferrampe - Ringösen -	gripper ramp - loop stitching -
36 38 235	Druckbolzen	pressure bolt
39 59 337	Drehfeder	torsion spring
44 00 215	Kugellager	ball bearing
52 08 002	Paßscheibe	shim ring
52 08 005	Paßscheibe	shim ring
53 03 200 1	Sicherungsscheibe	retaining washer for shafts
62 03 010	Spannstift	spring type straight pin
62 04 008	Spannstift	spring type straight pin
64 03 504	Spannstift	spring type straight pin
70 08 000 1	Sechskantmutter	hexagon nut
79 03 014	Inbusschraube	hexagon socket head cap screw
80 04 006	Gewindestift	hexagon socket set screw
80 05 004 3	Gewindestift	hexagon socket set screw
84 04 006	Senkschraube	countersunk screw
84 04 008 1	Senkschraube	countersunk screw
99 59 630	Hauptschieber -L8 -,kpl. - Ringösen -	main slide bar - L8 -,cpl. - loop-stitching -
99 59 633	Mittelschieber - L8 -,kpl. - Ringösen -	center slide bar - L8 -,cpl. - loop-stitching -

99 59 630



99 59 633



Art.-No.	Bezeichnung	Description
31 51 414	Greifer	gripper
31 59 093	Schaltrolle	actuating roller
31 59 348	Formerrücken	former back
31 59 459	Schuhzungenkurve - Ringösen -	shoe tongue curve - loop-stitching -
31 59 488	Formernase - L8 -	former nose - L8 -
31 59 591	Greiferachse	gripper axle
31 59 652	Typenschild SB 55/R	name plate SB 55/R
31 59 653	Gehäuse Ringösenheftung	housing - loop-stitching -
31 59 696	Führungslasche	guiding bracket
31 64 371	Achse	axle
39 59 449	Doppelfeder, lang	leaf spring, long
39 59 463	Zugfeder	extension spring
39 59 464	Zugfeder	extension spring
62 03 012	Spiralspannstift	spiral pin
53 02 300 2	Sicherungsscheibe	retaining washer for shafts
70 04 000 1	Sechskantmutter	hexagon nut
72 03 508	Zylinderschraube mit Schlitz	slotted cheese head screw head screw
76 04 008 3	Senkschraube	countersunk screw
79 03 006	Inbusschraube	hexagon socket head cap screw
79 04 012	Inbusschraube	hexagon socket head cap screw
80 04 025	Gewindestift	hexagon socket set screw screw with flat point
84 04 016	Senkschraube mit Innensechskant	hexagon socket counter- sunk head screw
94 51 422	Rollenhebel	roller lever
94 59 594	Former - L8 - - Ringösen -	former - L8 - - loop-stitching -
99 59 595	Former - L8 -, kpl. - Ringösen -	former - L8 - cpl. - loop-stitching -