

DELUXE STITCHER

C O M P A N Y I N C .

Head Serial Number : _____

Date Purchased : _____

Where Installed: _____
(make/model of machine)

G5 Stitcher Head

OPERATION AND MAINTENANCE MANUAL

Wire Size: 25 Ga. Round (0.52 mm)
Crown Sizes: 1/2" (12mm) and 13/64" (5 mm) Loop
Capacity: 2 sheets to 13/64" (5 mm)

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

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

Specifications

Weight

Shipping Weight 7.4 lbs (3.4 kg)

Physical Dimensions

Height 10-3/4" (26.3 cm)

Width 2" (5.1 cm)

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

Wire Type 25 round (0.52 mm max)

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

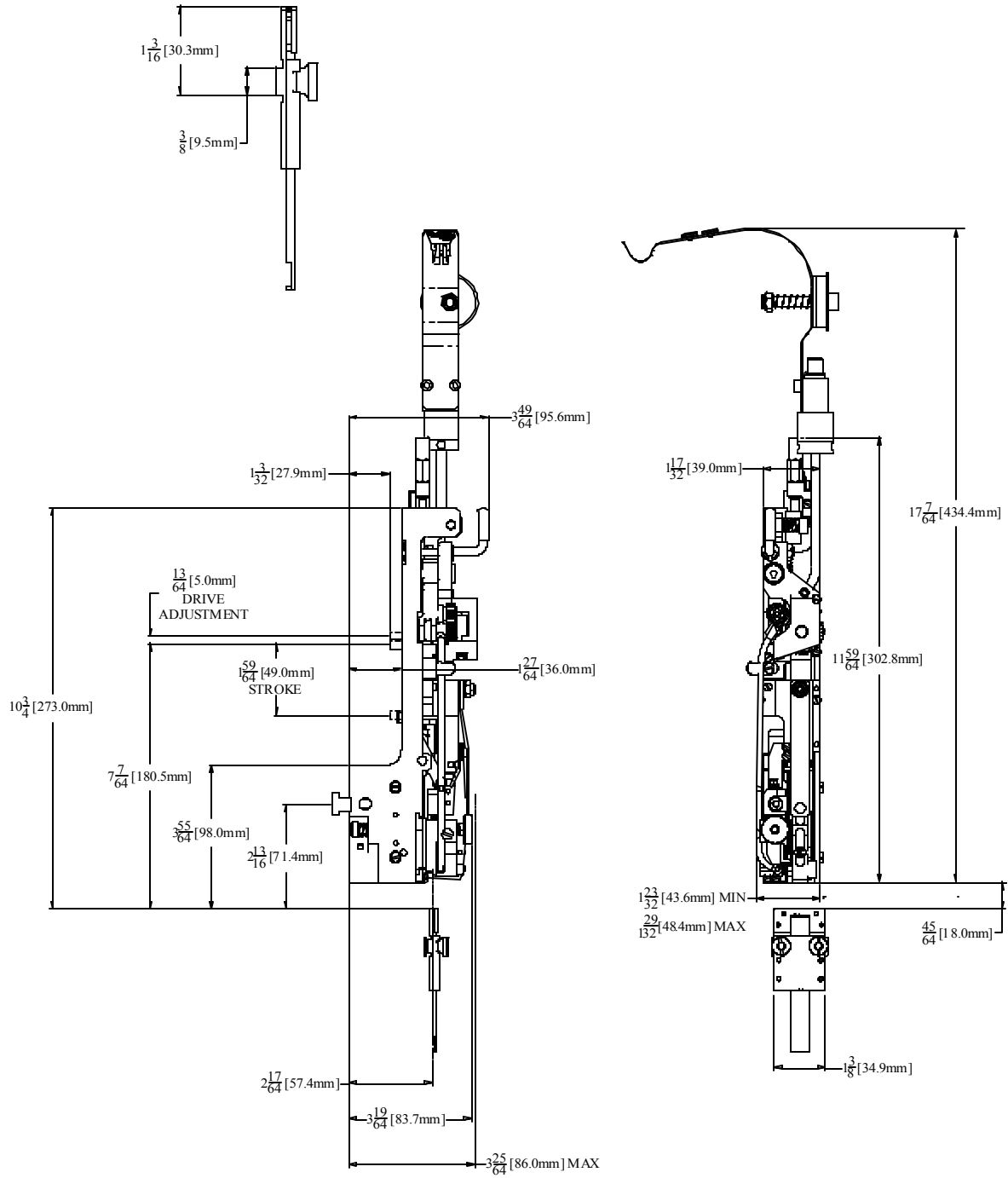
Minimum Head Center

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

Stitches Per Hour 10,000

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

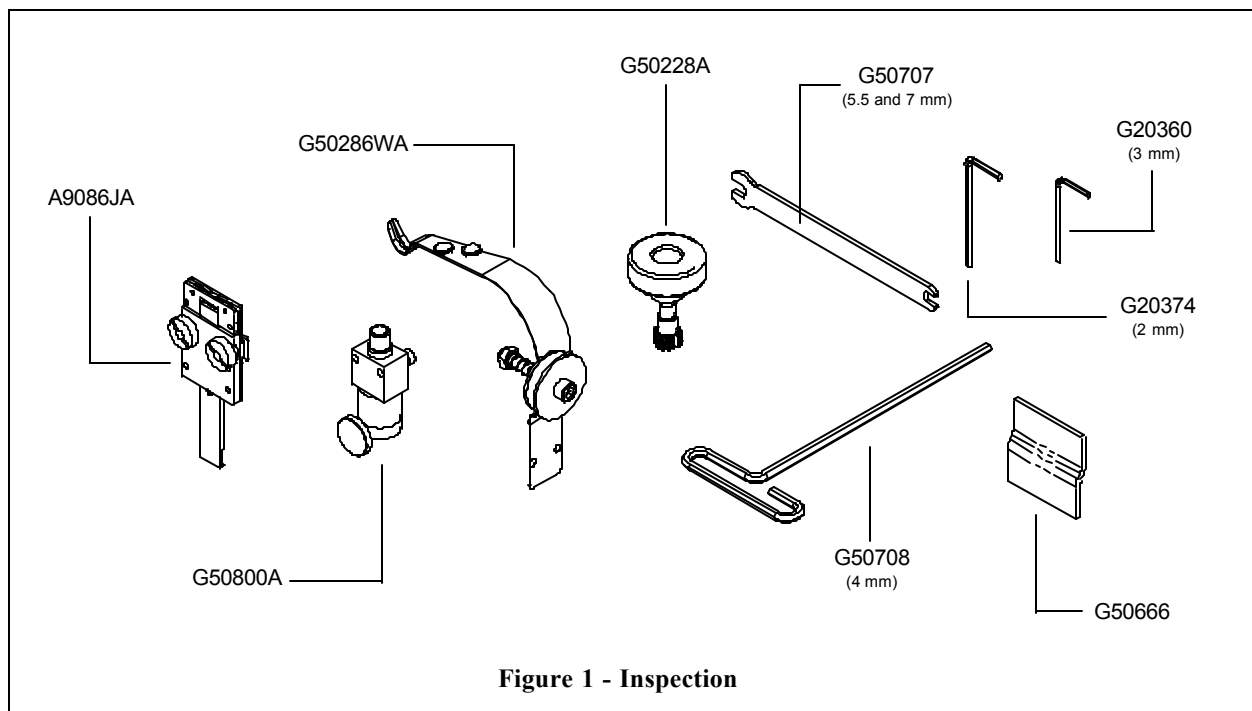
Dimensions



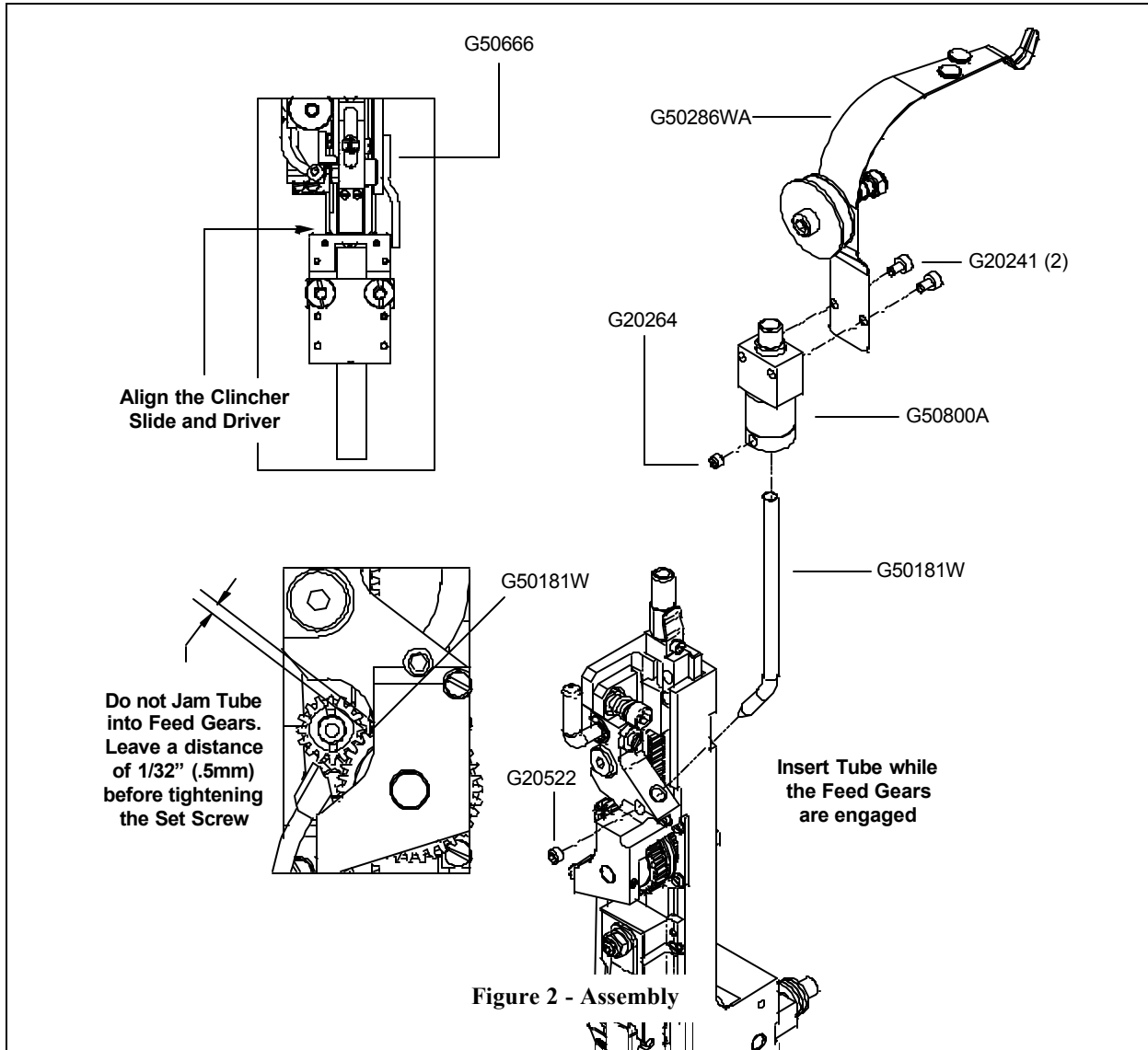
Installation

Contents

- G5 Manual
- Bag of tools; 2.0mm, 3.0mm and Double Open End Wrench (5.5mm and 7mm)
- T-Handle Hex Head Wrench; 4mm
- Head Mounting Key
- Wire Guide Spring and Wire Anti-Backup Unit
- Clincher Plate, Points, Slide, Nuts and Studs
- Clincher Alignment Gauge
- Adjustment Handle Assembly
- Stitch Samples



Assembly (Figures 2 & 4)



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

⚠ WARNING

Mounting (Figure 3)

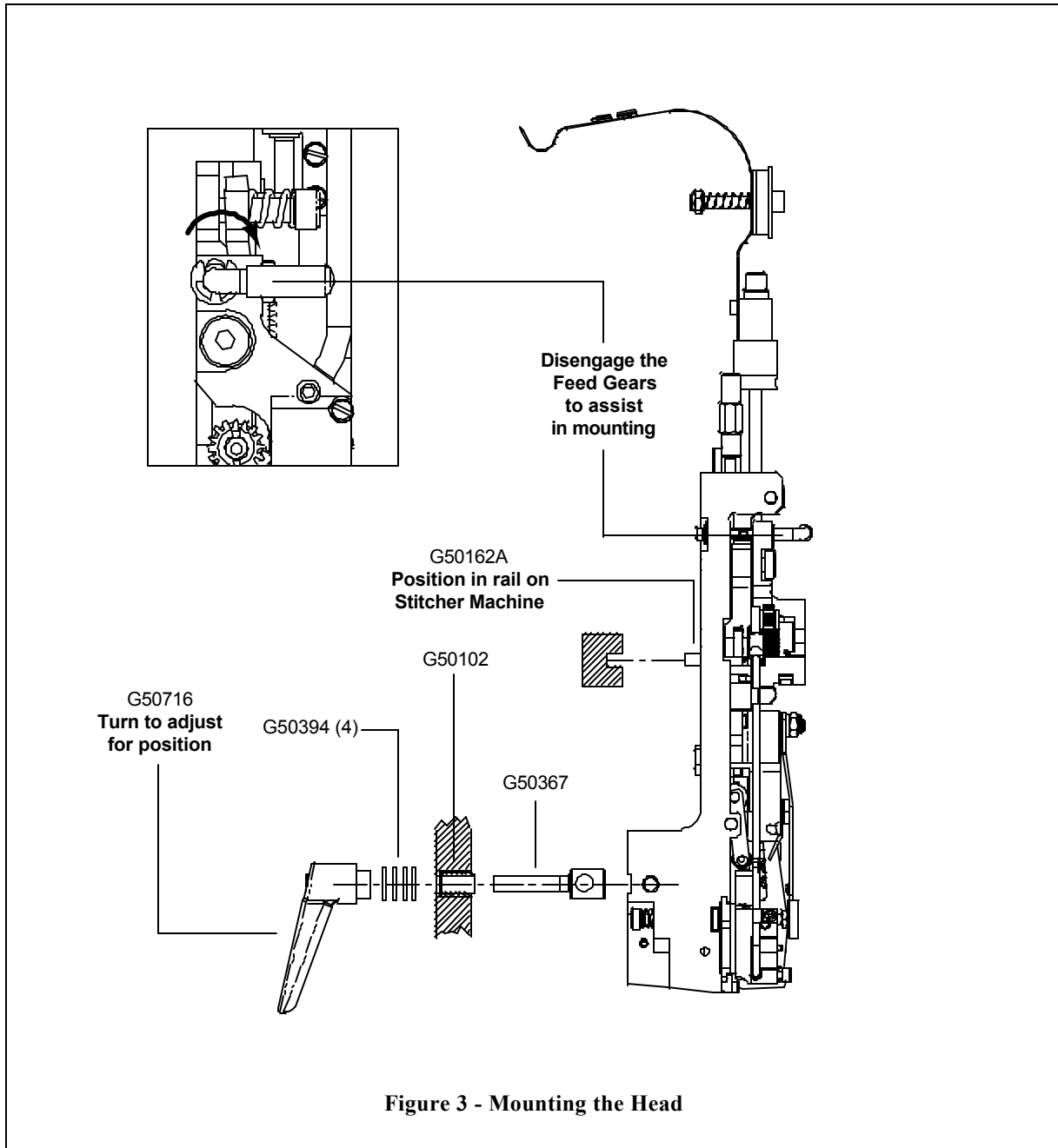
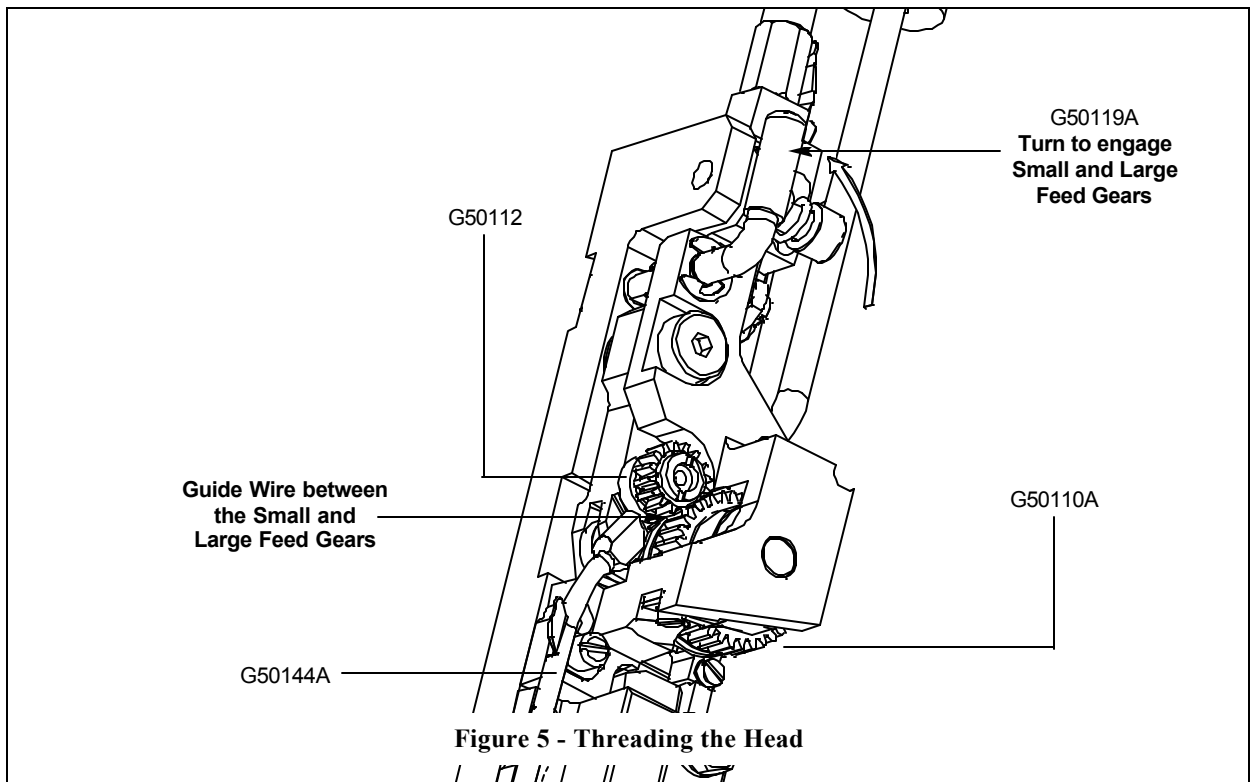
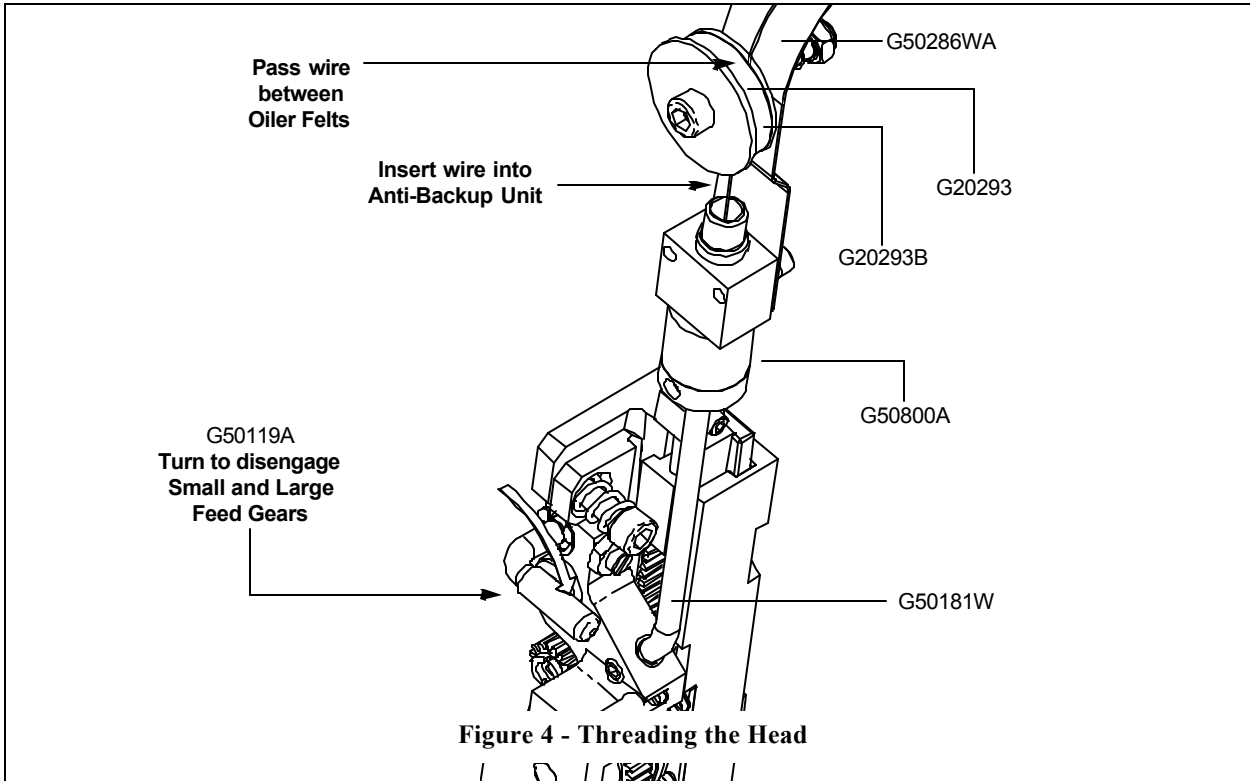


Figure 3 - Mounting the Head

Wire Threading (Figures 4 & 5)



Adjusting the Length of the Stitch Leg (Figure 6)

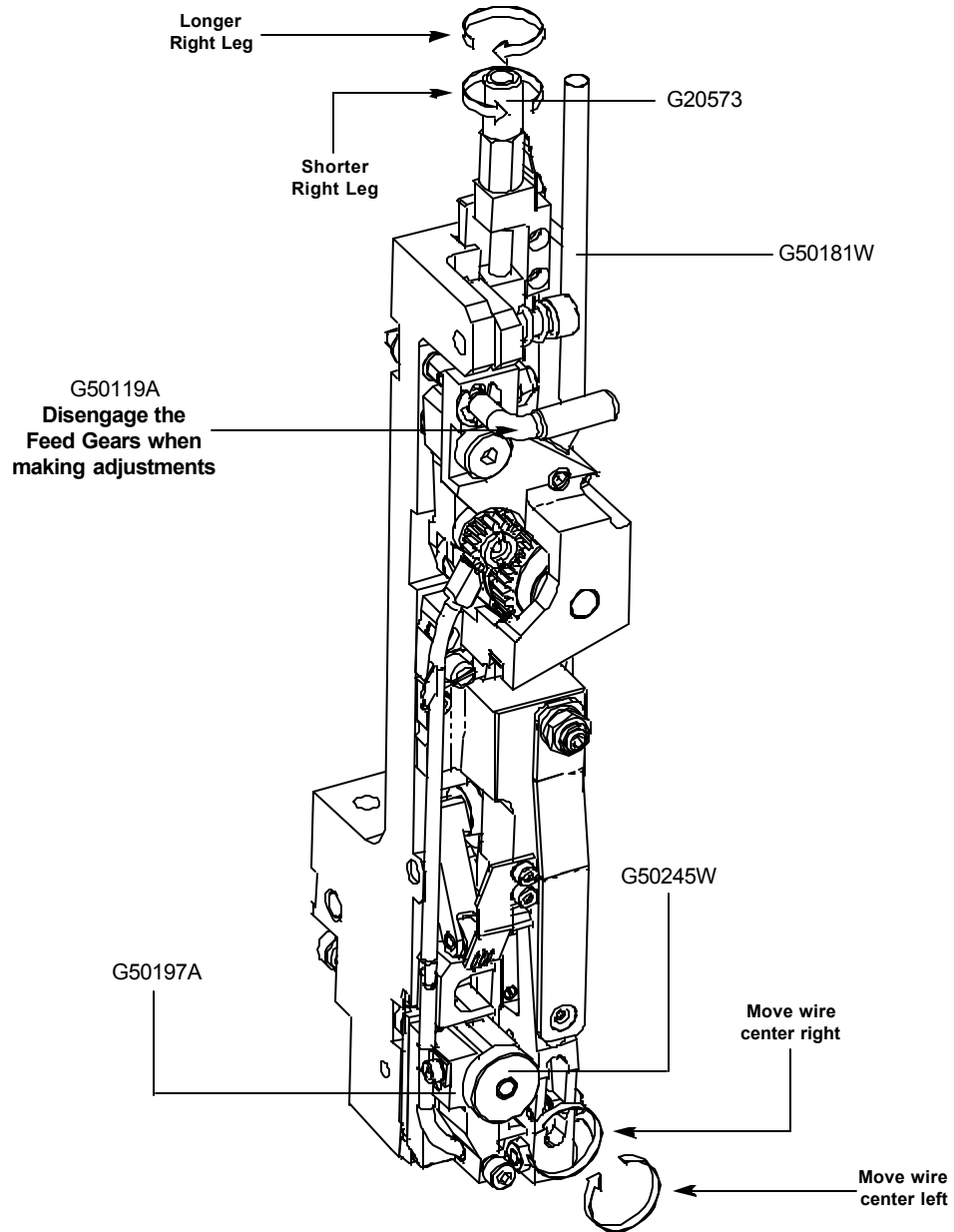
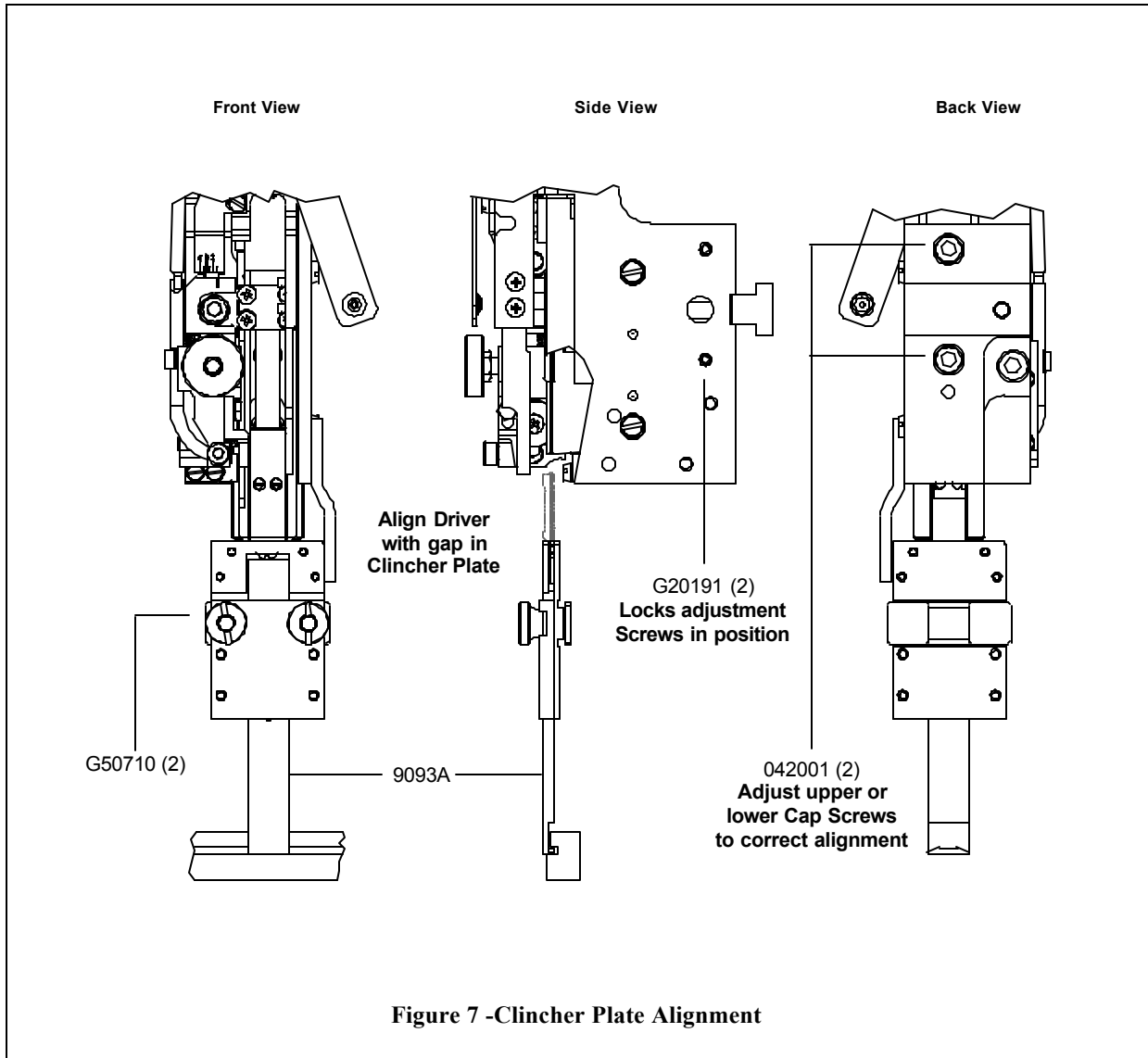


Figure 6 - Adjusting the Stitch Leg

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

⚠ WARNING

Aligning the Clincher Plate (Figure 7)



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

⚠ WARNING

Lubrication (Figure 8)

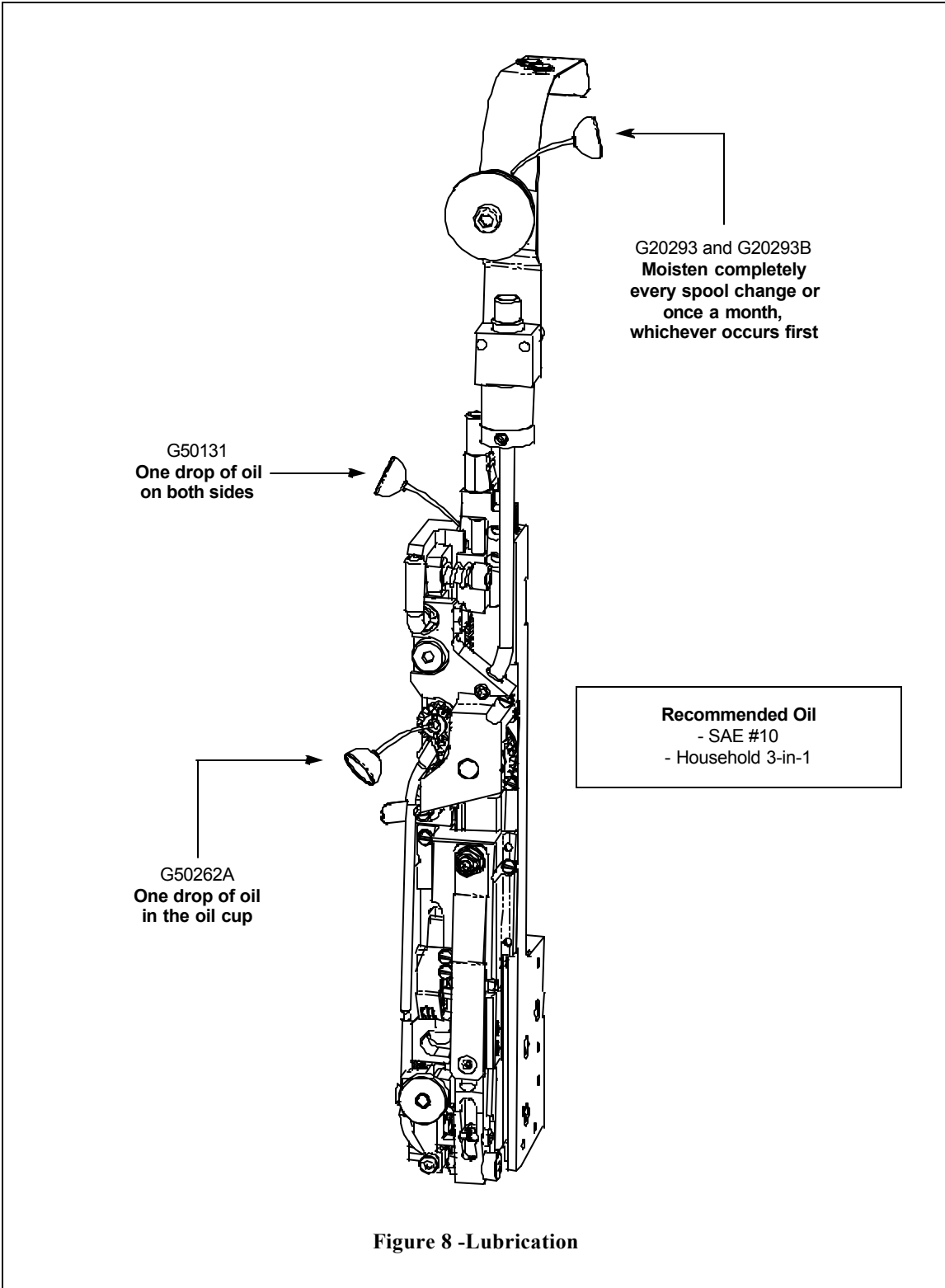
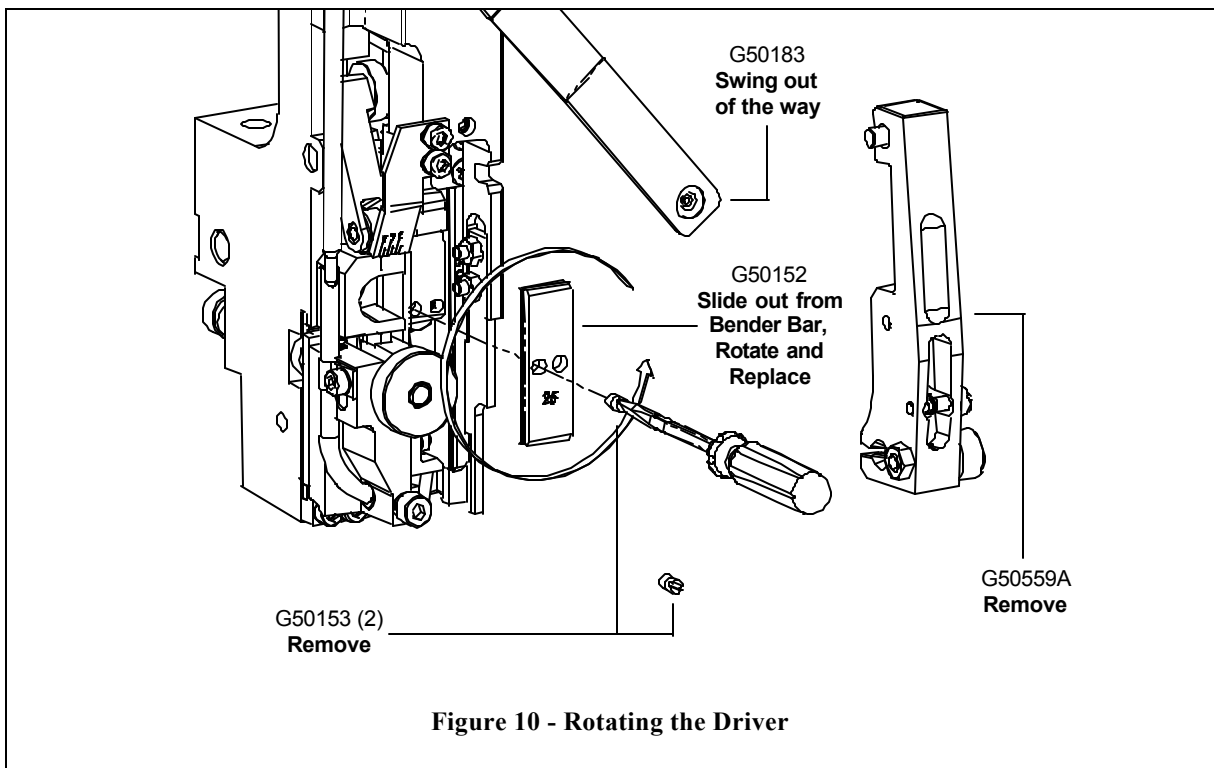
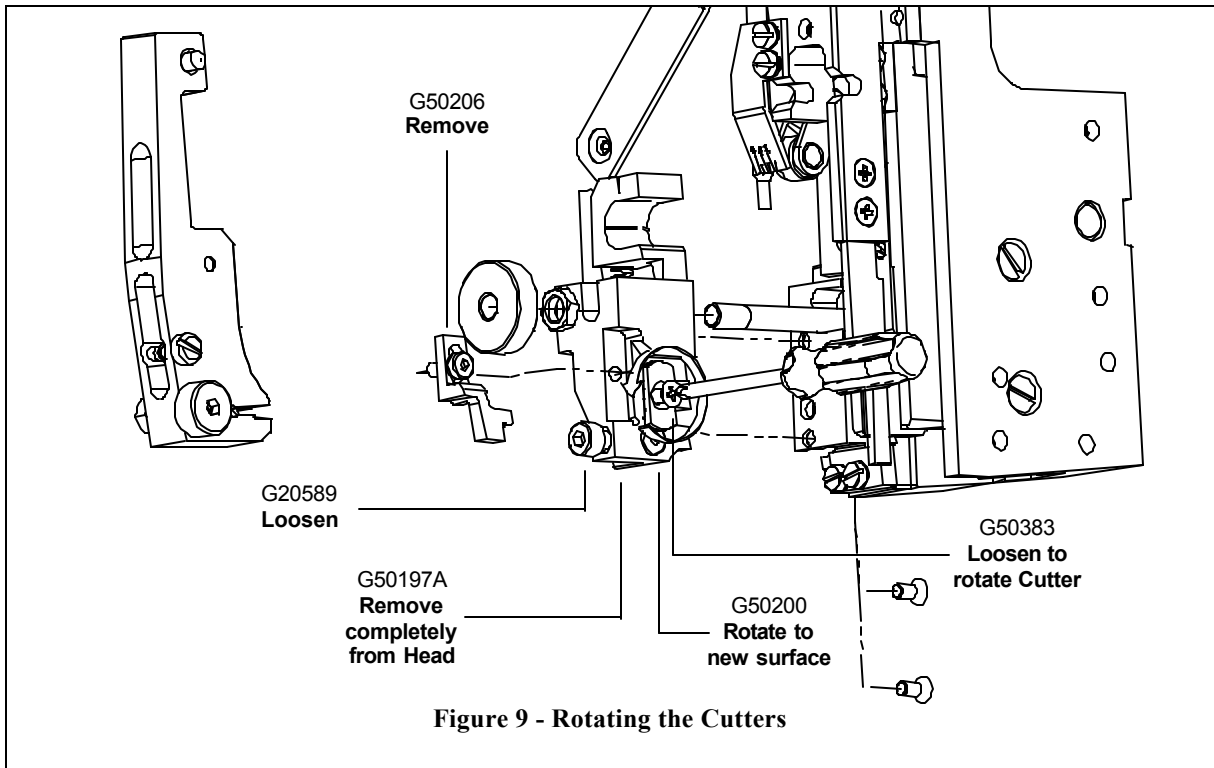


Figure 8 -Lubrication

Rotating Replacement Parts (Figures 9 & 10)



Cleaning

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

- **Large Feed Gear Assembly (G50110A):**

Remove and wash in a petroleum-based, oil-dissolving solvent, dry and repack the Feed Gear with any general Lithium-based light weight Grease.

- **Anywhere that dust, oil, pieces of wire and/or paper have built up:**

For example, around the Clincher Points and by the Forming Pin Cam (G50117). Remove the Wire Holder and blow clean with pressurized air.

Troubleshooting (Figure 11)

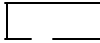
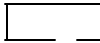
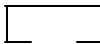
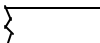
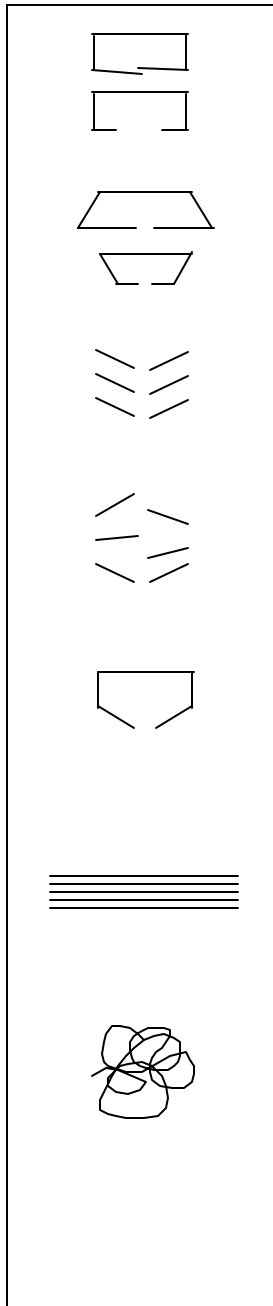
	<p>PROBLEM: Gap Out of Center SOLUTION: Lengthen or shorten the left leg by adjusting the Cutter Box. (See page 9)</p>
	<p>PROBLEM: Gap Too Big SOLUTION: Increase wire draw with the Feed Rack Adjustment Knob, then center stitch gap as described above. (See page 9)</p>
	<p>PROBLEM: Corner Buckled SOLUTION: Check the Driver (G50152) for a chipped corner and rotate or replace it if needed.</p>
	<p>PROBLEM: Leg(s) Buckled SOLUTION: If the ends of an unformed piece of wire are not smooth, the Wire Cutters (G50145 or G50200) are worn. Check for wear and rotate or replace if needed.</p>

Figure 11 - Troubleshooting



PROBLEM: Staple Legs Too Long or Too Short
 SOLUTION: Correct the overall wire draw by turning the Feed Rack Adjustment Knob (G20573) (See page 8)

PROBLEM: Legs are Spread or Contracted
 SOLUTION: Check wire cut-off.

PROBLEM: Legs Stray Forward or Backward Consistently
 SOLUTION: The Stitcher Head is not aligned properly front to back with respect to the Clincher Plate. (See page 9)

PROBLEM: Stitch Stray Randomly In and Out and Front to Back
 SOLUTION: Make sure the Cutters are aligned properly. Check the tensile strength of the wire or use thicker wire.

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

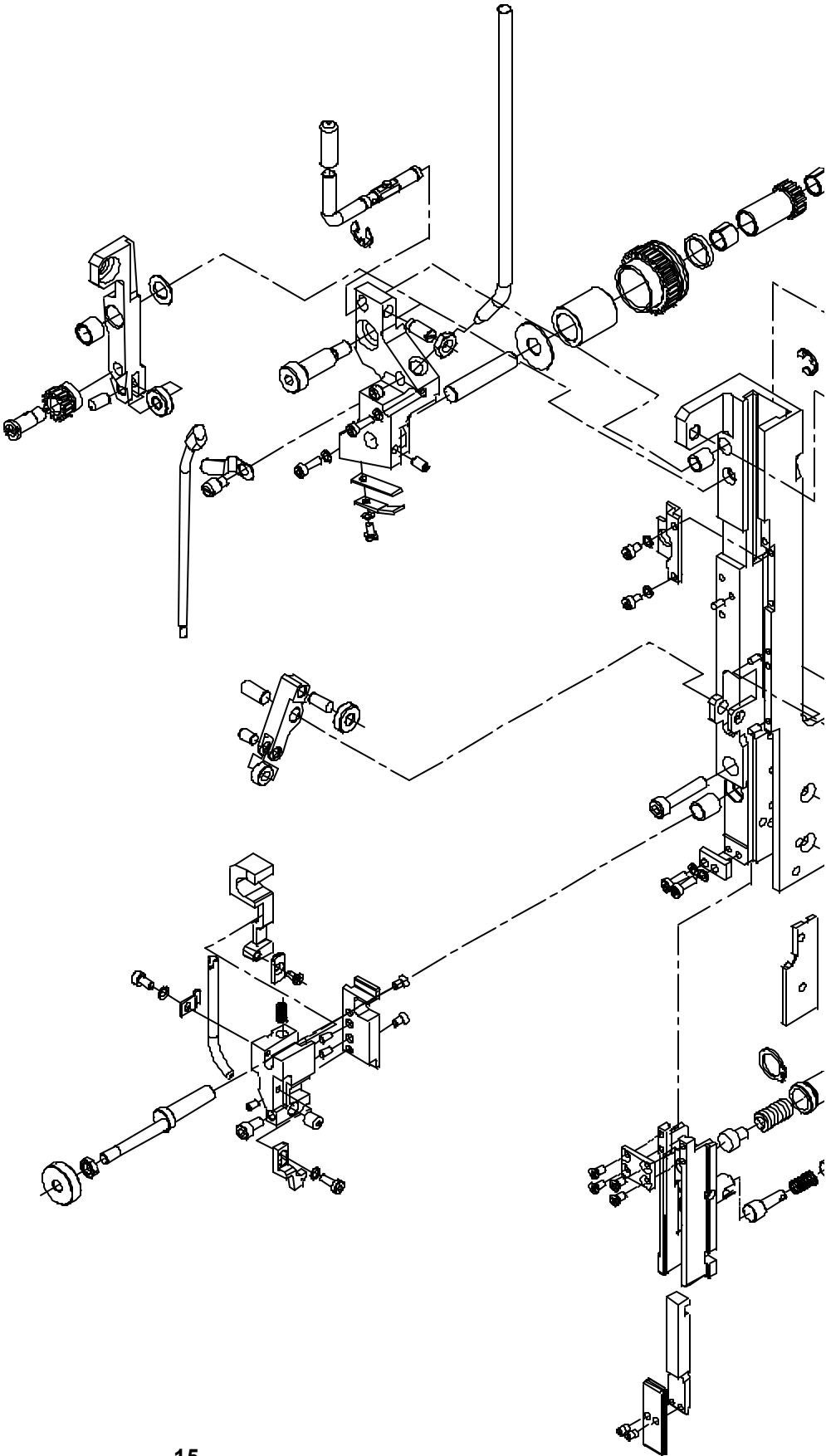
PROBLEM: Multiple Pieces of Wire Loaded
 SOLUTION: Make sure the Wire Holder is clean and free from debris. It should pass freely within the Bender Bar; straighten the Pivot Block if not.

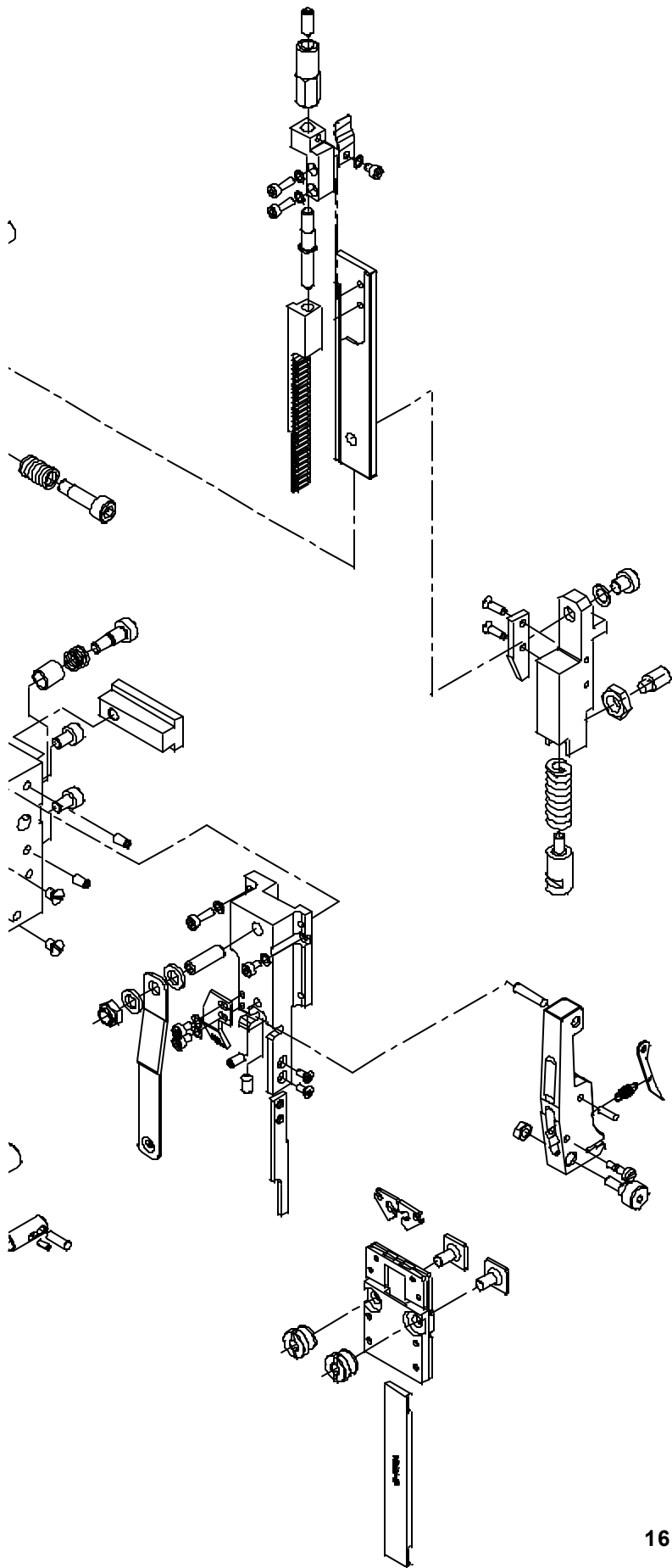
PROBLEM: Wire Jam
 SOLUTION: One or both of the Cutters could be worn or damaged; rotate to a new cutting surface. (See page 11)

PROBLEM: No wire being drawn
 SOLUTION: Make sure the Cutter Box Adjustment Knob is turned counter-clockwise and the Feed Gears engaged. (See page 8)

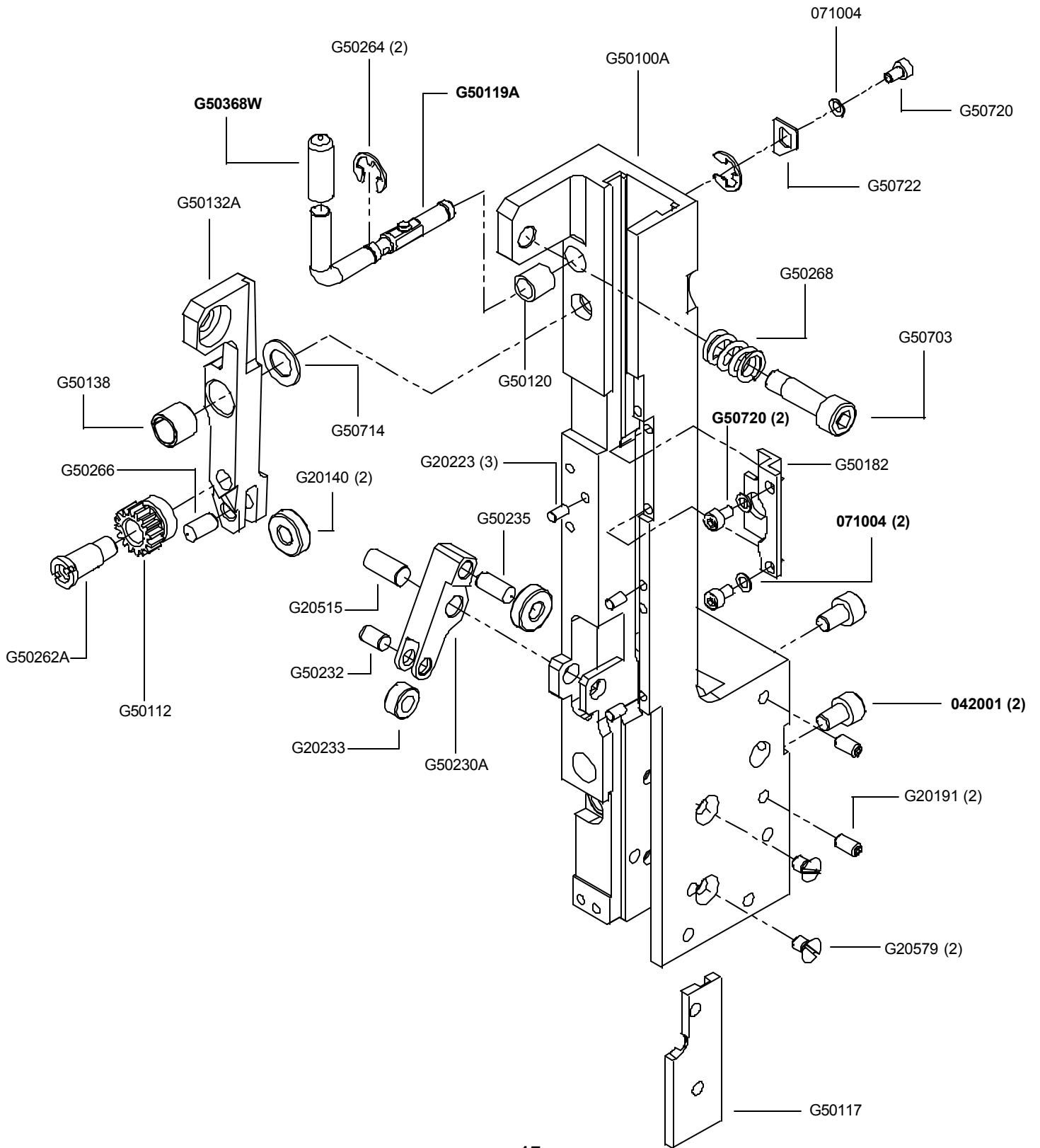
Figure 11 - Troubleshooting

The G5 Stitcher Head





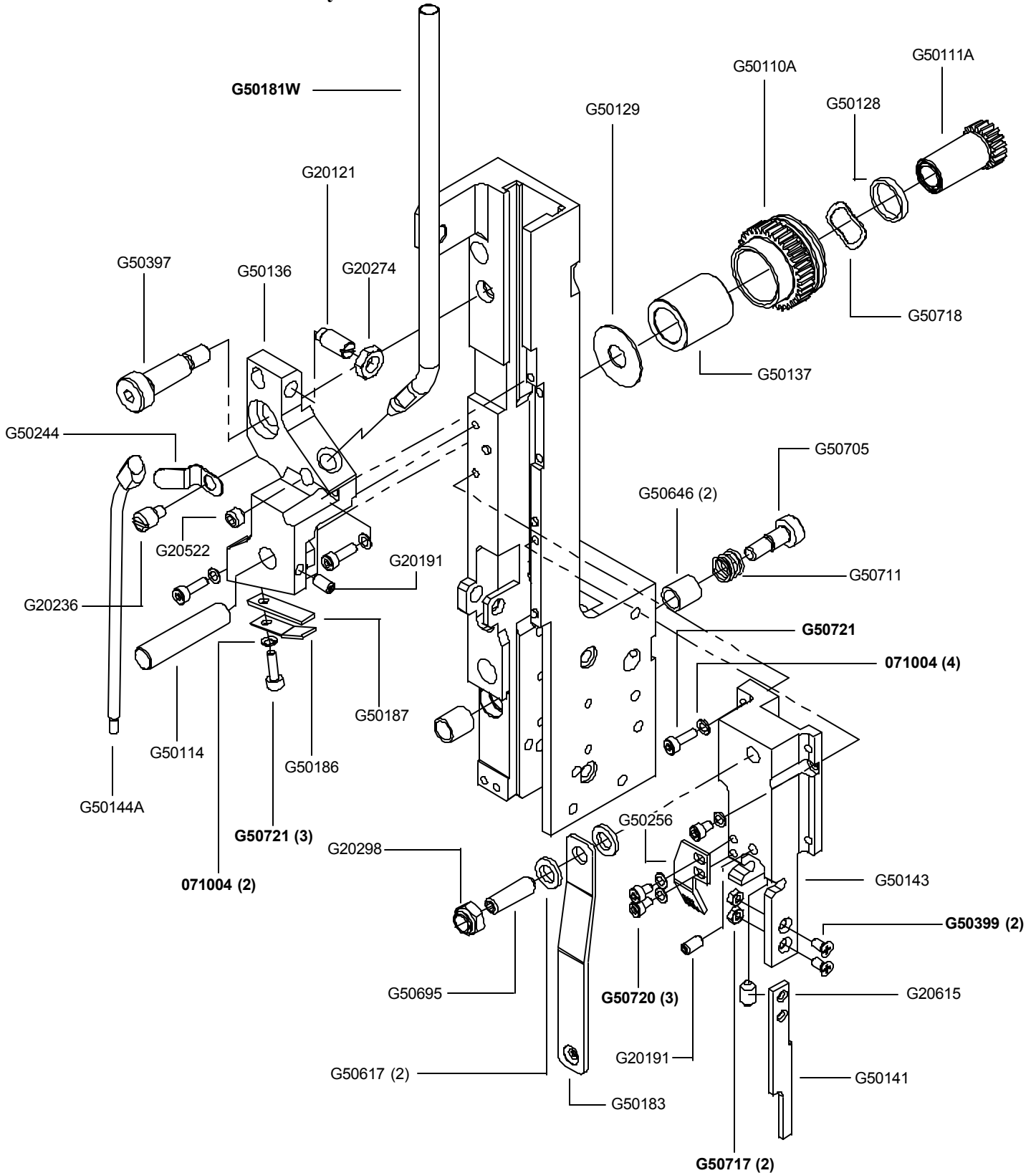
Bonnet Sub-Assembly 1



Bonnet Sub-Assembly 1

PART No.	DESCRIPTION	QUANTITY
G20140	Follower Ball Bearing	1
G20191	Screw M4x.7x8	2
G20515	Dowel Pin M6x14	1
G20579	Screw M4x0.7x6	2
G50100A	Bonnet Assembly	1
G50120	Feed Release Handle Bushing	1
G50101	Clamp Block	1
G50112	Small Feed Gear	1
G50117	Forming Pin Cam	1
G50119A	Feed Release Handle Assembly	1
G50126	Screw M5x.8x25	1
G50132A	Feed Lever Assembly	1
G50138	Feed Pinion Bearing	1
G50182	Feed Gear Plate	1
G50223	Dowel Pin M3x6	3
G50230A	Cutter Operating Lever Assembly	1
G20140	Follower Ball Bearing	1
G20233	Cutter Operating Lever Roller	1
G50232	Dowel Pin	1
G50235	Dowel Pin M5x12	1
G50262A	Small Feed Gear Shaft Assembly	1
87922	Oil Hole Cover	1
G50264	E-Ring 6mm	2
G50266	Dowel M5x10	1
G50268	Feed Lever Spring	1
G50368W	Feed Release Handle Cap- Orange	1
G50703	Feed Lever Spring Screw	1
G50714	Feed Lever Spacer	1
G50720	Screw M3x0.5x6	3
G50722	Feed Release Handle Stop	1
042001	Screw M5x.8x8	2
071004	Lock Washer Ribbed	3

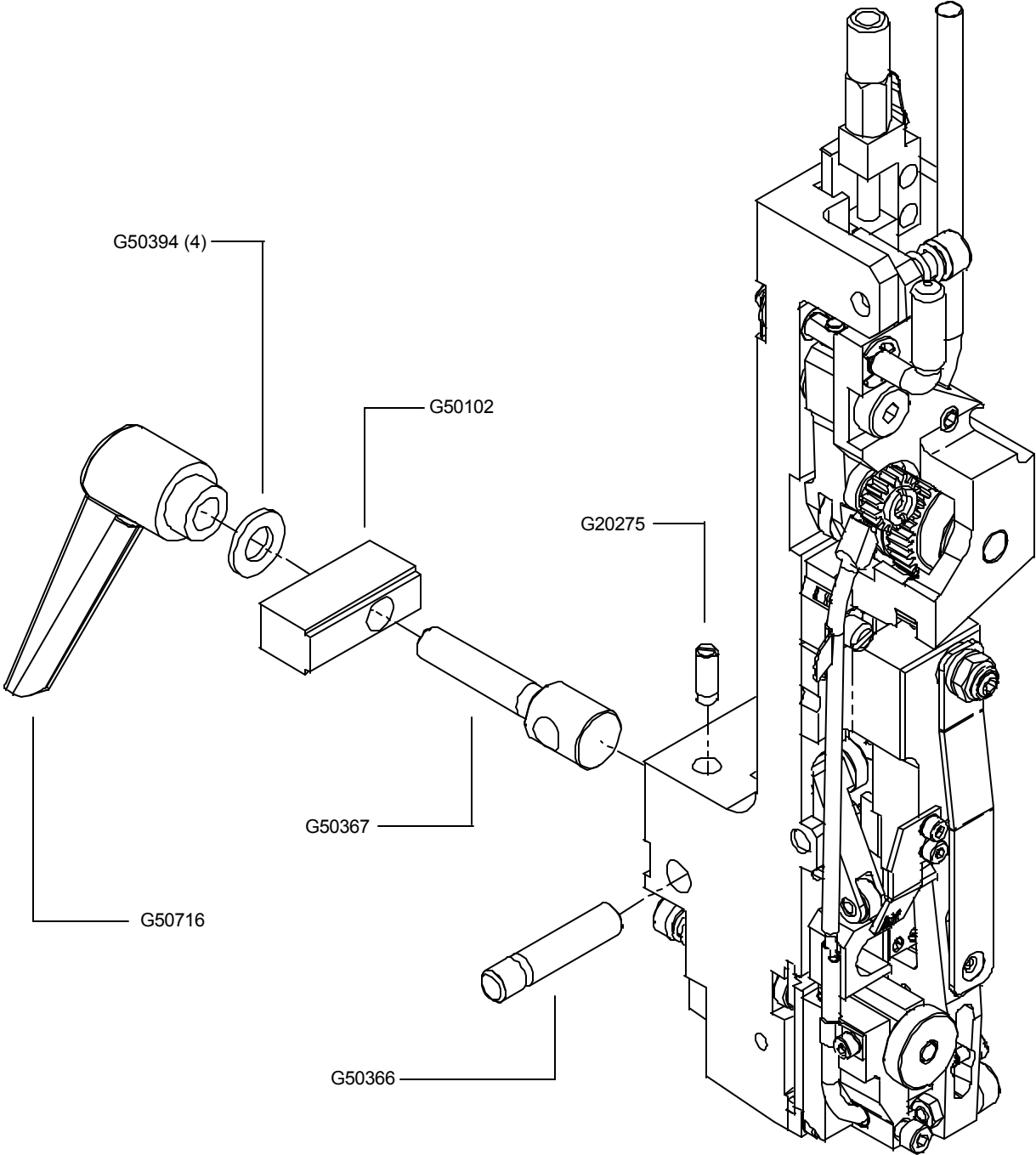
Bonnet Sub-Assembly 2



Bonnet Sub-Assembly 2

PART No.	DESCRIPTION	QUANTITY
G20121	Feed Release Plunger	1
G20191	Screw M4x.7x8	2
G20236	Tube Pivot Screw	1
G20274	Hex Jam Nut, M6x1	1
G20298	Nylock Lock Nut, M6x1	1
G20522	Screw M6x1.0x5	1
G20615	Screw M5x0.8x8	1
G50110A	Large Feed Gear Assembly	1
G50110	Large Feed Gear	1
G50137	Feed Gear Clutch	1
G50111A	Feed Pinion Assembly	1
G50114	Feed Gear Pin	1
G50128	Pinion Washer	1
G50129	Large Feed Gear Washer	1
G50136	Feed Gear Bracket	1
G50141	Wire Guide Bar	1
G50142	Screw M3x0.5x5	1
G50143	Pivot Block	1
G50144A	Middle Wire Tube Assembly	1
G50181W	Upper Wire Tube - Watkiss	1
G50183	Wire Holder Retaining Spring	1
G50186	Feed Gear Friction Spring	1
G50187	Feed Gear Friction Pad	1
G50244	Tube Clip	1
G50256	Scale	1
G50397	Shoulder Bolt M8x20	1
G50399	Screw M3x0.5x8	2
G50617	Wire Holder Retaining Spring Washer	2
G50646	Cutter Box Eccentric Bearing	2
G50695	Screw M6x1.0x20	1
G50705	Shoulder Screw M6x8	1
G50711	Cutter Box Eccentric Screw Spring	1
G50717	Hex Nut M3x0.5	2
G50718	Feed Gear Spring	1
G50720	Screw M3x0.5x6	3
G50721	Screw M3x0.5x10	4
071004	Lock Washer Ribbed	7

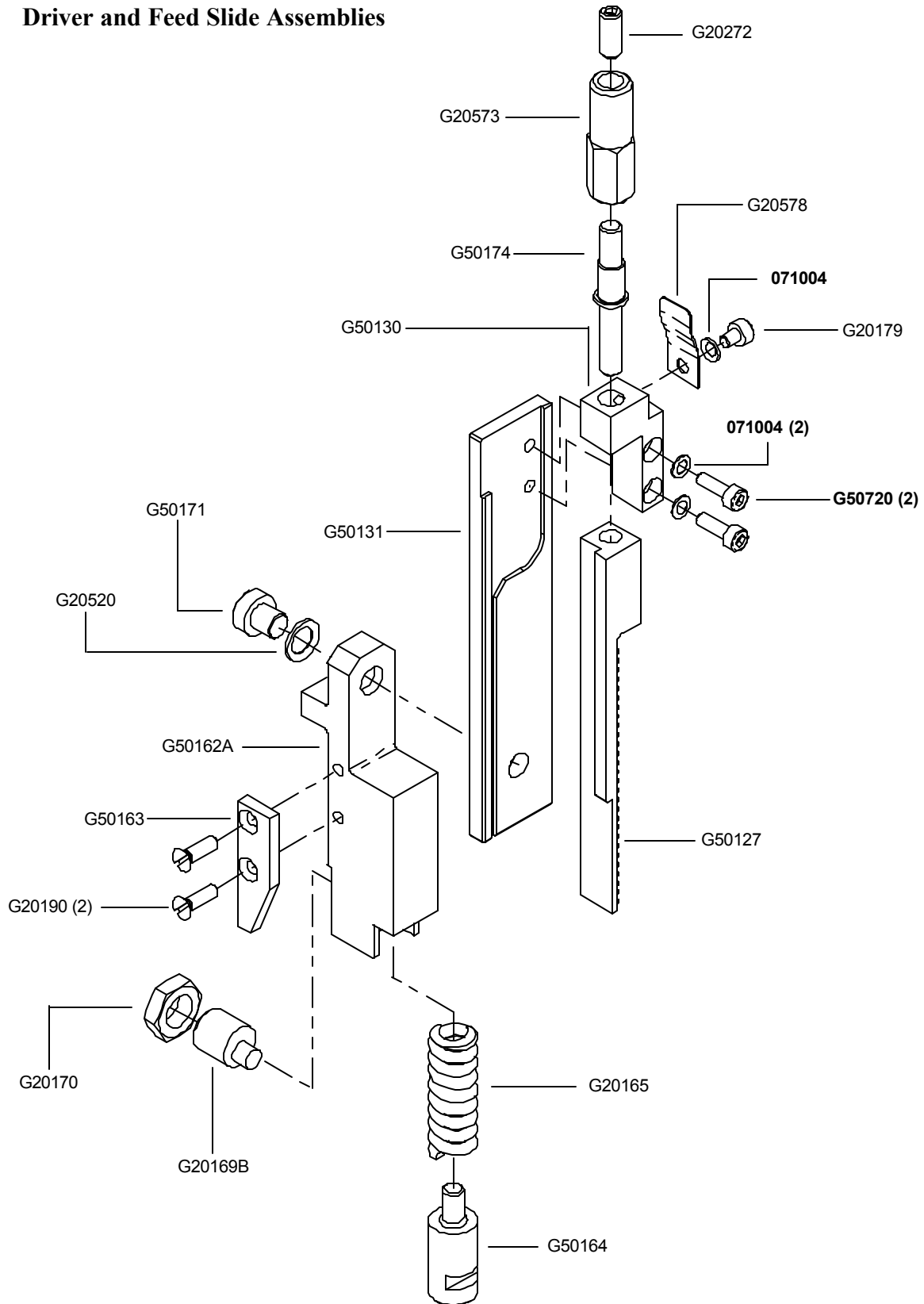
Bolt-Style Head Mounting



Bolt-Style Head Mounting

PART No.	DESCRIPTION	QUANTITY
G20275	Ball Spring Plunger	1
G50102	Mounting Block - Keyed	1
G50366	Bonnet Clamp Pin	1
G50367	Head Mounting Bolt, M8	1
G50394	Flat Washer M8	4
G50716	Mounting Block Handle	1

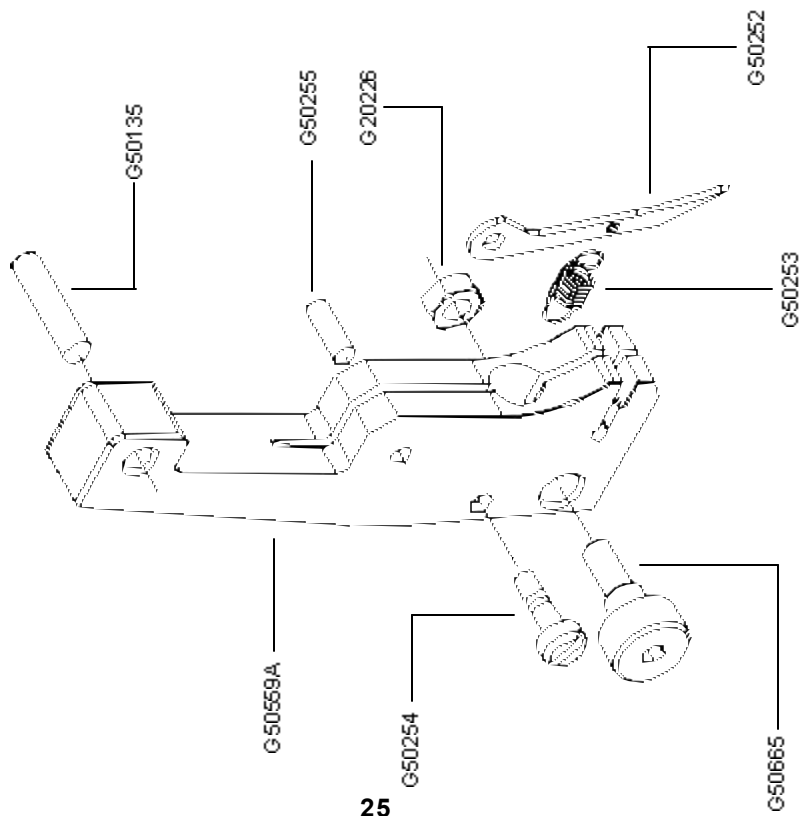
Driver and Feed Slide Assemblies



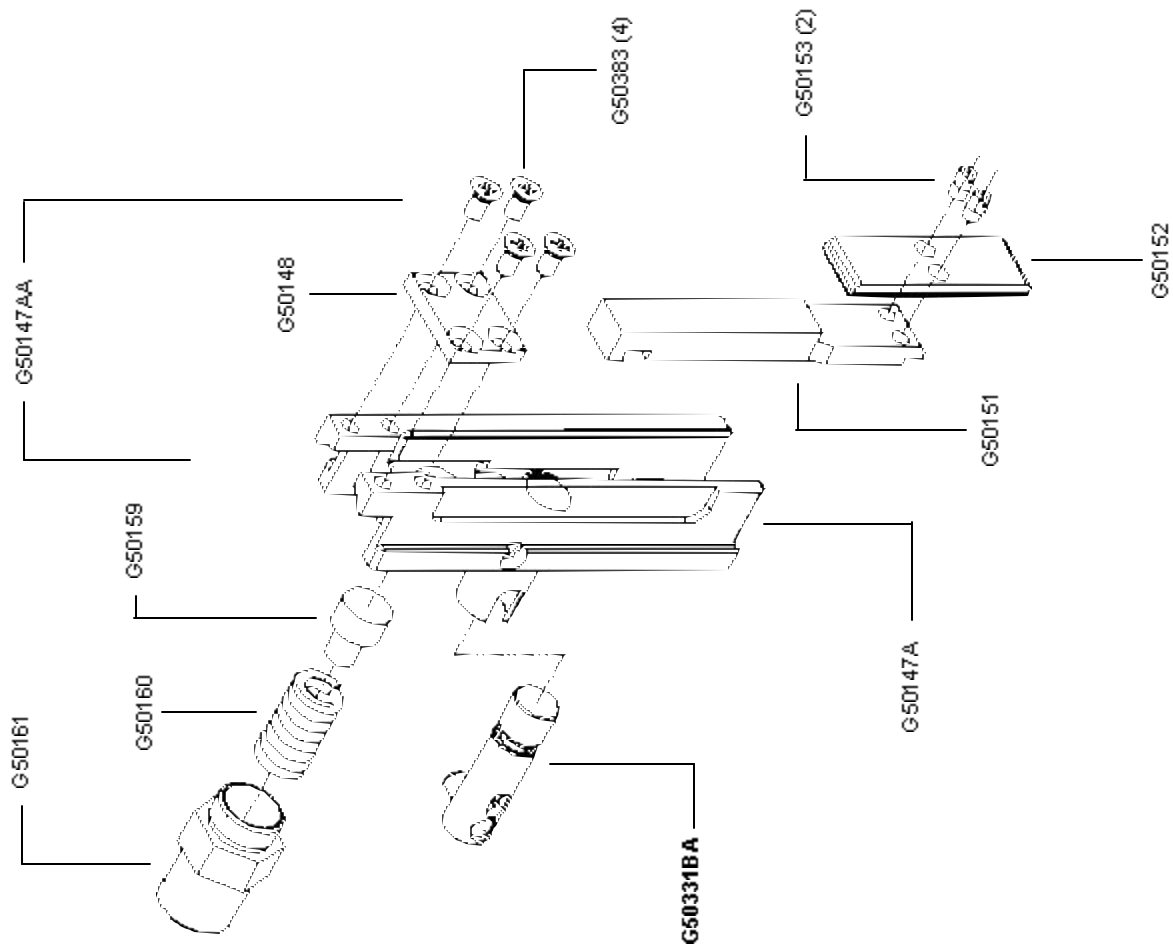
Driver and Feed Slide Assemblies

PART No.	DESCRIPTION	QUANTITY
G20165	Driving Slide Spring	1
G20169B	Driving Slide Plunger Screw Eccentric	1
G20170	Hex Jam Nut M8x1.25	1
G20179	Screw M3x.5x4	1
G20190	Screw M3x.5x10	2
G20272	Screw M5x0.8x12	1
G20520	Ribbed Lock Washer M6	1
G20573	Feed Rack Adjustment Knob	1
G20578	Rack Adjustment Knob Detent	1
G50127	Feed Rack	1
G50130	Feed Adjustment Block	1
G50131	Feed Slide	1
G50162A	Driving Slide Assembly	1
G50163	Cutter Operating Cam	1
G50164	Plunger	1
G50171	Screw M6x1.0x6	1
G50174	Feed Rack Adjustment Stud	1
G50720	Screw M3x0.5x6	2
071004	Lock Washer Ribbed	3

Wire Holder Assembly



Driver and Bender Bars

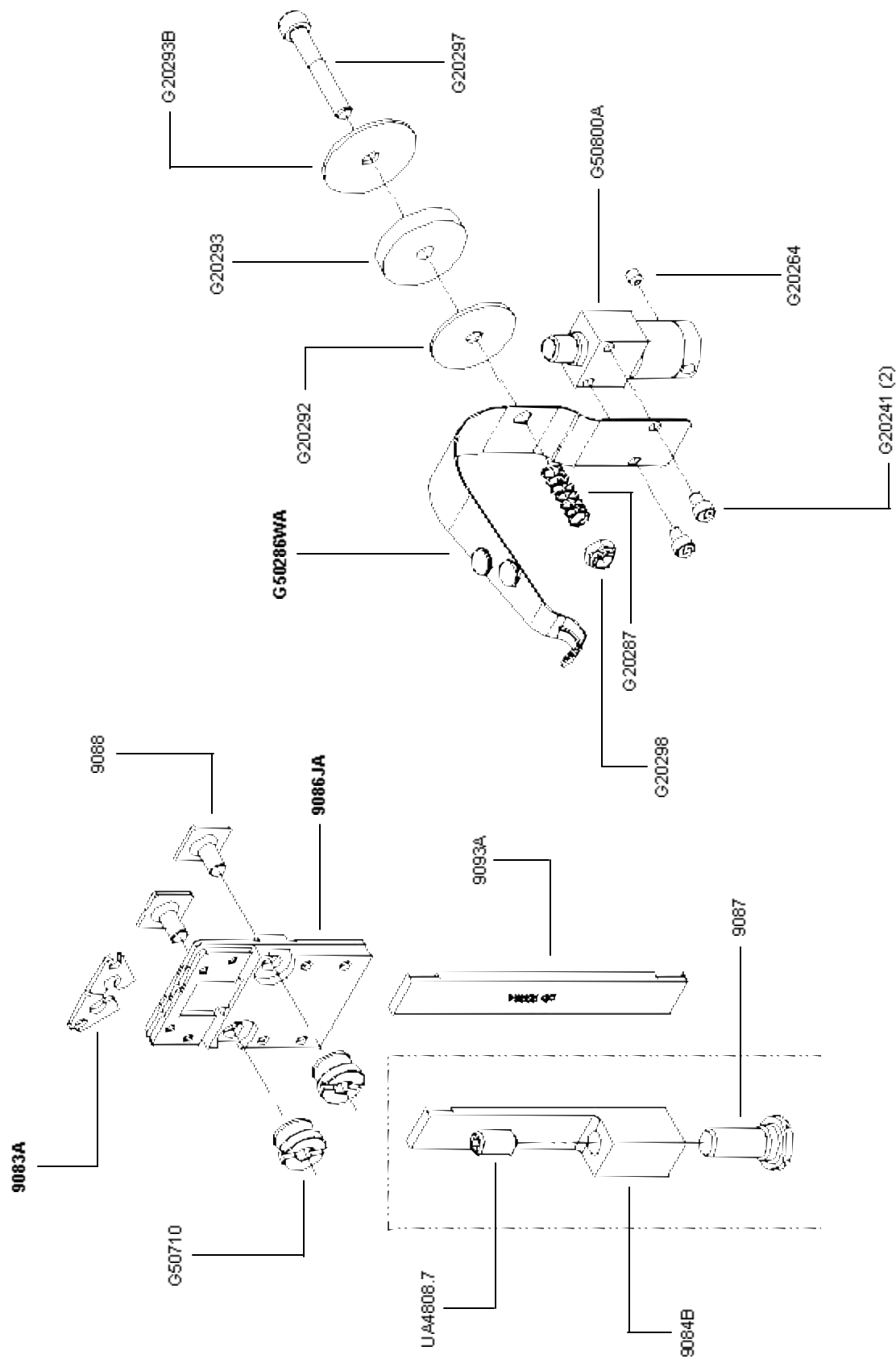


Wire Holder Assembly and Driver and Bender Bars

PART No.	DESCRIPTION	QUANTITY
G20226	Hex Nut M4x.7	1
G50135	Wire Holder Pivot Pin	1
G50147AA	Bender Bar Assembly	1
G50147A	Bender Bar	1
G50148	Bender Bar Friction Plate	1
G50383	Screw M3x.5x6	4
G50151	Driver Bar	1
G50152	Driver - 25 Gauge Wire	1
G50153	Driver Retaining Screw	2
G50159	Friction Plug	1
G50160	Bender Bar Friction Spring	1
G50161	Friction Plug Bushing	1
G50252	Wire Hook	1
G50253	Wire Hook Spring	1
G50254	Wire Holder Spring Screw	1
G50255	Dowel Pin M3x10	1
G50331BA	Forming Pin Assembly	1
G50559A	Wire Holder Assembly	1
G50665	Wire Holder Adjustment Screw	1

Clincher Plate Assembly

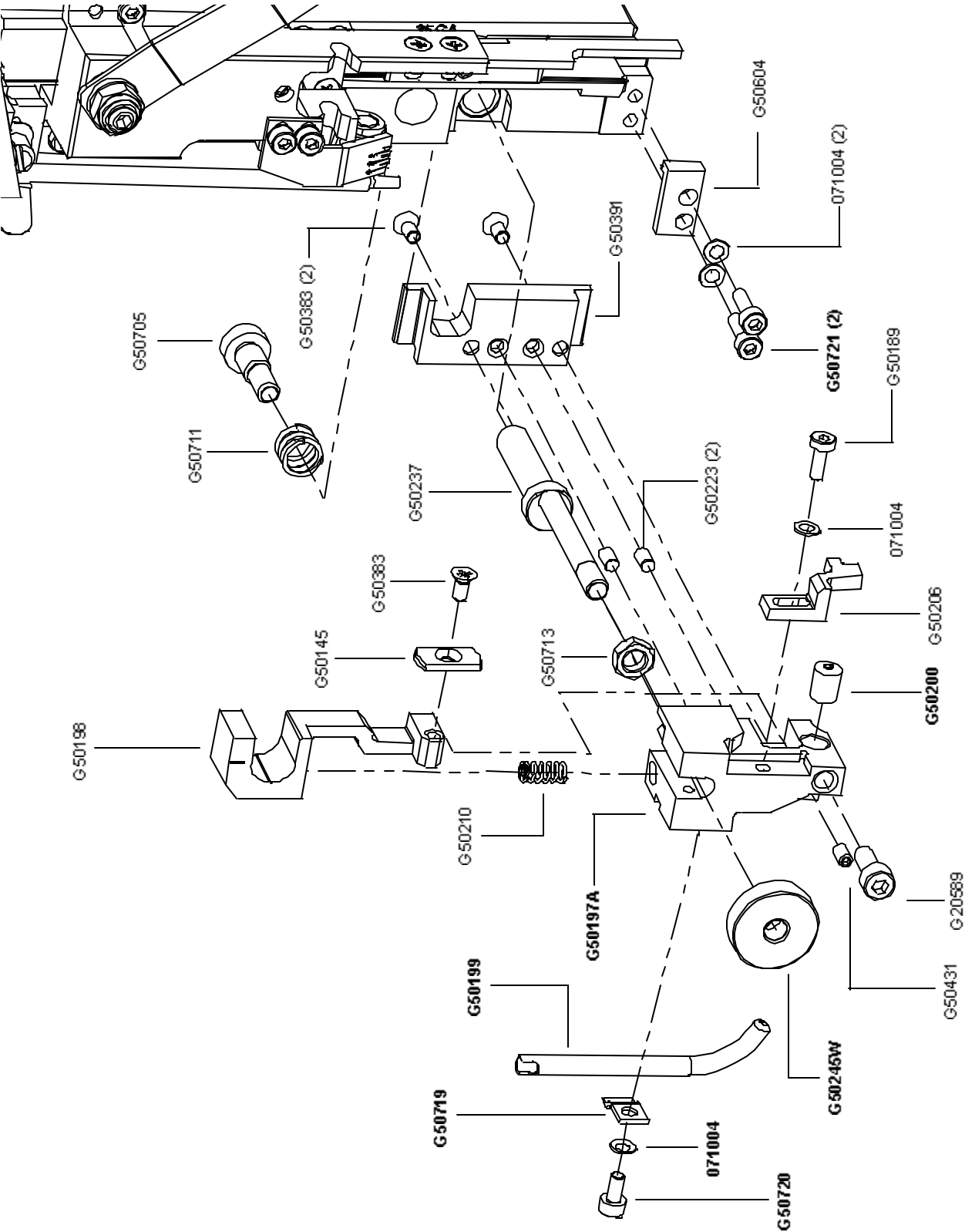
Wire Guide Bracket and Spring



Clincher Plate Assembly and Wire Guide Bracket, Spring

PART No.	DESCRIPTION	QUANTITY
9083A	Clincher Point - Thick, Round	2
9084B	Adjustable Clincher Slide	1
9086JA	Clincher Plate - Thick, G5	1
9087	Clincher Slide Adjustment Screw	1
9088	Clincher Plate Binder Bolt	2
9093A	Clincher Slide - Thick	1
G20241	Screw M4x0.7x6	2
G20264	Screw M5x0.8x5, Nylon	1
G20287	Wire Oiler Felt Spring	1
G20292	Wire Oil Felt Washer	1
G20293	Wire Oiler Felt	1
G20293B	Wire Oiler Felt, Thin	1
G20297	Screw M6x1.0x40	1
G20298	Nylock Lock Nut, M6x1	1
G50286WA	Wire Guide Spring Asy - Watkiss	1
G50710	Clincher Plate Nut	2
G50800A	Wire Anti-Back Up Unit	1
UA4808.7	Screw 1/4-28 x 1/4	1

Cutter Box Assembly



Cutter Box Assembly

PART No.	DESCRIPTION	QUANTITY
G20579	Screw M4x0.7x6	1
G20589	Screw M4x0.7x10	1
G50145	Moving Cutter	1
G50189	Screw M3x0.5x10	1
G50196	Screw M3x.5x6	1
G50197A	Cutter Box Assembly	1
G50223	Dowel Pin M3x6	2
G50198	Cutter Slide	1
G50199	Lower Wire Tube	1
G50200	Fixed Wire Cutter	1
G50206	Wire Straightener	1
G50210	Cutter Operating Spring	1
G50223	Dowel Pin M3x6	2
G50237	Cutter Box Adjusting Eccentric	1
G50245W	Cutter Box Adjustment Knob- Orange	1
G50383	Screw M3x.5x6	3
G50391	Cutter Box Mounting Plate	1
G50431	Screw M3x0.5x6	1
G50604	Cutter Box Guide Plate	1
G50705	Shoulder Screw M6x8	1
G50711	Cutter Box Eccentric Screw Spring	1
G50713	Hex Jam Nut M5	1
G50719	Lower Tube Clip	1
G50720	Screw M3x0.5x6	1
G50721	Screw M3x0.5x10	2
071004	Lock Washer Ribbed	4

Part Number / Description Cross-Reference

A9086JA	Clincher Plate Asy - Tk	1	G50101	Clamp Block	1
G20121	Feed Release Plunger	1	G50102	Mounting Block - Keyed	1
G20140	Follower Ball Bearing	2	G50110	Large Feed Gear	1
G20165	Driving Slide Spring	1	G50110A	Large Feed Gear Assembly	1
G20169B	Driving Slide Plunger Screw Eccentric	1	G50111A	Feed Pinion Assembly	1
G20170	Hex Jam Nut M8x1.25	1	G50112	Small Feed Gear	1
G20179	Screw M3x.5x4	1	G50114	Feed Gear Pin	1
G20190	Screw M3x.5x10	2	G50117	Forming Pin Cam	1
G20191	Screw M4x.7x8	4 (3)	G50119A	Feed Release Handle Assembly	1
G20226	Hex Nut M4x.7	1	G50120	Feed Release Handle Bushing	1
G20233	Cutter Operating Lever Roller	1	G50126	Screw M5x.8x25	1
G20236	Tube Pivot Screw	1	G50127	Feed Rack	1
G20241	Screw M4x0.7x6	2	G50128	Pinion Washer	1
G20264	Screw M5x0.8x5, Nylon	1	G50129	Large Feed Gear Washer	1
G20272	Screw M5x0.8x12	1	G50130	Feed Adjustment Block	1
G20274	Hex Jam Nut, M6x1	1	G50131	Feed Slide	1
G20275	Ball Spring Plunger	1	G50132A	Feed Lever Assembly	1
G20287	Wire Oiler Felt Spring	1	G50135	Wire Holder Pivot Pin	1
G20292	Wire Oil Felt Washer	1	G50136	Feed Gear Bracket	1
G20293	Wire Oiler Felt	1	G50137	Feed Gear Clutch	1
G20293B	Wire Oiler Felt, Thin	1	G50138	Feed Pinion Bearing	3
G20297	Screw M6x1.0x40	1	G50141	Wire Guide Bar	1
G20298	Nylock Lock Nut, M6x1	2	G50142	Screw M3x0.5x5	1
G20360	Hex Key Wrench 3.0mm	1	G50143	Pivot Block	1
G20374	Hex Key Wrench 2.0mm	1	G50144A	Middle Wire Tube Assembly	1
G20515	Dowel Pin M6x14	1	G50145	Moving Cutter	1
G20520	Ribbed Lock Washer M6	1	G50147BA	Bender Bar	1
G20522	Screw M6x1.0x5	1	G50147BAA	Bender Bar Assembly	1
G20573	Feed Rack Adjustment Knob	1	G50148	Bender Bar Friction Plate	1
G20578	Rack Adjustment Knob Detent	1	G50151	Driver Bar	1
G20579	Screw M4x0.7x6	3	G50152	Driver - 25 Gauge Wire	1
G20589	Screw M4x0.7x10	1	G50153	Driver Retaining Screw	2
G20615	Screw M5x0.8x8	1	G50159	Friction Plug	1
G50100A	Bonnet Assembly	1	G50160B	Bender Bar Friction Spring	1

Part Number / Description Cross-Reference

G50161B	Friction Plug Bushing	1	G50266	Dowel M5x10	1
G50162A	Driving Slide Assembly	1	G50268	Feed Lever Spring	1
G50163	Cutter Operating Cam	1	G50286WA	Wire Guide Spring Asy - Watkiss	1
G50164	Plunger	1	G50331BA	Forming Pin Assembly	1
G50171	Screw M6x1.0x6	1	G50366	Bonnet Clamp Pin	1
G50174	Feed Rack Adjustment Stud	1	G50367	Head Mounting Bolt, M8	1
G50181W	Upper Wire Tube - Watkiss	1	G50368W	Feed Release Handle Cap - Orange	1
G50182	Feed Gear Plate	1	G50383	Screw M3x.5x6	9 (7)
G50183	Wire Holder Retaining Spring	1	G50391	Cutter Box Mounting Plate	1
G50186	Feed Gear Friction Spring	1	G50394	Flat Washer M8	4
G50187	Feed Gear Friction Pad	1	G50397	Shoulder Bolt, M8x20	1
G50189	Screw M3x0.5x10	1	G50399	Screw M3x.5x8	2
G50196	Screw M3x.5x6	1	G50431	Screw, M3x0.5x6	1
G50197A	Cutter Box Assembly	1	G50559A	Wire Holder Assembly	1
G50198	Cutter Slide	1	G50604	Cutter Box Guide Plate	1
G50199	Lower Wire Tube	1	G50617	Wire Holder Retaining Spring Washer	2
G50200	Fixed Wire Cutter	1	G50646	Cutter Box Eccentric Bearing	2
G50206	Wire Straightener	1	G50665	Wire Holder Adjustment Screw	1
G50210	Cutter Operating Spring	1	G50666	Clincher Alignment Gage, G5	1
G50223	Dowel Pin M3x6	7	G50695	Screw M6x1.0x20	1
G50228A	Adjustment Handle Assembly	1	G50703	Feed Lever Spring Screw	1
G50230A	Cutter Operating Lever Assembly	1	G50705	Shoulder Screw M6x8	2
G50232	Dowel Pin	1	G50707	Double Open End Wrench - 5.5 & 7mm	1
G50235	Dowel Pin M5 x 12	1	G50708	T-Handle Hex Key Wrench - 4mm	1
G50237	Cutter Box Adjusting Eccentric	1	G50710	Clincher Plate Nut	2
G50244	Tube Clip	1	G50711	Cutter Box Eccentric Screw Spring	2
G50245W	Cutter Box Adjust. Knob - Orange	1	G50713	Hex Jam Nut M5	1
G50252	Wire Hook	1	G50714	Feed Lever Spacer	1
G50253	Wire Hook Spring	1	G50716	Mounting Block Handle	1
G50254	Wire Holder Spring Screw	1	G50717	Hex Nut M3x0.5	2
G50255	Dowel Pin M3 x 10	1	G50718	Feed Gear Spring	1
G50256	Scale	1	G50719	Lower Tube Clip	1
G50262A	Small Feed Gear Shaft Assembly	1	G50720	Screw M3x0.5x6	9
G50264	E-Ring 6mm	2	G50721	Screw M3x0.5x10	6

Part Number / Description Cross-Reference

G50722	Feed Release Handle Stop	1
G50800A	Wire Anti-Back Up Unit	1
UA4808.7	Screw 1/4-28x1/4	1
042001	Screw M5x.8x8	2
071004	Lock Washer Ribbed	17
9083A	Clincher Point - Thick, Round	2
9084B	Adjustable Clincher Slide	1
9086JAA	Clincher Plate - Thick, G5	1
9087	Clincher Slide Adjustment Screw	1
9088	Clincher Plate Binder Bolt	2
9091	Clincher Slide Strap Rivet	2
9093A	Clincher Slide - Thick	1
87922	Oil Hole Cover	1

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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