

DELUXE STITCHER

C O M P A N Y I N C .

Machine Serial Number : _____

Head Serial Number : _____

Date Purchased : _____

#7/7AW Stitchers

OPERATION AND MAINTENANCE MANUAL

7 Series Stitchers.....	Electric Clutch
7AW Stitcher w/Motor.....	115V and 60HZ
7BW Stitcher w/ Motor.....	230V and 50HZ
7CW Stitcher w/o Motor.....	115V and 60HZ
7EW Stitcher w/o Motor.....	230V and 50HZ

Before using this Stitcher, all operators must study this manual and follow the safety warnings and instructions. Keep these instructions with the #7/7AW Stitcher for future reference. If you have any questions, contact your local DeLuxe Stitcher Graphic Arts Representative or Distributor.

WARNING!

#7/7AW Stitchers

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 without all guards in place. The stitcher will not operate without the front guard closed properly. 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 supply before any disassembly work.

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Introduction

The Model Number 7 Book Stitcher is a combination light and heavy duty stitcher designed to staple both flat and saddle work ranging in thickness from a few sheets to 7/8" (22.2mm).

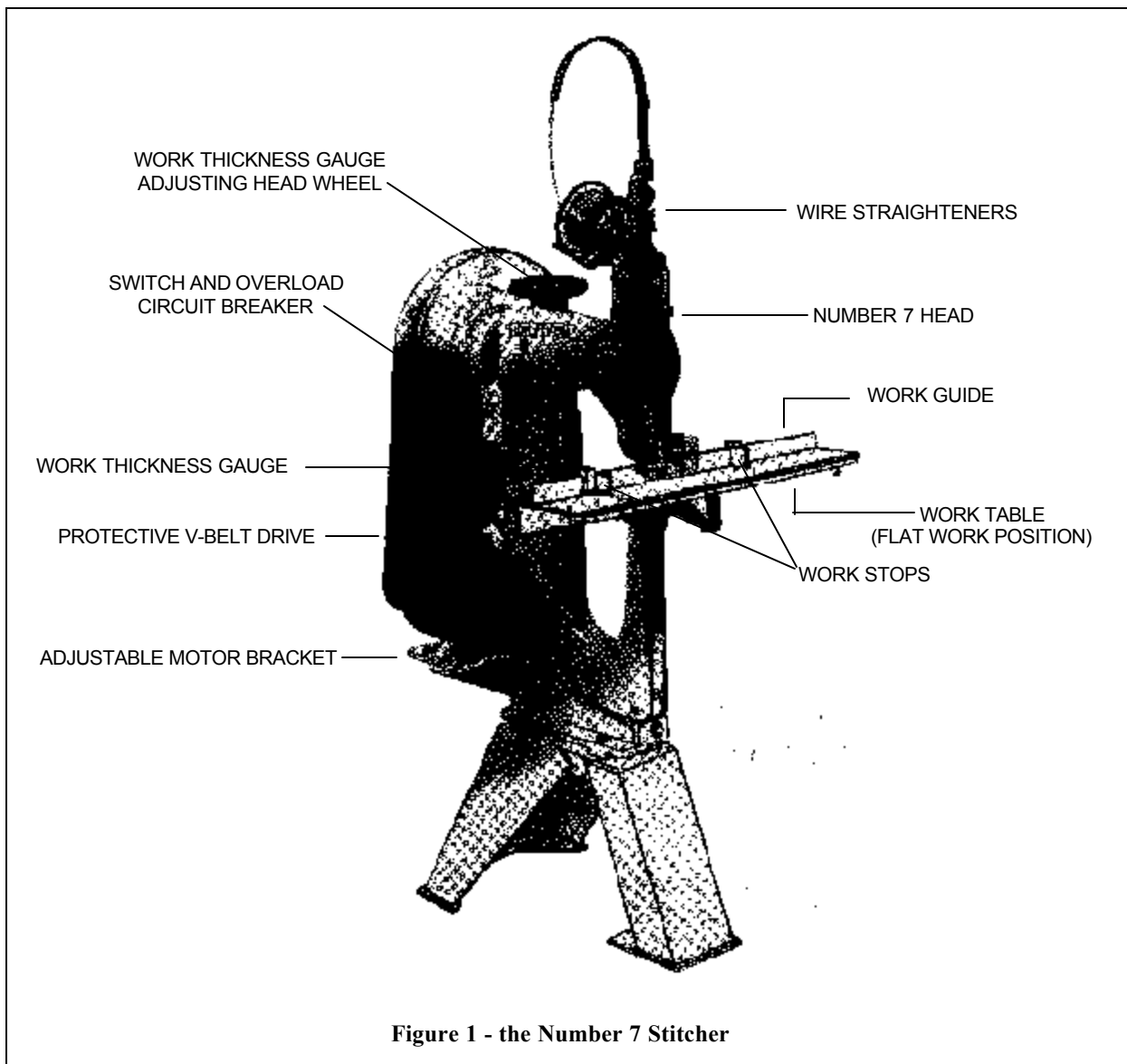
The recommended wire sizes to be used on the Number 7 Stitcher are as follows: round wire - 28 to 24 and flat wire - 20 x 24, 20 x 25, and 21 x 25. The above wire sizes can be used without changing parts. However, for heavy flat work it is recommended that the special flat work Driver be substituted for the standard Driver.

The Number 7 is easily adjustable for changing from saddle work to flat work by means of the tilting work table. Figure 1 shows the stitcher set for flat work operation. An adjustable work guide and adjustable work stops are easily attached to the work table and provide for accurate registering of flat work for uniform spacing of staples. When the work guide is not being used it can be attached to the right side of the stitcher's frame, where screw holes are provided for attaching the guide (using the same screws which attach it to the work table), thereby providing a convenient storing place for the guide. In addition, work table extensions, both front and back, are provided to accommodate the larger sizes of work to be stitched.

The Model Number 7 is foot-switch operated and is belt driven by a 1/3, HP motor, making possible operating speeds up to 125 stitches per minute. The motor is mounted on an adjustable bracket which can be raised or lowered for adjusting the tension of the driving belt. The machine driving mechanism is thoroughly shielded thus preventing the possibility of personal injury.

Operating Adjustments

The quality and quantity of work that can be stitched on the Number 7 machine is dependent upon the operator making the various operating adjustments as accurately as possible. The following illustrated instructions and information are provided so that the operator will clearly understand how to make the required operating adjustments.



Stitcher Head Door (Figure 2)

To open the stitcher head Door, press the Door Latch (1) to the right, thereby releasing the Latch from the Latch Catch and permitting the Door to swing to an open position (shown by the dotted line in Figure 2). To close the Door, first check that the machine is at the top of its stroke (the Supporter (2) will be at a forward position), then depress the Supporter back to its retracted position with one hand and close the Door with the other hand while compressing the Latch (1) until it catches in the Latch Catch.

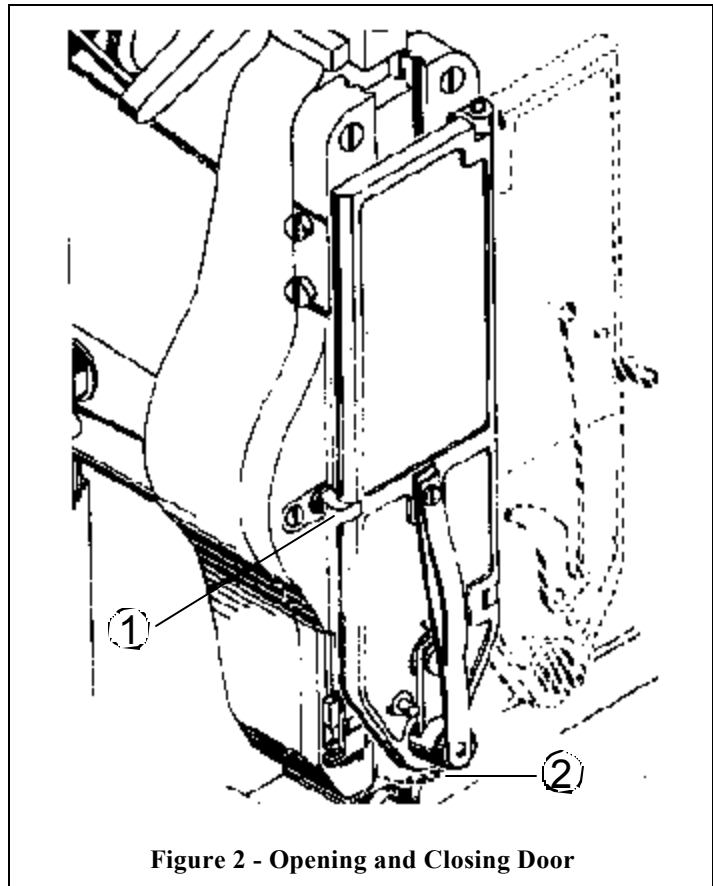


Figure 2 - Opening and Closing Door

Do not slam door shut, or attempt to force door shut while cycling machine or with machine positioned at bottom of stroke. Failure to comply with this may result in damage to the stitcher head.

CAUTION

Adjusting Thickness (Figure 3)

Turn the thickness adjustment handwheel (1) counter-clockwise (to the left) until the Column Gauge (2) has raised sufficiently to allow a sample of work to be stitched to be inserted between the Gauge and the Gauge Shelf, as shown in Fig. 3. With work held in this position, turn the handwheel (1) clockwise (to the right) until the work is firmly clamped between the Gauge (2) and the Gauge Shelf;

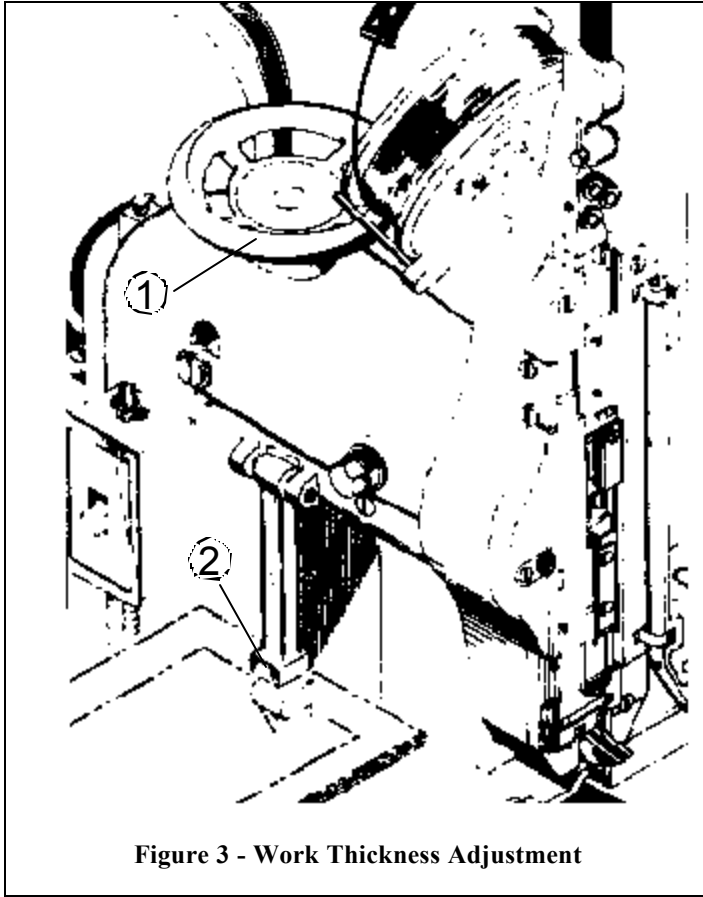


Figure 3 - Work Thickness Adjustment

then turn the handwheel to the left, raising the Gauge just far enough to permit work to be withdrawn from between the Gauge and the Gauge shelf. After withdrawing the sample work, turn the handwheel to the right until the Gauge has returned to the point at which it clamped the work.

Wire Gauge	Type of Work	20# Stock
Install 7089E Driver / 7257B Clincher Points for:		
28 Round	Light Flat or Saddle	2-10 Sheets
27 Round	Light Flat or Saddle	2-10 Sheets
26 Round	Light Flat or Saddle	2-10 Sheets
25 Round	Medium Flat or Saddle	10-50 Sheets
24 Round	Medium Flat or Saddle	10-50 Sheets
Install 7089F Driver / 7024B Clincher Points for:		
20 x 25 Flat	Heavy Flat Only	Over 50 Sheets
21 x 25 Flat	Heavy Flat Only	Over 50 Sheets
20 x 24 Flat	Heavy Flat Only	Over 50 Sheets
<p>* Note: 21x25 flat wire can be used for Heavy Saddle applications but it is not recommended. If 19x21-1/2 flat wire is required, contact your Graphic Arts Representative for the recommended parts.</p>		
Figure 4 - Recommended Wire Sizes		

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

⚠ WARNING

Wire Threading (Figure 5)

Open the Stitcher Head Door (1). Pass the wire from the Spool over the Wire Guide Spring (2), threading the wire between the Guide Studs on the Guide Spring and through the Oiler Felt in the Retainer (not shown). Thread the wire between the Rolls of the two sets of Wire Straighteners (3) and (4). Pass the end of the wire behind the Wire Clip (5) and then pull the wire down until it extends to just below the Wire Cutter Holder (6). Push the Wire Holder Slide (7) to the left. With the Slide held in this position, lay the wire well back in the slot (8) in the Wire Cutter Holder then release the Slide (7) allowing it to close over and retain the wire in the slot (8). Slide the Wire Retainer (9) up, thereby uncovering the groove in the Wire Guide (10). Lay the wire in the groove and then slide the Retainer (9) down securing the wire in the groove. Turn the machine over manually until the wire

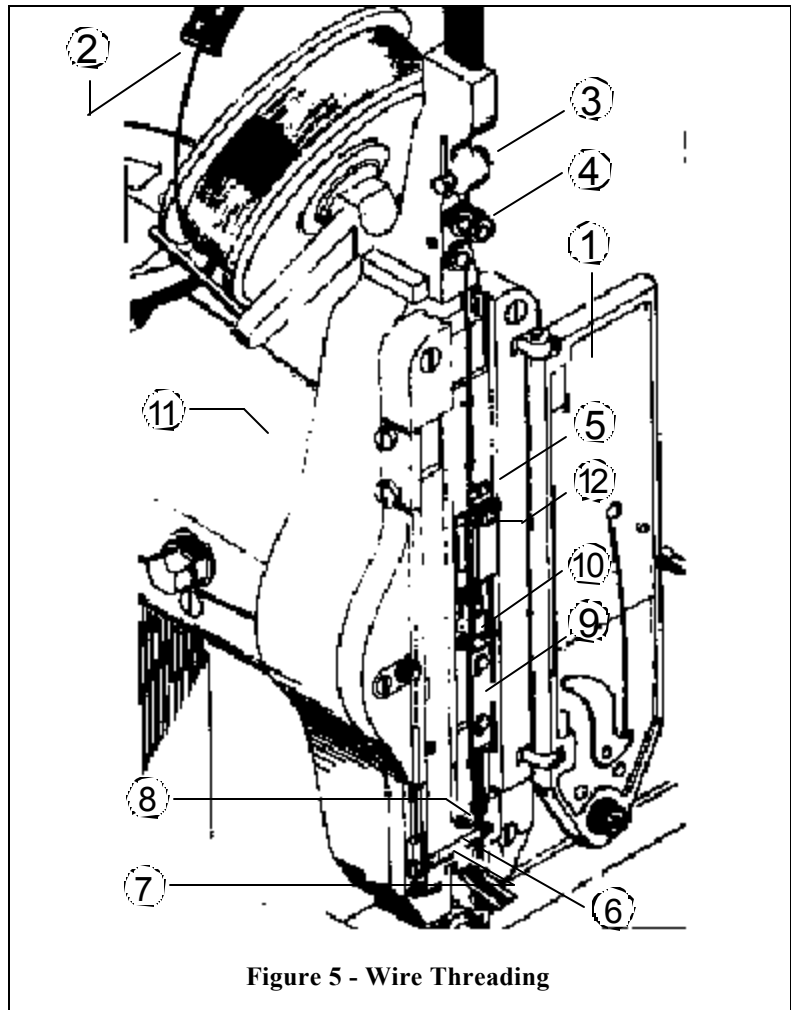


Figure 5 - Wire Threading

automatically falls in place between the Moveable and Fixed Grips (11) and (12).

The wire is now threaded in the Head. However, before operating the Stitcher under power, turn the machine over manually a few revolutions and observe that the wire is feeding freely and is being cut off by the Cutters in the Cutter Holder. Then close the stitcher head door and check that the wire is feeding in a straight vertical line, as directed in the following paragraph.

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

⚠ WARNING

Wire Straightening (Figure 6)

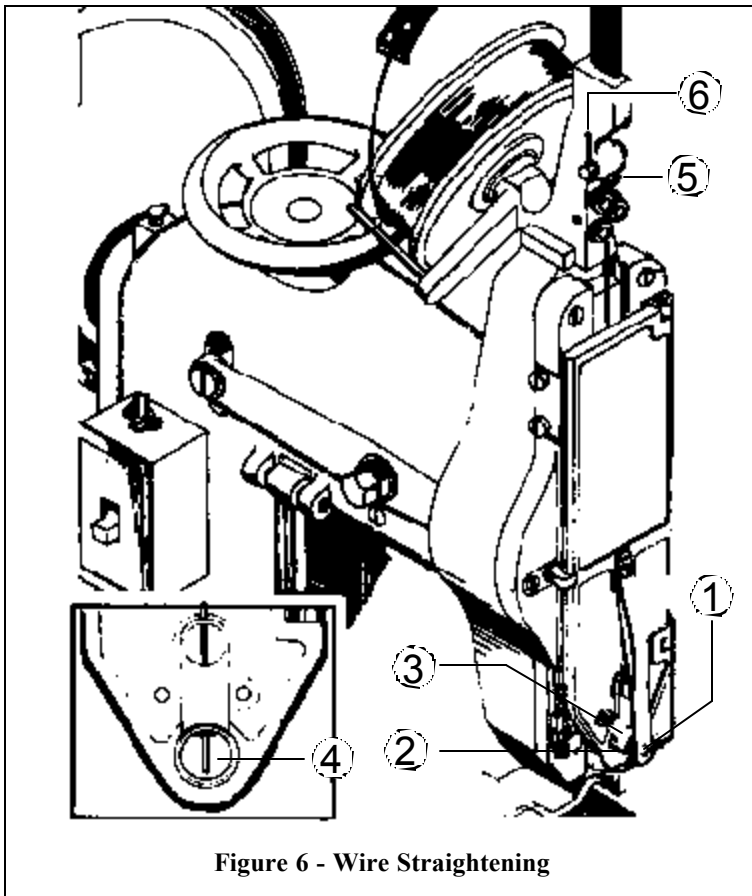


Figure 6 - Wire Straightening

In order to insure continuous operation of the Stitcher, it is important that the wire when being fed into the Swivel, enters in as close to a straight-vertical line as possible. To check this condition and make the necessary adjustments, proceed as follows. Disengage the Swivel Spring (1) from the Swivel (2) and withdraw the Swivel from its Bushing (3). Turn the machine over manually and observe by looking directly into the Swivel Bushing (4) that wire is being fed in a vertical line, as shown in insert Figure 6. If the wire is feeding to the left or to the right, turn the Lower Wire Straightener Eccentric Handle (5) clockwise or counter-clockwise as

required, until wire feeds in a vertical line. If wire is feeding in a straight line with respect to the left and the right but tends to curl forward or backward, turn the Upper Wire Straightener Eccentric Handle (6) until this condition is remedied. After the necessary adjustments have been made, replace the Swivel in its Bushing and attach the Swivel Spring.

Do not slam door shut, or attempt to force door shut while cycling machine or with machine positioned at bottom of stroke. Failure to comply with this may result in damage to the stitcher head.

⚠ CAUTION

Adjustments and Settings

Adjusting the Left Leg (Figure 7)

If staple is cut off center causing one leg to be longer than the other, the left leg of the staple can be shortened or lengthened as follows. Loosen but do not remove the two Wire Feed Adjustment Rack Screws (1) permitting the Adjustment Rack (2) to be moved up or down. If a shorter left leg is required, move the Adjustment Rack (2) up slightly. If a longer left leg is required, move the Adjustment Rack down slightly.

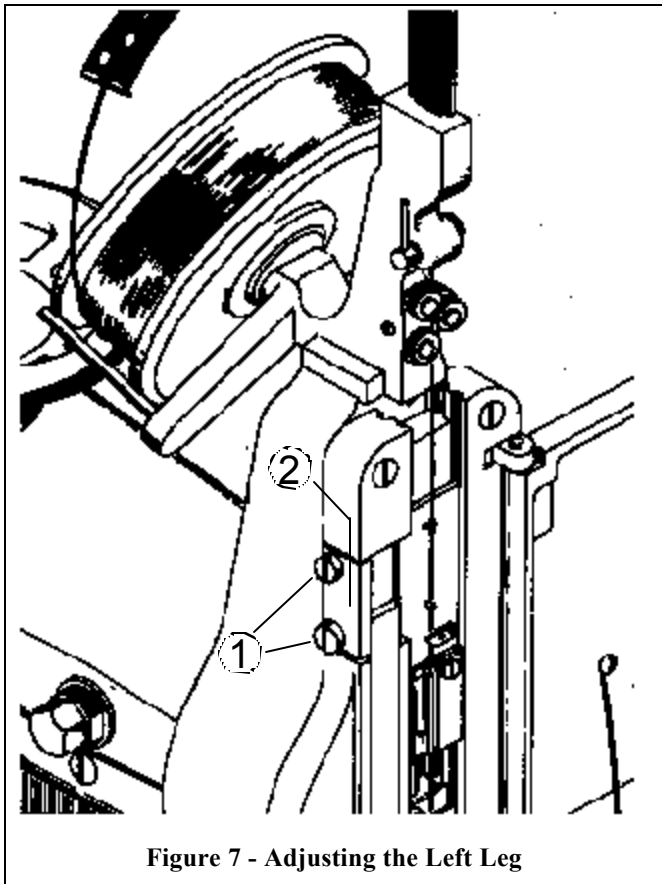


Figure 7 - Adjusting the Left Leg

After positioning the Adjustment Rack, tighten the Adjustment Rack Screws (1) and turn the machine over a few revolutions to check the stitches. If the staple is still off center, repeat the preceding steps until a perfect stitch is obtained. With a little experience, the operator will soon learn how much to raise or lower the Adjustment Rack to obtain the correct staple leg length. After the final adjustment has been made, securely tighten the Adjustment Rack Screws (1).

If the machine is operated on work thicker than it is set to handle, damage will result.

WARNING

Adjusting Both Legs (Figure 8)

If the staple legs are centered but are too long or too short, adjust amount of wire feed as follows:

Loosen the Adjustment Lever Eccentric Bushing Screw (1) sufficiently to release the knurled Eccentric Bushing (2). If longer staple leg is required, turn the Eccentric Bushing (2) clockwise (toward the front of Stitcher); if shorter staple leg is required, turn the Bushing counter-clockwise (toward rear of the Stitcher).

After adjusting the Eccentric Bushing, tighten the Bushing Screw (1) and turn the machine over a few revolutions to check the stitches. If the legs are still not the required length, repeat the preceding steps until a perfect stitch is obtained. With a little experience the operator will soon learn how far to turn the Eccentric Bushing to obtain the desired staple leg length.

After final adjustment has been made, securely tighten the Eccentric Bushing Screw (1).

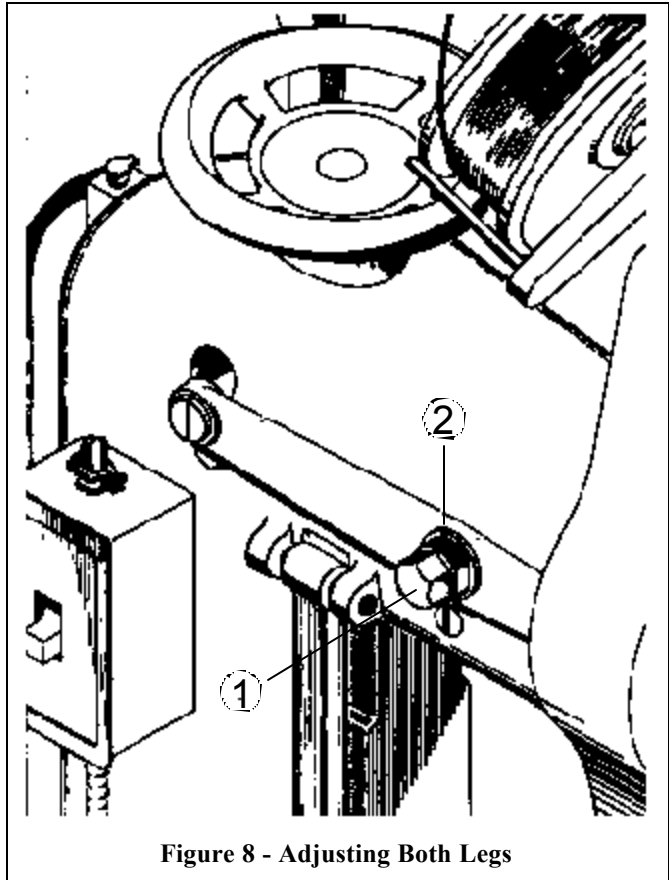


Figure 8 - Adjusting Both Legs

Adjusting the Clincher Points (Figure 9)

If the staples are being loosely clinched (see Staple N and O in the Trouble Shooting Chart on page 15), requiring the raising or lowering of the Clinchers, proceed as follows.

Remove the Retaining Screw (1) securing the Clincher Slide (2) to the Actuating Link Plunger (3). Loosen the Plunger Set Screw (4) and then turn the Plunger (3) to the left or to the right as required, to raise or lower the clincher slide. Replace and tighten the Retaining Screw (1) in the Plunger Screw hole now facing the front of the machine, and then tighten the Plunger Set Screw (4).

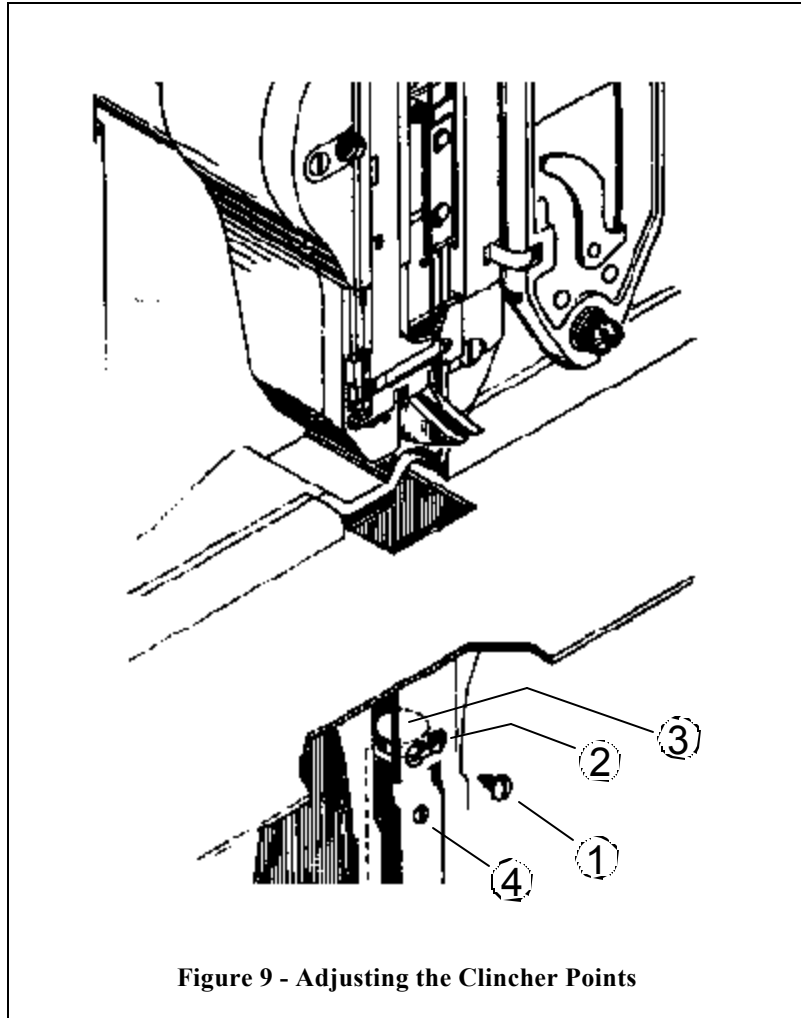


Figure 9 - Adjusting the Clincher Points

Maintenance

To insure continuous operation of the Number 7 Stitcher the operator should be sure that the machine is regularly lubricated and carefully maintained. The operator should periodically inspect all moving parts for signs of wear and when required, replace the worn parts. Some parts such as the Wire Cutters, the Wire Grip, and the Driver have been so designed as to provide duplicate cutting and gripping surfaces. If after continuous usage, the original cutting or gripping surfaces show signs of wear, their position in the head can be reversed, thereby providing a new surface and lengthening the life of the part.

The following instructions are provided so that the operator will clearly understand how to lubricate the machine, how to reverse or replace the parts referred to above, and how to adjust the clutch.

Lubrication (Figure 10)

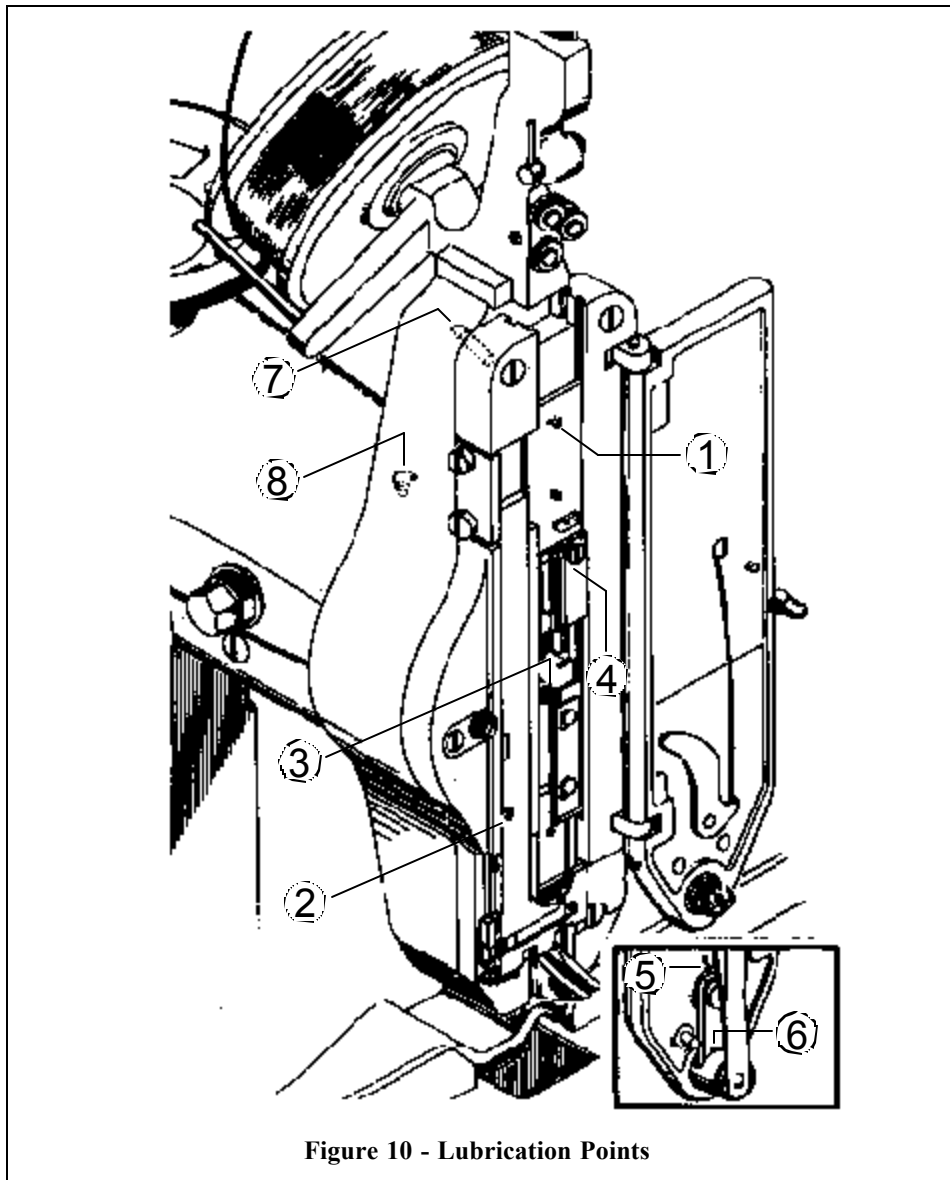


Figure 10 - Lubrication Points

Use a S.A.E. Number 10 oil for lubricating the Number 7 Stitcher. Machines that are in constant operation should be lubricated daily. Machines that are operated periodically should be lubricated just prior to running a job.

Usually only a drop of oil is required at each point of lubrication in the Stitcher Head. Care must be taken that those parts of the machine that contact the work being stitched are free from oil. Lubricate regularly instead of excessively. Excessive oiling will result in work becoming oil-spotted.

After lubricating the machine, wipe off any excessive oil.

- Oil hole in the Wire Feed Slide (1).
- Oil hole in the Wire Cutter Holder (2).
- Oil hole in the Swivel Operating Cam Roll Stud (3).
- Moving parts in this area (4). It is recommended that a toothpick tipped with oil moistened cotton dressing be used to lubricate these parts. (Apply just enough oil to keep these parts moist).

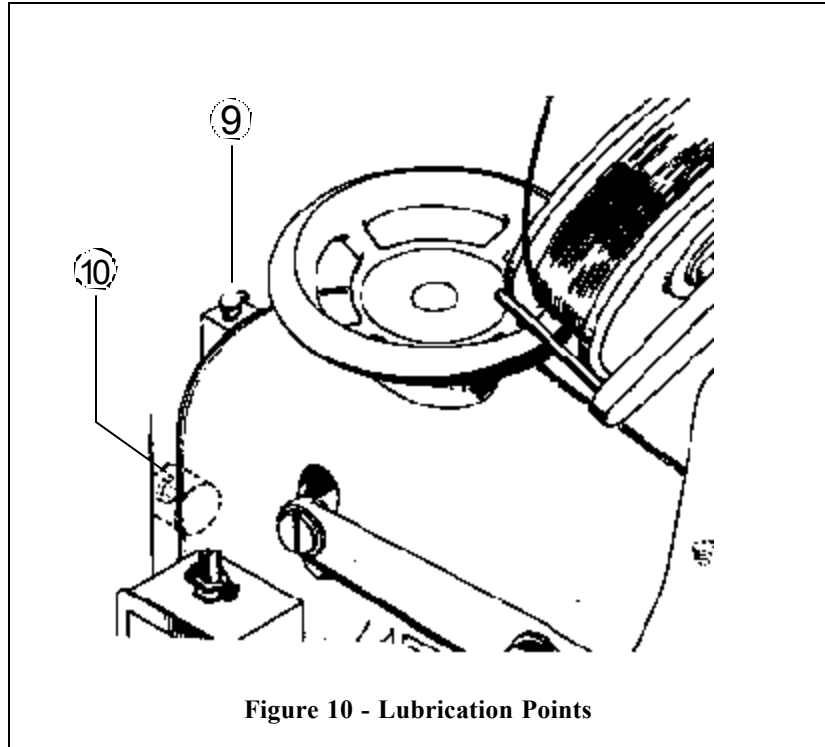


Figure 10 - Lubrication Points

- Oil slot in the Door (5) for the Swivel Operating Lever.
- Opening in Swivel Bushing (6).
- Oil tube in machine frame (7) for lubricating Main Shaft Connecting Link.
- Oil cup in frame (8) for lubricating main Drive Shaft.
- Oil cup in frame (9) for lubricating main Drive Shaft.
- Oil hole in Clincher Driving Bar Roll Stud (10).

Removing the Wire Cutters (Figure 11)

The Wire Cutters have four cutting edges, each of which may be used by reversing the ends and position of the Cutters in the Cutter Holder. To remove and replace the Cutters proceed as follows. Raise the Wire Cutter Retainer (1) and slide the Upper Wire Cutter (2) out from the Cutter Holder (3). Raise the Lower Wire Cutter (4) to the Upper Wire Cutter position and then slide the Cutter from the holder.

To replace the Cutters, first insert the Cutter that is going to be the Lower Wire Cutter into the Cutter Holder, being sure that the slot in the center of the Cutter is toward the rear of the machine. Slide the Cutter into the Holder until it drops down to its bottom position. Slide the second Cutter into the Holder and then lower the Cutter Retainer (1) back into operating position, thereby locking the Cutters in the Holder.

Turn the machine over manually and check that the Cutters are operating freely.

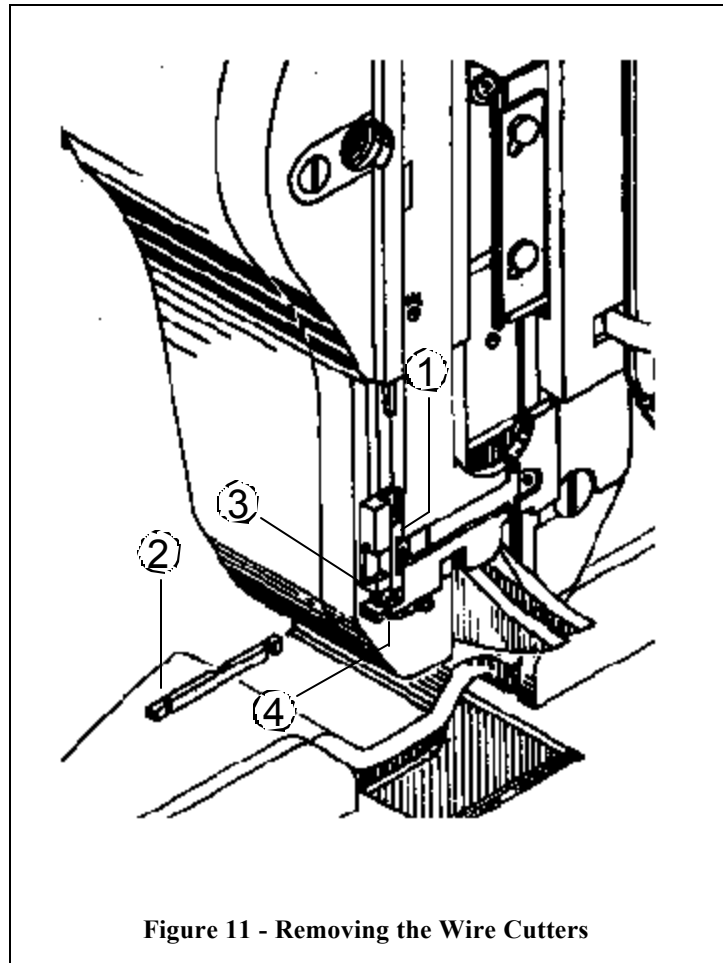


Figure 11 - Removing the Wire Cutters

Removing the Wire Grip (Figure 12)

The Fixed Wire Grip (1) has two saw-toothed gripping surfaces permitting the reversing of the Grip when one side shows signs of wear. To remove and replace the Grip, proceed as follows. Disengage the Moveable Wire Grip Spring (2) from the Moveable Wire Grip (3). Remove the Wire Grip Retaining Screw (4) permitting the removal of the Fixed Wire Grip (1) from the Grip Holder (5). Reverse and replace the Grip in the Grip Holder, replace and tighten Grip Retaining Screw, and re-engage the Spring with the Moveable Grip.

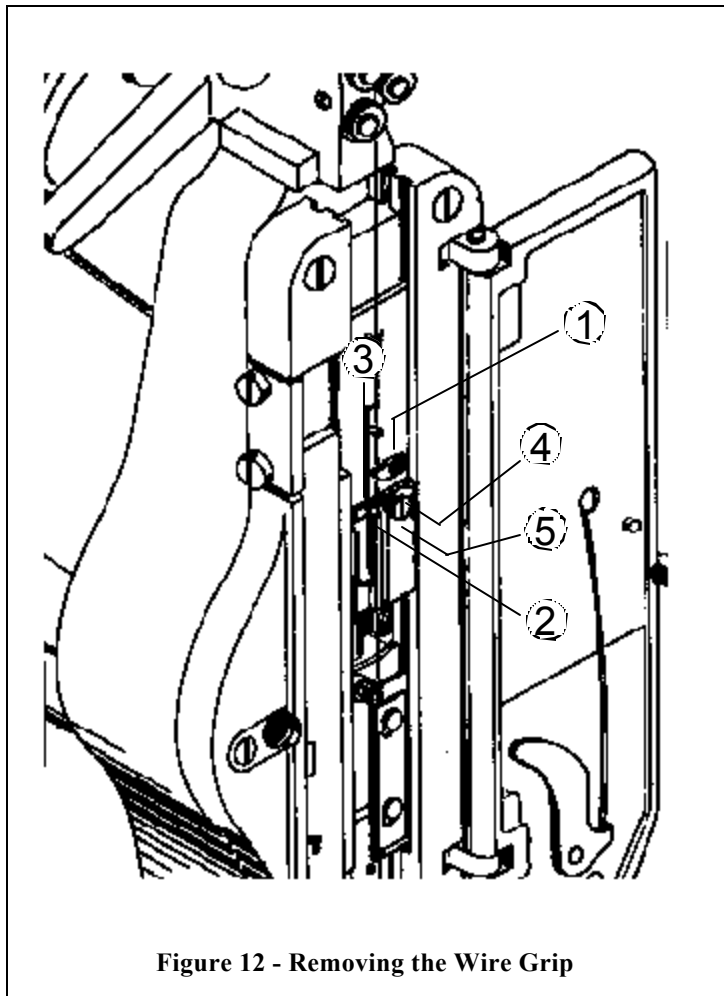


Figure 12 - Removing the Wire Grip

If the machine is operated on work thicker than it is set to handle, damage will result.

⚠ WARNING

Removing the Driver (Figure 13)

The Driver is double-ended and when one end is worn or damaged, it can be reversed thereby providing a new driving surface. To remove the Driver, proceed as follows. Set the Stitcher for maximum thickness work. (refer to the paragraph on page 2). Turn the machine over manually to the point where the Driver (1) is at its highest position and the release hole (2) in the Driver is still accessible.

Disengage the Supporter Spring Rod from the back of the Supporter (3) and then move the Supporter to its retracted position. Insert the Driver Release Pin (4), supplied with the Stitcher, in the release hole in the Driver, thereby depressing the Driver Retaining Spring. At the same time, push the Driver down until it can be withdrawn from the bottom of the Bender Bar.

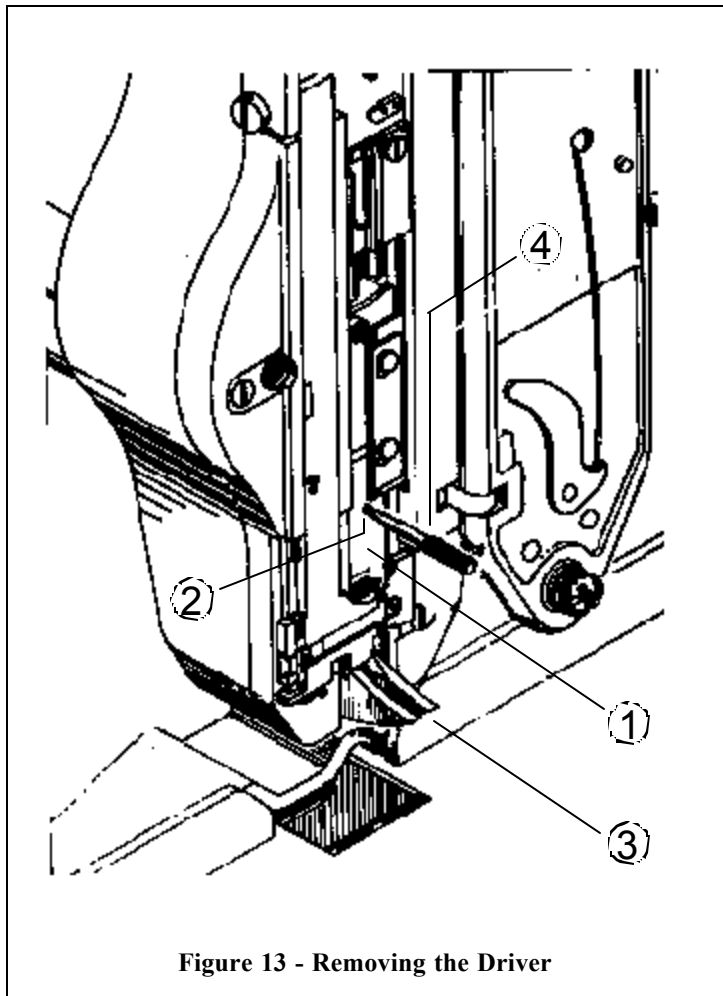


Figure 13 - Removing the Driver

After installing any new part, turn the machine over manually and check that the head operates freely.

Do not operate machine under power until certain that head is operating freely.

⚠ WARNING

Clutch-Brake Maintenance

Always disconnect the power supply before making any adjustments or servicing the stitcher



This stitcher is equipped with a solenoid actuated, continuous trip, wrap spring, clutch-brake unit. It is a dependable device that seldom needs service, but should a malfunction occur, the following information will serve as a service and trouble shooting guide for maintenance of this unit.

Actuator

The actuator is a simple straight-forward mechanical linkage. When the actuator does not trip the following checks should be made.

Problem	Cause and Remedy
No power to the Coil	Check all wiring and switching in the Clutch actuating system.
Lack of continuity in the Coil Windings	Replace the Coil
Mechanical binding of the Plunger	The Coil may have shifted or the Plunger end may have mushroomed due to striking the Backstop. In the latter the Plunger may be filed to its true diameter.
Insufficient clearance for the Actuator over the Stop Collar	Adjust the Linkage as needed
Actuator loaded by the Stop Collar so hard that the Actuator cannot be pulled by the Coil.	Braking force is exceeding the limits of the Brake or the Differential setting of the unit is too close (see Assembly & Disassembly for instructions)

Figure 27 - Actuator Checklist

Clutch and Brake Springs

With the brake engaged (full limit of output), the input hub should be free to rotate by hand. With the clutch engaged, the input and output hubs should rotate together. If the unit does not rotate in either of these modes, the clearance between the hubs of the unit on the shaft may have been disturbed or damaged. See Assembly/Disassembly instructions for re-adjusting.

Listed below are additional checks to be made if the clutch does not function correctly.

Problem	Cause and Remedy
Clutch Brake does not drive but Input Motor turns	<ol style="list-style-type: none"> 1. Drive Spring may be broken at the crossover point from an overload caused by a jam. Replace the Spring and check the Hubs for damage. 2. The Control Collar may not snap forward because of foreign matter restricting movement. Clean unit. 3. Actuator Assembly does not pull in.
Clutch Brake jams and stalls Input Motor	<ol style="list-style-type: none"> 1. Spring tang broken off Drive Spring not allowing the Clutch to disengage while the Brake is engaged. Replace the Drive Spring. 2. Clutch output is bound up. Check the clearance between the Output Hub and the Brake Hub. 3. Completely out of adjustment caused by losing an internal Spring tang. Replace Spring.
Output does not repeat stopping point	<ol style="list-style-type: none"> 1. Not enough inertia to actuate Brake. 2. Tang broken off the Brake Spring. Replace the Spring. 3. Adjustable Collar Locking Screw may be loose allowing Adjusting Screw to rotate.

Figure 27 - Actuator Checklist

Disassembly

When disassembling the Clutch-Brake unit, always mark the Spring Tang locations with reference to which slots they go in if the same Springs are to be used in re-assembly.

To disassemble the Clutch-Brake unit it will first be necessary to remove the Drive Pulley from the stitcher by removing the V-belt and Pulley Washer (7679) and then by disconnecting the Anchor Strap (7680) from the Clutch Plate. Disconnect the wires from the Solenoid, swing the Anchor Bracket down out of way and carefully slide the Pulley and Clutch off as a unit. Remove the Drive Pulley from the Input Hub. Next, release the Actuator Lever so that the Clutch is engaged and the Brake is released. Remove the Retaining Ring and Shim Washer, if any, from the input Hub end. Remove the Input Hub by rotating opposite to the drive direction. Remove the Retaining Ring and Shim Washer, if any, from the Mounting Plate end. Remove the Output Shaft Springs and Control Collar assembly by rotating the Output Shaft in the drive direction. **(DO NOT DISASSEMBLE THE BRAKE HUB FROM THE MOUNTING PLATE.)** Remove the Control Collar from the Output Shaft and Spring assembly by extracting towards the Brake Spring end.

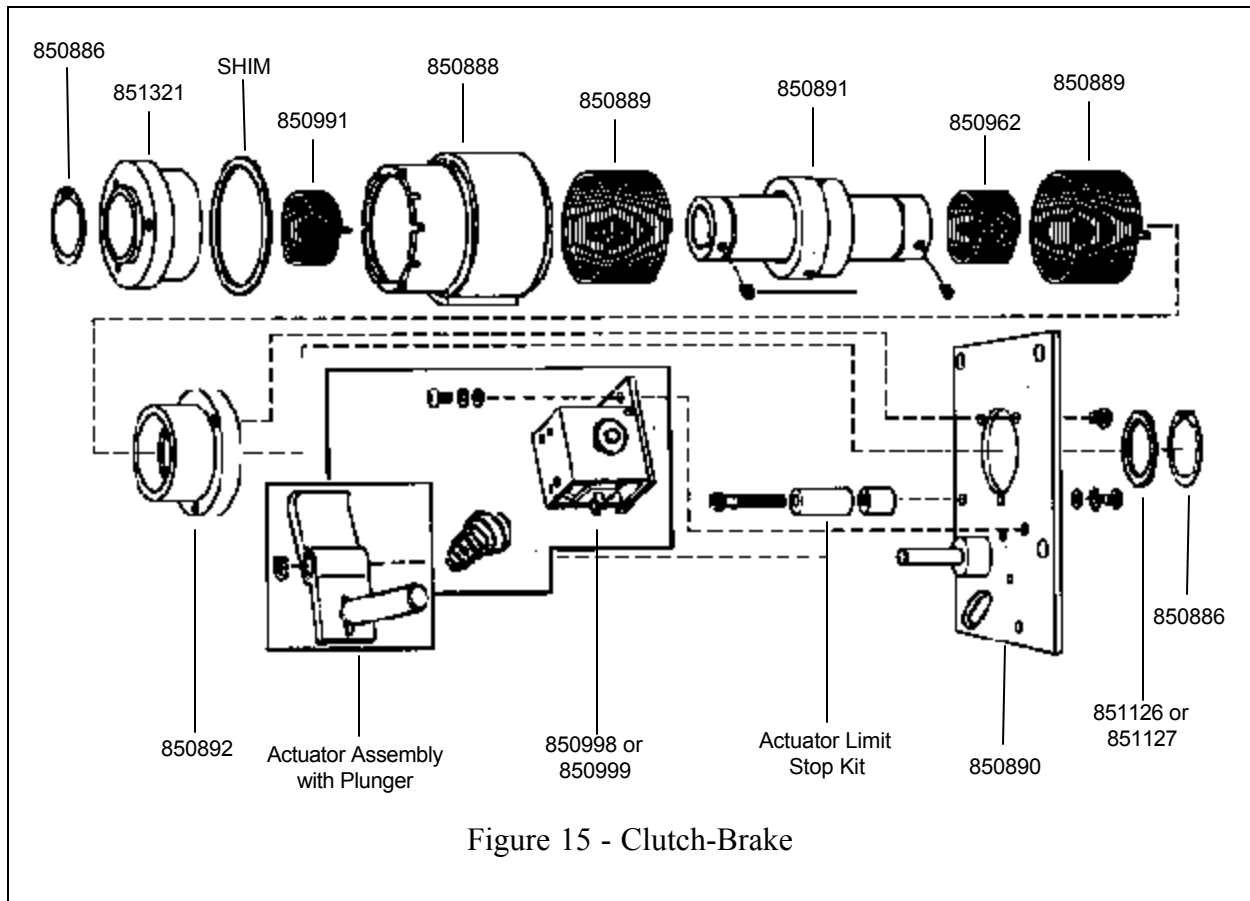
Assembly

Replace the Clutch, Brake and Anti-Back Up Springs as required. Assemble the Springs concentric and square to the Output Shaft. Assemble the Control Collar over the Output Shaft and Spring Assembly, by inserting from the Brake Spring end. It will be necessary to extend the Brake Spring using long needle-nose pliers. Place the Brake Spring tang in any one of the nine (9) Control Collar slots at random. Assemble the Output Shaft, Springs and Control Collar assembly to the Mounting Plate assembly by rotating the Output Shaft in the drive direction. Assemble the Retaining Ring to the Output Shaft at the Mounting Plate end with the smooth surface facing the Brake Hub. Check end play between the Hub and the Retaining Ring with a feeler gauge. There should be .004 to .010 end play. Use shim washer to adjust if not. Rotate the Output Shaft in the drive direction, until it reaches a full brake position. With the Clutch Spring Tang not in a slot, insert the Input Hub by rotating opposite to the drive direction. Select the one of ten (10) Control Collar slots for the Clutch Spring Tang that will provide a .38 to .50" circumferential overtravel of the Control Collar when released.

At this point it may be necessary to reselect one (1) of the nine (9) Control Collar slots for the Brake Spring Tang. Release the Actuator Lever, remove the Clutch Spring Tang from the slot, then move the Control Collar axially towards the Input Hub end and rotate it opposite to the drive direction to

pick up next slot. Repeat this step until the .38" to .50" specification is achieved. Assemble the Retaining Ring to the Output Shaft at the Input Hub end (the smooth surface facing the Input Hub). Check end play between the Input Hub and the Retaining Ring with a feeler gauge. There should be .002 to .003 end play on the Input Hub. Reassemble the unit to the machine.

IMPORTANT: After the Clutch is assembled to the machine, the Clutch Plate should be free to float on the Bearing. The Anchor Strap is only to prevent Plate rotation.



Coil Replacement

Place the spring onto the plunger with the narrow end towards the actuator. Slide the solenoid onto the actuator and plate assembly. Assemble the solenoid to the plate assembly with the cap screws and washers. **DO NOT TIGHTEN** more than finger tight.

Energize the coil and adjust the gap between the actuator and the top of the collar stop to 0.015" to 0.030" by sliding the solenoid assembly. Note: push the collar toward the actuator to allow for collar movement. Tighten the cap screws.

Lubrication

The clutch-brake unit is designed with bearing parts made from sintered metal that have been impregnated with oil and normally do not need to be re-lubricated. In cases where there is excessive duty, or the environment is such that it may "wick-out" oil, wash off oil, or fill the clutch with foreign matter, the unit may be re-oiled or flushed out with minimal or no disassembly by using a light bearing oil such as Shell Bearing Infusion Oil #33. If disassembly of the unit for cleaning and oiling is necessary, follow the detailed disassembly instructions to the point needed, flush and wipe parts in the oil to be used for re-lubrication. **DO NOT USE SOLVENT** to clean the parts. To get more cleaning action for the oil, it may be heated while cleaning the components, but bring the parts back to an ambient temperature by submerging them in cool oil.

Control Collar Adjustment (Figure 16)

The stopping position of the head can be changed if necessary by adjusting the position of the Stop Cam on the Control Collar Sleeve. Turn the power off, trip the Clutch by hand and rotate the Drive Pulley until the Driver is in the desired stopping position. Work the Retaining Ring "A" out of the groove and slide A forward on sleeve "C" (See Figure 16). Slide cam "B" off of the Splines and rotate until the desired relationship between the Stop and the Shaft Keyway has been achieved. Slide the Cam back onto the Splines. The Actuator Pawl will have to be held clear during this operation. Slide the Retaining Ring back into the groove.

Note: Make sure the Brake is locked up before proceeding to insure achieving the proper stop point.

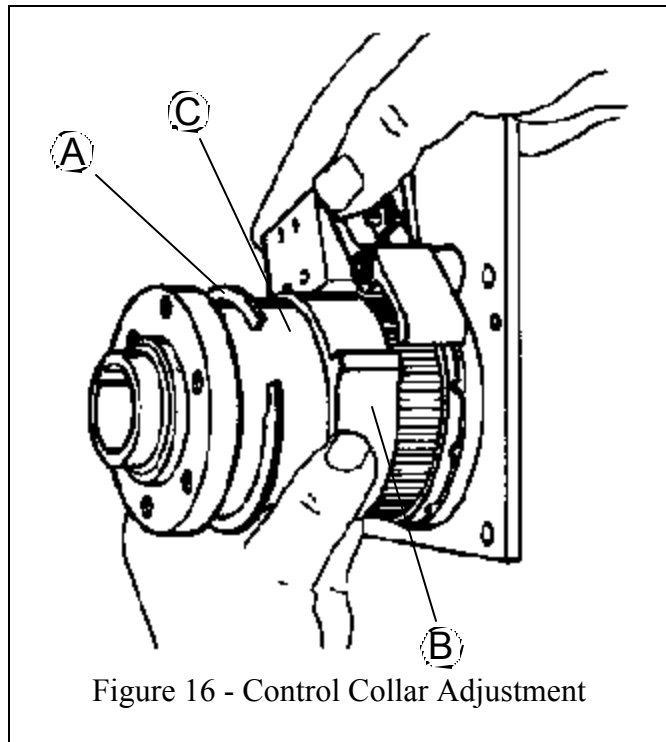
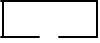


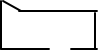

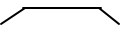


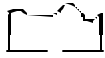
Figure 16 - Control Collar Adjustment

Troubleshooting (Formed Staples)

The quality and quantity of work that can be produced with the Number 7 Stitcher is dependent upon the operator making all adjustments as accurately as possible, and carefully maintaining the machine. The cause of staple imperfections usually can be traced to inaccurate settings and adjustments or normal wear of moving parts. In the event of trouble of this nature occurring, the operator can refer to the following Trouble Shooting Chart and quickly locate and remedy the causes of the trouble thereby reducing the time the Stitcher is inoperative.

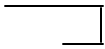
The first column of the chart illustrates the imperfect stitch while the second column describes the imperfections or troubles. The third column lists the probable cause or causes for the given trouble, while the fourth column lists the remedy or remedies for the troubles and also refers to the paragraph in this book in which will be found detailed information for making the necessary adjustments. If stitching is defective, the operator can compare the staple produced with the stitches illustrated in the chart and by carefully reading the information given for each type of imperfect stitch, remedy the cause of the imperfection.

	PROBLEM: Perfect Staple SOLUTION:
	PROBLEM: Right Leg Short SOLUTION: The Cutter is not properly adjusted in relation to the Swivel Shorten the left leg to make it the same length as the right leg (refer to page 4) then, adjust the length of both legs to the desired length (refer to page 5).
	PROBLEM: Left Leg Short SOLUTION: The Grip is clogged or worn or the left leg feed is not adjusted properly. Clean the Grip. Check for worn teeth and reverse or replace the Grip (refer to page 7). Adjust the length of the left leg (refer to page 4).
	PROBLEM: Staple Corner Buckled SOLUTION: The Driver is chipped or broken. Check the Driver ends for signs of damage and reverse or replace the Driver (refer to page 7).
	PROBLEM: Either or both legs buckled SOLUTION: The wrong wire size is being used for the job being stitched or the Wire Cutters are dull. Check to make sure the correct wire size is being used (refer to page 3). Check the Wire Cutters for wear and reverse or replace them (refer to page 6).
	PROBLEM: Partially Formed Staple SOLUTION: The Driver Bar Latch is worn and needs to be replaced.



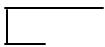
PROBLEM: Bent Crown

SOLUTION: The wrong wire size is being used for the job being stitched. The thickness adjustment setting could be incorrect or the Supporter is retracting too easily. Check to make sure the correct wire size is being used (refer to page 3). Check the work thickness adjustment setting (refer to page 6). Check the tension of the Supporter Spring and increase the tension or replace the Spring.



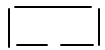
PROBLEM: Left Leg Missing

SOLUTION: The wire is slipping in the Grip. Clean the Grip unless it is worn, If worn, reverse the Grip within the Grip Holder or replace it (refer to page 7).



PROBLEM: Right Leg Missing

SOLUTION: The corner of the Swivel is too sharp. Check the Swivel. If the corner over which the wire is formed is too sharp, stone the corner slightly.



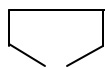
PROBLEM: Staple Comes out in Pieces

SOLUTION: Either the Swivel is sticking or its corner is too sharp. Clean and lubricate the Swivel (refer to page 6). Check the Swivel. If the corner over which the wire is formed is too sharp, stone the corner slightly.



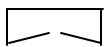
PROBLEM: Corners of Staple are Rounded

SOLUTION: The Swivel is worn and needs to be replaced.



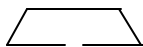
PROBLEM: Loose Clinch

SOLUTION: The thickness of work adjustment setting is wrong, the Clinchers are set too low. Correct the adjustment setting and raise the Clincher Points (refer to pages 5 and 6).



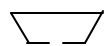
PROBLEM: Tight Clinch

SOLUTION: The thickness of work adjustment setting is wrong, the Clinchers are set too high. Correct the adjustment setting and lower the Clincher Points (refer to pages 5 and 6).



PROBLEM: Staple Legs are Spread

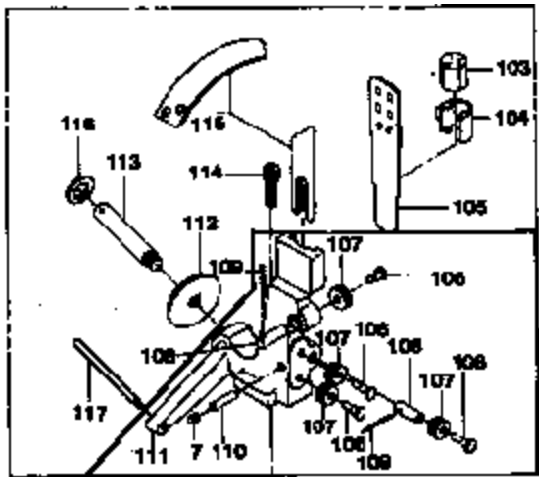
SOLUTION: The Wire Straighteners are not properly adjusted or the Wire Cutters and Bender Bar are worn. Adjust the Wire Straighteners (refer to page 4). Reverse or replace the Wire Cutters or replace the Bender Bar (refer to page 6).



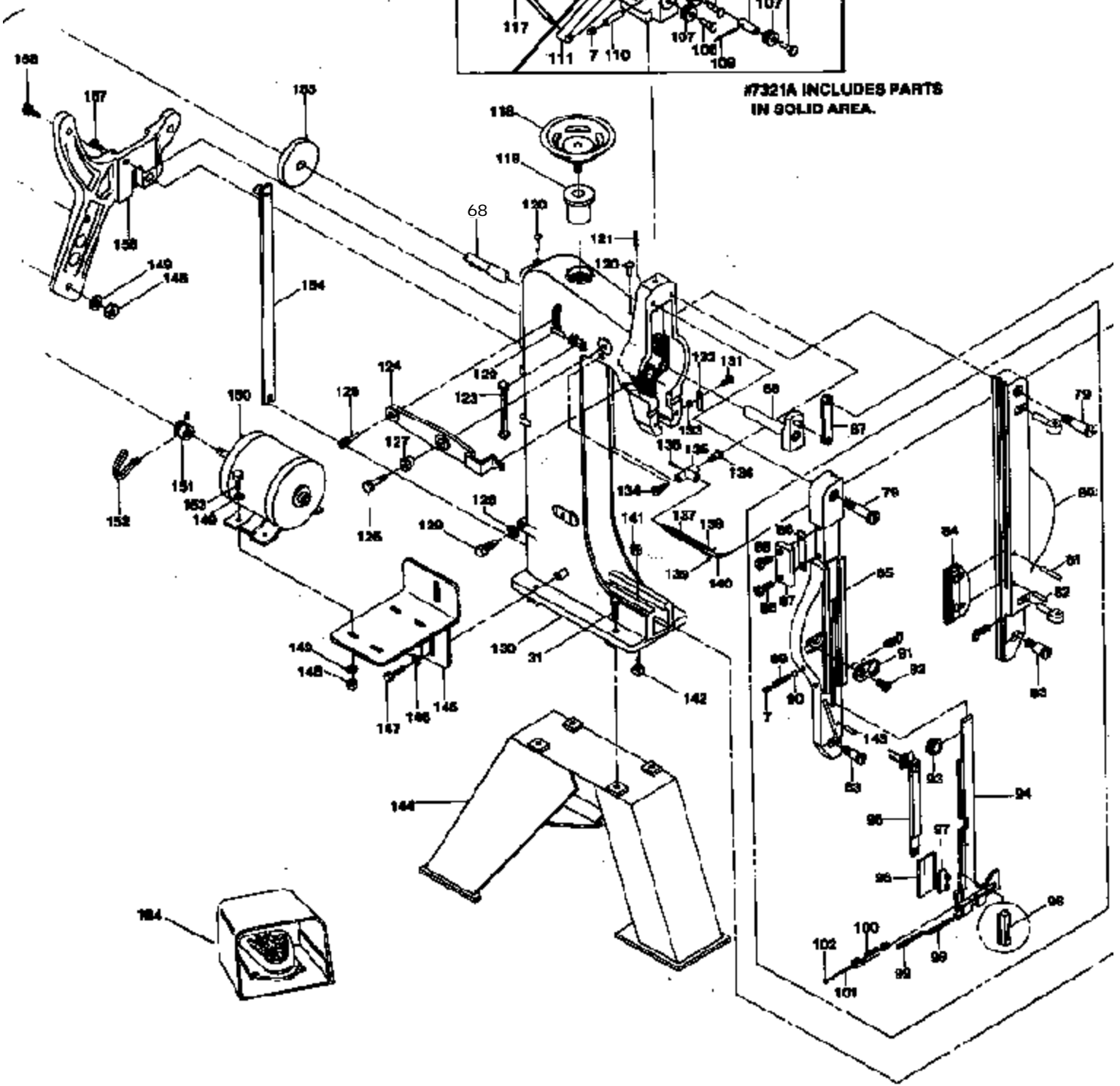
PROBLEM: Staple Legs are Contracted

SOLUTION: The Wire Straighteners are not properly adjusted or the Wire Cutters are worn.

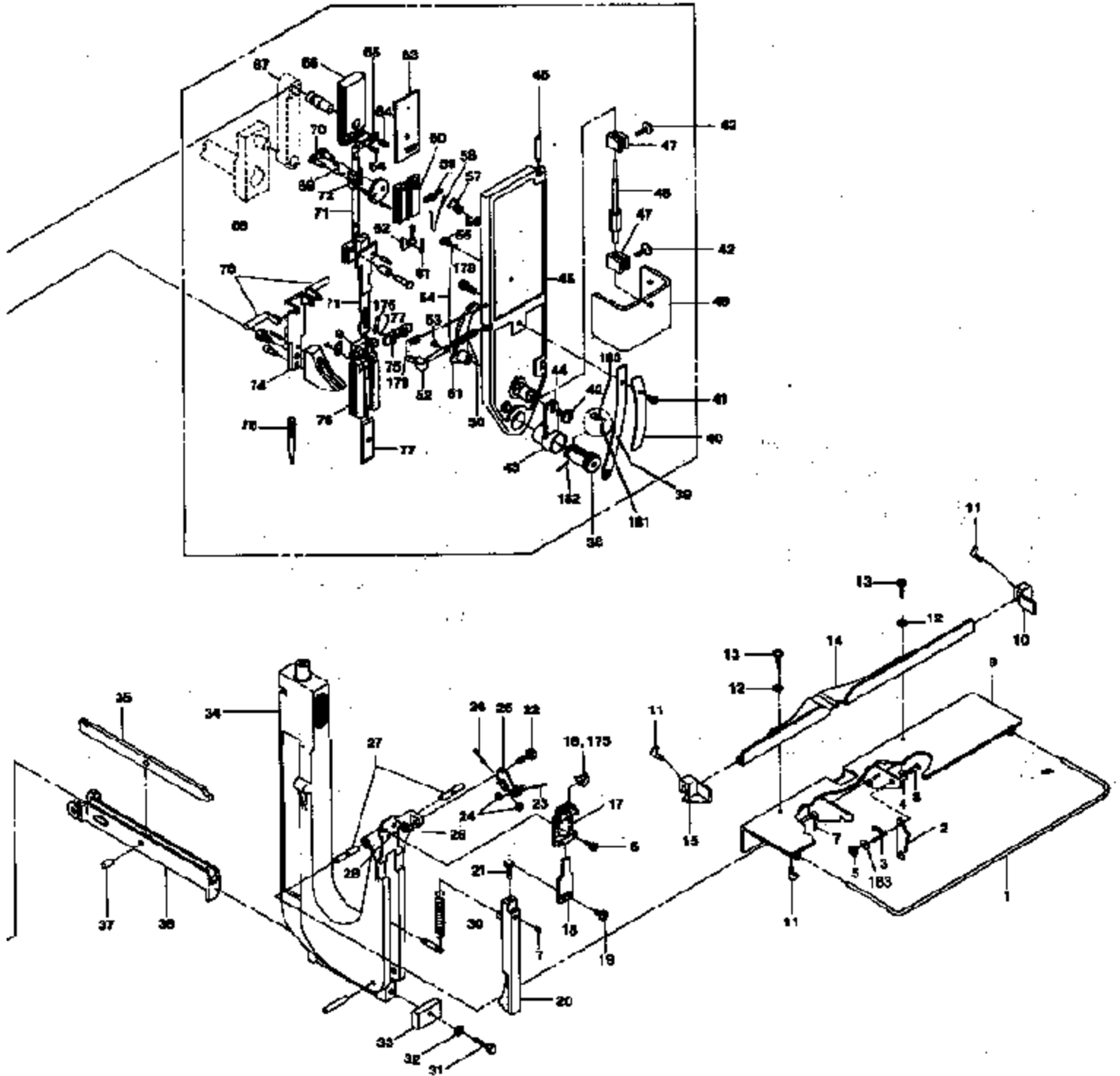
The #7/7AW Sticher Machine



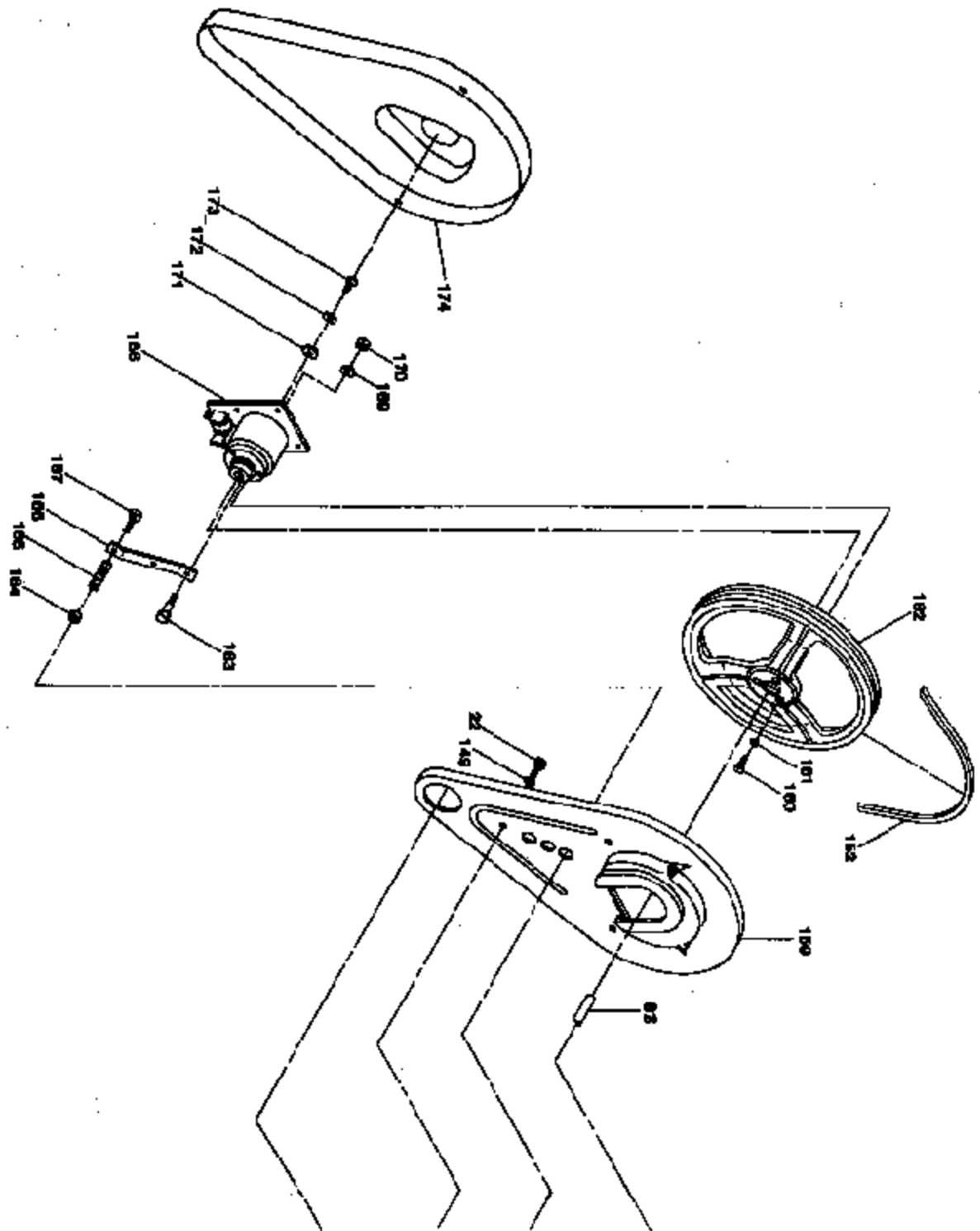
#7321A INCLUDES PARTS
IN SOLID AREA.



The #7/7AW Stitcher Machine



The #7/7AW Stitcher Machine



The #7/7AW Stitcher Machine

1.	7056	Work Table Extension
2.	7648	Table Support
3.	B554	Table Support Spring
4.	PW10.3	#10 Plain Washer
5.	HN103.24	#10-32 Hex Nut
6.	341	Clincher Plate Screw
7.	38	1/4"-28x3/8" Slotted Headless Set Screw
8.	UA3810.10	Table Support Stud
9.	7656A	Work Table
10.	7423	Work Stop - Right
11.	425	#10-32 binding Screw
12.	PW14	1/4" Plain Washer
13.	63	Work Guide Screw
14.	7201	Work Guide
15.	7424	Work Stop - Left
16.	7024B	Clincher - Curved - Flat Wire
17.	7253A	Clincher Plate
18.	7255	Clincher slide
19.	39	Clincher Slide Actuating Link Retainer Screw
20.	7034	Clincher Slide Actuating Link
21.	37	Clincher Slide Actuating Link Plunger
22.	UA5116.1	5/16"-I 8 x 1 " Hex Head Cap Screw
23.	UA4828.3	1/4"-2C x 1-3/4" Hex Socket Set Screw
24.	HN1420.2	1/4"-20 Hex Jam Nut
25.	7645A	Table Support Bracket
26.	UA4820.3	1/4"-20 x 1-1/4" Hex Socket Set Screw
27.	203B	Work Table Swivel Pin
28.	29	Clincher Plate Dowel
29.	HN51618.2	5/16"-I 8 Hex Jam Nut
30.	35	Clincher Slide Actuating Link Spring
31.	UA7124.1	7/16"-I 4 x 1-1/2" Hex Head Cap Screw
32.	179-010	Adjusting Washer (.010 thick)
	179-015	Adjusting Washer (.015 thick)
	179-050	Adjusting Washer (.050 thick)
33.	7192	Column Block
34.	7019BA	Column
35.	40	Clincher Slide Actuating Link Connection
36.	44B	Clincher Slide Actuating Link Connection Shoe
37.	41	Clincher Slide Actuating Link Connection Pin
38.	7138A	Swivel
39.	7140	Swivel Spring
40.	7265	Swivel Spring Reinforcing Strip
41.	154	Swivel Spring Screw
42.	7160	Swivel Operating Lever Screw
43.	7139A	Swivel Bushing
44.	7146	Swivel Operating Lever Sector
45.	7137A	Door
46.	7120	Door Hinge Screw
47.	7667	Pivot Block
48.	7666	Mounting Pin

The #7/7AW Stitcher Machine

49.	7665	Plastic Guard
50.	7180	Door Latch Spring
51.	7142	Swivel Operating Lever
52.	7115A	Door Latch
53.	7117	Door Latch Stop Screw
54.	7226	Swivel Operating Lever Spring
55.	7144	Swivel Operating Lever Spring Screw
56.	7135	Wire Grip Spring Screw
57.	7132B	Wire Grip - Fixed
58.	7134B	Wire Grip Spring
59.	7136	Wire Grip - Moveable
60.	7133A	Wire Grip Holder
61.	7176	Grip Operating Lever
62.	7178	Grip Operating Lever Slide
63.	7112A	Wire Feed Slide
64.	7088	Driving Bar Wedge Screw
65.	7173	Driving Bar Wedge
66.	7170A	Upper Driving Bar
67.	7065	Main Shaft Connecting Link
68.	7064BA	Main Shaft
69.	7190	Wire Feed Shoe Spring
70.	7126A	Feed Grip
71.	7091A	Driver Bar
72.	7154	Wire Feed Shoe
73.	7101	Supporter Crank Link
74.	7100A	Supporter
75.	7094	Driver Bar Latch
76.	7086A	Bender Bar
77.	7089E	Driver (Flat & Round Wire)
	7089F	Standard Driver (Flat Wire Only)
78.	5160	Driver Release Pin
79.	7084	Face Plate Screw - Upper
80.	7083A	Face Plate Assembly - Right
81.	7096	Driver Bar Latch Stop Pin - Right
82.	UB2106.5	1/8" x 3/8" Roll Pin
83.	7085	Face Plate Screw - Lower
84.	7111A	Wire Guide
85.	7082A	Face Plate Assembly - Left
86.	7110	Wire Feed Adjusting Rack Shim
87.	7113	Wire Feed Adjusting Rack
88.	7219	Wire Feed Adjusting Rack Screw
89.	7205	Wire Cutter Slide Friction Spring
90.	7204	Wire Cutter Slide Friction
91.	7199	Door Latch Catch
92.	7210	Door Latch Catch Screw
93.	7114	Wire Feed Adjusting Pinion
94.	7103A	Wire Cutter Holder
95.	7107A	Wire Cutter Slide
96.	7105	Wire Cutter Operating Slide Shoe Wedge
97.	7104	Wire Cutter Operating Slide Shoe

The #7/7AW Stitcher Machine

98.	7109	Wire Cutter Retainer
99.	7102	Wire Cutter
100.	7130	Wire Holder Slide
101.	7166	Wire Holder Slide Spring
102.	7168	Wire Holder Slide Spring Pin
103.	2167	Oiler Felt
104.	2166	Oiler Felt Retainer
105.	2165	Staple Wire Oiler Plate
106.	7278	Wire Straightener Roll Stud
107.	7277	Wire Straightener Roll
108.	7282	Wire Straightener Eccentric
109.	UB3912.2	Wire Straightener Eccentric Pin
110.	7281	Wire Straightener Eccentric Friction
111.	7276	Wire Straightener Bracket
112.	2245	Spool Stud Washer - Large
113.	7155	Spool Stud
114.	UA6816.2	3/8"-I 6 x 1 " Hex Socket Head Cap Screw
115.	7153A	Wire Guide Spring
116.	174	Spool Stud Washer - Small
117.	7227	Wire Straightener Bracket Stud
118.	143A	Hand Wheel
119.	7020	Column Bushing
120.	85202	Oil Cup
121.	UB4122	1/4" x 1-3/8" Roll Pin
122.	7022	Column Gauge Pin
123.	7021	Column Gage
124.	7123	Adjusting Lever
125.	7124	Adjusting Lever Stud
126.	7122	Adjusting Lever Eccentric Bushing Screw
127.	7121	Adjusting Lever Eccentric Bushing
128.	SW58	5/8" Internal Tooth Lock Washer
129.	7006	Actuating Link Connecting Shoe Stud
130.	7017A	Frame
131.	UA3812.3	*10-32 x 3/4" Thumb Screw
132.	320	Finger Guard
133.	321	Finger Guard Collar
134.	7244	Supporter Spring Rod Guide Stud
135.	7243	Supporter Spring Rod Guide
136.	UA2304.1	*8-32 x 1/4" Round Head Slotted Machine Screw
137.	7240	Supporter Spring
138.	7242	Supporter Spring Rod Collar
139.	UB2908.1	3/32" x 1/2" Cotter Pin
140.	7241	Supporter Spring Rod
141.	HN3816.2	3/8"-I 6 Hex Jam Nut
142.	UA6832.3	3/8"-16 x 2" Square Head Set Screw
143.	7236	Driver Bar Latch Stop Pin
144.	1C	Base
145.	261CA	Motor Bracket Assembly
146.	PW38	3/8" Plain Washer
147.	UA6116.1	3/8"-16 x I" Hex Head Cap Screw

The #7/7AW Stitcher Machine

148.	HN51618	5/16"-18 Hex Nut
149.	PW516	5/16" Plain Washer
150.	850269B	Motor (1/3 HP 60Hz 1725rpm 5.8A)
151.	11399A	Motor Pulley
152.	850730	V-belt
153.	UA5112.1	5/16"-I 8 x 3/4" Hex Head Cap Screw
154.	7047A	Clincher Driving Bar
155.	7677	Clincher Cam
156.	7682	Belt Guard Bracket
157.	UA3808.1	*10-32 x 1/2" Hex Socket Head Cap Screw
158.	UA7816.1	7/1 6"-I 4 x 1" Hex Socket Head Cap Screw
159.	7675	Belt Guard Mounting Plate
160.	UA4812.7	1/4"-20 x 3/4" Hex Socket Flat Head Cap Screw
161.	SWI 4.1	1/4" Counter Sunk External Tooth Lock Washer
162.	7678	Drive Pulley
163.	7681	Clutch Anchor Screw - Top
164.	HN3816	3/8"-16 Hex Nut
165.	141H3	Clutch Anchor Bolt Spring
166.	7680	Clutch Anchor
167.	UA6140.1	3/8"-16 x 2-1/2" Hex Head Cap Screw
168.	850671	Wrap Spring Clutch Assembly (for 115V Service)
168 (2)	850672	Wrap Spring Clutch Assembly (for 230V Service)
169.	SWI 4	1/4" Internal Tooth Lock Washer
170.	HN1420.5	1/4"-20 Hex Nut
171.	7679	Driving Pulley Washer
172.	SW516.3	5/16" Counter-sunk External Tooth Lock Washer
173.	UA5820.8	5/16"-18x 1-1/4" Hex Socket Flat Head Cap Screw
174.	7676	Belt Guard
175.	7257B	Clincher Point - Straight
176.	7090	Driver Spring
177.	7202	Driver Spring Rivet
178.	UA4808.17	Screw 1/4 - 28 x 1/2
179.	UA2804.6	Set Screw
180.	7232	Swivel Hook
181.	7234	Swivel Hook Spring
182.	7233	Swivel Hook Pin
183.	PW10.3	#10 Plain Washer
*184	851701	Foot-switch

REGISTRATION

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

CUSTOMER

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

PRODUCT

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

DEALER

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

Other Bindery Products Used : _____

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

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

PRODUCT

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

DE LUXE STITCHER GRAPHIC ARTS REPRESENTATIVE

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

Common Replacement Parts

Below is a list of the most common wear/replacement parts for the #7 Stitcher Machine. 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 46-48 in this manual.

Description	Item Number
Clincher Plate	7253A
Clincher Points	7024B or 7257B
Driver - Standard or Flat	7089E or F
Driver Bar Assembly	7091A
Driver Bar Latch	7094
Fixed Wire Grip	7132B
Grip Operating Lever	7176
Grip Operating Lever Slide	7178
Left Driver Bar Wedge	7095
Moveable Wire Grip	7136
Right Driver Bar Wedge	7208
Swivel Assembly	7138A
Swivel Hook	7232
Swivel Hook Spring	7234
Swivel Operating Lever Spring	7226
Wire Cutter	7102
Wire Feed Shoe	7154
Wire Grip Spring	7134B

**PLAC:
STAM
HERE**

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

LIMITED WARRANTY

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

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

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

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

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

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Phone: 773-777-6500 800-634-0810
Fax: 773-777-0156 800-417-9251
E-mail: deluxestitcher@aol.com
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