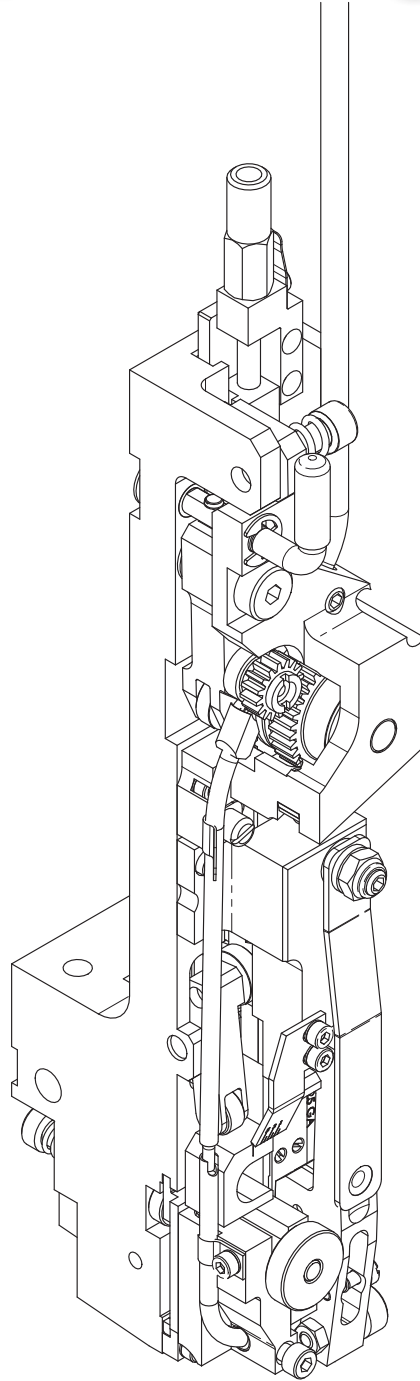


*Thank you for choosing the
G5 STITCHER HEAD
for your binding needs.*



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.

WARNING!

G5 Stitcher Heads

Machine operators and others in the work area should always wear safety glasses to prevent serious eye injury from fasteners and flying debris when loading, operating, or unloading the stitcher machine.

Do not operate this stitcher head without all stitcher machine guards in place. Do not modify the guards in any way. Always disconnect the power supply before removing any guards for servicing.

Never operate the machine with wire feeding through the head unless there is stock above the clinchers, otherwise serious damage may result.

Always turn power off when making adjustments. Always disconnect the power cord before any disassembly work.

EYEWEAR



REQUIRED

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Specifications

Weight

Shipping Weight 7.0 lbs... (3.2 kg)

Physical Dimensions

Height 12" Max." (30.5 cm)

Width 2" (5.1 cm)

Stitching Capacity Two Sheets to 5 mm. (3/16")

Wire Type 25 round (0.52 mm max)

..... 21x25 flat

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

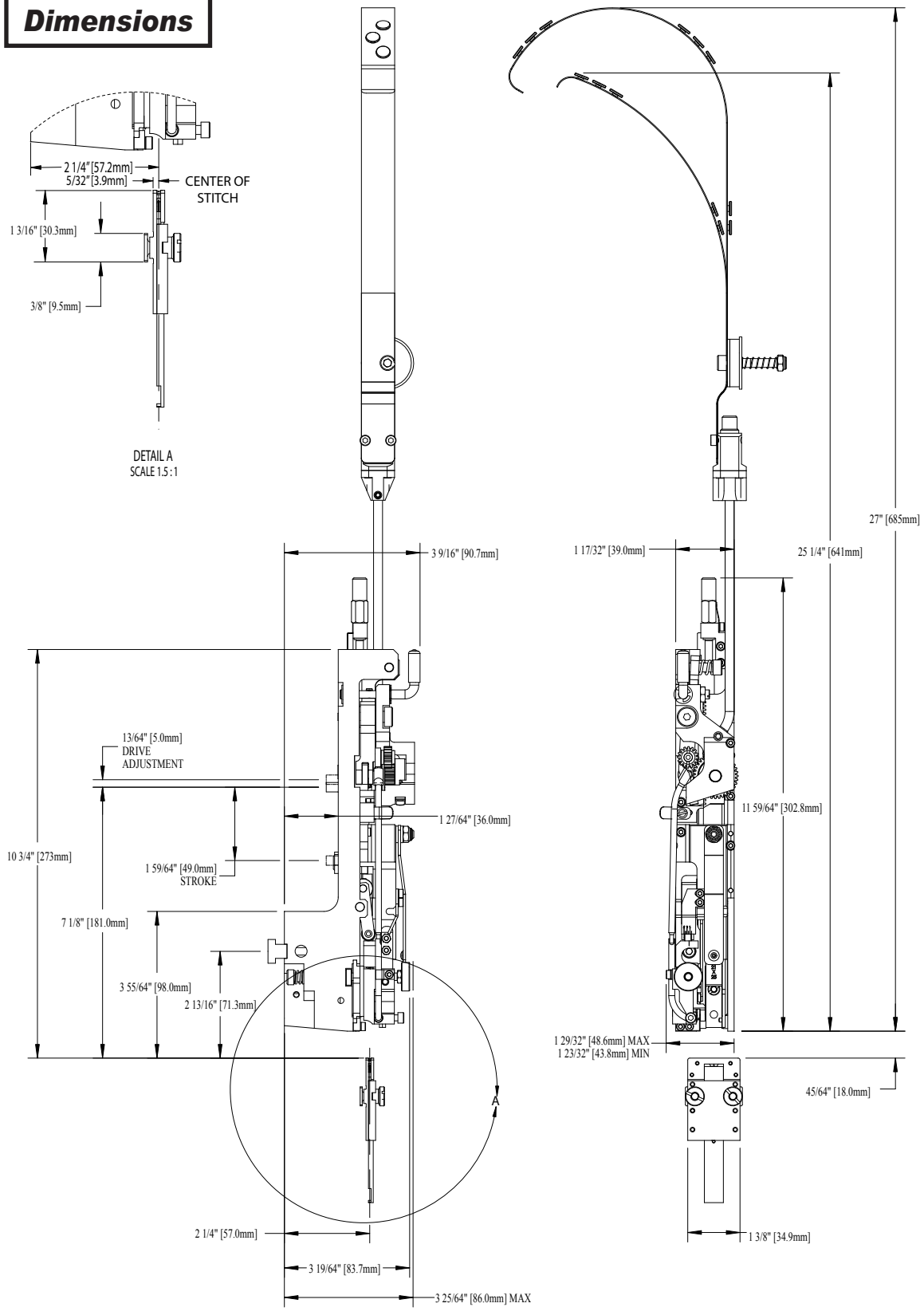
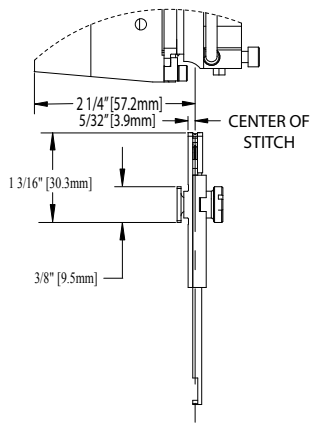
Minimum Head Center

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

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

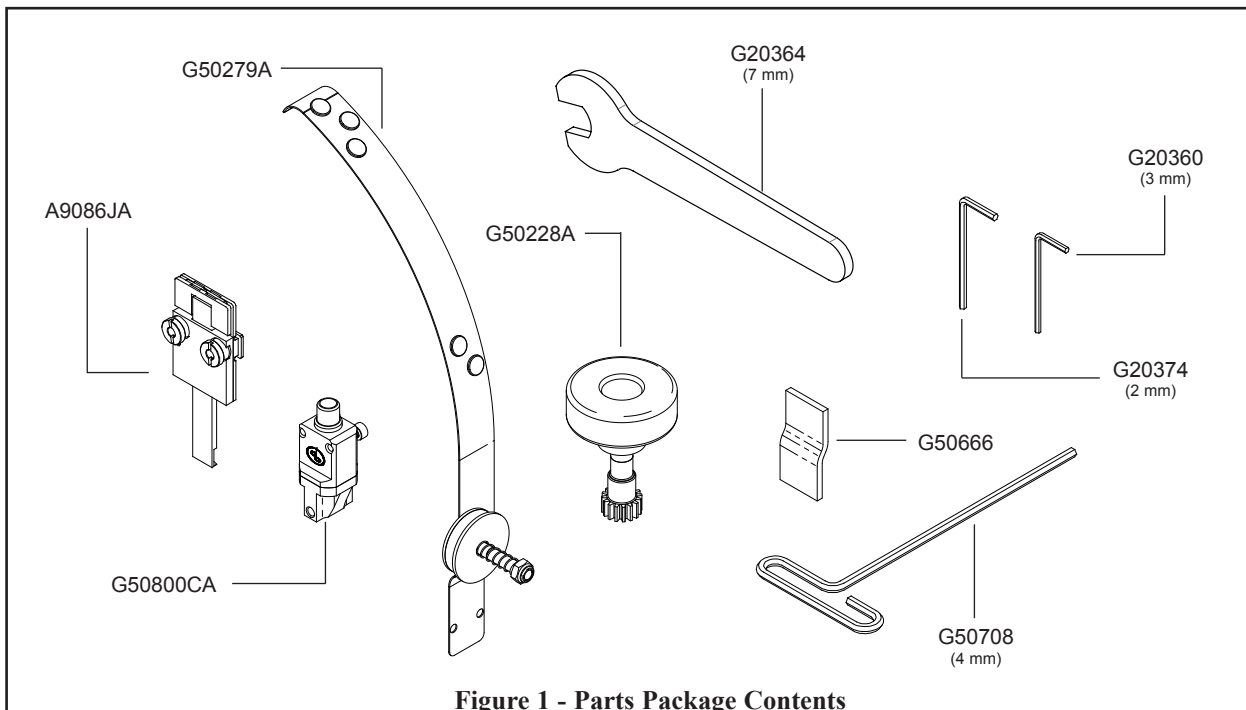
Dimensions



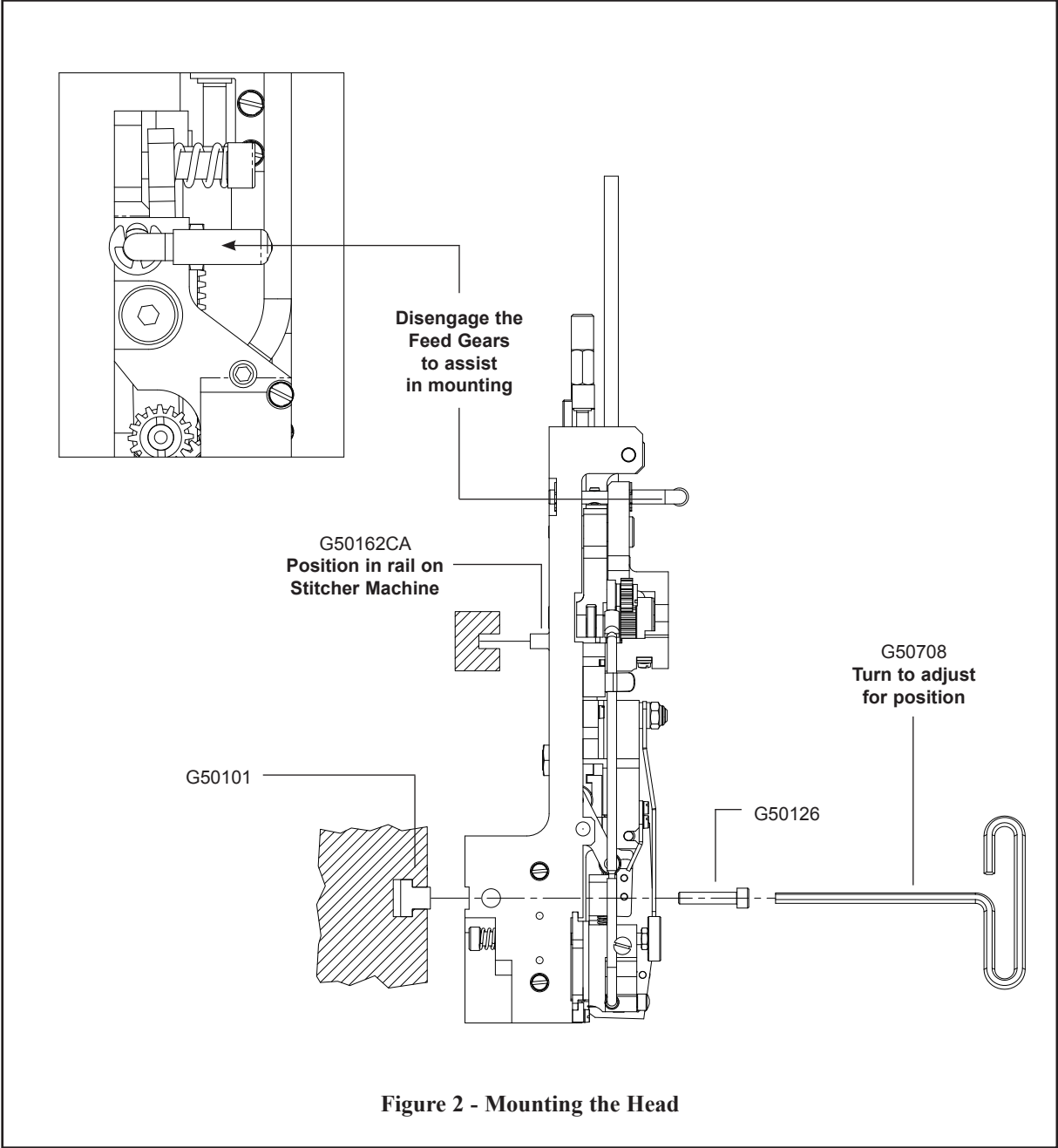
Installation

Contents

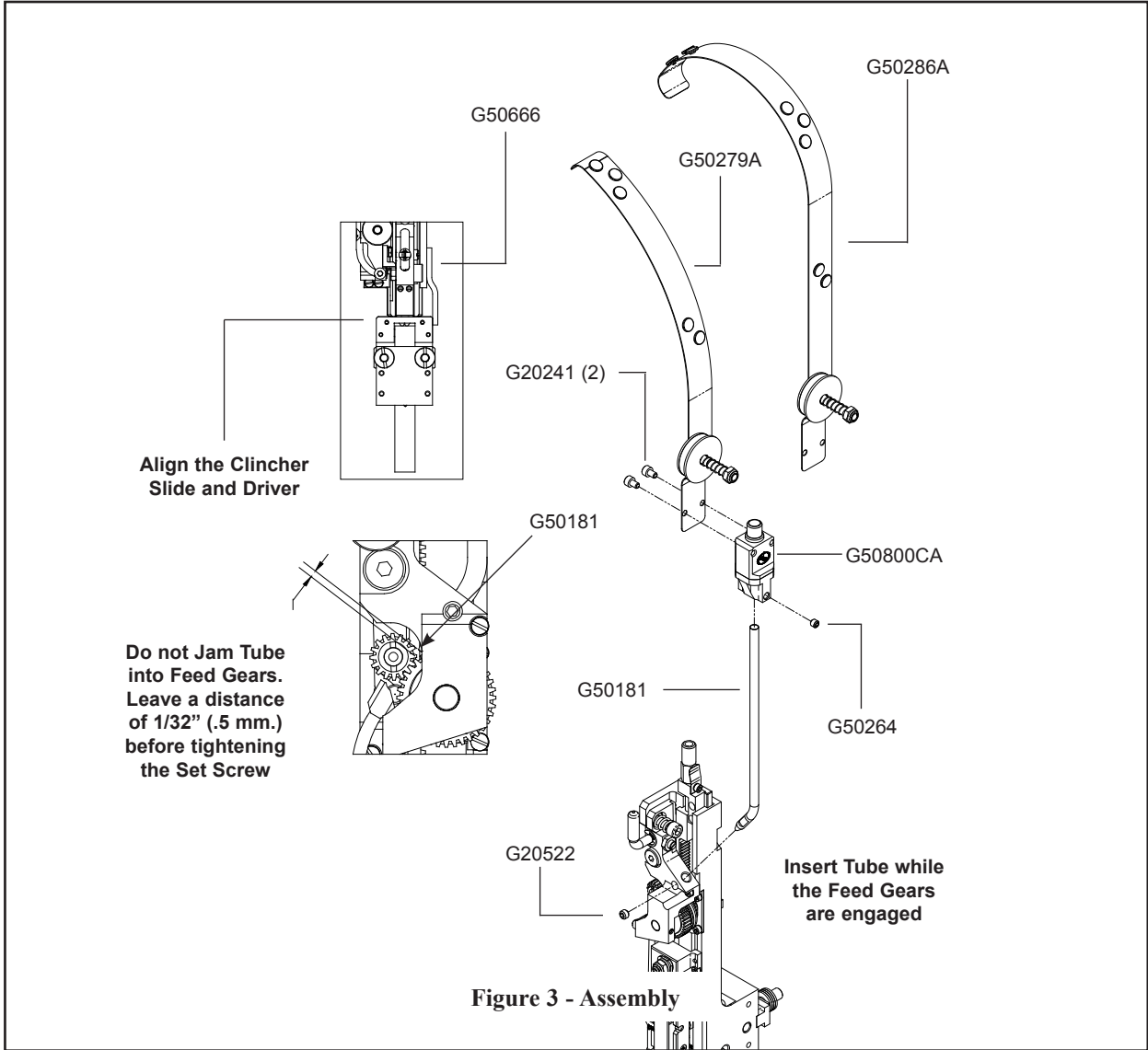
- G5 Manual
- Bag of tools; 2.0 mm., 3.0 mm. and Open End Wrench (7 mm.)
- T-Handle Hex Head Wrench; 4 mm.
- Head Mounting Accessories
 - Front Mount: Clamp Block (G50101), Screw M5x0.8x25 (G50126)
 - Bolt Mount: Head Mounting Bolt, M8 (G50367), Mounting Block - Keyed (G50102), Bonnet Clamp Pin (G50366), Mounting Block Handle (G50716) and Flat Washer M8 (G50394)
- Clincher Plate, Points, Slide, Nuts and Studs
- Clincher Alignment Gauge
- Wire Guide Spring and Wire Anti-Backup Unit
- Manual Feed Gear Tool
- Stitch Samples



Mounting (Figure 2)



Assembly (Figure 3)

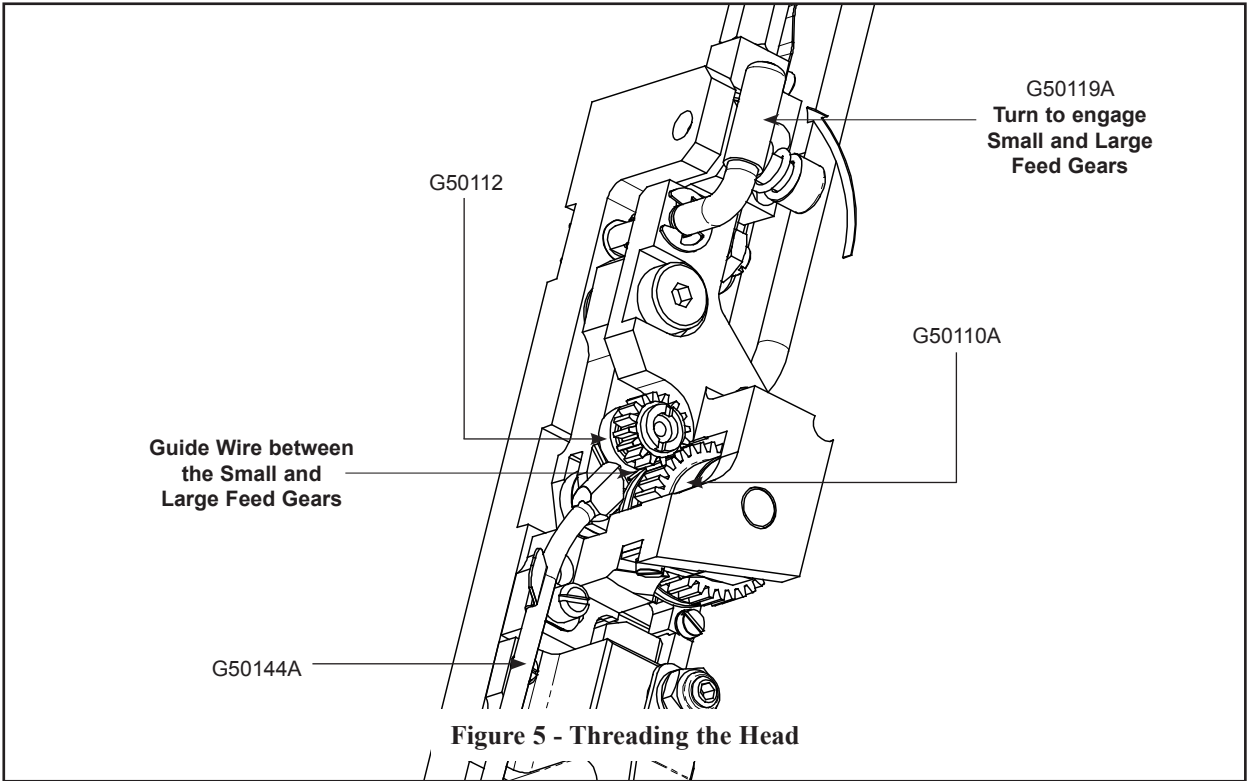
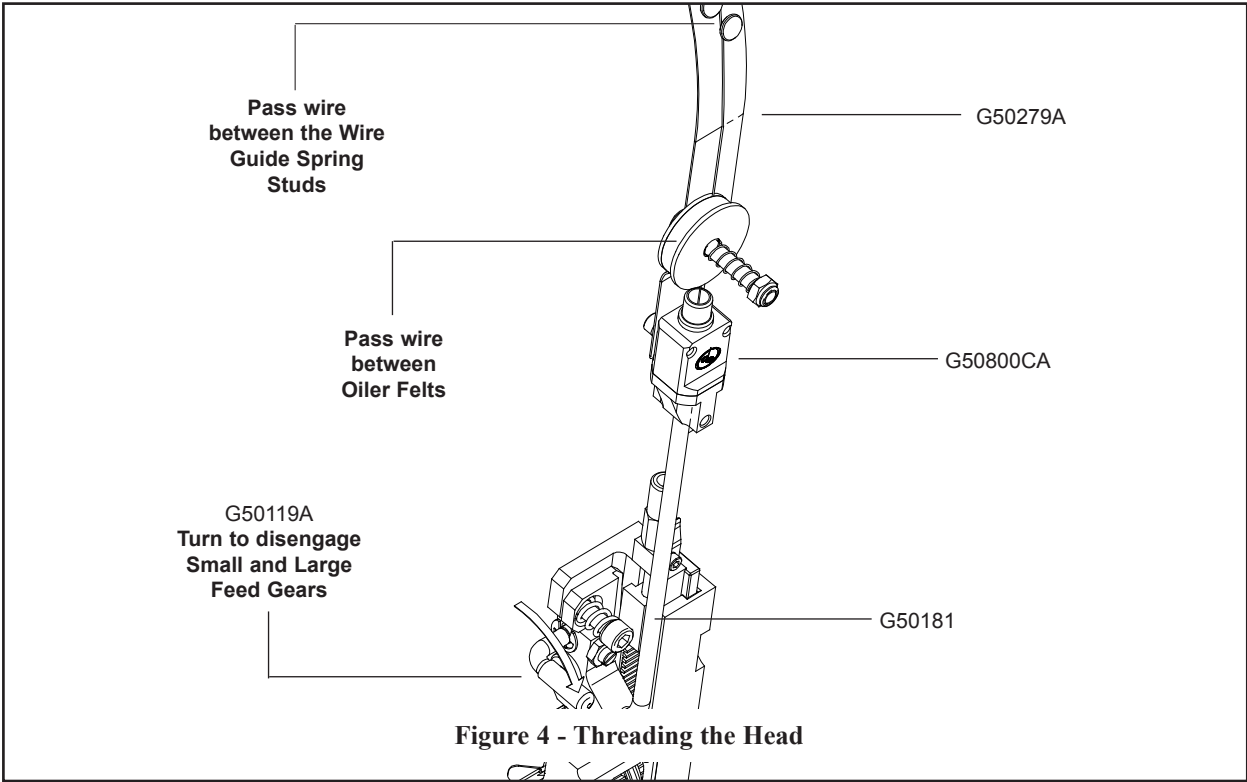


⚠ WARNING

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

Operation

Wire Threading (Figures 4 & 5)



Adjusting Wire Straightness (Figures 6-9)

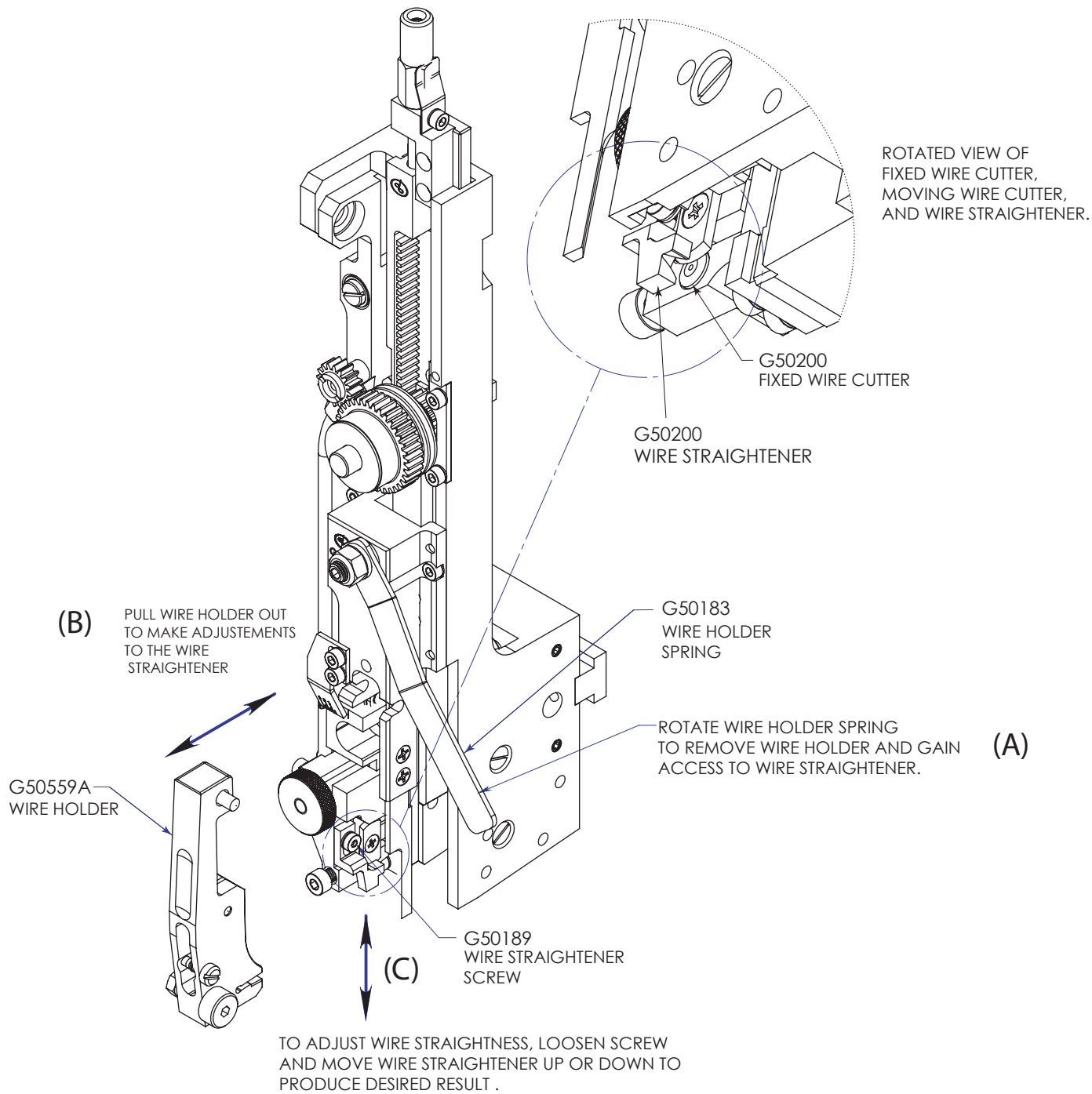


Figure 6 - Adjusting Wire Straightness

Horizontal Adjustment (Figures 6-7)

To begin horizontal wire adjustment;

(A) Swing open the Wire Holder Spring (G50183) by rotating it away from center.

(B) Pull out the Wire Holder (G50559A) to gain access to the Wire Straightener.

(C) Observe the direction the wire is moving as it emerges out of the Fixed Wire Cutter (G50200). Use an M3 wrench to loosen the Wire Straightener Screw (G50189) and allow adjustment to the Wire Straightener (G50200).

Adjustment is accomplished by simply sliding the Wire Straightener up or down to counter the effects of wire curl shown in Figs. 7a-7c. If the wire is curved upwards, slide the Wire Straightener down. Likewise If the wire is feeding downward, slide the Wire Straightener up.

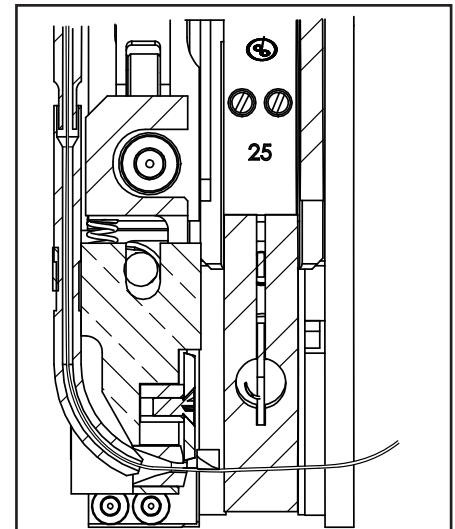


Figure 7a - Wire Curls Up

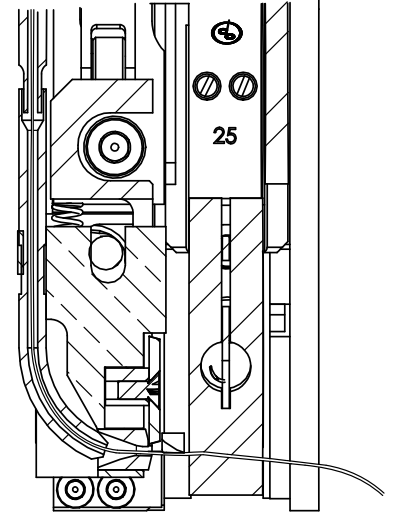


Figure 7b - Wire Curls Down

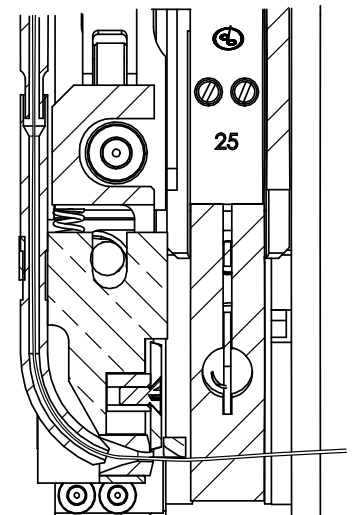


Figure 7c - Optimal Setting with Wire Pointing at 2 o'clock.

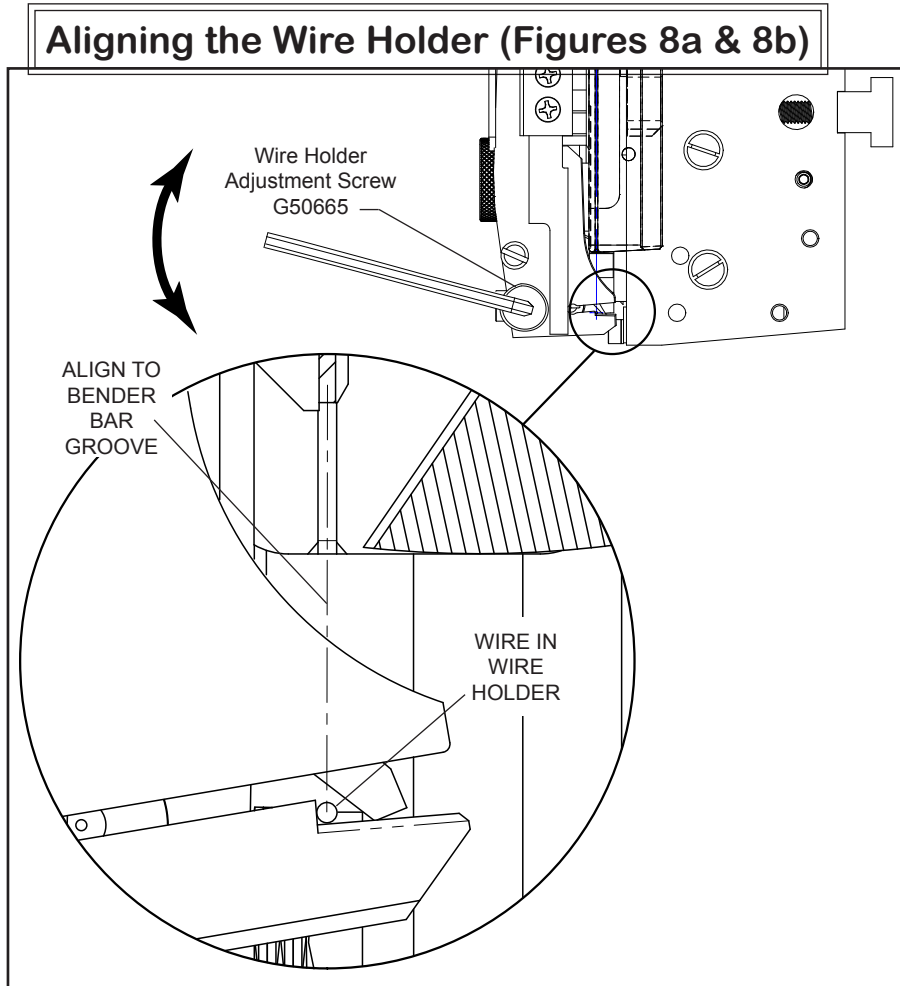
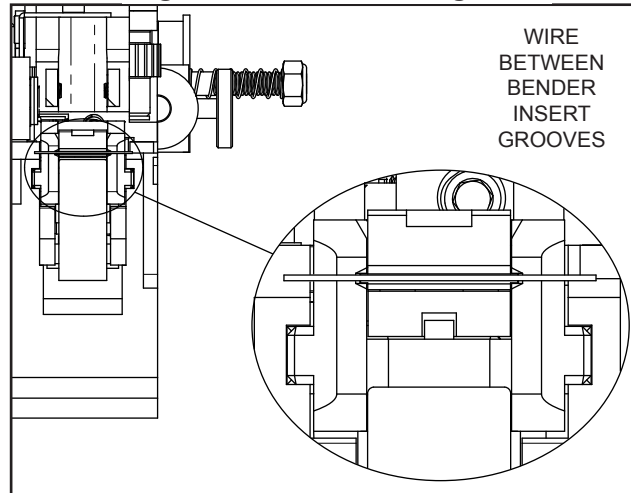


Figure 8a - Wire Holder Alignment

Figure 8b - Wire Holder Alignment

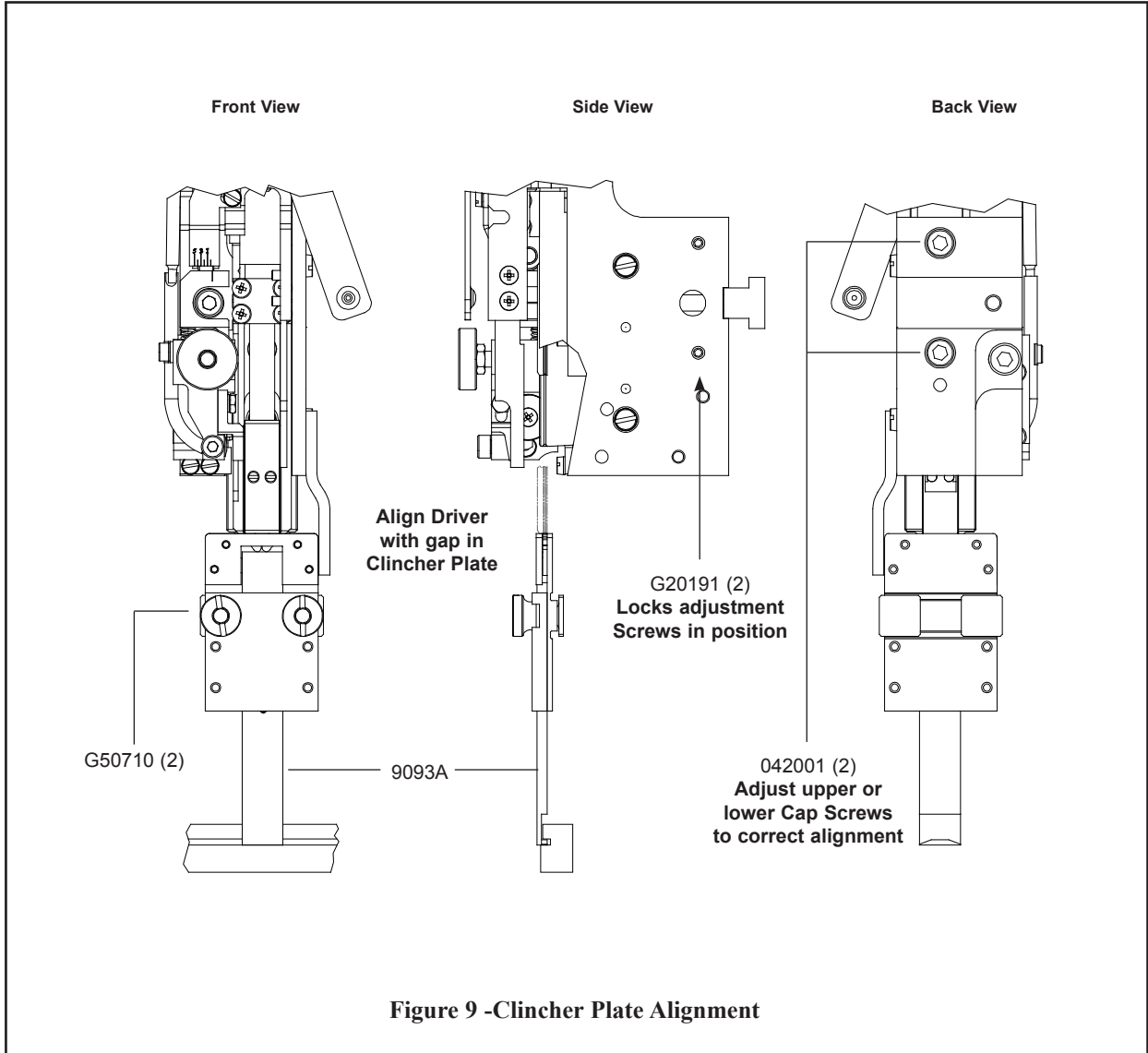


In order to form a quality stitch, the Wire Holder has to be in alignment with the Bender Bar. Specifically, the cut piece of wire held in the Wire Holder has to line up with the grooves in the Bender Bar. Poor adjustment may cause broken crowns or other poor stitching. Load a piece of wire into the Wire Holder.

Using a mirror, check to make sure the wire in the Wire Holder is lined up with the grooves in the Bender Bar (Figure 8b). Turn the Adjustment Screw (G50665) until the wire is aligned with the grooves in the Bender Bar. Tighten the Hex Nut to secure this setting.

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

Aligning the Clincher Plate (Figure 9)



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

⚠ WARNING

Adjusting the Length of the Stitch Leg (Figure 10)

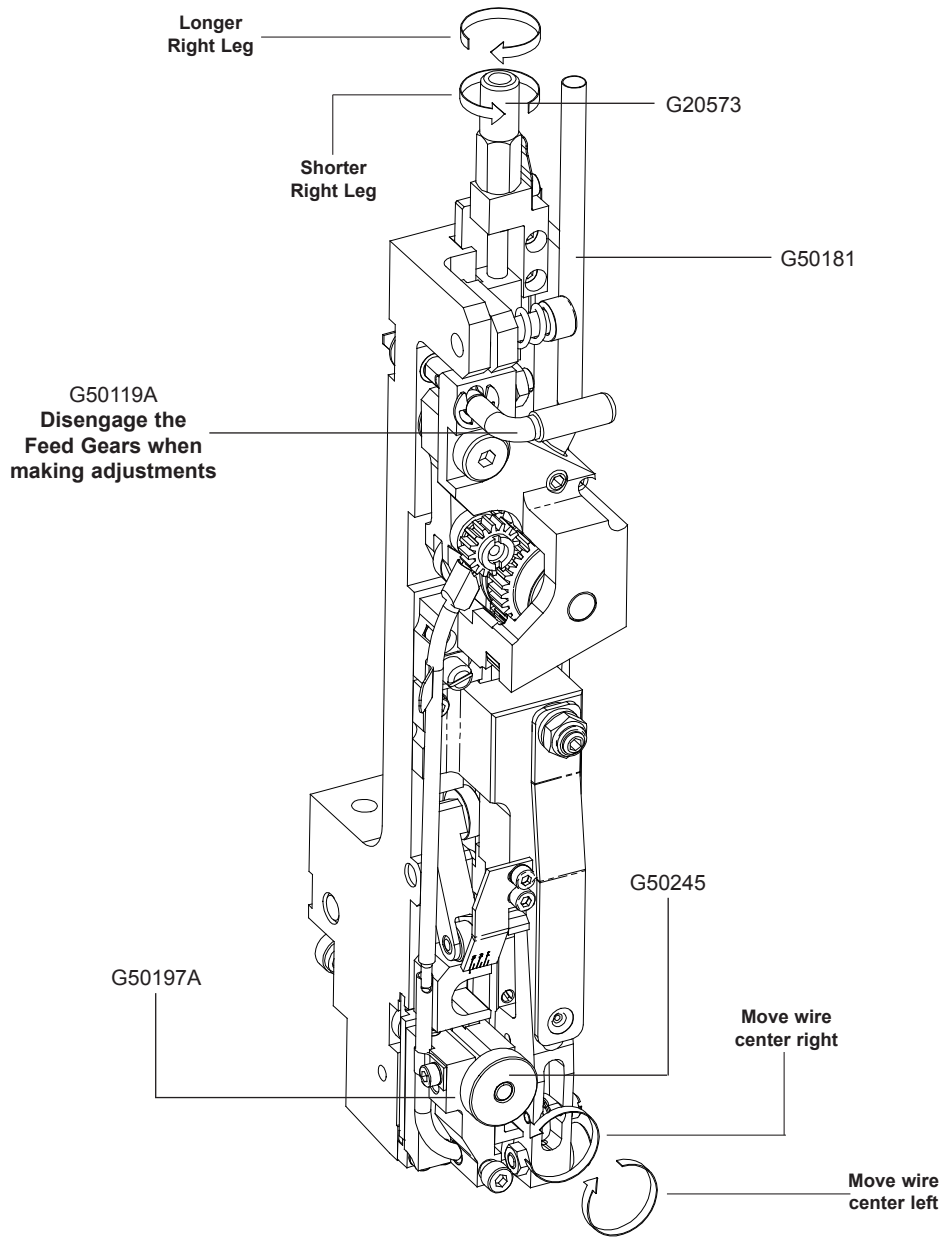


Figure 10 - Adjusting the Stitch Leg

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

 **WARNING**

Maintenance

Lubrication (Figure 11)

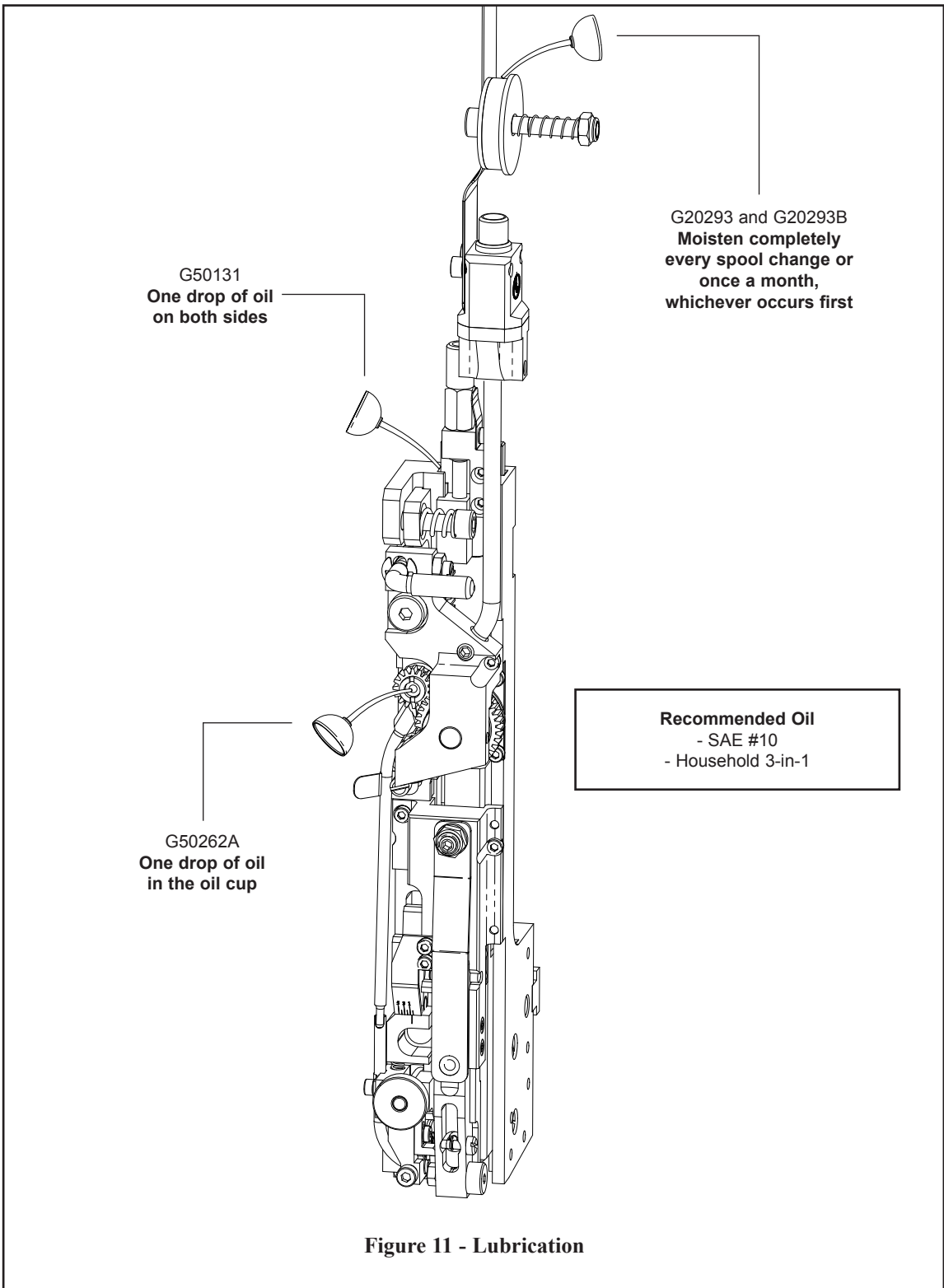
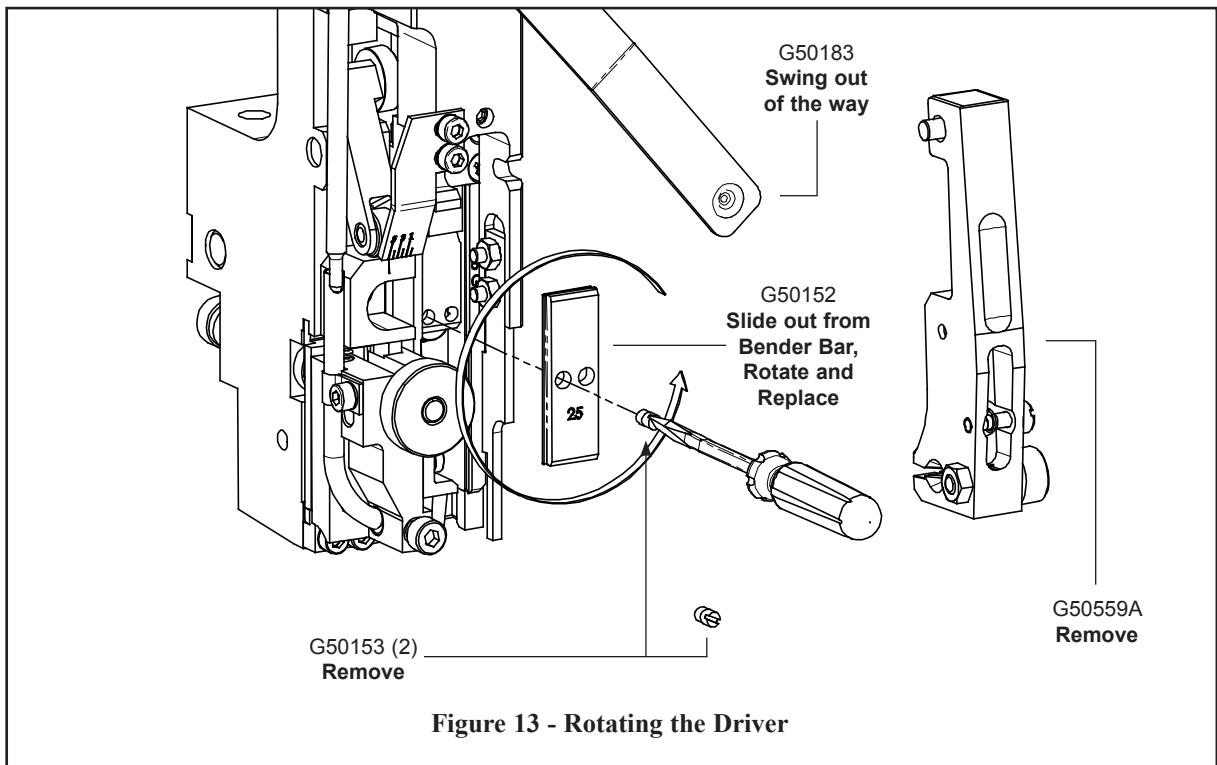
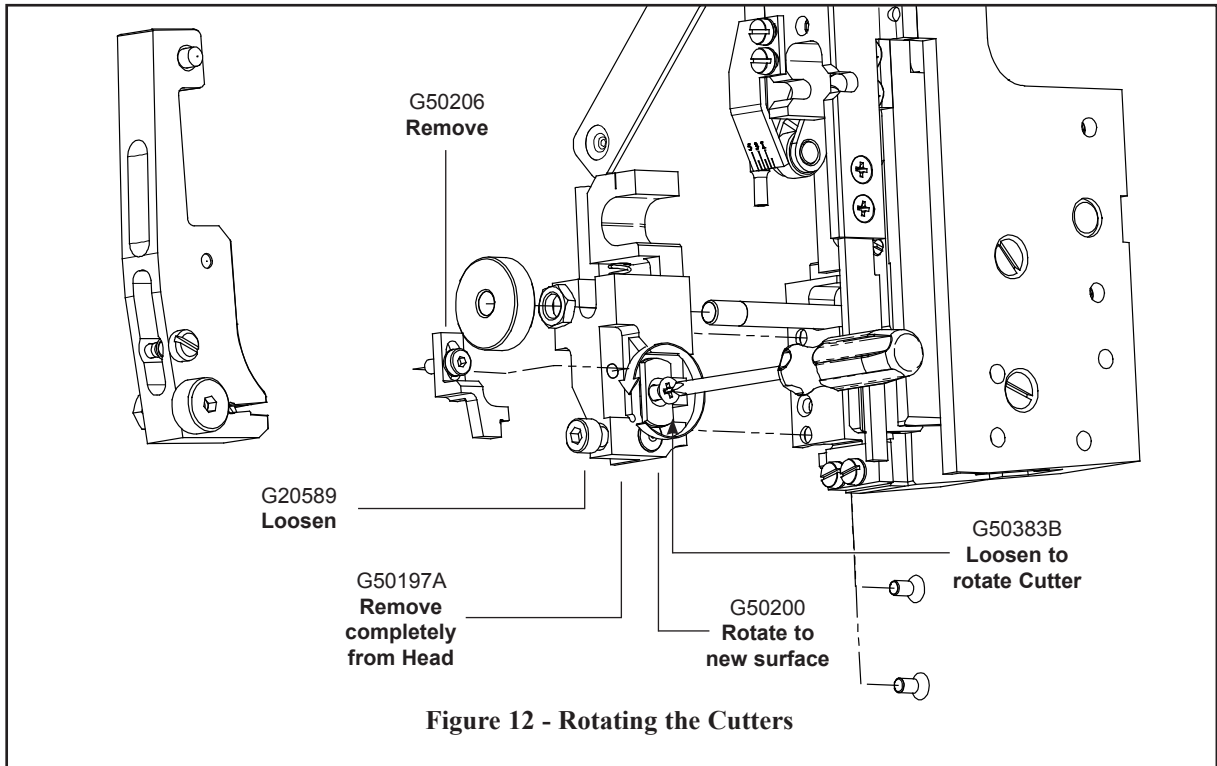


Figure 11 - Lubrication

Rotating Replacement Parts (Figures 12 & 13)



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):**

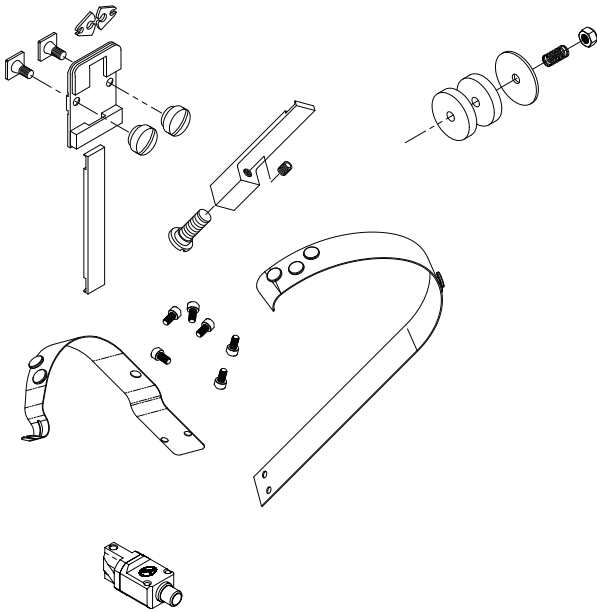
Remove and wash in a petroleum-based, oil-dissolving solvent, dry and repack the Feed Gear with any general Lithium-based light weight Grease.

- **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.

Ordering Spare Parts

In time, you will need to replace some parts in your G5 style Stitcher Head. When this happens, first locate the needed part in one of the following diagrams. Then locate the DeLuxe Stitcher part number and contact your Graphic Arts Representative to order the part by part number, description and quantity at **800-634-0810**.

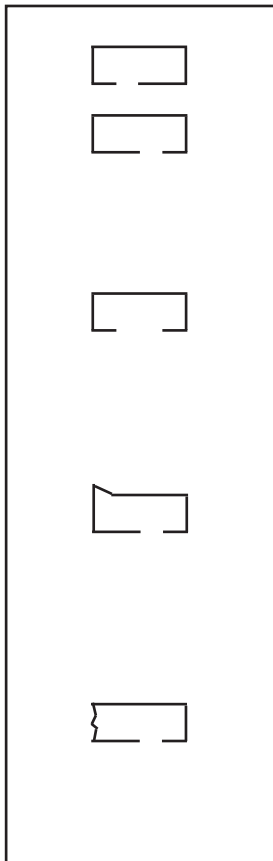


Troubleshooting (Figure 14)

The quality and quantity of work that can be produced with the G5 Stitching Head is dependent upon the operator making all adjustments as accurately as possible and carefully maintaining the head. The cause of staple imperfections usually can be traced to inaccurate settings or normal wear of moving parts. In the event of trouble of this nature occurring, the operator can, by referring to the following troubleshooting chart, quickly locate and remedy the cause or causes of the trouble.

The following is a brief list of problems and possible solutions which should cover the majority of situations encountered when stitching with the G5 style Stitching Heads.





PROBLEM: Gap Out of Center

SOLUTION: Lengthen or shorten the left leg by adjusting the Cutter Box. (See page 9)

PROBLEM: Gap Too Big

SOLUTION: Increase wire draw with the Feed Rack Adjustment Knob, then center stitch gap as described above. (See page 9)

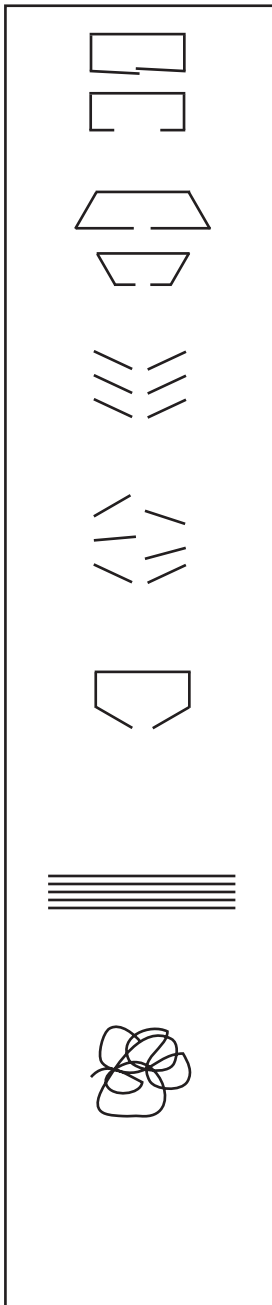
PROBLEM: Corner Buckled

SOLUTION: Check the Driver (G50152) for a chipped corner and rotate or replace it if needed.

PROBLEM: Leg(s) Buckled

SOLUTION: If the ends of an unformed piece of wire are not smooth, the Wire Cutters (G50145B or G50200) are worn. Check for wear and rotate or replace if needed.

Figure 14 - 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)

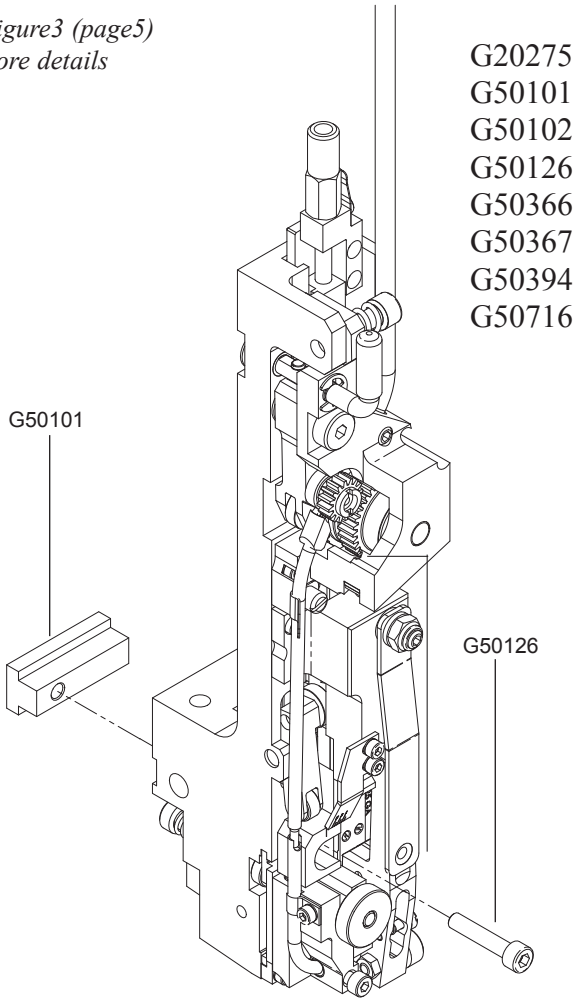
PROBLEM: No wire being drawn

SOLUTION: Make sure the Cutter Box Adjustment Knob is turned counter-clockwise and the Feed Gears engaged. (See page 8)

Figure 14 - Troubleshooting

Head Mounting - Front - STANDARD

see Figure3 (page5)
for more details

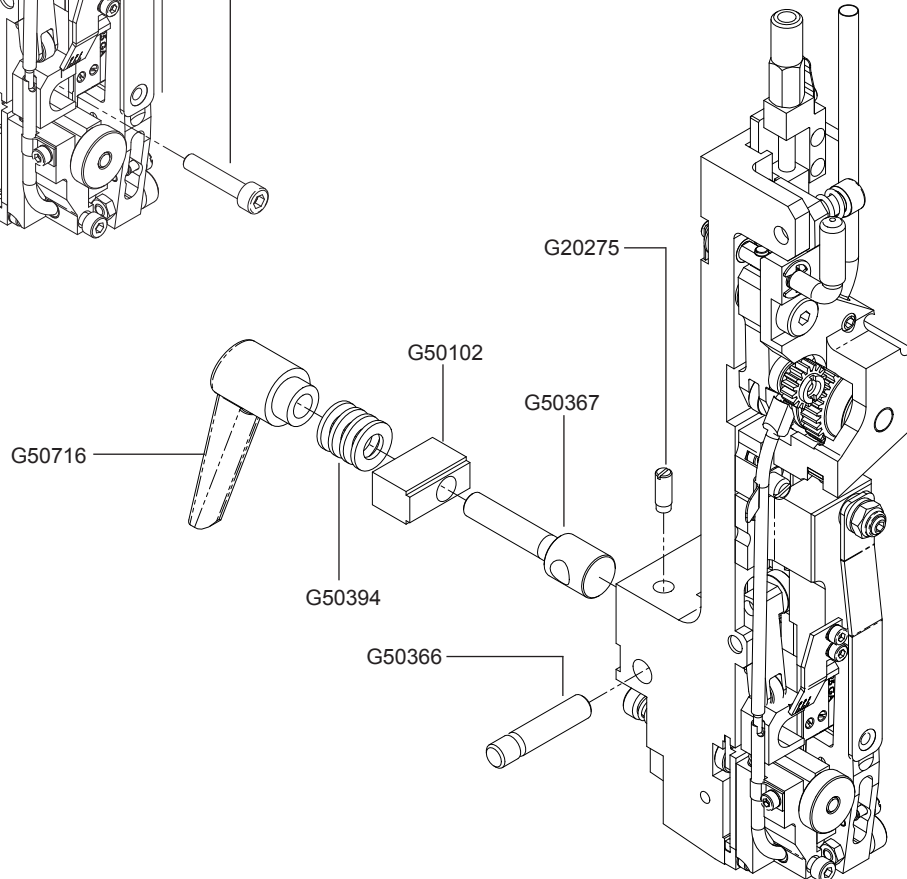


- G20275
- G50101
- G50102
- G50126
- G50366
- G50367
- G50394
- G50716

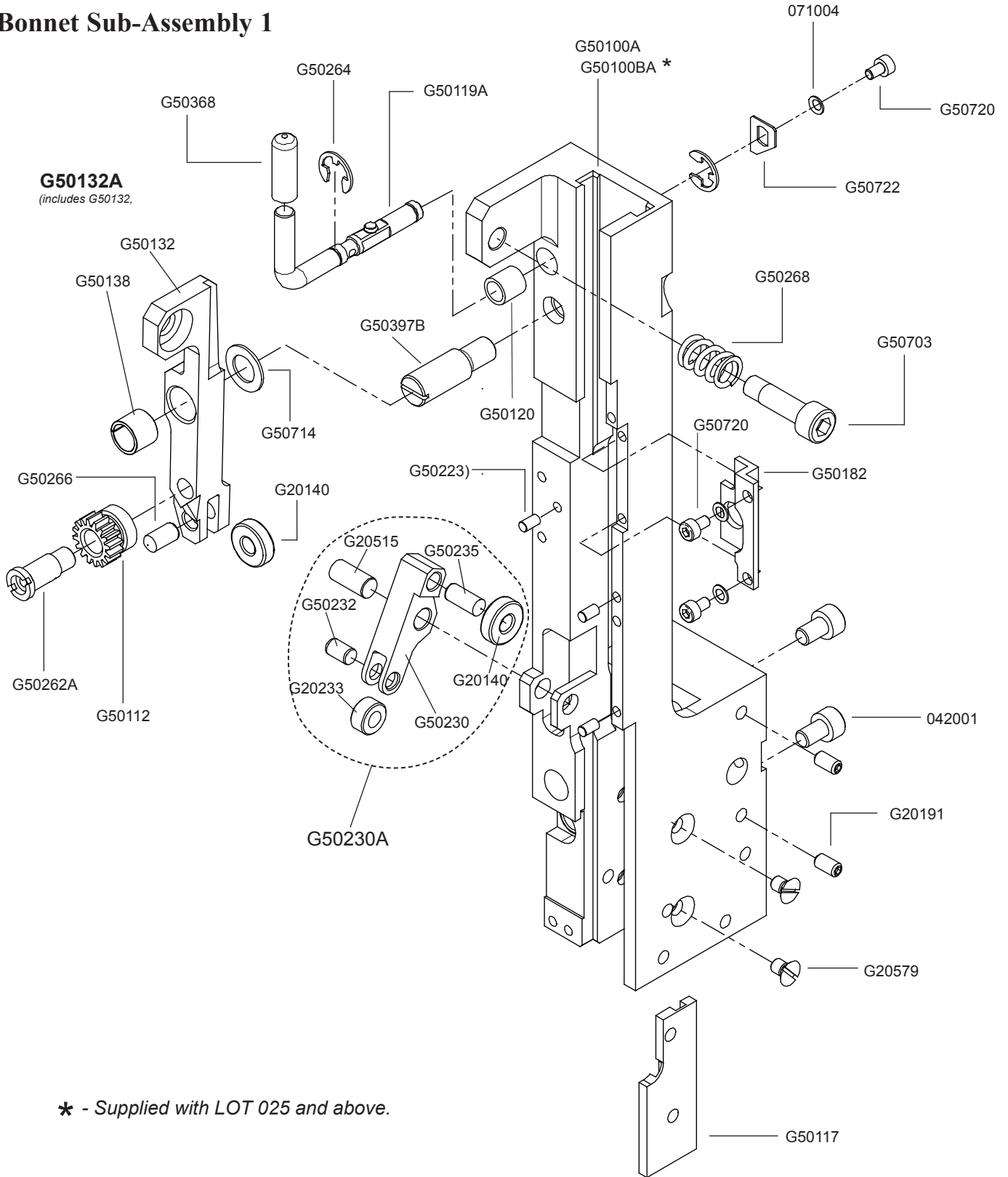
Head Mounting Hardware

- | | |
|--------------------------|---|
| Ball Spring Plunger | 1 |
| Clamp Block | 1 |
| Mounting Block - Keyed | 1 |
| Screw M5x0.8x25 | 1 |
| Bonnet Clamp Pin | 1 |
| Head Mounting Bolt, M8 | 1 |
| Flat Washer M8 (watkiss) | 4 |
| Mounting Block Handle | 1 |

Alternate-Style Head Mounting - Rear CPBOURG/HORIZON/WATKISS



Bonnet Sub-Assembly 1

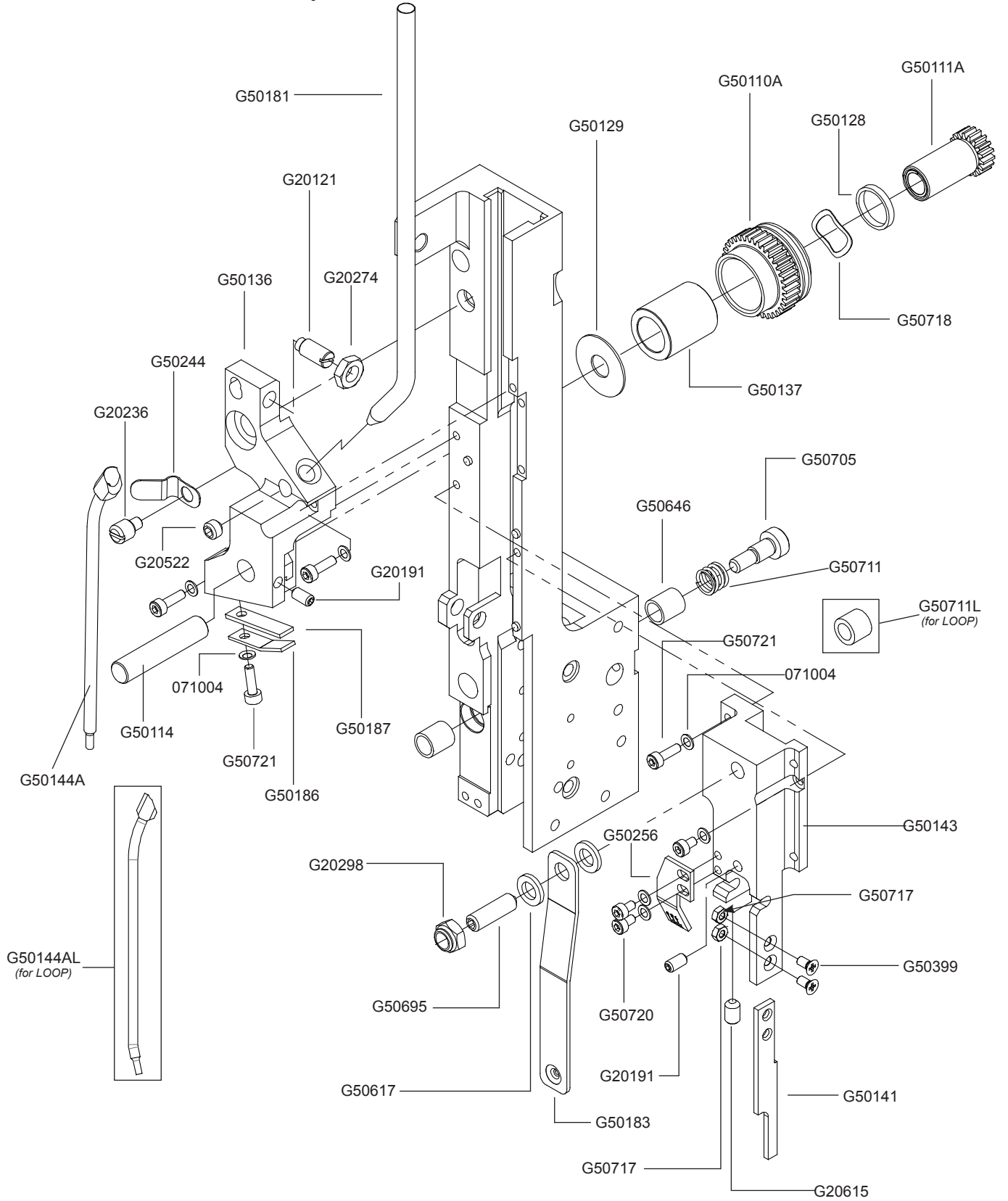


* - Supplied with LOT 025 and above.

Bonnet Sub-Assembly 1

042001	Screw M5x0.8x8	2
071004	Lock Washer Ribbed	3
G20191	Screw M4x0.7x8	2
G20515	Dowel Pin M6x14	1
G20579	Screw M4x0.7x6	2
G50100A	Bonnet Assembly - G5	1
G50100BA	Bonnet Assembly - G5	1
G50112	Small Feed Gear	1
G50117	Forming Pin Cam	1
G50119A	Feed Release Handle Assem.	1
G50132A	Feed Lever Assembly	1
G50182	Feed Gear Plate	1
G50230A	Cutter operating Lever Assem.	1
G50262A	Sm Feed Gear Shaft Assembly	1
G50264	E-Ring 6mm	2
G50266	Dowel M5x10	1
G50268	Feed Lever Spring	1
G50368	Handle Cap - Grey	1
G50397B	Stud, G5 Feed Lever	1
G50703	Feed Lever Spring Screw	1
G50714	Feed Lever Spacer	1
G50720	Screw M3x0.5x6	3
G50722	Feed Release Handle Stop	1

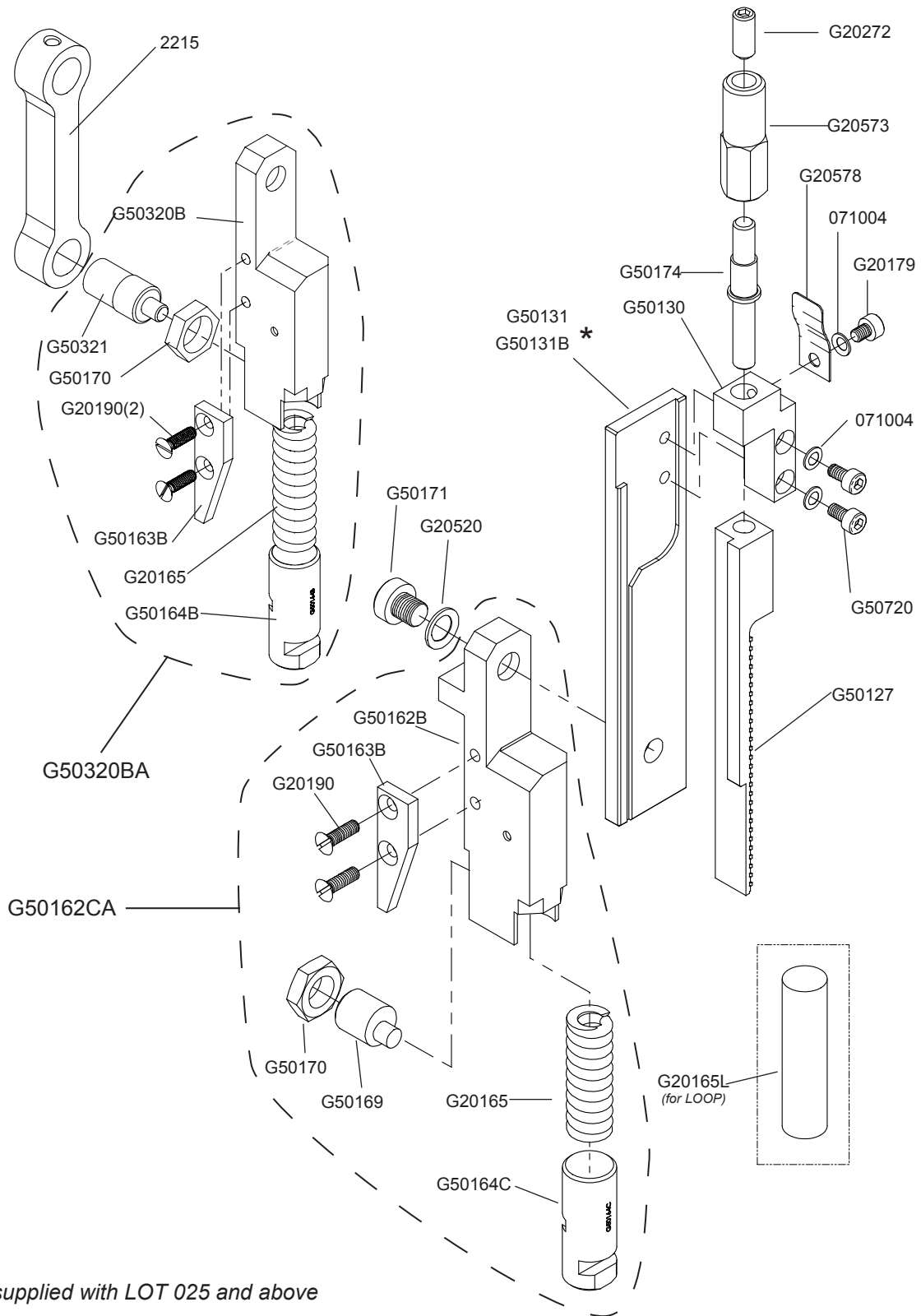
Bonnet Sub-Assembly 2



Bonnet Sub-Assembly 2

071004	Lock Washer Ribbed	7
G20121	Feed Release Plunger	1
G20191	Screw M4x0.7x8	2
G20236	Tube Pivot Screw	1
G20274	Hex Jam Nut, M6x1	1
G20298	Nylock Lock Nut, M6x1	2
G20522	Screw M6x1.0x5, Nylon	1
G20615	Screw M5x0.8x8	1
G50110A	Large Feed Gear Assembly	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
G50143	Pivot Block	1
G50144A	Middle Wire Tube Assembly	1
G50144AL	Middle Wire Tube AssemBLY - Loop	
G50181	Upper Wire Tube	1
G50183	Retaining Spring	1
G50186	Feed Gear Friction Spring	1
G50187	Feed Gear Friction Pad	1
G50244	Tube Clip	1
G50256	Scale	1
G50399	Screw M3x0.5x8	2
G50617	Wire Holder Spring Washer	2
G50646	Eccentric Bearing	2
G50695	Screw M6x1.0x20	1
G50705	Shoulder Screw M6x8	2
G50711	Screw Spring	1
G50711L	Eccentric Screw Spring-Loop	1
G50717	Hex nut m3X0.5	2
G50717	Hex Nut M3x0.5	2
G50718	Feed Gear Spring	1
G50720	Screw M3x0.5x6	3
G50721	Screw M3x0.5x10	4

Driver and Feed Slide Assemblies



* - supplied with LOT 025 and above

Driver and Feed Slide Assemblies

071004	Lock Washer Ribbed	2
G20179	Screw M3x0.5x4	1
G20272	Screw M5x0.8x12	1
G20520	Ribbed Lock Washer M6	1
G20573	Feed Rack Adjustment Knob	1
G20578	Rack Adjustment Detent	1
G50127	Feed Rack	1
G50130	Feed Adjustment Block	1
G50131	Feed Slide	1
G50131B	Feed Slide	1
G50171	Screw M6x1.0x6	1
G50174	Feed Rack Adjustment Stud	1
G50720	Screw M3x0.5x6	2

G50320BA Driving Slide Assembly, Crank Drive

G20165	Driving Slide Spring	1
G20190	Screw M3x0.5x10	2
G50163B	Cutter Operating Cam	1
G50164B	Driving Slide Plunger	1
G50170	Custom Hex Nut M10x1.25	1
G50320B	Driving Slide, G5 Crank	1
G50321	Crank Link Screw	1

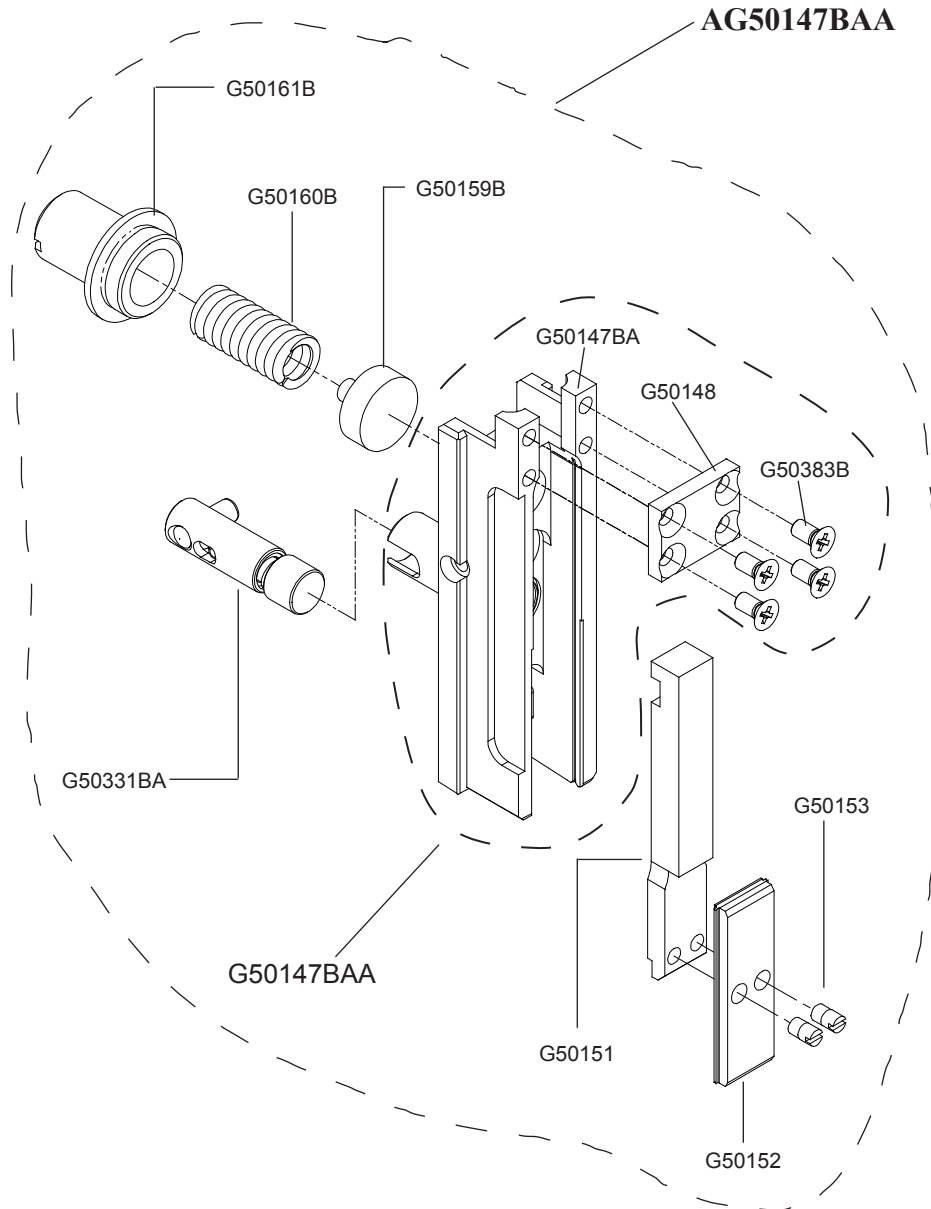
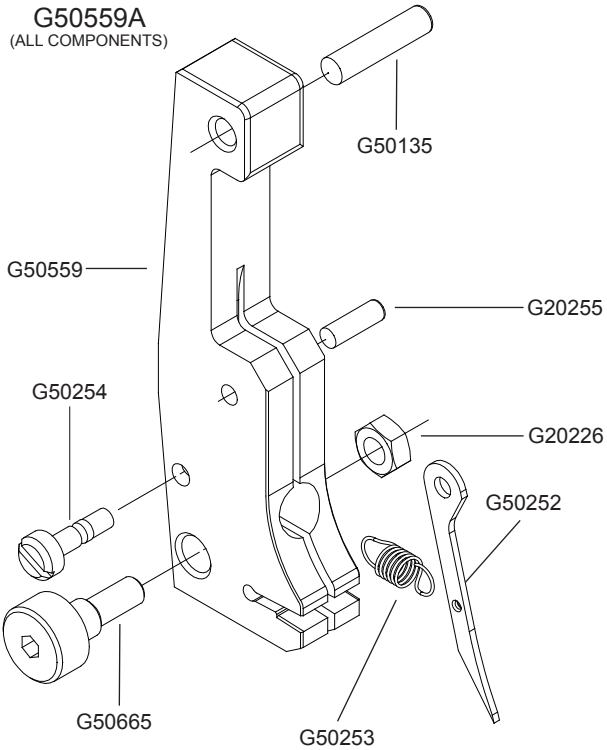
G50162CA Driving Slide Assembly, STANDARD

G20165	Driving Slide Spring	1
G20190	Screw M3x0.5x10	2
G50162B	Driving Slide	1
G50163B	Cutter Operating Cam	1
G50164C	Plunger	1
G50169	Driving Slide Plunger Ecc.	1
G50170	Custom Hex Nut M10x1.25	1
G50646	Cutter Box Eccentric Bearing	2

Driver and Bender Bars

AG50147BAA

Wire Holder Assembly



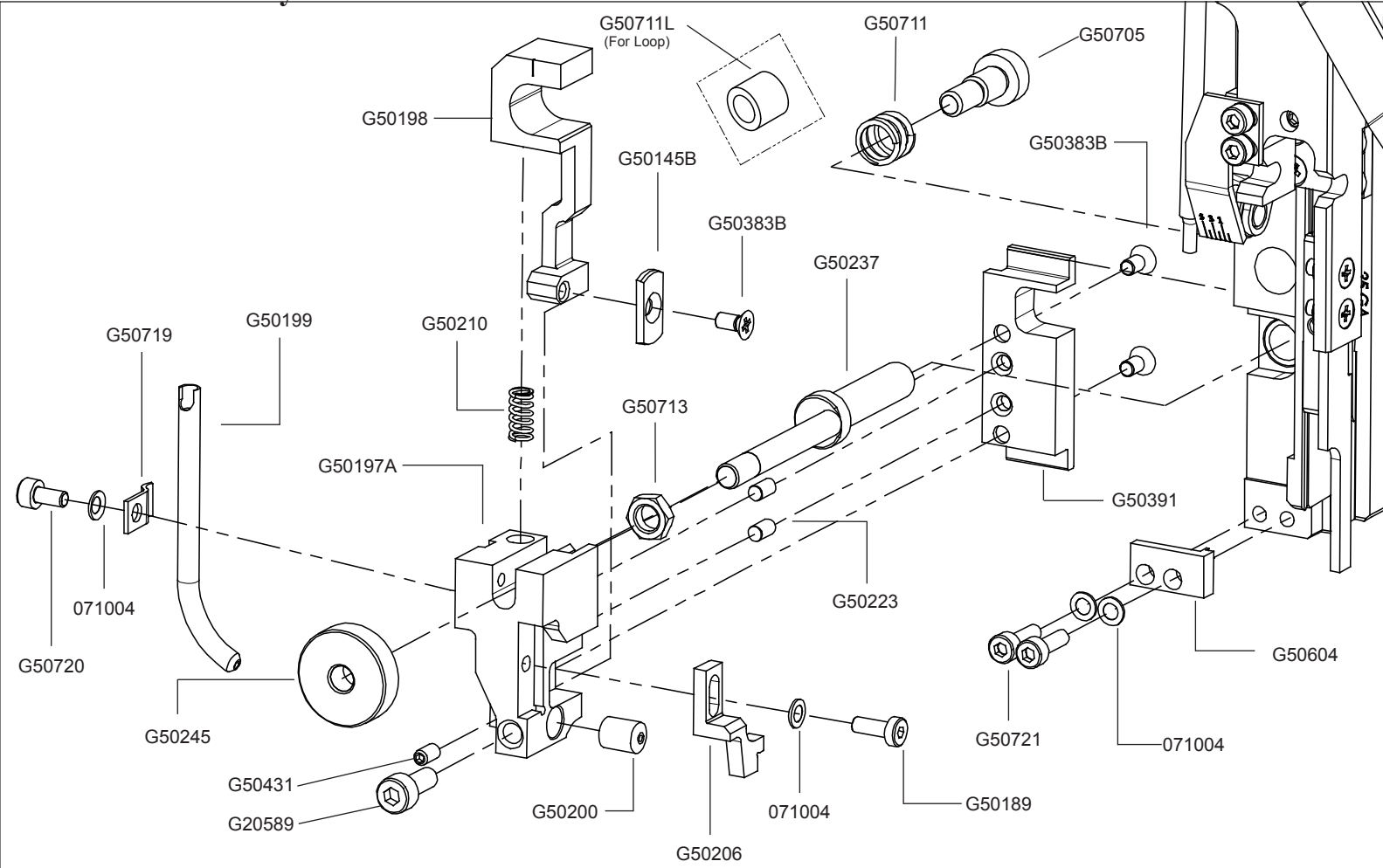
G50559A Wire Holder Assembly

G20226	Hex Nut M4x.7	2
G20255	Dowel Pin M3x10	1
G50135	Wire Holder Pivot Pin	1
G50252	Wire Hook	1
G50253	Wire Hook Spring	1
G50254	Wire Holder Spring Screw	1
G50559	Wire holder	1
G50665	Adjustment Screw	1

AG50147BAA Bender Bar Assembly, G5. Complete

G50147BAA	Bender Bar Assembly	1
G50151	Driver Bar	1
G50152	Driver - 25 Wire	1
G50153	Driver Retaining Screw	2
G50159B	Friction Plug	1
G50160B	Bender Bar Friction Spring	1
G50161B	Friction Plug Bushing	1
G50331BA	Forming Pin Assembly	1

Cutter Box Assembly



Cutter Box Assembly

071004	Lock Washer Ribbed	4
G20589	Screw M4x0.7x10	1
G50145B	Moving Cutter	1
G50189	Screw M3x0.5x10	1
G50197A	Cutter Box Assembly	1
G50198	Cutter Operating 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	Adjusting Eccentric	1
G50245	Cutter Box Adjustment Knob	1
G50383B	Screw M3x0.5x6	2
G50391	Cutter Box Mounting Plate	1
G50431	Screw M3x0.5x6	1
G50604	Cutter Box Guide Plate	1
G50705	Shoulder Screw M6x8	2
G50711	Screw Spring	1
G50711L	Ecc. Screw Spring-Loop	1
G50713	Hex Jam Nut M5	1
G50719	Lower Tube Clip	1
G50720	Screw M3x0.5x6	2
G50721	Screw M3x0.5x10	2

G5KL-Loop Stitch Conversion Kit

The standard G5 Head with 25 gauge wire can be converted to a loop style by exchanging the following three sub-assemblies: the Wire Holder Assembly, the Cutter Block Assembly and the Bender Bar Assembly.

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

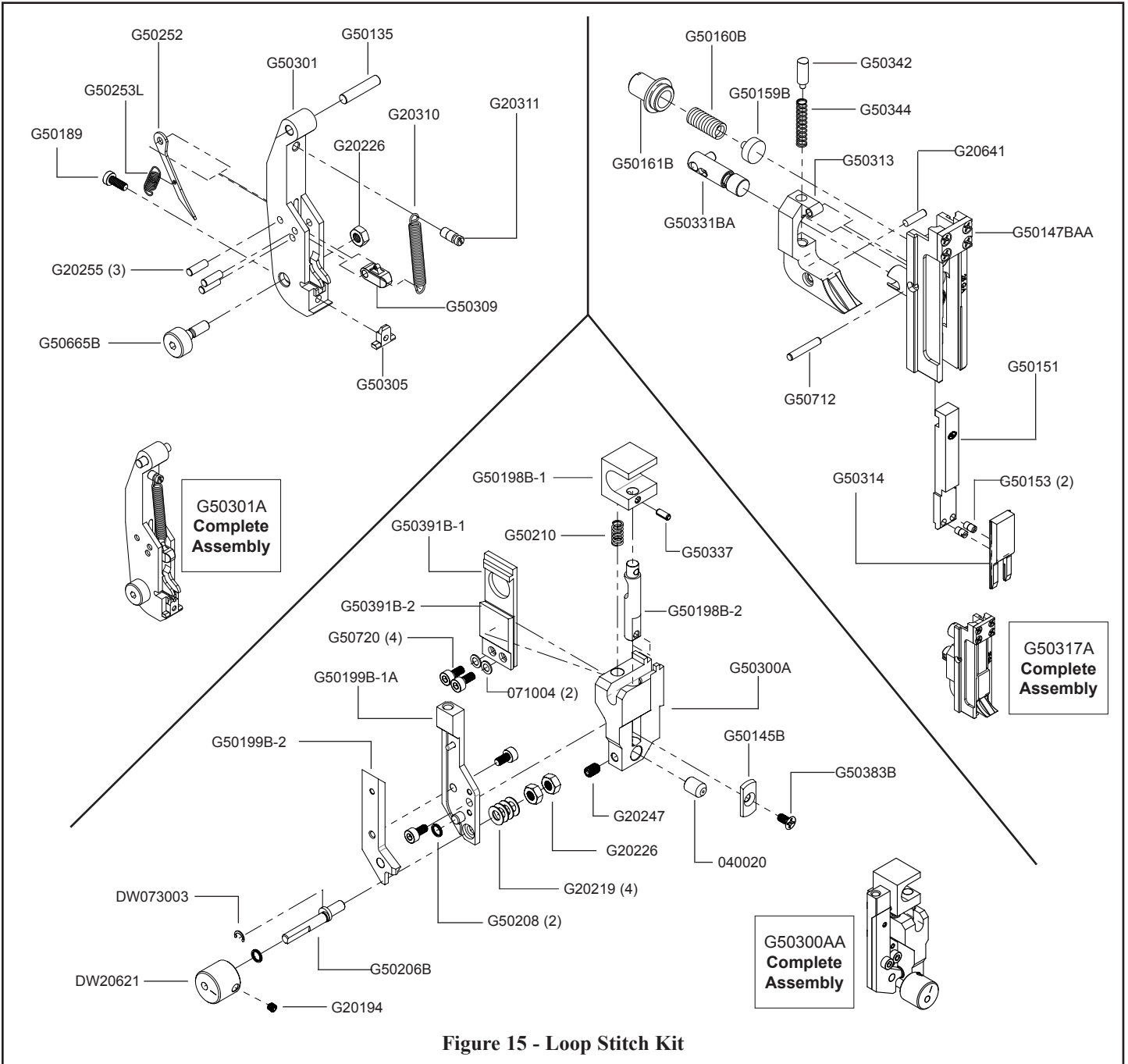


Figure 15 - Loop Stitch Kit

NOTE:
 Loop conversion also requires exchange of parts: G20165 with G20165L, G50711 with G50711L and G50144A with G50144AL.
 See pp. 26, 28 for reference.

G50301A Wire Holder Assembly - LOOP

G20226	Hex Nut M4x.7	1
G20310	Roller Lever Spring	1
G20311	Spring Anchor Screw	1
G20255	Dowel Pin M3x10	3
G50135	Wire Holder Pivot Pin	1
G50189	Screw M3x0.5x10	1
G50252	Wire Hook	2
G502531	Wire Hook Spring - G5 Loop	1
G50301	Wire Holder - Loop	1
G50309	Delay Lever, G5 Loop	1
G50665B	Eccentric Screw, G5 Loop	1
G50305	Anvil G5 - Loop	1

G50317A Bender Bar Assembly - G5 LOOP

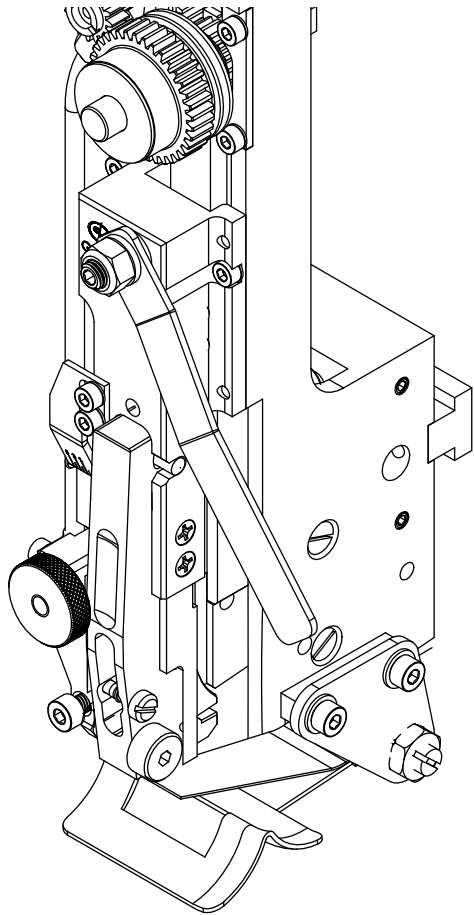
G20641	Dowel Pin M3x12	1
G50147BAA	Bender Bar Assembly	1
G50151	Driver Bar	1
G50153	Driver Retaining Screw	2
G50159B	Friction Plug	1
G50160B	Bender Bar Friction Spring	1
G50161B	Friction Plug Bushing	1
G50313	Supporter, G5 Loop	1
G50314	Driver, G5 Loop	1
G50331BA	Forming Pin Assembly	1
G50342	Spring Slunger, G5 Loop	1
G50344	Supporter Spring, G5 Loop	1
G50712	Dowel Pin M3x18	1
G50331BA	Forming Pin Assembly	1
G50199B-1A	Lower Wire Tube Assembly	1

G50300AA Cutter Box Assembly Complete-G5 LOOP.

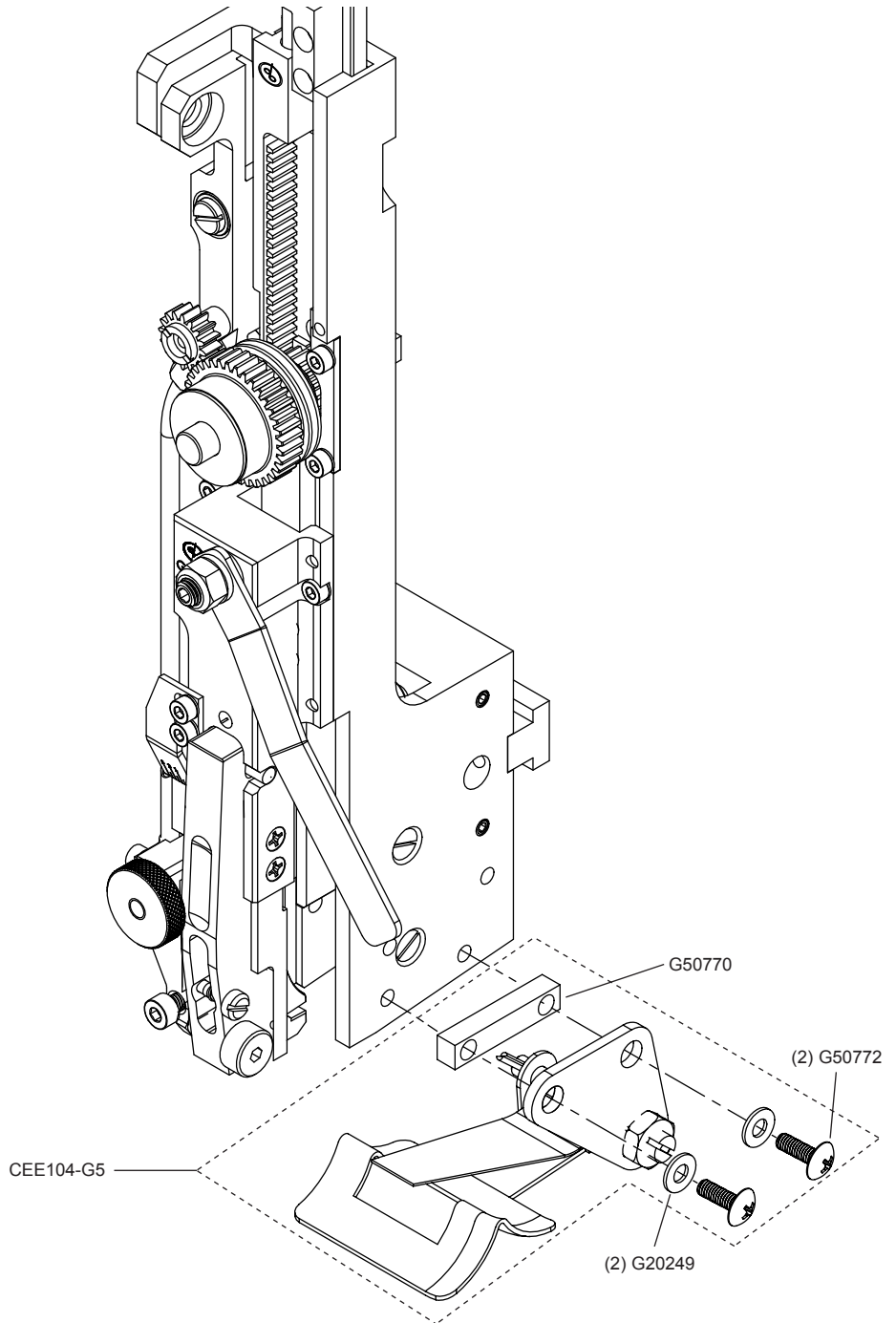
040020	Fixed Cutter, DB45	1
DW073003	Retaining Ring - Low Clear	1
DW20621	Wire Adjustment Knob	1
G20194	Screw M3x0.5x3	1
G20219	Disc Spring	4
G20226	Hex Nut M4x0.7	2
G20247	Screw M4x0.7x6, Nylon	1
G20647	Screw M3x0.5x5, Nylon	2
G50145B	Moving Wire Cutter	1
G50198B-1	Cutter Slide Block - G5 Loop	1
G50198B-2	Cutter Slide Shaft - G5 Loop	1
G50199B-1A	Lower Tube Assembly	1
G50199B-2	Lower Tube Cover - G5 Loop	1
G50206B	Eccentric. Shaft	1
G50208	Roller, G5 loop	2
G50210	Cutter Operating Spring	1
G50300A	Cutter Box Assembly, G5 Loop	1
G50337	Spring Pin M2.5x6, Hardened	1
G50383B	Screw M3X0.5X6, Hardened	1
G50391B-1	Cutter Base - G5 Loop	1
G50391B-2	Base, Adjustment Tab	1
G50720	Screw M3X0.5X6	4

**CEE104 - G5
Work Alignment Gauge Assembly**

The standard G5 Head can be fitted with a work alignment gauge to properly hold and align the booklet being stitched. Contact your DeLuxe Stitcher Graphic Arts Representative or the DeLuxe Stitcher Customer Service Department for ordering information or for additional technical information on other accessories available..



PROPERLY ASSEMBLED WORK ALIGNMENT GAUGE TO BONNET



CEE104-G5 Work Alignment Assembly - G5 Heads

072003	Screw M4x0.7x12	2
CEE104	Work Aligment Assembly	1
G20249	M4 Washer	2
G50770	Centerinig Guide Spacer	1

NOTES: