

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 8.0 lbs... (3.6 kg)

Physical Dimensions

Height 10-3/4 (26.3 c m)

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

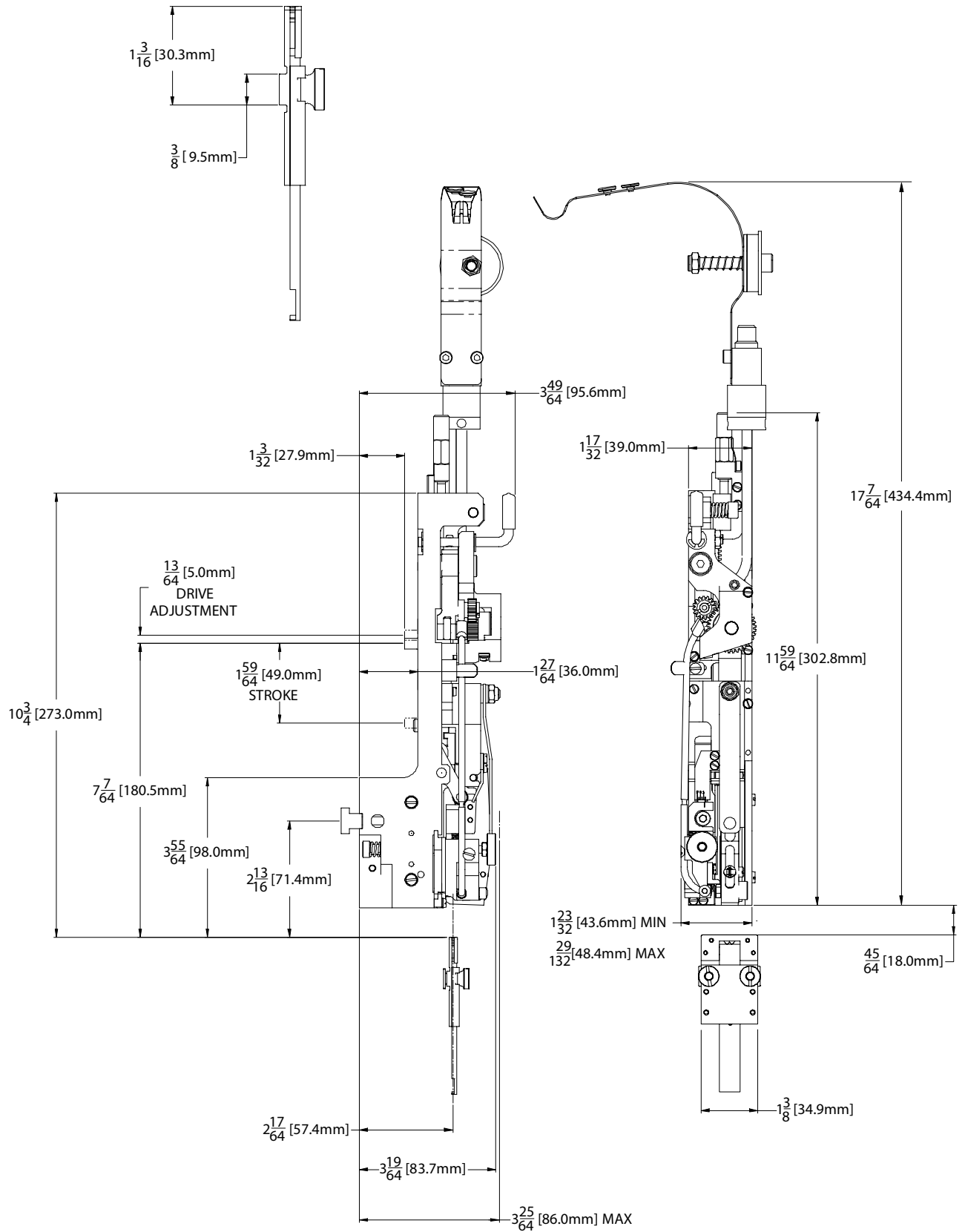
Minimum Head Center

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

Stitches Per Hour 10,000 max.

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 Watkiss Edition Manual
- Bag of Tools with 2.0 mm, 3.0 mm & 7.0mm Open End Wrenches
- T-Handle Hex Head Wrench - 4 mm
- Head Mounting Key
- Clincher Plate, Points, Slide, Nuts & Studs
- Clincher Alignment Gauge
- Wire Guide Spring and Wire Anti-Backup Unit
- Manual Feed Gear Tool
- Stitch Samples

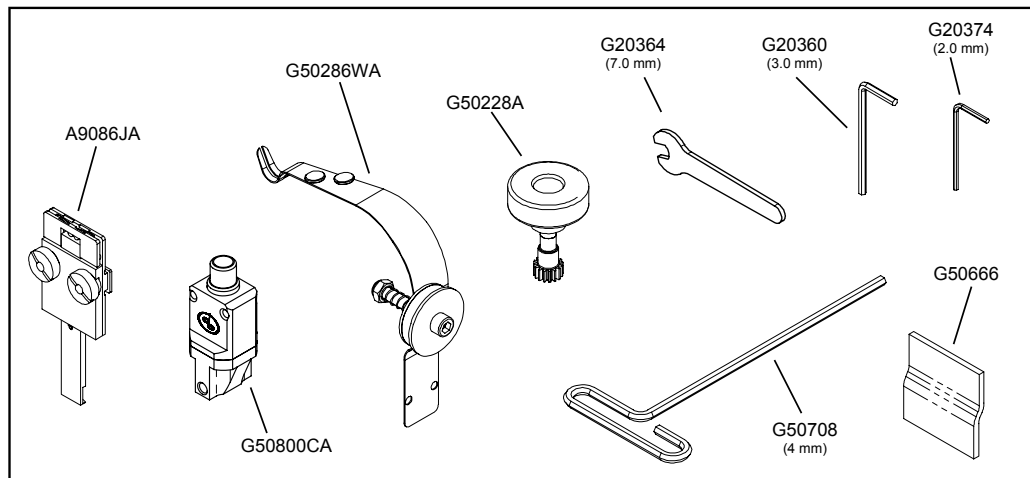
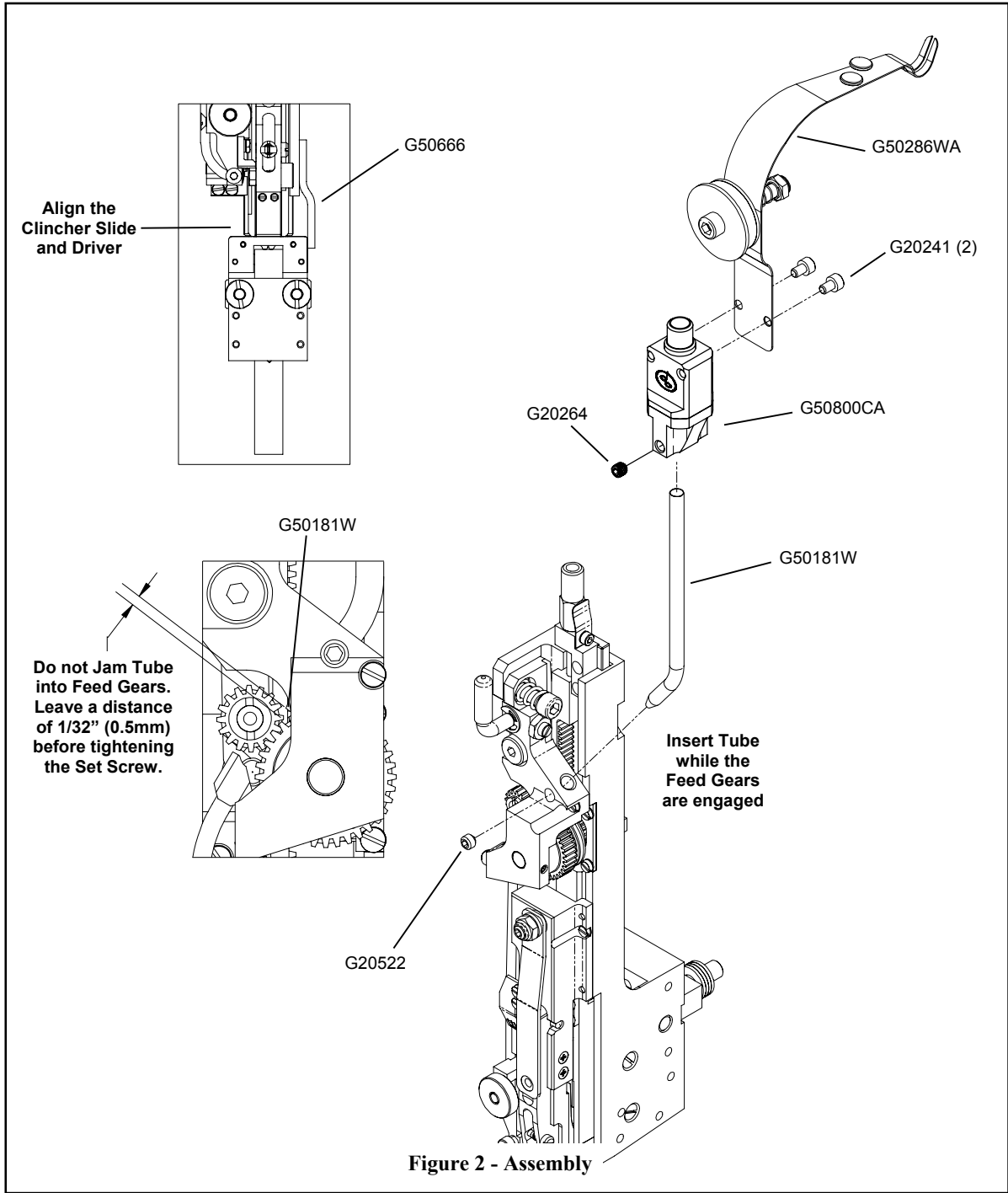


Figure 1 - Parts Package Contents

Assembly (Figures 2 - 4)



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

Mounting (Figures 3)

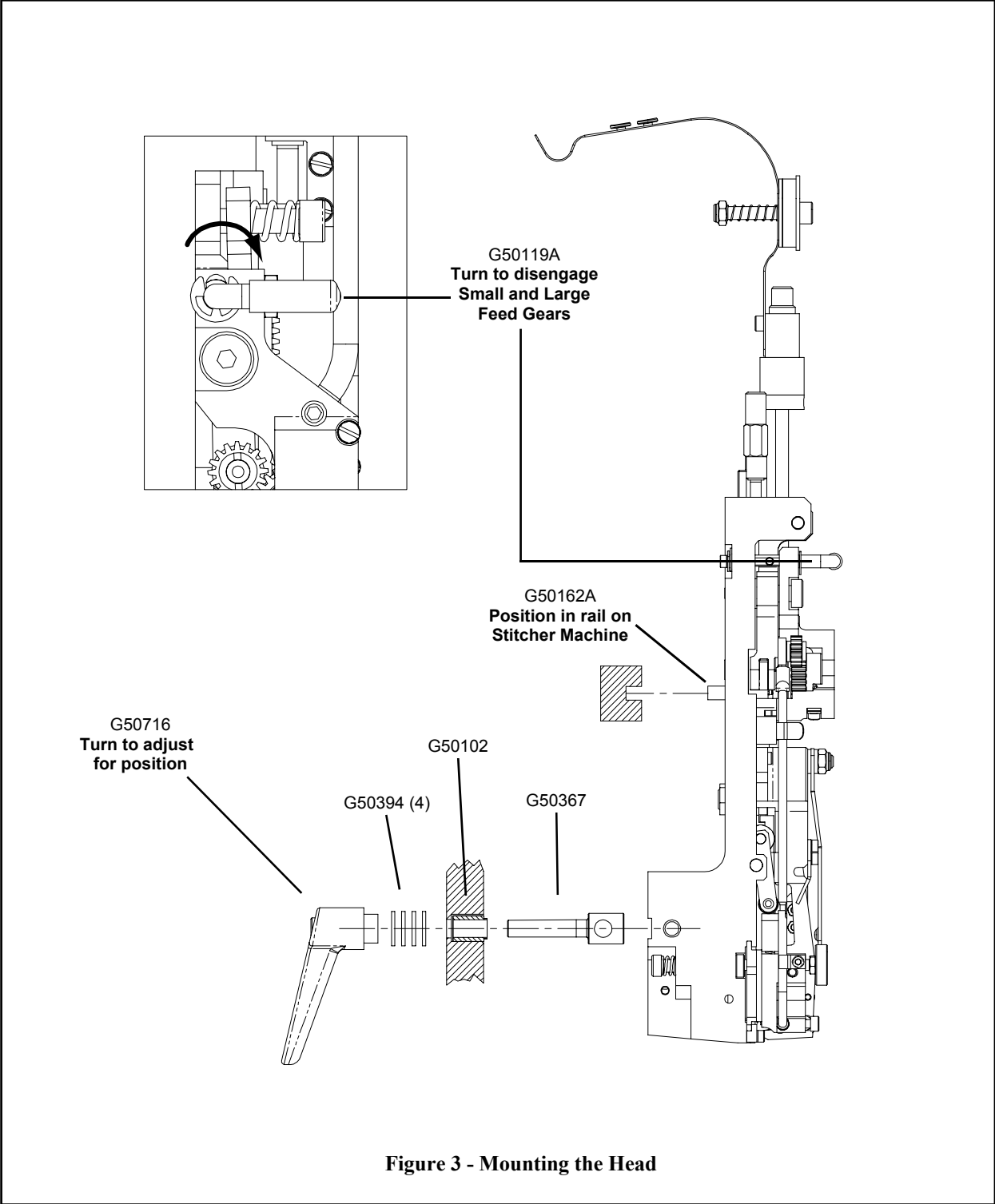
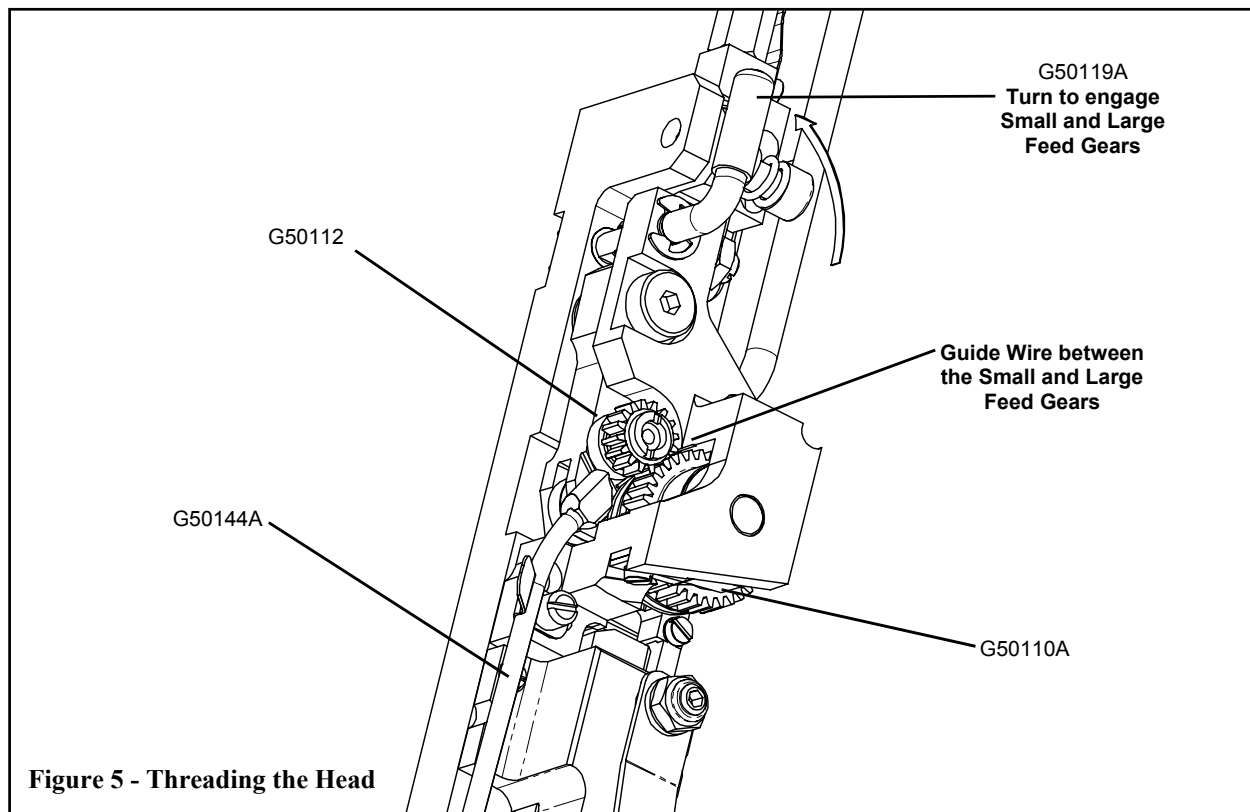
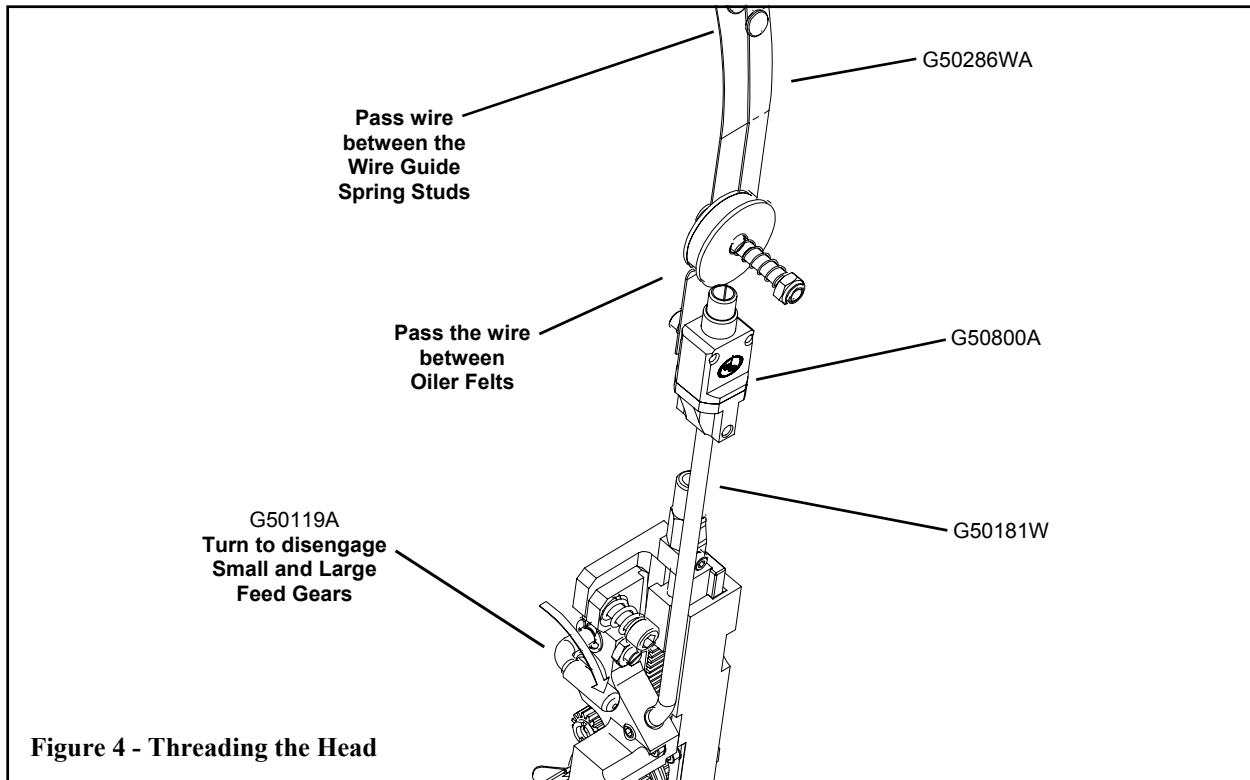


Figure 3 - Mounting the Head

Wire Threading (Figures 4 & 5)



Adjust the Length of the Stitch Leg (Figure 6)

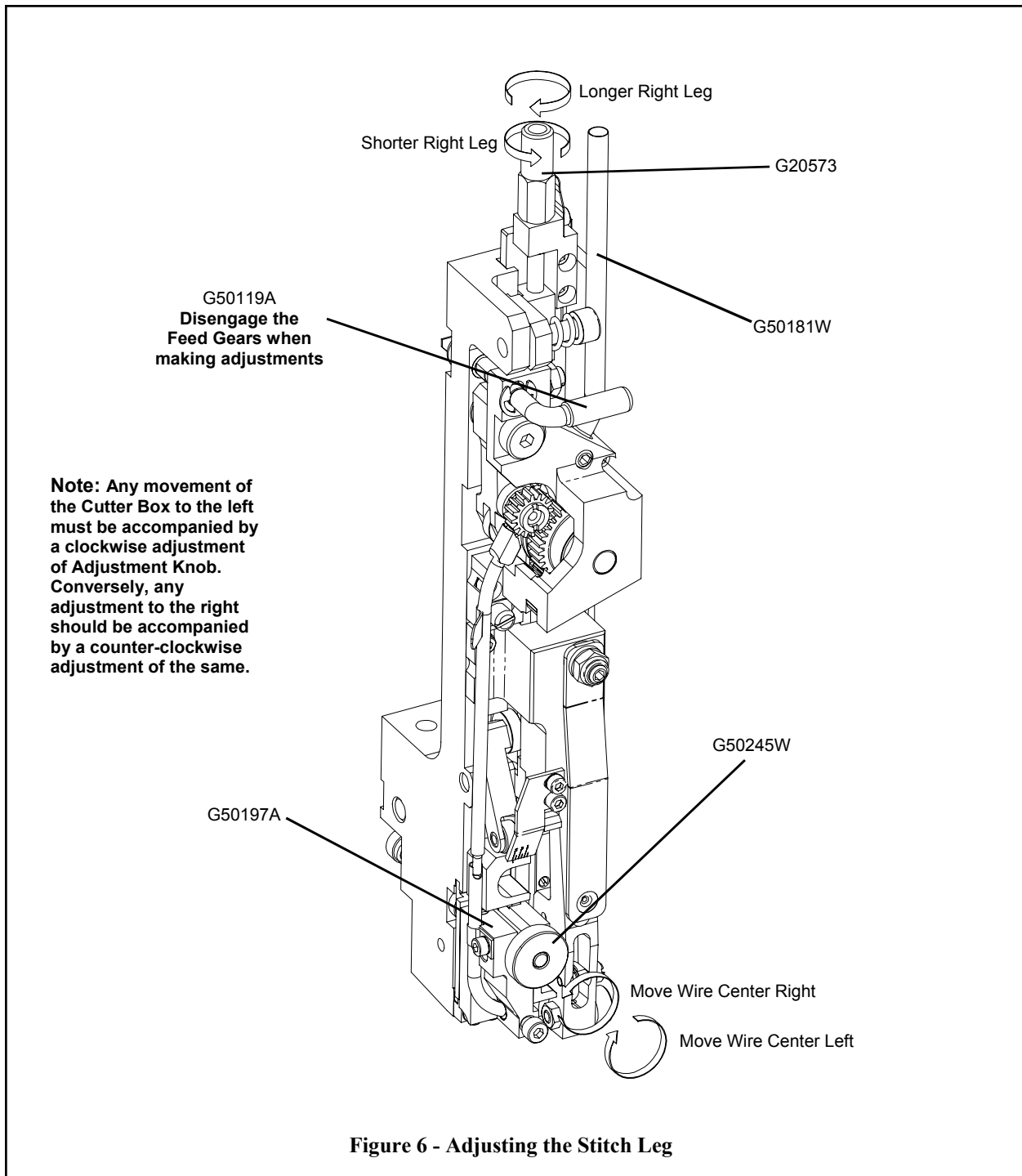
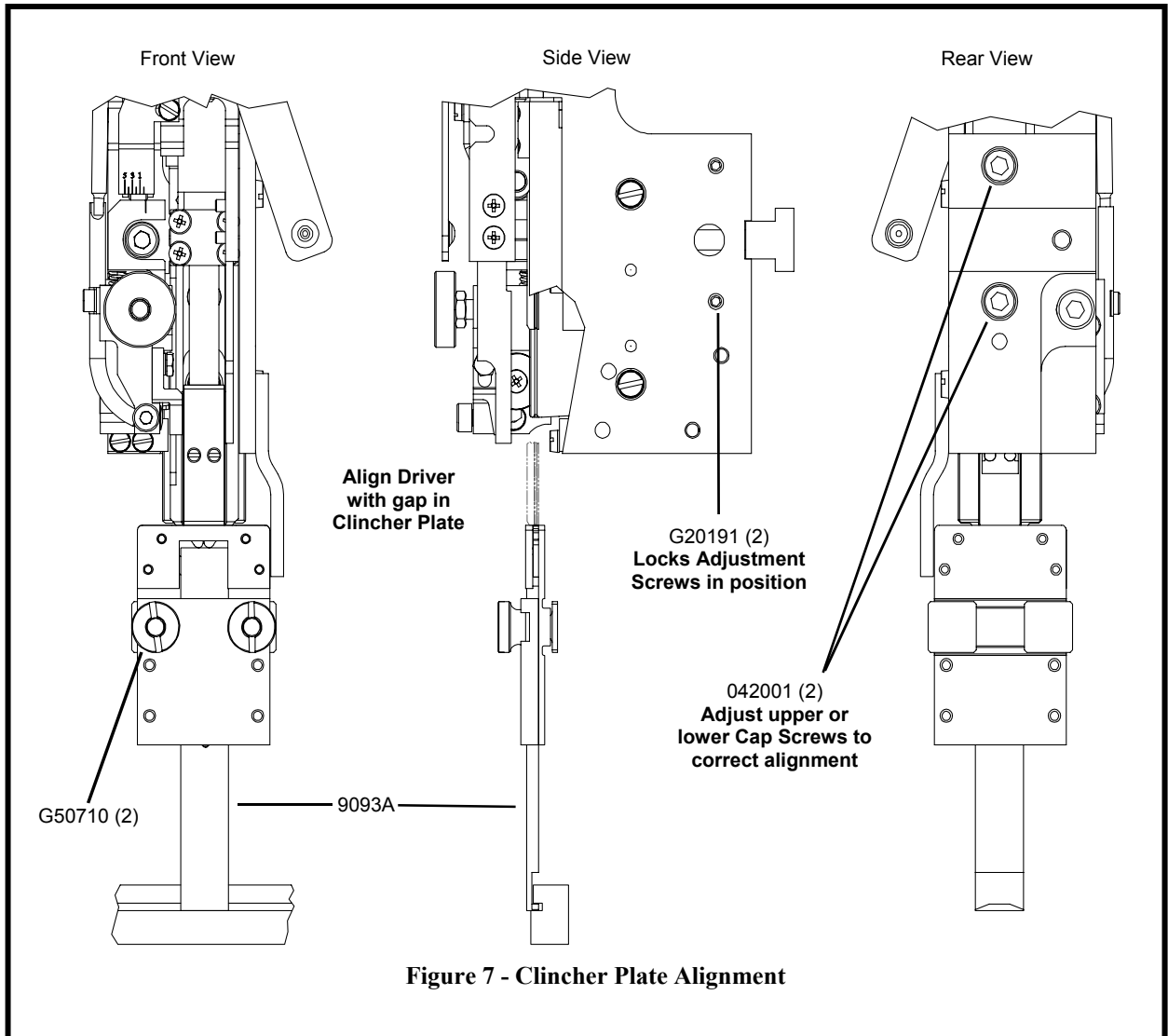


Figure 6 - Adjusting the Stitch Leg

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 (Figures 8)

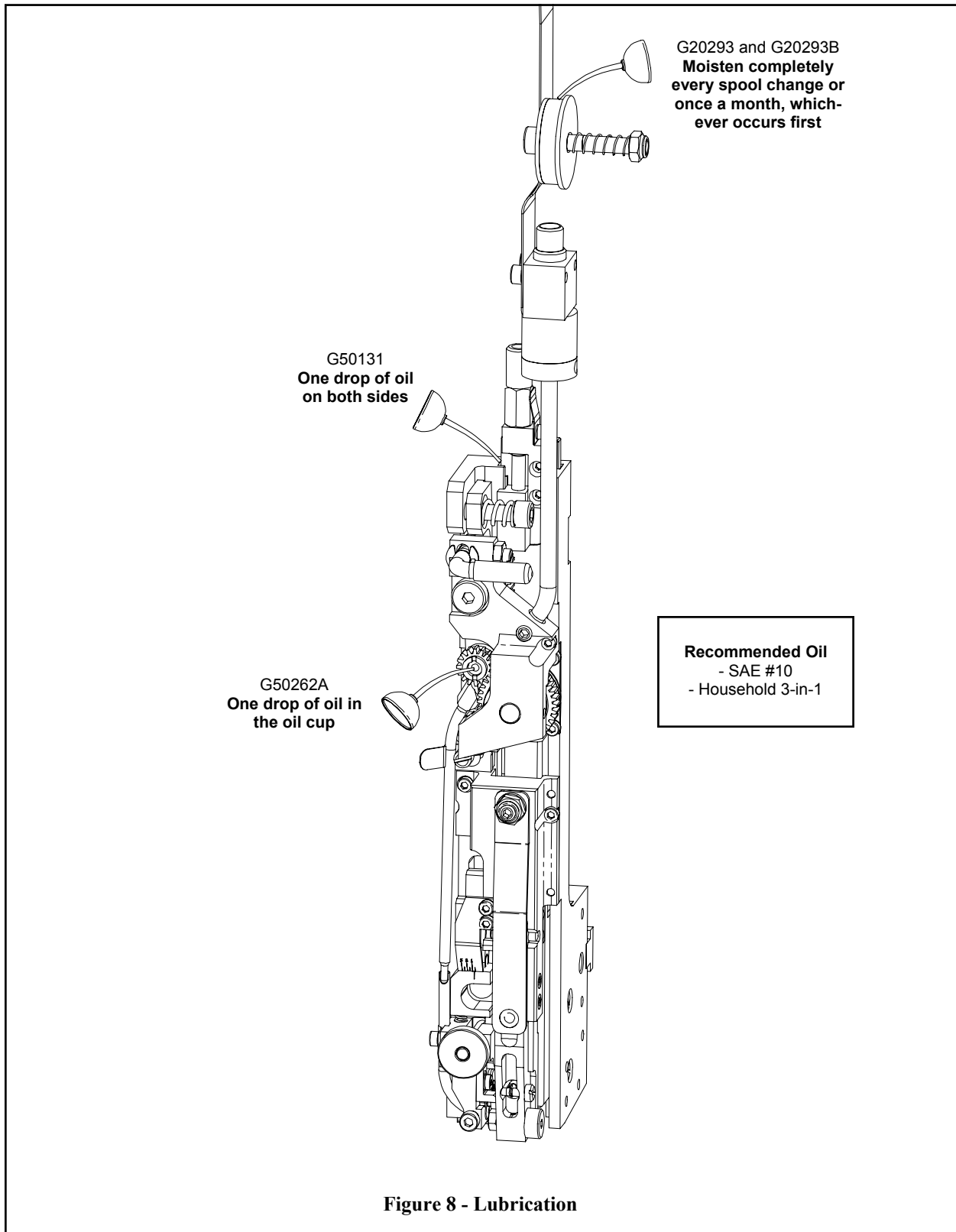
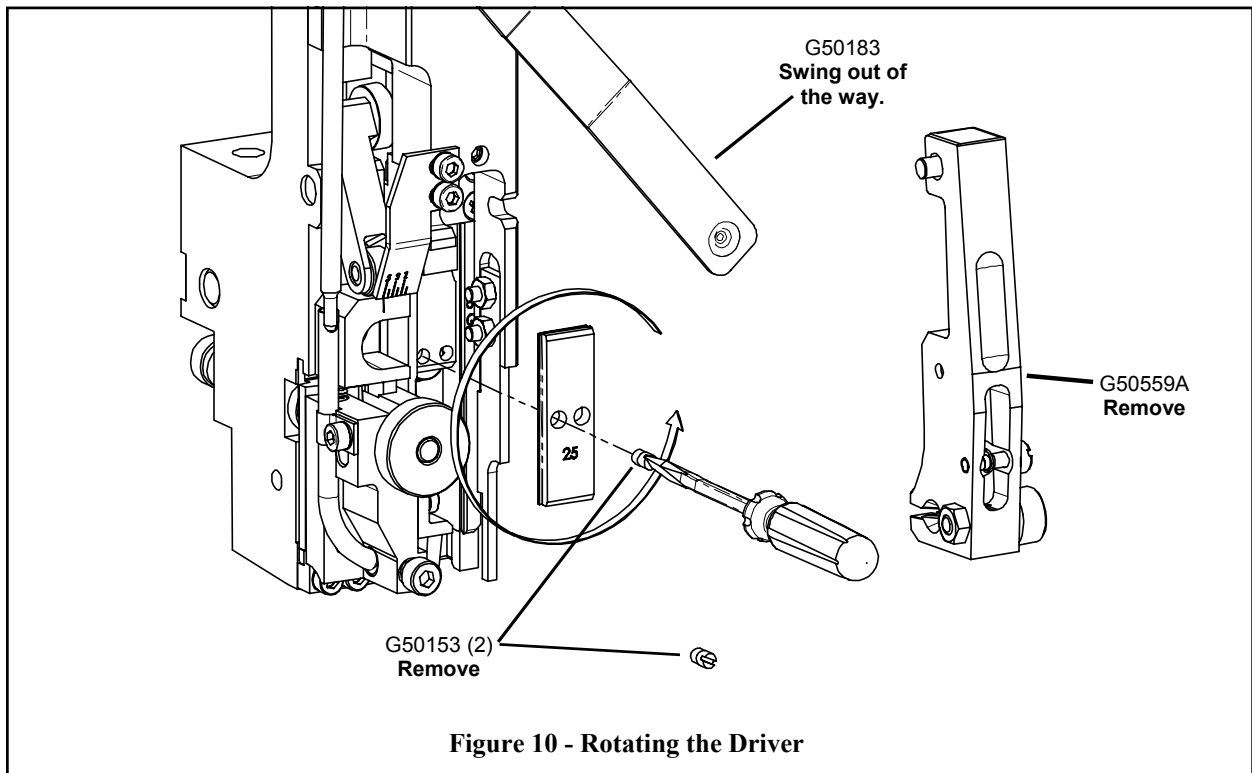
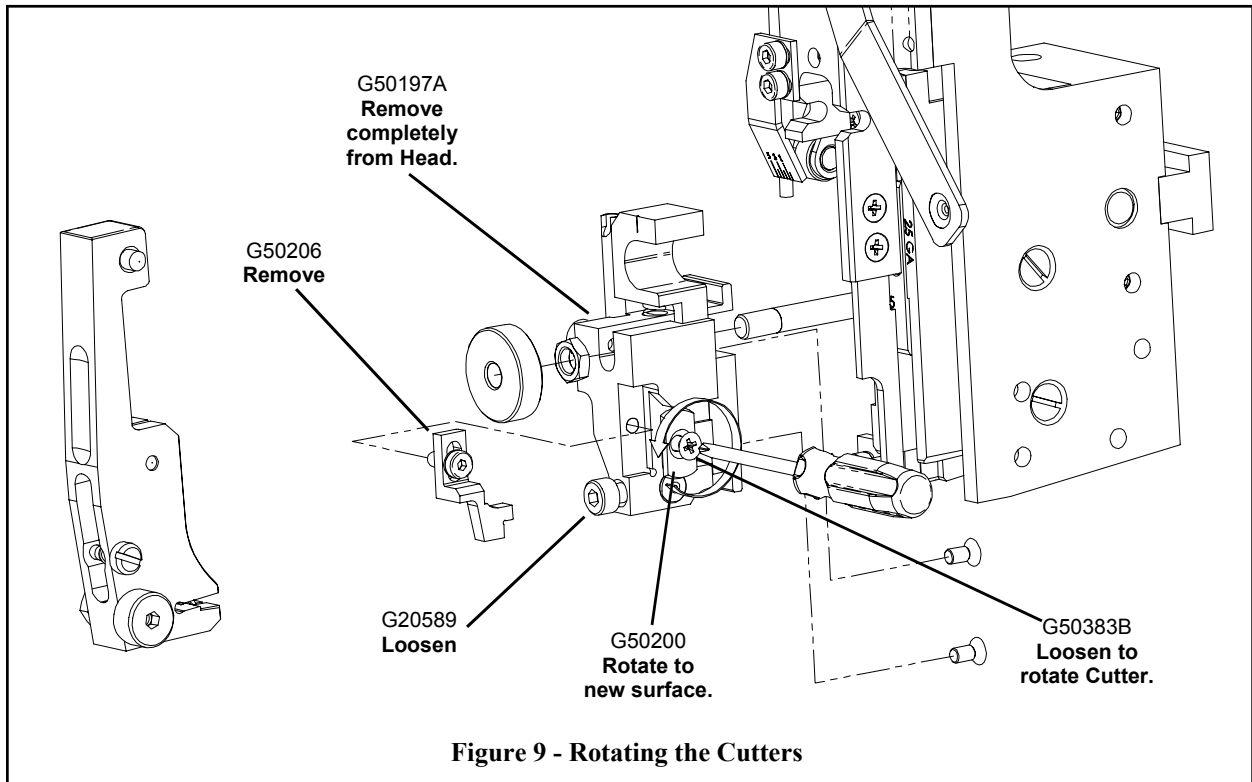


Figure 8 - Lubrication

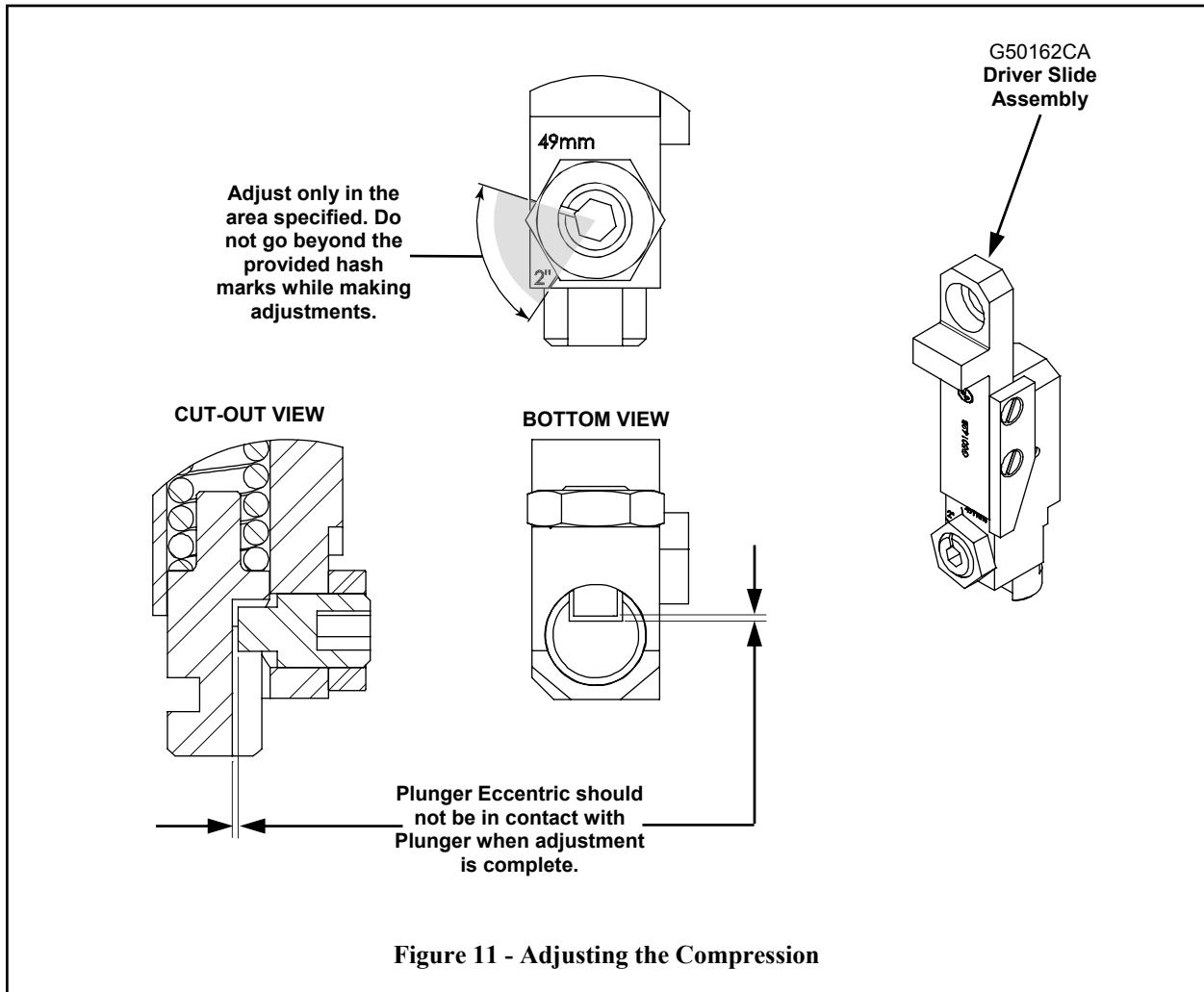
Rotating Replacement Parts (Figures 9 & 10)



Compression Adjustment (Figure 11)

⚠ WARNING

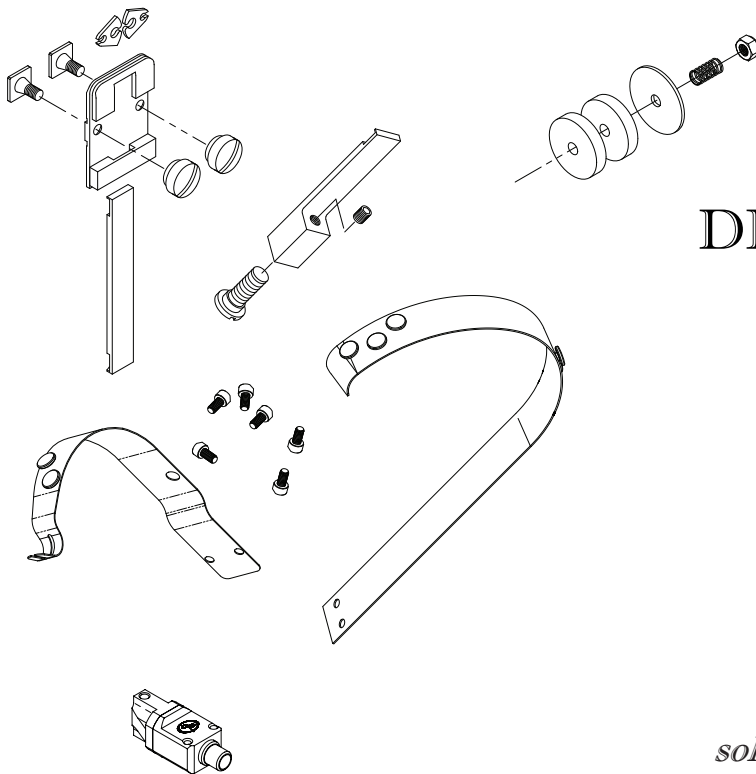
Compression is set at the factory and should not need any adjustments beyond what is stated below.



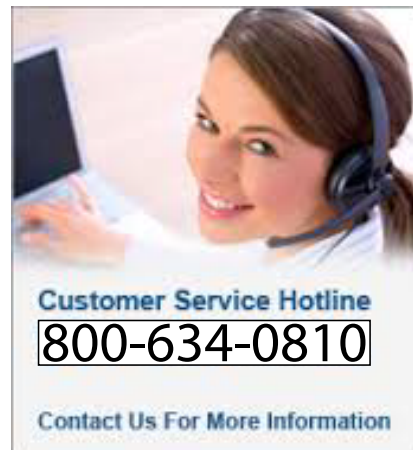
Ordering Spare Parts

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 the part number, description and quantity.

???



DELUXE STITCHER



*solving your wire stitching needs for
125 years...*

Cleaning

Routine cleaning is important for the maintenance of your G5 Head. Blow off dust, dirt and build-up with compressed air at every Spool changes, including:

- 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.

The Head should be refurbished every one million stitches.



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.

Troubleshooting (Figure 22)



PROBLEM: Leg[s] Buckled

SOLUTION: If the ends of an unformed piece of wire are not smooth, the Wire Cutters are worn. Check for wear and rotate or replace if needed. Make sure the Cutters are aligned properly. Make sure the correct wire size is being used and that the wire is straight.



PROBLEM: Corner Buckled

SOLUTION: Check the Driver for a chipped corner and rotate or replace it if needed. Align the Wire Holder. Straighten wire. Check the tensile strength of the wire or use thicker wire.



PROBLEM: Clinch Too Loose

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.



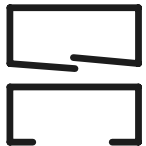
PROBLEM: Left Leg Too Short / Right Leg Too Long

SOLUTION: Adjust the position of the Cutter Block Assembly by moving it away from the Head.



PROBLEM: Left Leg Too Long / Right Leg Too Short

SOLUTION: Adjust the position of the Cutter Block Assembly by moving it towards the Head.



PROBLEM: Staple Legs Too Long or Too Short

SOLUTION: Correct the overall wire draw by adjusting the Feed Rack Adjustment Knob.



PROBLEM: Legs are Spread or Contracted
SOLUTION: Straighten the wire. Replace worn Bender Bars.



PROBLEM: Legs Stray Forward or Backward Consistently
SOLUTION: The Clincher Points are not aligned properly front to back. Straighten the wire.



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



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



PROBLEM: Wire jam
SOLUTION: Be sure the Cutter Operating Lever moves freely. Add oil to Pivot Pin if necessary. Readjust Fixed Wire Cutter. Make sure cutters are sharp. Inspect and rotate as required.

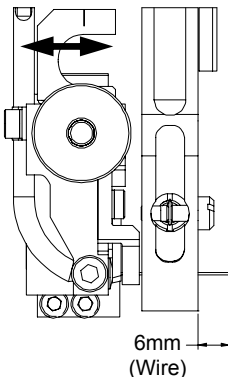
**NO STITCH
MADE**

PROBLEM: No wire being drawn
SOLUTION: Make sure the Feed Release Cam is turned to the “on” position and the Feed Gears engaged.

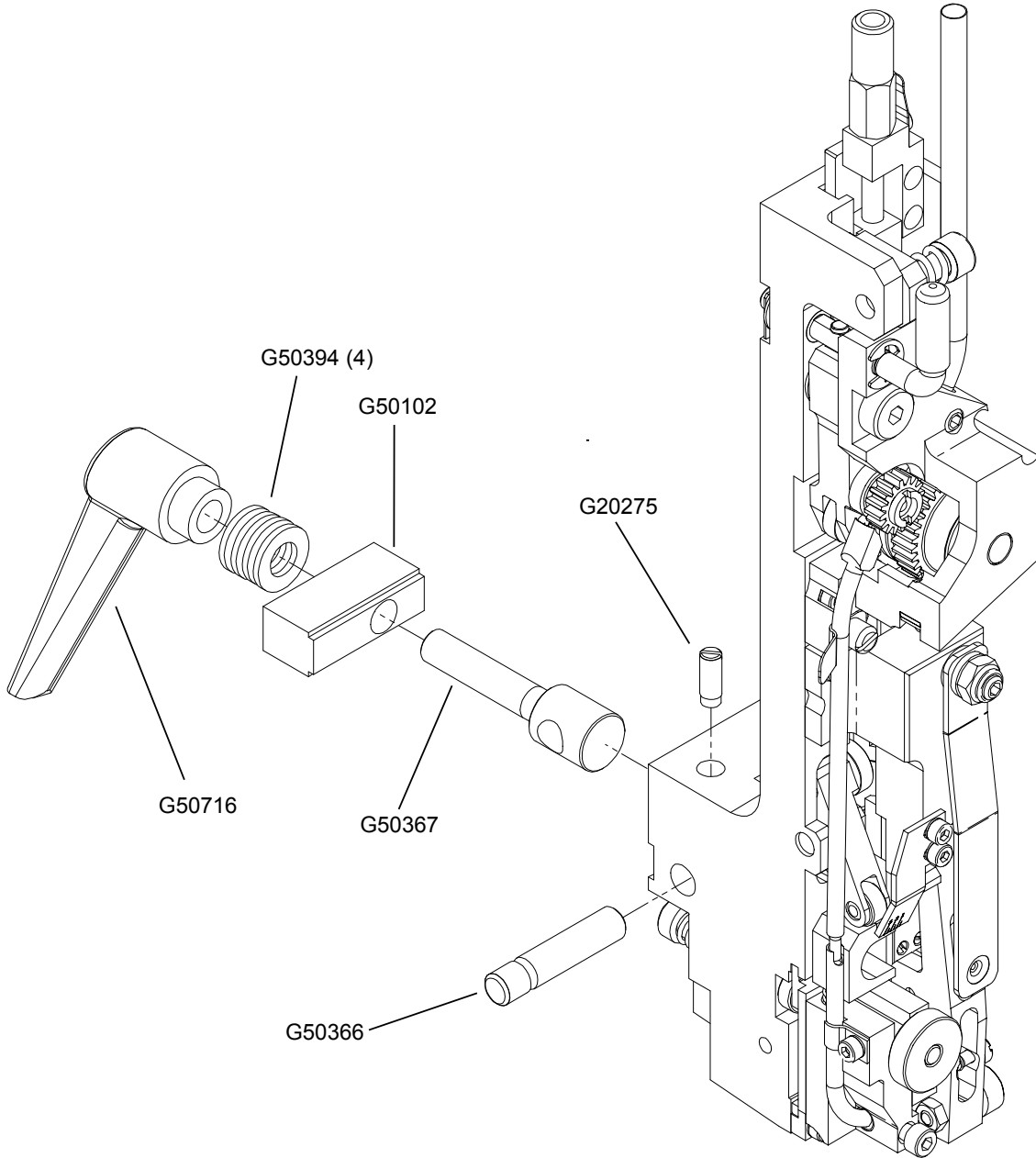
**NO STITCH
MADE**

PROBLEM: Dropped stitches
SOLUTION: (Refer to illustration at the left and Fig. 6)

1. Pull the Wire Holder away from the Head to remove any wire that may already be loaded.
2. Move the Cutter Box all the way to the right.
3. With the Feed Gears engaged, cycle the machine, then pull the Wire Holder out away from the Head to remove the wire.
4. Cycle the machine again and measure the length of wire protruding past the right side of the Wire Holder. This length should be 6mm. If the length is not 6mm, then increase or decrease the wire draw with the Adjustment Knob [G20245W].
5. Pull the Wire Holder out away from the Head to remove the wire.
6. Repeat the previous 2 steps until the wire protrudes 6mm past the Wire Holder.
7. Refer to Fig. 6 to adjust the location and size of the gap.



Head Mounting

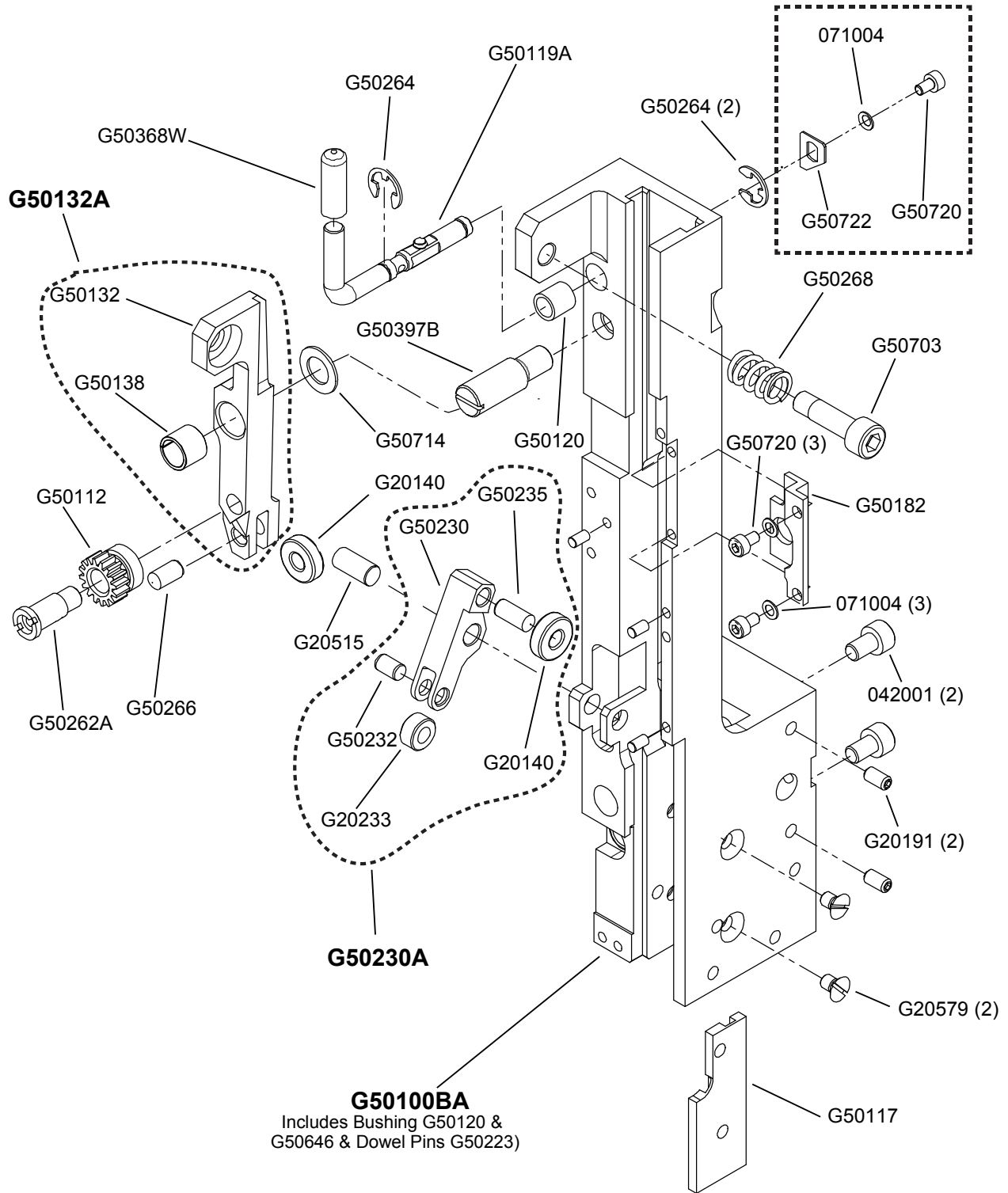


Part Number / Description Cross-Reference / QTY

Assembly Parts

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

Bonnet—Sub-Assembly #1



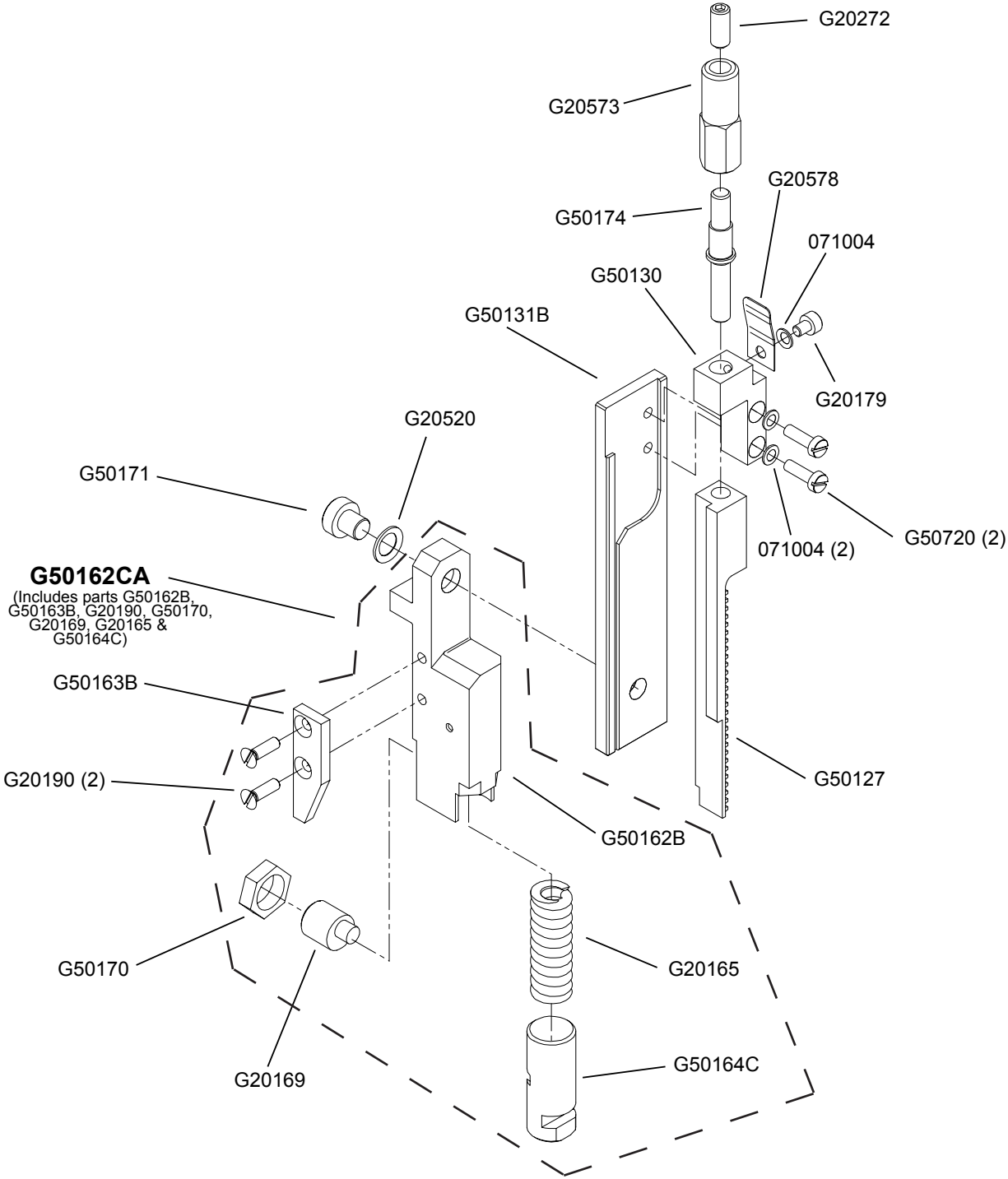
Bonnet-Sub Assembly #1 Parts

042001	Screw M5x0.8x8	2
071004	Lock Washer Ribbed	3
G20140	Follower ball bearing	1
G20191	Screw M4x0.7x8	2
G20515	Dowel Pin M6x14	1
G20579	Screw M4x0.7x6	2
G50100BA	Bonnet Assembly - G5 - Wide Slot	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
G50368W	Handle Cap - Orange	1
G50397B	Stud, G5 Feed Lever	1
G50703	Feed Lever Spring Screw	1
G50714	Feed Lever Spacer	3
G50720	Screw M3 x 0.5 x 6	3
G50722	Feed Release Handle Stop	1

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
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
G50137	Feed Gear Clutch	1
G50141	Wire Guide Bar	1
G50143	Pivot Block	1
G50144A	Middle Wire Tube Assembly	1
G50181W	Upper Wire Tube, Watkiss	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	1
G50711	Screw Spring	1
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



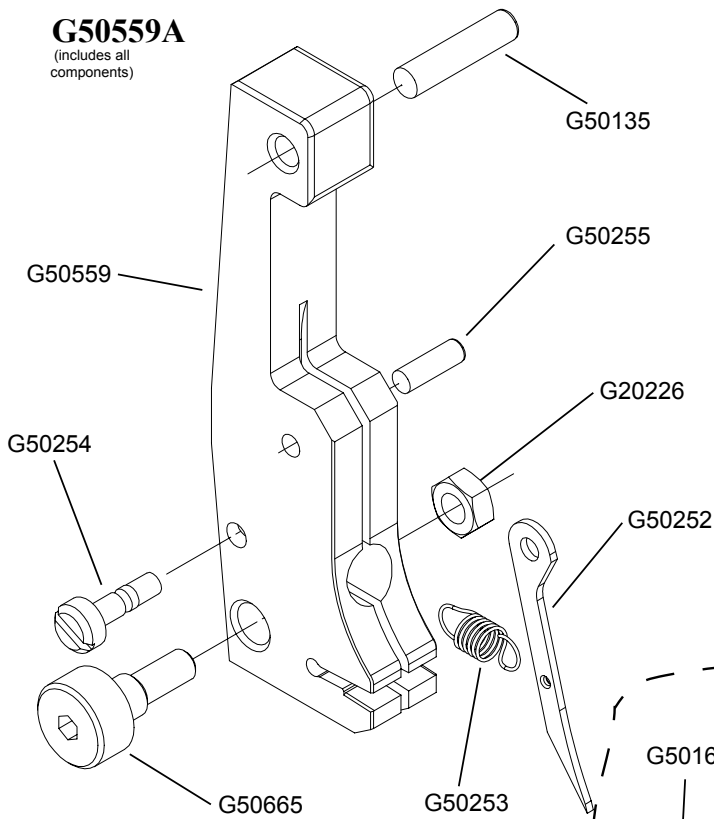
Driver And Feed Slide Assembly Parts

071004	Lock Washer Ribbed	3
G20272	Screw M5x0.8x12	1
G20573	Feed Rack Adjustment Knob	1
G20578	Rack Adjustment Detent	1
G50174	Feed Rack Adjustment Stud	1
G50130	Feed Adjustment Block	1
G20179	Screw M3x0.5x4	1
G50131	Feed Slide	1
G50720	Screw M3x0.5x6	2
G20520	Ribbed Lock Washer M6	1
G50171	Screw M6x1.0x6	1
G50162CA	Driving Slide Assembly, STANDARD	1
G20190	Screw M3x0.5x10	2
G50170	Custom Hex Nut M10x1.25	1
G50163B	Cutter Operating Cam	1
G50170	Custom Hex Nut M10x1.25	1
G50169	Driving Slide Plunger Ecc.	1
G50164C	Plunger	1

Wire Holder Assembly

G50559A

(includes all components)

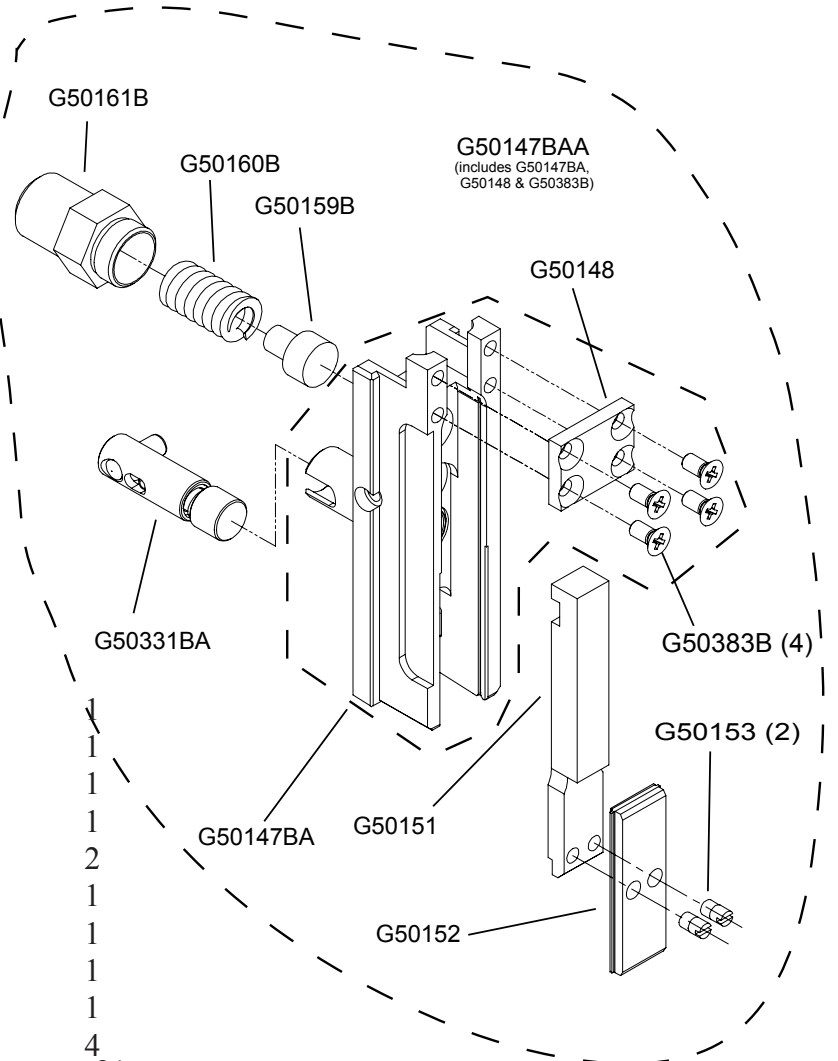


Assembly Parts

G20226	Hex Nut M4x.7	1
G50135	Wire Holder Pivot Pin	1
G50252	Wire Hook	1
G50253	Wire Hook Spring	1
G50254	Wire Holder Spring Screw	1
G50255	Dowel Pin M3x10	1
G50559	Wire holder	1
G50665	Adjustment Screw	1

Driver and Bender Bars

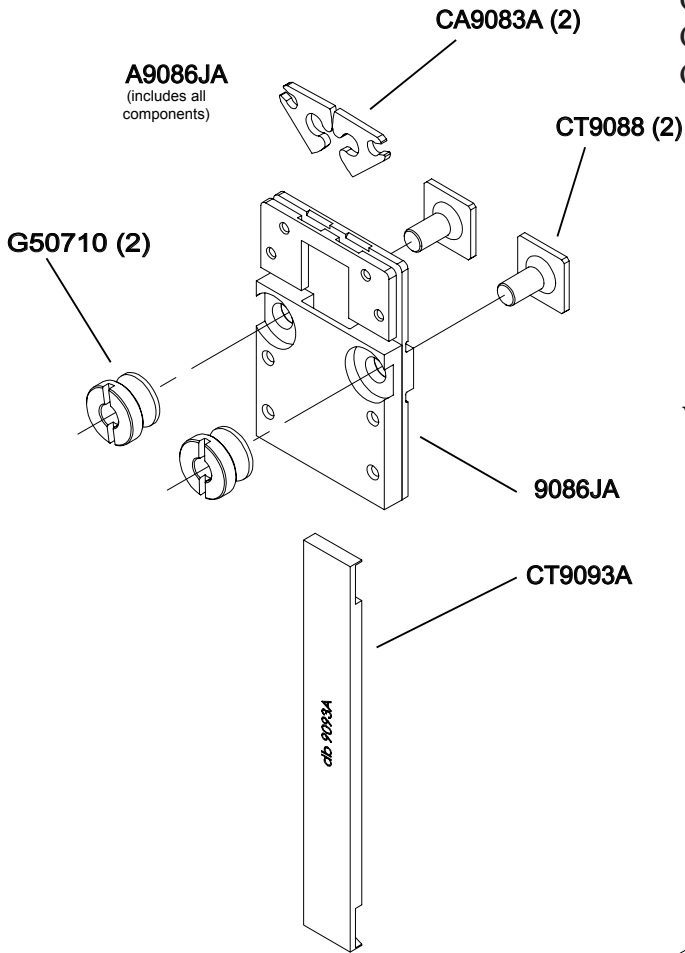
AG50147BAA



Assembly Parts

G50147BA	Bender Bar Assembly	1
G50148	Bender Bar Friction Plate	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
G50383B	Screw M3 x 0.5 x 6	4

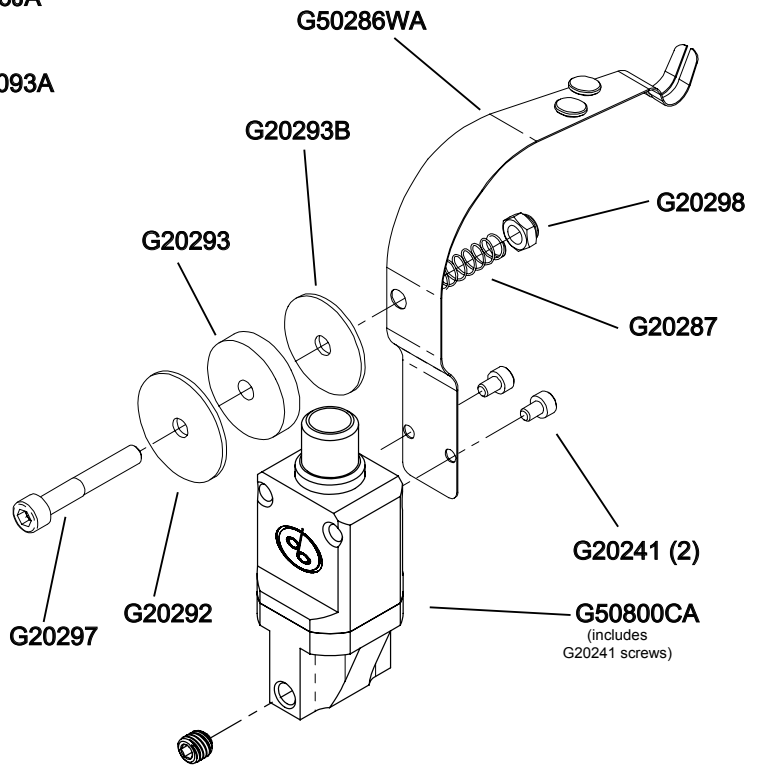
Clincher Plate Assembly



Assembly Parts

9086JA	Clincher Plate ASSEM. - Thick,	1
CA9083A	Clincher Point - Thick, Round	2
CT9093A	Clincher Slide - Thick	1
CT9088	Clincher Plate Binder Bolt	2
G50710	Clincher Plate Nut	2

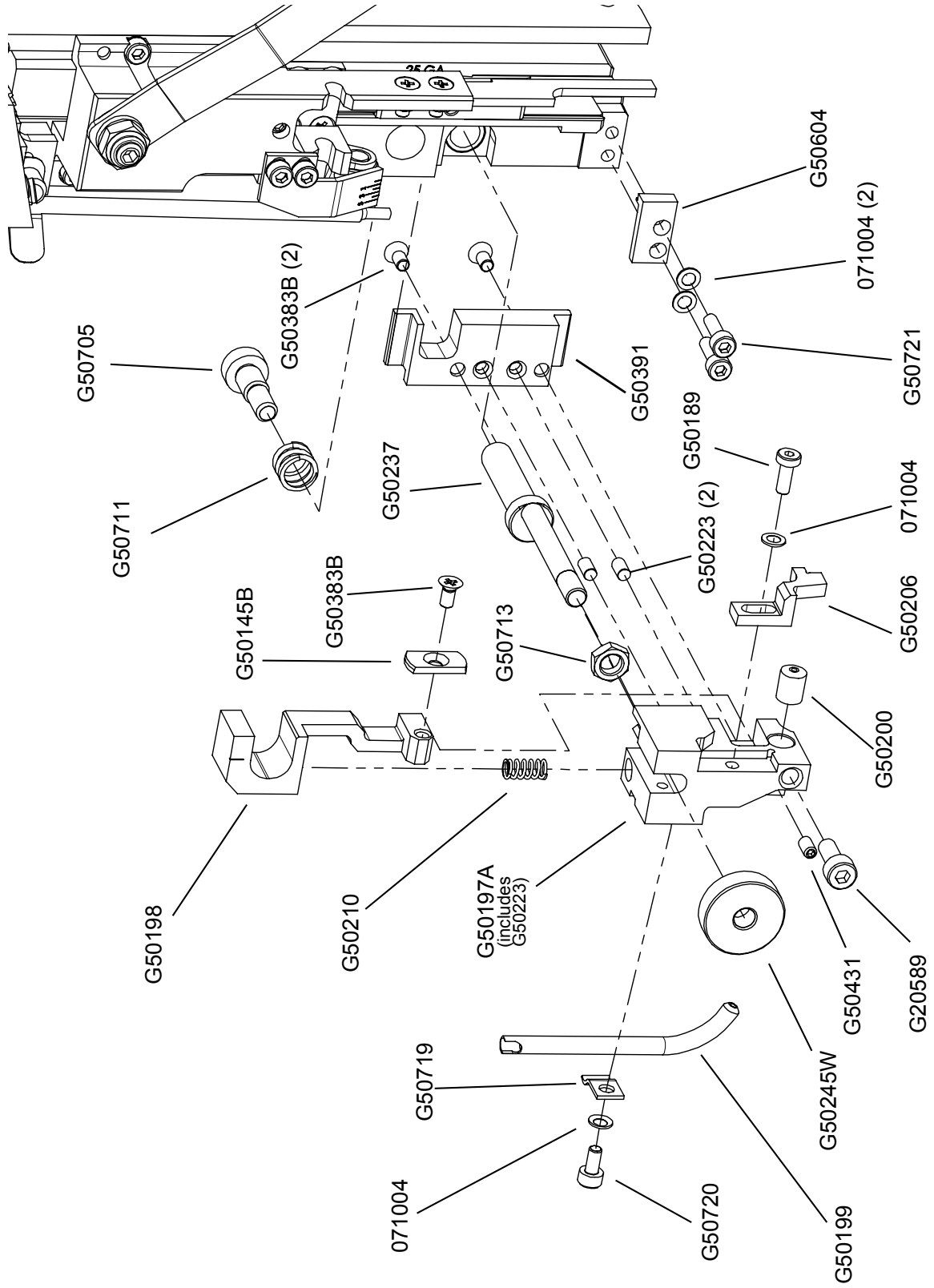
Wire Guide Bracket and Spring



Assembly Parts

G20241	Screw M4x0.7x6	2
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	Guide Spring Assembly, Watkiss	1
G50800CA	Wire Anti-Back Up Unit	1

Cutter Box Assembly



Assembly Parts

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
G50245W	Cutter Box Adjustment Knob	1
G50383B	Screw M3x0.5x6	3
G50391	Cutter Box Mounting Plate	1
G50431	Screw M3x0.5x6	1
G50604	Shoulder Screw M6x8	2
G50711	Screw Spring	1
G50713	Hex Jam Nut M5	1
G50719	Lower Tube Clip	1
G50720	Screw M3x0.5x6	1
G50721	Screw M3x0.5x10	2

NOTES:

Part Number / Description Cross-Reference

042001	Screw M5x0.8x8	2	G50110A	Large Feed Gear Assembly	1
071004	Lock Washer Ribbed	17	G50111A	Feed Pinion Assembly	1
2215	Driving Shaft Connector	1	G50112	Small Feed Gear	1
9083A	Clincher Point -Thick, Round	2	G50114	Feed Gear Pin	1
9084B	Adjustable Clincher Slide	1	G50117	Forming Pin Cam	1
9086JA	Clincher Plate -Thick, Round	1	G50119A	Feed Release Handle Assembly	1
9087	Clincher Slide Adjustment Screw	1	G50120	Feed Release Handle Bushing	1
9088	Clincher Plate Binder Bolt	2	G50126	Screw M5x0.8x25	1
9093A	Clincher Slide - Thick	1	G50127	Feed Rack	1
A9086JA	Clincher Plate Assy.—Thick	1	G50128	Pinion Washer	1
G20121	Feed Release Plunger	1	G50129	Large Feed Gear Washer	1
G20140	Follower Ball Bearing	2	G50130	Feed Adjustment Block	1
G20165	Driving Slide Spring	1	G50131B	Feed Slide	1
G20169B	Driving Slide Plunger Screw Ecc.	1	G50132	Feed Lever	1
G20179	Screw M3x0.5x4	1	G50132A	Feed Lever Assembly	1
G20190	Screw M3x0.5x10	2	G50135	Wire Holder Pivot Pin	1
G20191	Screw M4x0.7x8	4	G50136	Feed Gear Bracket	1
G20226	Hex Nut M4x.7	1	G50137	Feed Gear Clutch	1
G20233	Cutter Operating Lever Roller	1	G50138	Feed Pinion Bearing	2
G20236	Tube Pivot Screw	1	G50141	Wire Guide Bar	1
G20241	Screw M4x0.7x6	2	G50142	Screw M3x0.5x6	1
G20272	Screw M5x0.8x12	1	G50143	Pivot Block	1
G20274	Hex Jam Nut, M6x1	1	G50144A	Middle Wire Tube Assembly	1
G20275	Ball Spring Plunger	1	G50145B	Moving Cutter	1
G20287	Wire Oiler Felt Spring	1	G50147BA	Bender Bar	1
G20290	Flat Washer, M5	2	G50147BAA	Bender Bar Assembly	1
G20292	Wire Oil Felt, Washer	1	G50148	Bender Bar Friction Plate	1
G20293	Wire Oiler Felt	1	G50151	Driver Bar	1
G20293B	Wire Oiler Felt, Thin	1	G50152	Driver - 25 Wire	1
G20297	Screw M6x1.0x40	1	G50153	Driver Retaining Screw	2
G20298	Nylock Lock Nut, M6x1	2	G50159B	Friction Plug	1
G20360	Hex Key Wrench 3.0mm	1	G50160B	Bender Bar Friction Spring	1
G20364	Open End Wrench 7.0mm	1	G50161B	Friction Plug Bushing	1
G20374	Hex Key Wrench 2.0mm	1	G50162B	Driving Slide	1
G20515	Dowel Pin M6x14	1	G50162CA	Driving Slide Assembly	1
G20520	Ribbed Lock Washer M6	1	G50163B	Cutter Operating Cam	1
G20522	Screw M6x1.0x5, Nylon	1	G50164C	Plunger	1
G20573	Feed Rack Adjustment Knob	1	G50169	Driving Slide Eccentric	1
G20578	Rack Adjustment Knob Detent	1	G50170	Hex Nut, M10	1
G20579	Screw M4x0.7x6	2	G50171	Screw M6x1.0x6	1
G20589	Screw M4x0.7x10	1	G50174	Feed Rack Adjustment Stud	1
G20615	Screw M5x0.8x8	1	G50181W	Upper Wire Tube	1
G50100BA	Bonnet Assembly - G5	1	G50182	Feed Gear Plate	1
G50101	Clamp Block	1	G50183	Wire Holder Retaining Spring	1
G50102	Mounting Block - Keyed	1	G50186	Feed Gear Friction Spring	1
G50110	Large Feed Gear	1	G50187	Feed Gear Friction Pad	1

Part Number / Description Cross-Reference

G50189	Screw M3x0.5x10	1	G50695	Screw M6x1.0x20	1
G50197A	Cutter Box Assembly	1	G50703	Feed Lever Spring Screw	1
G50198	Cutter Operating Slide	1	G50705	Shoulder Screw M6x8	2
G50199	Lower Wire Tube	1	G50708	T-Handle Hex Key Wrench	1
G50200	Fixed Wire Cutter	1	G50703	Feed Lever Spring Screw	1
G50206	Wire Straightener	1	G50705	Shoulder Screw M6x8	2
G50210	Cutter Operating Spring	1	G50707	Dbl. Open End Wrench - 5.5 & 7 mm	1
G50223	Dowel Pin M3x6	4	G50708	T-Handle Hex Key Wrench	1
G50228A	Manual Feed Gear Tool	1	G50710	Clincher Plate Nut	2
G50230	Cutter Operating Lever	1	G50711	Cutter Box Ecc. Screw Spring	2
G50230A	Cutter Operating Lever Assembly	1	G50713	Hex Jam Nut M5	1
G50232	Dowel Pin	1	G50714	Feed Lever Spacer	1
G50235	Dowel Pin M5x12	1	G50716	Mounting Block Handle	1
G50237	Cutter Box Adjusting Eccentric	1	G50717	Hex Nut M3x0.5	2
G50244	Tube Clip	1	G50718	Feed Gear Spring	1
G50245W	Cutter Box Adjustment Knob	1	G50719	Lower Tube Clip	1
G50252	Wire Hook	1	G50720	Screw M3x0.5x6	9
G50253	Wire Hook Spring	1	G50721	Screw M3x0.5x10	6
G50254	Wire Holder Spring Screw	1	G50722	Feed Release Handle Stop	1
G50255	Dowel Pin M3x10	1	G50800CA	Wire Anti-Back Up Unit - M6 Tube	1
G50256	Scale	1	UA4808.7	Screw 1/4-28 x 14	1
G50262A	Small Feed Gear Shaft Assembly	1			
G50264	E-Ring 6mm	2			
G50266	Dowel M5x10	1			
G50268	Feed Lever Spring	1			
G50279A	Wire Guide Spring Asy-90 Deg	1			
G50286WA	Wire Guide Spring Asy-Watkiss	1			
G50320BA	Driving Slide Assembly-Crank Drive	1			
G50321	Crank Link Screw	1			
G50331BA	Forming Pin Assembly	1			
G50366	Bonnet Clamp Pin	1			
G50367	Head Mounting Bolt, M8	1			
G50368W	Feed Release Handle Cap-Orange	1			
G50383B	Screw M3x0.5x6	7			
G50391	Cutter Box Mounting Plate	1			
G50394	Flat Washer M8	4			
G50397B	Shoulder Bolt M8x20	1			
G50399	Screw M3x0.5x8	2			
G50431	Screw M3x0.5x6	1			
G50559	Wire Holder	1			
G50559A	Wire Holder Assembly	1			
G50604	Cutter Box Guide Plate	1			
G50617	Wire Holder Retain. Spring Washer	2			
G50646	Cutter Box Eccentric Bearing	2			
G50665	Wire Holder Adjustment Screw	1			
G50666	Clincher Alignment Gage, G5	1			