



C O M P A N Y I N C .

Machine Serial Number : _____

Head Serial Number : _____

Date Purchased: _____

#2/2AW Stitchers

OPERATION AND MAINTENANCE MANUAL

2 Series Stitchers.....Electric Clutch
2AW Stitcher w/Motor.....115V and 60HZ
2EW 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 #2/2AW Stitcher for future reference.

If you have any questions, contact your local
DeLuxe Stitcher Company Graphic Arts Representative or Distributor.

WARNING!

#2/2AW 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.

DELUXE STITCHER

COMPANY INC.

FOR MODEL 2 SERIES WIRE STITCHERS

EQUIPPED WITH WRAP SPRING ELECTRIC CLUTCH AND 2001DHD251/2 HEAD

MODEL 2AW - with motor and 115v and 60Hz service
MODEL 2EW - without motor-with 230v and 50Hz service
MAX CAPACITY - 1/4" (6.35mm)
WIRE SIZE (STD) - *25 (.021) Round
CROWN WIDTH - 1/2" (12.7mm)

OPERATION and MAINTENANCE MANUAL

▲WARNING:

BEFORE OPERATING THIS TOOL ALL OPERATORS SHOULD STUDY THIS MANUAL TO UNDERSTAND AND FOLLOW THE SAFETY WARNINGS AND INSTRUCTIONS. KEEP THESE INSTRUCTIONS WITH THE TOOL FOR FUTURE REFERENCE. IF YOU HAVE ANY QUESTIONS, CONTACT YOUR STANLEY-BOSTITCH REPRESENTATIVE OR DISTRIBUTOR.

▲WARNING:

DO NOT OPERATE THIS STITCHER UNTIL ALL GUARDS ARE IN PLACE.
NEVER OPERATE MACHINE WITH WIRE FEEDING AND NO STOCK ABOVE CLINCHERS. SERIOUS DAMAGE MAY RESULT IF THIS PRACTICE IS FOLLOWED.
ALWAYS TURN POWER OFF BEFORE ANY DISASSEMBLY WORK OR WHEN MAKING ADJUSTMENTS.

INTRODUCTION

The BOSTITCH model No. 2 Stitcher is a light duty stitcher designed to staple both flat and saddle work ranging in thickness from 2 sheets to 1/4" (6.35 mm).

The recommended wire sizes to be used on the No. 2 Stitcher are as follows: Round Wire — 30 to 24; Flat Wire — 20 x 24, 20 x 25, and 21 x 25.

The Stitcher is easily adjustable for changing from saddle work to flat work by means of the tilting work table. 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 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 Stitcher is footswitch operated and is belt driven by a 1/3 HP motor, making possible operating speeds up to 215 stitches per minute. The motor is mounted on an adjustable bracket which can be raised or lowered for adjusting the driving belt tension. The machine driving mechanism is thoroughly shielded thus preventing the possibility of personal injury.

INSTALLATION

1. Carefully inspect condition of crate in which it arrives. If it is broken and there is evidence that the machine may be damaged, immediately notify carrier Claim Department as well as the Bostitch office from which the machine was purchased.
2. Uncrate the machine carefully — do not use large crowbars which may damage small parts.
3. Move machine to spot where it will be used. It should be placed where operator will have sufficient light for efficient operation. Level machine by using shims, if necessary, and lagging it to floor if desired.

4. Remove Belt Guard (see Belt Guard Instructions, page 3). See that motor is free to revolve when large pulley or flywheel is turned by hand (see turning machine manually, page 3).
5. Examine nameplate on motor to determine if specifications fit your requirements. If these do not conform to your needs, notify Bostitch office immediately.
6. When satisfied that motor specifications are correct and before attempting to operate machine under power, it should be turned over a few times by hand (see turning machine manually, page 3) with clutch engaged.

SETTING UP MACHINE

Since each machine is shipped with some parts disassembled, it is necessary that these parts be reassembled onto the machine.

Attach table 2257A, long end to right. Enter pivot pin 2258 through lugs in table and top hole in frame. Grooved end of 2258 must be at right.

Tighten binder screw 38, end of which should enter groove in 2258. Place lock pin 2260 in lower hole. Table can then be locked in either flat or saddle position. Place washer 2245 over threaded end of 7155 and screw same into head of machine. Place small washer 174 over stud. Attach 2133A.

Oil machine thoroughly as described in head instructions and as follows. Put drop of oil on clinchers 9083. Oil roll 48. Oil two holes in top of frame which reach main shaft, one under part marked 5160 on diagram and the other directly behind head of machine on top of frame. Also oil hole in top of 2215. This part is the link which drives the head mechanism and is inside the bonnet of machine. This can be reached through hole in left side of head. In some instances no mention is made in parts chart of certain obvious places to oil. These can be determined by means of oil cups, oil tubes, etc.

OPERATION

(a) Place a spool of wire of the proper size on spool holder located near stitching mechanism or head. Thread machine as described in instructions.

(b) Referring to head operating adjustment instructions, follow procedure for remainder of operations required, such as wire straightening, adjustment for length of wire. Gauge for thickness of work by loosening handle 2209 and swinging same to obtain desired thickness, then tighten 2209. It is not necessary to measure thickness of work as with a little practice the operator can determine position of 2209 with relation to the thickness of work to be stitched. However, if machine is set for thin work, and thicker work is stitched, no harm will be done. The machine will simply feed less wire. This will be noted and proper thickness gauged. For fine adjustments, see head instructions "How to Adjust Length of Both Legs of Staple." However, most adjustments for longer wire can be made by simply

setting handle 2209, at rear of stitcher, for thicker work.

(c) Machine is now ready to stitch, and with directions followed as outlined above, satisfactory results should be obtained. Make several rows of stitches in stock; examine crown and legs for proper appearance. If not satisfactory, adjust machine in accordance with directions given below. See section "Appearance of Stitches" and "Trouble Shooting Chart" in head instructions.

WARNING: NEVER OPERATE MACHINE WITH WIRE FEEDING AND NO STOCK ABOVE CLINCHERS. SERIOUS DAMAGE MAY RESULT IF THIS PRACTICE IS FOLLOWED.

APPEARANCE OF STITCHES

If stitching is defective, compare stitch produced with illustrations in head instruction manual. To eliminate defect, follow instructions given with illustration that agrees with the defect.

If it is necessary to correspond about any defective stitches or other difficulties with the machine, be sure to refer by letter to the illustration in head instructions book, which shows the type of stitch defect and, if possible, send a sample of the work actually being done on the machine.



If stitch is rolled (in thin work), clincher is out of line with wire grooves. Remedy: — Realign same. This is normally a factory adjustment and should never be disturbed unless you are convinced that it must be done to rectify trouble as itemized.

This adjustment can be made by means of adjusting screw "B" (See Figure 1) located in frame near bottom of head. Loosening bonnet binder stud nut "A" and turning screw "B", head can be moved forward or back as desired. Be sure to lock nut "A" tightly after re-adjustment is made.

*THE ESSENTIAL POINTS OF STITCHING

To obtain satisfactory stitches, it is necessary that the following be observed:

(a) The legs of the staple must be of the same length.

(b) Wire must enter cutters as straight as possible.

(c) The cutters must be sharp and properly set so that there are no burrs on wire and wire is cut with a square end.

(d) The clinchers must be adjusted to the proper height, must work freely and be centrally located forward and back. They must be in good condition with no pitted or badly worn grooves. Head must be adjusted for proper compression of work to be stitched.

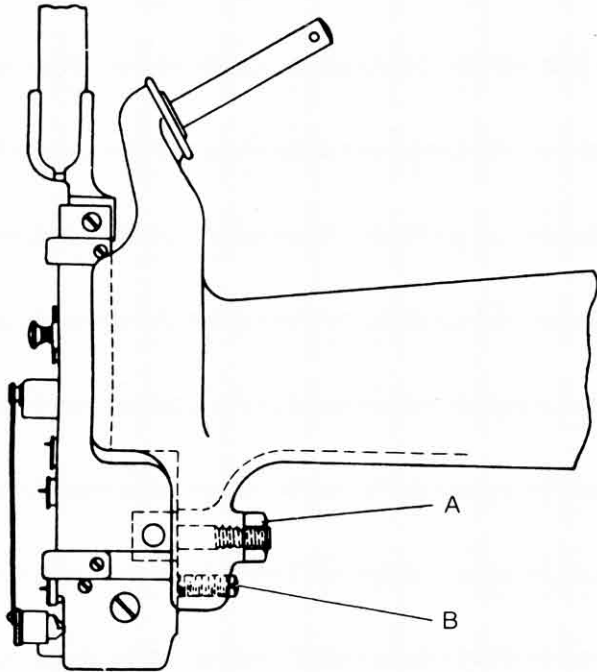


FIGURE 1

(e) The machine must be kept clean and properly oiled.

(f) The wire must be of the correct size for stock to be stitched and must be used only in the proper bender bar. Wire fitting the bender bar grooves too loosely will cause buckling, and too large a wire will also cause buckling in addition to excess wear on the bender bars. Check operating instructions for the proper size wire.

(g) The wire spool must be free to turn and the wire must not be allowed to become crossed. Short staples and even failure to produce staples may result from crossed or tangled wires.

(h) The wire feed grips must *not* be clogged or the points badly worn. Short leg staples on one side can be caused by these conditions.

**The necessary adjustments, replacements, etc., required to meet conditions as listed above are described in detail in the head and stitcher instructions.*

MAINTENANCE

(a) Machine should be lubricated regularly as described under heading of "Installation" in this pamphlet and under heading of "Maintenance" in head instructions.

(b) Clinchers 9083 can be removed by loosening nuts 2091 enough to let clincher slide 2095B be pushed down past lip on clincher lever. Clinchers can then be swung to vertical position and removed.

Clinchers are two sided so that when one side is worn they can be reversed. In replacing clinchers push down as far as they will go in clincher plate 2089A so that lip on inside of 2095B will enter the center of clincher. 2095B controls the clinchers when clinching and returning. To secure good stitching, clinchers should be kept free from dirt and particles of wire.

TURNING MACHINE MANUALLY

⚠ WARNING: Always turn off the power supply before making adjustments or servicing these stitchers.

To turn the machine manually, it is necessary to remove the belt guard (see *Belt Guard Removal, this page*). Locate the actuator assembly on the wrap spring clutch and push the actuator to pivot it away from the control collar cam, releasing the brake. The machine will now rotate one revolution when the drive pulley is turned manually in the direction of the arrow on the pulley.

BELT GUARD REMOVAL and ASSEMBLY

To remove the plastic belt guard, press in one side tab while prying out locking face. This will release the first tab. Next, pull down slightly on top of guard to release bottom tab. Guard will now be free to lift off remaining tabs on mounting plate.

To reassemble, interlock the top tab, and one side tab. Pull down slightly on top of guard to interlock bottom tab, then squeeze mounting plate and guard together to lock remaining tab, completing assembly.

CLUTCH-BRAKE UNIT MAINTENANCE

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 strait-forward mechanical linkage. When the actuator does not trip the following checks should be made:

Problem	Cause and remedy
1. No power to the coil.	1. If no power to the coil, check all wiring and switching in the system that actuates the clutch.
2. Lack of continuity of the coil windings.	2. If no continuity, replace the coil.
3. Mechanical binding of the plunger.	3. Plunger binding may be caused by the shifting of the coil, or mushrooming of plunger end due to striking the back stop. In the latter case the plunger may be turned or filed to its true diameter.
4. Insufficient clearance of the actuator over the stop collar.	4. No clearance over the stop collar detent would be caused by lack of continuity of the linkage. Repair or adjust as needed.
5. Actuator loaded by the stop collar, in which case the collar pushes so hard on the actuator that it cannot be pulled by the coil.	5. Actuator loading can be caused by the braking force exceeding the limits of the brake or the differential setting of the unit being too close, i.e., CLUTCH ON BRAKE ON. (See instructions of setting on Assembly and Disassembly Instructions.)

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 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 by dropping or hammering the unit on the shaft at assembly.

See Assembly and Disassembly instructions for readjusting.

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

Problem	Cause and remedy
1. Clutch Brake does not drive but input turns.	A. Drive spring may be broken at crossover point from an overload caused by a jam. Replace spring and check hubs for damage. B. Collar may not snap forward because of foreign matter restricting movement. Clean unit. C. Actuator does not pull in. (See "Actuator.")
2. Clutch-Brake jams and stalls input motor.	A. Spring tang broken off drive spring, not allowing clutch to disengage while brake is engaged. Replace drive spring. B. Clutch output bound up. Check clearance between output hub and brake hub. C. Completely out of adjustment caused by losing an internal spring tang. Replace spring.
3. Output does not repeat stopping point.	A. Not enough inertia to actuate brake. B. Tang broken off brake spring. Replace spring. C. If unit has an adjustable collar, locking screw may be loose allowing adjusting screw to rotate.

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 reassembly.

WARNING: ALWAYS DISCONNECT STITCHER MACHINE POWER CORD FROM POWER OUTLET BEFORE ANY DISASSEMBLY WORK.

To disassemble the clutch-brake unit it will first be necessary to remove the drive pulley from the stitcher by removing the V-belt, pulley washer (7679) and disconnecting anchor strap (7680) from clutch plate.

Disconnect wires from solenoid, swing Anchor Bracket down out of way and carefully slide pulley and clutch off as a unit. Remove drive pulley from input hub then:

- (a) Release Actuator Lever so that clutch is engaged and brake released.
- (b) Remove Retaining Ring and Shim Washer, if any, from the input Hub end.
- (c) Remove Input Hub, by rotating opposite to the drive direction.
- (d) Remove Retaining Ring and Shim Washer, if any, from the Mounting Plate end.
- (e) Remove Output Shaft, Springs, and control Collar assembly, by rotating Output shaft in the drive direction. (DO NOT DISASSEMBLE BRAKE HUB FROM MOUNTING PLATE.)
- (f) Remove Control Collar from the Output Shaft and Spring assembly, by extracting towards the Brake Spring end.

ASSEMBLY

- (a) Replace Clutch, Brake, and Anti Back-up Springs as required. (Assemble springs concentric and square to the Output Shaft.)
- (b) Assemble Control Collar over the Output Shaft and Spring assembly, by inserting from the Brake Spring end. (It will be necessary to extend Brake Spring using long nose pliers.)
- (c) Place the Brake Spring tang in any one of the nine (9) Control Collar slots at *random*.
- (d) Assemble Output Shaft, Springs, and Control Collar assembly to the Mounting Plate assembly by rotating Output Shaft in the drive direction.
- (e) Assemble Retaining Ring to Output Shaft at the Mounting Plate end (smooth surface facing Brake Hub.) Check end play between hub and Retaining Ring with feeler gauge. There should be .004 to .010 end play. Use shim washers to adjust.
- (f) Rotate Output Shaft in the drive direction, until it reaches a full brake position.
- (g) With the *Clutch* Spring Tang *not* in slot, insert the Input Hub by rotating opposite to the drive direction.
- (h) 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.

CLUTCH AND BRAKE UNIT

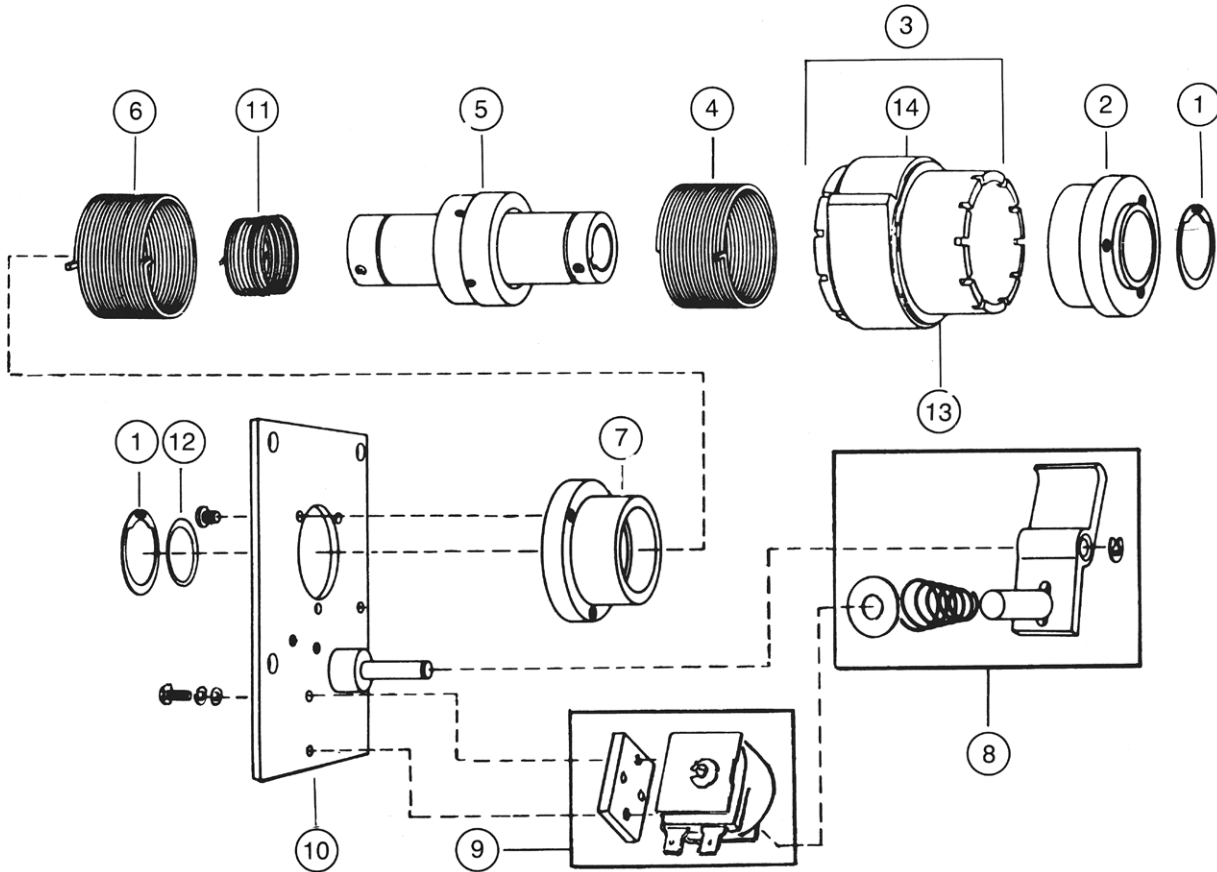


FIGURE 2

ITEM	DESCRIPTION	PART NO.
1	Retaining Ring	850886
2	Input Hub	851321
3	Control Collar Assembly — CW	850888
4	Spring — Drive — CW	850889
5	Output Assembly	850891
6	Spring — Brake — CW	850889
7	Brake Hub	850892
8	Actuator Assembly (6 pieces)	850809
9	Coil Assembly (For 115V Service — 60 HZ) Coil Assembly (For 230V Service — 50 HZ)	850893 850894
10	Plate Assembly	850890
11	Anti Back-up Spring	850962
12	Shim Washer	851126
13	Retaining Ring	851243
14	Control Collar Cam	851766

NOTE: At this point it may be necessary to reselect one (1) of the nine (9) Control Collar slots for the Brake

Spring Tang (release Actuator Lever, remove Clutch Spring Tang from slot, then move Control Collar axially towards the Input Hub end and rotate it opposite to the drive direction to pick up next slot).

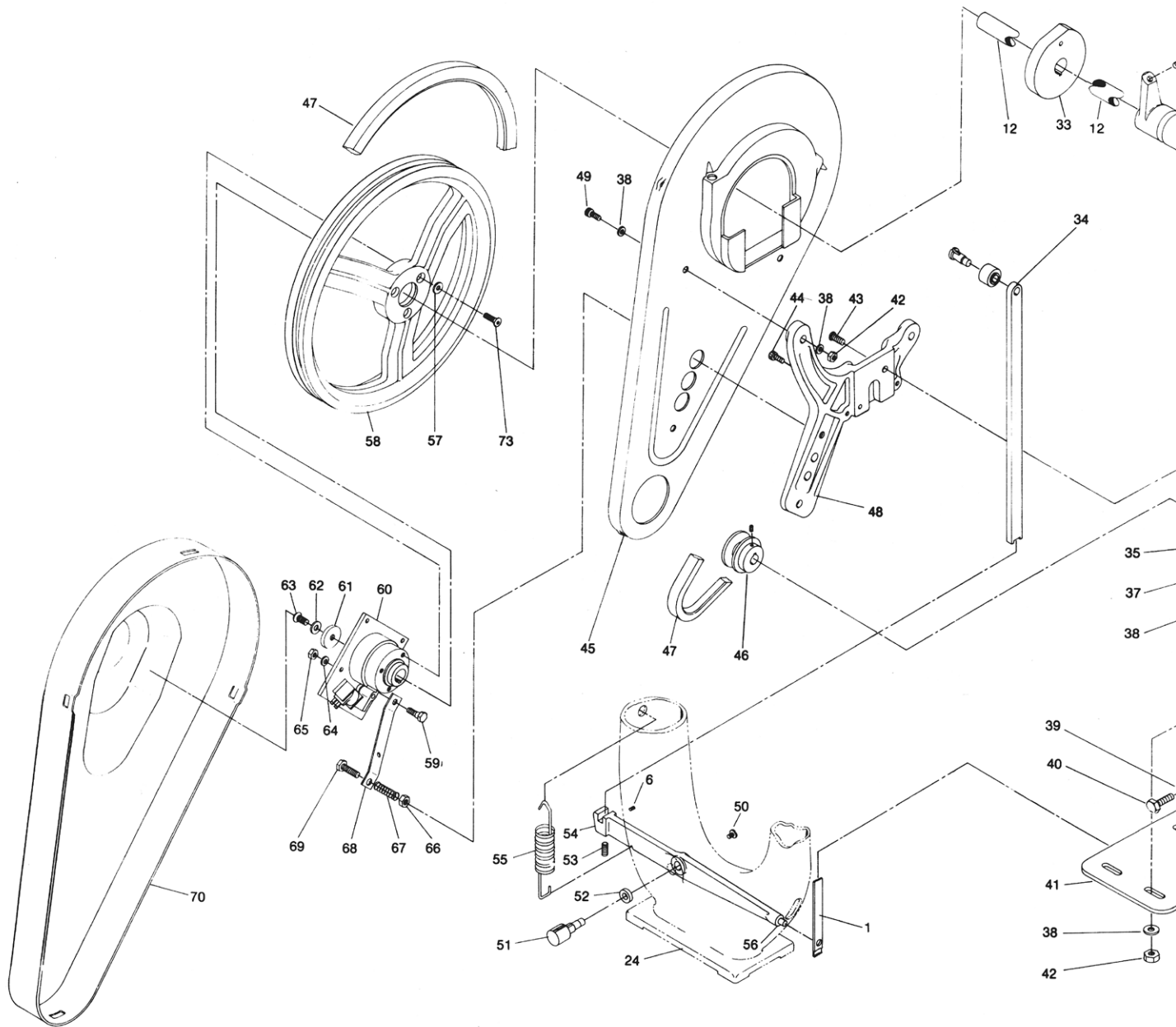
- (i) Repeat Step (h) until the .38" to .50" specification is achieved.
- (j) Assemble Retaining Ring to Output Shaft at the Input Hub end (smooth surface facing Input Hub).
- (k) Reassemble unit to machine.

Check end play between Input Hub and Retaining Ring with feeler gauge. There should be .002 to .003 end play on Input Hub.

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

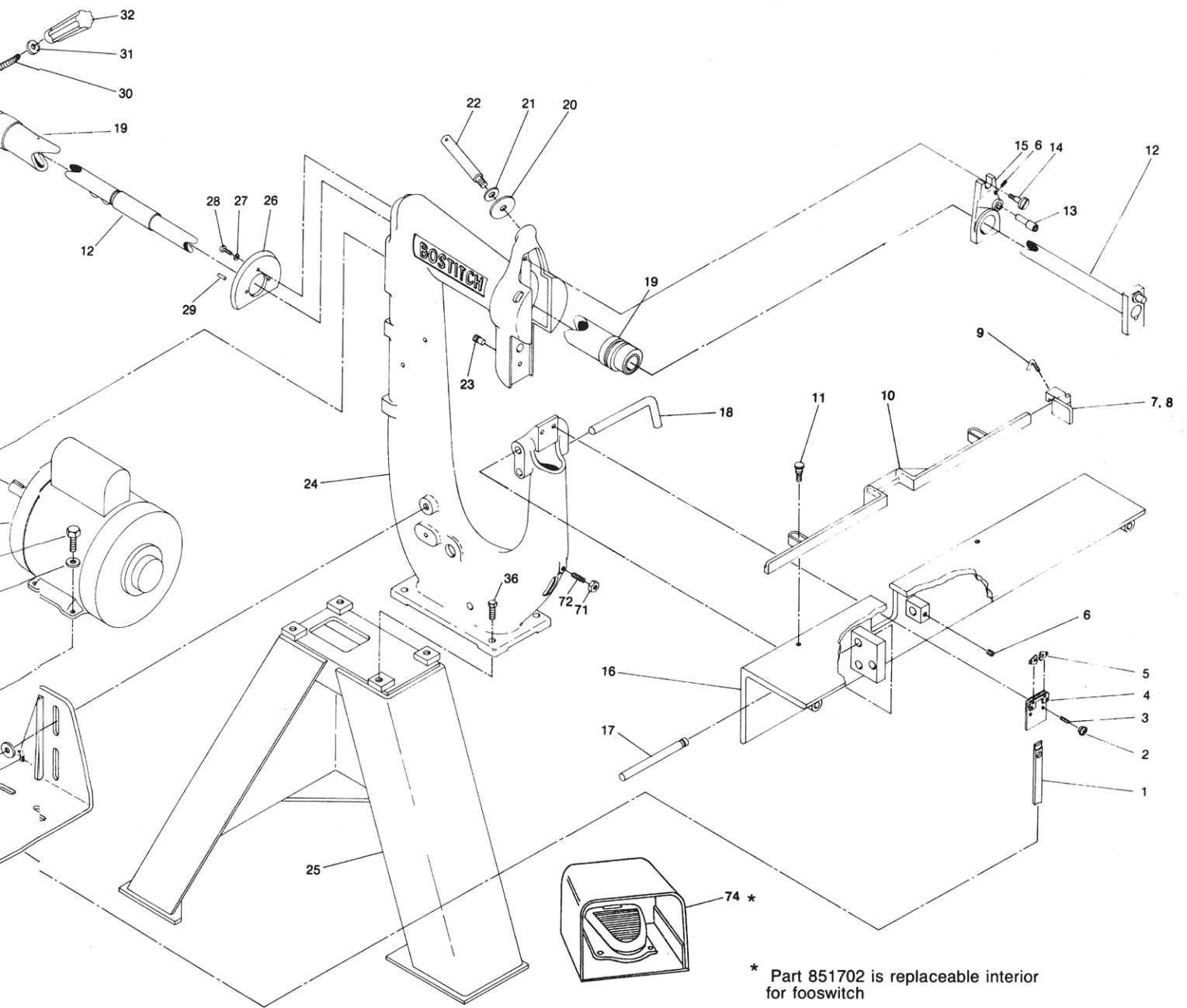
LUBRICATION:

The clutch-brake unit is designed with the bearing parts made from sintered metal that has been impregnated with oil and normally do not need to be re-lubricated. In cases where there is severe duty, or



PARTS FOR MODEL 2 STANLEY-BOSTITCH WIRE STITCHER

ITEM #	PART #	DESCRIPTION	ITEM #	PART #	DESCRIPTION
1	2095B	Clincher Slide	39	PW38	3/8" Plain Washer
2	2091	Clincher Plate Binder Stud Nut	40	UA6116.1	3/8"-16 x 1" Hex Hd. Cap Screw
3	2090	Clincher Plate Binder Stud	41	16010D	Motor Bracket
4	2089A-25W	Clincher Plate	42	HN51618	5/16"-18 Hex Nut
5	9083-25W	Clincher Point	43	UA3808.1	#10-32 x 1/2" Hex. Socket Hd. Cap Screw
6	38	Binder	44	UA7816.1	7/16"-14 x 1" Hex. Socket Hd. Cap Screw
7	2263	Work Stop — Right	45	2171	Belt Guard Mounting Plate
8	424	Work Stop — Left (not illustrated)	46	850736	Motor Pulley
9	425	Work Stop Binder	47	850730	V-Belt
10	2261	Work Guide	48	7682	Belt Guard Bracket
11	63	Work Guide Binder Screw	49	UA5116.1	5/16"-18 x 1" Hex. Hd. Cap Screw
12	2212A	Driving Shaft	50	0053	Clincher Oper. Lever Pivot Screw
13	2241	Face Plate Adj. Link Eccentric	51	2237	Clincher Oper. Lever Pivot
14	2292	Face Plate Adj. Link Stud	52	2238	Clincher Oper. Lever Pivot Collar
15	2240	Face Plate Adj. Link	53	UA5820.2	5/16"-18 x 1-1/4" Hex. Socket Set Screw
16	2257A	Work Table	54	2235	Clincher Oper. Lever
17	2258	Work Table Pivot Pin	55	14	Clincher Oper. Lever Spring
18	2260	Work Table Lock Pin	56	2293	Clincher Oper. Lever Pin
19	2206	Eccentric Quill	57	SW14.1	1/4" Countersink Lock Washer
20	2245	Spool Stud Washer — Large	58	7678	Driving Pulley
21	174	Spool Stud Washer — Small	59	7681	Clutch Anchor Screw — Top
22	7155	Spool Stud	60	850671	Wrap Spring Clutch Ass'y (for 115V service)
23	2287	Bonnet Aligning Screw	60 (2)	850672	Wrap Spring Clutch Ass'y (for 230V service)
24	2201	Frame	61	7679	Driving Pulley Washer
25	2286B	Base	62	SW516.3	5/16" C'Sunk Ext. Tooth Lock Washer
26	2210	Eccentric Quill Sector	63	UA5820.8	5/16"-18 x 1-1/4" Hex. Soc. Flat Hd. Cap Screw
27	LW10.4	Eccentric Quill Sector Screw Lock Washer	64	SW14	1/4" Internal Tooth Lock Washer
28	9080	Eccentric Quill Sector Screw	65	HN1420.5	1/4"-20 Hex Nut
29	9078	Eccentric Quill Sector Pin	66	HN3816	3/8"-16 Hex Nut
30	2207	Eccentric Quill Binder Stud	67	141H3	Clutch Anchor Bolt Spring
31	2208	Eccentric Quill Binder Washer	68	7680	Clutch Anchor
32	2209	Eccentric Quill Binder Nut	69	UA6140.1	3/8"-16 x 2-1/2" Hex. Hd. Cap Screw
33	2172	Clincher Cam	70	7676	Belt Guard
34	2232A	Clincher Cam Slide Ass'y	71	HN1420	1/4"-20 Hex Nut
35	850269B	Motor (1/3 HP, 60 Hz, 1725 RPM, 5, 8A)	72	UA4824.3	1/4"-20 x 1-1/2" Hex. Socket Set Screw
36	UA5120.2	5/16"-18 x 1-1/4" Hex. Hd. Cap Screw	73	UA4812.7	1/4"-20 x 3/4" Hex. Socket Flat Hd. Screw
37	UA5112.1	5/8"-18 x 3/4" Hex. Hd. Cap Screw	* 74	851701	Footswitch
38	PW516	5/16" Plain Washer			



* Part 851702 is replaceable interior for footswitch

THE FOLLOWING ITEMS ARE PART OF #2AW STITCHER BUT FOR CLARITY HAVE NOT BEEN ILLUSTRATED.

UA4208.1	Circuit Breaker Screw (1/4"-20 x 1/2" Slotted Fillister Hd. Mach. Screw)	86035	#14 Wire Green (Starter — Footswitch Conn.) (Starter Switch — Motor)
UA3306.2	Ground Screw (Circuit Breaker) (#10-32 x 3/8" Rd. Hd. Slotted Machine Screw)	85777	Anti-Short Bushing (Footswitch Cord) (Conduit Motor Starter To Brkt) (Power Cord)
HN1032	Ground Screw Nut (Circuit Breaker) (#10-32 Machine Screw Nut)	85797	Insulated Wire Conn.
UA3308.3	Screw (Motor Ground) (#10-32 x 1/2" Rd. Hd. Slotted Machine Screw)	86198	90° Angle Conn. (Bracket) (Belt Guard Bracket) (Motor Starter Top)
HN1032	Nut (Motor Ground) (#10-32 Machine Screw Nut)	87228	Motor Starter Box (was 87000B)
UA3806.21	Plastite Screw (Belt Guard) (#10-14 x 3/8" Pan Hd. Slotted Screw)	87229	Motor Starter Cover (was 87001B)
0-99-995-046	5 lb. Coil, 25GA Rd. Bookbinder's Wire	87230	Motor Starter (was 87002)
2001DHD251/2	2001D Head	87583	Wire Terminal (BL + WH Wires at Footswitch)
85095	Wire Terminal (Green Wire At Footswitch)	850602	Extra Flex Conduit
85098	Duplex Conn. (Motor Starter — Bot.)	850603	Wire Terminal (WH Wire at Sol. Coil)
85125	Cable Clamp	HN1032	#10-32 Hex Nut (Cable Clamp Cl. Anchor)
85126	Cable Connector (Motor)	SW10	#10 Internal Washer (Motor Ground Screw) (Motor Starter Ground Screw) (Cable Clutch Screw at Clutch Screw)
85416	Flexible Conduit (Motor Starter To Motor)	UA3306.1	#10-32 x 3/8" Rd. Hd. Slotted Machine Screw (Cable Clamps)
85199	Wire Terminals (Starter Switch To Motor)	86243	Power Cord for 115V
85417	#14 Wire Black (Starter-Footswitch Conn.) (Starter Switch — Motor)	87234	Heater (5.84 to 6.39A) (was 850963 and 5.84 to 6.39A)
85419	#14 Wire White (Starter — Solenoid Conn.) (Starter Switch — Motor)	2581S	Name Plate (CSA)

unit may be re-oiled or flushed out with minimal or no disassembly by using a light bearing oil as used in manufacture (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 from the oil, it may be heated while cleaning the components, but bring the parts back to ambient temperature submerged in cool oil.

CONTROL COLLAR ADJUSTMENT

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 power off, trip clutch by hand (see turning machine manually, page 3) and rotate drive pulley until driver is in desired stopping position then proceed as follows:

(a) Work retaining ring "A" out of groove and slide forward on sleeve "C" (See illustration)

(b) Slide cam "B" off splines, rotate to desired relationship of stop to shaft keyway, and slide back on splines. The actuator pawl will have to be held clear during this operation.

(c) Slide retaining ring back into groove.

NOTE: Make sure brake is locked up before proceeding to insure getting proper stop point.

INSTRUCTIONS FOR COIL REPLACEMENT

1. Place the spring onto the plunger with the narrow end towards the actuator then slide the nylon washer onto the plunger. Slide the solenoid and spacer plate onto the actuator and spacer plate with the cap screws and washers. DO NOT tighten more than finger tight.
2. Energize the coil and adjust the gap between the actuator and the top of the collar stop .015" to .030" by sliding the solenoid assembly. (Note: push the collar towards the actuator to allow for collar movement). Tighten the cap screws.

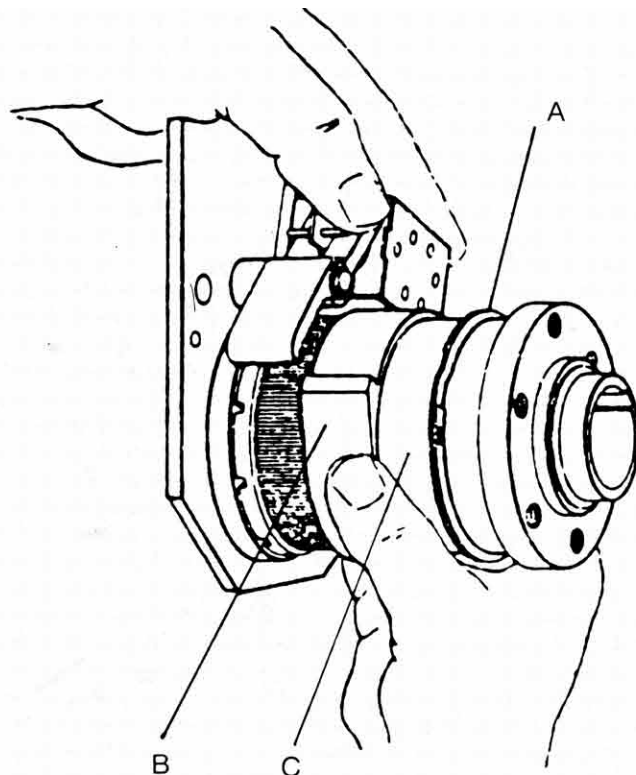


FIGURE 3

2391 HEAD GUARD KIT, OR REPLACEMENT OF HEAD GUARD 2390

1. Remove lower left Face Plate Retaining Clip Screw (UA2305.2) and replace with Upper Stud (2388) as shown in illustration, tightening firmly with wrench.
2. Remove lefthand Swivel Holder Screw (9044B) and replace with Lower Stud (2389) as shown in illustration, tightening firmly with wrench.
3. Engage lower slot in Plastic Guard on neck of Lower Stud and upper slot over $\frac{1}{4}$ -20 thread of Upper Stud. Assemble Washer (PW10) and Wing Nut (WN1420).
4. Vertical adjustment of Guard may be obtained by loosening Wing Nut and repositioning Guard to suit.

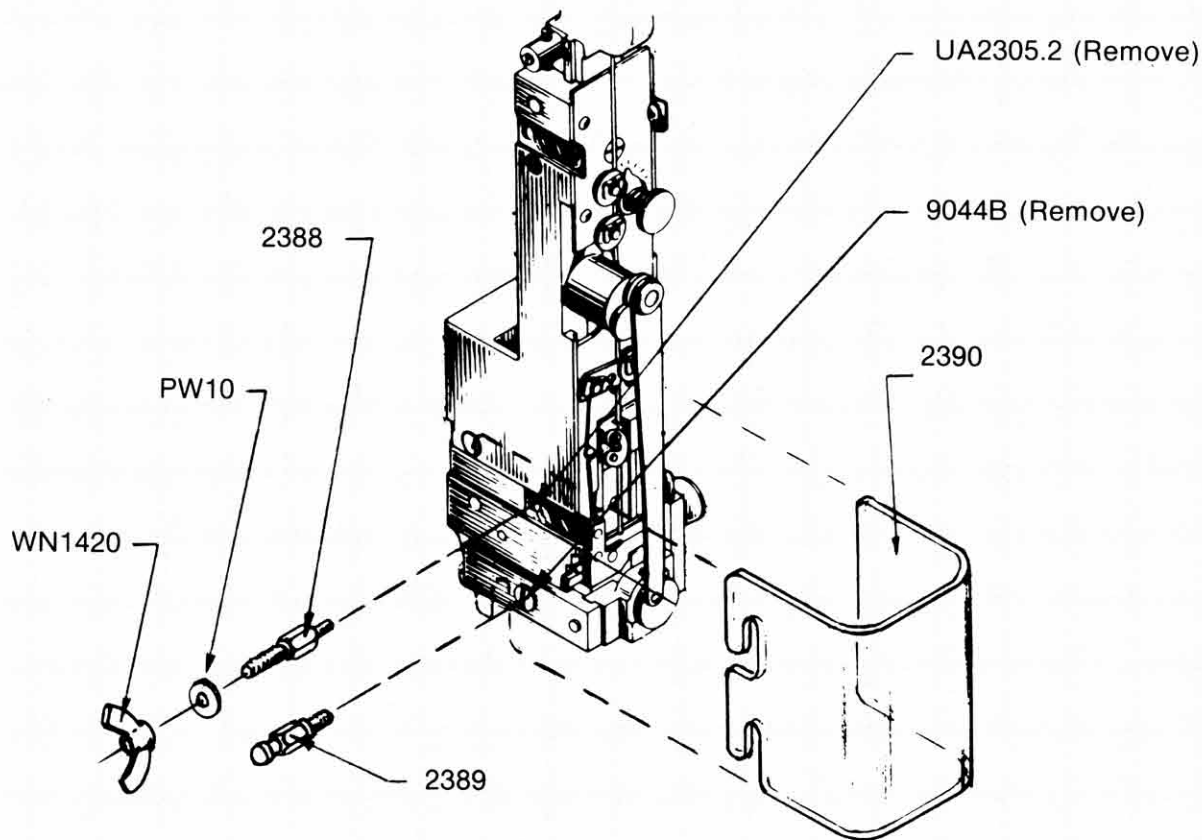


FIGURE 5

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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