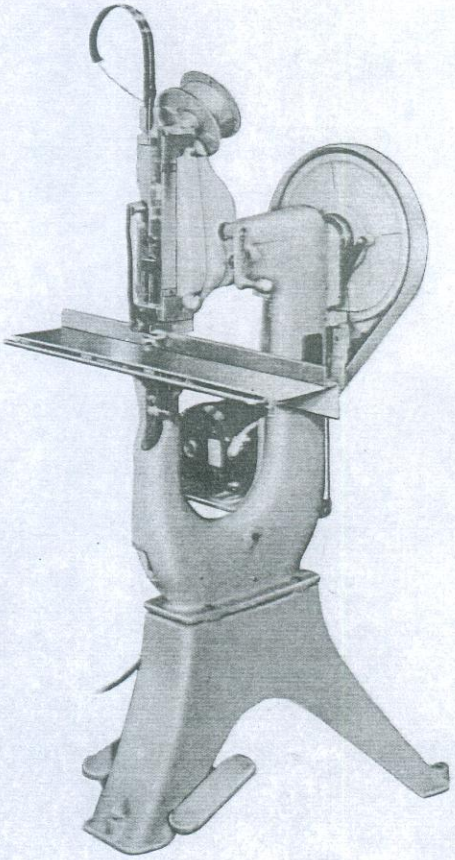
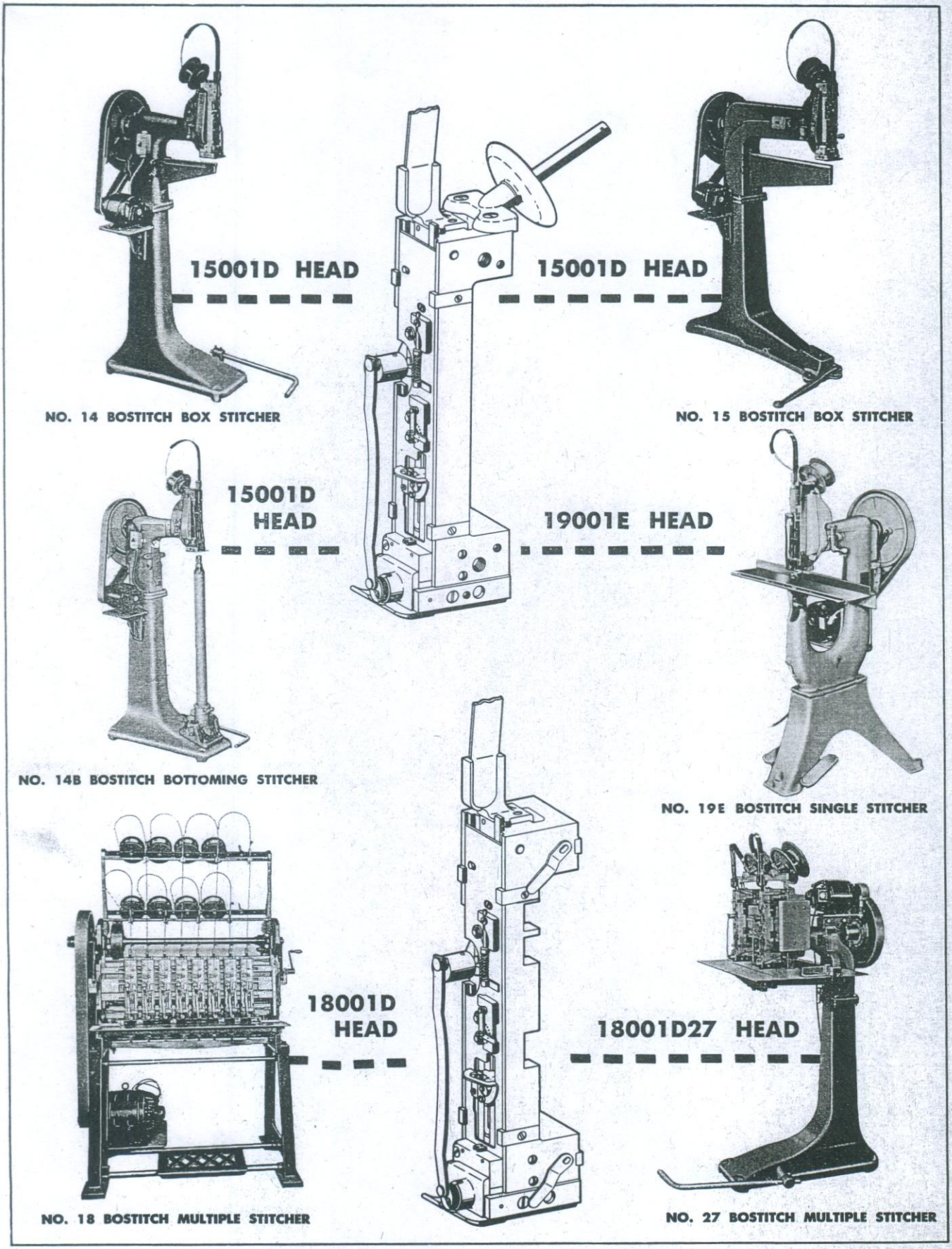
BOSTITCH®

MODEL 19E
WIRE STITCHER



OPERATION and MAINTENANCE MANUAL



Bostitch Stitchers Using No. 15001D, 18001D, 18001D27, or 19001E Heads

INSTALLATION, OPERATION AND MAINTENANCE
of
No. 19E BOSTITCH STITCHER WITH No. 19001E HEAD

CAPACITY: 9/16"

SIZE OF WIRE: No. 19x21½, 20x24 and 21x25 Flat
No. 20, 23 and 25 thru 30 Round

CROWN OR STAPLE WIDTH: ⅜", ½" (Standard), ⅝" and ¾"

SPEED: Up to 300 stitches per minute

Note: This book does not include head instructions. It should be used in conjunction with
"Bostitch Model 19001E Wire Stitcher Head Operation and Maintenance Manual"

1. INTRODUCTION

To obtain satisfactory results from a wire stitcher, as with any other machine, it is necessary that it be properly installed and adjusted, regularly lubricated and carefully maintained.

In case of any serious trouble, however, you should notify the nearest sales office, sending samples of the defective work and describing the trouble in detail, so as to obtain the benefit of their experience in arriving at the proper solution. Be sure to report the serial number and model of the machine when corresponding in regard to it, so that it may be quickly identified.

2. INSTALLATION

To prevent damaging the machine during its installation, we recommend that the following procedure be closely followed:

a. After uncrating machine, examine carefully for any breakage in transit. If such is found, do not attempt to run machine but report at once to the selling agent. If service man is present, let him examine machine carefully and then report to manufacturer.

b. Examine name plate on motor and see that its specifications are the same as those of the power to be used. If not, do not attempt to use.

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

Attach spool stud and disc, wire guide spring, adjusting screw crank arm, motor bracket, motor, V-belts, belt shield, belt guard and table.

The mounting of motor onto the base is a simple matter which needs no explanation. When assembling belts, make sure that they are only tight enough to run machine without slippage. Belt tension may be adjusted by moving motor bracket up or down.

d. Place machine on level floor, using shims under base to prevent any movement or rocking.

e. Lubricate machine thoroughly as described in head instructions and as follows: Apply generous supply of oil (S.A.E. 10) to pulley washer as this lubricates clutch. Oil drive shaft through oil cups (2) at top of frame and oil universal joints in drive shaft through large holes (2) in left side of frame. Oil cam roll at upper end of clincher cam slide at rear of machine.

f. Trip the clutch by means of the movable foot pedal at front of machine and turn machine over by hand a few times to see that everything is clear.

Then take foot off clutch trip pedal and rotate clutch pulley rapidly, so that clutch will be entirely disengaged. Do not turn electric switch on until pulley rotates freely.

g. Connect motor cord to power outlet and start motor. See that large pulley or flywheel turns in direction of arrow cast on pulley, or clockwise as viewed from the front of the machine. Should it rotate counterclockwise, motor wiring should be reconnected by electrician in order to reverse direction of rotation.

h. If rotation is correct, push down on foot pedal and start machine operating. Remove foot from pedal and machine will stop. A very little practice will enable operator to know exactly how to stop and start machine exactly when desired.

3. OPERATION

a. Place a spool of wire of the proper size on the spool holder located near the stitching mechanism or head.

When loading with wire wound on paper cores: Remove detachable flange from spool and insert coil of wire, replacing flange and turning coil till binding wires are aligned with slots in flanges. Tighten nut till coil is snugly held. Cut binding wires, except the one holding the end of the coil. (They may be pulled out through the slots.) Then grasp, end of coil and cut and remove the binding wire which holds it. Thread the machine as described in head instructions.

b. Referring to head operating adjustments instructions, follow procedure for remainder of operations required, such as wire straightening and adjustment for length of wire.

Gauge for thickness by placing work under gauge at left of head and adjust crank at right of head until work is tightly pinched under gauge. After turning pulley by hand once so as to be sure that machine is properly set for thickness to be stitched, power can be applied.

Clinchers can be adjusted for tight or loose clinch by means of screw at back of clincher operating lever, first releasing the binder screw. A slight turn will make considerable difference in the operation of the clinchers.

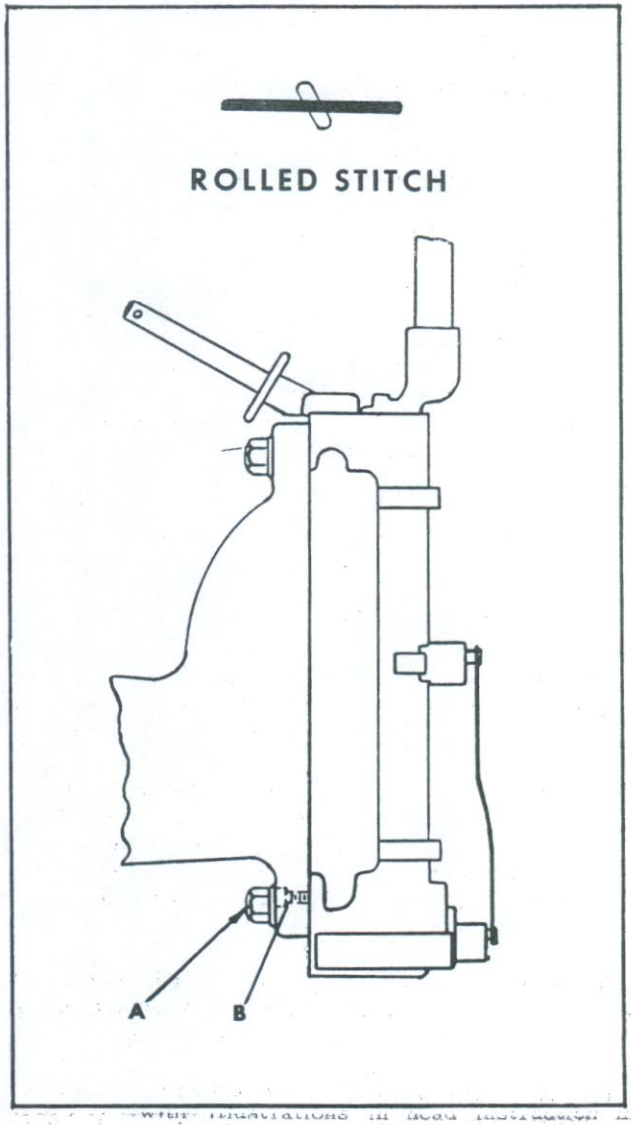
c. Machine is now ready to do stitching and with directions as outlined above satisfactory results should be obtained. Make several rows of stitches in stock to be used, examining crown and legs for proper appearance. If not satisfactory, adjust machine in accordance with directions given below. See section 4 "Appearance of Stitches" and "Trouble Shooting Chart" in head instructions.

d. CAUTION: - Never operate machine with wire feeding and no stock above clinchers. Serious damage may result if this practice is followed.

4. 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 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.

To align clincher with wire grooves: 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 screws "B" located in frame near bottom of head as shown below. Loosening bonnet binder screw "A" and turning screws "B", head can be moved forward or back as desired. Be sure to lock screw "A" tightly after re-adjustment is made.



5. *THE ESSENTIAL POINTS OF STITCHING

In order to continue to obtain satisfactory stitches it is necessary that the following essentials be observed:

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

b. Wire must enter cutters as nearly straight as possible.

c. The cutters or knives must be sharp and properly set so that there are no burrs on end of wire and wire is cut with a square end (not beveled).

d. The clinchers must work freely and be in good condition mechanically, with no pitted or badly worn grooves. Head must be adjusted for proper compression of work to be stitched.

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. Be guided by the 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 entire failure to produce staples may result from crossed or tangled wires.

h. Stitcher must be equipped with proper clincher points for either round or flat wire depending on wire being used.

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

6. MAINTENANCE

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

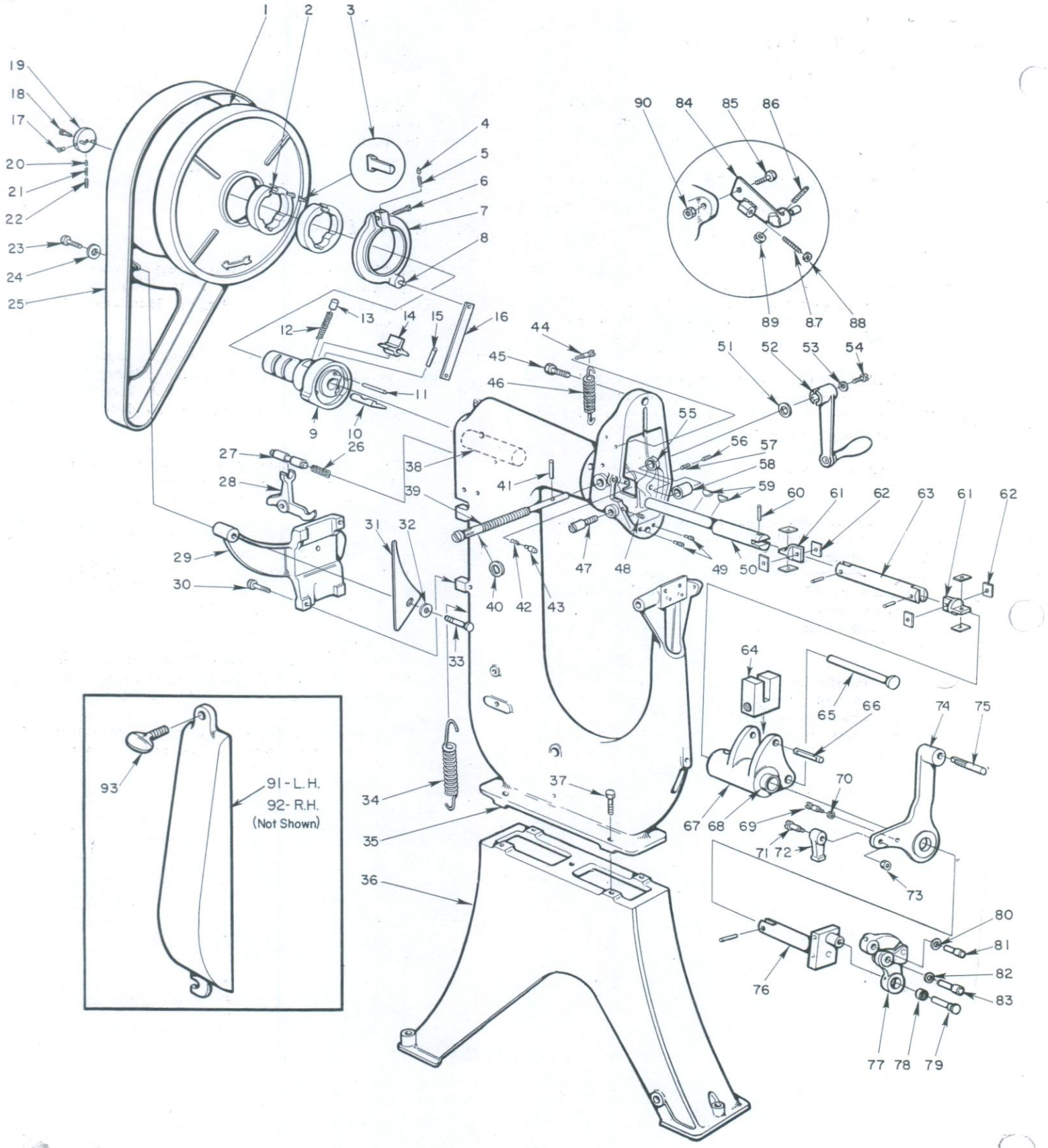
b. The friction clutch is adjusted by means of screw 2340B in brake band 2339A. Screw in if clutch slips. Screw out if clutch knocks. A quarter turn will make considerable difference in action of the clutch.

c. Removal and replacement of clinchers. To remove clinchers, release clincher slide 19184B from slide bar 19186 by removing screw 9044B.

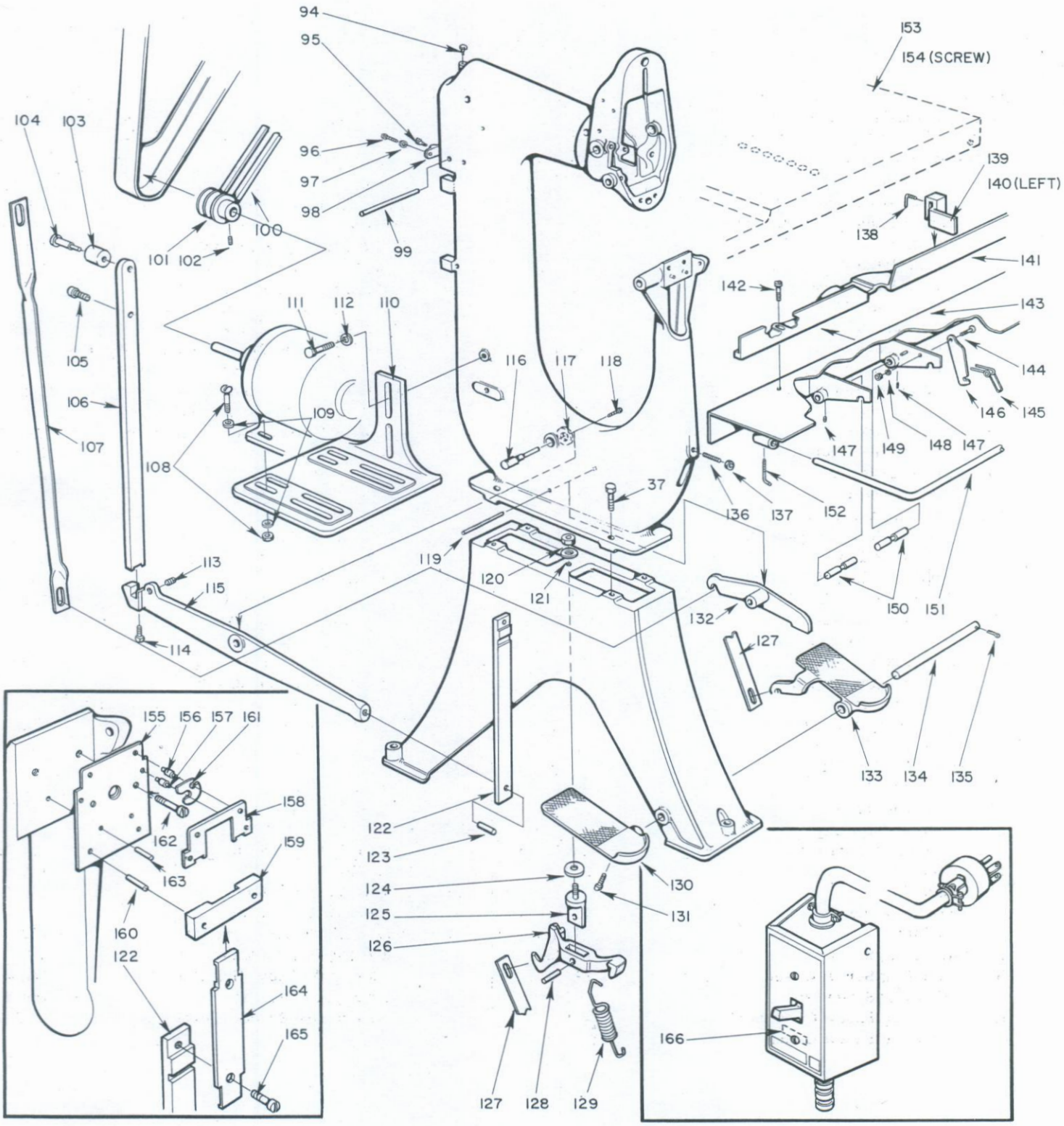
Hold slide when releasing screw, to prevent slide from dropping into base of machine. Lower slide enough to disengage clinchers, which can then be raised to vertical position and removed through upper opening in clincher plate.

To replace clinchers, push down as far as they will go into clincher plate, so that lip on slide will enter notch in clincher. Align hole in slide with that in slide bar and replace screw.

To assure good stitching, clinchers should be kept free from dirt and particles of wire.



STITCHER COMPONENT PARTS - SHEET 1



STITCHER COMPONENT PARTS - SHEET 2

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1	Driving Pulley	2331B
2	Clutch Ring	2332BA
3	Clutch Ring Expanding Pin	2347
4	Brake Band Adjusting Screw Lock	2341
5	Brake Band Adjusting Screw Lock Spring	9051
6	Brake Band Adjusting Screw	2340B
7	Brake Band Assembly	2339A
8	Brake Band Pin	2344
9	Clincher Cam	19244
10	Clutch Pawl	2337
11	Clutch Lever Pivot Pin	2334
12	Clutch Lever Spring	2335
13	Clutch Lever Spring Plunger	2336
14	Clutch Lever	2333
15	Clutch Pawl Plunger	347
16	Brake Band Link	19242
17	Driving Pulley Washer Oiler	85221
18	Driving Pulley Washer Screw	2349
19	Driving Pulley Washer Assembly	2217DA
20	Driving Pulley Washer Screw Lock	2350
21	Driving Pulley Washer Screw Lock Spring	030
22	Driving Pulley Washer Set Screw	UA5804.1
23	Belt Guard Screw	UA7116.2
24	Belt Guard Washer	PW716
25	Belt Guard	2359
26	Stop Plunger Spring	19238
27	Stop Plunger	19237
28	Stop Plunger Lever	2226C
29	Belt Guard Bracket	2358
30	Belt Guard Bracket Screw	UA7120.2
31	Belt Shield	2356
32	Belt Shield Washer	PW716.2
33	Belt Shield Screw	UA7116.2
34	Clincher Operating Lever Spring	E183B
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36	Base	19204
37	Frame Screw	7018
38	Bushing	148H
39	Adjusting Screw	19273
40	Adjusting Screw Washer - Large	19275
41	Adjusting Screw Pin	19277
42	Adjusting Screw Catch Spring	461
43	Adjusting Screw Catch	19274
44	Adjusting Link Spring Pin	406
45	Bonnet Screw	15002
46	Adjusting Link Spring	14280
47	Thickness Gage Seat	19296
48	Thickness Gage Seat Binder	UA5806.1
49	Bonnet Aligning Screw	2287
50	Clutch Shaft Assembly	19314A
51	Adjusting Screw Washer - Small	19276
52	Adjusting Screw Crank Arm	19278A
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63	Intermediate Shaft	19309
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65	Adjusting Bearing Pivot	14277
66	Adjusting Nut Connecting Pin	14283
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76	Crank Shaft Assembly	19301A
77	Bender Link Assembly	19283A
78	Crank Pin Roll	19306
79	Crank Pin Roll Stud	19307
80	Connecting Pin Washer	2228
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85	Table Support Bracket Screw	UA5116.1

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87	Work Table Adjusting Screw - Flat Position	UA4820.3
88	Work Table Position Adjusting Screw Nut	HN1420.2
89	Work Table Position Adjusting Screw Nut	HN1420.2
90	Table Support Bracket Nut	HN51618.2
91	Bonnet Guard - Left	19006
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93	Bonnet Guard Screw	UA4812.5
94	Oil Cup	85202
95	Brake Band Link Stud	2343
96	Clincher Cam Slide Strap Screw	UA3308.2
97	Clincher Cam Slide Strap Screw Lock Washer	LW10
98	Clincher Cam Slide Strap	2345
99	Stop Plunger Lever Pivot	UB6144
100	V-Belt	2290B
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102	Motor Pulley Set Screw	UA5806.1
103	Clincher Cam Roll	48
104	Clincher Cam Roll Stud	49
105	Clincher Cam Slide Stop Screw	UA6805
106	Clincher Cam Slide	19246A
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108	Motor Bolt and Nut	2301
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112	Motor Bracket Washer	PW38
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114	Clincher Operating Lever Screw	UA5520.1
115	Clincher Operating Lever	19251
116	Clincher Operating Lever Pivot	19254
117	Clincher Operating Lever Pivot Collar	2238
118	Clincher Operating Lever Pivot Screw	0053
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120	Treadle Connection Lever Bracket Nut	5026
121	Treadle Connection Lever Bracket Washer	PW38
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