

DELUXE STITCHER

C O M P A N Y I N C .

Head Serial Number : _____

Date Purchased : _____

Where Installed: _____

(make/model of machine)

26D Stitcher Head

DUPLO EDITION

2601DDPHD251/2

OPERATION AND MAINTENANCE MANUAL

Wire Size: 25 Ga. Round

Crown Size: 1/2" (12.7mm)

Capacity: 2 sheets to 1/4" (6.4 mm)

Before using this Stitcher Head, all operators must study this manual and follow the safety warnings and instructions. Keep these instructions with the 26D Stitcher Head for future reference. If you have any questions, contact your local DeLuxe Stitcher Graphic Arts Representative or Distributor.

WARNING!

26D Stitcher Head

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 this 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.

Table of Contents

Specifications.....	4
Installation	6
Pre-Inspection	6
Inspection	6
Mounting	7
Operation	8
Wire Threading	8
Wire Straightening	9
Adjustments and Settings	10
Maintenance.....	12
Lubrication	12
Cleaning	13
How to Order Spare Parts	14
Replacing Spare Parts.....	14
Troubleshooting.....	19
Formed Staple Chart	19
Appendices	21
Exploded Drawings.....	21
Part Number/Description Cross Reference	31
Registration Card.....	33
Wear/Replacement Parts.....	34
Warranty	35

Specifications

Weight

Shipping Weight 7 lbs (3.2 kg)

Physical Dimensions

Height 10-3/4" (26.3 cm)

Width 2" (5.1 cm)

Stitching Capacity Two Sheets to 1/4" (6.4 mm)

Wire Type 25 gauge round standard

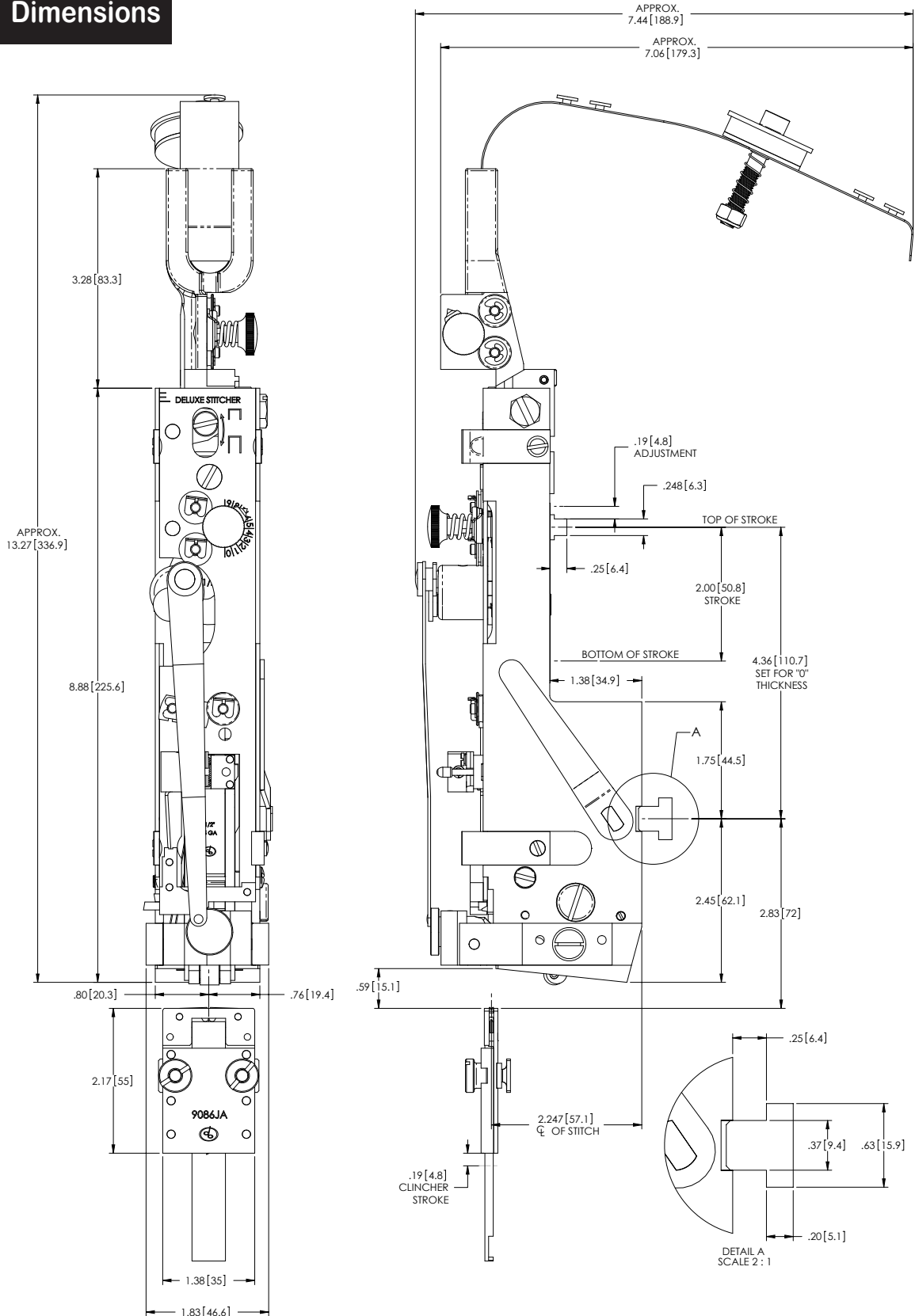
Crown Size 1/2" (12.7mm)

Minimum Head Centers

..... 1-7/8" (47.6mm)

Stitches Per Hour 12,000

Dimensions



Installation

Pre-Inspection

Carefully inspect the condition of the shipping container before unpacking your 26D Stitcher Head. If the container is broken or damaged and there is evidence that the stitcher head may be damaged, immediately notify the carrier who delivered the head and the DeLuxe Stitcher Graphic Arts Representative from whom the 26D Stitcher Head was purchased.

Inspection

As you carefully unpack the head, check to make sure all components were delivered and are in good working order. Refer to **Figure 1** in this manual for reference to the following pieces:

- 26D Manual
- Driver Release Pin
- Wire Guide Spring Assembly
- Bonnet Clamp Block and Bonnet Clamp Handle
- Bonnet Binder Stud, Stud Pin and Stud Nut
- Clincher Plate, Points and Slide
- Driving Shaft Connector Link
- Stitch Samples

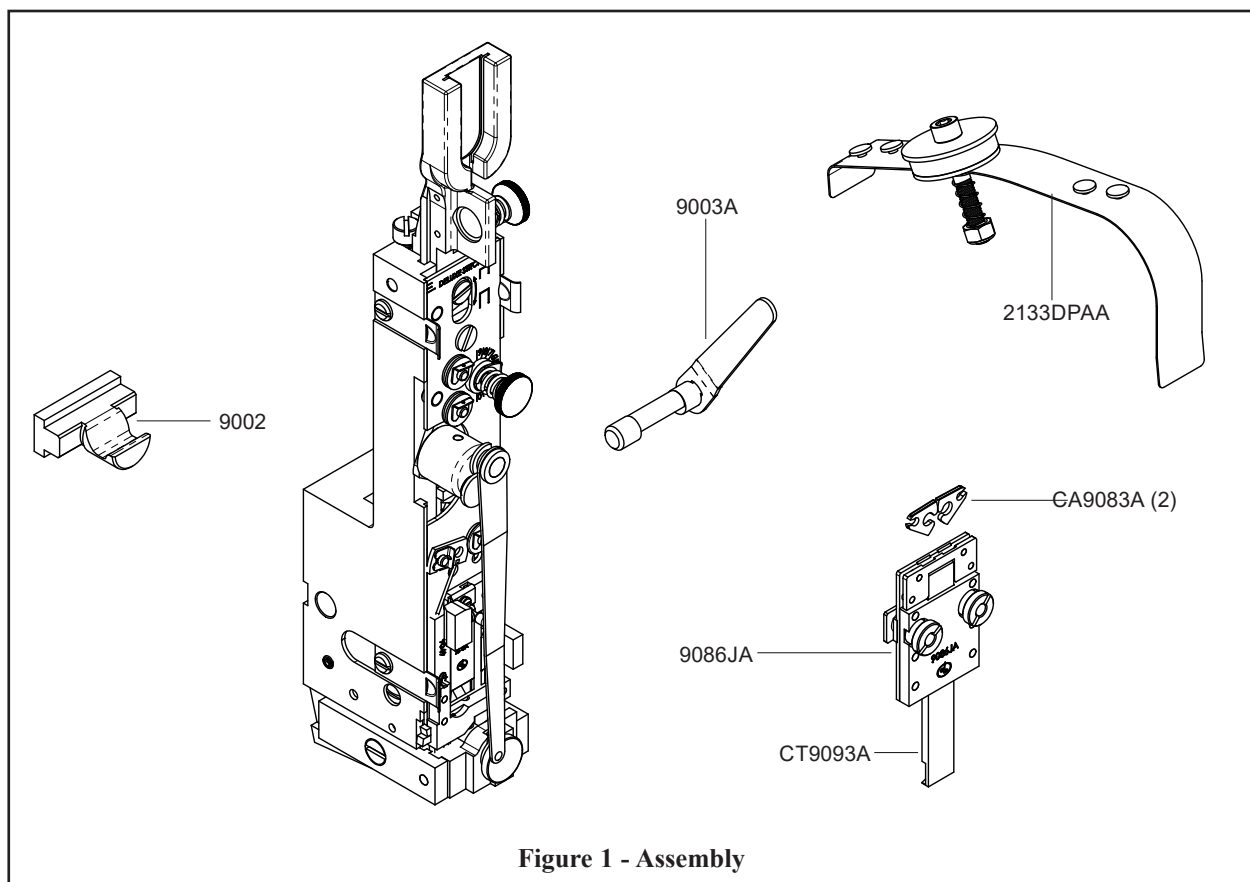


Figure 1 - Assembly

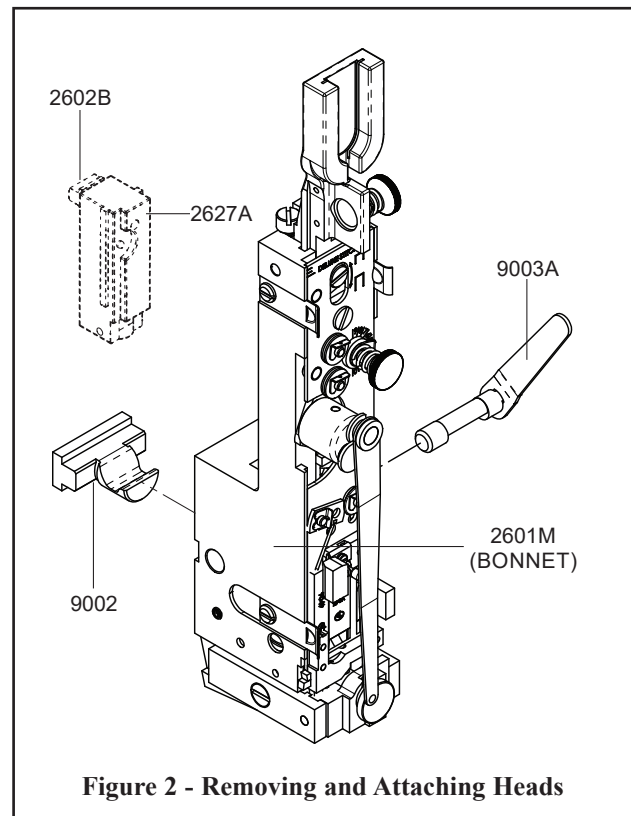
Mounting

The quality and quantity of work that can be produced by the DeLuxe Stitcher Company Heads is dependent upon the operator making the various operating adjustments as accurately as possible. The following illustrated instructions are provided so that the operator will clearly understand how to make the various required operating adjustments.

2601DDPHD Slot Mount/Rail Drive)

To remove the 2601DDPHD Series head, raise the clamping Eccentric Handle (9003A) until the Bonnet Clamp Block (9002) disengages (approximately an 11 o'clock position). The head can then be removed from the stitcher. Refer to **Figure 2**.

When attaching the Series, the 2601DDPHD Series and the Series Heads to the stitching machine, check to see that the Driving Slide Lug (2602B) is engaged in the grooves of the stitching machine's Driving Rails. Lock the Bonnet (2601M) in position by pressing down on the clamping Eccentric Handle.



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

⚠ WARNING

Operation

Wire Threading (Figures 3 & 4)

1. Disengage the Swivel Operating Spring (2155A) and remove the Swivel (9038M) from the stitcher head.

2. Pass the wire from the Spool over the Wire Guide Spring Assembly (2133DPAA), between the Guide Spring Studs and under the flanges of the Wire Straightener Rollers (9103) on the Wire Guide Spring Bracket (CAAA9074A2) as well as between the Wire Straightener Eccentric Roller (9065B) and in the grooves of the Wire Straightener Rollers (9103B) on the Face Plate (2146MA).

3. Continue to pull the wire through the Tension Pawl (9098) and through the hole in the Face Plate, located at the top of the Wire Cutter (9048) Holder and through the Swivel Holder (2147). At this point, do not worry if the wire is not fed between the Grip (9015D) and the Grip Holder area.

NOTE: The Tension Pawl will hold the wire in the Wire Straightener Roller's (9103) groove. This will allow the wire to feed through the Head but not allow it to "back-up."

4. Pull enough wire through the bottom of the Head to clear away what was bent in the threading process.

5. With the Swivel still removed, power the stitcher machine on and complete one cycle under power to allow the wire to automatically thread between the Grip and the Grip Holder. This will also cut off any excess wire below the Cutters.

NOTE: Hold the Swivel operating Spring away from the Swivel Holder so as not to damage it.

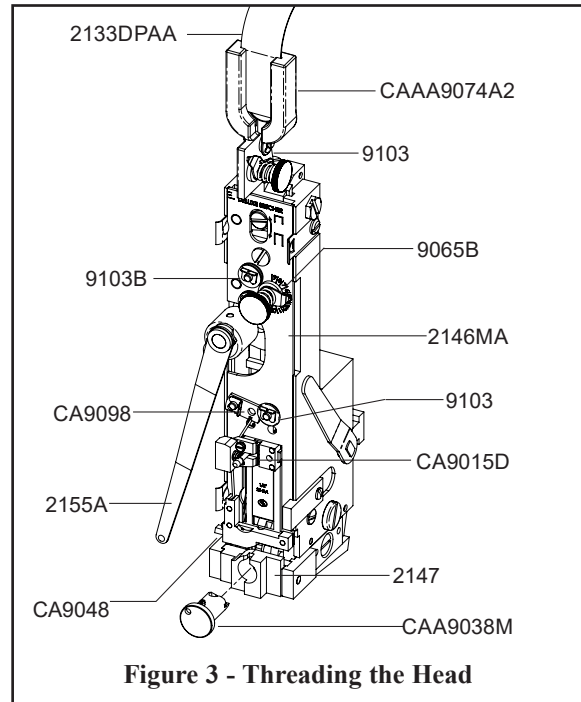


Figure 3 - Threading the Head

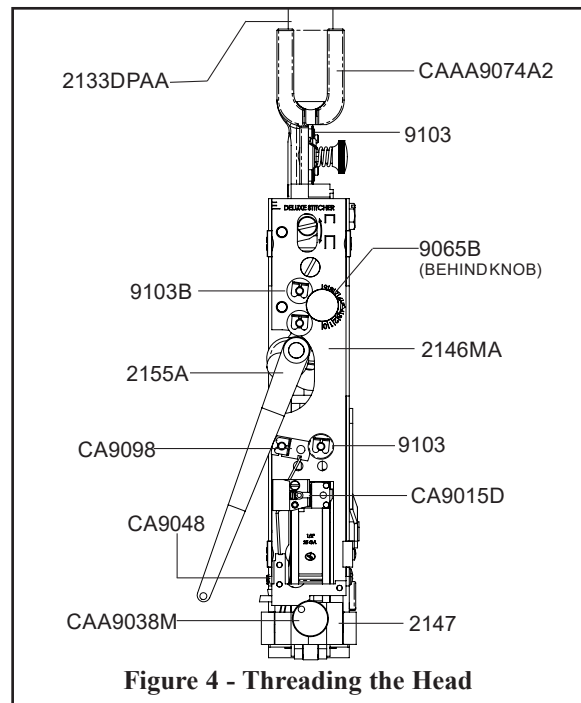


Figure 4 - Threading the Head

Wire Straightening (Figure 5)

In order to ensure the stitches are loaded, driven and clinched properly in addition to ensuring continuous operation of the 26D style heads, it is important that the wire enters the Swivel (9038M) in straight vertical line. Wire straightness is the single biggest factor for ensuring good stitches and stitcher head reliability. Although straightness is set at the factory, every roll of wire has varying degrees of twist which make it necessary for the user to properly straighten the wire prior to production **as well as during normal production**. Follow the steps for straightening wire listed below.

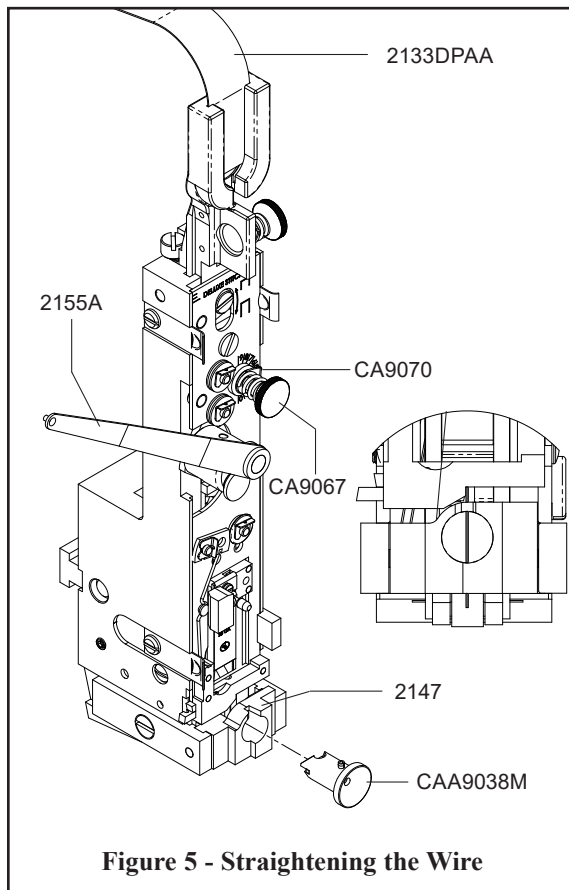


Figure 5 - Straightening the Wire

Right-to-Left Adjustment

Disengage the Swivel Operating Spring (2155A) from the Swivel (9038M) and remove the Swivel. Rotate the Operating Spring to a 10 o'clock position and remove it as well. Activate the stitcher and observe the feeding of the wire through the Swivel Holder (2147) and take note of the direction the wire is moving. Use the Wire Straightener Eccentric Nut (9067) on the Face Plate (2146MA) to adjust the wire. If the wire is feeding to the left, turn the Wire Straightener Eccentric Nut counter-clockwise. If the wire is feeding to the right, turn the Eccentric Nut clockwise. Allow enough wire to be fed through the Head so that an accurate assessment can be made. After an adjustment is made it take approximately four to six stitches to take effect.

The Pointer, (9070) attached to the Wire Straightener Eccentric Nut, and the graduated markings on the Face Plate provide a reference point for straightening the wire. The numbers have no real value though and will vary from head to head and with each spool of wire.

Front-to-Back Adjustment

If the wire is feeding in a straight line (left to right), but tends to curl forward or backward, turn the Wire Straightener Adjustment Nut (9067) on the Wire Guide Spring Assembly (2133DPAA) clockwise or counter-clockwise as required, until the condition is remedied. After the adjustments have been made so that the wire is feeding in a straight line, replace the Swivel and re-engage the Swivel Operating Spring.

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

 **WARNING**

Adjusting the Length of the Left Leg (Figure 6)

Once the 26D style Stitcher Head has been threaded and the wire straightness has been obtained, it is time to begin stitching. Activate the stitcher machine to load one piece of wire in the Swivel (9038M). Even though the 26D Stitcher Heads have been tested at the factory, the wire draw adjusted and the legs equalized, the following are directions to make these adjustments if necessary.

If the staple is off-center, meaning one leg is longer than the other, the length of the left leg has to be changed. Loosen, do not remove, the Wire Guide Spring Bracket Screw (9075) and the Wire Guide Adjustment Lock Screw (090330). Using a screwdriver, turn the Wire Guide Adjustment Screw (9076) clockwise if a shorter left leg is necessary and counter-clockwise if a longer left leg is necessary. A slight turn of the Adjusting Screw will usually prove sufficient to achieve the desired length. A quarter turn of the Adjusting Screw will make a considerable difference in the length of the staple's leg. Once the desired length has been achieved, tighten the Wire Guide Spring Bracket Screw and the Adjustment Lock Screw. At this point, the left leg should be approximately one half the width of the crown.

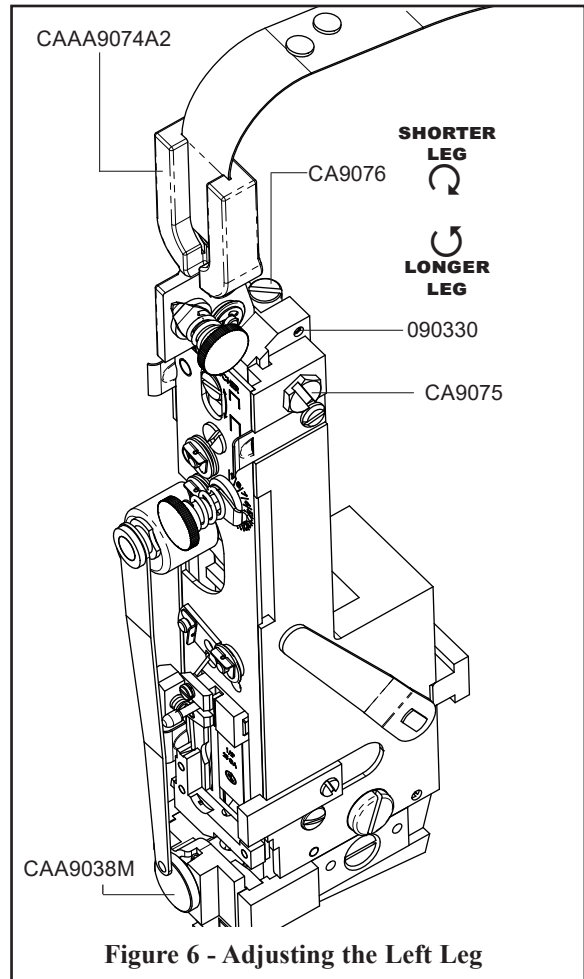


Figure 6 - Adjusting the Left Leg

NOTE: If the staple leg has been lengthened, meaning the Wire Guide Adjustment Screw (9076) has been turned counter-clockwise, tap down on the Wire Guide Spring Bracket Assy. (CAAA9074A2) before tightening the Wire Guide Spring Bracket Screw (9075).

Adjusting the Wire Draw (Figure 7)

The overall length of the stitch is controlled by the amount of wire that is drawn from the spool after each stroke of the stitcher machine. To change the overall length of the stitch, the stitcher head's Face Plate has to be raised or lowered accordingly.

2601DDPHD Series Head (Figure 7)

Loosen the Face Plate Adjusting Slide Nut (2608) found in the center of the Face Plate (2146MA). To increase the overall length of the stitch, raise the Face Plate slightly by applying pressure at the bottom edge of the Face Plate. Use a large screwdriver as a lever under the Wire Cutter Housing area

of the Face Plate. Raising the Face Plate draws more wire from the Wire Spool and increases the length of each staple leg. To shorten the staple legs or draw less wire from the Wire Spool, lower the Face Plate slightly by tapping the top edge of the Face Plate. After the adjustments have been made, tighten the Face Plate Locating Screw. As a rough gauge, the distance the Face Plate is above the Bonnet (2601M) should be equal to the work thickness. As a rule, this adjustment should only have to be made once since this style Head automatically adjusts itself when the compression setting of the Stitcher machine is changed. Some minor modifications may have to be made for individual jobs though.

**Adjusting the Clincher Points
(Figure 8)**

2601DDPHD Series Head (Figure 8)

The final position of the Clincher Points should be flush, or slightly above flush, with the Clincher Plate in order to achieve a quality stitch. The best way to see the position of the Clincher Points is to manually cycle the stitcher machine to the position when the

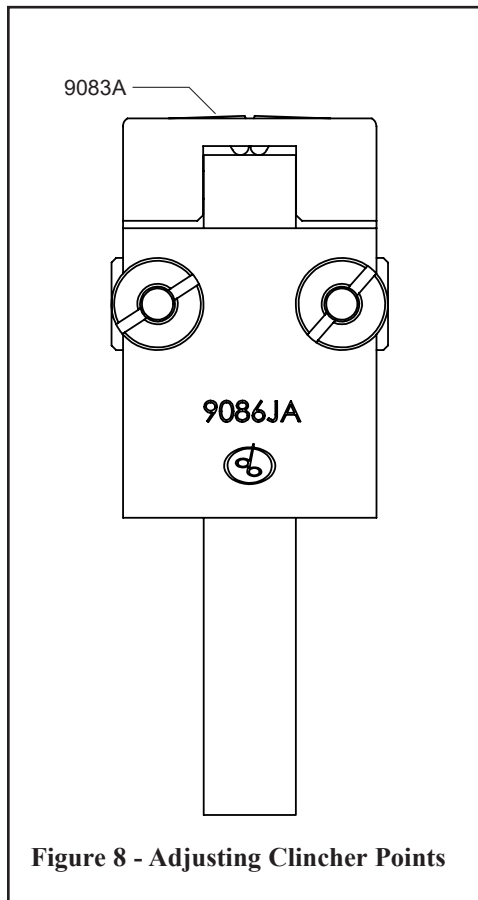


Figure 8 - Adjusting Clincher Points

to see the position of the Clincher Points is to manually cycle the stitcher machine to the position when the

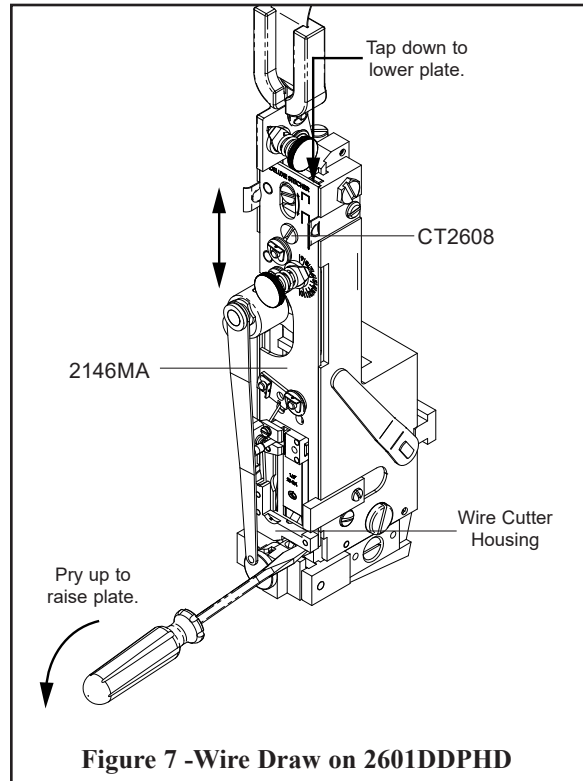


Figure 7 -Wire Draw on 2601DDPHD

Driver is at the lowest position of its stroke, the Clincher Points are at their highest position. Slowly advance the cycle of the stitcher machine just past this point to reveal the Clincher Points' position. Clincher Points that do not pivot high enough will produce a weak clinch, where Clincher Points that pivot too high will cause poor stitch quality or mark the stock being stitched.

If the clinch on the staple is not tight enough, the Clincher Points (9083A) have to be raised, assuming the Stitcher machine's compression setting is correct. If the legs of the staple are being pushed back through the stock, the Clincher Points are set too high and have to be lowered. These adjustments are specific to each stitcher machine and cannot

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

WARNING

be fully explained in this manual, since many Machines have Clincher Lever adjustments built in. Consult the stitcher machine's operating manual for complete Clincher Point adjustment instruction. This is especially useful when using non-adjustable Clincher Plates.

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

⚠ WARNING

Maintenance

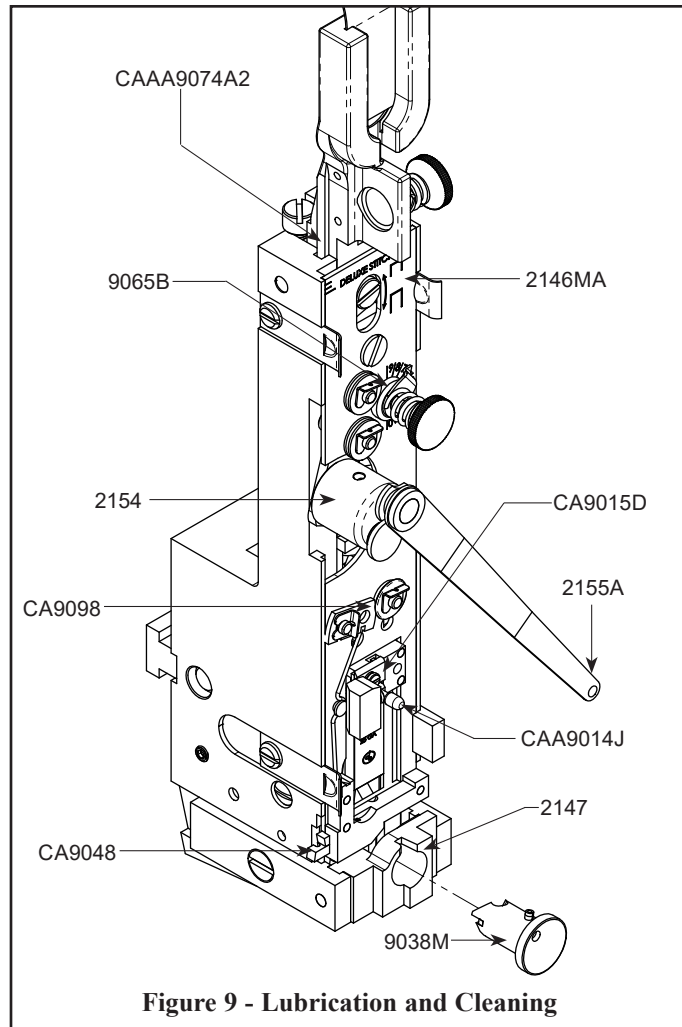
Your 26D Stitcher Head has been fully lubricated at the factory, but to insure continuous superior operation and a longer life of the head, the operator should be sure that the heads are lubricated regularly and carefully maintained. The operator should periodically inspect all moving parts for signs of wear and when required, replace the worn parts. Parts such as the Wire Cutters, the Grip, the Tension Pawl and the Driver are subject to wear and have been so designed to be reversible to provide duplicate cutting and gripping surfaces. If after continuous usage, the original cutting or gripping surfaces of any of these parts show signs of wear, their position in the head can be reversed, thereby providing a new surface and lengthening the life of the part. For a complete list of wear and replacement parts for your 26D style Stitcher Head, refer to page 32 in the back of this manual.

The following instructions are provided so that the operator will clearly understand how to lubricate the Stitcher Heads and how to identify and remove any of the parts which may need to be replaced.

Lubrication (Figure 9)

Use any standard S.A.E. #10 oil for lubricating the heads. Heads that are in constant operation should be lubricated daily. Heads that are operated periodically should be lubricated every five pound wire spool change or every month, whichever comes first. Usually, only a drop of oil is required at each lubrication point. Care must be taken that those parts of the head that contact the work to be stitched are free of oil. Lubricate regularly instead of excessively. Excessive oiling will result in work becoming spotted with oil. Use one drop of oil in the following lubrication points:

- the top of the Bonnet (2601M) on either side of the Wire Guide Spring Bracket (CAAA9074A2).
- the oil hole in the Swivel Operating Lever Hub (2154).
- the oil holes in the Face Plate (2146MA).
- on the Bender Bar Latch (9014EA) and on the Grip (9015D).
- the opening in the Swivel Holder (2147).
- where the Clincher Points pivot.
- the hole in the Wire Cutter (9048) Holder.
- on the Wire Straightener Rollers (9065B) and Tension Pawl (9098).



Cleaning (Figure 9)

In addition to proper lubrication, routine cleaning is important for the maintenance of your 26D Head. The entire Head should be torn down and rebuilt every three months and the following areas should be cleaned once a month:

- **Swivel Assembly (9038M):** remove and wash in an oil-dissolving solvent, dry and relubricate.
- **Swivel Holder (2147):** clean inside the Swivel hole.
- **Swivel Operating Lever Hub and Stud:** remove the Swivel Operating Spring (2155A), Lever (2151A) and/or Lever Hub (2154). Clean the Swivel Operating Spring Stud (2156) and the hole in the Hub, relubricate and replace.

Note: Use care when replacing the Swivel Operating Lever and/or Lever Hub to avoid serious damage being done to the head.

- **Anywhere that dust, oil or pieces of wire and paper have built up** - for example: the Grip, Clincher Points and around the Wire Straightener Rollers.

Ordering Spare Parts

In time, you will need to replace some parts in your 26D style Stitcher Head. When this happens, first locate the needed part in one of the following diagrams. Then locate the DeLuxe/Bostitch part number and contact your Graphic Arts Representative to order the part by the part number, description and quantity.

Replacing Spare Parts (Figure 10)

The following are some of the more common wear parts which will need to be removed and replaced in your 26D style Stitcher Head. Some common replacement parts do not require the Stitcher Head to be removed from the stitcher machine. These parts will be addressed first, then a more specific explanation for disassembling and replacing wear parts for the 26D Stitcher Head will follow.

Removing and Replacing the Wire Cutters Figure 11

The Wire Cutters (9048) have four cutting surfaces, each of which may be used by reversing the ends and positioning in the Face Plate (2132BA or 2146MA). Worn Cutters can cause poor stitch quality. To change or reverse the Wire Cutters, remove them from the Face Plate. Loosen the Screws (UA2305.2) securing the Face Plate Clips (9056) and the Screw (0084) securing the Solid Face Plate Clip (9171). Once the clips are loosened, the Face Plate can be tilted away from the Bonnet (2601M) to remove the Wire Cutters. This may be a good time to check for wear on the Wire Cutter Operating Slide Friction Plug (9050) and Friction Plug Spring (9051) and replace if necessary. Slide the existing or

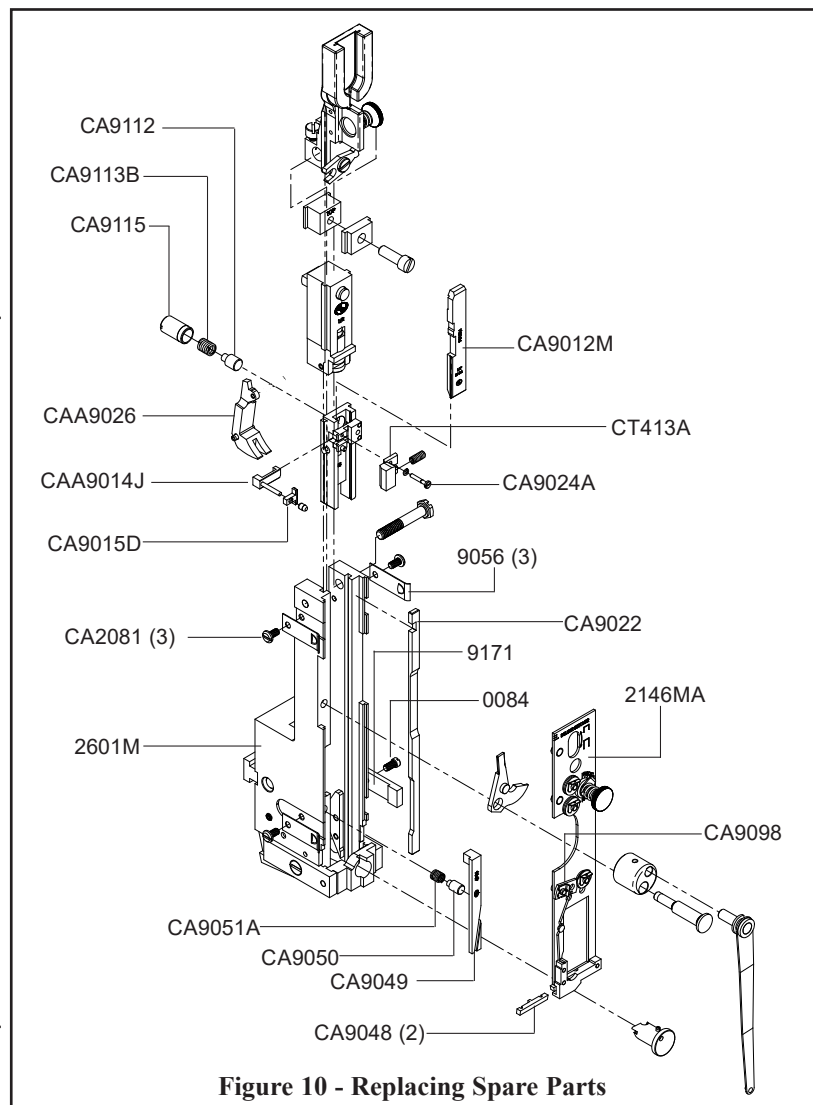


Figure 10 - Replacing Spare Parts

new Wire Cutters into the cutter holder in the Face Plate, with the tongue of the upper Cutter facing the Face Plate and the tongue of the lower cutter facing the Wire Cutter Operating Slide. Before tightening the Face Plate Clip Screws and the Solid Face Plate Clip Screw, make sure that each Cutter has slipped into position in the Face Plate and in the Wire Cutter Operating Slide. (9049) Press the Face Plate under the Face Plate Clips and tighten the Face Plate Clip Screws. Always cycle the stitcher machine manually before switching the power on to ensure free mechanical movement. This will prevent serious damage to both machine and stitcher head.

Removing and Replacing the Tension Pawl (Figure 12)

The Tension Pawl (9098) is double-ended so that when one end is worn, it can be reversed, increasing the life of the part by providing a new gripping surface. A worn Tension Pawl may cause inconsistent wire draw. To remove the Tension Pawl, disengage the Tension Pawl Spring (9134) from the Tension Pawl and remove the Wire Straightener Roll Clip (9124). Flip the Tension Pawl over so that a new surface is in contact with Wire Straightener Roller (9103) and replace the E-clip. Make sure that the Tension Pawl is under the flange in the Wire Straightener Roll before re-engaging the Tension Pawl Spring. If both ends of the Pawl are worn, replace the part.

Removing and Replacing the Grip (Figure 13)

The Grip (9015D) can be used in two positions so that when the gripping teeth show signs of wear, it may be reversed to extend the life of the part. A worn Grip may cause inconsistent wire draw. Remove the Grip Spring Housing (9914) to gain access to the Grip by unfastening the Retaining Clip Screw (9024) and then remove the Silicone Cap (2182). Remove the Grip and reverse its position within the Grip Holder. If both edges are worn, replace the part. While at this point, check the Grip Spring (9915) in the Grip Spring Housing. If worn or broken, replace.

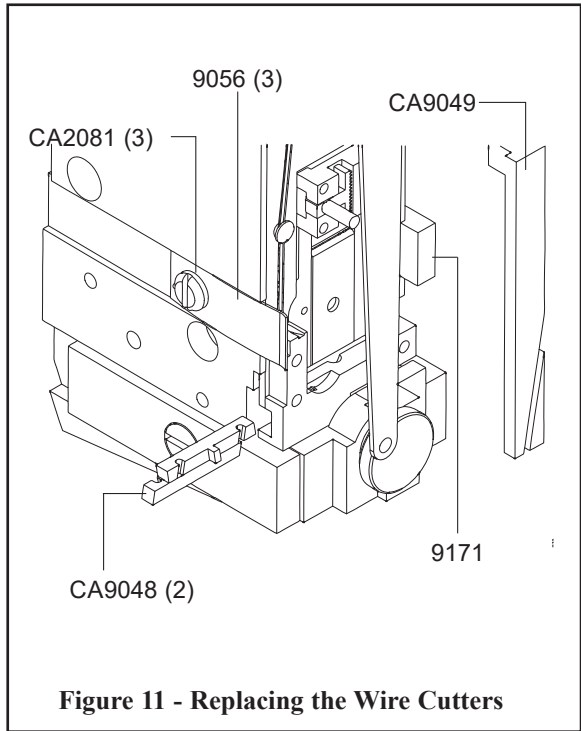


Figure 11 - Replacing the Wire Cutters

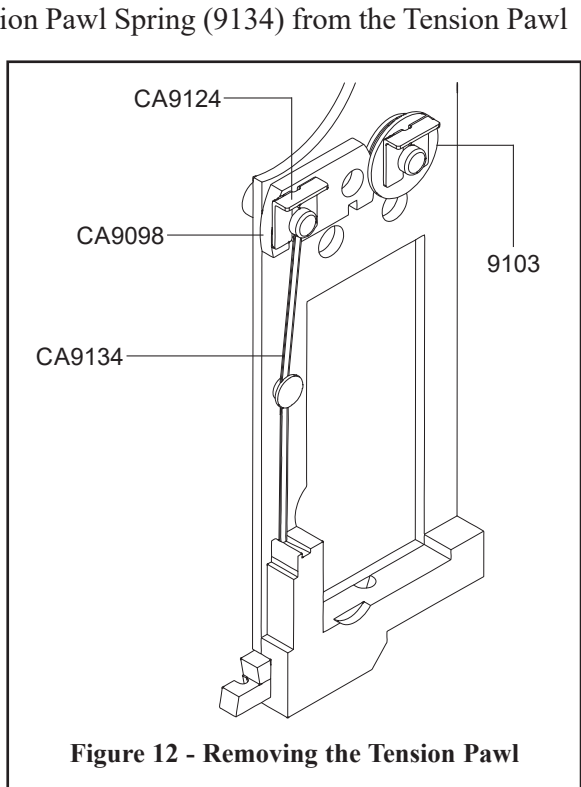


Figure 12 - Removing the Tension Pawl

⚠ **CAUTION!**
 After replacing or installing new parts, rotate the Drive Pulley manually to check for free movement.

Removing and Replacing the Driver (Figure 14)

A worn driver end may result in poorly formed crowns. To replace the 9012M driver, follow the section "Disassembling the Stitcher Head" until the Bender Bar Assy. (9013CA-25) has been removed (See Figure 15 for reference.). Then loosen and remove the Friction Bushing (9115) which houses the Spring (9113B) and Plug (9112). Once these are removed, the driver can freely slide out from the assembly. Insert the new driver and reassemble in the reverse order. (See Figure 15 for reference.)

Disassembling the Stitcher Head (Figure 15)

Remove the 26D style Stitcher Head from the stitcher machine. On 2601DDPHD series heads, loosen the Bonnet Clamp Eccentric Handle (9003A) and remove the Stitcher Head from the Bonnet Clamp Block (9002).

Release the Swivel (9038M) from the Swivel Holder (2147) by lifting the Swivel Operating Spring (2155A) off of the Swivel. Continue to rotate the Spring upward until it can be released from the Swivel Operating Lever Stud (2152) – at approximately the 11 o'clock position. Loosen, but do not remove, the Screws securing the Face Plate Retaining Clips. With the Face Plate Clips hanging loosely from the Bonnet, remove the Face Plate paying special attention to the loose Wire Cutters (9048). Remove the Wire Cutter Operating Slide, the Wire Cutter Operating Slide Friction Plug, the Wire Cutter Operating Slide Friction Spring and place these pieces along side of the Bonnet. Remove the Swivel Operating Lever Hub (2154) from the Stud by first removing the retaining screw (9058) securing the Stud to the Bonnet, thus securing the Hub to the Bonnet as well. Remove this Screw in order to remove the Stud and Swivel Operating Lever (2151A). Remove any accessories at this time in addition to the Swivel Holder.

Remove the Grip Release Slide Lever (9025B) and Grip Release Slide (9022) and set them aside. Loosen and remove the Wire Guide Spring Bracket Screw (9075), which will release the Wire Guide Spring Bracket (CAA9074A2) from the top of the Bonnet. Loosen the Face Plate Locating Screw (2608) and slide the Face Plate Adjustment Slide Block (2611), the Face Plate Lock Clamp (2606) and Lock Block (2607) out the top of the Bonnet. The Driving Slide

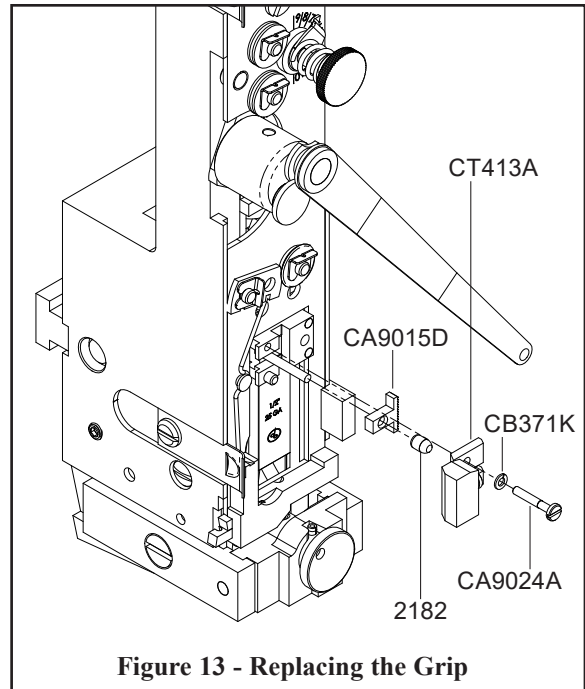


Figure 13 - Replacing the Grip

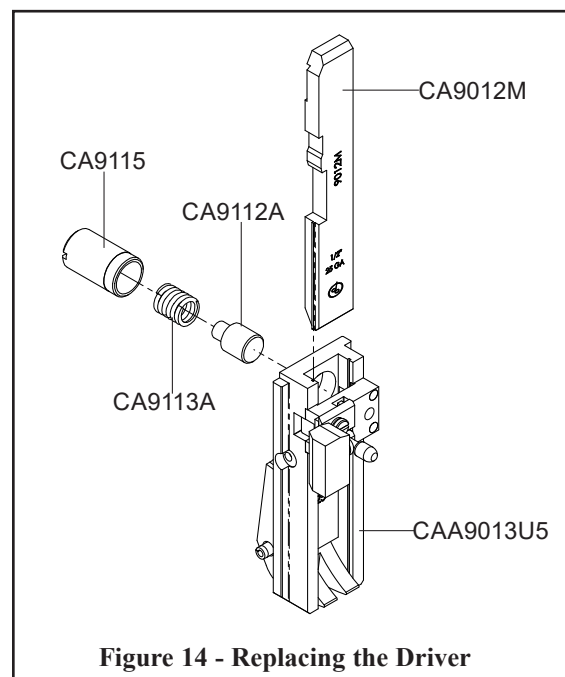


Figure 14 - Replacing the Driver

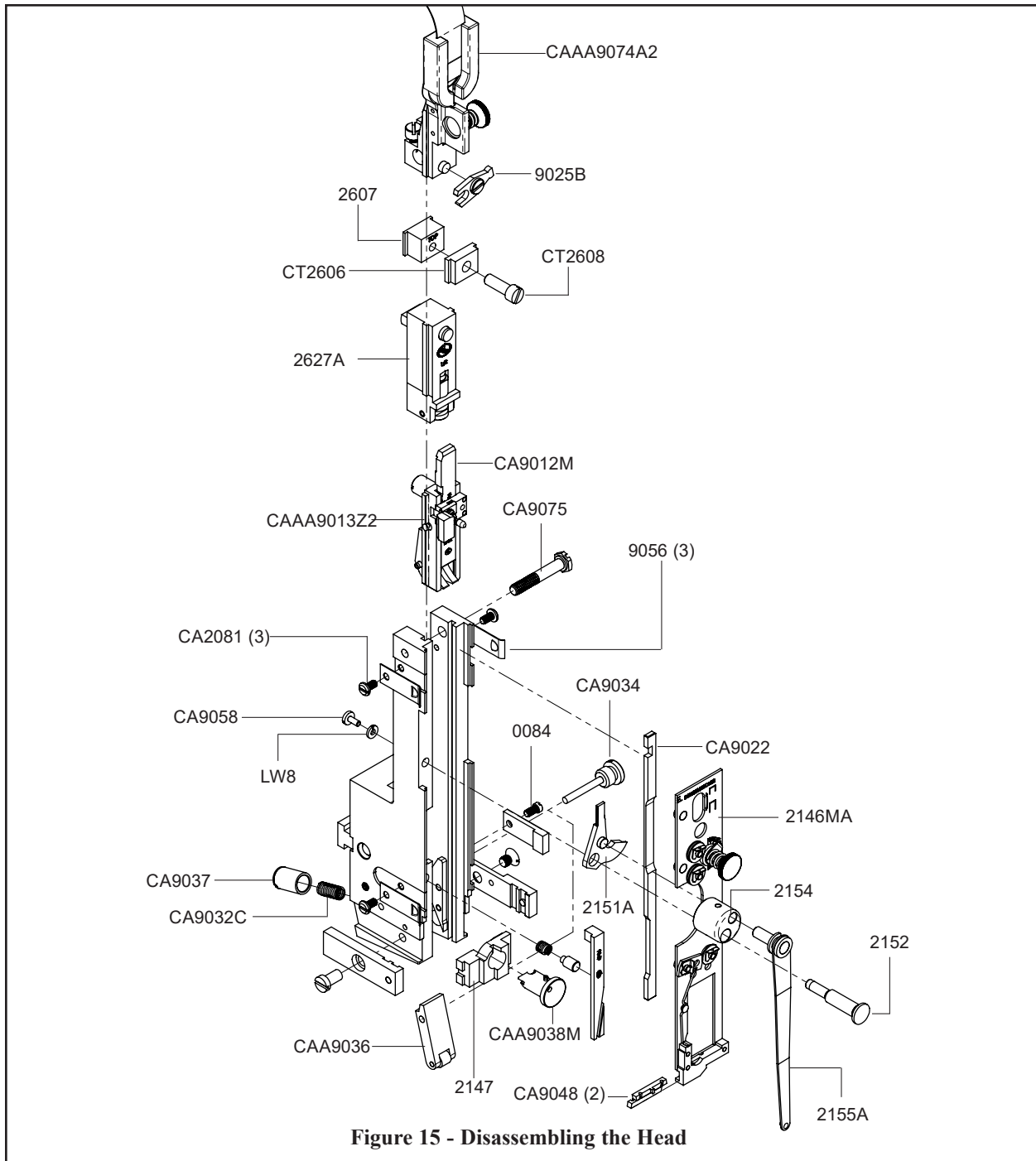


Figure 15 - Disassembling the Head

Assembly Link (2627A) will be free to slide out of the top of the Bonnet now as well as the Bender Bar Assembly (9013CA-25). Loosen and remove the Supporter Spring Lever Bushing (9037) as well as the Supporter Spring (9032). The Supporter Spring Lever Assembly (9036A) will now be swinging freely within the Bonnet. Loosen and remove the Supporter Spring Lever Screw (9034) to remove

**Always power down the stitcher machine
before any maintenance or adjustments
are made to the stitcher head.**

CAUTION

the Lever Assembly from the Bonnet.

Any of these assemblies can now be taken apart for cleaning or repair. The Bonnet itself can also be cleaned or checked for damage. Most common wear parts can be exchanged while the Head is still assembled though. Reassembling the Head is as simple as reversing the method used to disassemble the Head. Always turn the machine over manually anytime repairs or adjustments are made for the safety of both the operator and the Stitcher Head.

Re-assembling the Stitcher Head (Figure 19)

1. Insert the Supporter Spring Lever Screw (9034) through the Supporter Spring Lever Assembly (9036A) and into the Bonnet. Grease one end of the Supporter Spring and insert it into the Supporter Spring Lever Bushing (9037). Insert both the Spring and Bushing into the back of the Bonnet but do not tighten the Bushing completely at this point.
2. Start the Bender Bar Assembly (9013CA-25) into the top of the Bonnet. Hook the Bender Bar Assembly in the notch of the Driving Slide Assembly Lug (2627A) and finish guiding both assemblies between the rails of the Bonnet.
3. Slide the Face Plate Lock Clamp (2606) and Block (2607) or the Face Plate Adjustment Slide Block (2611) into the top of the Bonnet but do not tighten the Face Plate Locating Screw at this point. Next, slide the Wire Guide Spring Bracket (CAAA9074A2) into the top of the Bonnet and secure it with the Wire Guide Spring Bracket Screw (9075).
4. Secure the Grip Release Slide Lever (9025B) on the Pivot Pin on the Wire Guide Spring Bracket. Oil the right rail of the Bonnet slightly, engage the Lever in the notch of the Grip Release Slide (9022) and rest the Slide on the rail of the Bonnet.
5. Grease one end of the Wire Cutter Operating Slide Friction Spring (9051) and the Wire Cutter Operating Slide Friction Plug (9050) and insert both into the Bonnet. Rest the Wire Cutter Operating Slide (9049), along the left Bonnet rail, on the Friction Plug. Secure the Swivel Operating Lever (2151A), the Swivel Operating Lever Hub (2154) and the Swivel Operating Lever Stud (2152) to the Bonnet. Verify the orientation is correct.
6. Secure the Face Plate (2146MA), with the Wire Cutters (9048), to the Bonnet by tightening the Screws (UA2305.2 and 0084) securing the Face Plate Clips (9056 and 9171). Make sure the internal assemblies move freely before mounting the Head on a Machine.

After replacing or installing new parts, rotate the Drive Pulley manually to check for free movement.

 **CAUTION!**

Troubleshooting (Figure 16)

The quality and quantity of work that can be produced with the 26D Stitcher 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 solutions which should cover the majority of situations encountered when stitching with the 26D Stitching Head.



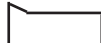


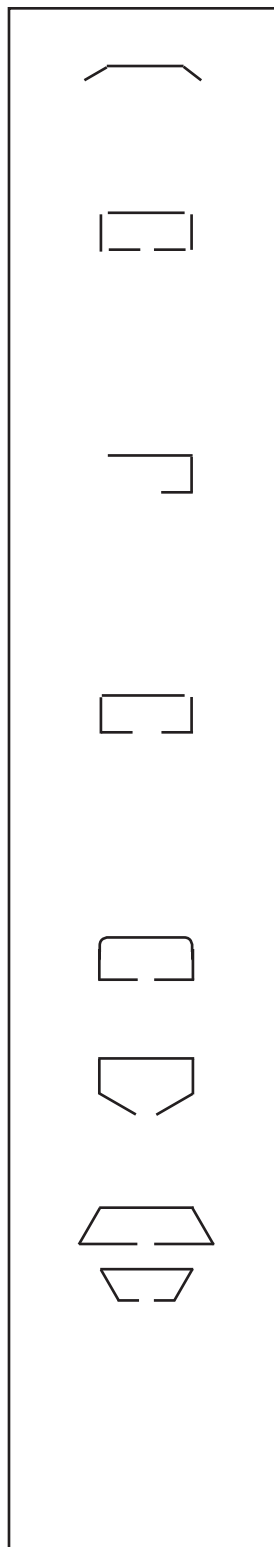
	<p>PROBLEM: Left Leg Short SOLUTION: Lengthen the left leg. (See Fig. 6) Check the Grip for wear and clean, rotate or replace it if needed. (See Fig. 13 instructions)</p>
	<p>PROBLEM: Right Leg Short SOLUTION: Shorten the left leg to match the right leg, then adjust both legs to desired length by adjusting the Face Plate. (See Figs. 6 & 7 instructions)</p>
	<p>PROBLEM: Corner Buckled SOLUTION: Check the Driver (9012M) for a chipped corner and rotate or replace it if needed. (See Fig. 14 instructions) Check the tensile strength of the wire or use thicker wire.</p>
	<p>PROBLEM: Leg(s) Buckled SOLUTION: If the ends of an unformed piece of wire are not smooth, the Wire Cutters (9048) are worn. Check for wear and rotate or replace if needed. (See Fig. 11 instructions) Make sure the correct wire size is being used and that the wire is straight.</p>
	<p>PROBLEM: Crown Bent or Buckled SOLUTION: Check Supporter Spring (9032) tension, adjust the Supporter Spring Lever Bushing or replace the Spring if needed. Check for correct wire size being used. Check for correct work thickness setting. Make sure there is not too much chamfer on the Swivel or that it is worn.</p>

Figure 16 - Troubleshooting



PROBLEM: Partially Formed Stitches

SOLUTION: Replace the worn Driver Bar Latch (9014EA) or Driver Bar (9012M). The Grip Spring (9915) in the Grip Spring Housing (9914) could be worn or broken, replace it. (See Fig. 13 instructions)

PROBLEM: Stitch in Pieces or Right or Left Leg Sheared Off

SOLUTION: Clean and lubricate Swivel (9038M). (See Fig. 9 instructions) Loosen the Swivel Holder Screw and correct the alignment between the Swivel Holder and the Bender Bar. If problem persists, file the forming corner of the Swivel slightly with a honing stone.

PROBLEM: Left Leg Missing

SOLUTION: Clean the Grip (9015D). Reverse or replace the part if needed. (See Fig. 13 instructions) Make sure the Wire Straightener Rollers are not set too tight. Make sure the Tension Pawl is not worn and is pivoting correctly. (See page 12 instructions)

PROBLEM: Corner of stitch broken or nearly cut through

SOLUTION: File the forming corner of the Swivel slightly with a honing stone if too sharp. Lower Clincher Points (9083A) if too high. (See Fig. 8 instructions) Loosen the Swivel Holder Screw and correct the alignment between the Swivel Holder and the Bender Bar.

PROBLEM: Corners of the Crown are Rounded

SOLUTION: Replace the worn Swivel (9038M).

PROBLEM: Loose Clinch

SOLUTION: Check thickness setting for work or raise Clincher Points (9083A). (See Fig. 8 instructions)

PROBLEM: Legs are Spread or Contracted

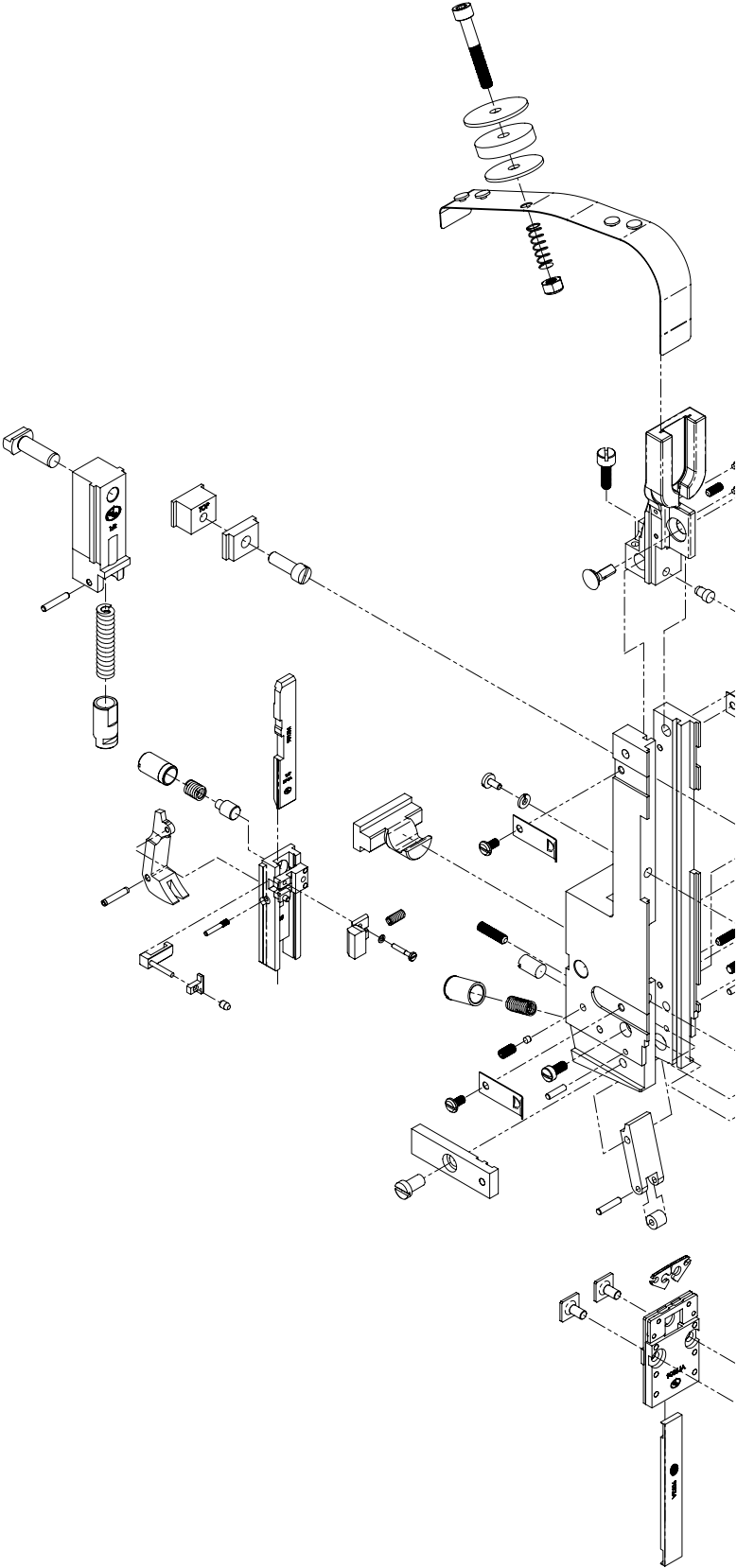
SOLUTION: Re-adjust the Wire Straightener Eccentrics to improve straightness. (See Fig. 6 instructions) Check the Wire Cutters for wear and rotate or replace. (See Fig. 11 instructions) Check the Bender Bar (9013CA-25) for wear in the grooves and replace if necessary.

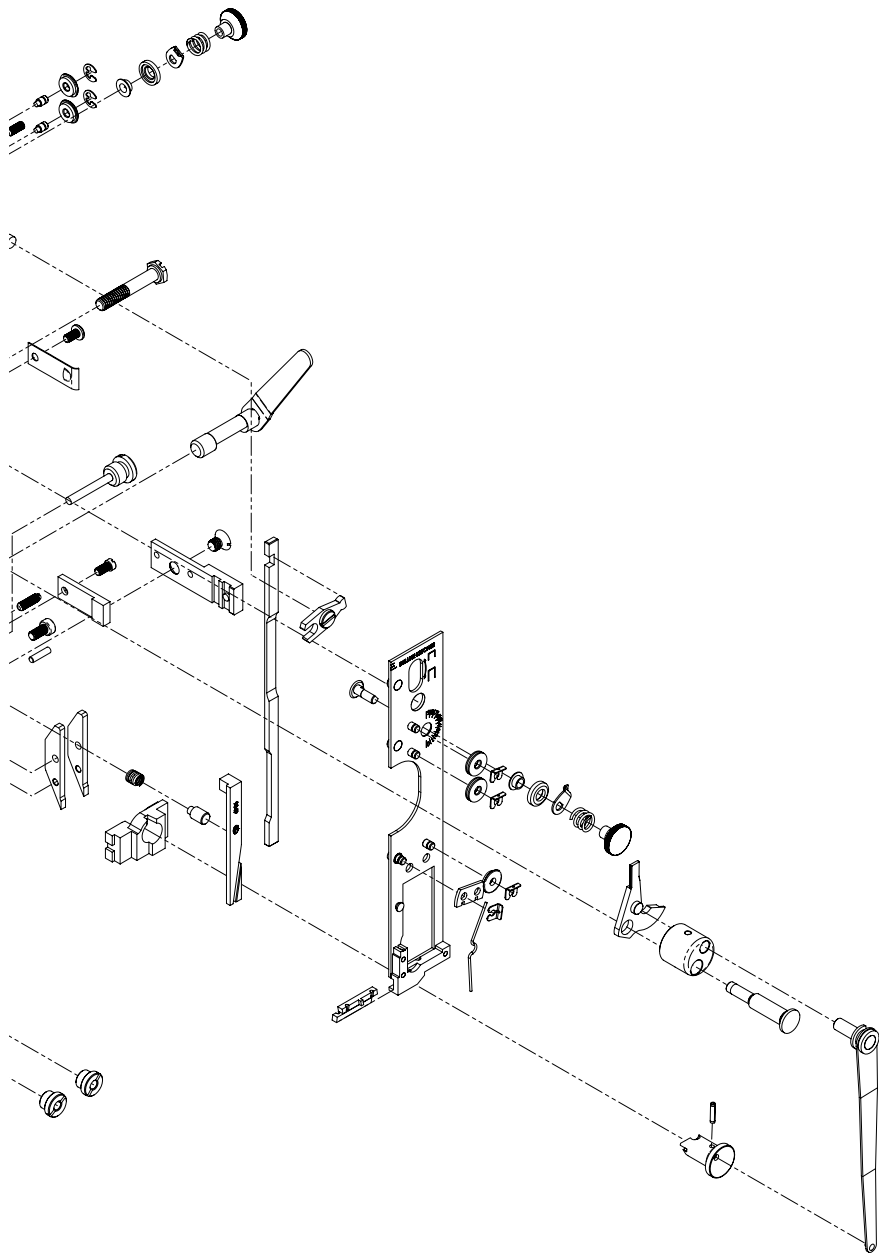
PROBLEM: No wire being drawn

SOLUTION: Lower the Face Plate. (See Fig. 7 instructions)

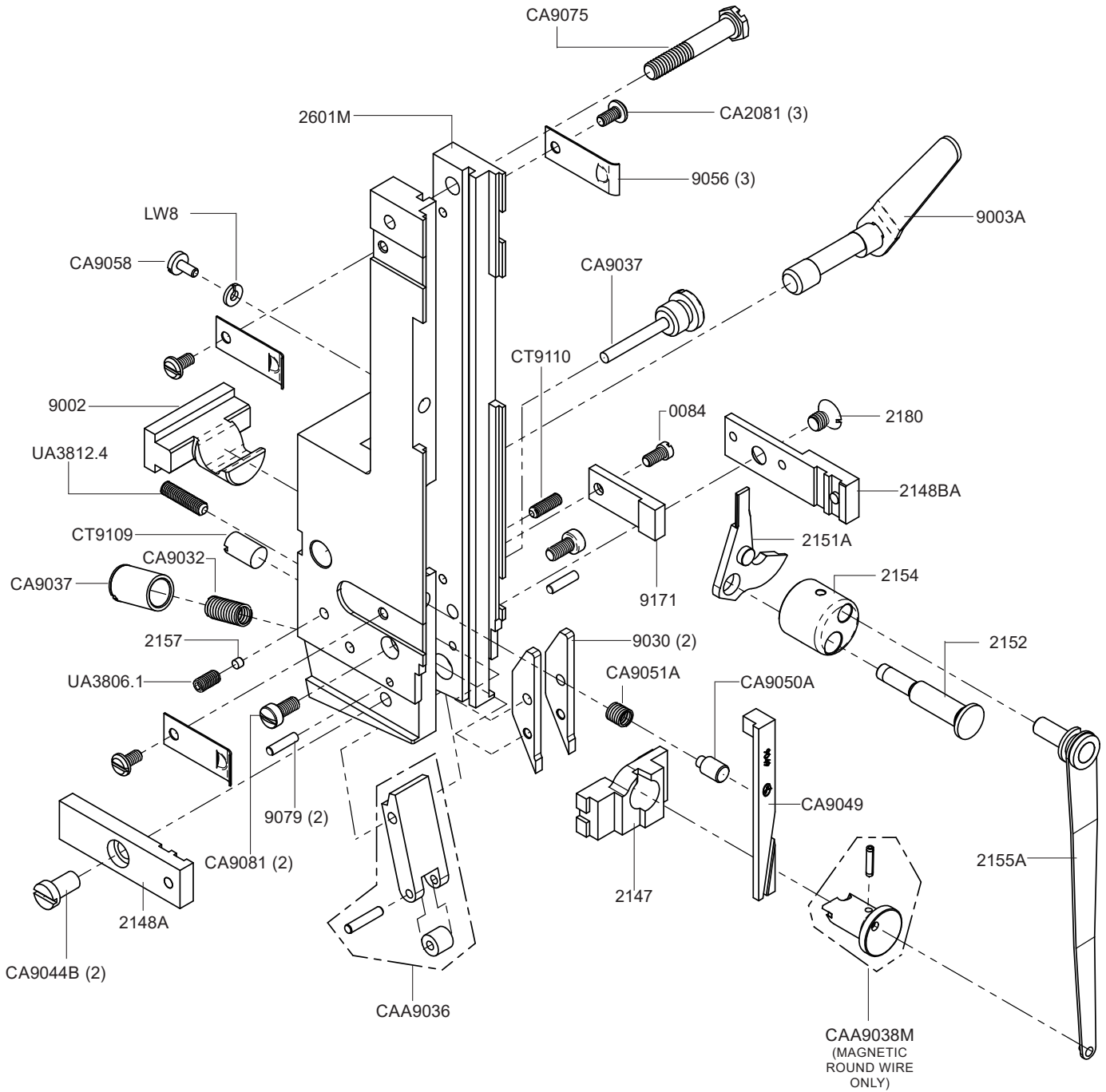
Figure 16 - Troubleshooting

**The 26D Stitcher Head
(Figure 18)**

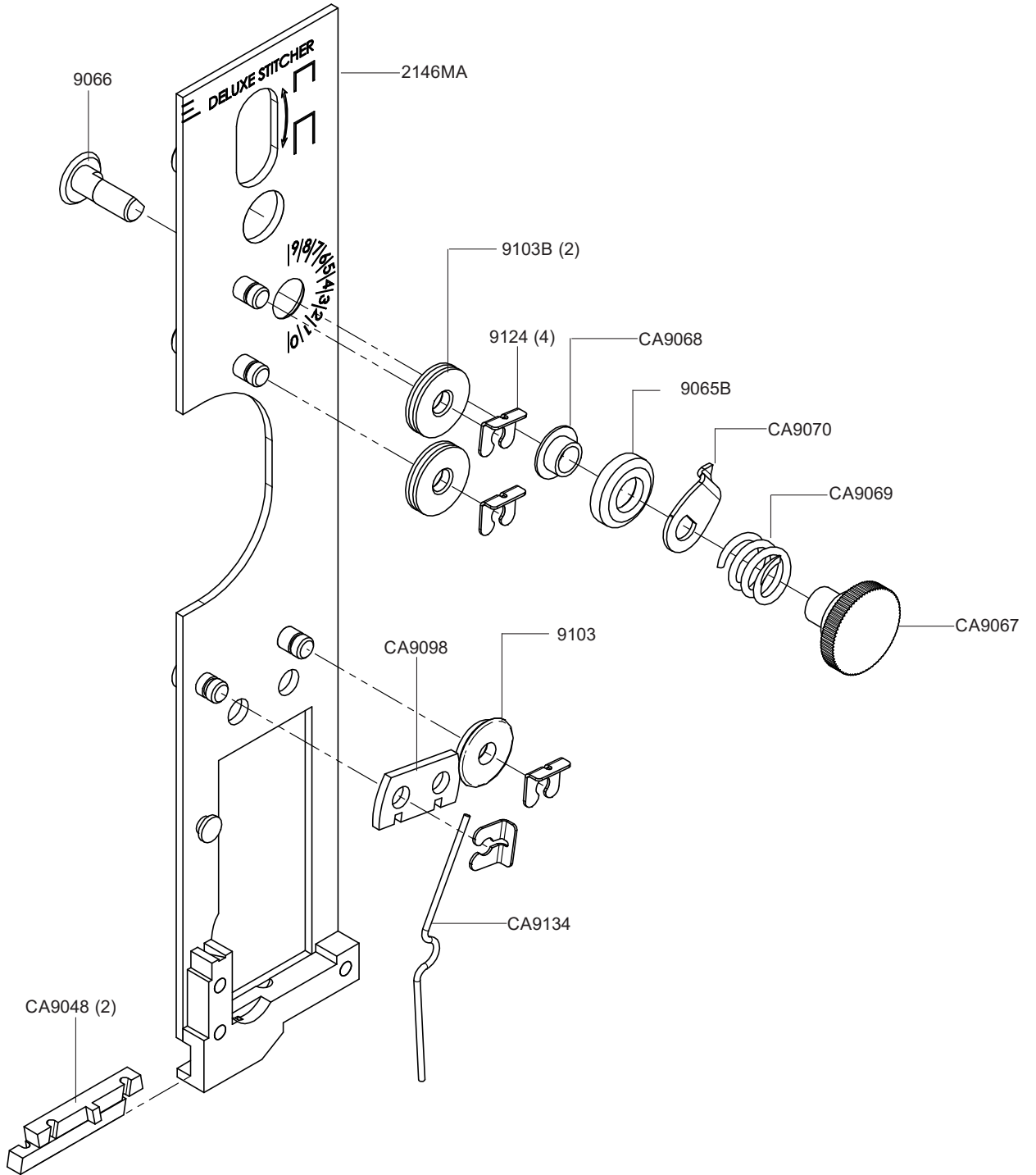




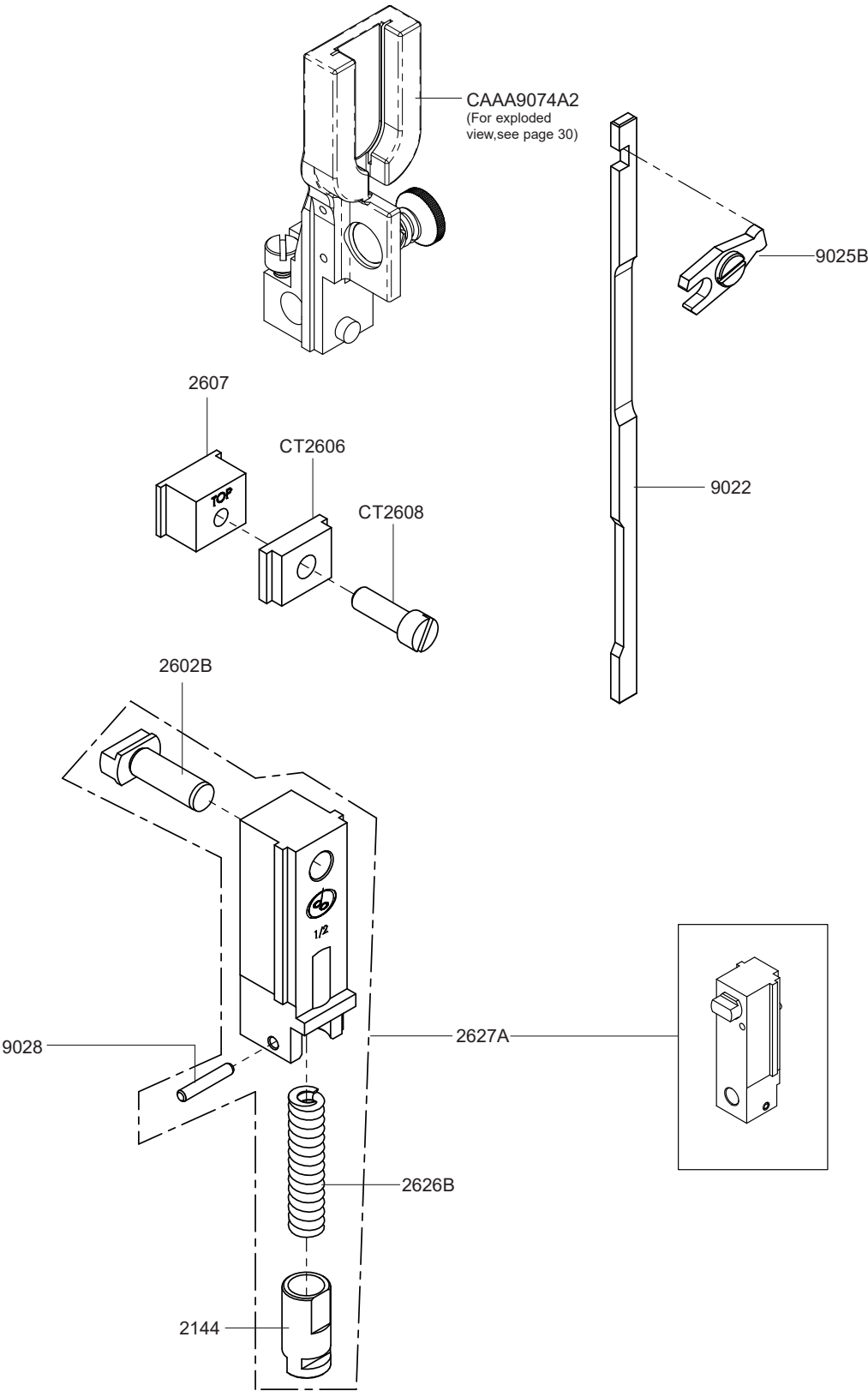
**Bonnet Sub-Assembly - "D" Style
(Figure 17)**



**Face Plate Assembly
(Figure 19)**

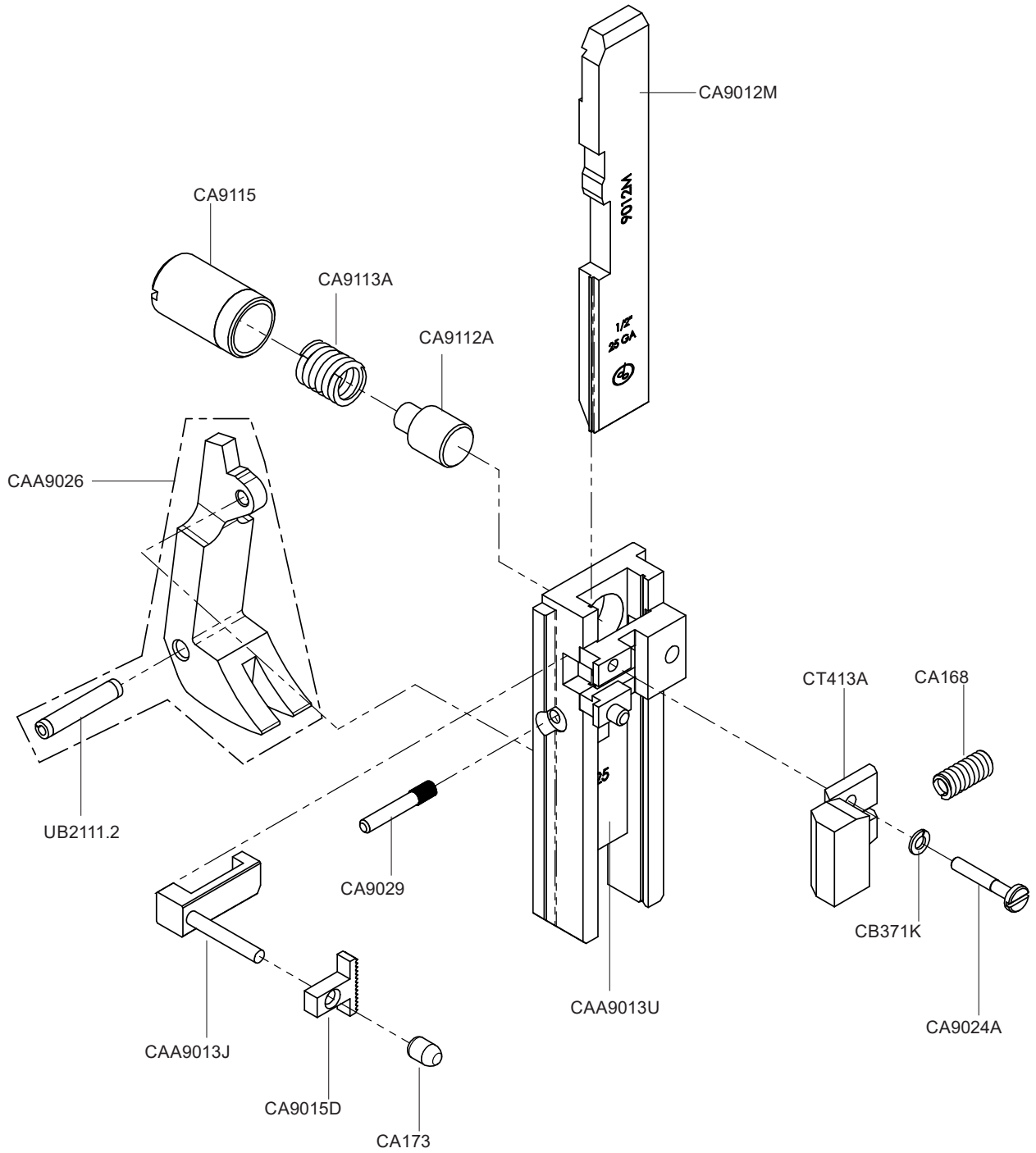


**Driving Slide Assembly - "D" Style
(Figure 20)**

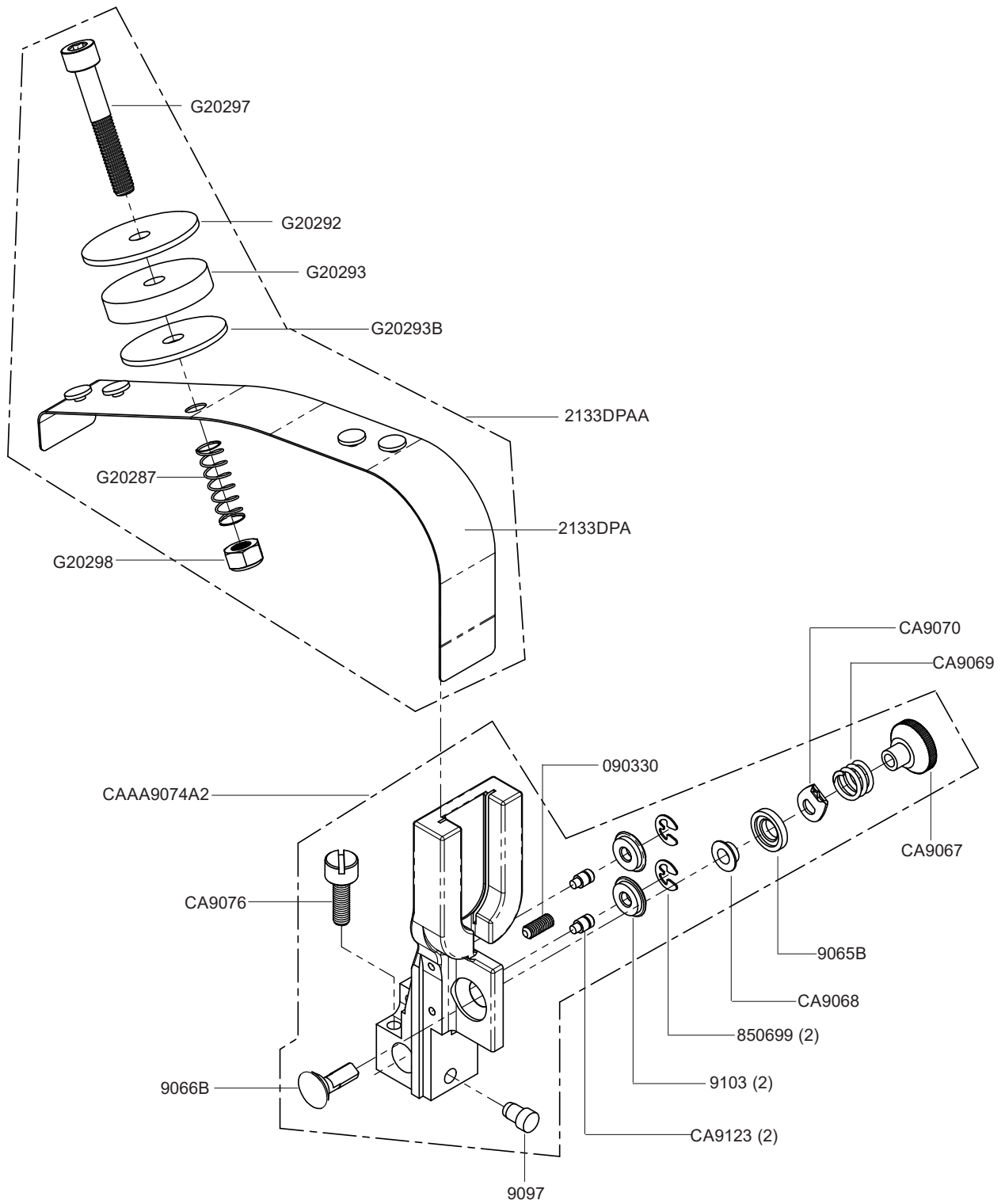


Bender Bar Assembly (Full)
(Figure 21)

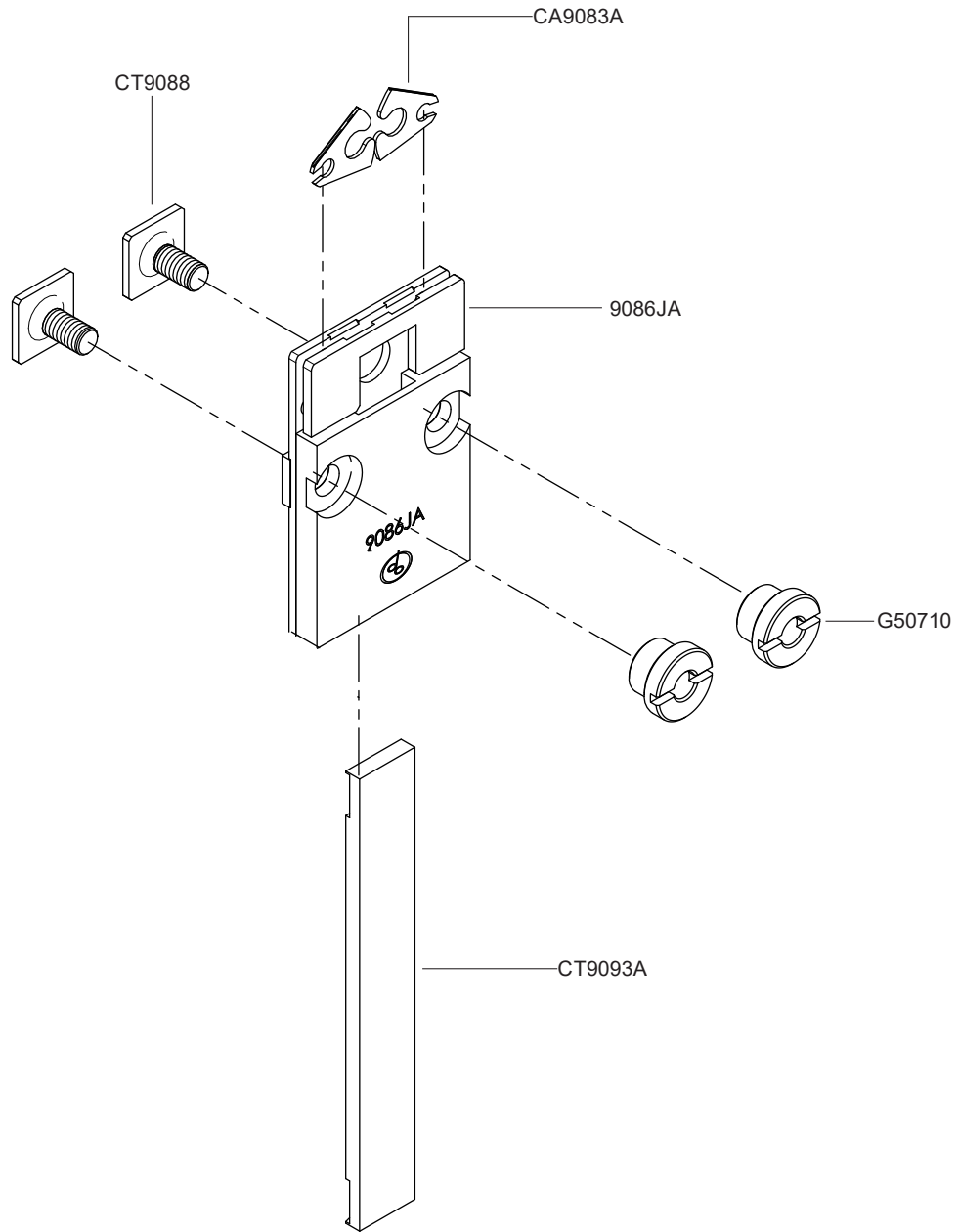
CAA9013Z2



Wire Guide Bracket and Spring (Figure 22)



Clincher Plate Assemblies (Figure 23)



NOTES:

NOTES:

Part Number / Description Cross-Reference

0084	Solid Face Plate Clip Screw	1	9028	Driving Slide Spring Lock Pin	1
090330	Wire Guide Adjust. Brkt. Lock Screw	1	CA9029	Supporter Pivot Pin	1
2133DPA	Wire Guide Spring Assembly	1	9030	Supporter Guide Plate	2
2133DPAA	Wire Guide Spring Asy w/ Oiler Felt	1	CA9032C	Supporter Spring	1
2144	Driving Slide Plunger	1	9033	Dowel Pin	1
2145	Supporter Guide Plate Screw	1	CAA9036	Supporter Spring Lever Assembly	1
2146MA	Face Plate 1/2 w/Adjuster Slot (26D)	1	CA9037	Supporter Spring Lever Bushing	1
2147	Swivel Holder (26D)	1	CAA9038M	Swivel, Magnetic Assembly - 1/2	1
2148A	Swivel Holder Clamp	1	CA9044B	Swivel Holder Screw	2
2148BA	Swivel Holder Clamp	1	CA9048	Wire Cutter	2
2151A	Swivel Operating Lever	1	CA9049	Wire Cutter Operating Slide	1
2152	Swivel Operating Lever Stud	1	CA9050A	Wire Cutter Oper Slide Friction Plug	1
2154	Swivel Operating Lever Hub	1	CA9051A	Wire Cutter Oper Slide Friction Spring	1
2155A	Swivel Operating Spring	1	9056	Face Plate Retaining Clip	3
2156	Swivel Operating Spring Stud	1	CA9058	Swivel Operating Lever Screw	1
2157	Supporter Lever Lock Shoe	1	9065B	Wire Straightener Eccentric Roller	2
2180	Swivel Holder Screw	1	9066	Wire Straightener Eccentric	1
CA173	Cap	1	9066B	Wire Straightener Eccentric	1
2601M	Bonnet Sub-Assembly (26D)	1	CA9067	Wire Straightener Eccentric Nut	2
2602B	Driving Slide Lug (26D)	1	CA9068	Wire Straightener Eccentric Bushing	2
CT2606	Face Plate Locating Clamp	1	CA9069	Wire Straightener Eccentric Spring	2
2607	Face Plate Lock Block	1	CA9070	Wire Straightener Eccentric Pointer	2
CT2608	Face Plate Lock Screw	1	CA9075	Wire Guide Spring Bracket Screw	1
2626B	Driving Slide Spring	1	CA9076	Wire Guide Adjust. Brkt. Screw	1
2627A	Driving Slide Assembly (26D)	1	CA9079	Supporter Guide Plate Dowel	2
CAAA9074A2	Wire Guide Spring Bracket	1	CA9081	Supporter Guide Plate Screw	2
850699	E-ring	2	CA9083A	Clincher Point, Thick, Round	2
9002	Bonnet Clamp Block	1	9086JA	Clincher Plate, Thick	1
9003A	Bonnet Clamp Handle	1	CT9088	Clincher Plate Binder Bolt	2
CA9012M	Driver Bar - 1/2	1	CT9093A	Clincher Slide, Thick	1
CAA9013U5	Bender Bar Asy 1/2, Ext. Grip Spring	1	CA9097	Grip Release Lever Pin	1
CAA9014J	Latch Assembly	1	CA9098	Tension Pawl	1
CA9015D	Grip	1	9103	Wire Straightener Roller-Flanged	3
CA9022	Grip Release Slide	1	9103B	Wire Straightener Roller-Grooved	2
CA9024A	Grip Spring Housing Screw	1	CT9109	Bonnet Alignment Screw	1
9025B	Grip Release Slide Adjust. Lever Assy.	1	CT9110	Bonnet Screw Binder	1
CAA9026	Supporter Assembly - 1/2	1	CA9112A	Bender Bar Friction Plug	1

Part Number / Description Cross-Reference

CA9113A	Bender Bar Friction Spring	1	G20293	Wire Oiler Felt	1
CA9115	Bender Bar Friction Bushing	1	G20293B	Wire Oiler Felt, Thin	1
CA9123	Wire Straightener Roll Stud	2	G20297	Screw M6x1.0x40	1
CA9124	Wire Straightener Roll Clip	4	G20298	Nylock Lock Nut, M6x1	2
CA9134	Tension Pawl Spring	1	G50710	Clincher Plate Nut	2
9171	Solid Face Plate Clip	1	CB371K	Lock Washer #2	1
CT413A	Grip Spring Housing	1	LW8	Lock Washer #8	1
CA968	Bender Bar Spring	1	LW38	Lock Washer 3/8	1
CAA9013U5	Bender Bar Asy Complete 1/2	1	UA2305.2	Face Plate Retaining Clip Screw	3
CAAA9074A2	Wire Guide Spring Bracket Assy	1	UA3806.1	Supporter Lever Lock Screw	1
G20287	Wire Oiler Felt Spring	1	UA3812.4	Supporter Lever Stop Screw	1
G20292	Wire Oil Felt, Washer	1	UB2111.2	Supporter Guide Pin	1

REGISTRATION

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

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

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 : _____

PRODUCT

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

DELUXE STITCHER GRAPHIC ARTS REPRESENTATIVE

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

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

Common Replacement Parts for 1/2" Crown

Below is a list of the most common wear/replacement parts for the 26D Stitcher Head. 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 24-30 in this manual.

Description	Item Number
Driver	9012M
Latch	CA9014J
Grip	CA9015D
Grip Spring	CT413A
Grip Retaining Clip Screw	CA9024A
Swivel Assembly	CAA9038M
Wire Cutter	CA9048
Wire Cutter Oper. Slide Friction Plug	CA9050A
Wire Cutter Slide Friction Spring	CA9051A
Clincher Points-Thick	CA9083A
Tension Pawl	CA9098
Wire Straightener Rollers	9103 & 9103B
Bender Bar Friction Plug	CA9112A
Bender Bar Friction Spring	CA9113A
Wire Straightener Roll Clip	CA9124
Tension Pawl Spring	CA9134

PLACE
STAMP
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 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.



COMPANY INC.

ISP **Stitching & Bindery Products**

3747 Acorn Lane • Franklin Park • Illinois 60131

Phone: 847-455-4400 • 800-634-0810

Fax: 847-455-4900 • 800-417-9251

<http://www.deluxestitcher.com>

DBS26DDP-0323