



# DELUXE STITCHER

COMPANY INC.

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

Head Serial Number : \_\_\_\_\_

Date Purchased : \_\_\_\_\_

Where Installed: \_\_\_\_\_

(make/model of machine)

## DB75V Loop

### OPERATION AND MAINTENANCE MANUAL

DB75VHD231/2L....Stitcher Head.....23 Wire

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

# WARNING!

## DB75V Loop Stitching 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.

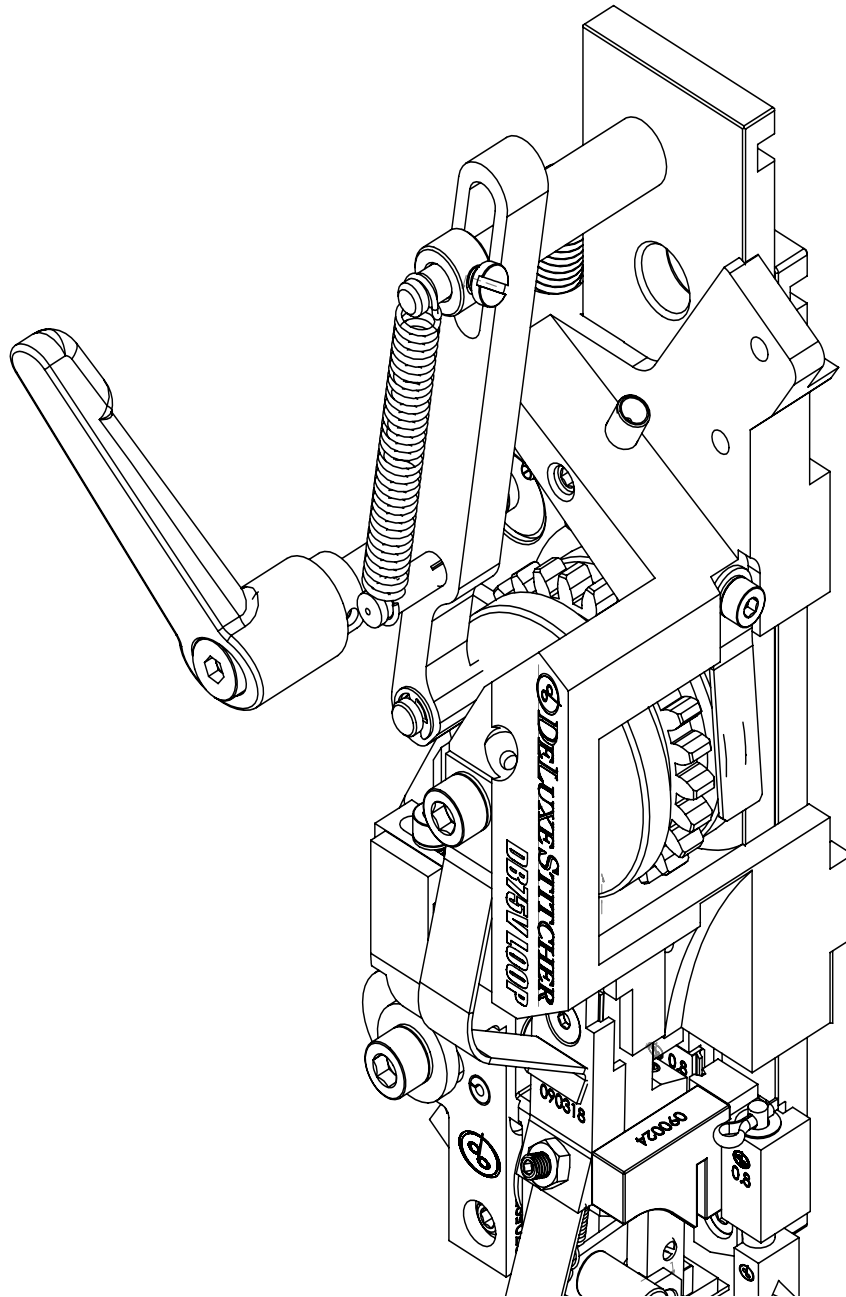
Never operate the machine with wire feeding through the head unless there is stock above the clinchers, otherwise serious damage may result.

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

**EYEWEAR**



**REQUIRED**



*Thank you for choosing the  
DB75V LOOP STITCHER HEAD  
for your binding needs.*

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# Introduction

The DeLuxe Stitcher Müller-Martini Replacement Heads, along with a complete line of fully interchangeable replacement parts are available for current Müller-Martini users. Anywhere the HK75V is utilized the DeLuxe Stitcher DB75VHDL can be used.

The DB75VHDL has a stitching capacity from 2 sheets up to 3mm (.118”) and will accommodate 25 gauge round wire. The perfect replacement head for Müller-Martini Stitchers 221, 235, 321, 335, Prima, Bravo and more, the DB75VHDL is completely interchangeable.

The DB75VHD & DB75VSHD have a stitching capacity from 2 sheets up to 6mm (.236) and will accommodate wire sizes from 20-28 gauge round as well as 21 x 25 and 20 x 24 flat. This replacement head for Müller-Martini Stitchers 301, Tempo, Optima, Supra and the like, is also completely interchangeable.

Each of these heads weighs 7 lbs (3.2 kgs.) independently. The packaged shipping weight including the wire guide spring, clincher plate assembly and user manuals is 10 lbs. (4.5 kgs.).

Always use a high quality galvanized wire so the plating does not peel. Excessive peeling will cause clogging and the premature wear of many components. Use only specified wire gauge for .

2 sheets - 1/8” (3mm) .....25 gauge

NOTE: ALL PRODUCTS ARE MANUFACTURED BY DELUXE STITCHER.

## Specifications

### Weight

Shipping Weight	10 lbs (4.5 kg)
Box Dimensions	21" x 10" x 7" (53 x 25 x 18 cm)
Stitcher Head	
DB75VHDL	7 lbs (3.2 kg)

### Physical Dimensions

Height	8.5" (22 cm)
Width	3.5" (9 cm)
Depth	4.25" (11 cm)

### Stitching Capacity

DB75VHDL	Two Sheets to 1/8" (3 mm)*
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Wire Types	25 round
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### Stitcher Machine Compatibility

.....	Valore
.....	Minuteman
.....	Fox, 221, 235
.....	Bravo
.....	Presto, 300
.....	Prima, 331, 335

\*Actual stitching thickness capacity depends on the type of stock being stitched and the capacity of the saddle stitcher being used.

## Installation

### Pre-Inspection

Carefully inspect the condition of the shipping container before unpacking your replacement Head for Müller-Martini Stitchers. 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 head was purchased.

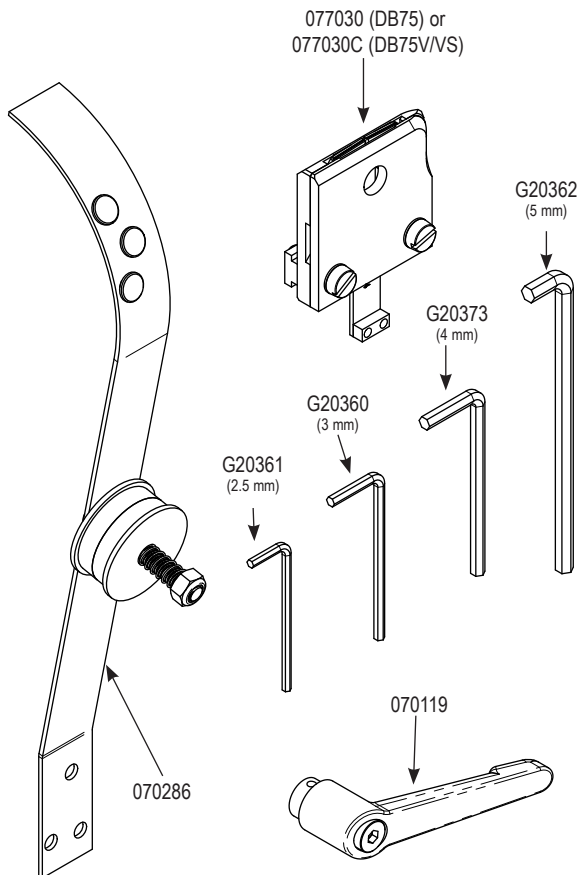


Figure 1 - Inspection

### Inspection (Figure 1)

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

- Replacement head for Müller Martini Stitchers: DB75HD, DB75VHD or DB75VSHD
- Wire guide spring [070286]
- Clincher plate assembly [077030 or 077030C]
- Feed release handle [070119]
- 2.5, 3, 4 and 5 mm hex key wrenches [G20361, G20360, G20373 and G20362]
- Stitch samples

### Mounting & Assembly (Figure 2-6)

#### Attaching the Feed Release Handle (Figure 2)

From out of the box, secure the **Feed Release Handle** [070119] to the stitcher head by slipping the handle over the **Feed Release Cam Assembly** [070118] and securing it with the provided screw, inserting it through the spring. Make sure the handle is angled toward the outside of the head when the screw is tightened.

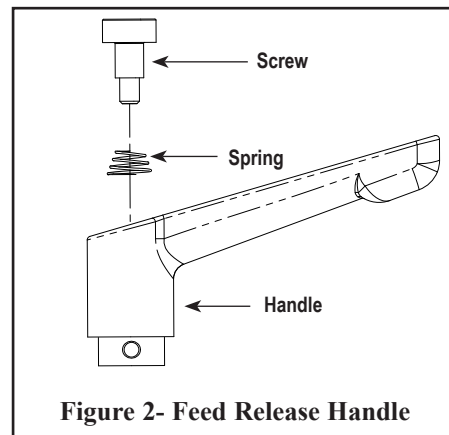
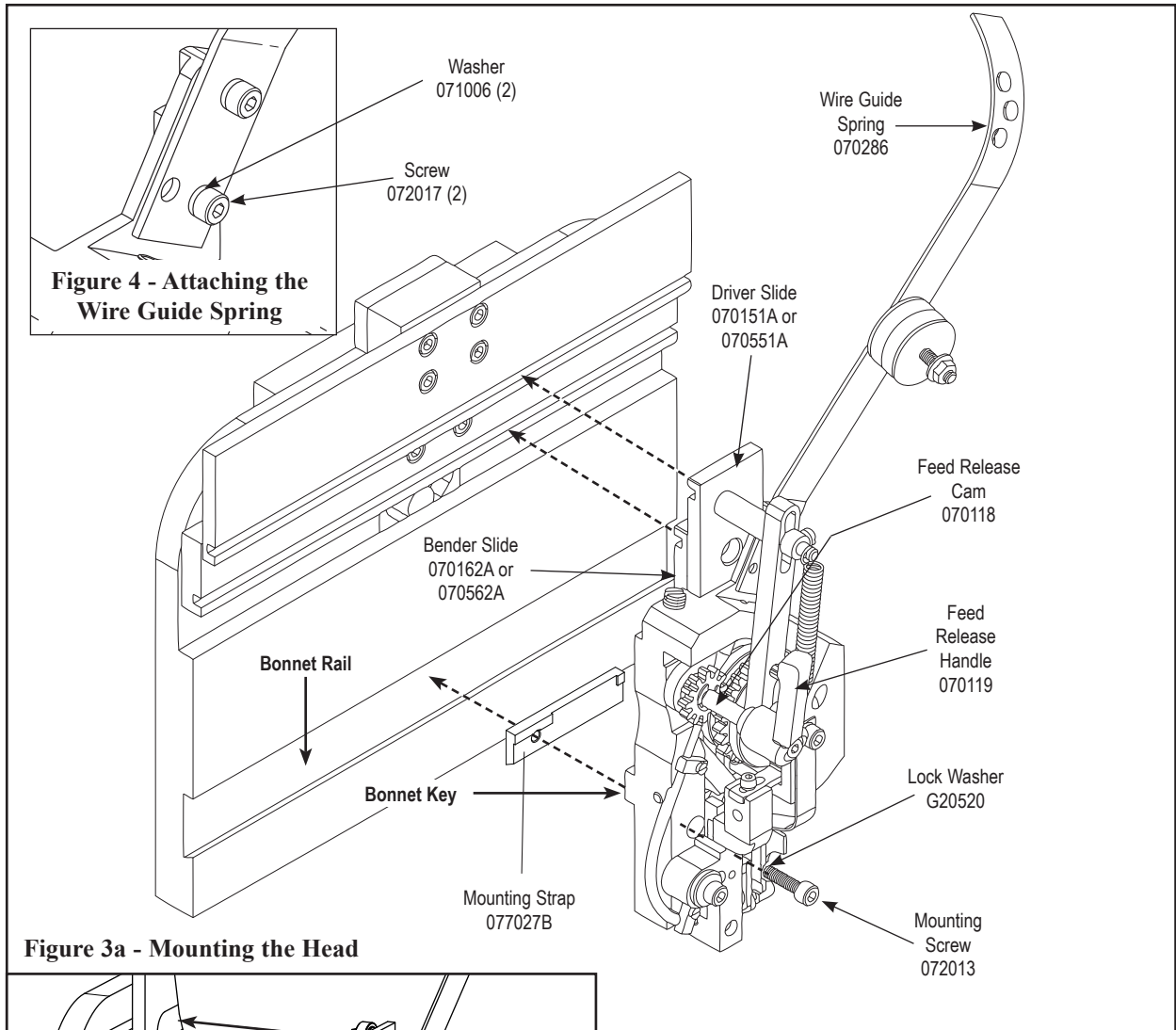
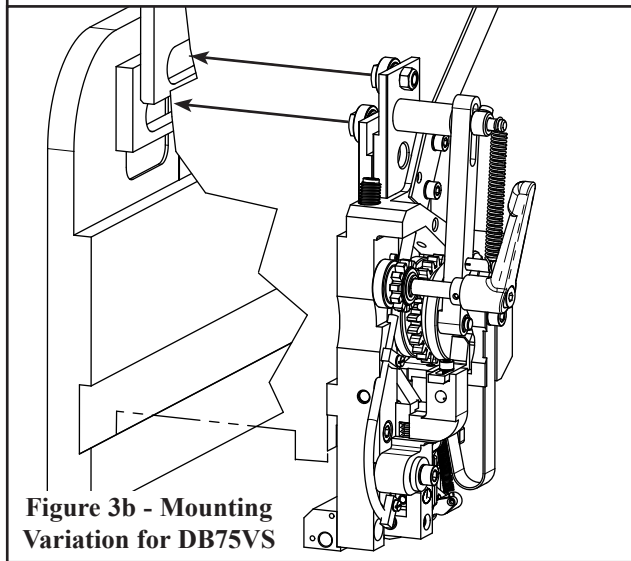


Figure 2- Feed Release Handle



**Figure 3a - Mounting the Head**



**Figure 3b - Mounting Variation for DB75VS**

**Mounting the Head ( See Figure 3)**

**Attaching the Wire Guide Spring (Figure 4)**



## Mounting the Clincher Plate (Figure 5 & 6)

Figure 5 - Mounting Clincher Plate Assembly

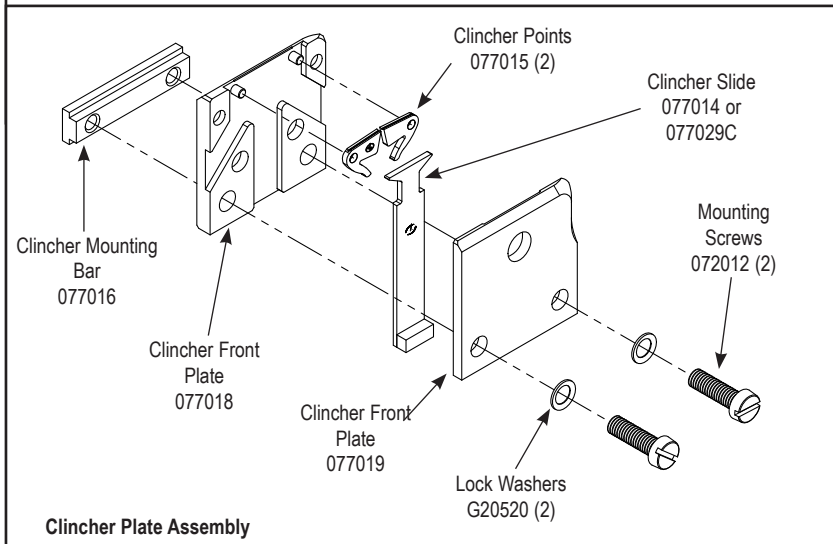
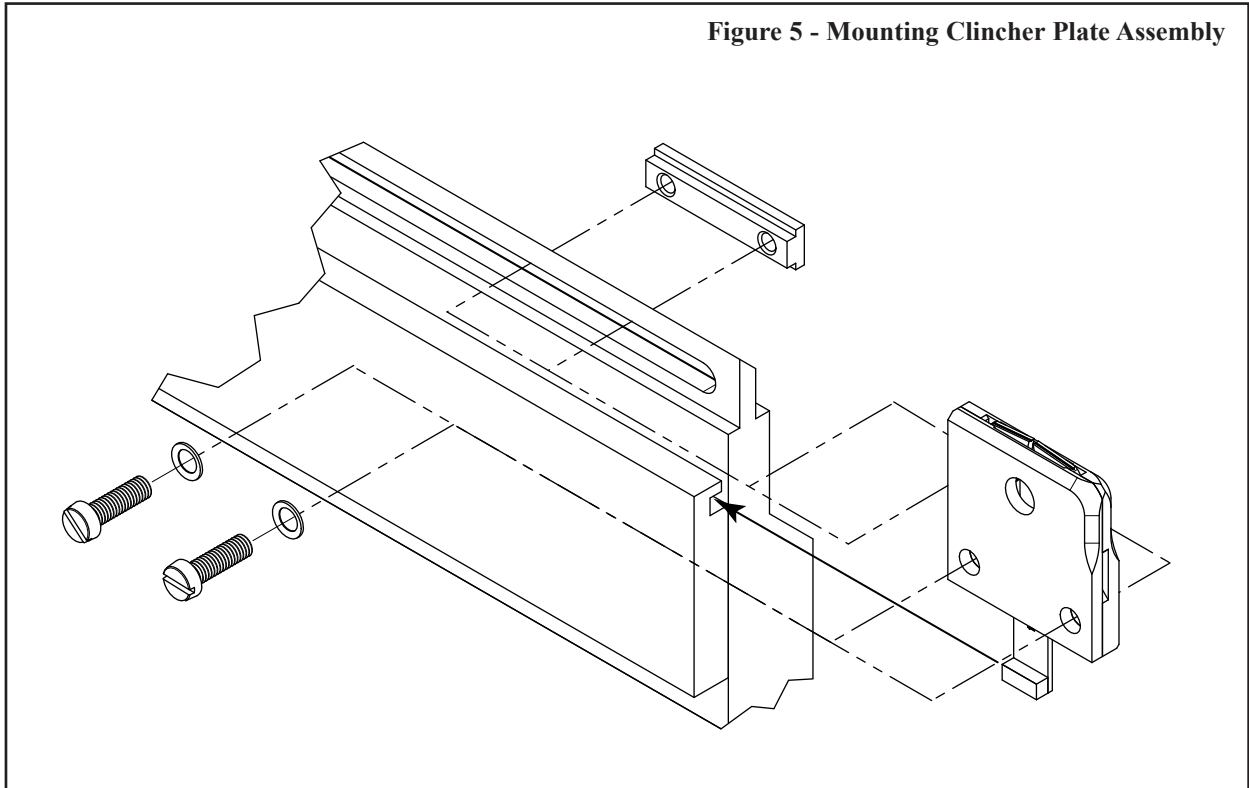
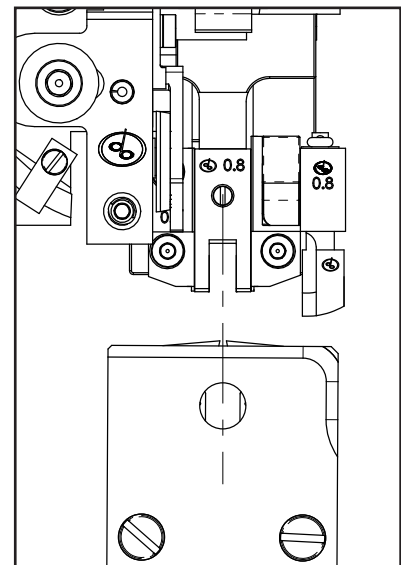


Figure 6 - Aligning Clincher Plate Assembly



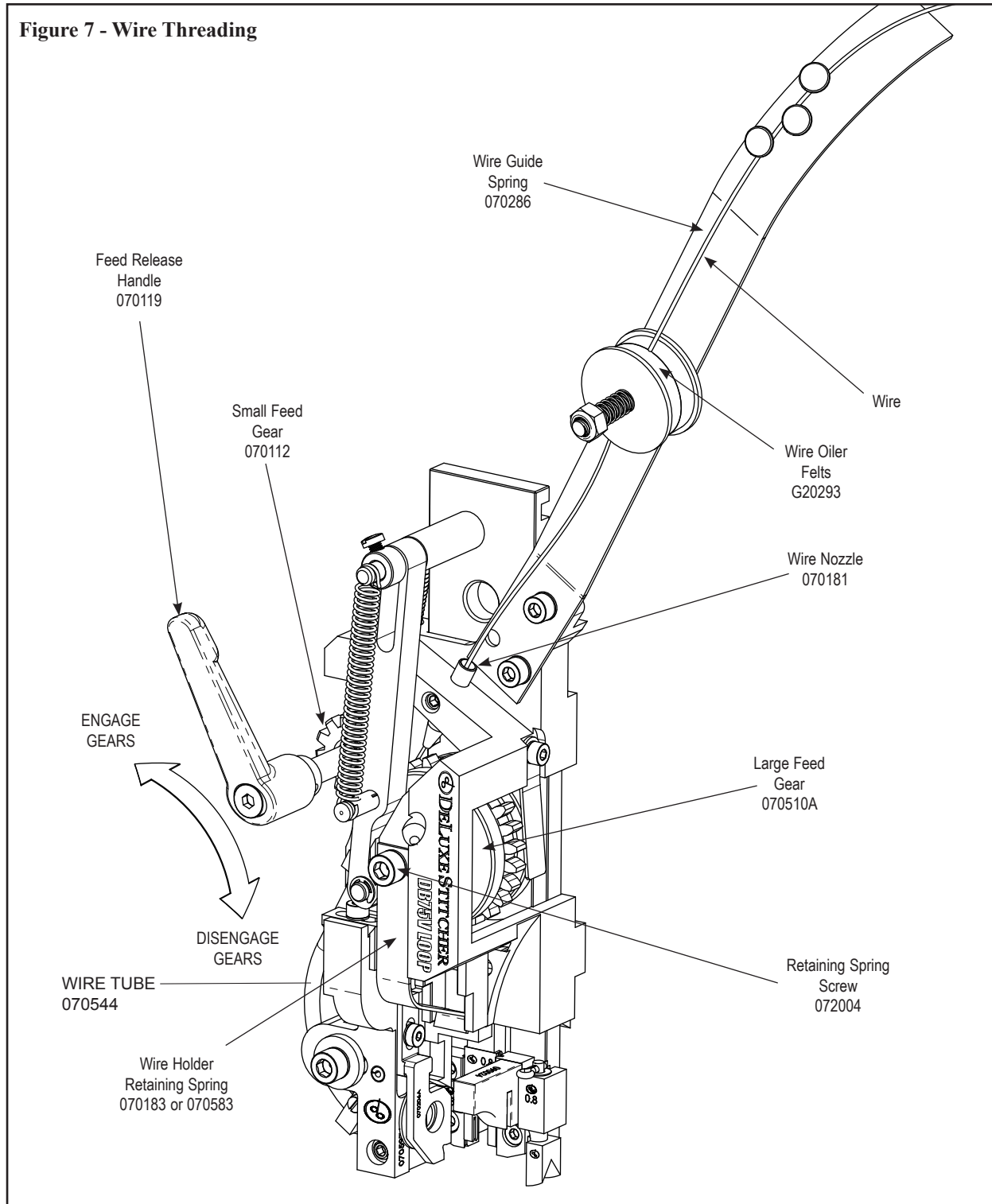
### CAUTION

Always disconnect the power before assembling or making adjustments to your stitcher machine.

# Operation

## Wire Threading (Figure 7-8)

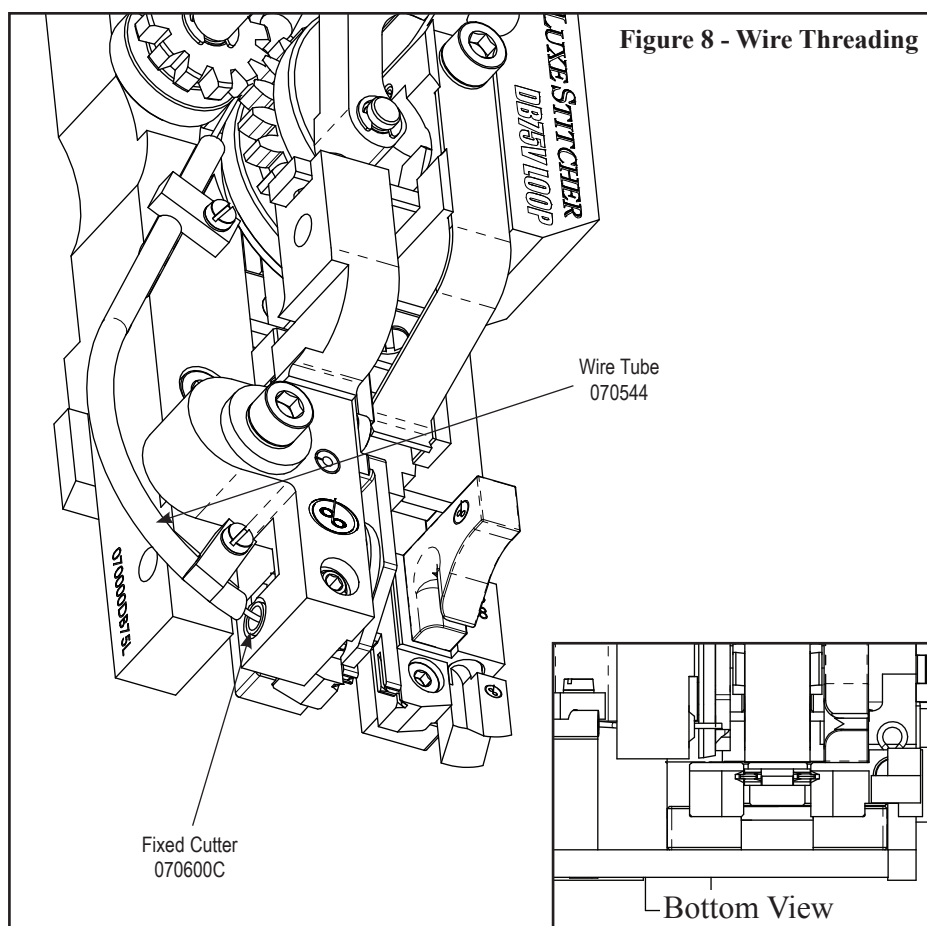
Figure 7 - Wire Threading



Before the Stitcher Machine is turned on, release the **Wire Holder Assembly** [070135A] (*Not shown-See Fig. 7*) secured by the **Wire Holder Retaining Spring** [070183 or 070583] by loosening the **Screw** [072004] on the front of the head. Thread the wire from the Spool under the studs on the **Wire Guide Spring** (070286), between the **Wire Oiler Felts** [G20293] on the Spring and into the **Wire Nozzle** [070181]. Turn the **Feed Release Handle** [070119] clockwise so that the **Small Feed Gear** [070112] is disengaged from the **Large Feed Gear** [070510A].

Continue to push wire through the Replacement Head until the end of the wire passes the Small and Large Feed Gears, enters the **Wire Tube** [070544] and begins to come out the bottom of the wire tube. Then using a small screw driver, wedge the wire up until it enters the **Fixed Wire Cutter** [070600C]. Engage the Small and Large Feed Gears by turning the **Adjustable Lever** counter-clockwise.

**Note:** It will take two full cycles for the proper length staple to come out of the head.



## Wire Straightening (Figure 9)

Once threaded, cycle the Stitcher Machine and watch the wire feeding out of the the **Cutter Box** [070197A or 070597A] to the right of the **Moving Cutter** [070145C]. The wire should be traveling in an approximate horizontal direction when exiting the Cutter Box.

### Top-to-Bottom Adjustment

If the wire is feeding in an upward or downward direction, the **Wire Straightener** [070206A] will have to be adjusted. Loosen the **Screw** [G20589] securing the Wire Straightener to the Cutter Box. If the wire is feeding in an upward direction, slide the Wire Straightener down slightly.

Conversely, if the wire is feeding in a downward direction, slide the Assembly up slightly. Make sure to tighten the Screw after every adjustment to see accurate results. Allow enough Wire to be fed through the Head so that an accurate assessment can be made. Make sure the ends of each cut piece of wire is free of burrs, which would negatively affect the driving and clinching of the formed Wire.

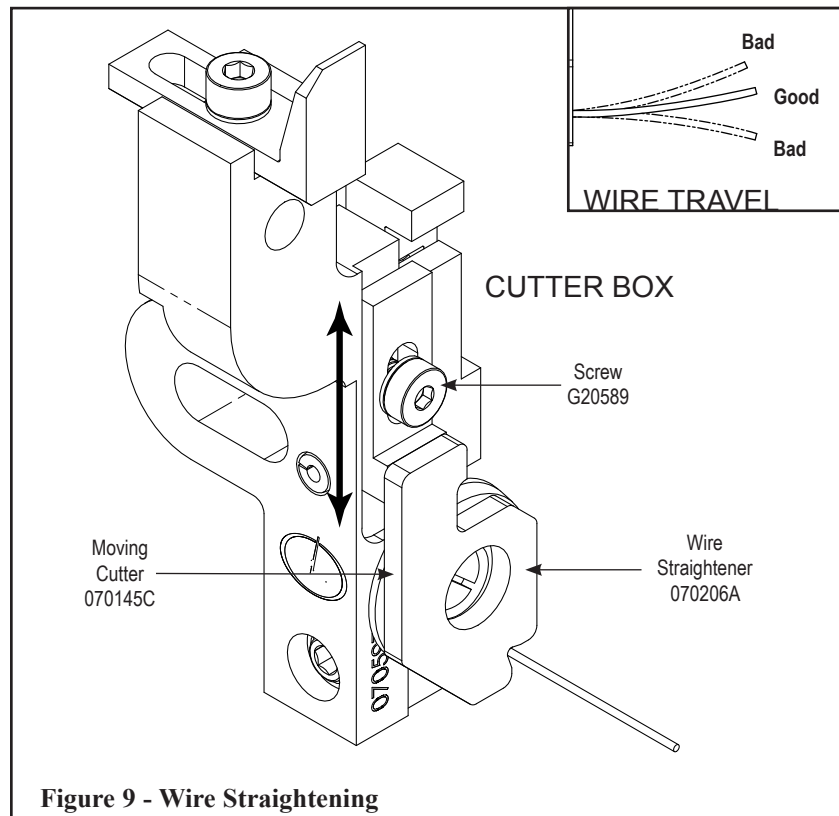


Figure 9 - Wire Straightening

Make sure the Wire Holder Assembly has been removed before tripping the Machine to avoid jams and the chipping of parts.

**⚠ WARNING**

## Adjusting the Length of the Right Leg (Figure 10-12)

### Setting the Stitch's Right Leg (& Setting It's Center)

If after a few stitches, the length of the stitch's right leg is too short or too long, you will need to make adjustments. Adjustments are always made to the right leg to compensate for the length of the left leg. First adjust the stitch's right leg to match the left and then make adjustments for the overall length of the stitch or wire draw.

Power off the Stitcher Machine and release the **Extension Spring** [074002] from the **Feed Gear Operating Lever Pin** [043002] on the Replacement Head. Disengage the Small Feed Gear from the Large Feed Gear by turning the **Feed Release Handle** [070119]. Push the **Feed Gear Operating Lever** [077001] down which will move the pin on the **Feed Gear Pinion** [070111A] out of the way of the **Feed Gear Stop** [077026]. Loosen, but do not remove, the **Screw** [G20589] securing the **Feed Gear Stop** to the top of the Cutter Box Assembly. If the legs of the stitch are not even, do one of the following:

If the right leg is too short, slide the **Feed Gear Stop** to the left slightly, to lengthen it.

If the right leg is too long, then adjust the **Feed Gear Stop** slightly to the right.

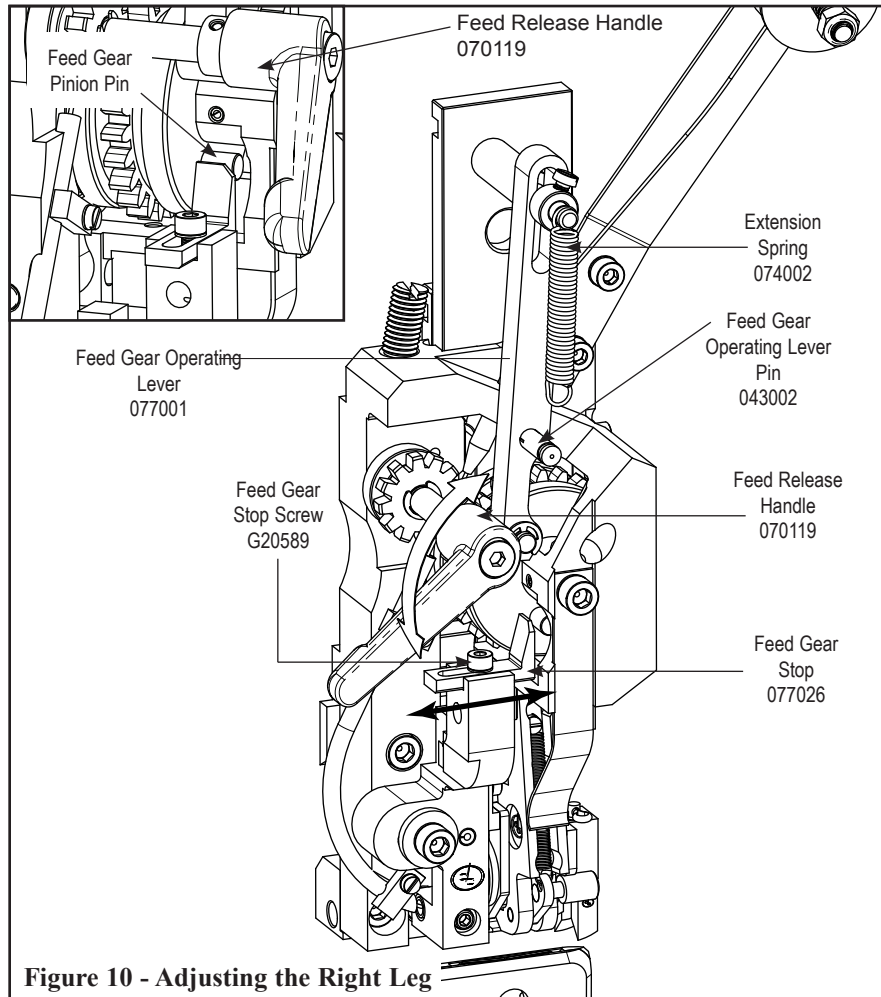
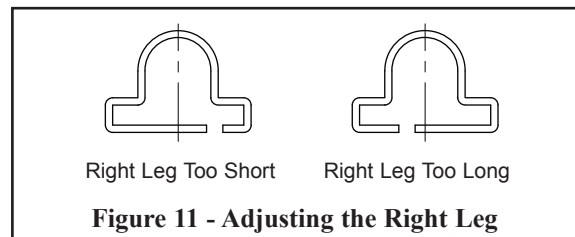


Figure 10 - Adjusting the Right Leg



Right Leg Too Short      Right Leg Too Long

Figure 11 - Adjusting the Right Leg

Always disconnect the power before assembling or making adjustments to your stitcher machine.

**CAUTION**

Power on the Stitcher Machine and jog the Stitcher to observe the length of the stitch's right leg after the initial adjustment. Continue to make adjustments and re-test the Head until the length of the stitch's right leg is satisfactory.

When set, any one of the stitches below are regarded as good stitches with the two on the left needing the next step in adjustment and the two on the right as properly set (with amount of gap a matter of preference).

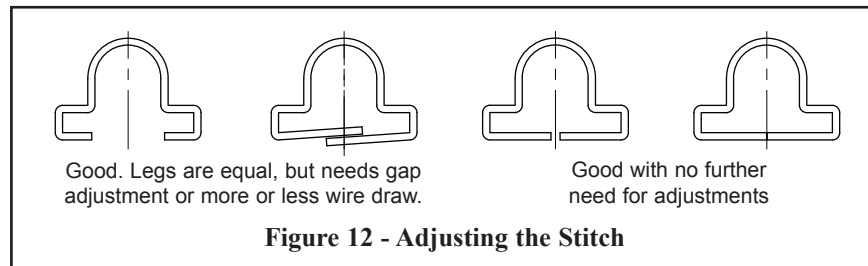


Figure 12 - Adjusting the Stitch

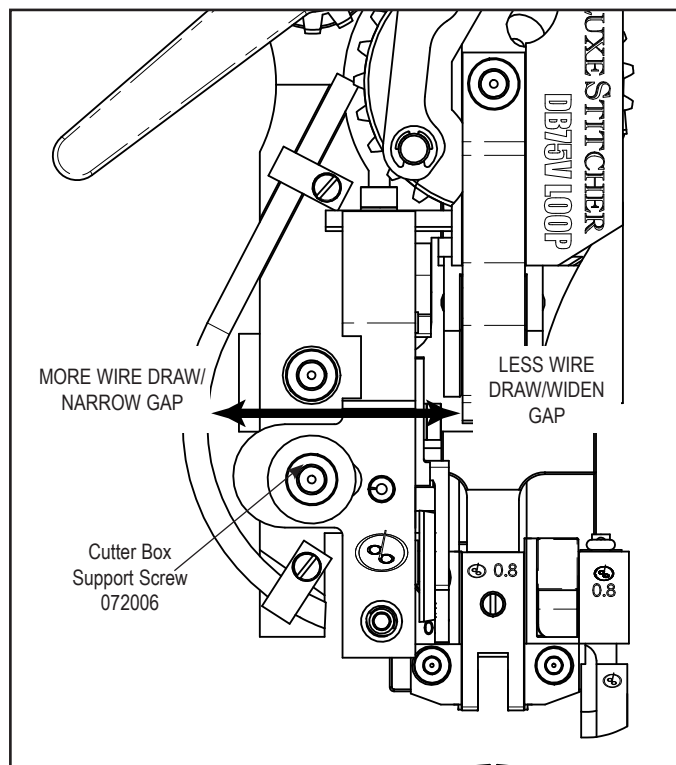
### Adjusting the Stitch Gap or Wire Draw (Figure 13)

#### Adjusting the Overall Length of the Stitch (Adjusting the Stitch Gap)

To change the overall length of the stitch, or more specifically to change the gap between the legs of the stitch, the position of the **Cutter Box** must be adjusted. Begin by releasing the **Extension Spring** from the **Feed Gear Operating Lever Pin**. Disengage the **Small Feed Gear** and the **Large Feed Gear** by turning the **Feed Release Handle**. Push the **Feed Gear Operating Lever** down which will move the pin on the **Feed Gear Pinion Pin** out of the way of the Feed Gear Stop. Loosen the **Screw [072006]** securing the Cutter Box to the Stitcher Head.

If the legs are too short, increase the overall length of the stitch's legs by sliding the Cutter Box to the left and if too long, to the right. Tighten the Screw, attach the Extension Spring and power on the Stitcher Machine. Trip the Stitcher to observe the overall length of the each stitch after the initial adjustment. Repeat as necessary.

Figure 13 - Adjusting the Stitch Gap



## Adjusting the Clincher Points (Figure 14)

If the clinch on the staple is not tight enough, the **Clincher Points** [077015] have to be raised. Conversely, if the clinch is too tight, the Clincher Points have to be lowered. This adjustment is made on the Stitcher Machine and so cannot be completely explained in this manual as each individual Machine is different.

The final position of the Clincher Points should be flush (or slightly above flush) with the Clincher Plates. The best way to see the position of the Clincher Points is to jog the Machine where the Stitcher Head is mounted. When the Driver is at the lowest position of its stroke, the Clincher Points are at their highest position. Jog the Stitcher Machine until the Stitcher Head is just past this point to reveal the Clincher Points' position. To be sure that the Points are at the best position possible, run a few test stitches and compare the clinched staples.

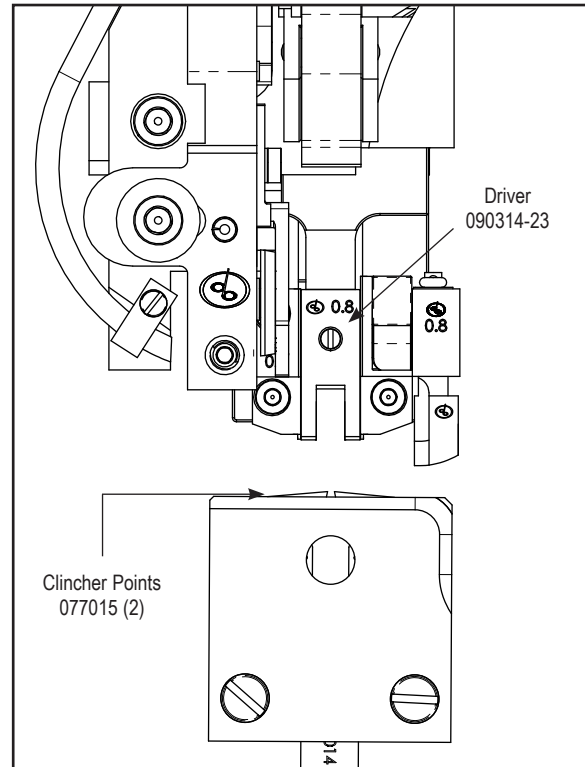


Figure 14 - Adjusting Clincher Points

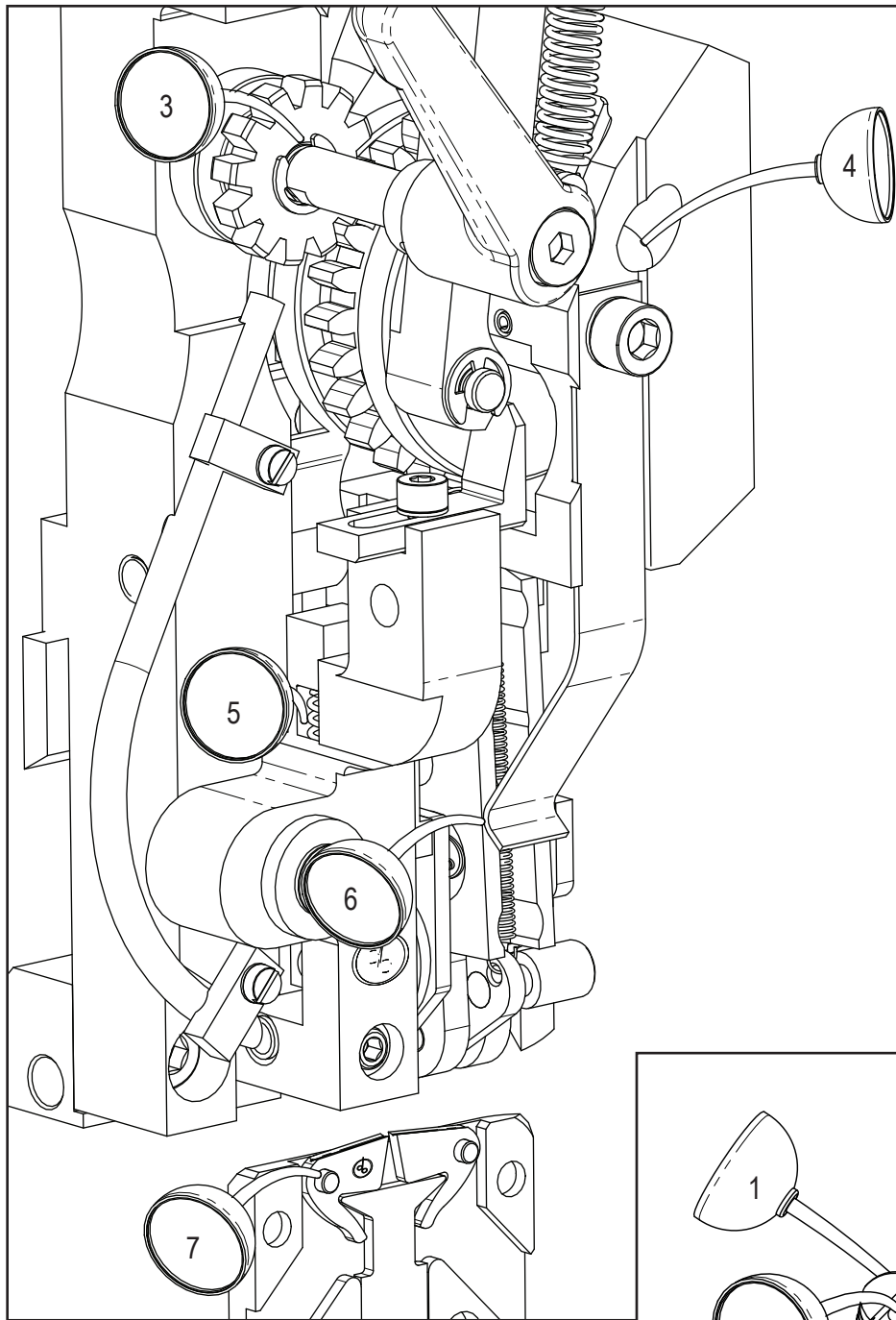
Always disconnect the power before assembling or making adjustments to your stitcher machine.

**CAUTION**

## Maintenance

### Lubrication (Figure 15)

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 lubrication will result in work becoming spotted with oil. Use one drop of oil in the following lubrication points:



1. At the top of the **Bonnet** [070000 or 070500] on either side of the **Driver Slide** [070551A or 070151A] and **Bender Slide** [070162A or 070562A].

2. In the hole of the **Feed Cam Plunger Bushing** [077010].

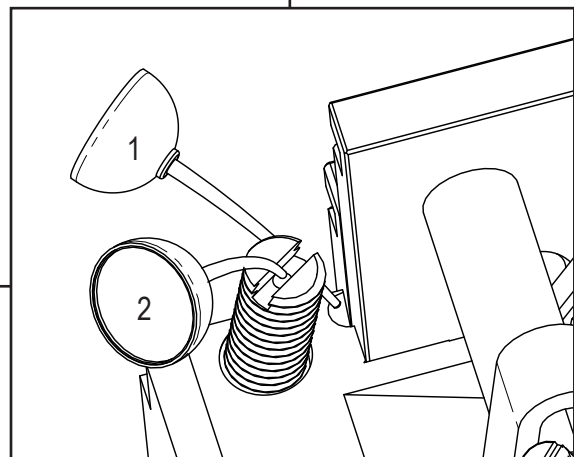
3. On the shaft of the **Feed Release Cam Assy.** [070118] in the front of the Small Feed Gear [070112]

4. The oil hole in the front of the Bonnet [090500] - this lubricates the **Clutch Bearing** located inside the Feed Gears

5. On the **Cutter Operating Lever** [070230] behind the

**Cutter Box** [070197A or 070597A].

6. In between the **Wire Holder Retaining Spring** [070183 or 070583] and the **Wire Holder** [070135A] and on the **Hook Pivot Pin** [073009] in the **Wire Holder** [070135A]



**Figure 15 - Lubrication and Cleaning**

7. On each of the **Clincher Point Pivot Pins** [077018-2] on the **Clincher Back Plate** [077018]



### Feed Gear Information (Figure 16)

Correct clutch assembly.

**CAUTION**  
Always disconnect the power cord before any maintenance is done or adjustments are made to the Müller Replacement Head

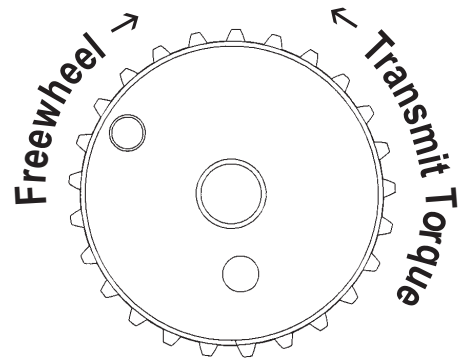
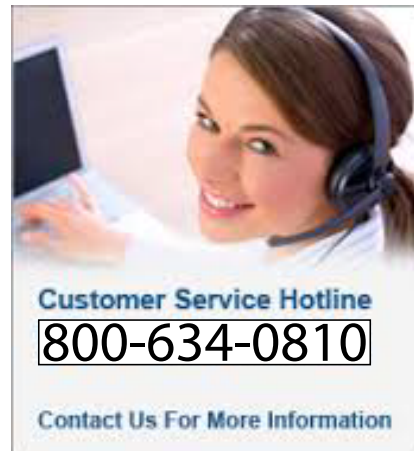
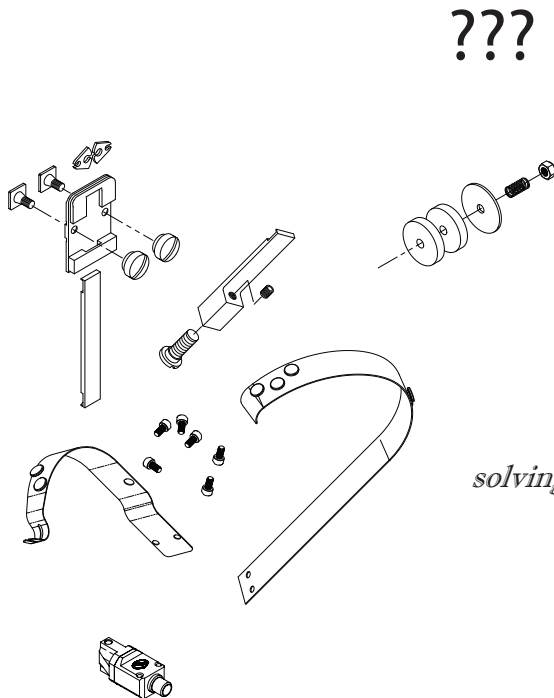


Figure 16 - Feed Gear Pinion Assy

### Ordering Spare Parts

In time, you will need to replace some parts in your DBS75LOOP 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,

## DELUXE STITCHER



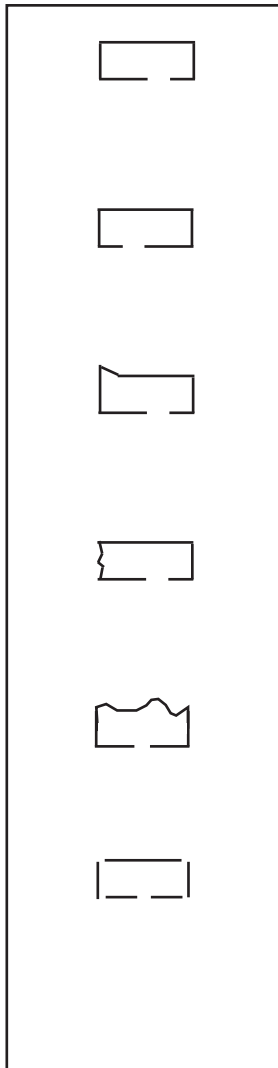
*solving your wire stitching needs for 125 years...*

## Troubleshooting (Figure 17)

The quality and quantity of work that can be produced with the Müller Replacement 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 DB style Stitching Heads.





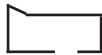
**PROBLEM:** Right Leg Short

**SOLUTION:** Move the Feed Gear Stop to the right, slightly.  
(See page 11)



**PROBLEM:** Right leg Long

**SOLUTION:** Move the Feed Gear Stop to the left, slightly.  
(See page 11)



**PROBLEM:** Corner Buckled

**SOLUTION:** Check the Driver for a chipped corner and rotate or replace it if needed. Use a heavier gauge wire.



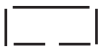
**PROBLEM:** Leg(s) Buckled

**SOLUTION:** Check the Wire Cutters and Wire Cutter Operating Slide for wear and rotate or replace if needed. Use a heavier gauge wire.



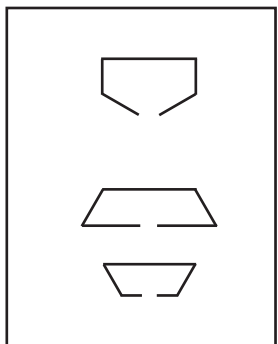
**PROBLEM:** Crown Buckled

**SOLUTION:** Check Supporter Spring tension on the Head. If it is too loose replace it.



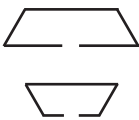
**PROBLEM:** Stitch in Pieces

**SOLUTION:** Clean and lubricate the Head. Check for hard or brittle wire and replace. Check the tension of the Wire Holder Spring and replace Spring if too loose. Look for wear in Wire Holder pivot point in Bonnet.



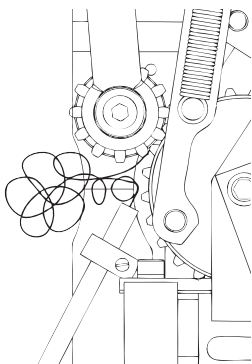
**PROBLEM:** Loose Clinch

**SOLUTION:** Raise the Clincher Points. (See page 15)



**PROBLEM:** Legs are Spread or Contracted

**SOLUTION:** Make sure the wire is feeding straight through the Head. (See page 10) Check the Wire Cutters for wear and rotate or replace if needed. Check the Formers for wear in the grooves and replace if needed.

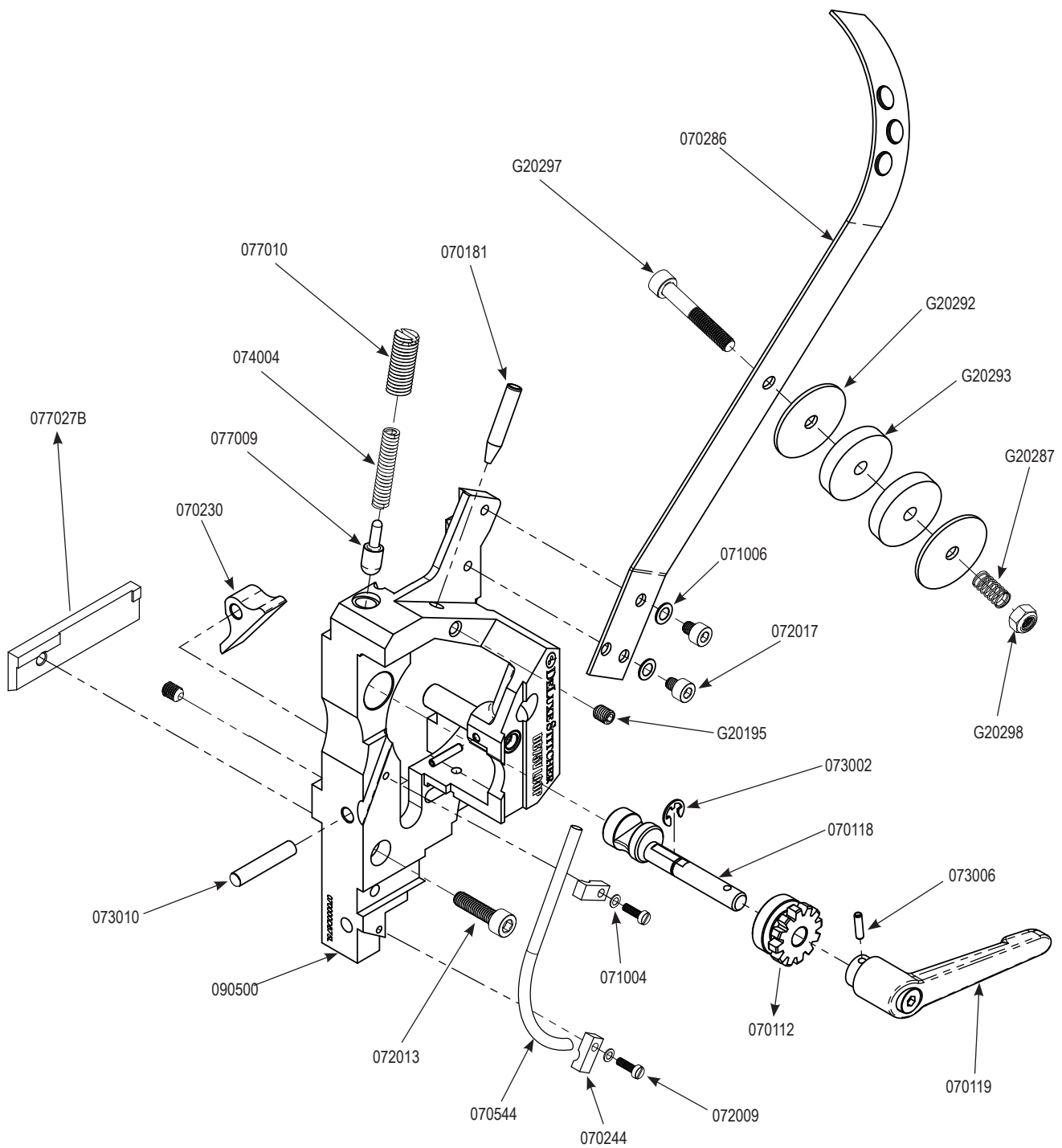


**PROBLEM:** Wire jam near Feed Gear

**SOLUTION:** Tighten Cutters. Check for the following worn parts and replace if necessary. Fixed Cutter, Moving Cutter, Cutter Operating Slide, Cutter Operating Lever, Bender Slide Insert, Wire Guide, Hook, Hook Pivot Pin and Feed Gear Friction Strip.

Figure 17 - Troubleshooting

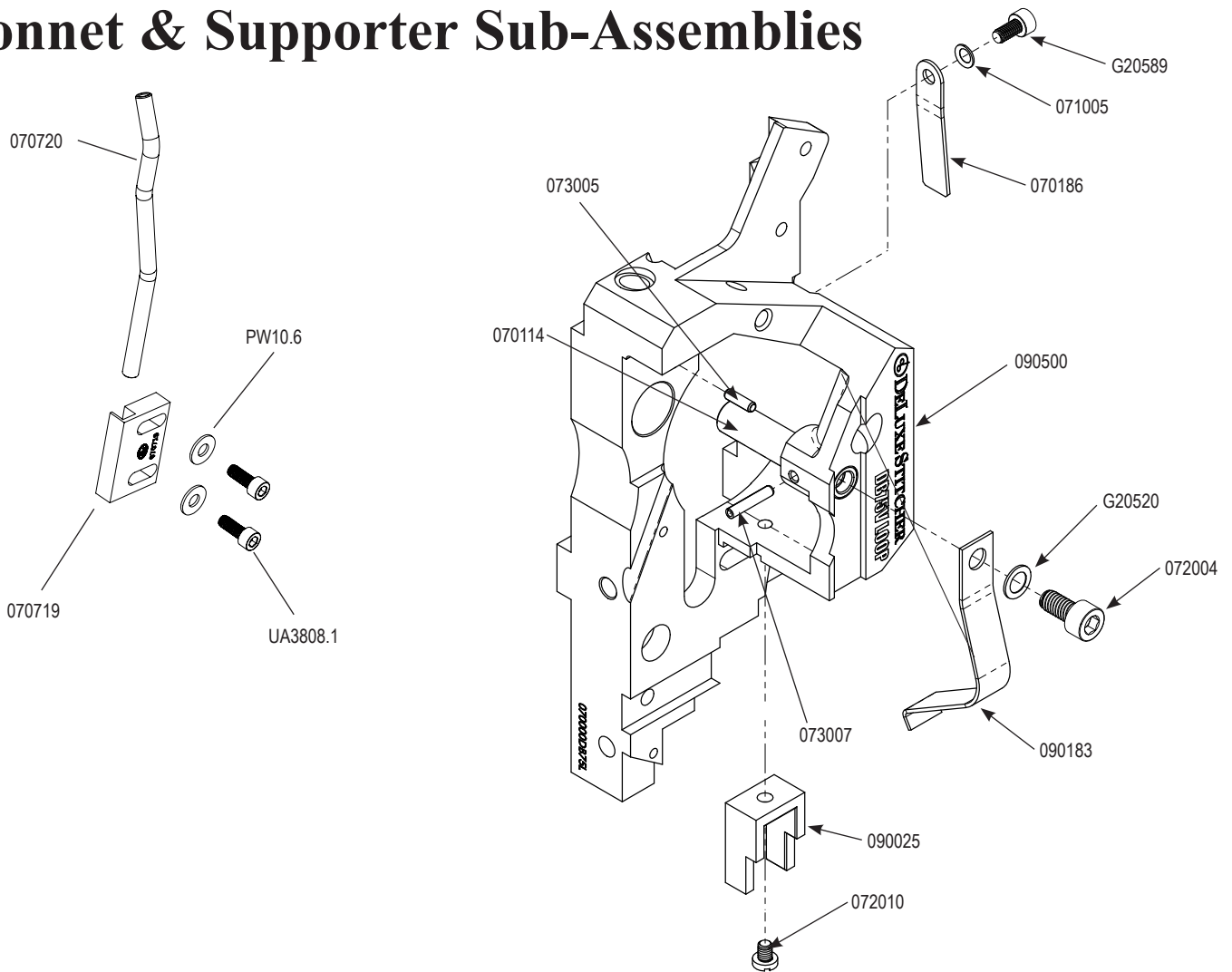
# Bonnet & Wire Guide Sub-Assemblies



# Bonnet & Wire Guide Sub-Assemblies

<b>DELUXE PART NUMBER</b>	<b>MÜLLER PART NUMBER CROSS REFERENCE</b>	<b>PART DESCRIPTION</b>	<b>QTY.</b>
070112	0881.0003.4	Feed Gear, Small	1
070118	0881.0018.4	Feed Release Cam Assembly	1
070119	0022.027	Feed Release Handle	1
070181	0881.0009.4	Upper Wire Tube	1
070230	0881.0006.4	Cutter Operating Lever	1
070244	0881.0043.4	Wire Tube Clamp	2
070286	0881.0301.3	Wire Guide Spring assembly	1
070544	0249.1014.4	Lower Wire Tube	1
071004	0031.5103	Lock Washer, Ribbed	2
072009	0030.3434	Screw M3x0.5x10	2
072013	0030.9001	Screw M6x1.0x22	1
072017	0881.0041.4	Screw M5x0.8x5.5	2
073002	0031.0759	E-Ring	1
073006	0031.6212	Spring Pin, M3x12	1
073010	0881.0030.4	Dowel Pin, M6x32	1
074004	0034.237	Compression Spring	1
077009	0881.0032.4	Feed Cam Plunger	1
077010	0881.0035.4	Feed Cam Plunger Bushing	1
090500	0249.1072.2	Bonnet	1
077027B	0881.0325.4	Mounting Strap, DB75V	1
G20195	0030.1725	Screw M6x1x8	2
G20287	0034.2254	Wire Oiler Felt Spring	1
G20292	0881.0302.4	Wire Oil Felt Washer	2
G20293	0881.0303.4	Wire Oiler Felt	2
G20297	0030.3494	Screw M6x1x40	1
G20298	0030.3494	Hex Nut M6x1	1

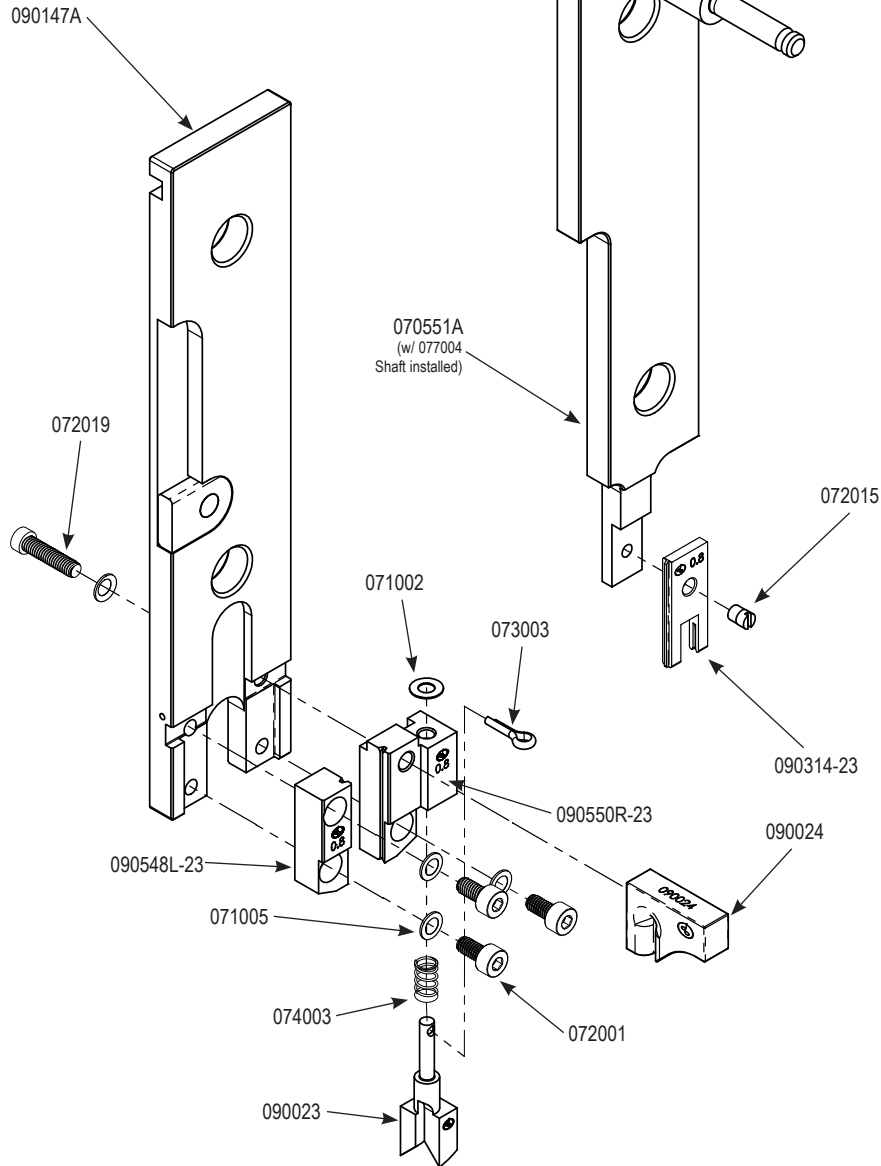
# Bonnet & Supporter Sub-Assemblies



## Bonnet & Supporter Sub-Assemblies

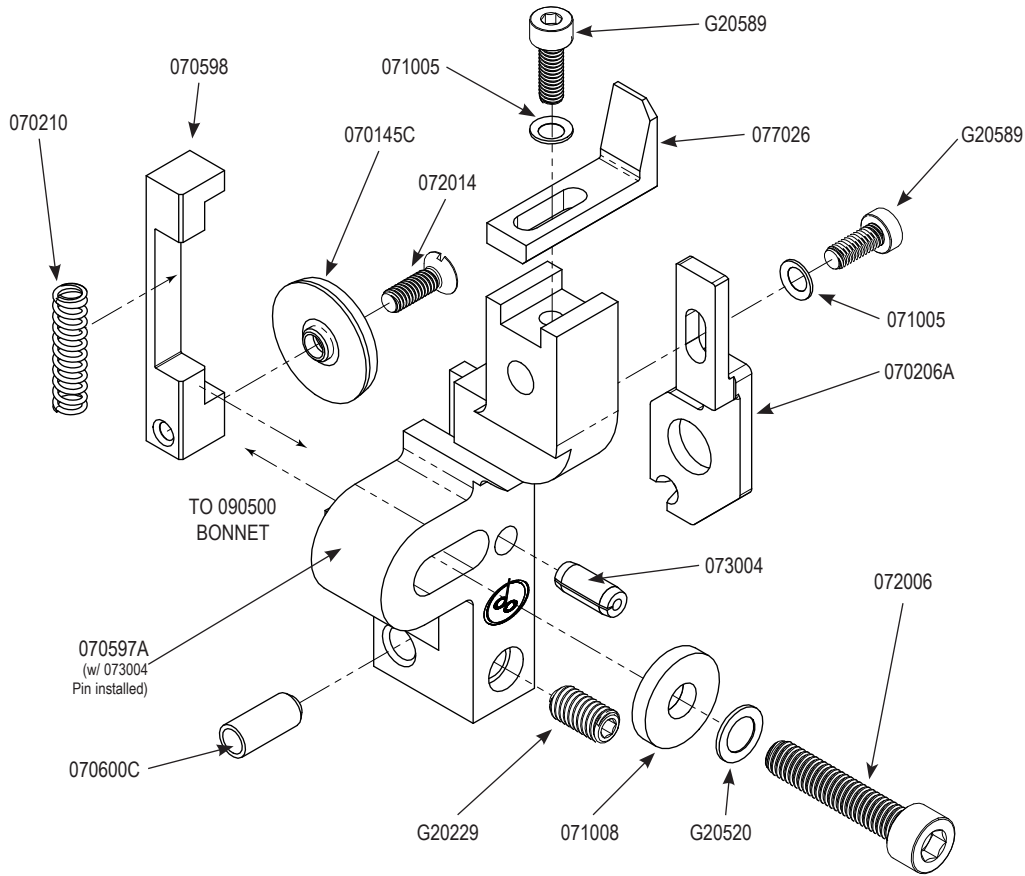
DELUXE PART NUMBER	MÜLLER PART NUMBER CROSS REFERENCE	PART DESCRIPTION	QTY.
070114	0881.0008.4	Feed Gear Shaft	1
070186	0034.6301	Friction Strip	1
070719	1509.1351.4	Tube Clamp	1
070720	1509.1352.3	Wire Guide Tube	1
071005	0031.5104	Lock Washer Ribbed, 4mm	1
072004	0030.0048	Screw M6x1.0x12	1
072010	0030.3447	Screw M4x0.7x5	1
073005	0031.631	Spring Pin, M3x10	1
073007	0031.6316	Spring Pin, M3x16	1
090025	0249.1086.4	Wire Holder Guide	1
090183	0249.1075.4	Wire Holder Retaining Spring	1
090500	0249.1072.2	Loop Bonnet	1
G20520	0031.0557	Lock Washer Ribbed, 6mm	1
G20589		SHCS m4x0.7x10mm, Nylon	1
PW10.6		Flat Washer #10	2
UA3808.1		Screw, 10-32x1/2 SHC	2

# Bender & Driver Inserts



DELUXE PART NUMBER	MÜLLER PART NUMBER CROSS REFERENCE	PART DESCRIPTION	QTY.
071002	0023.0931	Washer, Shim	1
071005	0031.5104	Lock Washer Ribbed, 4mm	4
072001	0030.0016	Screw M4x0.7x8	3
072015	0249.1054.4	Driver Retaining Screw	1
072019	0881.0318.4	Screw M4x0.7x16	1
073003	0031.5021	Cotter Pin	1
074003	0034.2152	Center Guide Spring	1
090023	0249.1088.4	Centering Guide	1
090024	0249.1052.4	Hook Guide	1
090314-23	0249.1058.3	Driver, 0.8mm	1
090548L-23	0249.1061.4	Former LH 0.8mm	1
090550R-23	0249.1062.3	Former RH 0.8mM	1
070551A	0249.1065.4	Driver Slide Assembly	1
090147A	0249.1063.4	Bender Slide Assembly	1

# Cutter Box Assembly



## Cutter Box Assembly

DELUXE PART NUMBER	MÜLLER PART NUMBER CROSS REFERENCE	PART DESCRIPTION	QTY.
070210	0034.2252	Cutter Box Spring	1
070598	0249.1073.4	Cutter Operating Slide	1
071005	0031.5104	Lock Washer Ribbed, 4mm	2
071008	0881.0323.4	Washer, M6 - Thick	1
072006	0030.0052	Screw M6x1.0x30	1
072014	0030.9016	Screw M4x0.7x12 LH	1
077026	0881.0324.4	Feed Gear Stop	1
070145C	0881.0197.4	Moving Cutter - Carbide	1
070206A	0249.1074.4	Wire Straightener Assembly	1
070597A	0881.322.4	Cutter Box Assembly	1
070600c	0881.0198.4	Fixed Cutter - Carbide	1
G20229	0030.1727	Screw M6x1x12	1
G20520	0031.0557	Lock Washer Ribbed, 6mm	1
G20589		SHCS m4x0.7x10mm, Nylon	2



# Feed Gear Assembly

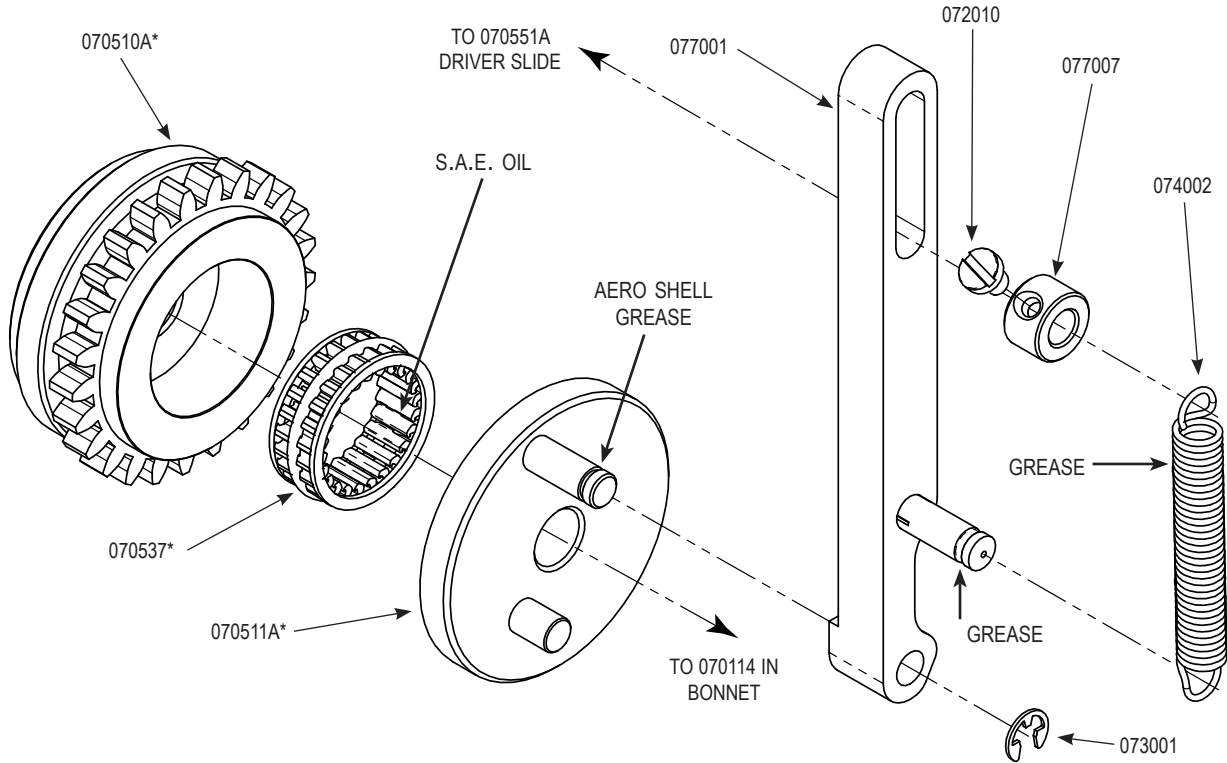
Replacement kit: **MMKFG2**  
 (for DB75V, DB75VL or DB75VS)

[ Also replaces Feed Gear Assy for HK75V or HK75VS]

0881.0304.4 (DB75V) or 0881.0368.4 (DB75)

Used together replaces 0881.0308.3

0881.0330.4



\* Indicates parts that are not interchangeable with Müller-Martini parts.  
 All parts used together can be used interchangeably with the HK75 or HK75V.

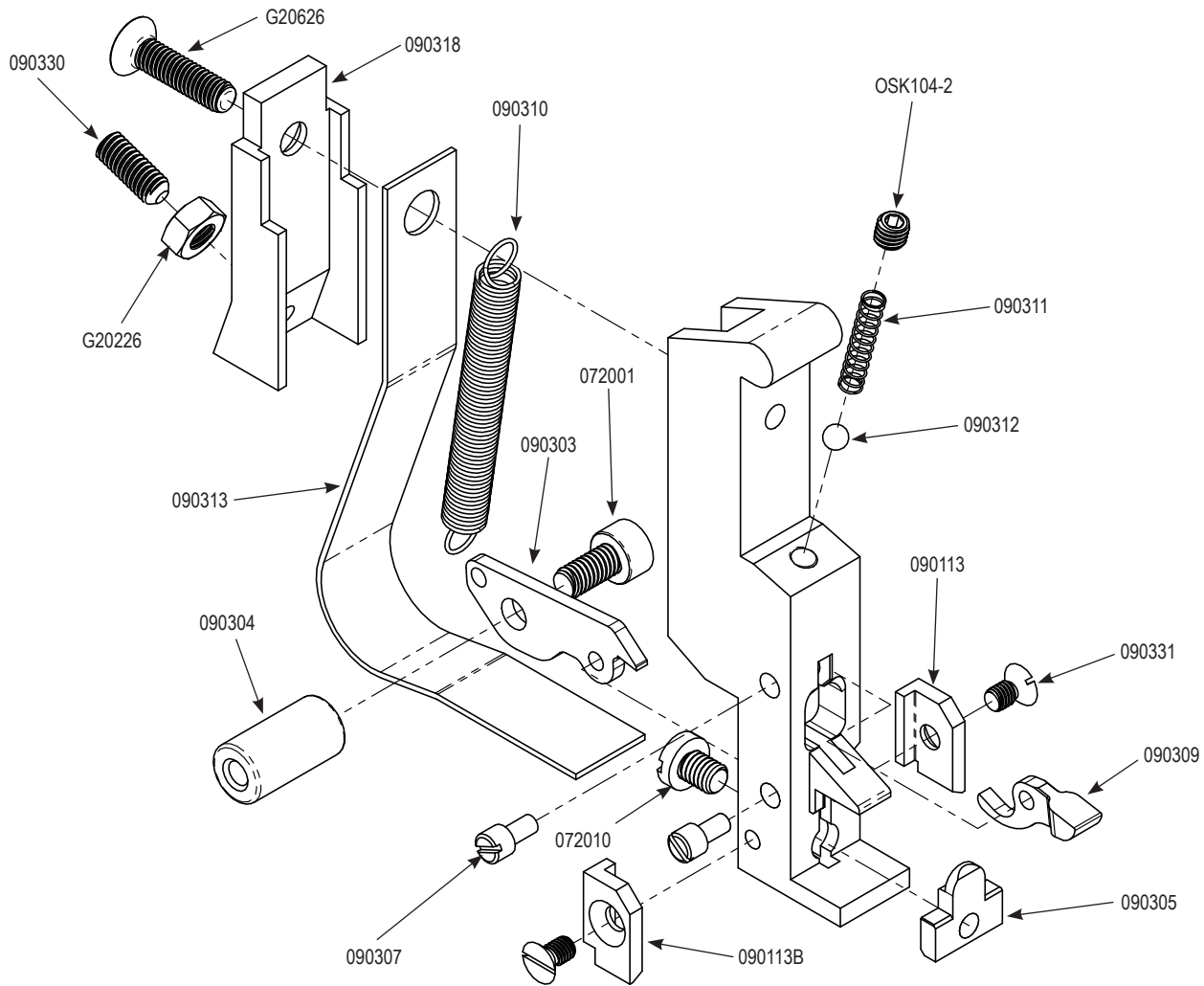
## Feed Gear Assembly

DELUXE PART NUMBER	MÜLLER PART NUMBER CROSS REFERENCE	PART DESCRIPTION	QTY.
072010	0030.3447	Screw M4x0.7x5	1
073001	0031.0757	E-Ring	1
074002	0034.0302	Extension Spring	1
077001	0881.001.4	Feed Operating Lever Assem.	1
077007	0881.0022.4	Set Collar	1

## MMKFG2 Kit - DB75V Feed Gear

070510A*	0881.0308.3DB	Feed Gear, Large	1
070511A*	0881.0304.4DB	Feed Gear Pinion Assembly	1
070537*	0881.0330.4DB	Feed Gear Clutch	1

# 090301A 0249.1079.3 Wire Holder

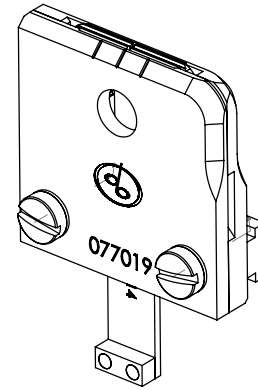
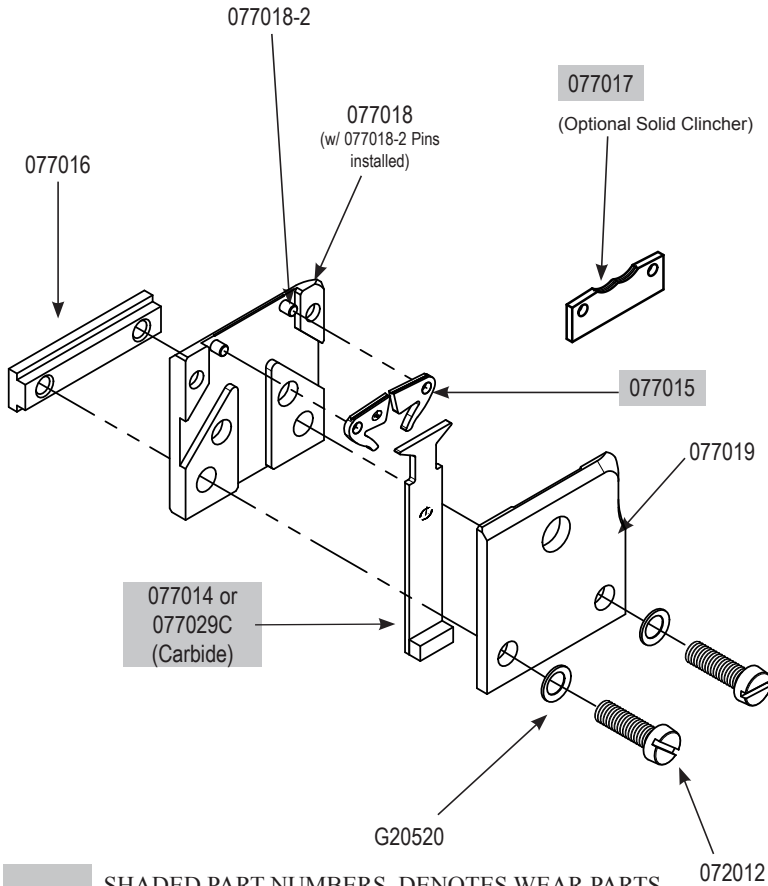


## 090301A 0249.1079.3 Wire Holder

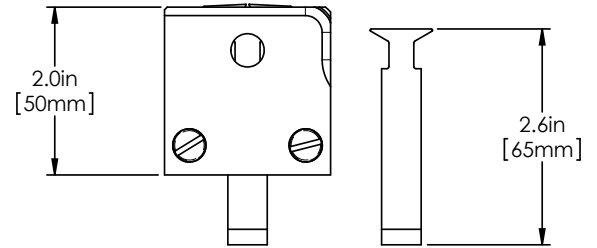
DELUXE PART NUMBER	MÜLLER PART NUMBER CROSS REFERENCE	PART DESCRIPTION	QTY.
072001	0030.0016	Screw M4x0.7x8	1
072010	0030.3447	Screw M4x0.7x5	1
090113		Supporter Guide - Right	1
090303	0249.1060.4	Wire Hook, Loop	1
090304	0249.1057.4	Hook Knob, Loop	1
090305	0249.1059.4	Anvil, Loop	1
090307	0249.1070.4	Hook Pivot Pin, Nylon	2
090309		Wire Holder Lever	1
090310	0034.0152	Hook Spring, Loop	1
090311		Lever Spring	1
090312		Wire Holder Lever Ball, Loop	1
090313	0249.1068.4	Supporter, Loop	1
090318	0249.1087.3	Supporter Bracket	1
090330		Screw M4x0.7x10, SHS	1
090331		Screw M3x0.5x5, FHM	2
090113B	0249.1068.4	Supporter GUIDE - LEFT	1
G20226		Hex Nut, M4x0.7	1
G20626		Screw, M4x0.7x16, FHM-Nylon	1
OSK104-2		Screw, M4x0.7x4, SHS	1

# Clincher Plate Assemblies

077030 or 077030C (Carbide)



077030 or 077030C (Carbide)



Standard Clincher Plate

SHADED PART NUMBERS DENOTES WEAR PARTS

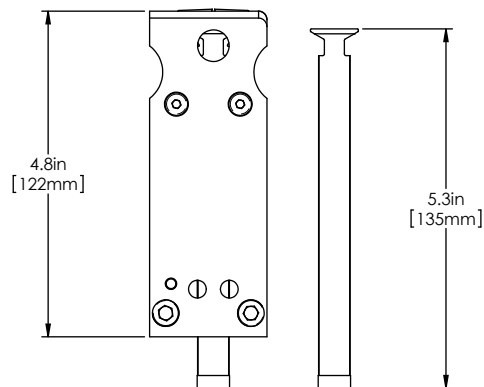
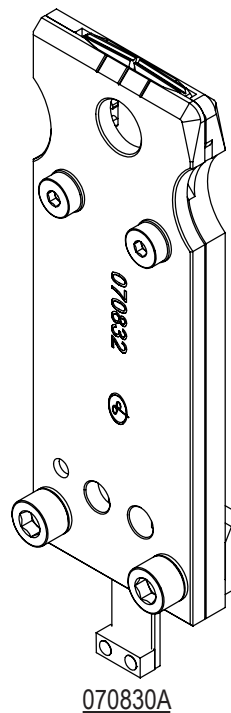
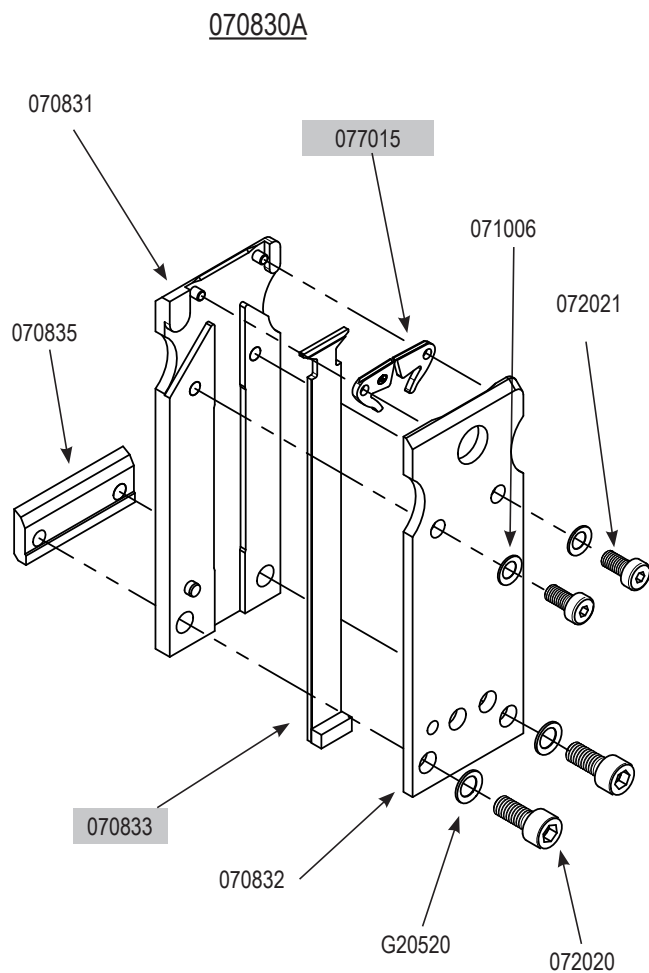
## 077030 0881.9050 Clincher Plate Assembly

DELUXE PART NUMBER	MÜLLER PART NUMBER CROSS REFERENCE	PART DESCRIPTION	QTY.
072012	0030.3488	Screw M6x1.0x20	2
077014	0881.0123.4	Clincher Slide Assembly	1
077015	0881.0125.3	Clincher Point 1/2"	2
077016	0881.0136.4	Clincher Mounting Bar	1
077017		SOLID CLINCHER (OPTIONAL)	
077018	0881.0141.3	Clincher Back Plate Assembly	1
077019	0881.0142.3	Clincher Front Plate	1
077029C	0881.0351.3	Clincher Slide Assy-CARBIDE	1
G20520	0031.0557	Lock Washer Ribbed, 6mm	2

## 077030C 0881.9050CAR Clincher Plate Assembly-CARBIDE

072012	0030.3488	Screw M6x1.0x20	2
077029C	0881.0351.3	Clincher Slide Assembly - Carbide	1
077015	0881.0125.3	Clincher Point 1/2"	2
077016	0881.0136.4	Clincher Mounting Bar	1
077018	0881.0141.3	Clincher Back Plate Assembly	1
077019	0881.0142.3	Clincher Front Plate	1
G20520	0031.0557	Lock Washer Ribbed, 6mm	2

# Clincher Plate Assemblies cont'd



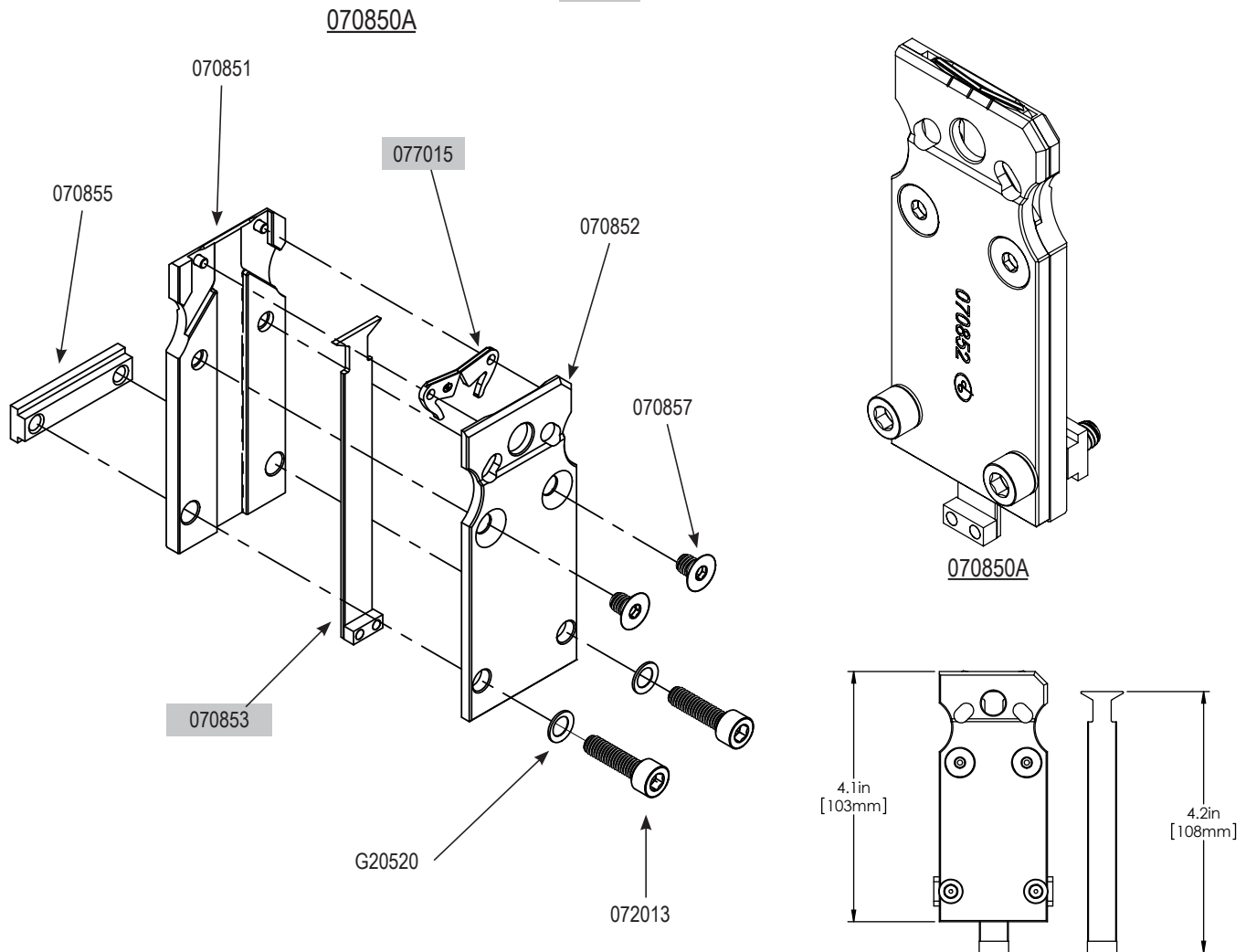
Used on Bravo/Prima machines  
After 2004, used on all Optima & Supra machines

## 070830A Clincher Plate Assembly-CARBIDE

DELUXE PART NUMBER	MÜLLER PART NUMBER CROSS REFERENCE	PART DESCRIPTION	QTY.
070831		Clincher Back Plate, Bravo	1
070832		Clincher Front Plate, Bravo	1
070833		Clincher Slide, Carbide, Bravo	1
070835		Clincher Mounting Bar, Bravo	1
071006	0031.5105	Lock Washer, Ribbed	2
072020		Screw, M6x1.0x14, SHC	2
072021		Screw, M5x0.8x10, SHC Low	2
077015	0881.0125.3	Clincher Point 1/2"	2
G20520	0031.0557	Lock Washer Ribbed, 6mm	2

# Clincher Plate Assemblies cont'd

SHADED PART NUMBERS DENOTES WEAR PARTS



Used on all Presto & Valore machines  
 Used on Minuteman (1509) machines built after  
 Jan. 2004

## 070850A Clincher Plate Assembly, Presto

DELUXE PART NUMBER	MÜLLER PART NUMBER CROSS REFERENCE	PART DESCRIPTION	QTY.
070851		CLINCHER BACK PLATE, PRESTO	1
070852		CLINCHER FRONT PLATE, PRESTO	1
070853		CLINCHER SLIDE ASSY., PRESTO	1
070855		CLINCHER MOUNTING BAR, PRESTO	1
070857		SCREW, M6x1.0x8, FHM	2
072013	0030.9001	SCREW M6x1.0x22	2
077015	0881.0125.3	CLINCHER POINT 1/2"	2
G20520	0031.0557	LOCK WASHER RIBBED, 6mm	2

# Notes:

## DeLuxe Stitcher / Müller Part Number Cross-Reference

070112	0881.0003.4	Feed Gear, Small	071002	0023.0931	Washer, Shim
070114	0881.0008.4	Feed Gear Shaft	071004	0031.5103	Lock Washer, Ribbed
070118	0881.0018.4	Feed Release Cam Assembly	071005	0031.5104	Lock Washer Ribbed, 4mm
070119	0022.0270	Feed Release Handle	071006	0031.5105	Lock Washer, Ribbed
070145C	0881.0197.4	Moving Cutter - Carbide	071008	0881.0323.4	Washer, M6 - Thick
070181	0881.0009.4	Upper Wire Tube	072001	0030.0016	Screw M4x0.7x8
070186	0034.6301	Friction Strip	072002	0030.0016	Screw M4x0.7x10
070206A	0249.1074.4	Wire Straightener Assembly	072003	0030.0018	Screw M4x0.7x12
070210	0034.2252	Cutter Box Spring	072004	0030.0048	Screw M6x1.0x12
070230	0881.0006.4	Cutter Operating Lever	072005	0030.0051	Screw M6x1.0x25
070244	0881.0043.4	Wire Tube Clamp	072006	0030.0052	Screw M6x1.0x30
070286	0881.0301.3	Wire Guide Spring	072009	0030.3434	Screw M3x0.5x10
070510A	0881.0308.3DB	Feed Gear, Large	072010	0030.3447	Screw M4x0.7x5
070511A	0881.0304.4DB	Feed Gear Pinion Assembly	072012	0030.3488	Screw M6x1.0x20
070537	0881.0330.4DB	Feed Gear Clutch	072013	0030.9001	Screw M6x1.0x22
070544	0249.1014.4	Lower Wire Tube	072014	0030.9016	Screw M4x0.7x12 LH
070548L-23	0881.0184.4	Former LH 22-24 Wire	072015	0249.1054.4	Driver Retaining Screw
070550R-23	0881.0185.4	Former RH 22-24 Wire	072017	0881.0041.4	Screw M5x0.8x5.5
070551A	0249.1065.4	Driver Slide Assembly	072019	0881.0318.4	Screw M4x0.7x16
070554	0881.0312.4	Supporter	072020		Screw, M6x1.0x14, SHC
070597A	0881.322.4	Cutter Box Assembly	072021		Screw, M5x0.8x10, SHC Low
070598	0249.1073.4	Cutter Operating Slide	073001	0031.0757	E-Ring
070600C	0881.0198.4	Fixed Cutter - Carbide	073002	0031.0759	E-Ring
070719	1509.1351.4	Tube Clamp	073003	0031.5021	Cotter Pin
070720	1509.1352.3	Wire Guide Tube	073004	0031.6039	Spring Pin, M5x12
070830A		Clincher Plate Assy., Carbide	073005	0031.6310	Spring Pin, M3x10
070831		Clincher Back Plate, Bravo	073006	0031.6212	Spring Pin, M3x12
070832		Clincher Front Plate, Bravo	073007	0031.6316	Spring Pin, M3x16
070833		Clincher Slide, Carbide, Bravo	073010	0881.0030.4	Dowel Pin, M6x32
070835		Clincher Mounting Bar, Bravo	074002	0034.0302	Extension Spring
070850A		Clincher Plate Assy., Presto	074003	0034.2152	Center Guide Spring
070851		Clincher Back Plate, Presto	074004	0034.2370	Compression Spring
070852		Clincher Front Plate, Presto	077001	0881.001.4	Feed Gear Operating Lever Assy
070853		Clincher Slide Assy., Presto	077004	0881.0019.4	Driving Slide Shaft
070855		Clincher Mounting Bar, Presto	077007	0881.0022.4	Set Collar
070857		Screw, M6x1.0x8, FHM	077009	0881.0032.4	Feed Cam Plunger

## DeLuxe Stitcher / Müller Part Number Cross-Reference

077015	0881.0125.3	Clincher Point 1/2"	090312		Wire Holder Lever Ball, Loop
077016	0881.0136.4	Clincher Mounting Bar	090313	0249.1068.4	Supporter, Loop
077017		Solid Clincher	090314-23	0249.1058.3	Driver, 0.8mm
077018	0881.0141.3	Clincher Back Plate	090318	0249.1087.3	Supporter Bracket
077019	0881.0142.3	Clincher Front Plate	090330		Screw M4x0.7x10, SHS
077026	0881.0324.4	Feed Gear Stop	090331		Screw M3x0.5x5, FHM
077027B	0881.0325.4	Mounting Strap, DB75V	090500	0249.1072.2	Bonnet
077029C	0881.0351.3	Clincher Slide - Carbide	090548L-23	0249.1061.4	Former LH 0.8mm
077030	0881.9050	Clincher Plate Assy	090550R-23	0249.1062.3	Former RH 0.8mm
077030C	0881.9050CAR	Clincher Plate Assy-Carbide	G20195	0030.1725	Screw M6x1x8
090023	0249.1088.4	Centering Guide	G20226		Hex Nut, M4x0.7
090024	0249.1052.4	Hook Guide	G20229	0030.1727	Screw M6x1x12
090025	0249.1086.4	Wire Holder Guide	G20287	0034.2254	Wire Oiler Felt Spring
090113		Supporter Guide - Right	G20292	0881.0302.4	Wire Oil Felt Washer
090113B		Supporter Guide - Left	G20293	0881.0303.4	Wire Oiler Felt
090147A	0249.1063.4	Bender Slide Assembly	G20297	0030.3494	Screw M6x1x40
090183	0249.1075.4	Wire Holder Retaining Spring	G20298	0030.3494	Hex Nut M6x1
090301A	0249.1079.3	Wire Holder Assembly	G20360		Hex Key Wrench 3.0mm
090301B	0249.1071.3	Wire Holder	G20361		Hex Key Wrench 2.5mm
090303	0249.1060.4	Wire Hook, Loop	G20362		Clamp Wrench 5.0mm
090304	0249.1057.4	Hook Knob, Loop	G20373		Hex Key Wrench 4.0mm
090305	0249.1059.4	Anvil, Loop	G20520	0031.0557	Lock Washer Ribbed, 6mm
090307	0249.1070.4	Hook Pivot Pin, Nylon	G20626		Screw, M4x0.7x16, FHM-Nylon
090309		Wire Holder Lever	MMKFG2	(See page 28)	Müller Feed Gear Kit
090310	0034.0152	Hook Spring, Loop	OSK104-2		Screw, M4x0.7x4, SHS
090311		Lever Spring	PW10.6		Flat Washer #10
			UA3808.1		Screw, 10-32x1/2 SHC



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

## PRODUCT

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Dealer Name : \_\_\_\_\_  
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Serial Number(s) : \_\_\_\_\_  
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Serial Number(s) : \_\_\_\_\_  
Head(s) Purchased : \_\_\_\_\_  
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## Common Replacement Parts for 1/2" Crown

Below is a list of the most common wear/replacement parts for the DB75 and 75V 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 47 - 48.

Description	Item Number
Moving Cutter - Carbide	070145C
Driver (DB75) - 25-28	090314-23
Wire Holder Retaining Spring	090183
Cutter Operating Lever	070230
Fixed Cutter - Carbide	070600C
Moving Cutter Screw	072014
Driver Retaining Screw	072015
Hook Pivot Pin	090307
Wire Holder Spring	090310
Hook Guide	090024
Bender Slide Insert	077012
Clincher Slide Assembly	077014
Clincher Point 1/2"	077015
Clincher Point Pivot	077018-2

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# LIMITED WARRANTY

DeLuxe Stitcher Company, Inc. 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.



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