

DELUXE STITCHER

C O M P A N Y I N C .

Head Serial Number : _____

Date Purchased : _____

Where Installed: _____

(make/model of machine)

G8 Stitcher Head

OPERATION AND MAINTENANCE MANUAL

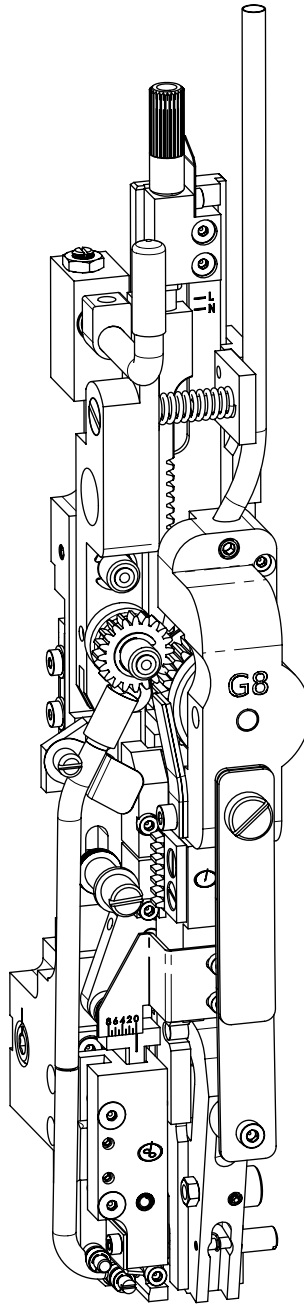
Wire Sizes: 23-28 Ga. Round, 20x24 and 21x25 Flat

Crown Size: 1/2" (13.5 mm)

Capacity: 2 sheets to 5/16" (8 mm) Standard

2 sheets to 5/32" (4 mm) Loop

Before using this Stitcher Head, all operators must study this manual and follow the safety warnings and instructions. Keep these instructions with the G8 Stitcher Head for future reference. If you have any questions, contact your local DeLuxe Stitcher Company Graphic Arts Representative or Distributor.



Thank you for choosing the
G8 STITCHER HEAD
for your binding needs.

WARNING!

G8 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.

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Introduction

Typical Style Uses:

G8BHD No. 2 and M2 Wire Stitchers
G8MHD No. 17 and M17 Wire Stitchers
G8HD Automatic Saddle-Stitchers,
 Gang-Stitchers, Multibinders and Others

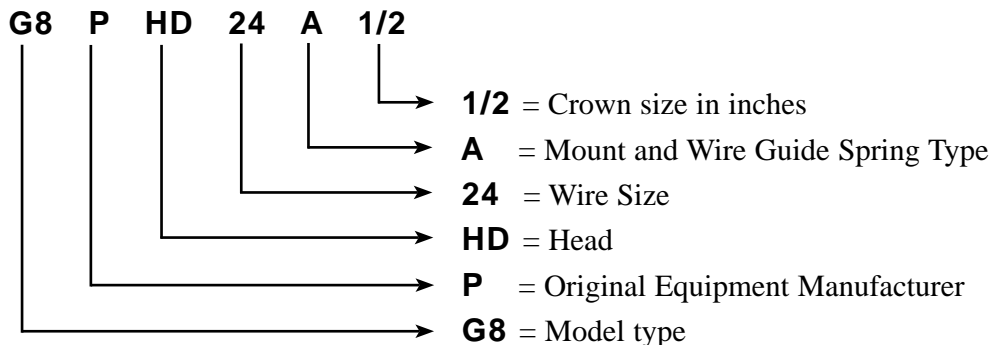
Examples of Replacement Heads for OEM Users*:

AM Graphics / Harris / Heidelberg / Sheridan 455, 562, 690	G8HD24A
AM Graphics / Harris / Heidelberg / Sheridan 705	G8HD24A
C.P. Bourg	G8HD24D
Christensen	G8HD24A
Horizon SP, SPF	G8HD24D
Macey Multibinder	G8HD24B
McCain	G8HD24A
Rosback	G8HD24B
Boewe 4601	G8BOHD241/2
McCain / OmegaBinder.....	G8HD23A
Harris 855	G8HD24-HARRIS
McCain / Sheridan / Harris / Bielomatik, ECH Will \ et.al.....	G8HDC24A
Heidelberg ST100, ST270, ST300, ST350.....	G8HEHD241/2
JMZ&A (Parker)	G8PKHD241/2
Watkiss	G8WAHD241/2

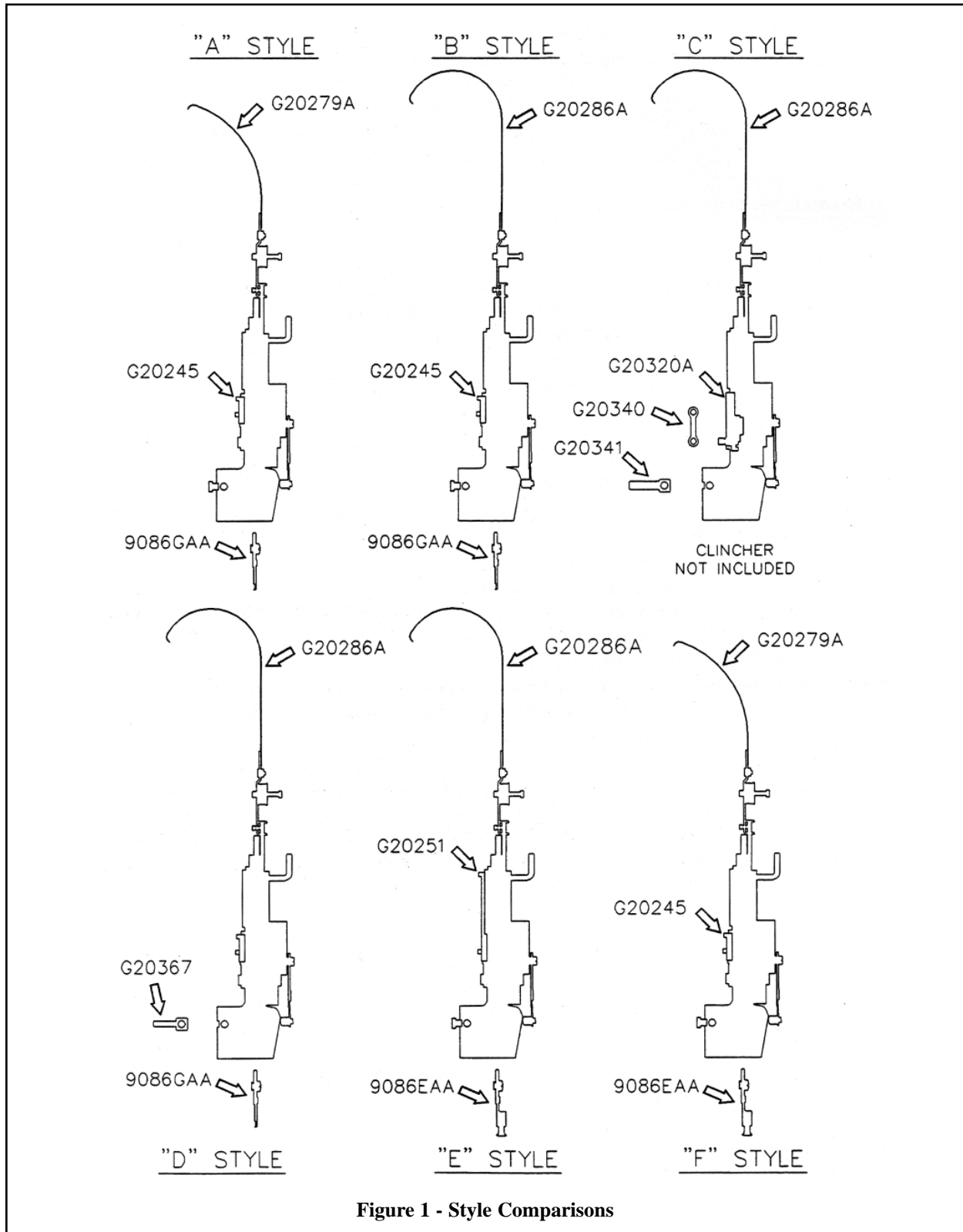
* These are just a few examples of the replacement heads available for these OEM's.

Part Number Definition

The part number for each Stitcher Head can be used to define the stitcher head itself, in most cases. The Head's model type, mounting style, nominal wire size and crown size can all be determined from the part number.



Some Head Style Examples



Specifications

Weight

Shipping Weight 11 lbs (5 kg)

Box Size 21 x 10 x 7

Physical Dimensions

Height 13-9/16" (345 mm)

Width 2-3/4" (70 mm)

Stitching Capacity Two Sheets to 5/16" (8 mm)

..... Two Sheets to 5/32" (4 mm) Loop

(Stitching capacities are highly dependent on wire and paper type, tensile strength and machine capacity.)

Wire Types 23 through 28 round or

..... 20x24 and 21x25 flat

..... (24 gauge round standard)

..... 25 gauge only for Loop

Crown Sizes 17/32" (13mm)

..... 13/64" (5mm) Loop

Minimum Head Centers

..... 2-3/64" (52mm) at two sheets to

..... 1/16" (1.5mm) material thickness

..... loop = 56mm at two sheets to 2mm

Stitches Per Hour 20,000 or 12,000 with Loop Head

Replacement for: Interlake/Acme/Champion/

..... Magnatek/M2000 heads,

..... 26/26D Model Heads, or Hohner

..... 52/8, 55/7, 43/6 and 48/5 Heads

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

 **WARNING**

Dimensions

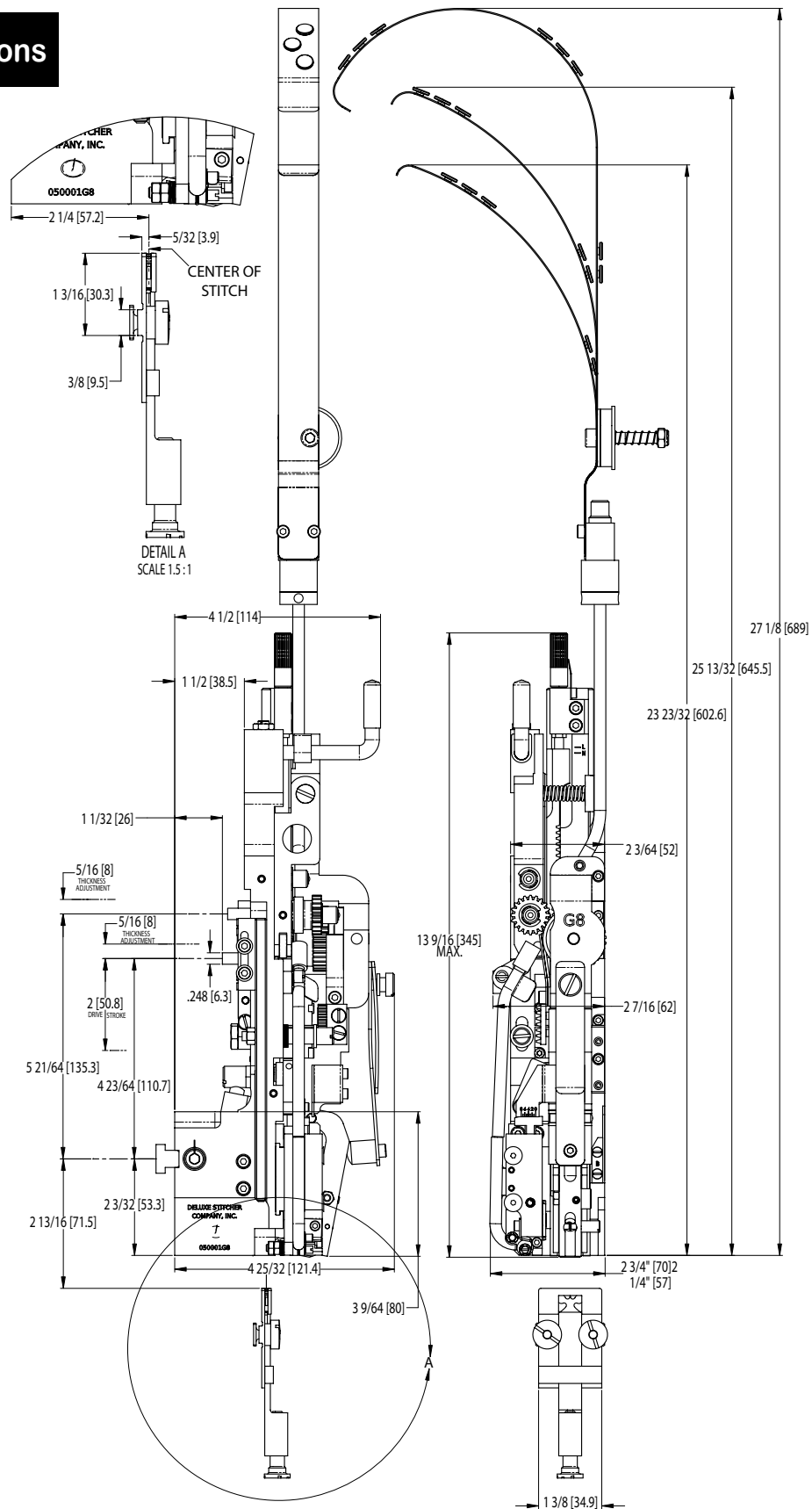


Figure 1

Installation

Pre-Inspection

Carefully inspect the condition of the shipping container before unpacking your G8 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 G8 Stitcher Head was purchased.

Inspection

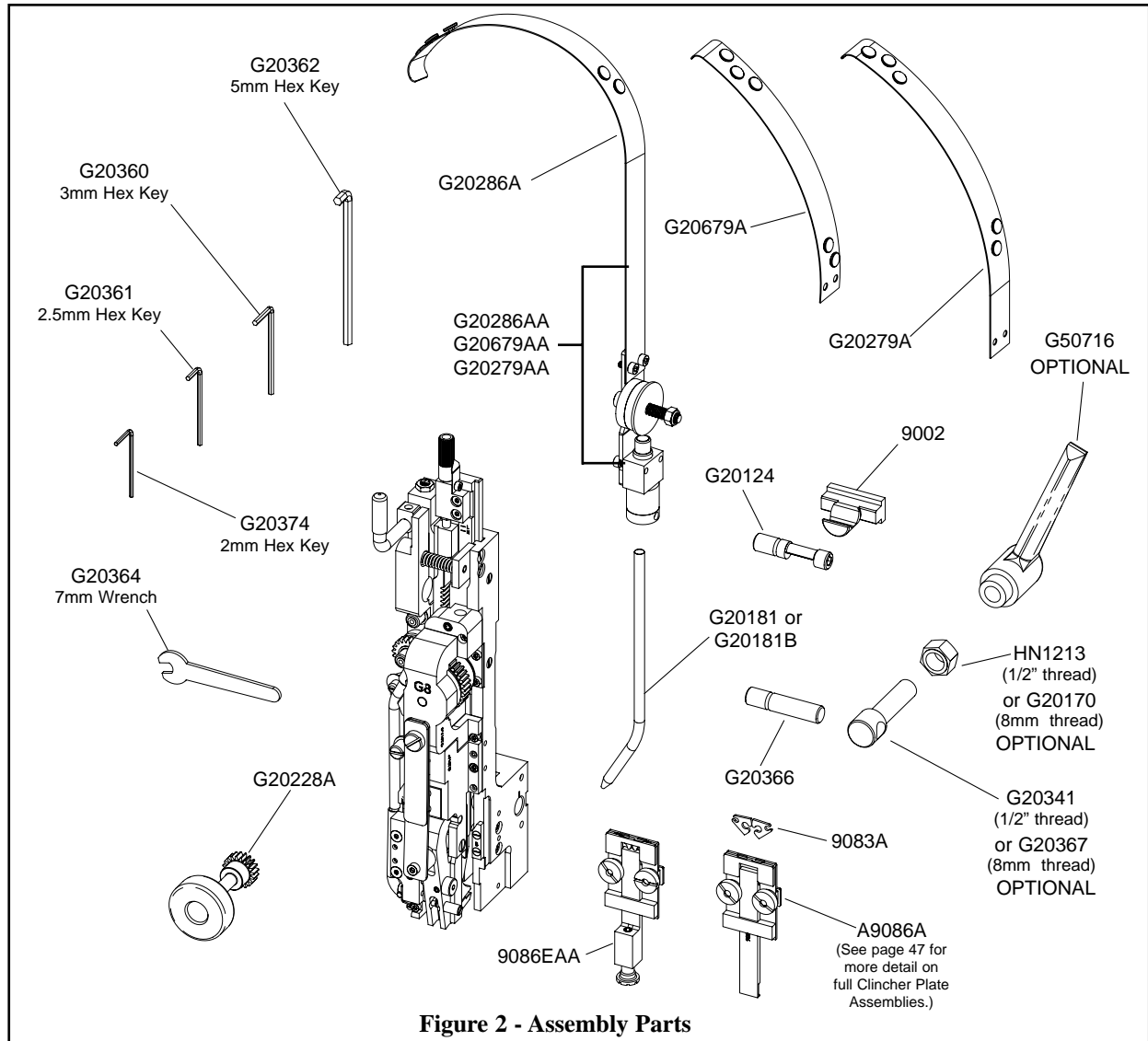
As you carefully unpack the head, check to make sure all components were delivered and are in good working order. Refer to **Figure 2** in this manual for reference to the following pieces:

- G8 Manual
- 2.0mm Hex Key Wrench (G20374)
- 2.5mm Hex Key Wrench (G20361)
- 3.0mm Hex Key Wrench (G20360)
- 5.0mm Hex Key Wrench (G20362)
- 7.0mm Open End Wrench (G20364)
- Complete Wire Guide Spring Plate Assembly (G20278AA)
- Adjustment Knob Assembly (G20228A)
- Short (G20279A) or Long (G20286A) Wire Guide Spring Assembly
- Clincher Plate Assembly - Thick (9086A)
- Round (9083A) or Flat (9083C) Thick Clincher Points
- Clamp Block (9002) and Clamp Block Eccentric (G20124) or Rear Clamp Pin (G20366) and Rear Mounting Bolt (G20367 or G20341)
- Either Clincher Plate Binder Nut (2091), Bolt (9088) and Thick Clincher Slide (9093A) or Clincher Plate Binder Nut (2091), Bolt (9088), Adjustable Clincher Slide (9084B), Clincher Slide Adjusting Screw (9087) and Clincher Slide Adjusting Lock Screw (UA4808.7).
- Stitch Samples

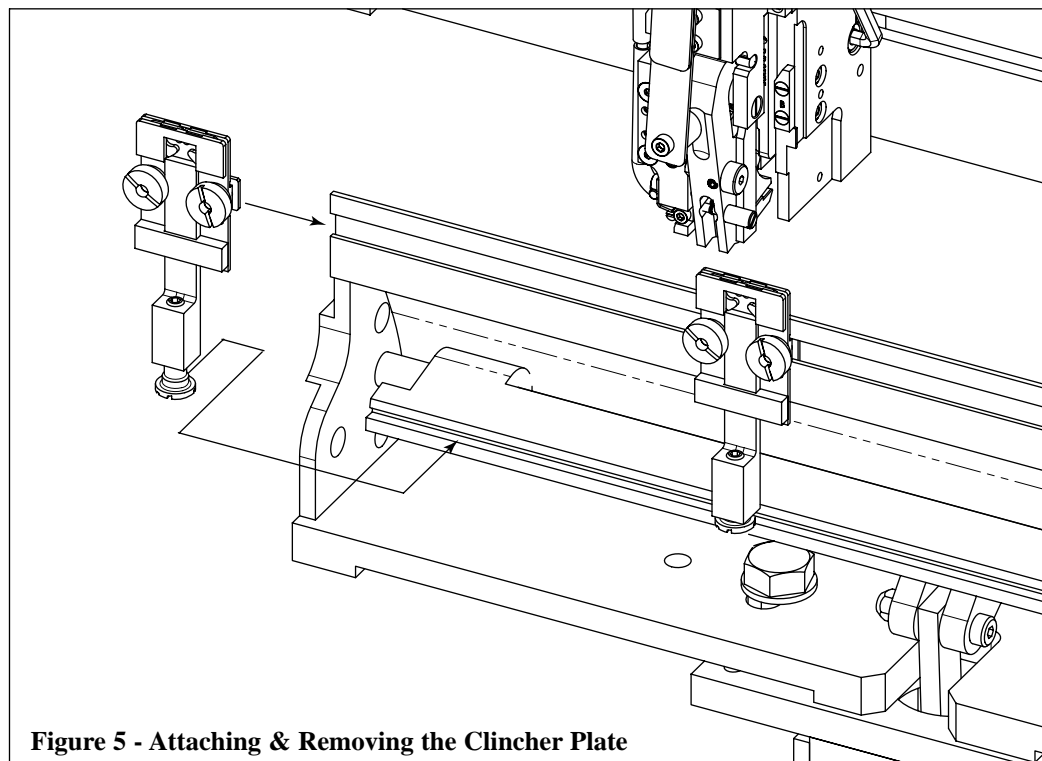
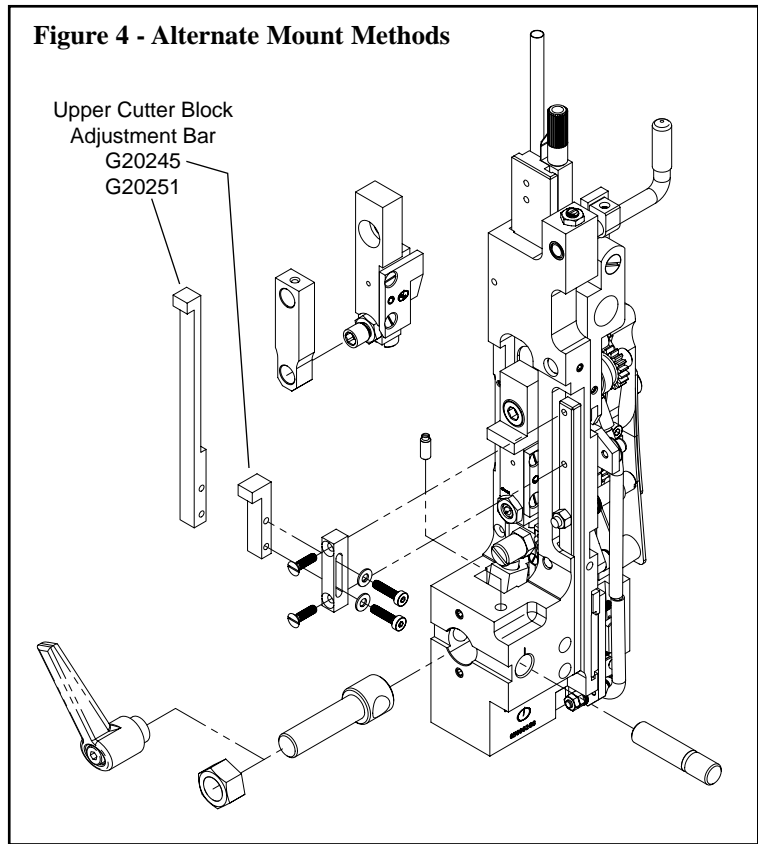
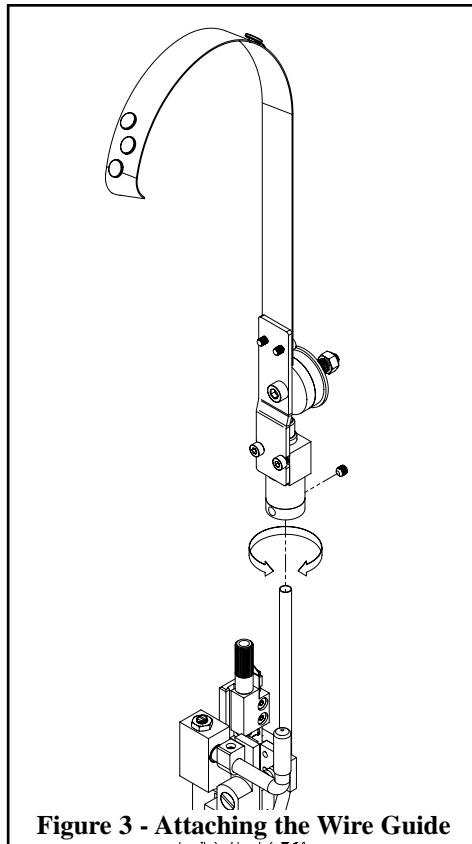
*** Note: the accessories included with the G8 will vary with the style of Head purchased**

Assembly Parts

Please take a few moments to fill out the registration card located on page 44 prior to beginning installation.



Mounting



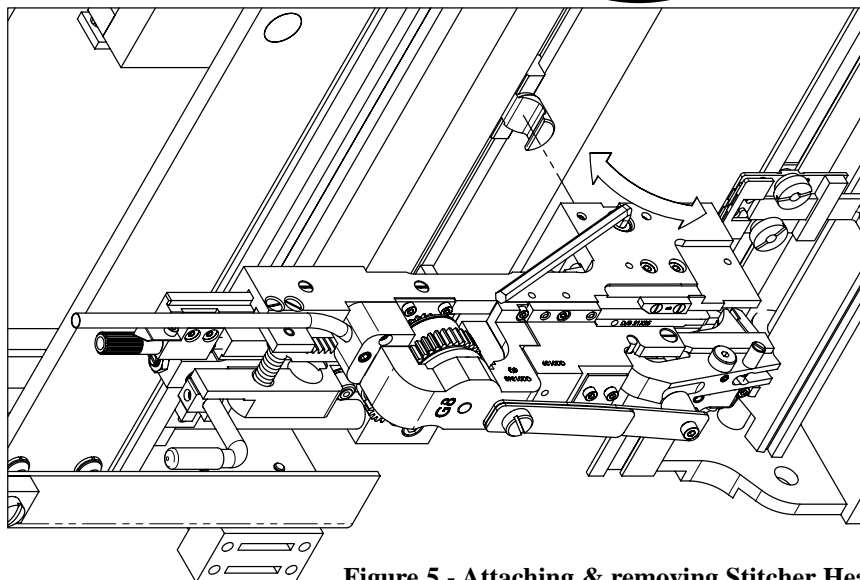
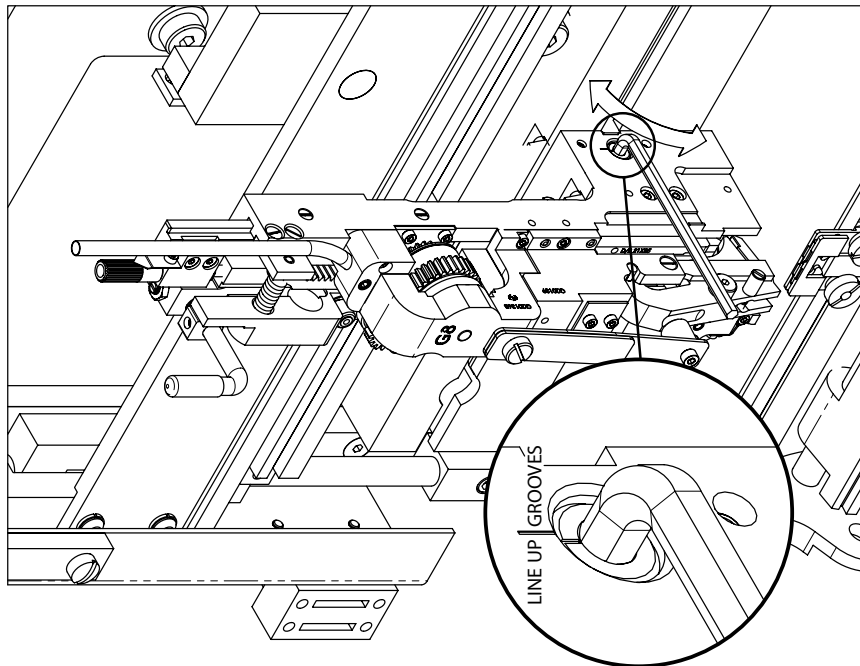
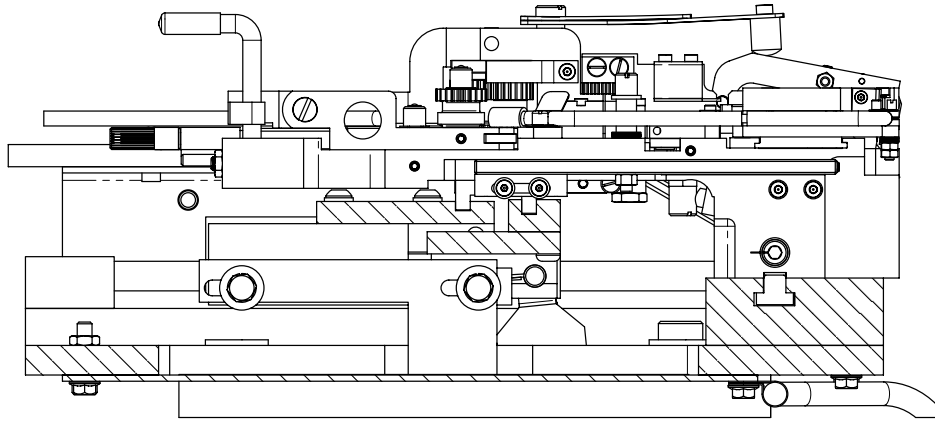
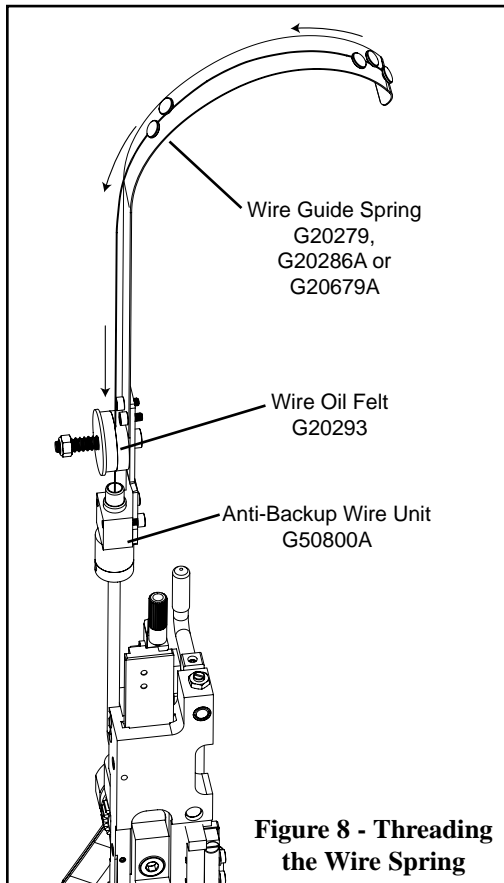
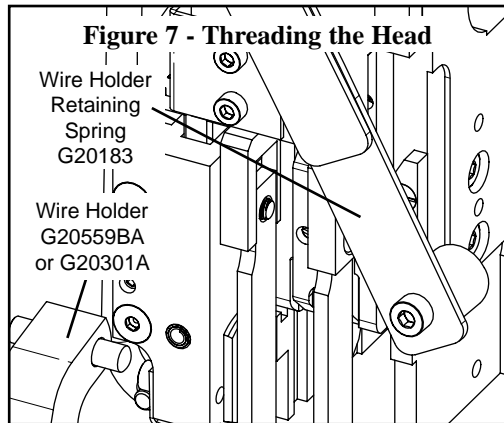


Figure 5 - Attaching & removing Stitcher Heads

Operation

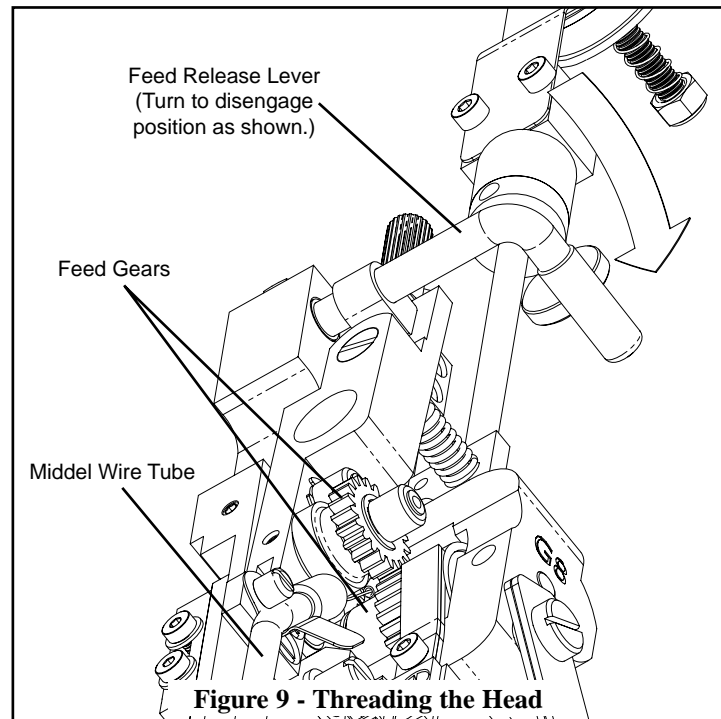
Wire Threading (Figures 7 - 13)



1. Slide the Wire Holder Retaining Spring over to the side and remove the Wire Holder (Figure 7) from the Stitcher Head.

2. Pass the wire from the Spool over the Wire Guide Spring between the Wire Guides, between the Washer and Wire Oiler Felt and into the Anti-Backup Wire Unit (Figure 8).

3. Turn the Feed Release Handle clockwise (Figure 9) to disengage the Feed Gears and guide the wire into the Middle

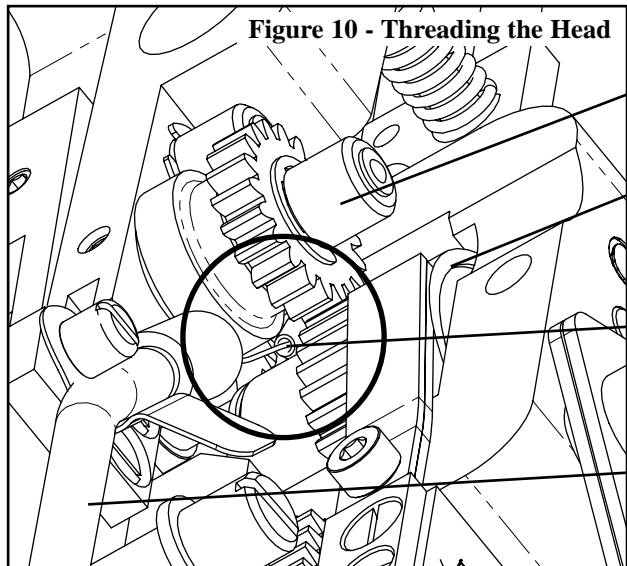


Wire Tube (Figure 10). (Or with the gears engaged, place the Adjustment Handle over the Small Gear pin and rotate clockwise to feed the wire through. See Figure 11.) Re-engage the gears.

4. Turn the stitcher machine on and cycle it until the

wire emerges from the Lower Wire Tube in the Cutter Block. When accomplished, proceed to wire straightening

Note: Never operate the Stitcher Head with the Wire Holder in place unless there is wire stock above the Clincher Points.

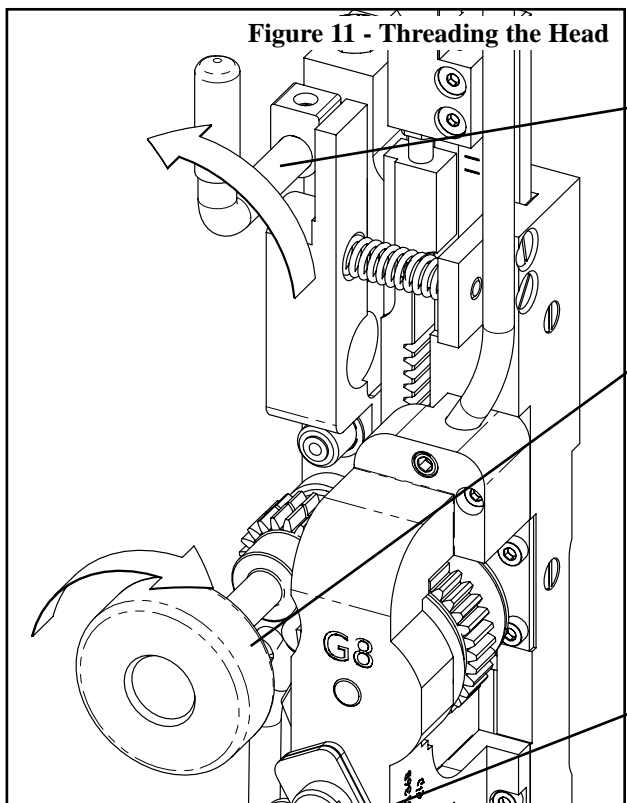


Small Feed Gear
G20112

Large Feed Gear
G20110A

Wire

Middle Wire Tube
G20144A

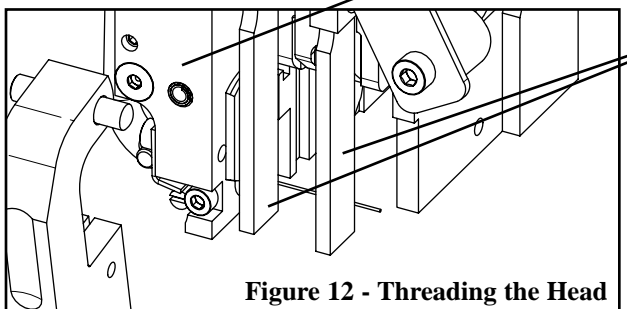


Feed Release Lever
G20119
(Turn to engage
position as shown)

Adjustment Handle
G20228A

Lower Wire Tube
G20199A

Cutter Block
G20197A



Wire Guides
G20541

Wire Straightener
Eccentric
G20206

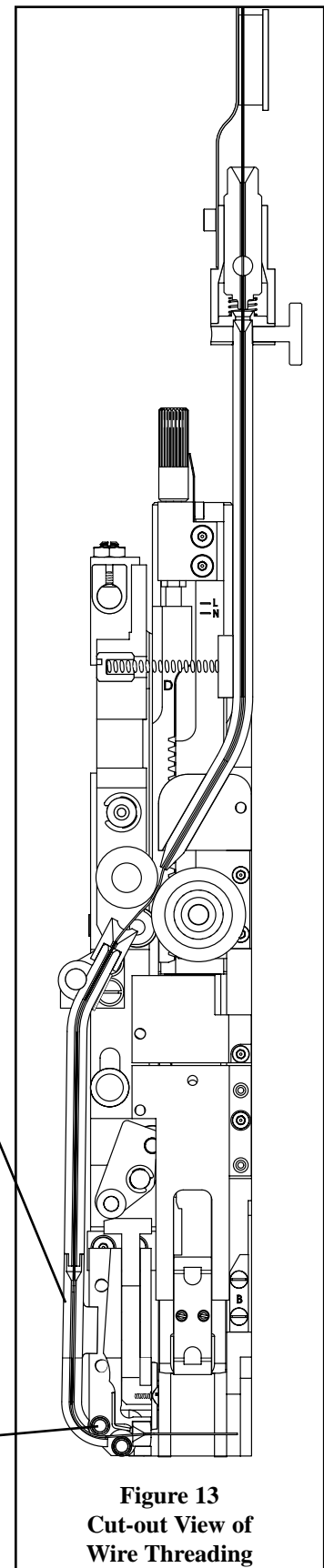
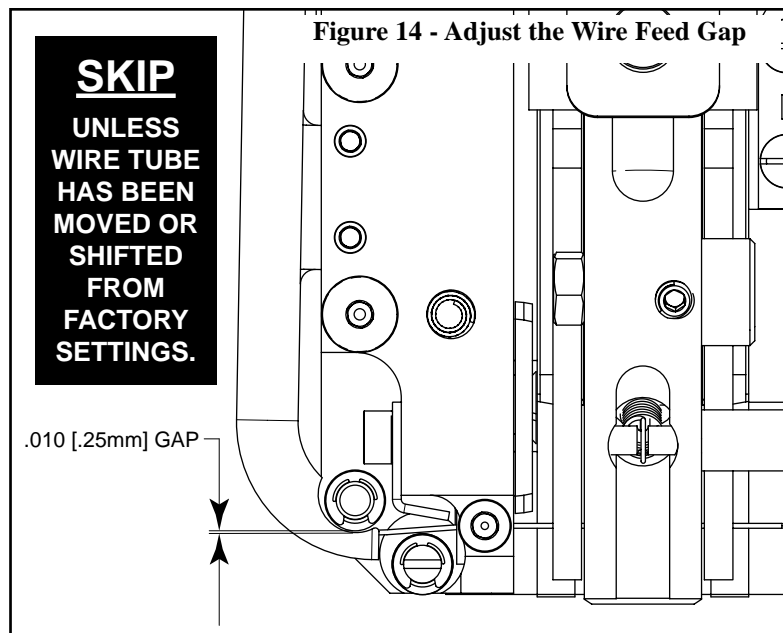
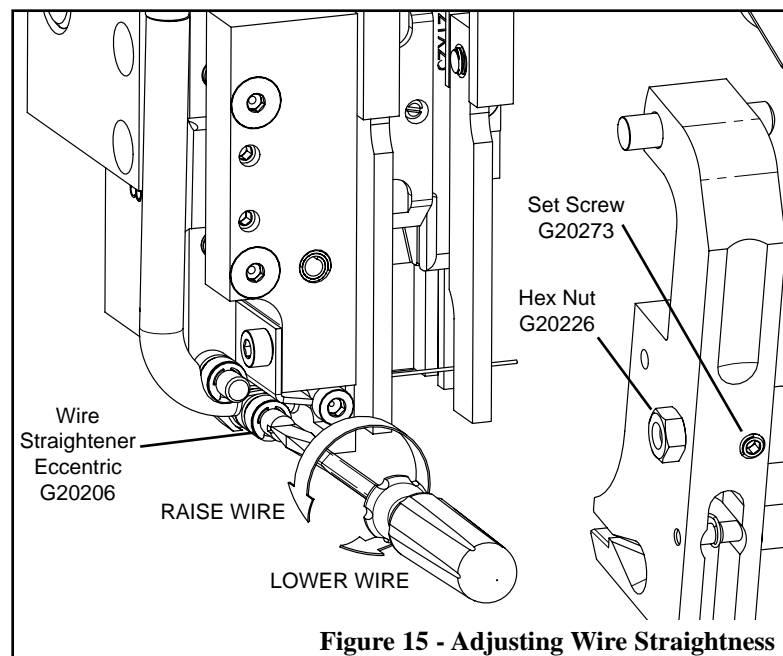


Figure 13
Cut-out View of
Wire Threading

Adjusting Wire Straightness (Fig. 14-17)



Note: Use a metal shim to set gap will simplify this step.



Horizontal Adjustment (Figures 15-16)

Observe the direction the wire is moving as it emerges. Use a slotted head screwdriver on the Wire Straightener Eccentric in the Cutter Block to adjust the wire. If the wire is curved upwards, turn the Wire Straightener Eccentric clockwise. If the wire is feeding downward, turn the Eccentric counter-clockwise.

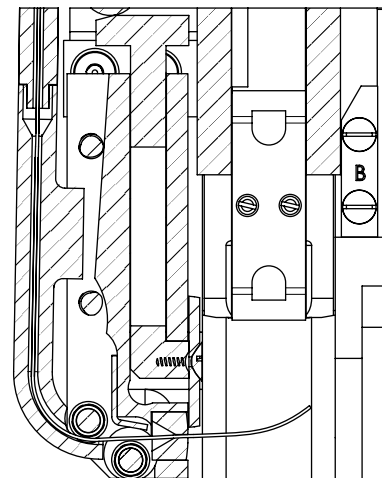


Figure 16a - Wire Curls Up

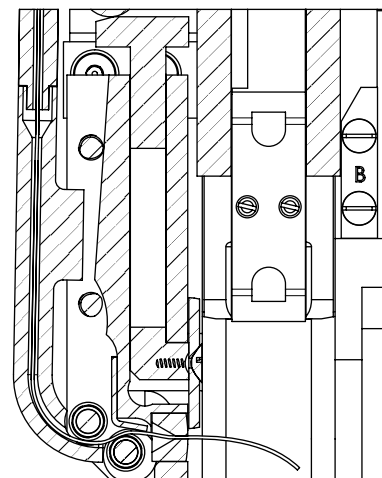


Figure 16b - Wire Curls Down

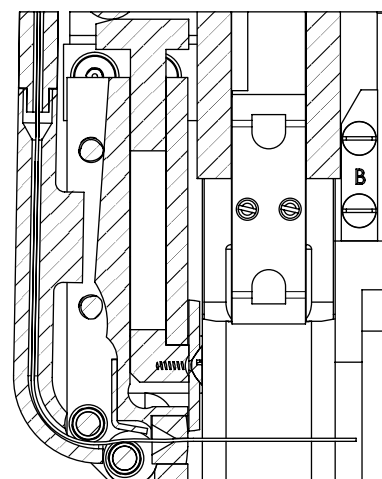


Figure 16c - Straight Wire

Front-to-Back Adjustment

If the Wire Guide Bars are not properly positioned, the wire will rub against them as it exits the Cutter Block. Look at the G8 Head from the side past both the Right and Left Wire Guide Bars (Figure 17). Make sure there is a clear view of the opening in the Fixed Wire Cutter from the side of the G8 Head. If there is not, loosen the Flat Head Machine Screws securing the Wire Guide Bars to the Pivot Block and move them out of the path of the wire. Tighten the Screws after making sure the Wire Guide Bars are even with each other. Replace the Wire Holder and re-engage the Wire Holder Retaining Spring.

NOTE: Depending on its size, adjust wire straightness every 3-10 lbs. of wire used approximately as follows:

5-10 lbs. Spool every 3 lbs.
 10-25 lbs. Spool every 5 lbs.
 25-70 lbs. Spool every 7 lbs.
 70 lbs.+ Spool every 10 lbs.

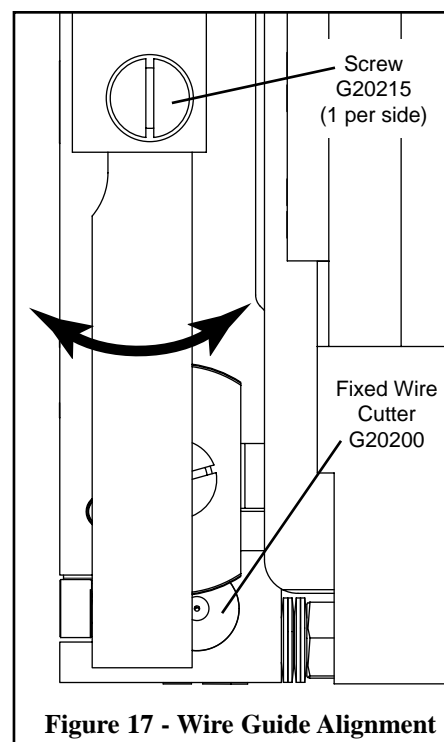


Figure 17 - Wire Guide Alignment

Aligning the Wire Holder (Figure 18a & b)

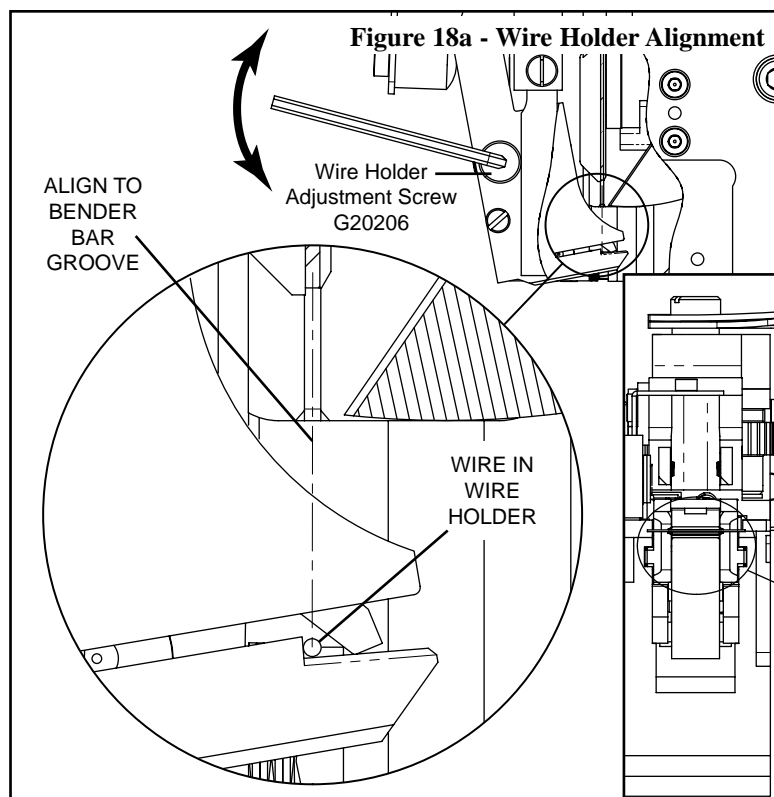


Figure 18a - Wire Holder Alignment

In order to form a quality stitch, the Wire Holder has to be in alignment with the Bender Bar. Specifically, the cut piece of wire held in the Wire Holder has to line up with the grooves in the Bender Bar. Poor adjustment

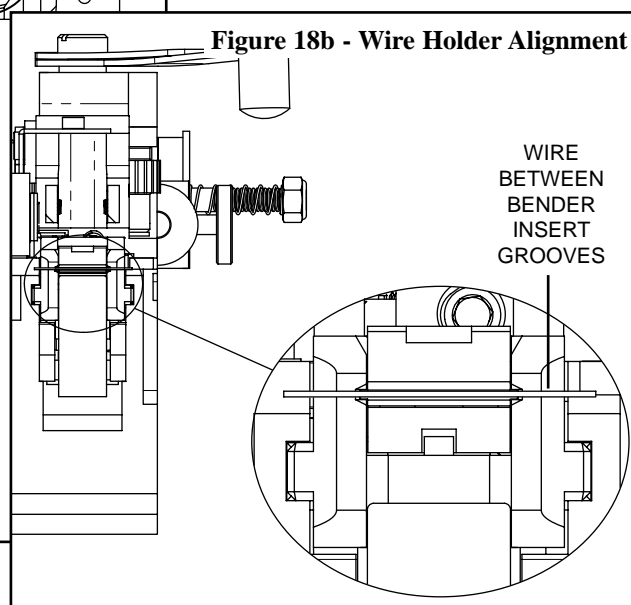


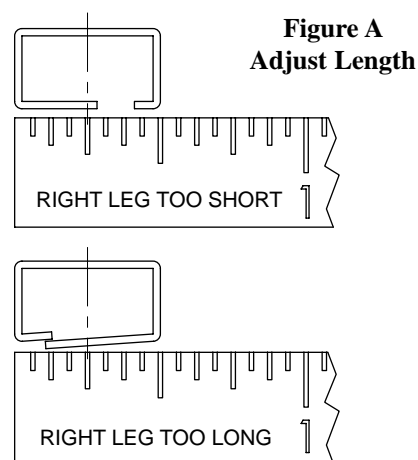
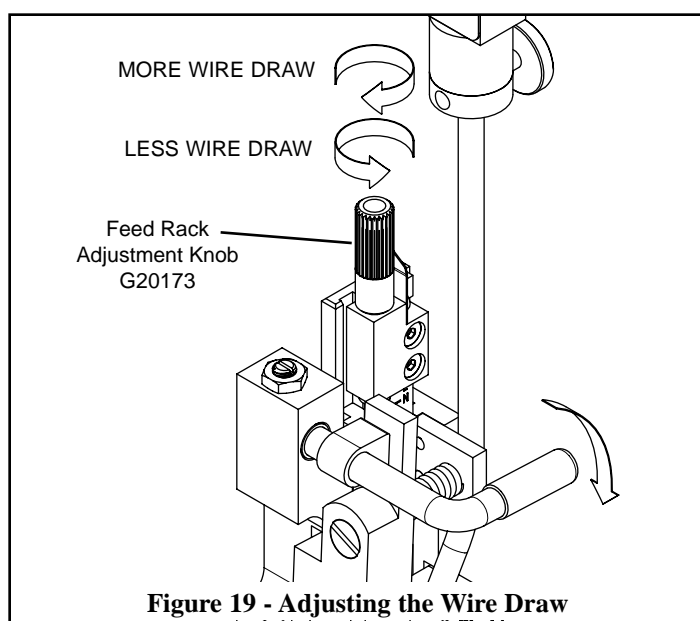
Figure 18b - Wire Holder Alignment

may cause broken crowns or other poor stitching.

Load a piece of wire into the Wire Holder. Using a mirror, check to make sure the wire in the Wire Holder is lined up with the grooves in the Bender Bar (Figure 18b). If it is not, loosen the Socket Head Set Screw in the front of the Wire Holder and the Hex Nut (seen in Figure 15) securing the Wire Holder Adjustment Screw (Figure 18a). Turn the Adjustment Screw until the wire is aligned with the grooves in the Bender Bar. Tighten the Hex Nut and Set Screw to secure this setting.

Remove the wire in the Wire Holder and load another piece in the Stitcher Head. Verify that the setting established is accurate by again checking the piece of wire with the mirror.

Adjusting the Stitch (Figure 19-23)



Before making any adjustments, make sure your stitching machine compression setting is set to the proper thickness of work. Make a few sample stitches and look at the results.

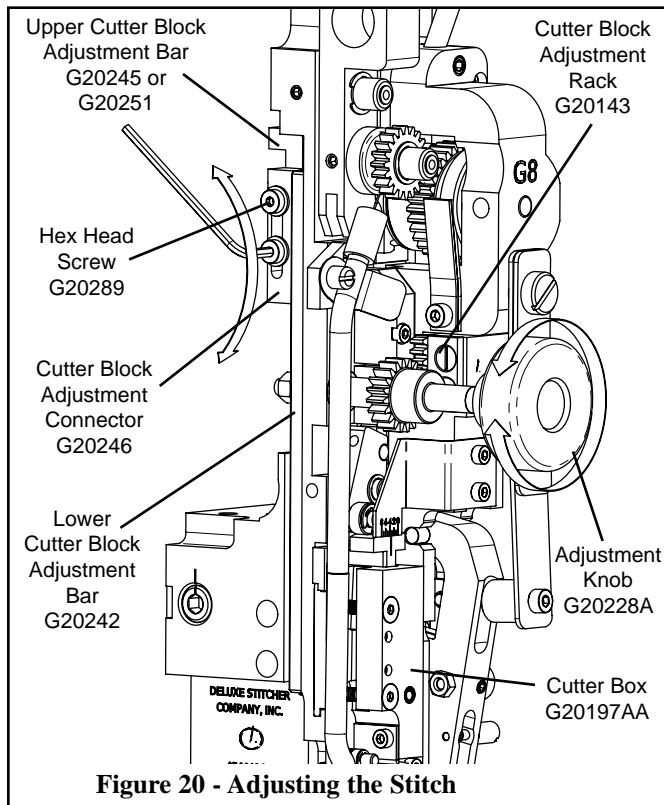
Setting the Stitch Gap (Or Adjusting the Wire Draw)

To adjust the overall length (wire draw) of the stitch, disengage the Small Feed Gear by turning the Feed Release Handle 1/4 of a turn to the right as shown. Adjust the Feed Rack Adjustment Knob until the gap between the staple legs allows only the edge of a fingernail to pass between them.

- To extend the length of the stitch or decrease the gap, turn the Feed Rack Adjustment Knob clockwise. (See upper view of Figure A)
- To shorten the length of the stitch or increase the gap, turn the knob counter-clockwise. (See lower view of Figure A)

Centering the Stitch Gap (Or Setting Equal Length Legs)

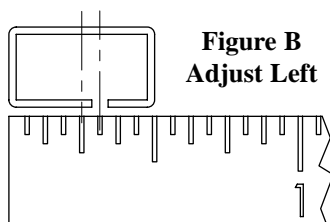
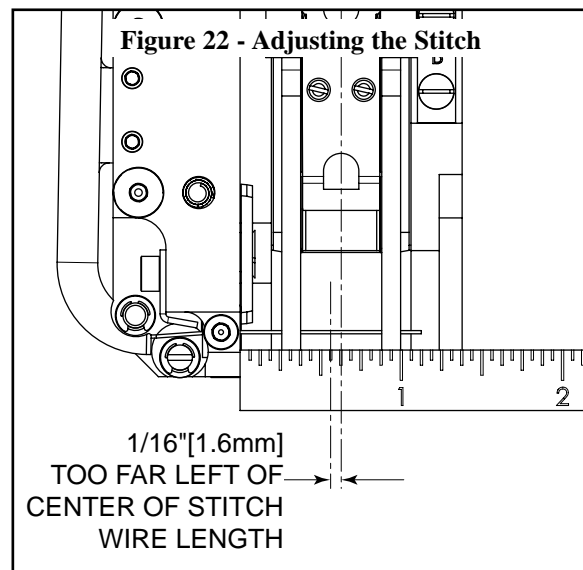
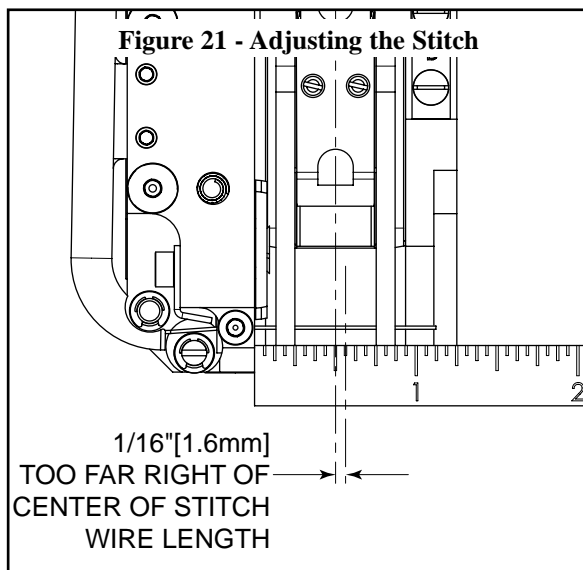
The amount of wire on either side of the stitch gap should be the same. The gap position is controlled by the position of the Cutter Block. As thicker work is stitched, the Cutter Block must be moved further from the Wire Holder to keep the legs of the stitch even and the gap centered.



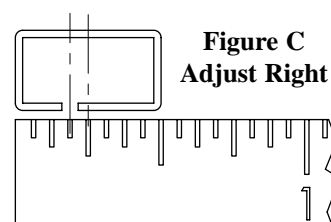
For **G8 Heads mounted to a machine with an adjuster rail**, loosen the two (2) Hex Head Screws securing the Lower Cutter Block Adjustment Bar and Cutter Block Adjustment Connector to the Upper Cutter Block Adjustment Bar (both versions shown in Fig. 4). **For all G8 style Heads**, place the Adjustment Knob over the Cutter Adjustment Stud as shown in Figure 20 and engage the teeth of the Cutter Block Adjustment Rack and adjust as shown in the following illustrations. Be sure to run a couple of stitches after each adjustment.

⚠ WARNING

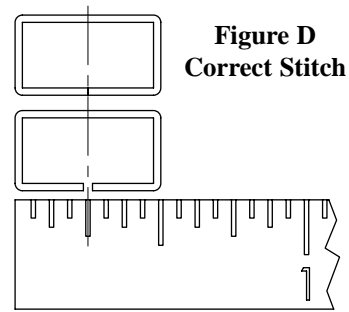
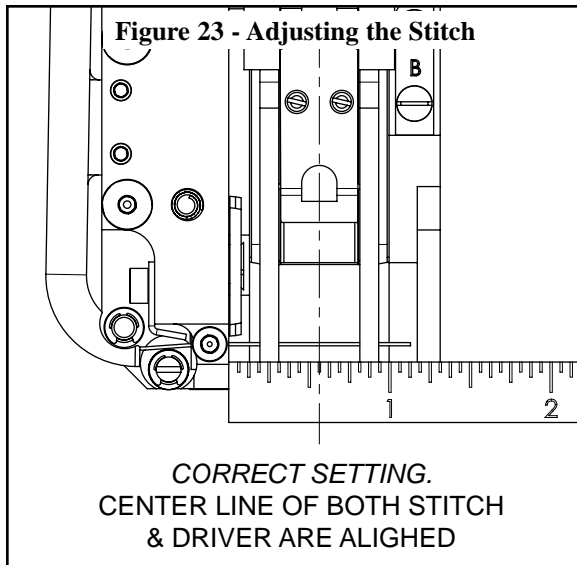
Always disconnect the power supply before making any adjustments or servicing the head.



Gap of stitch is 1/16" off center to the right. To correct, turn the Adjustment Knob clockwise, to shift the Cutter Box 1/16" to the left.



Gap of stitch is 1/16" off center to the left. To correct, turn the Adjustment Knob counter-clockwise to shift the Cutter 1/16" to the right.



The ideal stitch has the center of gap aligned to the center of the finished stitch.

Aligning the Clincher Plate (Figures 24-27)

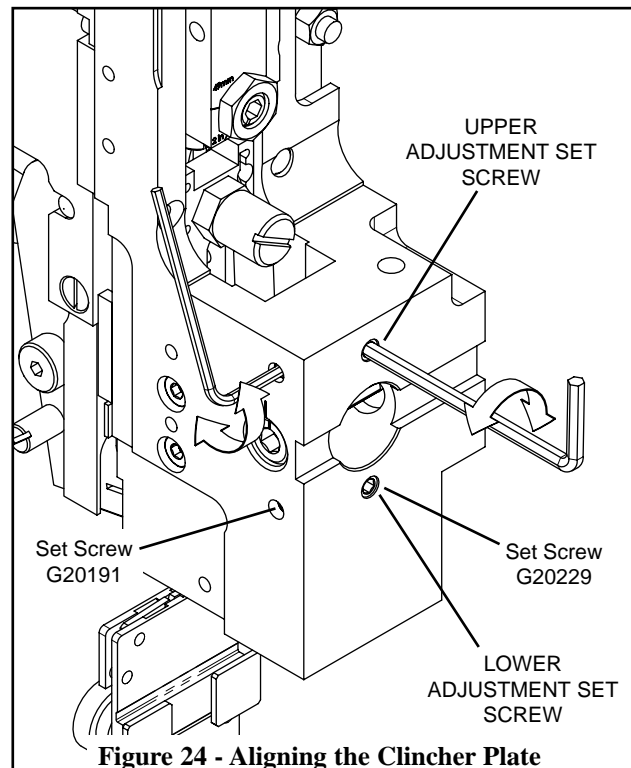
In order to produce properly clinched staples, the center of the Clincher Plate (round or flat, thick or thin) must be exactly in line with the Driver both left-to-right and front-to-back.

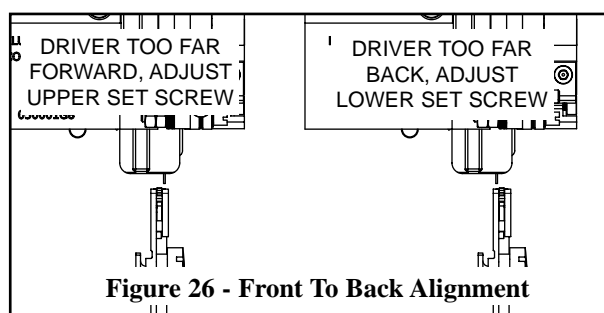
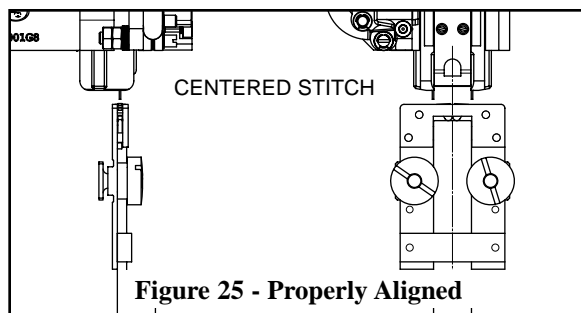
Front-to-Back Adjustment

Manually activate the G8 until the Stitcher Head is at the bottom of its stroke and the Driver is touching the top of the Clincher Plate. Looking from the side of the Stitcher Head, make sure the rib of the Driver is aligned with the center of the gap between the front and back plates of the Clincher Plate Assembly. All adjustments are made to the screws in the back of the G8 while the Stitcher Head is removed from the Stitcher Machine.

Loosen the two (2) Socket Head Set Screws in the side of the Head. If the Driver is positioned in front of the Clincher Plate then the upper Adjustment Set Screw must be turned counter-clockwise until the Screw sticks out slightly from the back of the Head, while the lower Screw remains under flush.

If the Driver is positioned in back of the Clincher Plate then the lower Adjustment Set Screw must be turned counter-clockwise until it sticks out slightly from the back of the Head, while the upper Screw remains under flush.

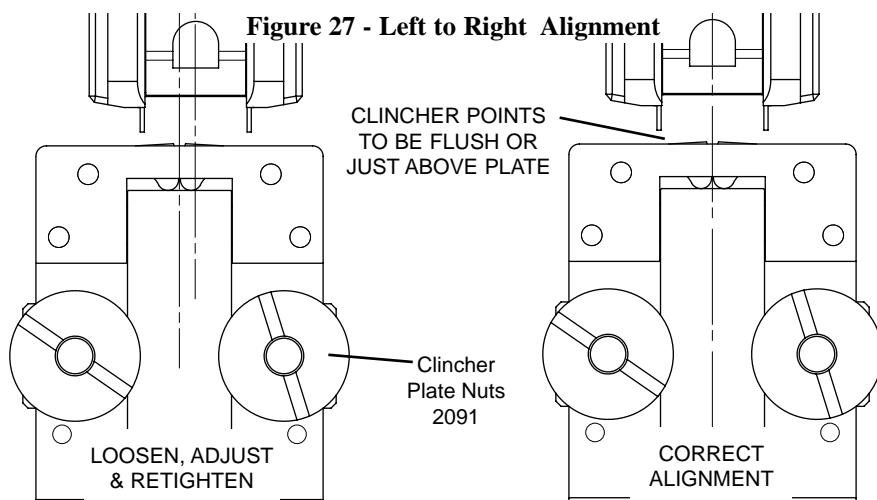




Slight adjustments to the Set Screws make significant differences in position. Once the position is set, tighten the two (2) Socket Head Set Screws in the side of the Stitcher Head.

Left-to-Right

Looking from the front of the Stitcher Head, make sure the Driver is centered directly above the Clincher Slide (9093A or 9084B). If it is not, loosen the two (2) Clincher Plate Nuts and move the entire Clincher Plate Assembly to the right or to the left. Secure this position while tightening the nuts again.



Adjusting the Clincher Points (Figure 28-29)

The position of the Clincher Points should be flush, or slightly above flush, with the Clincher Plate in order to achieve a quality stitch. To ensure this, manually turn the stitcher machine until the Driver is at the lowest position of its stroke and the Clincher Points are at their highest position. Turn 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 cut the stock being stitched.

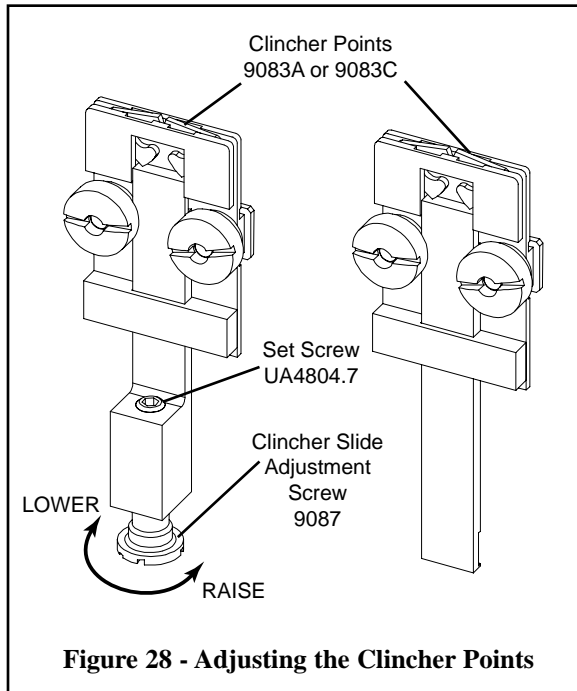


Figure 28 - Adjusting the Clincher Points

Note: Ensure that the stitcher machine's compression setting is correct before making Clincher Point adjustments.

To adjust the Clincher Points, loosen the Set Screw on the top of the Clincher Slide (9084B). Turn the Clincher Slide Adjustment Screw clockwise to lower the Clincher Points and counter-clockwise to raise them. Once set, reighten the Set Screw.

Refer to the complete list of wear parts for the G8 style Stitcher Head, found in the back of this manual on page 47. The Clincher Points and Clincher Plates necessary for a quality stitch are specific to the crown size and wire gauge size used in each stitcher head.

For a Solid Clincher Plate, the legs of each stitch are formed when the wire hits the formed grooves of the Clincher Plate, instead of movable Clincher Points

coming up to meet the wire. The resulting stitch will curled legs instead of flat (Figure 29).

The only adjustment that can be made to a Solid Clincher Plate is to make sure it is centered below the Head's Driver and even that adjustment can only be made on multi-head stitcher machines.

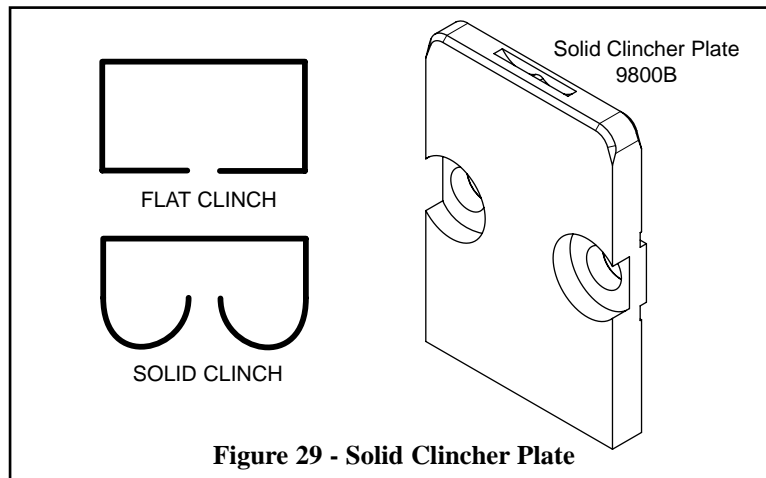
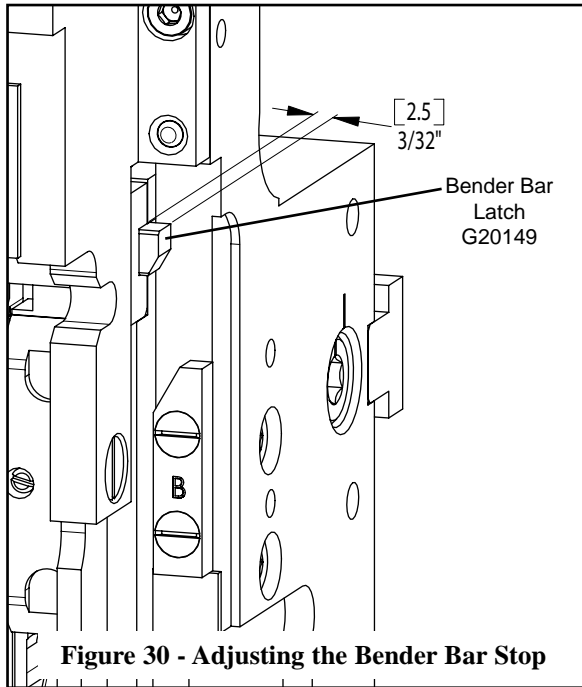


Figure 29 - Solid Clincher Plate

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

⚠ WARNING

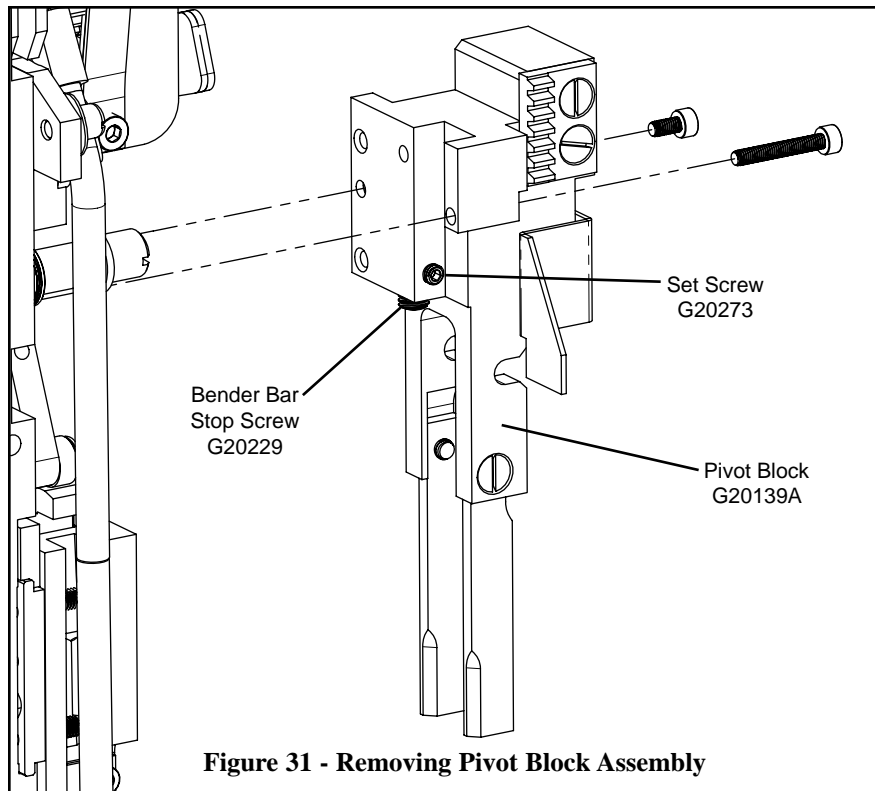
Adjusting the Bender Bar Stop (Figures 29-31)

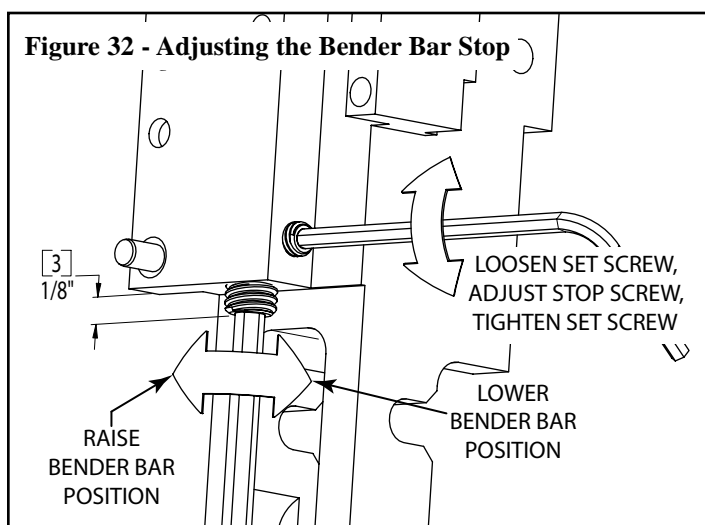


The Bender Bar Stop is set at the factory. The Stop controls the position of the Bender Bar Latch at the top of the stitcher head's stroke. If the Latch does not fall within the proper area of the Driver Bar, partially formed stitches will result or the G8 will jam.

The right edge of the Bender Bar Latch should stick out from the Bender Bar at least 3/32" [2.5mm] (Figure 30) when the G8 reaches the top of its stroke. If the Latch does not protrude this far then the Bender Bar Stop Screw is set too high. If the Stop Screw is set too low then the wire will hit the Bender Bar rather than feeding below it for forming.

To adjust, remove the two (2) Screws securing the Pivot Block (with attached components) to remove it from the Feed Gear Bracket (Figure 31). Loosen, but do not remove, securing the Stop Screw. Turn the Stop





Screw clockwise to raise the Bender Bar's position and counter-clockwise to lower it's position. The normal position is about 1/8" or 3mm out from the Feed Gear Bracket.

Replace the Pivot Block using its Locating Pins with the holes in the Bonnet. Manually turn the Large Feed Gear (G20110A) if its teeth are not aligned with those on the Feed Rack (G20127). Replace the Screws.

Maintenance

Lubrication (Figure 33)

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, which ever 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:

1. the top of the Bonnet (G20000A) on either side of the Feed Slide (G20131).
2. the fittings on the Feed Lever Pivot Pin and the Small Feed Gear Pin (G20262A).
3. the Cutter Operating Lever Pivot Pin (G20231) and Roller Pin (G20232).
4. the Wire Straightening Rollers (G20208B) in the Cutter Block Assembly (G20197A).
5. on the Wire Holder Assembly under the Wire Holder Retaining Spring Foot (G20184).
6. where the Wire Holder Assembly (G20559BA) pivots in the Left and Right Wire Guide Bars (G20141 and G20142).
7. on the Bender Bar Latch (G20149) and the Latch Release Cam (G20115).
8. in the Cutter Block Assembly, along side the Cutter Operating Slide (G20198).
9. in the Wire Felt to saturate it.

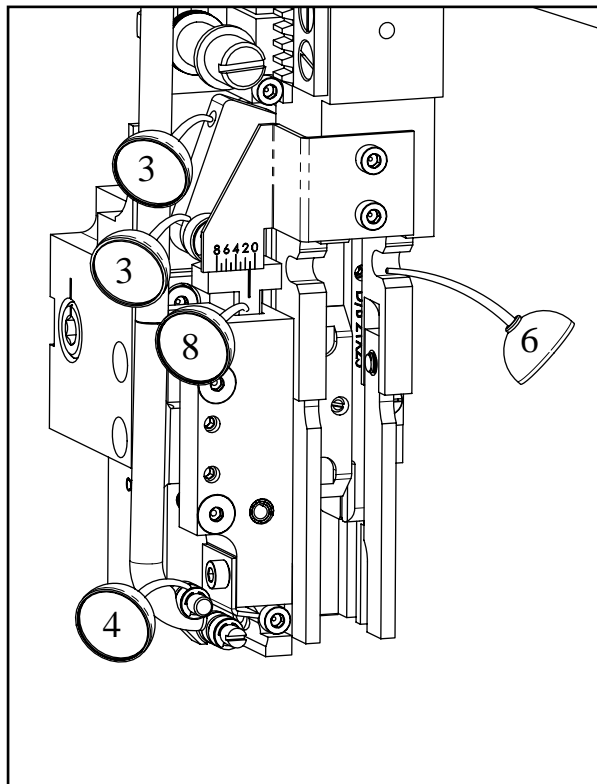
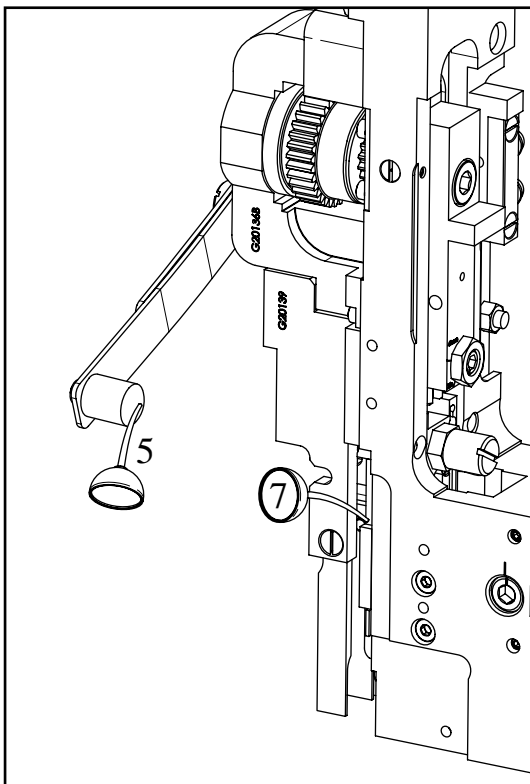
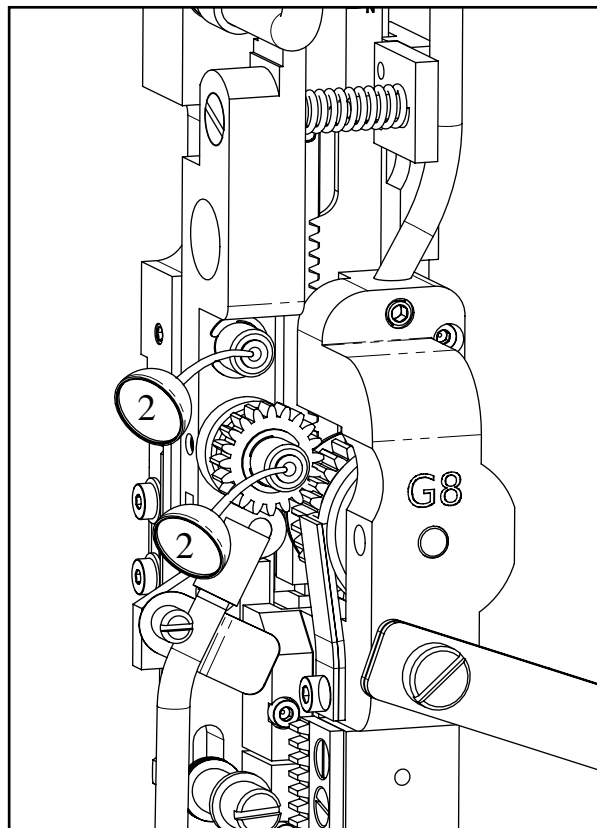
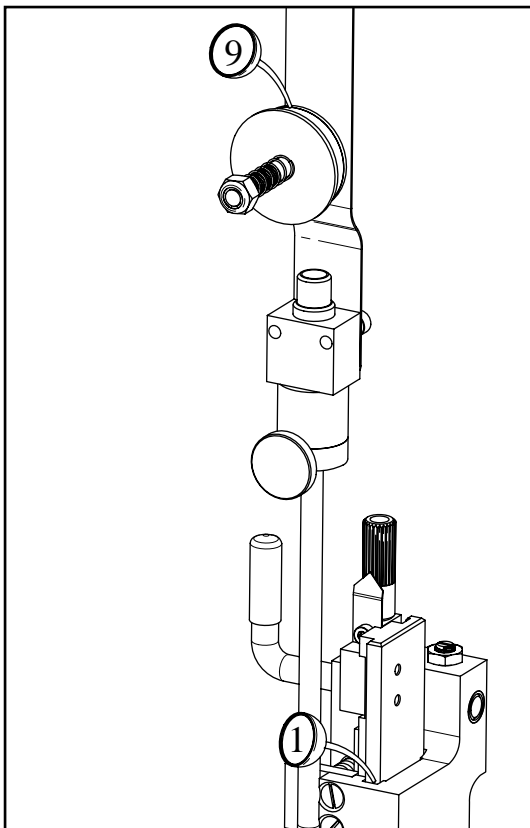


Figure 33 - Lubrication Points

Cleaning

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

CAUTION

In addition to proper lubrication, routine cleaning is important for the maintenance of your G8 Head. The entire Head should be torn down and rebuilt every three to six months and the following areas should be cleaned once every three months:

- **Large Feed Gear (G20110A):** remove and wash in an oil-dissolving solvent, like Aeroshell 14 (G20824). Dry and relubricate.
- **Anywhere that dust, oil or pieces of wire and paper have built up** - for example: around the Clincher Points and around the Wire Straightener Rollers.

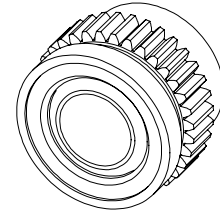


Figure 34 - Large Feed Gear

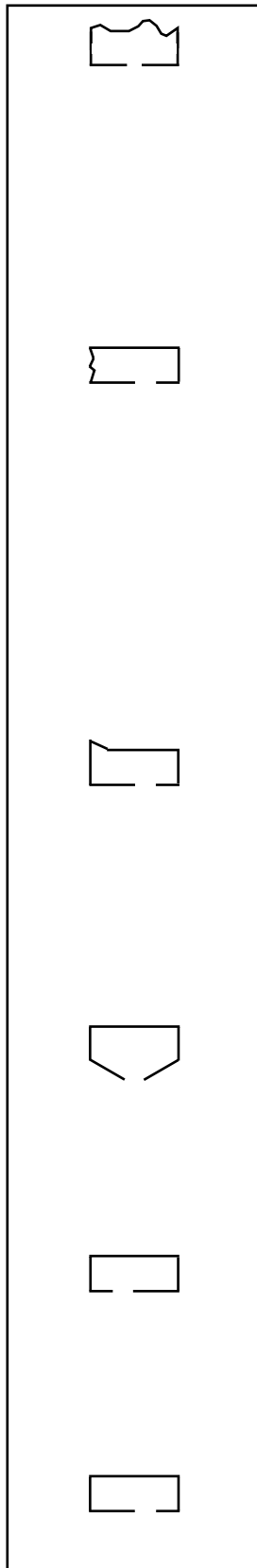
Ordering Spare Parts

In time, you will need to replace some parts in your G8 style Stitcher Head. When this happens, first locate the needed part in one of the following diagrams. Then locate the DeLuxe Stitcher part number and contact your Graphic Arts Representative to order the part by the part number, description and quantity.

Troubleshooting (Figure 34)

The quality and quantity of work that can be produced with the G8 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 G8 Stitching Head. In the event of problems of this nature occurring, the operator can, by referring to the following troubleshooting chart, quickly locate the solutions.



PROBLEM: Crown Not Straight

SOLUTION: Straighten the wire. (See page 14) Align the Clincher Points. (See page 19) Reverse or replace the worn or broken Driver. (See page 26) Make sure the Cutters are aligned and not dull. (See page 24) Check for correct wire size and strength being used. Check for correct work thickness setting. Check the quality of the wire being used, change spools.

PROBLEM: Leg(s) Buckled

SOLUTION: If the ends of an unformed piece of wire are not smooth, the Wire Cutters are worn. Check for wear and rotate or replace if needed. (See page 24) Make sure the Cutters are aligned properly. (See page 24) Make sure the correct wire size is being used and that the wire is straight. (See page 14). Check the quality of the wire being used, change spools.

PROBLEM: Corner Buckled

SOLUTION: Check the Driver for a chipped corner and rotate or replace it if needed. (See page 26) Align the Wire Holder. (See page 15) Check the tensile strength of the wire or use thicker wire.

PROBLEM: Clinch Too Loose

SOLUTION: The Clincher Points are too low or too high and need adjusting. (See page 19) The compression of the stitcher machine is insufficient and needs to be increased.

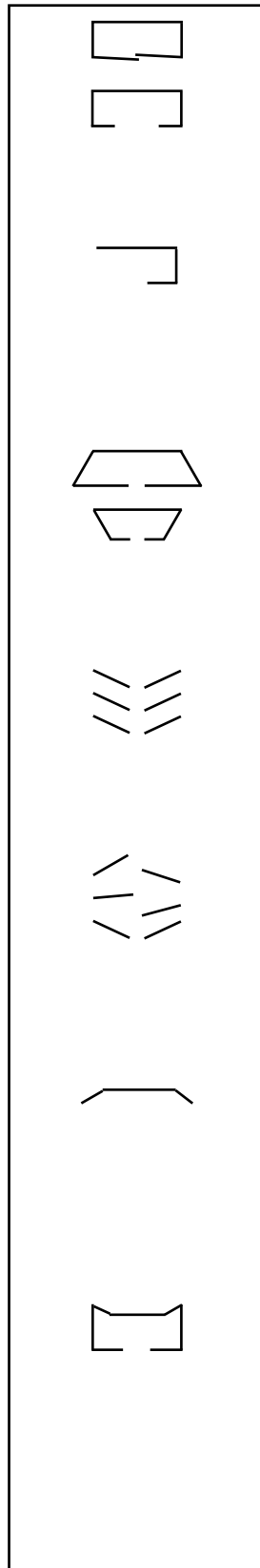
PROBLEM: Left Leg Too Short / Right Leg Too Long

SOLUTION: Adjust the position of the Cutter Block Assembly by moving it away from the Head. (See page 17)

PROBLEM: Left Leg Too Long / Right Leg Too Short

SOLUTION: Adjust the position of the Cutter Block Assembly by moving it away toward the Head. (See page 17)

Figure 34 - Troubleshooting



PROBLEM: Staple Legs Too Long or Too Short

SOLUTION: Correct the overall wire draw by repositioning the Feed Rack within the G8 Head. (See Page 18)

PROBLEM: Left Leg Missing

SOLUTION: Straighten the wire. (See page 14) The Wire Holder Assembly is not aligned properly with the groove in the Bender Bar.

PROBLEM: Legs are Spread or Contracted

SOLUTION: Straighten the wire. (See page 14) Weak wire or wrong gauge being used, change spools.

PROBLEM: Legs Stray Forward or Backward Consistently

SOLUTION: The Clincher Points are not aligned properly front to back. (See page 19)

PROBLEM: Stitch Stray Randomly In and Out and Front to Back

SOLUTION: Straighten the wire. (See page 14) Make sure the Cutters are aligned properly. (See page 24) Check the tensile strength of the wire or use thicker wire. Verify correct wire gauge is being used, change spools.

PROBLEM: Partially Formed Stitches

SOLUTION: The Bender Bar Latch is not engaging with the Driver Bar, either may be worn. The Bender Bar Stop Screw is set too low. (See page 21). Broken Latch or Latch Spring, replace. (See page 26)

PROBLEM: Weak crown, crown breaks off after stitch

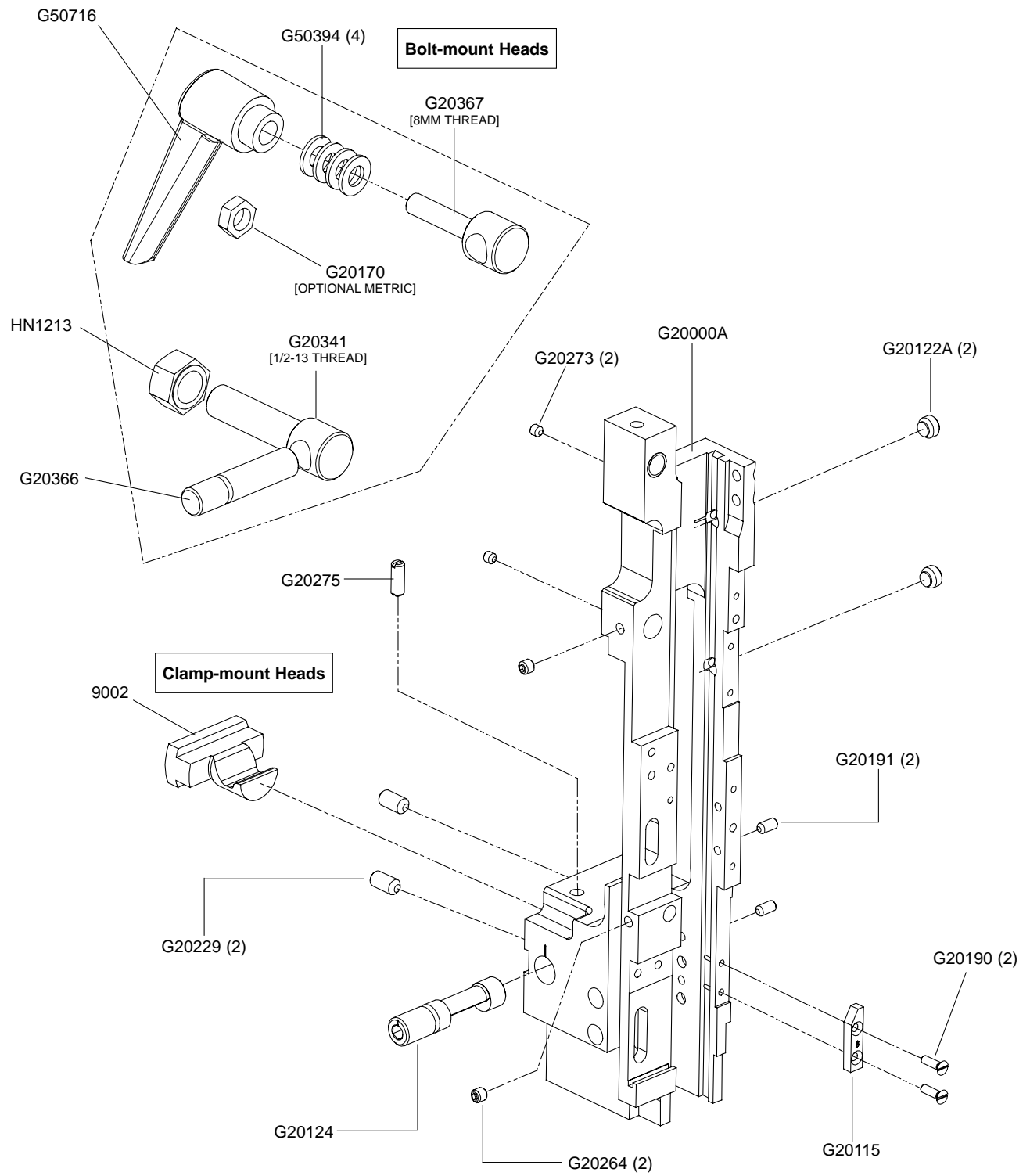
SOLUTION: Align the Wire Holder with the grooves in the Bender Bar (See page 15). Check the tensile strength and size of the wire being used.

PROBLEM: No wire being drawn

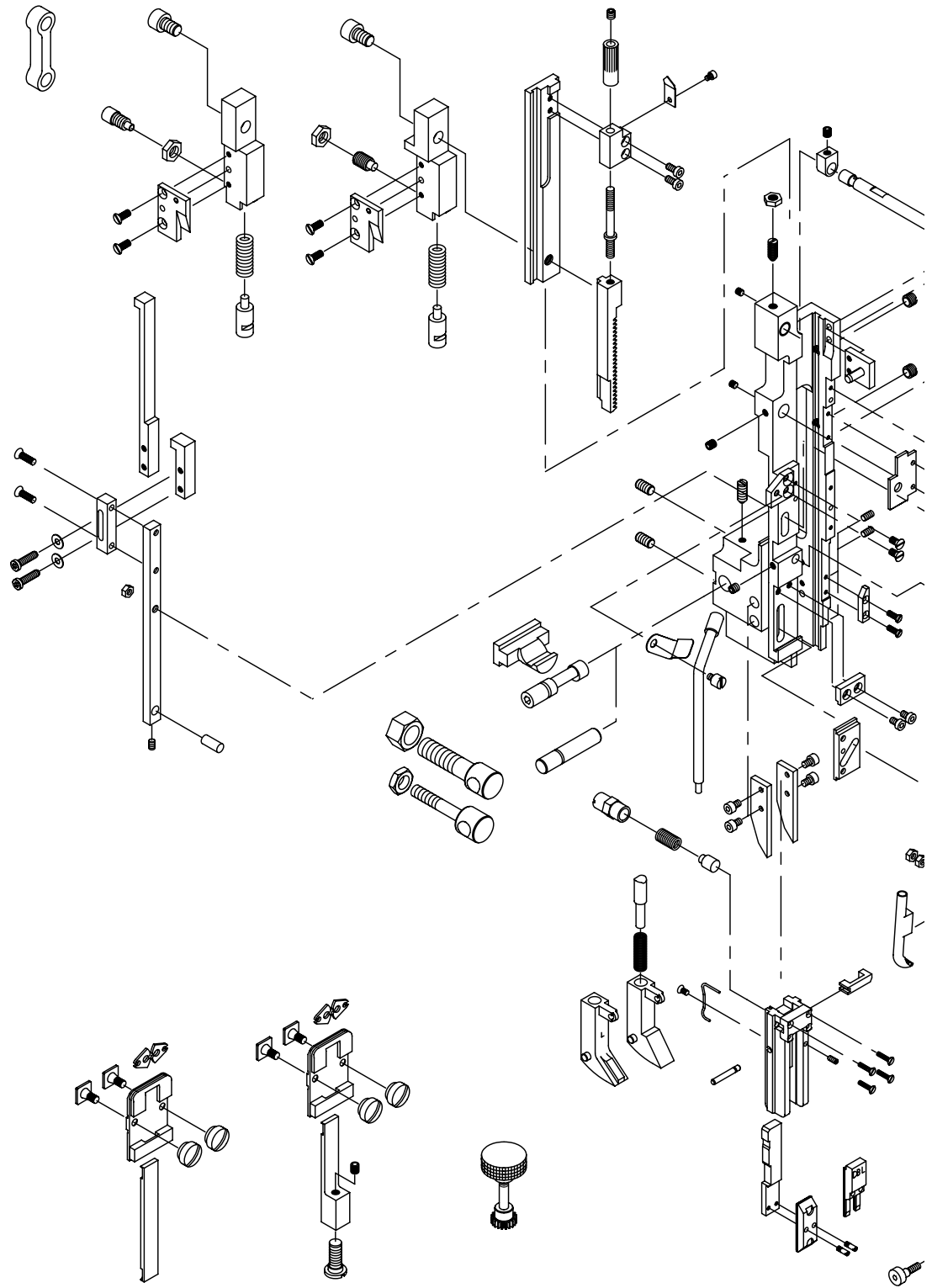
SOLUTION: Make sure the Feed Release Handle is turned to the "on" position and the Feed Gears engaged. (See page 13)

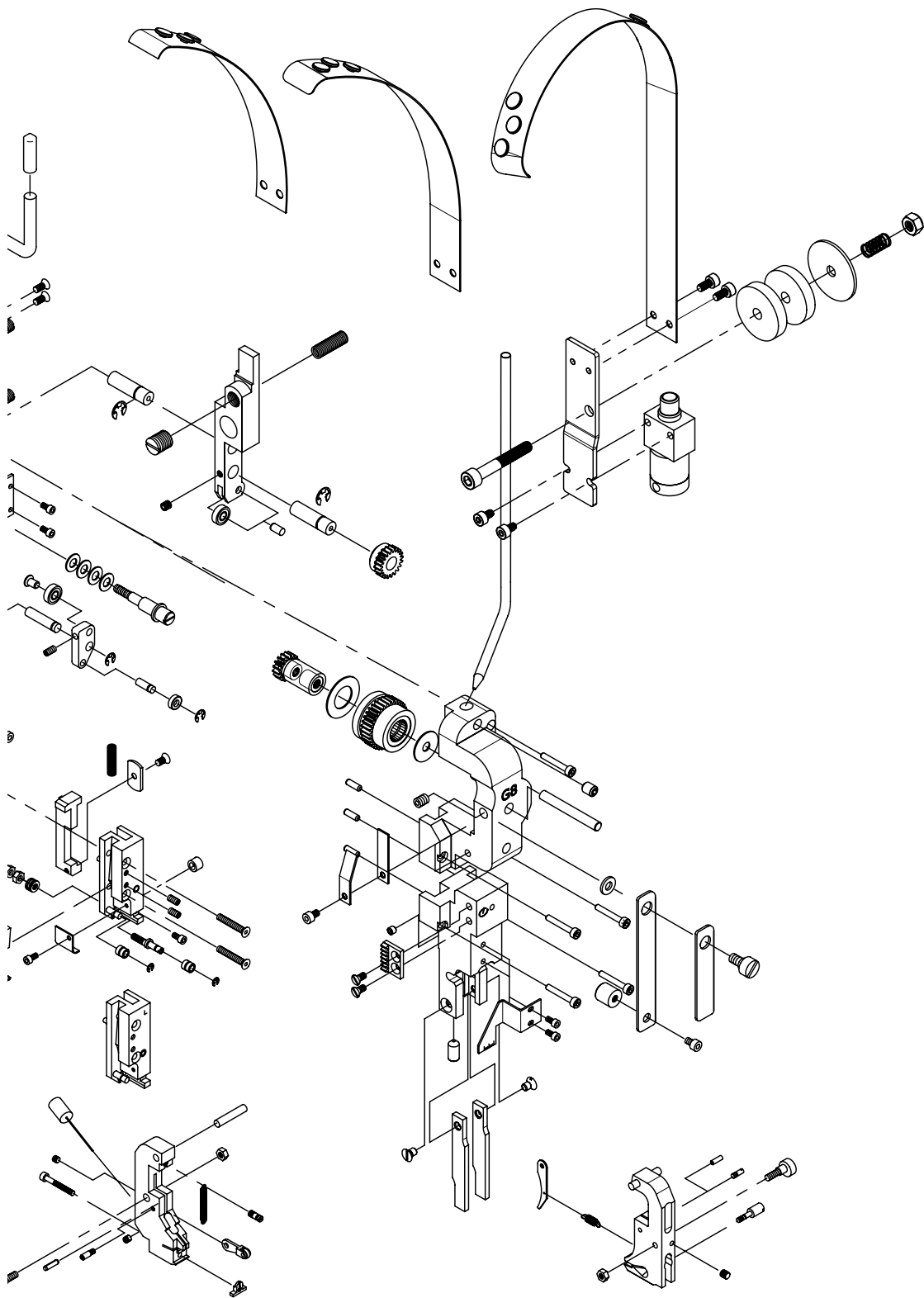
Figure 34 - Troubleshooting

Bonnet Sub-Assembly

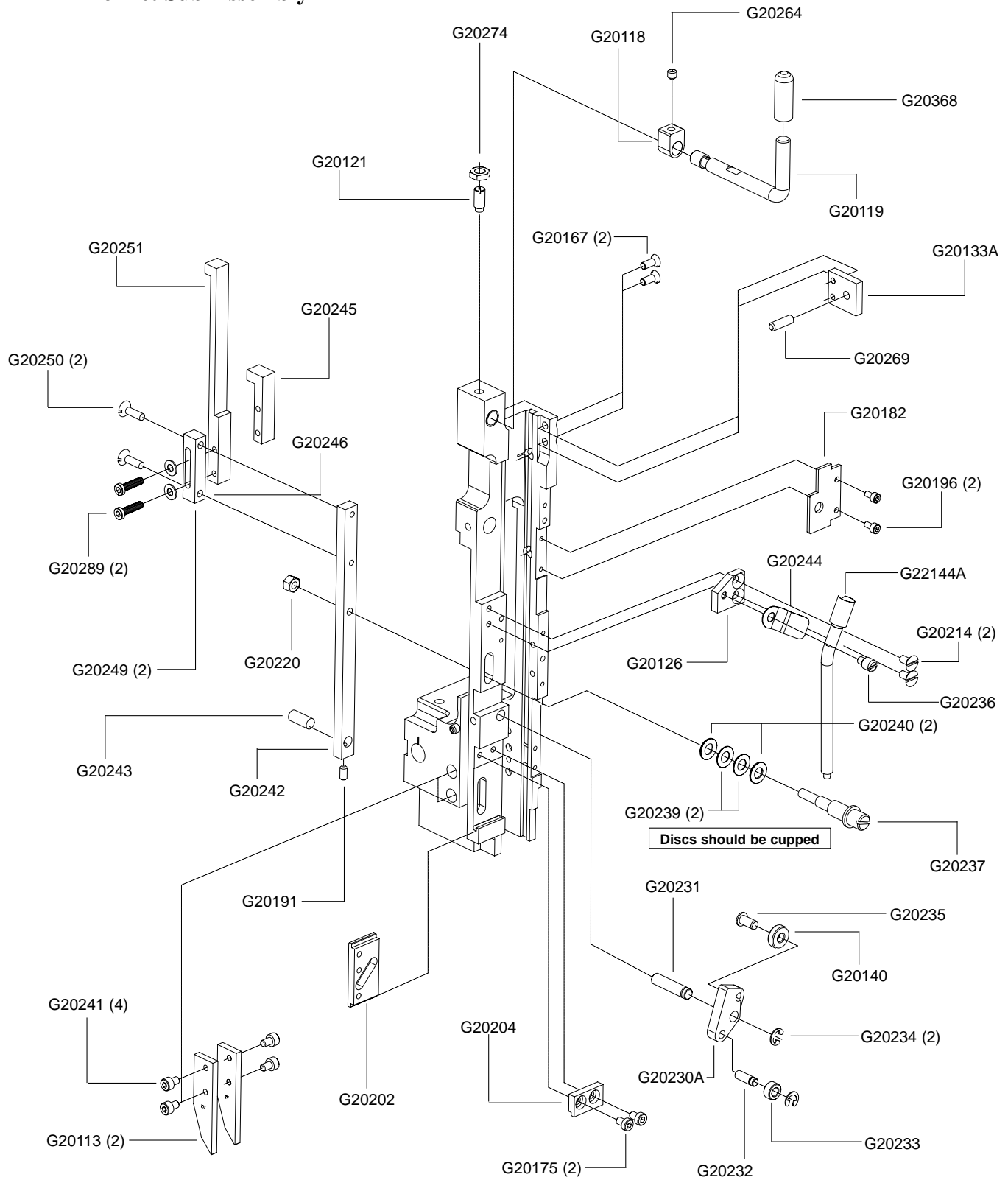


The G8 Stitcher Head

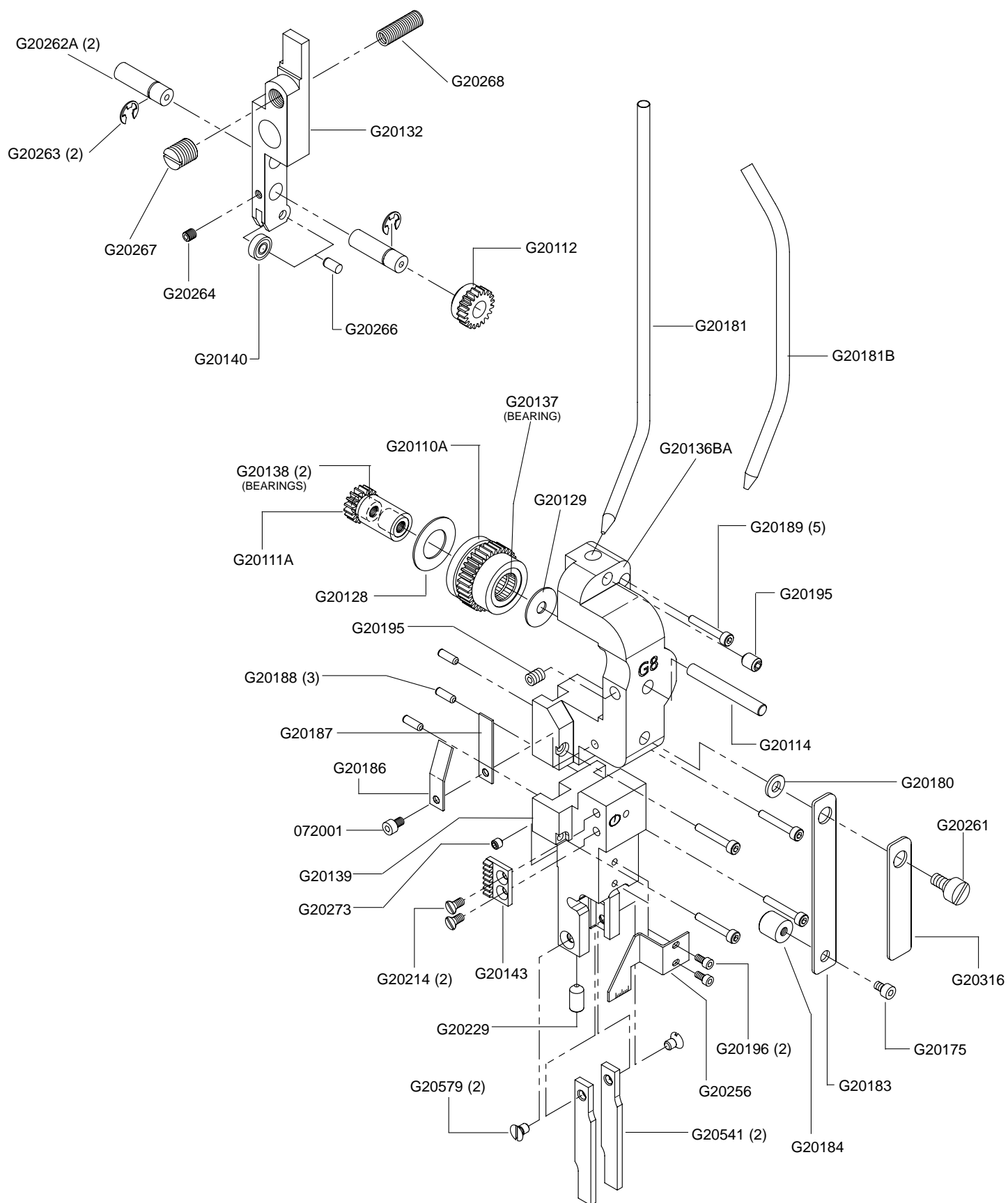




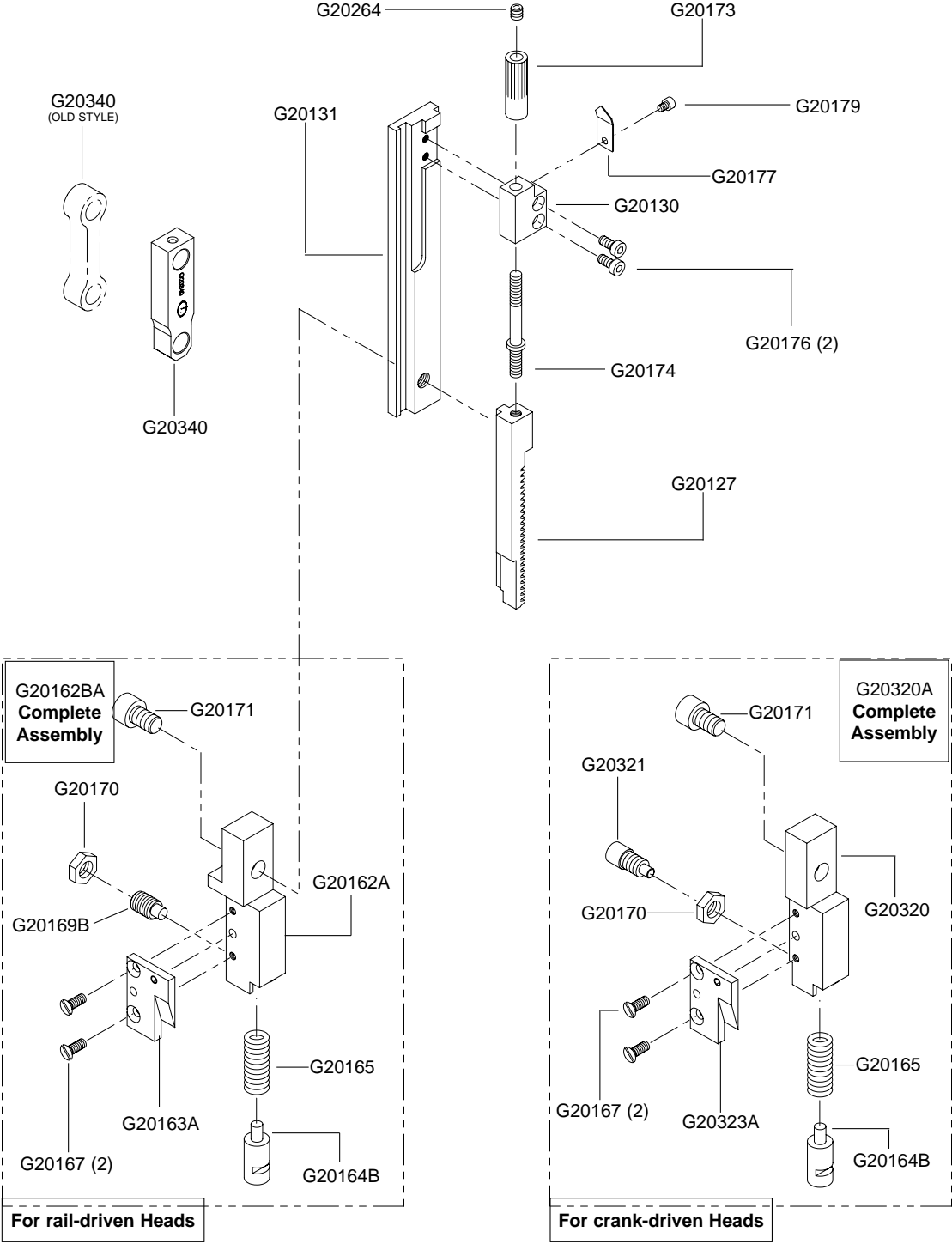
Bonnet Sub-Assembly



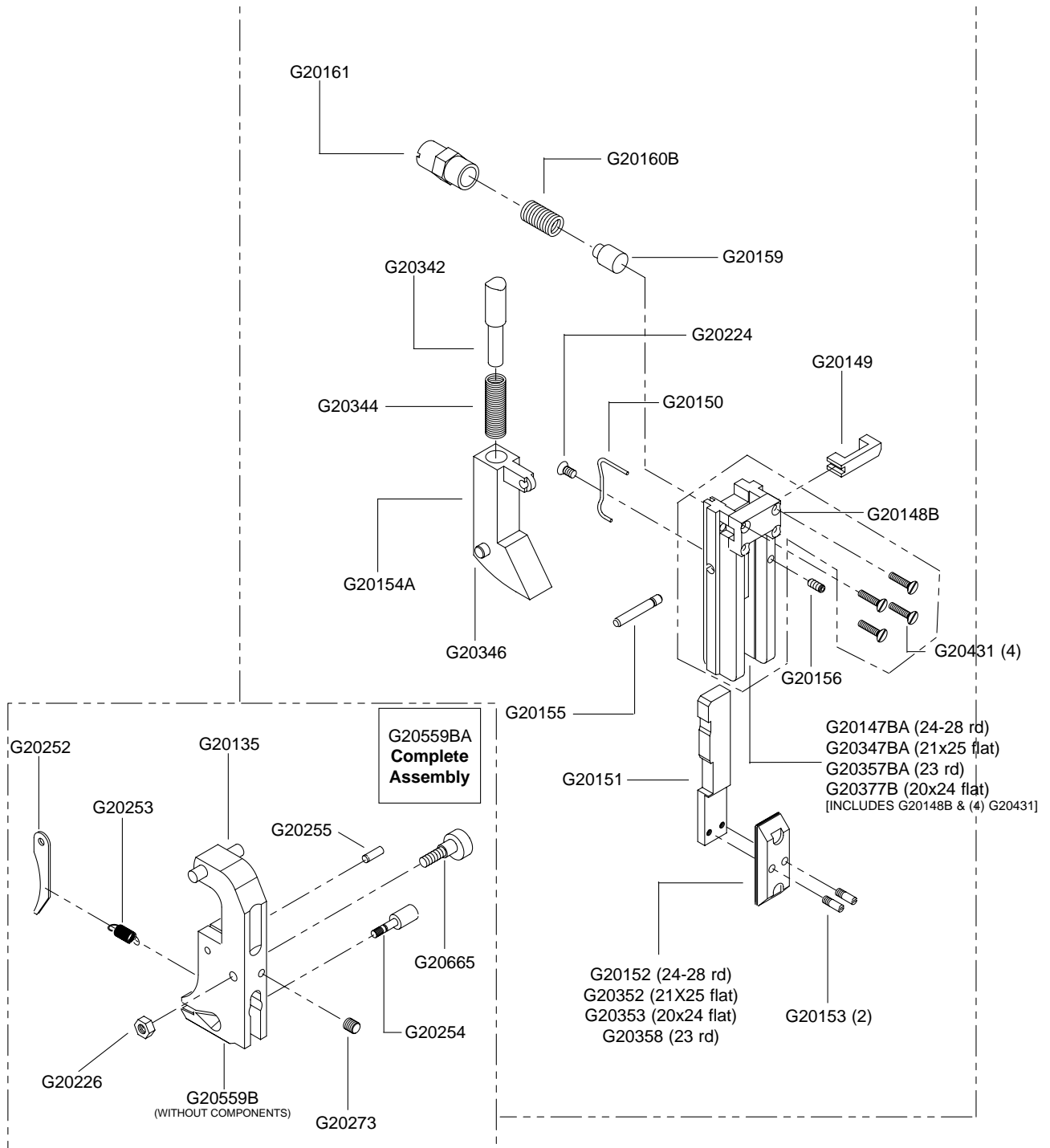
Feed Lever and Feed Gear Assemblies



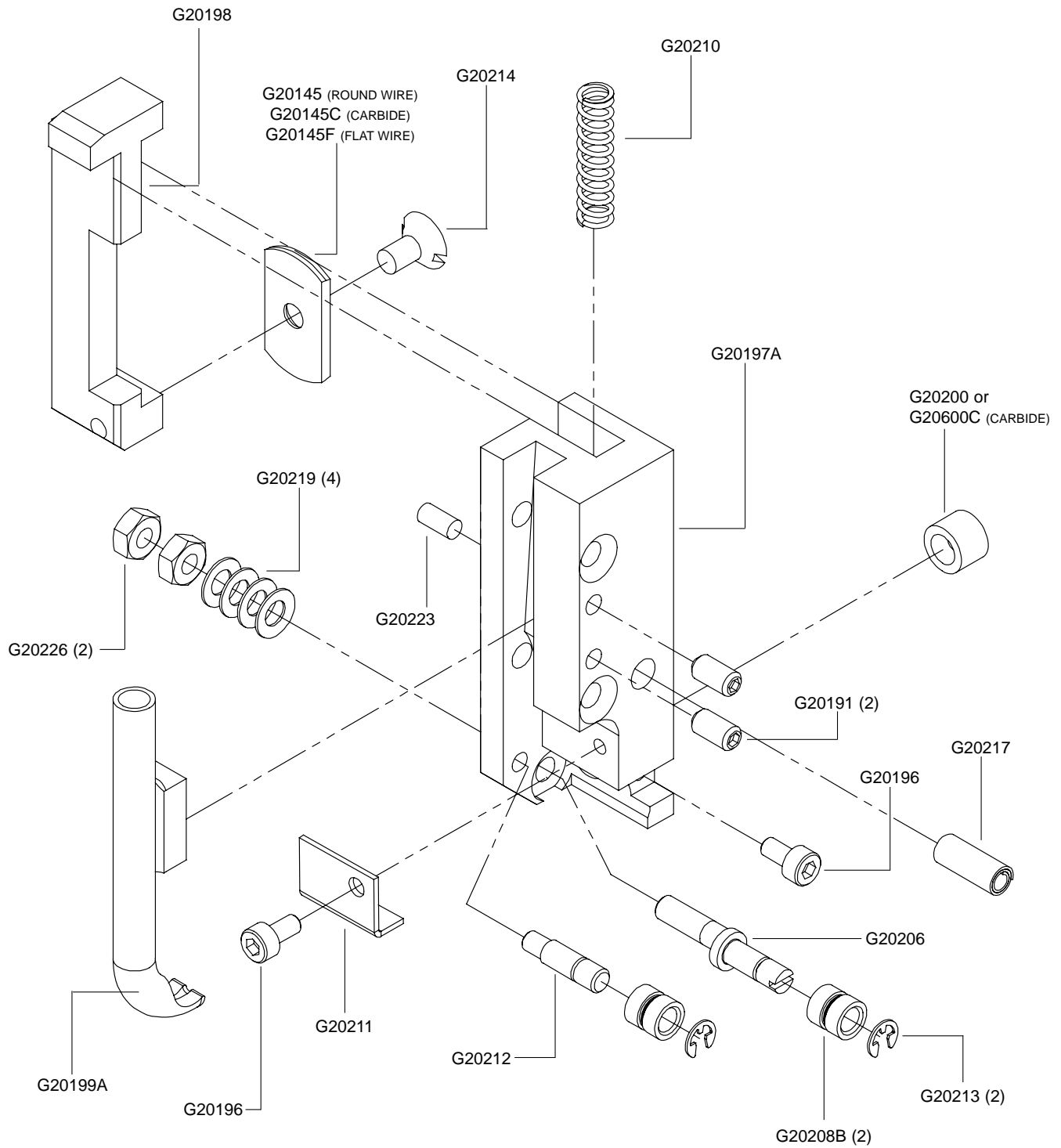
Driving and Feed Slide Assemblies



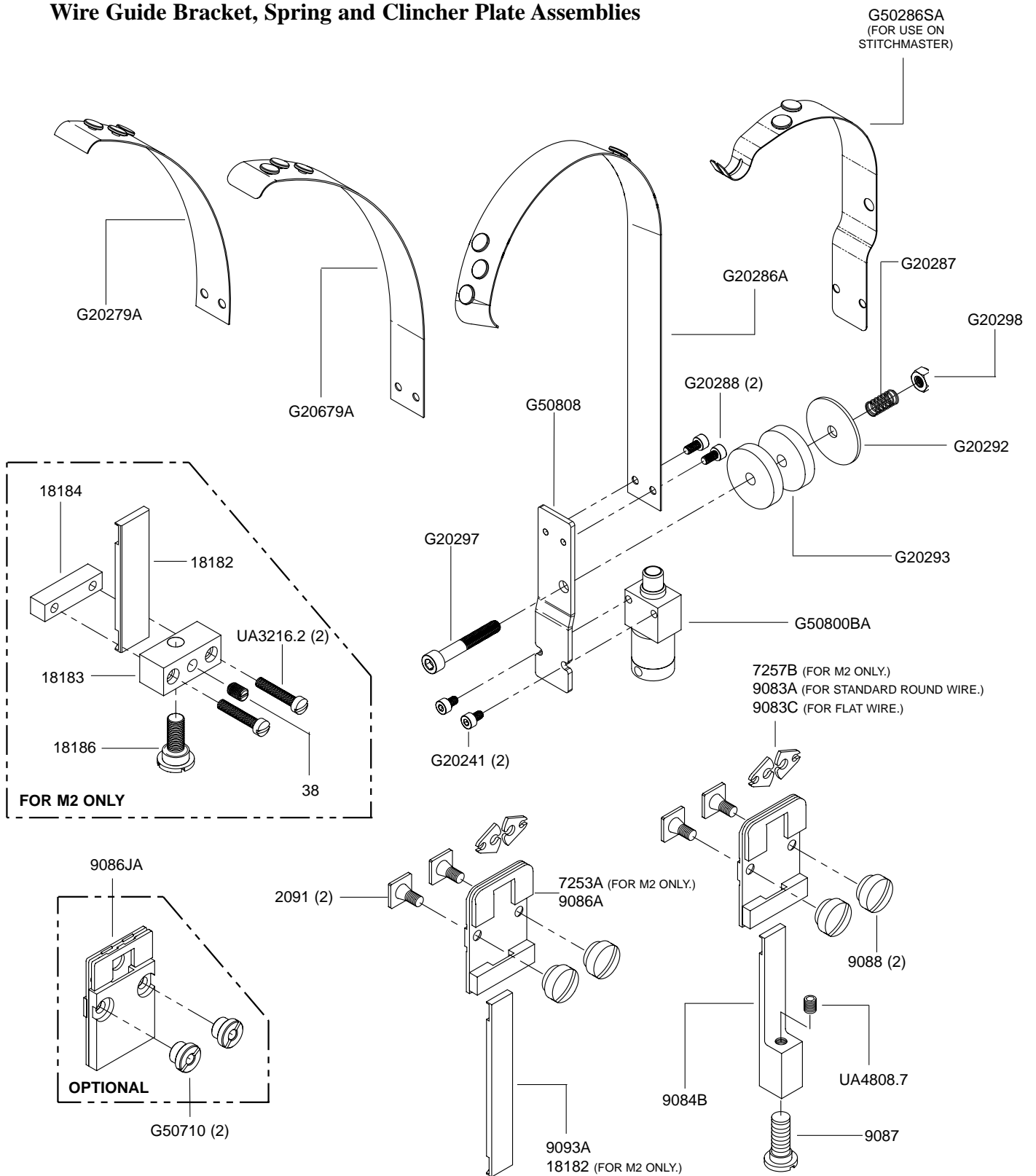
Bender Bar and Wire Holder Assemblies



Cutter Block Assembly

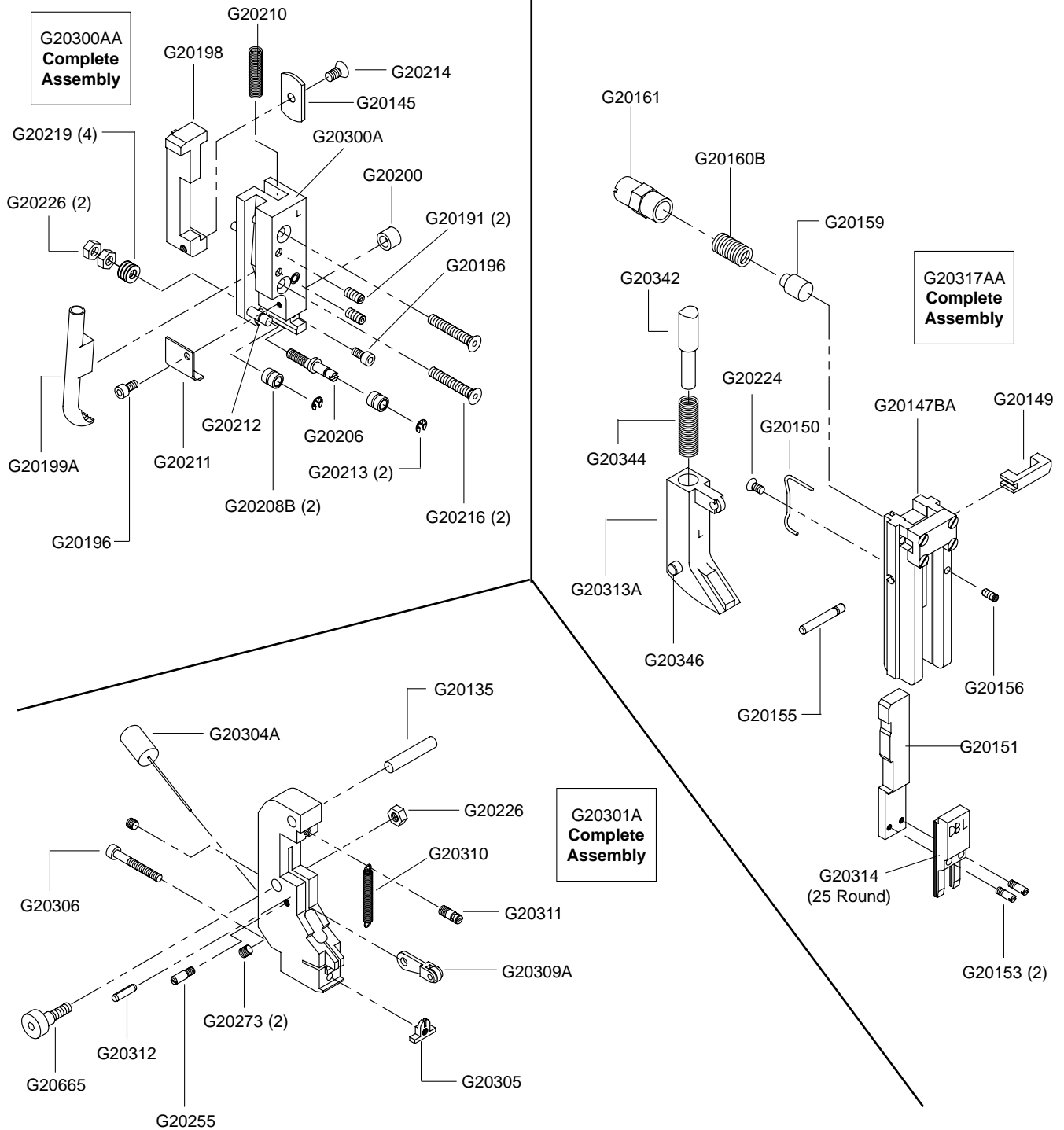


Wire Guide Bracket, Spring and Clincher Plate Assemblies



Loop Stitch Kit

G8KL Loop Conversion Kit includes all parts shown below.



Part Number / Description Cross-Reference

G20000A	Bonnet Assembly - G8	1	G20152	Driver, 24W	1
G20110A	Large Feed Gear Assembly	1	G20153	Driver Retaining Screw	2
G20111A	Feed Pinion Assembly	1	G20154A	Supporter Assembly	1
G20112	Small Feed Gear	1	G20155	Supporter Pivot Pin	1
G20113	Supporter Guide Plate	2	G20156	Supporter Pivot Pin Screw	1
G20114	Feed Pinion Shaft	1	G20159	Bender Bar Friction Plug	1
G20115	Latch Release Cam	1	G20160B	Bender Bar Friction Spring	1
G20118	Feed Release Handle Cam	1	G20161	Bender Bar Friction Bushing	1
G20119	Feed Release Handle	1	G20162	Driving Slide	1
G20121	Feed Release Plunger	1	G20162BA	Driving Slide Assembly Eccentric	1
G20122A	Feed Slide Retaining Screw Asy	2	G20163A	Cutter Operating Ramp Assembly	1
G20124	Bonnet Clamp Eccentric	1	G20164B	Driver Slide Plunger Eccentric	1
G20126	Tube Pivot Plate	1	G20165	Driving Slide Spring	1
G20127	Feed Rack	1	G20167	Screw, M4x.7x10 FHCS	4
G20128	Large Feed Gear Washer	1	G20169B	Driving Slide Plunger Screw Ecc	1
G20129	Small Feed Gear Washer	1	G20170	Hex Jam Nut M8x1.25	1
G20130	Feed Adjustment Block	1	G20171	Screw M8x1.25x12	1
G20131	Feed Slide	1	G20173	Feed Rack Knob - Knurled	1
G20132	Feed Lever	1	G20174	Feed Rack Adjustment Stud	1
G20133A	Feed Release Spring Block Assembly	1	G20175	Screw M4x.7x6 SHCS	3
G20135	Dowel Pin M5x24	1	G20176	Screw M4x.7x12 SHCS Low Head	2
G20136BA	Feed Gear Bracket Assembly	1	G20177	Feed Rack Adj Knob Pointer	1
G20137	Roller Clutch Bearing	1	G20179	Screw M3x.5x4, SHCS	1
G20138	Feed Pinion Bearing	2	G20180	Flat Washer M6	1
G20139	Pivot Block Insert	1	G20181	Upper Wire Tube	1
G20140	Follower Ball Bearing	1	G20182	Feed Gear Shaft Plate	1
G20143	Cutter Block Adjustment Rack	1	G20183	Wire Holder Retaining Spring - Long	1
G20144A	Middle Wire Tube Assembly	1	G20184	Wire Holder Retaining Spring Foot	1
G20145	Moving Cutter - Round Wire	1	G20186	Feed Gear Friction Spring	1
G20145C	Moving Cutter - Carbide	1	G20187	Feed Gear Friction Strip	1
G20145F	Moving Cutter - Flat Wire	1	G20188	Dowel Pin, 1/8"x3/8"	4
G20147BA	Bender Bar Assembly, 24W	1	G20189	Screw M3x.5x20	3
G20148B	Latch Housing, Removable	1	G20190	Screw M3x.5x10- FHMS- Slotted	4
G20149	Bender Bar Latch	1	G20191	Screw, M4x.7x8 SHSS	5
G20150	Bender Bar Latch Spring	1	G20195	Set Screw M6x1x8	2
G20151	Driver Bar	1	G20196	Screw M3x.5x6 SHCS	8

Part Number / Description Cross-Reference

G20197A	Cutter Block Assembly	1	G20245	Cutter Adjustment Bar - Upper	1
G20198	Cutter Operating Slide	1	G20246	Cutter Block Adjustment Connect	1
G20199A	Lower Wire Tube Assembly	1	G20249	Cutter Block Washer	2
G20200	Fixed Wire Cutter	1	G20250	Screw M4x.7x14	2
G20202	Cutter Block Slide Plate	1	G20251	Cutter Adjustment Bar - Upper	1
G20204	Upper Cutter Block Guide	1	G20252	Wire Hook	1
G20206	Wire Straightener Eccentric	1	G20253	Wire Hook Spring	1
G20208B	Wire Straightener Roller	2	G20254	Wire Hook Spring Screw	1
G20210	Cutter Operating Spring	1	G20255	Hook Pivot Pin	1
G20211	Cutter Wire Shield	1	G20256	Cutter Block Scale	1
G20212	Wire Straightener Roll Stud	1	G20261	Wire Holder Retaining Spring Screw	1
G20213	Wire Straightener Roll Clip	2	G20262A	Feed Lever Pin Assembly	2
G20214	Screw M4x0.7x8 FHMS	5	G20263	Feed Lever E-Ring	2
G20216	Screw M4x.7x25 SFHS	2	G20264	Screw M5x.8x5 SHCS	5
G20217	Spirol Pin M5x12	1	G20266	Follower Bearing Pin	1
G20219	Wire Straightener Disc Spring	4	G20267	Feed Lever Bushing	1
G20220	Hex Nut M5x.8	1	G20268	Feed Lever Spring	1
G20223	Dowel Pin 1/8x1/4	1	G20269	Spirol Pin 3/16x5/8	1
G20224	Bender Bar Latch Spring Screw	1	G20273	Screw M4x.7x4 SHSS	2
G20226	Hex Nut M4x.7	2	G20274	Hex Jam Nut, M6x1	1
G20228A	Adjustment Handle Assembly	1	G20275	Ball Spring Plunger	1
G20229	Set Screw M6x1x12	2	G20279A	Wire Guide Spring Assembly - Short	1
G20230A	Cutter Operating Lever Assembly	1	G20286A	Wire Guide Spring Assembly - Long	1
G20231	Cutter Operating Lever Pivot Pin	1	G20287	Wire Oiler Felt Spring	1
G20232	Cutter Operating Lever Roll Pin	1	G20288	Screw, M4x.7x8 SHCS	4
G20233	Cutter Operating Lever Roller	1	G20289	Screw M4x.7x16	2
G20234	E-Ring- 3/16"	1	G20292	Wire Oil Felt Washer	1
G20235	Follower Bearing Shaft	1	G20293	Wire Oiler Felt	1
G20236	Tube Pivot Screw	1	G20297	Screw, M6x1x40 SHCS	1
G20237	Cutter Block Adjustment Stud	1	G20298	Nylock Lock Nut, M6x1	1
G20239	Disc Washer Spring	2	G20300A	Cutter Block Assembly - Loop	1
G20240	Cutter Block Adjustment Washer	2	G20301A	Wire Holder Assembly - Loop	1
G20241	Screw M4x0.7x6 SHCS	4	G20304A	Wire Hook Assembly - Loop	1
G20242	Cutter Adjustment Bar - Lower	1	G20305	Anvil - Loop	1
G20243	Dowel Pin 1/4x9/16	1	G20306	Screw M3x.5x25-SHC	1
G20244	Tube Pivot Clip	1	G20309A	Wire Holder Lever Assembly - Loop	1

Part Number / Description Cross-Reference

G20310	Wire Holder Roller Lever Spring	1	G20559BA	Wire Holder Assembly 1/2	1
G20311	Spring Anchor Screw	1	G20579	Screw, M4x0.7x6-FHM-Slotted	2
G20312	Spirol Pin M3x12	1	G20600C	Fixed Cutter - Carbide	1
G20313A	Supporter Assembly - Loop	1	G20665	Wire Holder Eccentric Adj Screw	1
G20314	Driver - Loop	1	G20679A	Wire Guide Spring Assembly-Medium	1
G20316	Wire Holder Retaining Spring - Short	1	G50286SA	Wire Guide Spring Assembly-Short	1
G20320	Driving Slide - Crank Drive	1	G50394	Flat Washer - M8	1
G20320A	Driving Slide Assembly	1	G50710	Clincher Plate Nut	2
G20321	Crank Link Screw	1	G50716	Mounting Block Handle	1
G20323A	Cutter Operating Ramp Assembly	1	G50800BA	Anti-Wire Backup Unit	1
G20340	Crank Drive Link	1	G50808	Wire Spring Guide Clamp Plate	1
G20341	Rear Mounting Bolt	1	HN1213	Bonnet Stud Nut	1
G20342	Supporter Spring Plunger	1	UA3216.2	Clincher Slide Block Screw	2
G20344	Supporter Spring	1	UA4808.7	Set Screw, 1/4-28x1/2", SH	1
G20344B	Supporter Spring - Heavy	1	072001	Screw M4x0.7x8	1
G20346	Supporter Guide Pin	1	18182	Clincher Slide	1
G20347BA	Bender Bar Assembly, 21x25	1	18183	Clincher Slide Adjustment Block	1
G20352	Driver, 21x25W	1	18184	Clincher Slide Block Clamp	1
G20353	Driver, 20x24W	1	18186	Clincher Slide Adjustment Screw	1
G20357BA	Bender Bar Assembly, 23W	1	2091	Clincher Plate Binder Nut	2
G20358	Driver, 23W	1	38	Clincher Slide Adjustment Screw	1
G20360	Hex Key Wrench 3.0mm	1	7253A	Clincher Plate Assembly - 1/2	1
G20361	Hex Key Wrench 2.5mm	1	7257B	Clincher Point - Round	2
G20362	Clamp Wrench 5.0mm	1	9002	Bonnet Clamp Block	1
G20364	Open End Wrench	1	9083A	Clincher Point - Thick, Round	2
G20366	Rear Clamp Pin	1	9083C	Clincher Point - 20x24, Flat	2
G20367	Rear Mounting Bolt	1	9084B	Adjustable Clincher Slide	1
G20368	Feed Release Handle Cap	1	9086A	Clincher Plate - Thick	1
G20374	Hex Key Wrench 2.0mm	1	9086JA	Clincher Plate - Thick	1
G20377B	Bender Bar, 20x24W	1	9087	Clincher Slide Adjusting Screw	1
G20431	Screw, M2.5x.45x12	4	9088	Clincher Plate Binder Bolt	2
G20541	Wire Guide Bar	2	9093A	Clincher Slide - Thick	1

Optional Equipment

In addition to the standard features offered with the G8 Stitcher Head, optional equipment items can be purchased to better accommodate your stitching needs. The following kits can be purchased from your Graphic Arts Representative.

G8KC

The G8 Crank Drive Kit is available to owners of all styles of rail-driven G8 Heads who need to convert, for whatever reason, their existing G8 head to a crank-driven model. Included in this Kit are the Rear Clamp Pin, Rear Mounting Bolt, Bonnet Stud Nut, the Crank Drive Link and a complete assembly of the Link-Driven Driving Slide.

For more information about purchasing the G8KC or for technical support when making the conversion from rail-driven to crank-driven, contact your local Graphic Arts Representative.

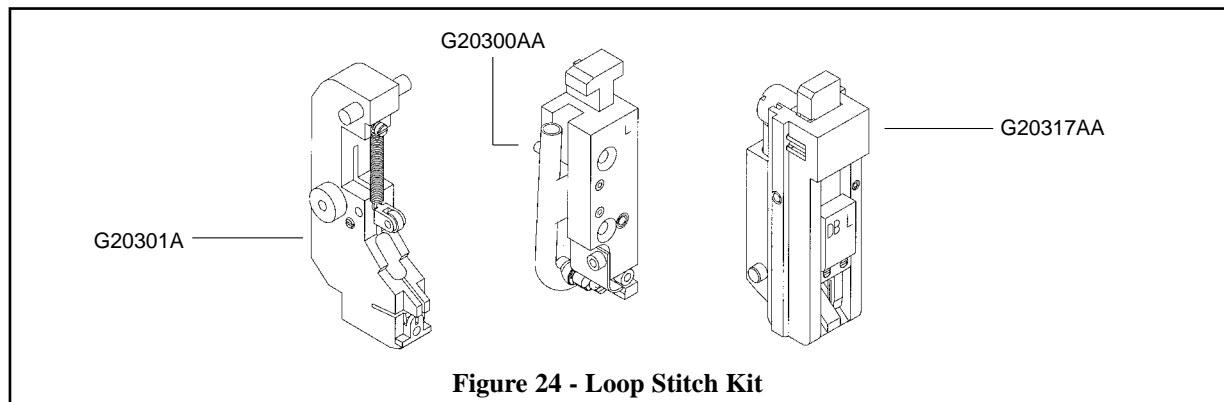
Always disconnect the power supply before making any adjustments or servicing the head.

⚠ WARNING

G8KL-Loop Stitch Conversion Kit

The standard G8 Head with 24 gauge wire can be converted to a Loop style by exchanging the following three sub-assemblies: the Wire Holder Assembly, the Cutter Block Assembly and the Bender Bar Assembly. Refer back to pages 23 through 28 for complete disassembly and reassembly instructions.

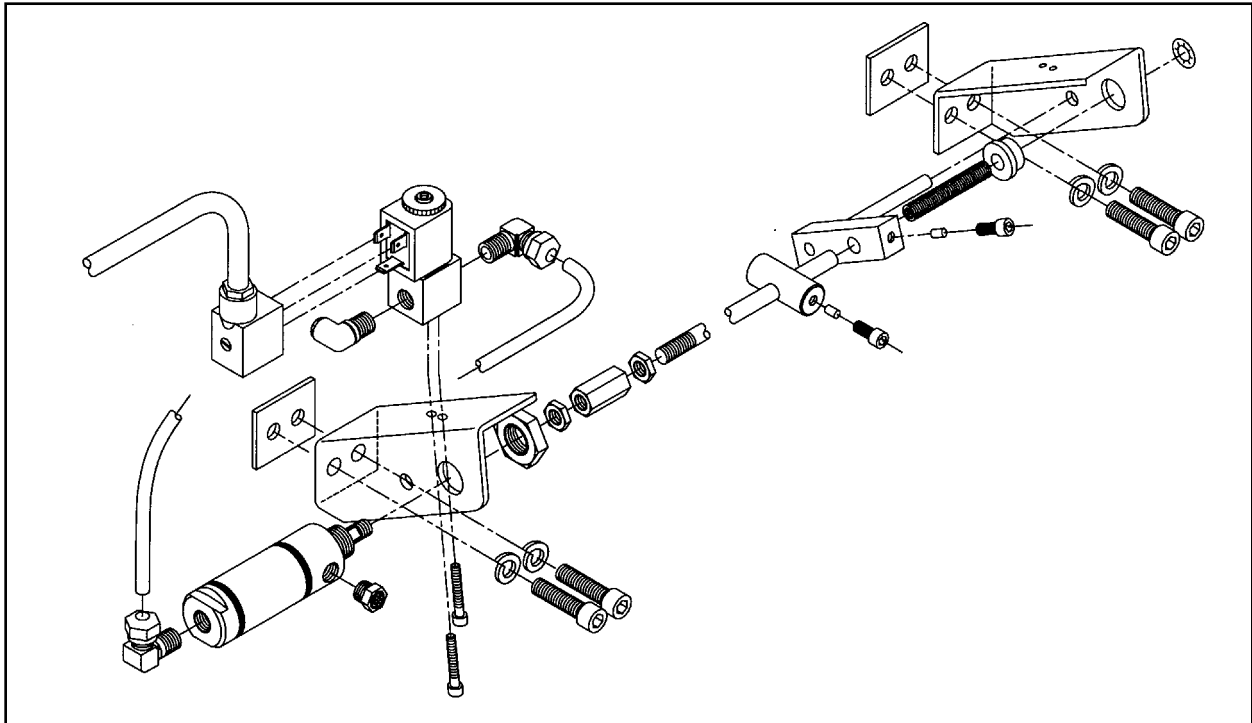
Contact your DeLuxe Stitcher Graphic Arts Representative or the DeLuxe Stitcher Customer Service Department for ordering information or for additional technical information on other wire sizes available in Loop Stitch.



G8KS-Stop Stitch Kit

The G8KS mounts on the Adjustment Rail of McCain Saddle Stitchers. It stops the feeding of wire through the Stitcher Heads by pushing open the Feed Release Handles (stopping the stitch) when it receives a signal from the calipers of the Stitcher.

The G8KS Stop Stitch Kit comes complete with all the components necessary for converting your existing stitcher machine, along with fully illustrated instructions. Call your Graphic Arts Representative for more information.



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

⚠ WARNING

G8KT-Stop Stitch Toggle Kit

The G8KT is a Stop Stitch Toggle Kit specifically designed for users of McCain Stitchers using both 26/26D and G8 Stitcher Heads.

The Electrical Box, Box Cover and Toggle Switch replace your machine's existing equipment to make switching between the two styles of Stitcher Heads easier. This Kit comes complete with a wiring diagram and replacement electrical box. For more information or technical support, contact your local Graphic Arts Representative.

LIMITED WARRANTY

DeLuxe Stitcher Company warrants to the original retail purchaser that this product is free from defects in material and workmanship and agrees to repair or replace, at DeLuxe Stitcher's option, any defective product within 90 days from the date of purchase. This warranty is not transferable. It covers damage resulting only from defects in material or workmanship and does not cover conditions or malfunctions resulting from normal wear, neglect, abuse or accident.

This warranty is in lieu of all other express warranties. Any warranty of merchantability or fitness for a particular purpose is limited to the duration of this warranty. DeLuxe Stitcher shall not be liable for any incidental or consequential damages.

Some states do not allow limitations on how long an implied warranty lasts, or the exclusion or limitation of incidental or consequential damages, so the above limitations or exclusions may not apply to you. This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

To obtain warranty service you must return the product, at your expense, together with proof of purchase to an authorized DeLuxe Stitcher Company Graphic Arts Dealer.

Always use genuine DeLuxe Stitcher parts. When ordering parts, please identify the part number, the part name, the wire size and crown size of your Stitcher.

DeLuxe Stitcher Company, Inc.
6635 West Irving Park Road
Chicago, Illinois 60634-2410
Phone: 773-777-6500 800-634-0810
Fax: 773-777-0156 800-417-9251
E-mail: info@deluxestitcher.com
Web Site: <http://www.deluxestitcher.com>

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.

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 : _____

REGISTRATION

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

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 : _____

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 G8 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 38-40 in this manual.

Description	Item Number
Clincher Point - Thick, Round	9083A
Latch Release Cam	G20115
Feed Slide Retain Screw Asy	G20122A
Follower Ball Bearing	G20140
Moving Wire Cutter	G20145
Bender Bar Latch	G20149
Bender Bar Latch Spring	G20150
Driver Bar	G20151
Driver, 24W	G20152
Driver Retaining Screw	G20153
Bender Bar Friction Plug	G20159
Bender Bar Friction Spring	G20160B
Wire Holder Retaining Spring Foot	G20184
Feed Gear Friction Strip	G20187
Fixed Wire Cutter	G20200
Wire Hook	G20252
Hook Pivot Pin	G20255

PLACE
STAMP
HERE

DELUXE STITCHER
COMPANY INC.
6635 West Irving Park Road
Chicago, Illinois 60634-2410 U.S.A.
Attn: Customer Service

* You can purchase the G8RPK which includes these and other common replacement parts.

