



DELUXE STITCHER

C O M P A N Y I N C .

Head Serial Number : _____

Date Purchased : _____

Where Installed: _____

(make/model of machine)

G5 Stitcher Head

Watkiss Edition

OPERATION AND MAINTENANCE MANUAL

Wire Sizes: 25 Ga. Round (0.52 mm)

Crown Sizes: 1/2" (12.7 mm) and 5/8" (15.9 mm)

Capacity: 2 sheets to 13/64" (5 mm)

Before using this Stitcher Head, all operators must study this manual and follow the safety warnings and instructions. Keep these instructions with the G5 Stitcher Head for future reference. If you have any questions, contact your local DeLuxe Stitcher Graphic Arts Representative or Distributor.

THANK YOU FOR CHOOSING THE
G5 STITCHER HEAD
FOR YOUR BINDING NEEDS.



Specifications

Weight

Shipping Weight..... 8.0 lbs (3.6 kg)

Physical Dimensions

Height 10-3/4" (26.3 cm)

Width..... 2" (5.1 cm)

Stitching Capacity Two Sheets to 5mm (3/16")

Wire Type 25 round (0.52 mm max)

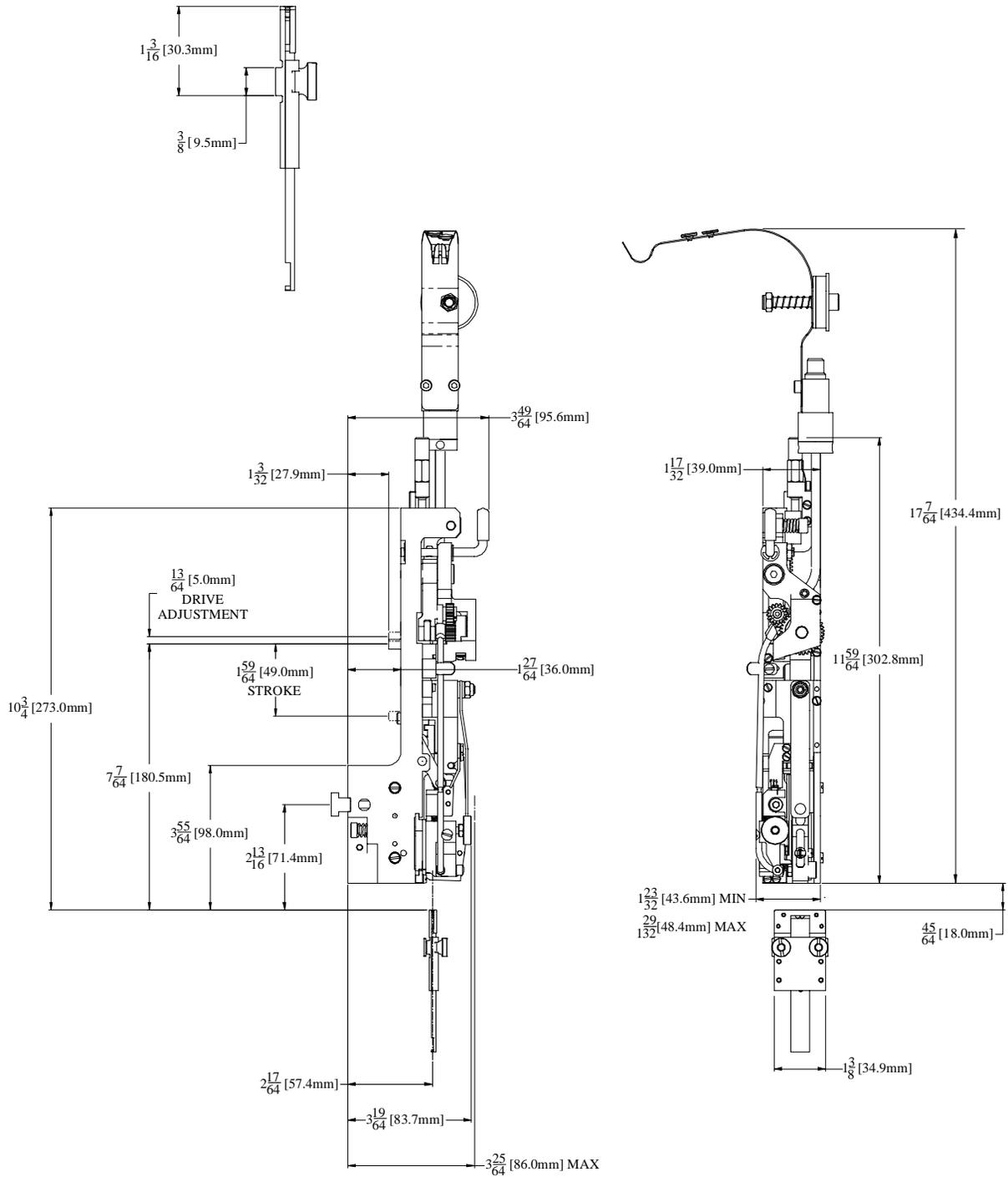
Crown Sizes..... 1/2" (12mm), 13/64" (5mm) Loop

Minimum Head Center..... 1-1/2" (39mm)

Stitches Per Hour..... 10,000 max.

Replacement for: DeLuxe Stitcher 26/26D heads as well as Hohner 43/6, 48/5, 52/8 and 55/7 heads and Acme, Champion, Interlake, ISP and Magnatek heads

Dimensions



Installation

Contents

- G5 Watkiss Edition Manual
- Bag of Tools with 2.0 mm, 3.0 mm & 7.0mm Open End Wrenches
- T-Handle Hex Head Wrench - 4 mm
- Head Mounting Key
- Clincher Plate, Points, Slide, Nuts & Studs
- Clincher Alignment Gauge
- Wire Guide Spring and Wire Anti-Backup Unit
- Manual Feed Gear Tool
- Stitch Samples

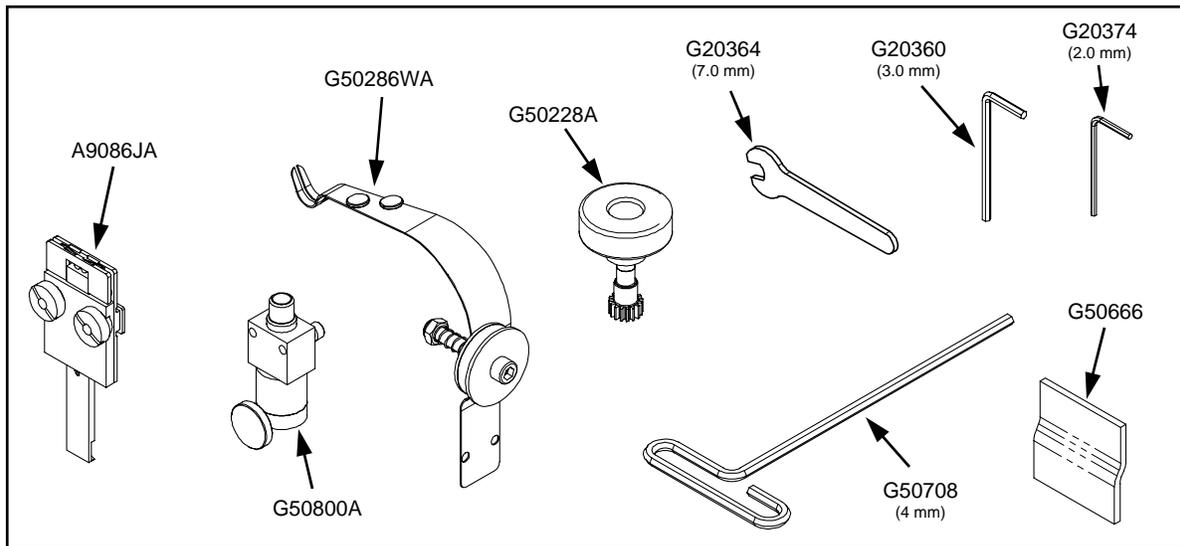
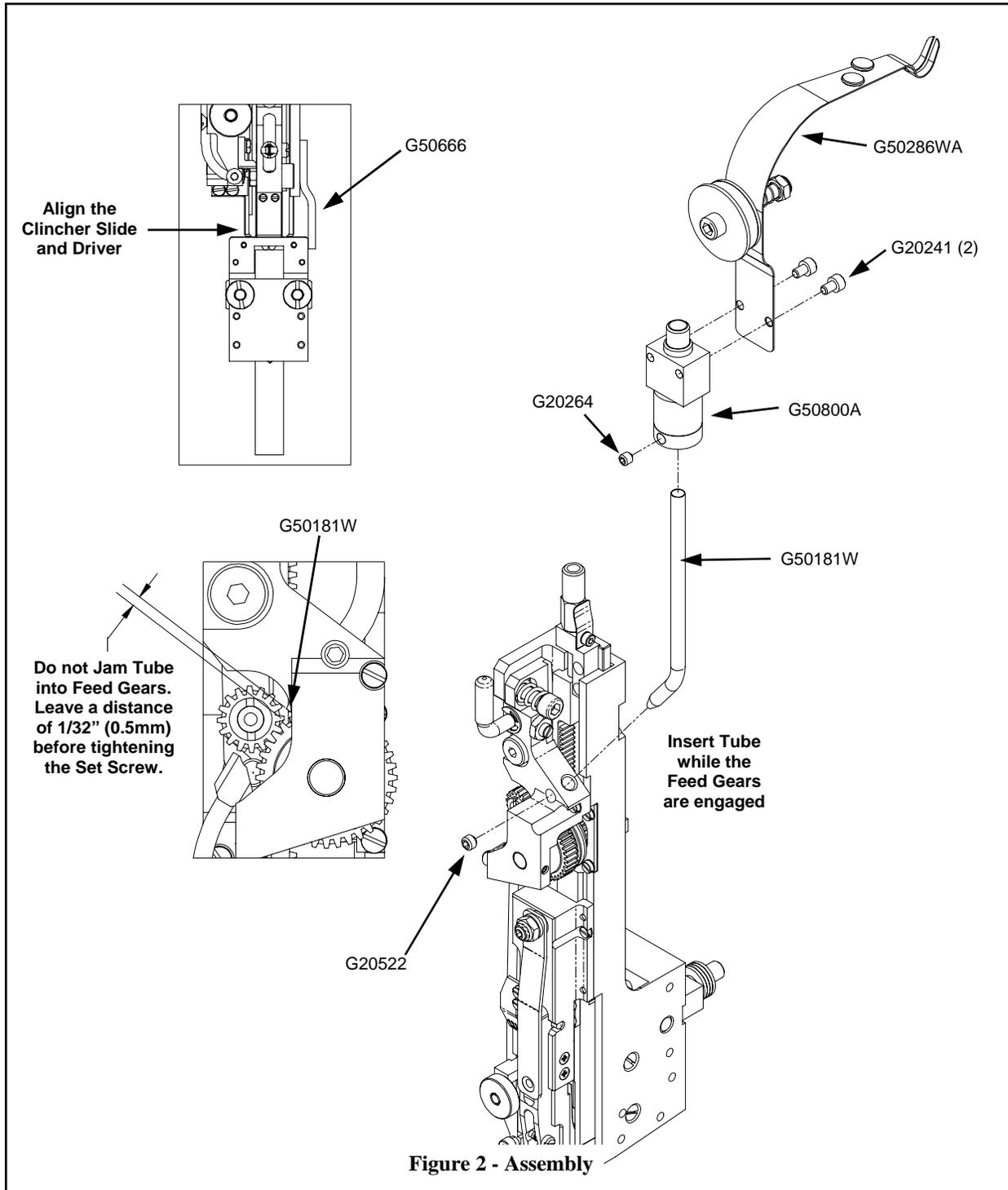


Figure 1 - Parts Package Contents

Assembly (Figures 2 - 4)



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

⚠ WARNING

Mounting (Figures 3)

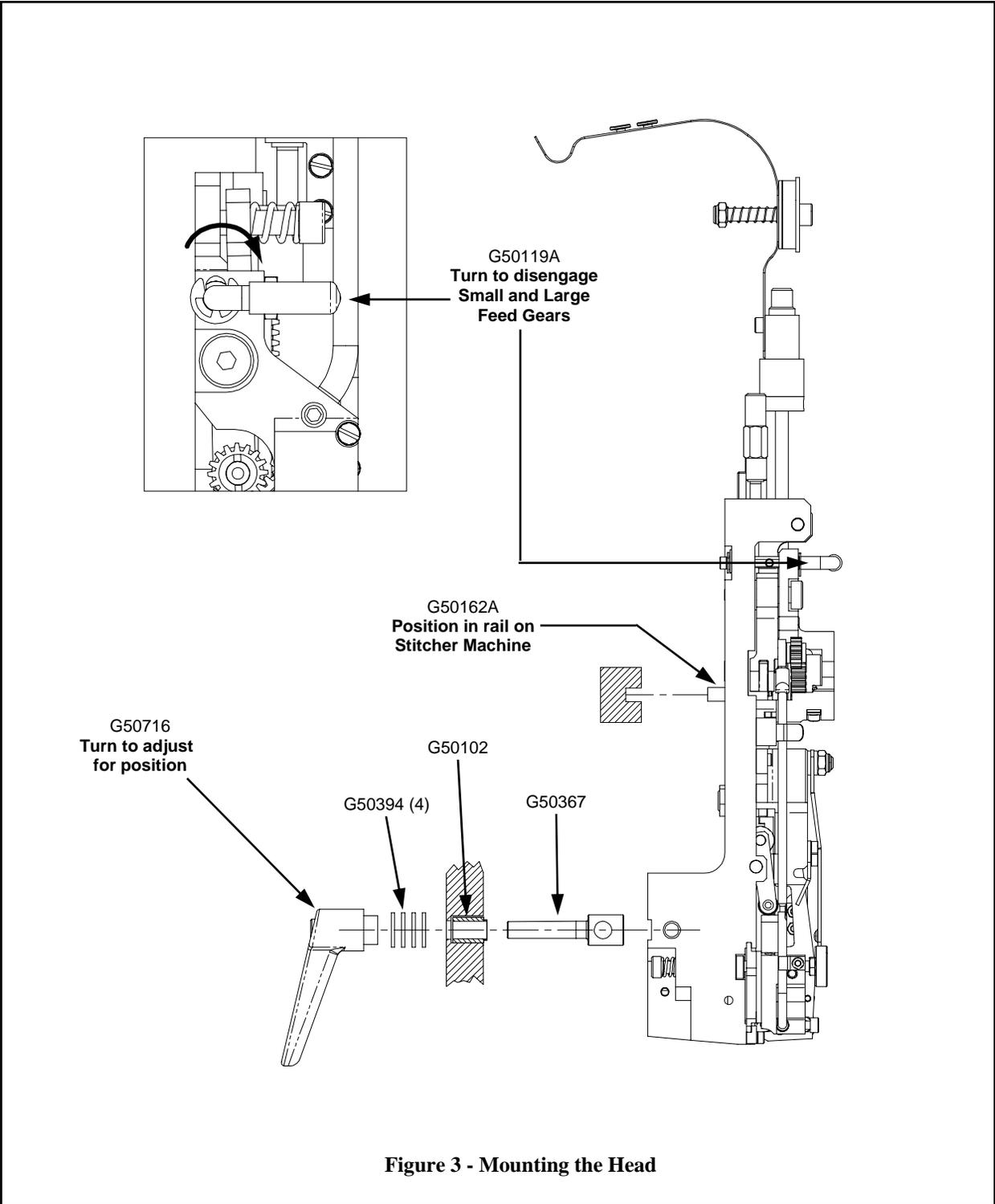
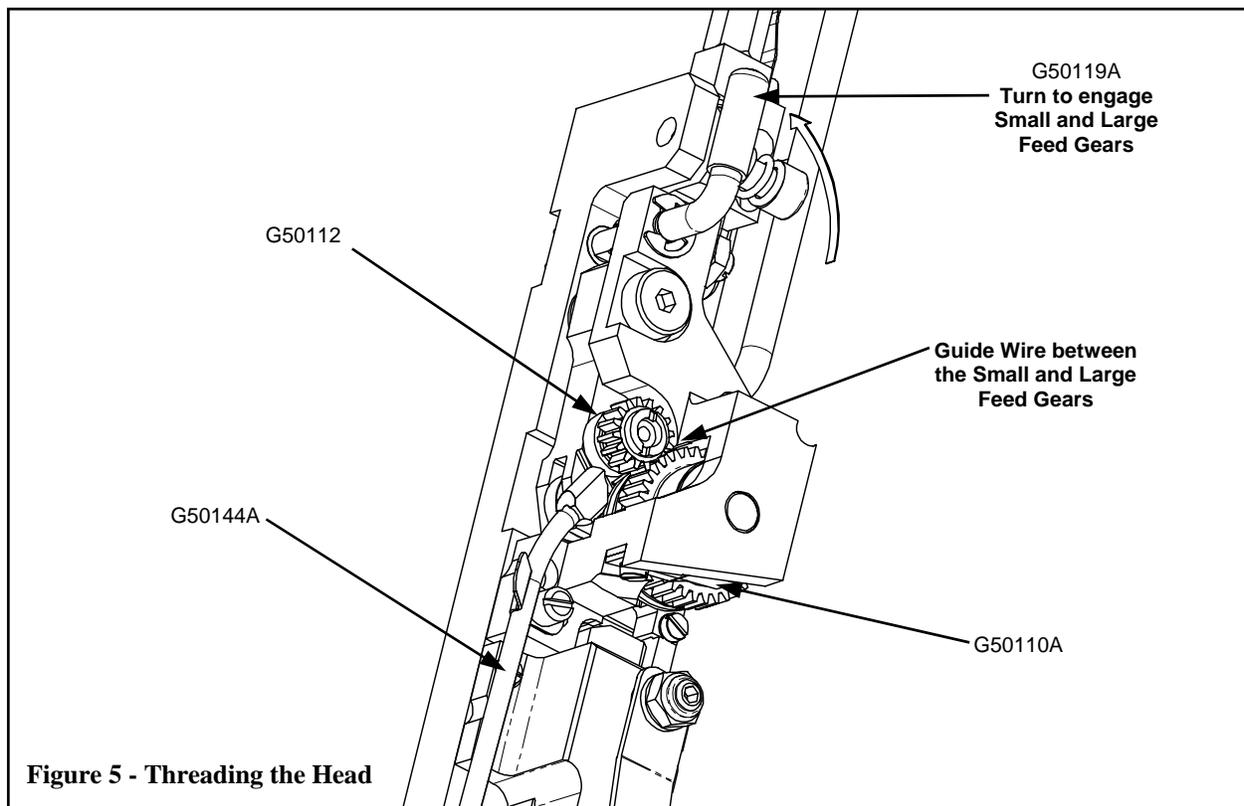
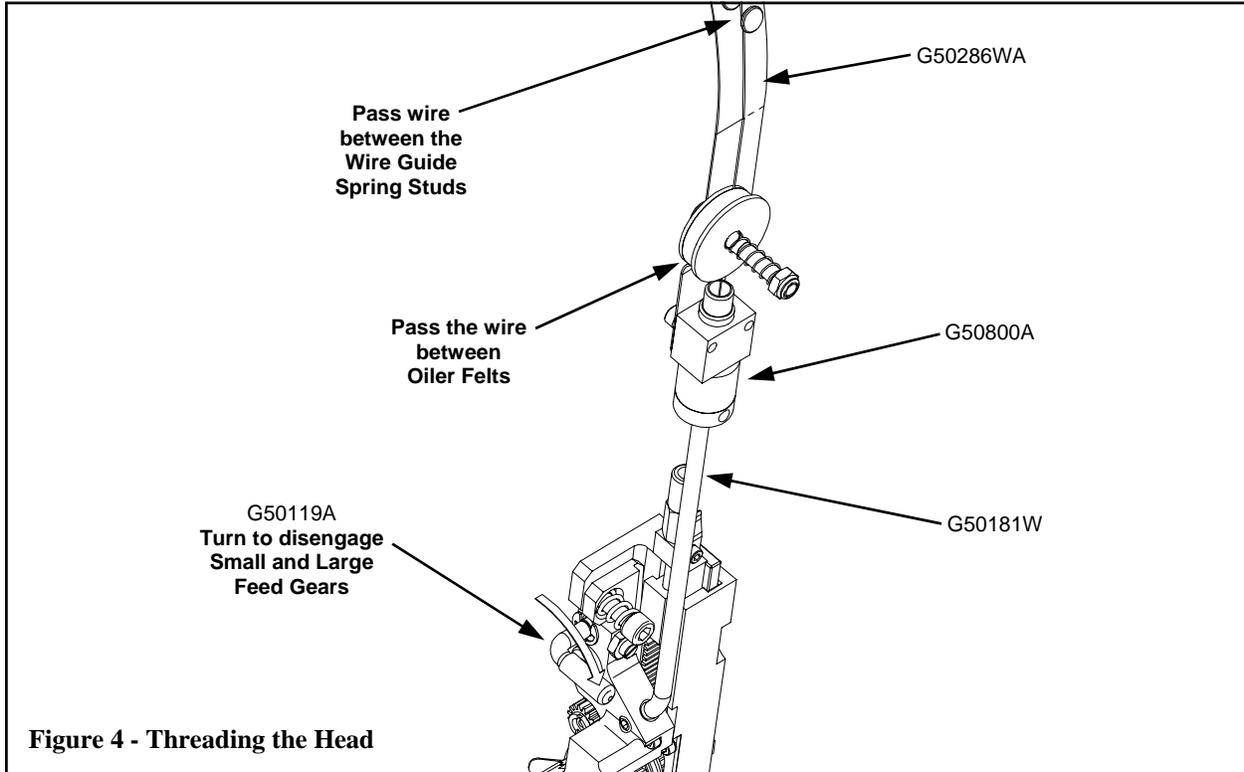
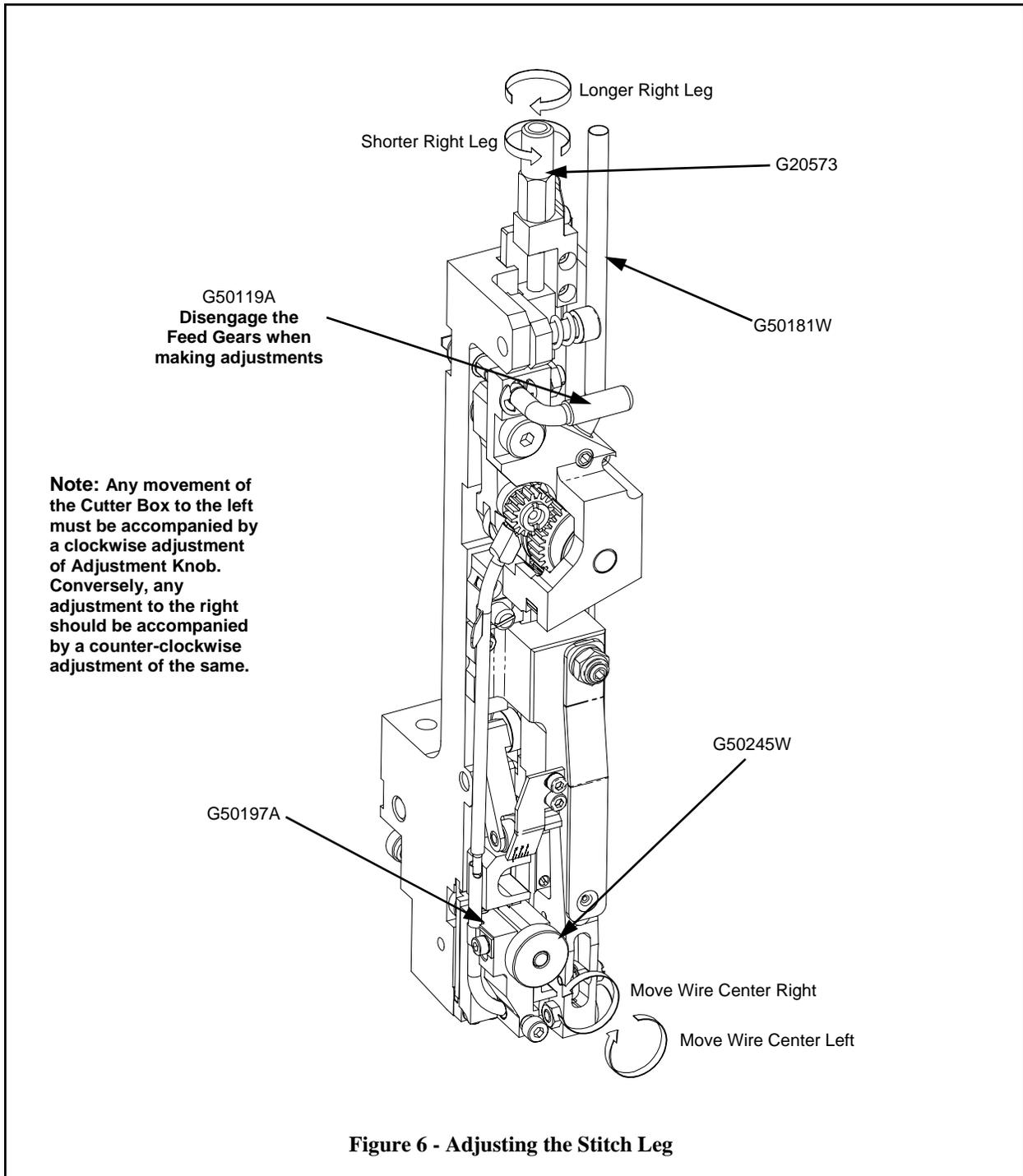


Figure 3 - Mounting the Head

Wire Threading (Figures 4 & 5)



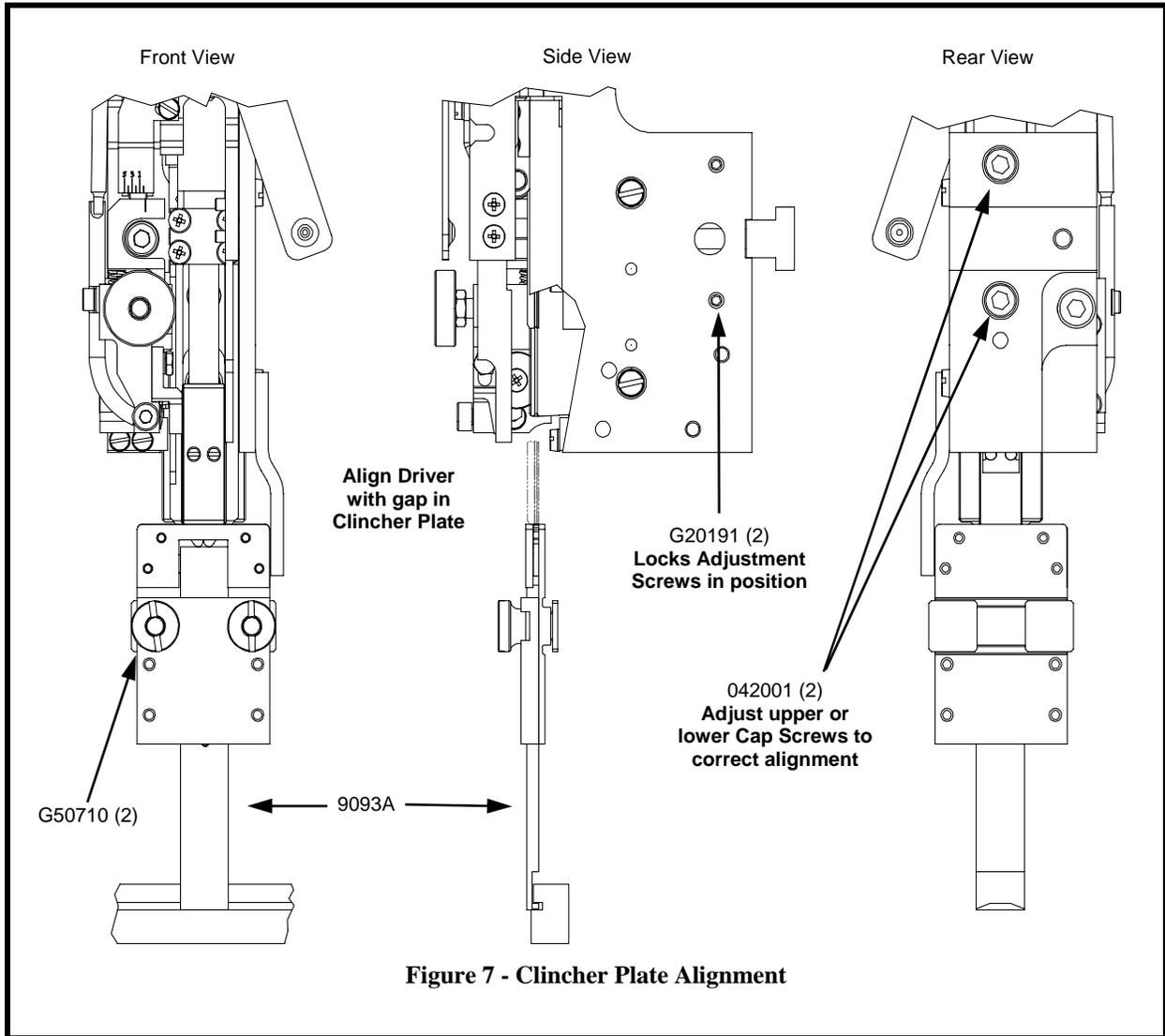
Adjust the Length of the Stitch Leg (Figure 6)



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

⚠ WARNING

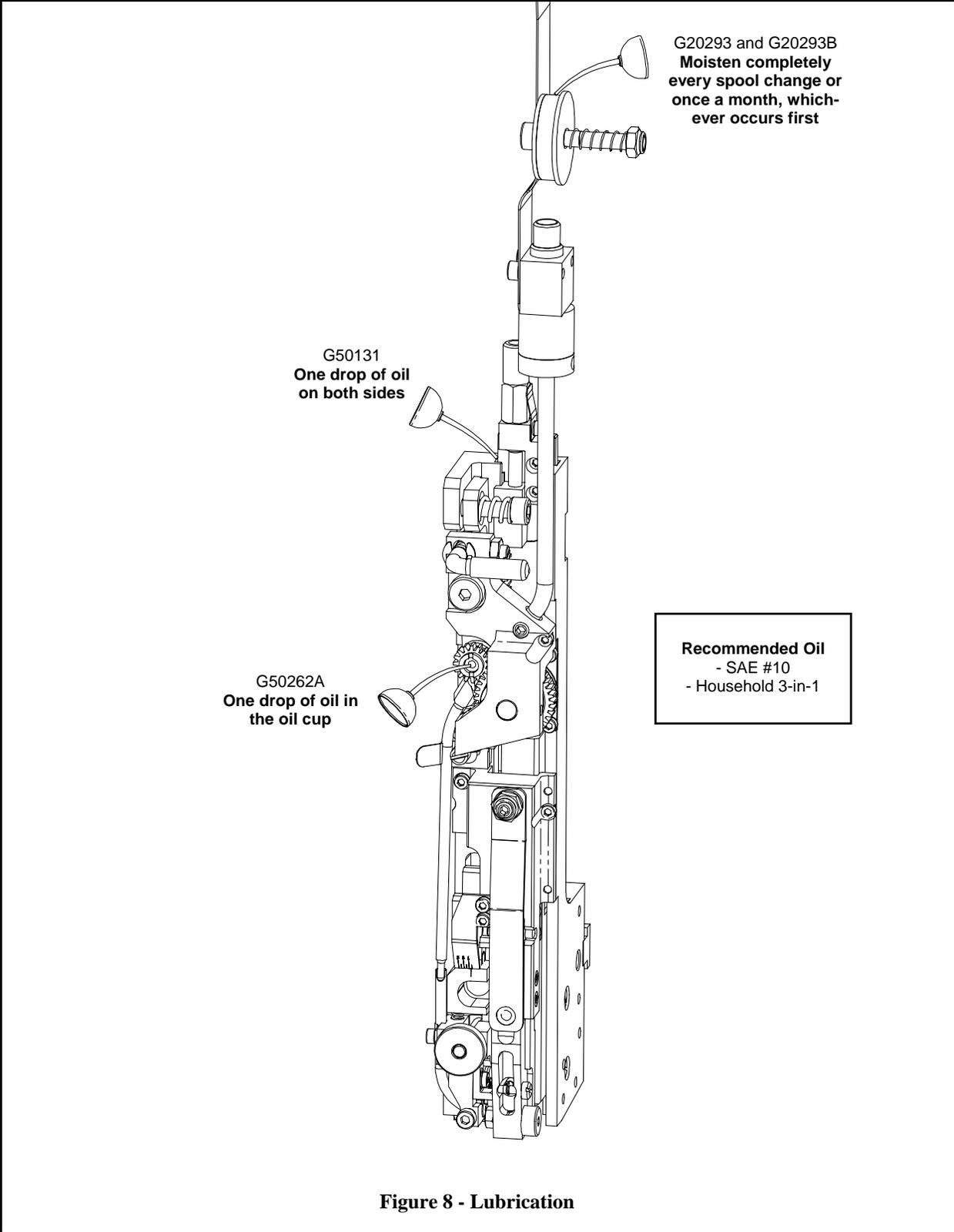
Aligning the Clincher Plate (Figure 7)



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

⚠ WARNING

Lubrication (Figures 8)



G20293 and G20293B
Moisten completely every spool change or once a month, whichever occurs first

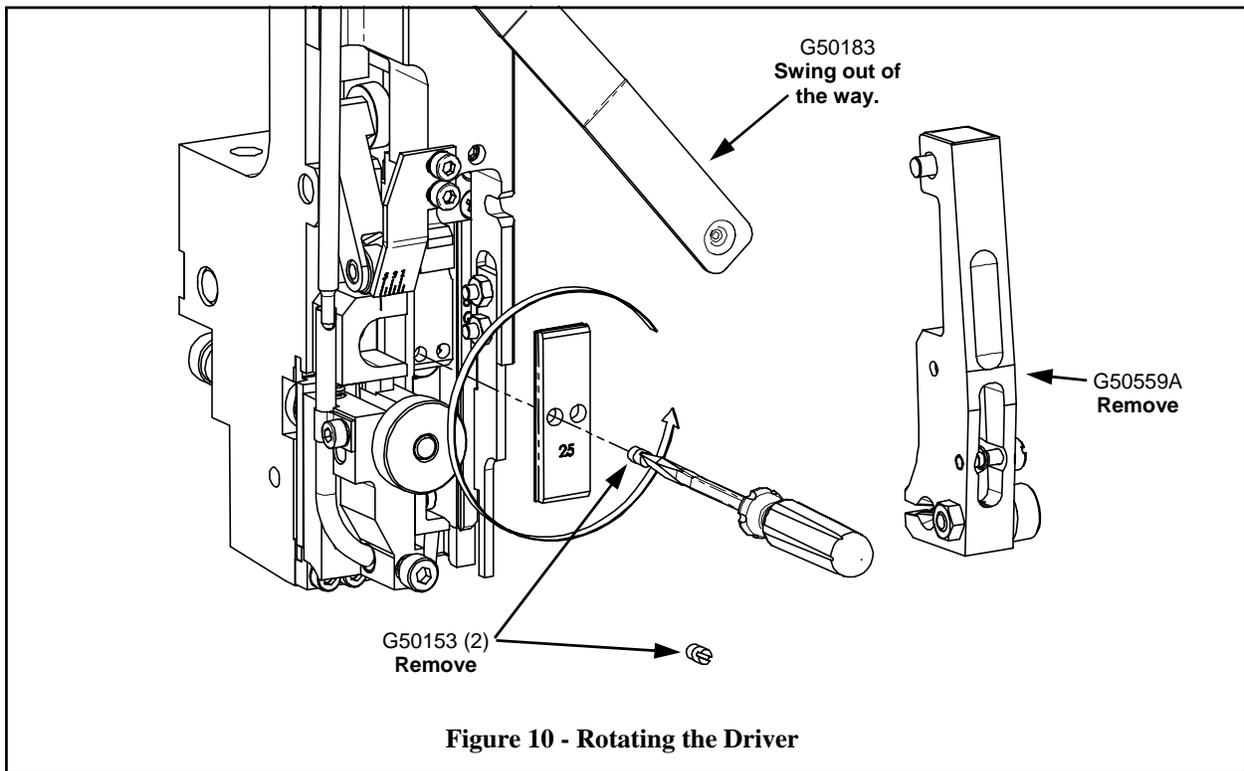
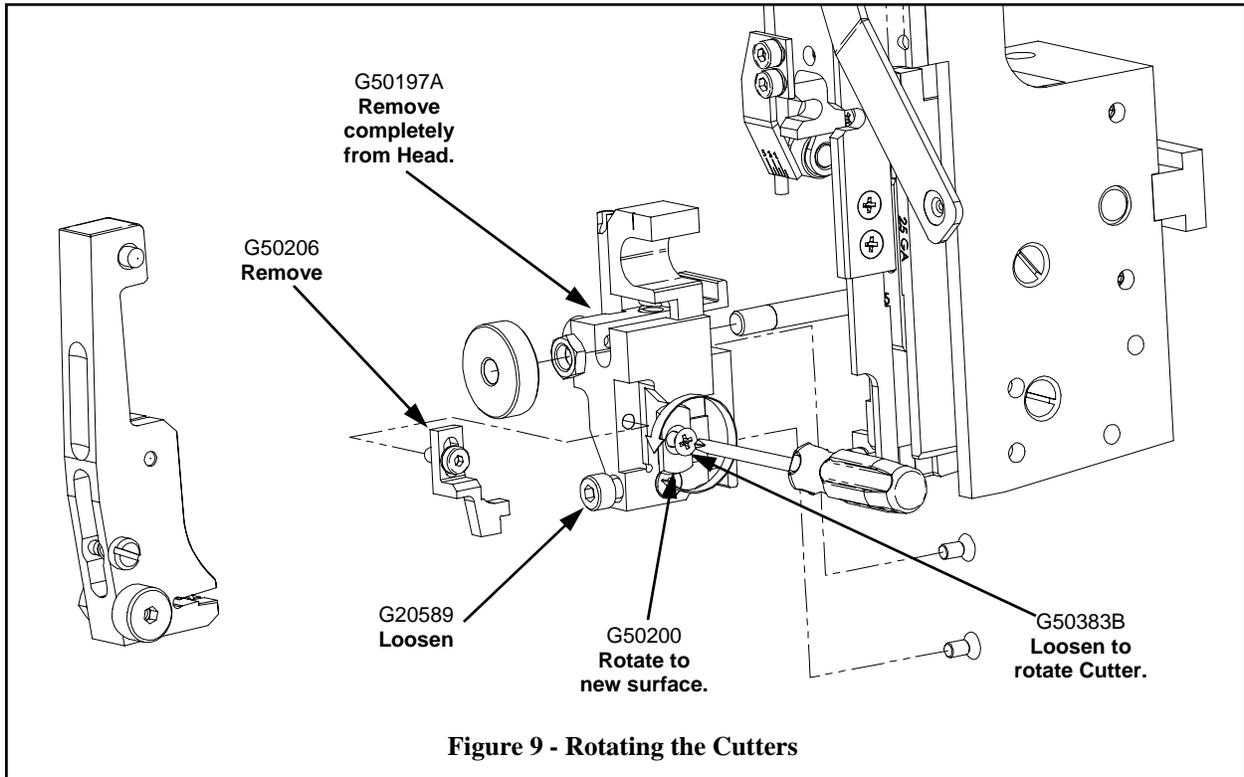
G50131
One drop of oil on both sides

G50262A
One drop of oil in the oil cup

Recommended Oil
- SAE #10
- Household 3-in-1

Figure 8 - Lubrication

Rotating Replacement Parts (Figures 9 & 10)



Compression Adjustment (Figure 11)

WARNING

Compression is set at the factory and should not need any adjustments beyond what is stated below.

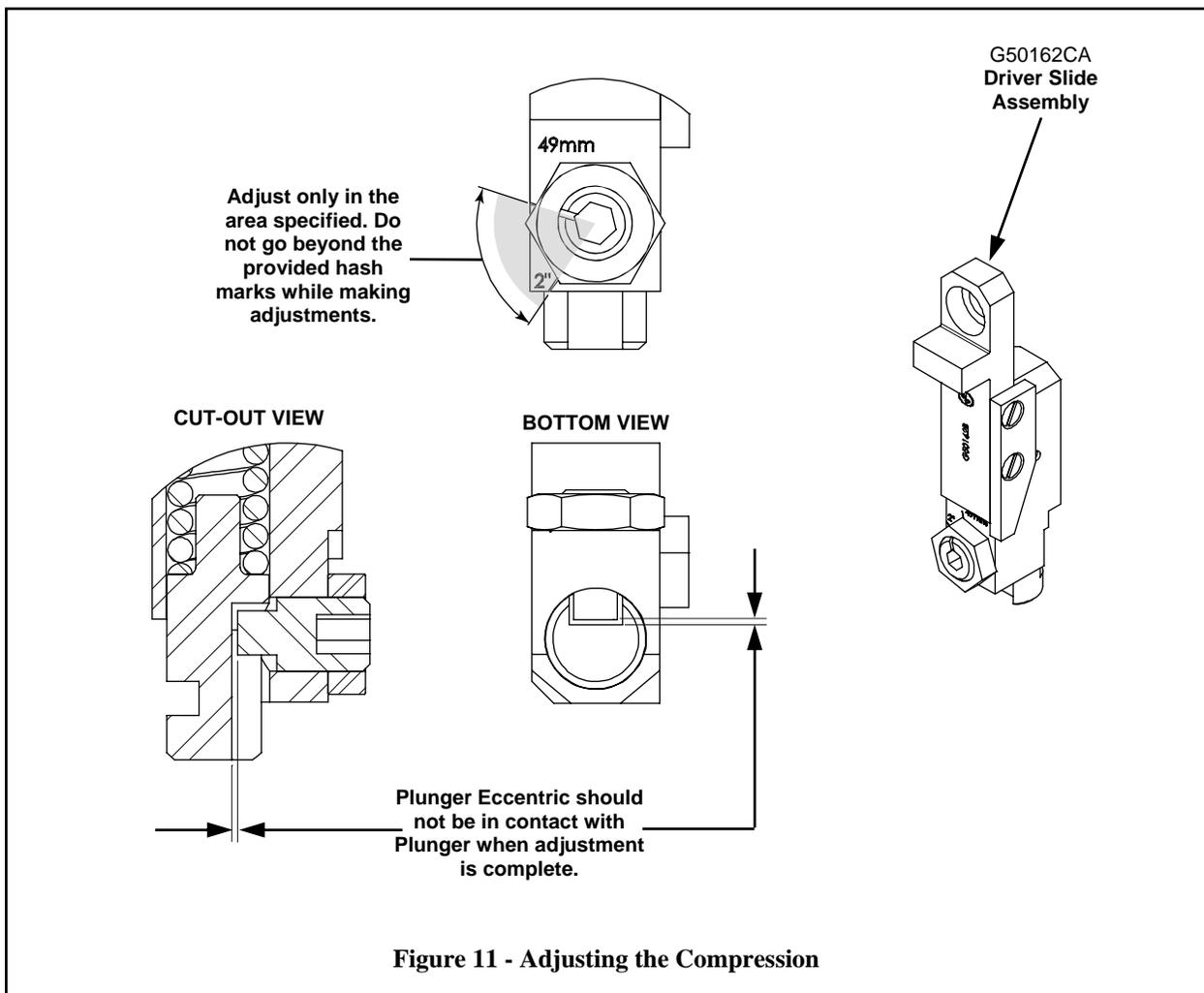


Figure 11 - Adjusting the Compression

Cleaning

Routine cleaning is important for the maintenance of your G5 Head. Blow off dust, dirt and build-up with compressed air at every Spool changes, including:

- Large Feed Gear Assembly (G50110A):

Remove and wash in a petroleum-based, oil-dissolving solvent, dry and repack the Feed Gear with any general Lithium-based light weight Grease.

- Anywhere that dust, oil, pieces of wire and/or paper have built up:

For example, around the Clincher Points and by the Forming Pin Cam (G50117). Remove the Wire Holder and blow clean with pressurized air.

The Head should be refurbished every one million stitches.

Troubleshooting (Figure 22)



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. Make sure the Cutters are aligned properly. Make sure the correct wire size is being used and that the wire is straight.



PROBLEM: Corner Buckled

SOLUTION: Check the Driver for a chipped corner and rotate or replace it if needed. Align the Wire Holder. Straighten wire. Check the tensile strength of the wire or use thicker wire.



PROBLEM: Clinch Too Loose

SOLUTION: The Clincher Points are too low and need adjusting. The compression of the stitcher machine is insufficient and needs to be increased. The eccentric on the Driving Slide Assembly needs to be adjusted.



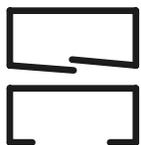
PROBLEM: Left Leg Too Short / Right Leg Too Long

SOLUTION: Adjust the position of the Cutter Block Assembly by moving it away from the Head.



PROBLEM: Left Leg Too Long / Right Leg Too Short

SOLUTION: Adjust the position of the Cutter Block Assembly by moving it towards the Head.



PROBLEM: Staple Legs Too Long or Too Short

SOLUTION: Correct the overall wire draw by adjusting the Feed Rack Adjustment Knob.



PROBLEM: Legs are Spread or Contracted
SOLUTION: Straighten the wire. Replace worn Bender Bars.



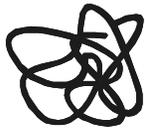
PROBLEM: Legs Stray Forward or Backward Consistently
SOLUTION: The Clincher Points are not aligned properly front to back. Straighten the wire.



PROBLEM: Stitch Stray Randomly In and Out and Front to Back
SOLUTION: Straighten the wire. Make sure the Cutters are aligned properly. Check the tensile strength of the wire or use thicker wire.



PROBLEM: Weak crown, crown breaks off after stitch
SOLUTION: Align the Wire Holder with the grooves in the Bender Bar. Check the tensile strength and size of the wire being used.



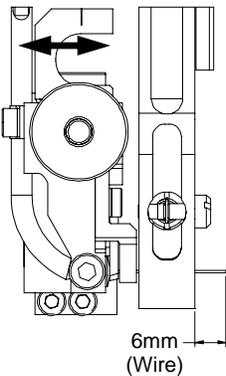
PROBLEM: Wire jam
SOLUTION: Be sure the Cutter Operating Lever moves freely. Add oil to Pivot Pin if necessary. Readjust Fixed Wire Cutter. Make sure cutters are sharp. Inspect and rotate as required.

**NO STITCH
MADE**

PROBLEM: No wire being drawn
SOLUTION: Make sure the Feed Release Cam is turned to the “on” position and the Feed Gears engaged.

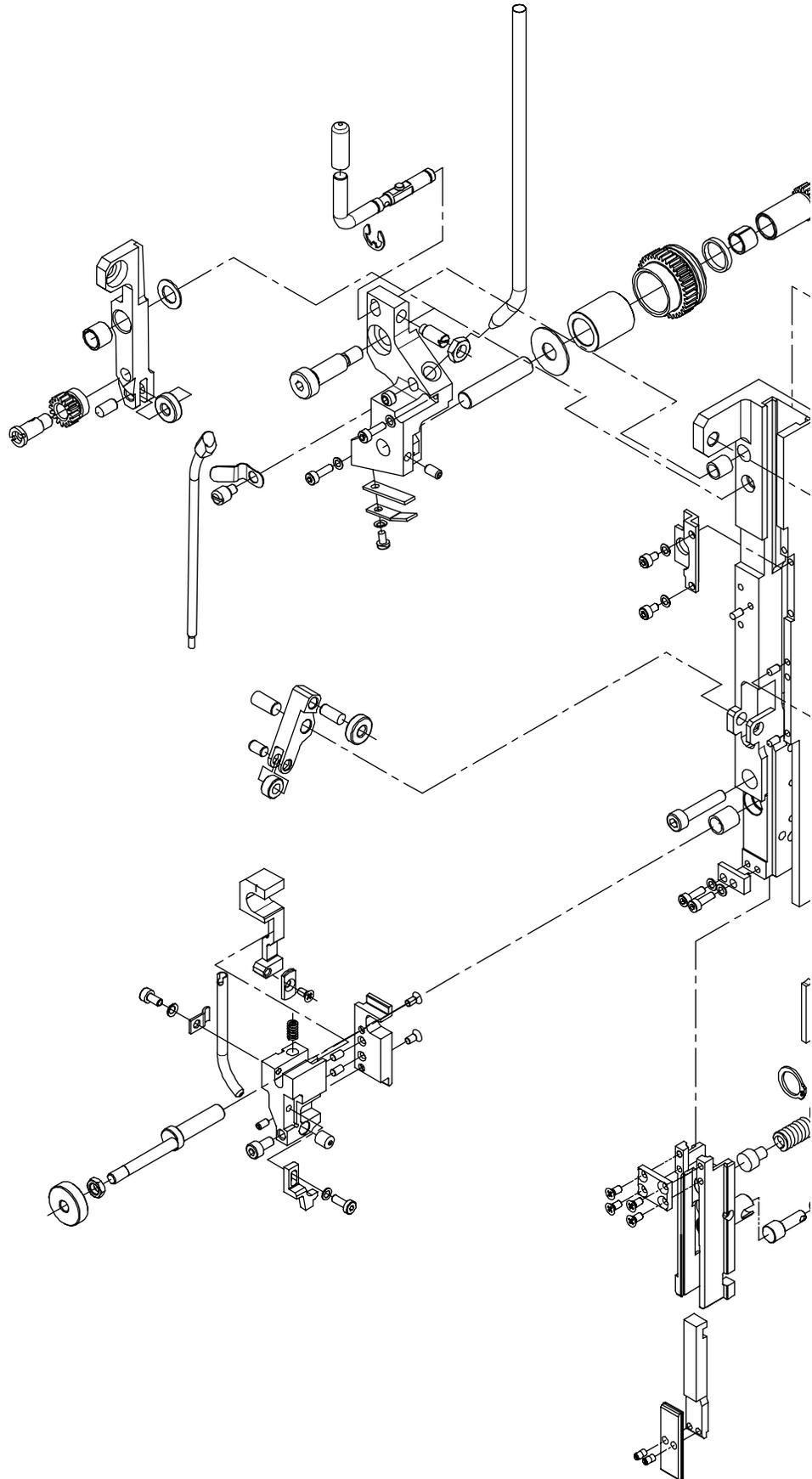
**NO STITCH
MADE**

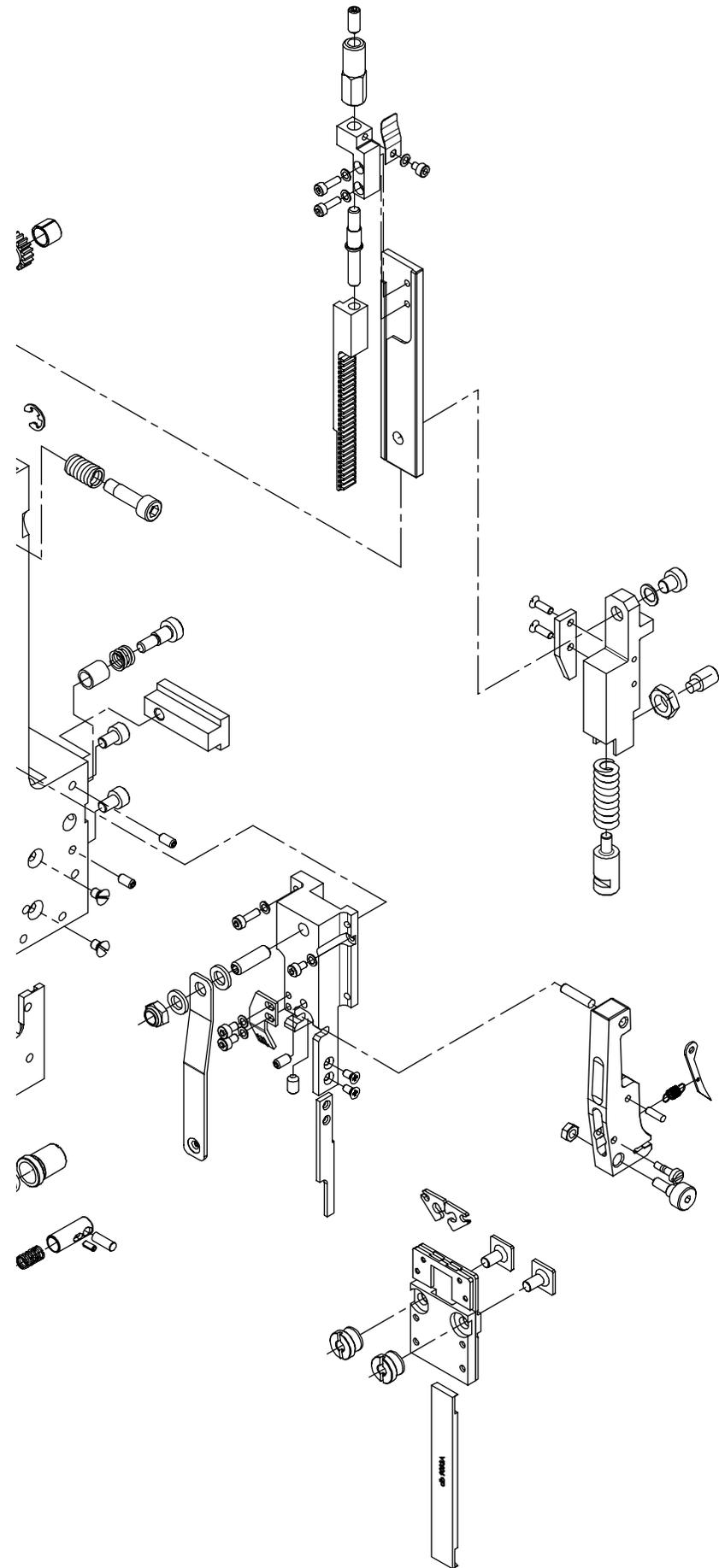
PROBLEM: Dropped stitches
SOLUTION: (Refer to illustration at the left and Fig. 6)



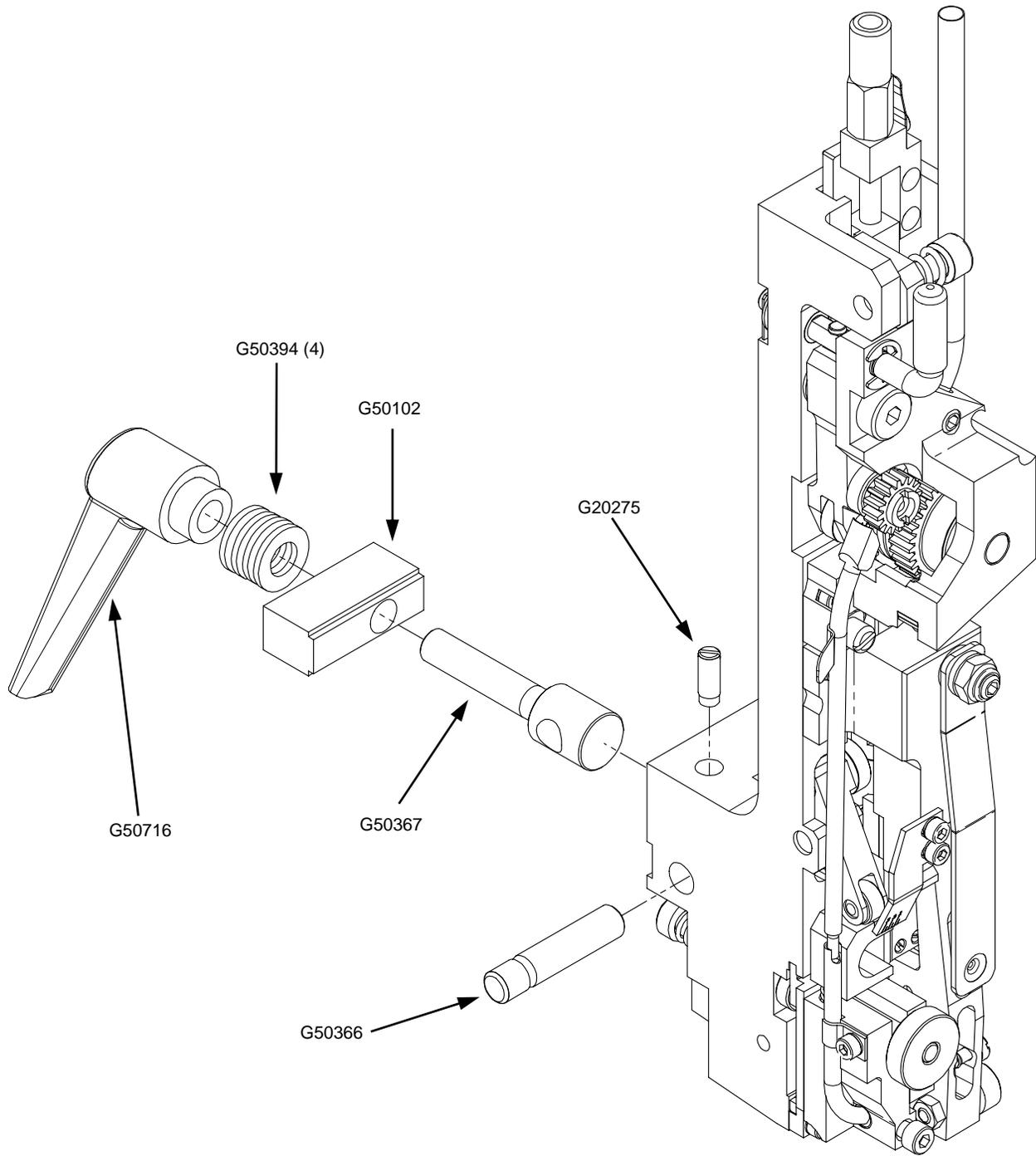
1. Pull the Wire Holder away from the Head to remove any wire that may already be loaded.
2. Move the Cutter Box all the way to the right.
3. With the Feed Gears engaged, cycle the machine, then pull the Wire Holder out away from the Head to remove the wire.
4. Cycle the machine again and measure the length of wire protruding past the right side of the Wire Holder. This length should be 6mm. If the length is not 6mm, then increase or decrease the wire draw with the Adjustment Knob [G20245W].
5. Pull the Wire Holder out away from the Head to remove the wire.
6. Repeat the previous 2 steps until the wire protrudes 6mm past the Wire Holder.
7. Refer to Fig. 6 to adjust the location and size of the gap.

G5 Stitcher Head

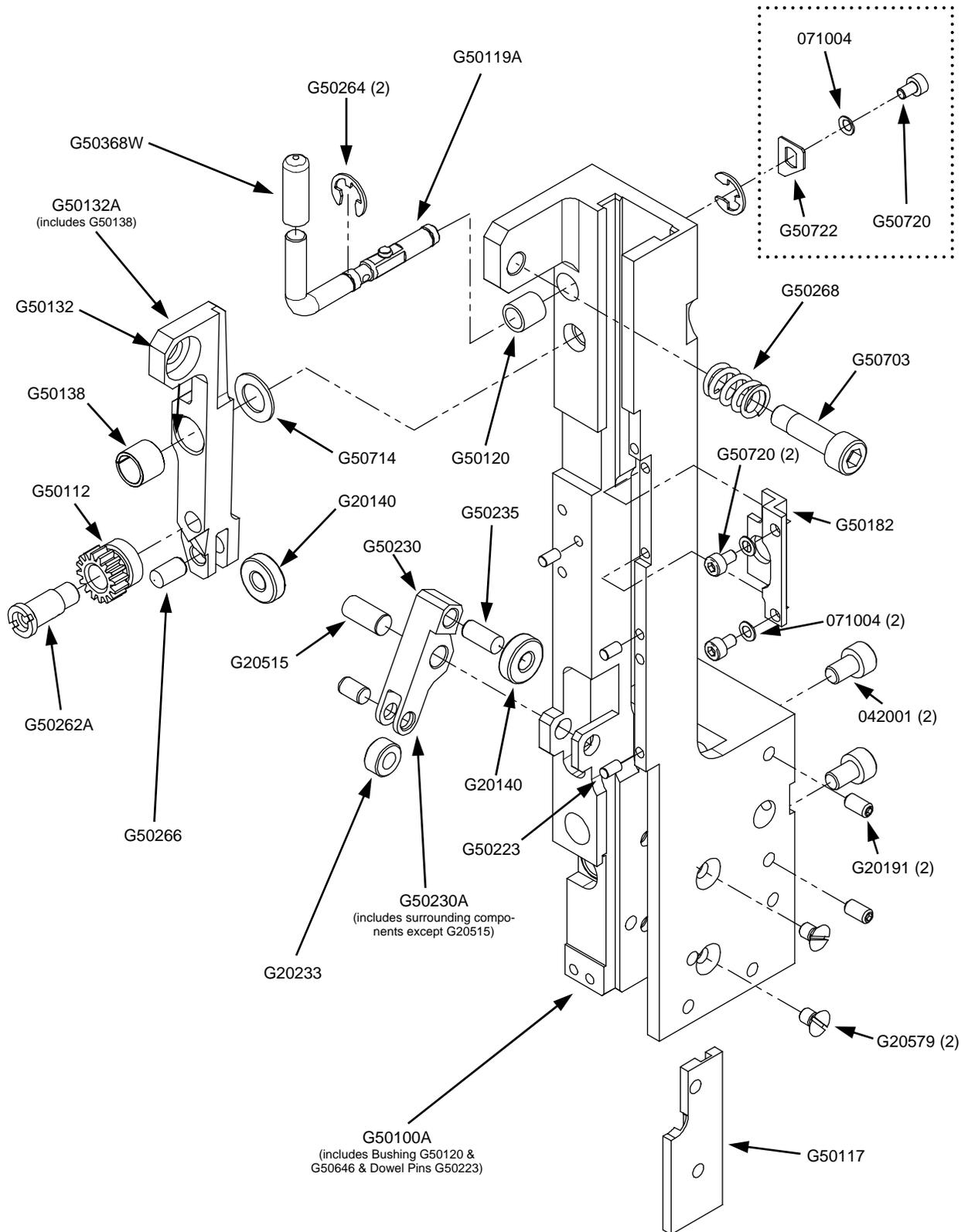




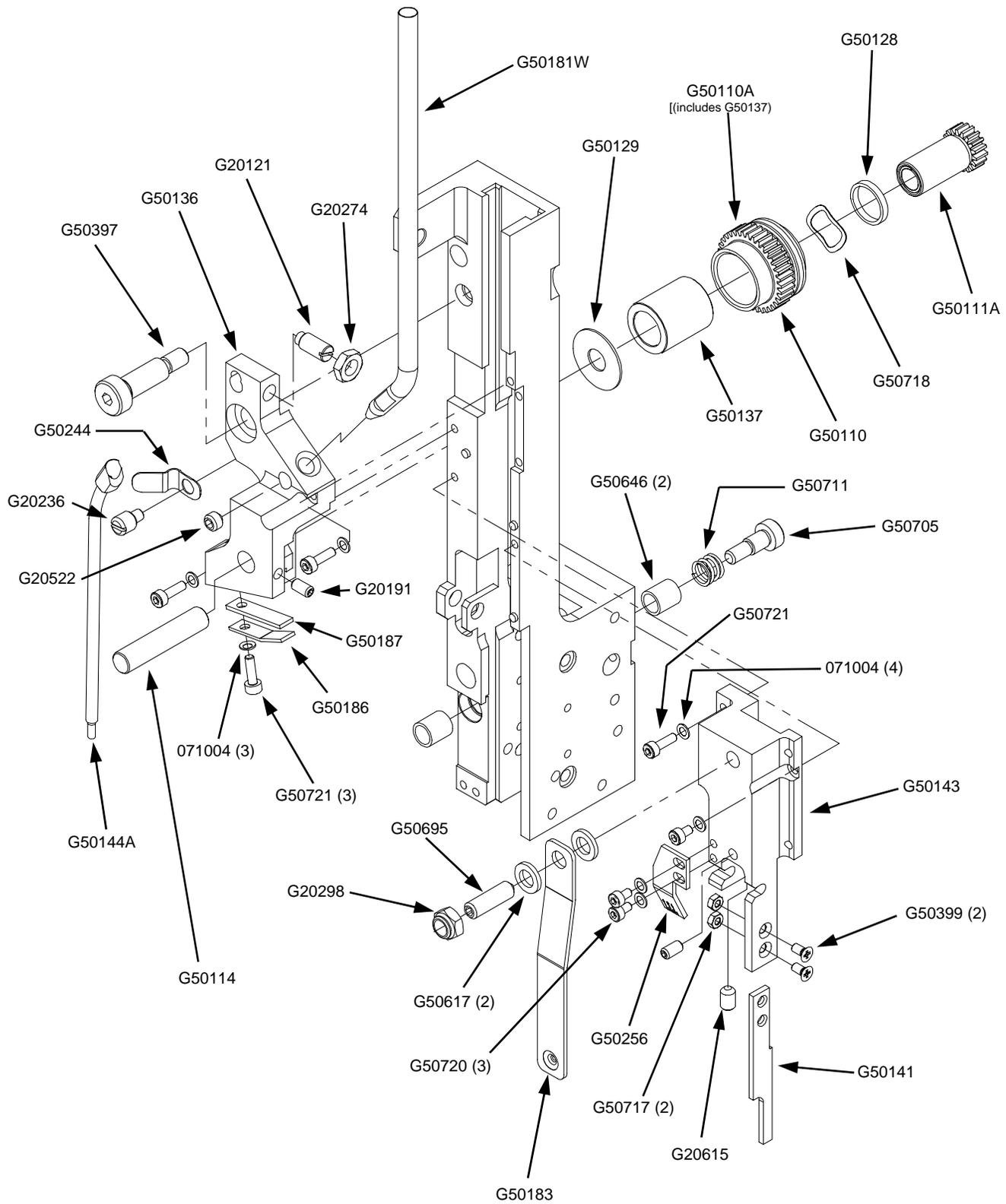
Head Mounting



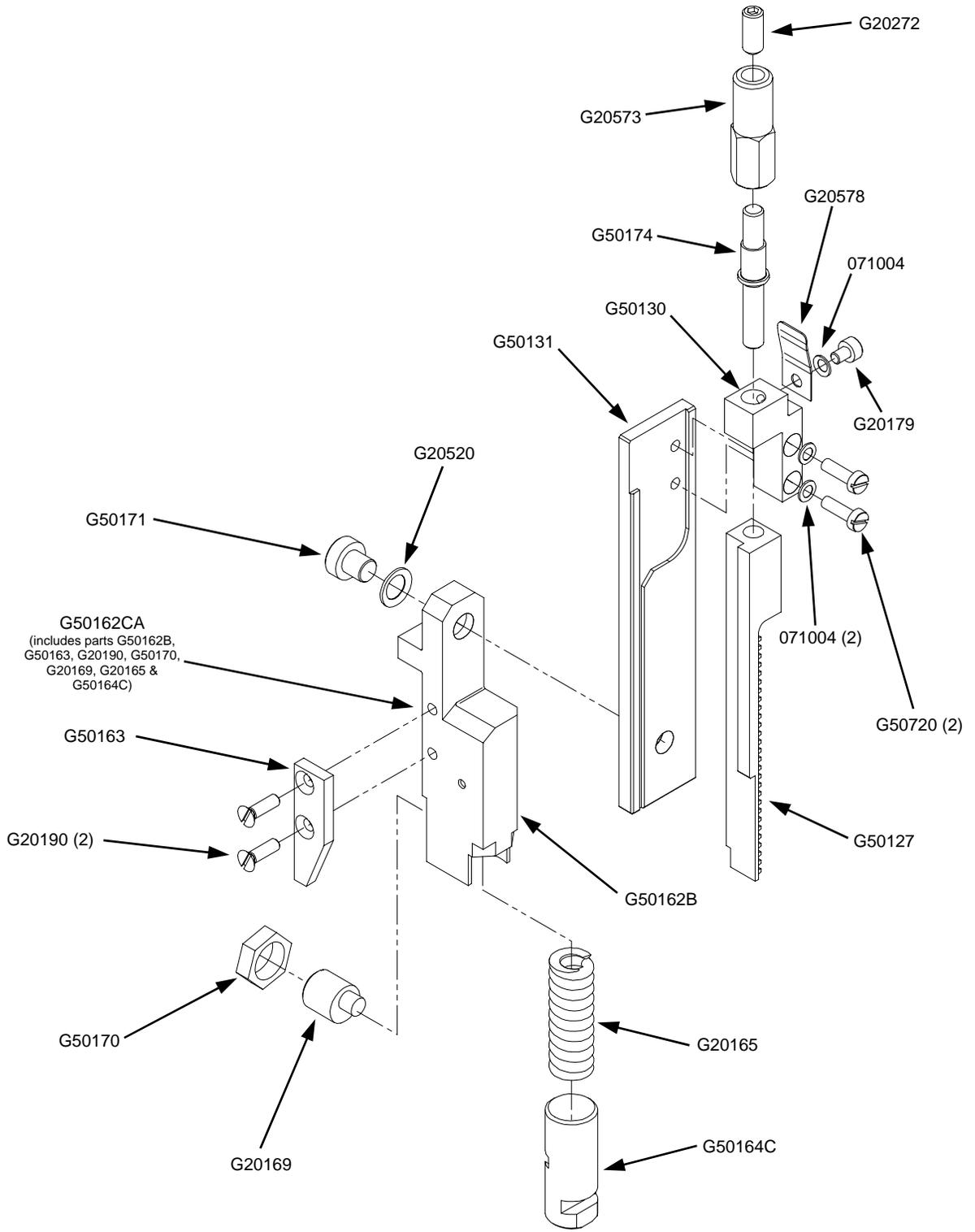
Bonnet—Sub-Assembly #1



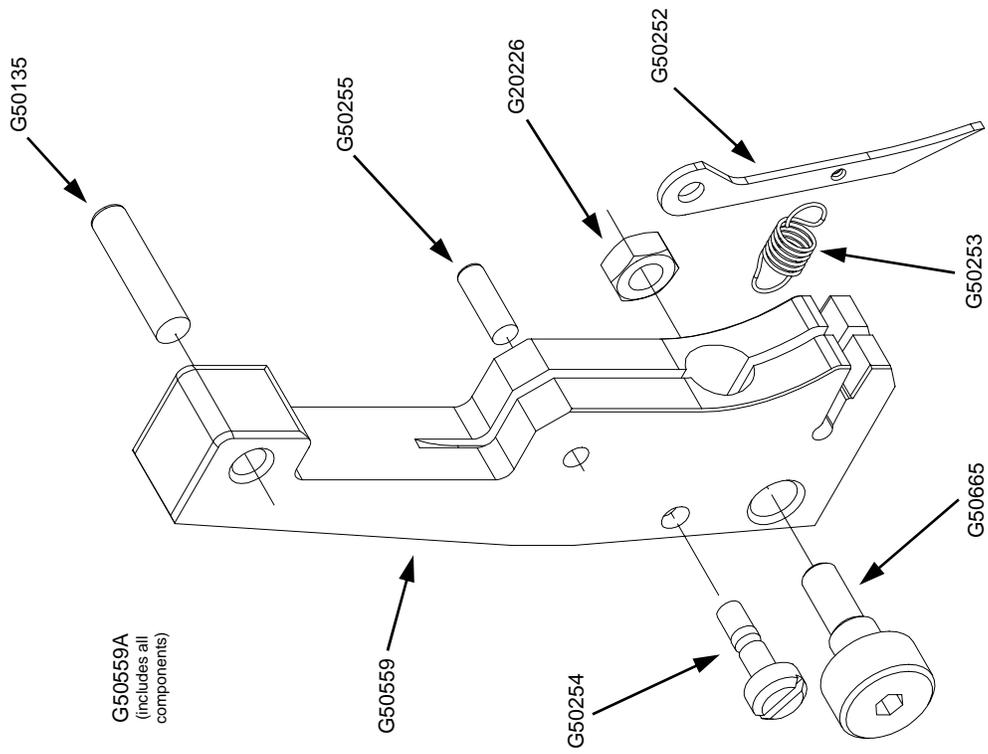
Bonnet—Sub-Assembly #1



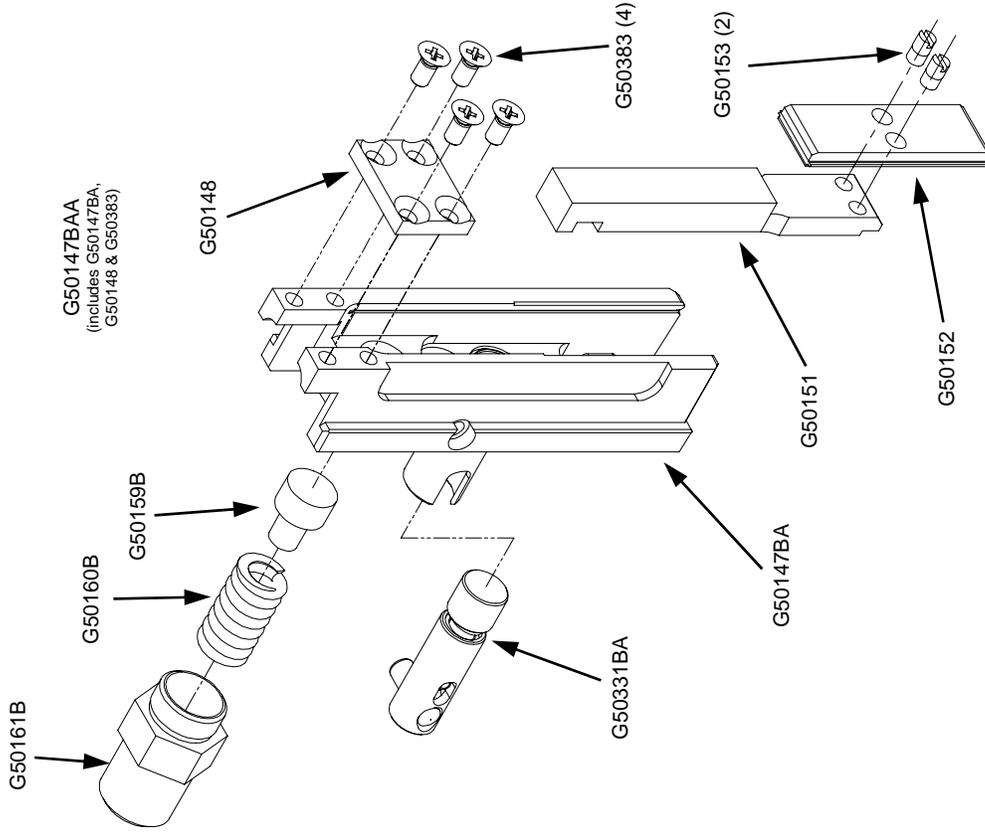
Driver and Feed Slide Assemblies



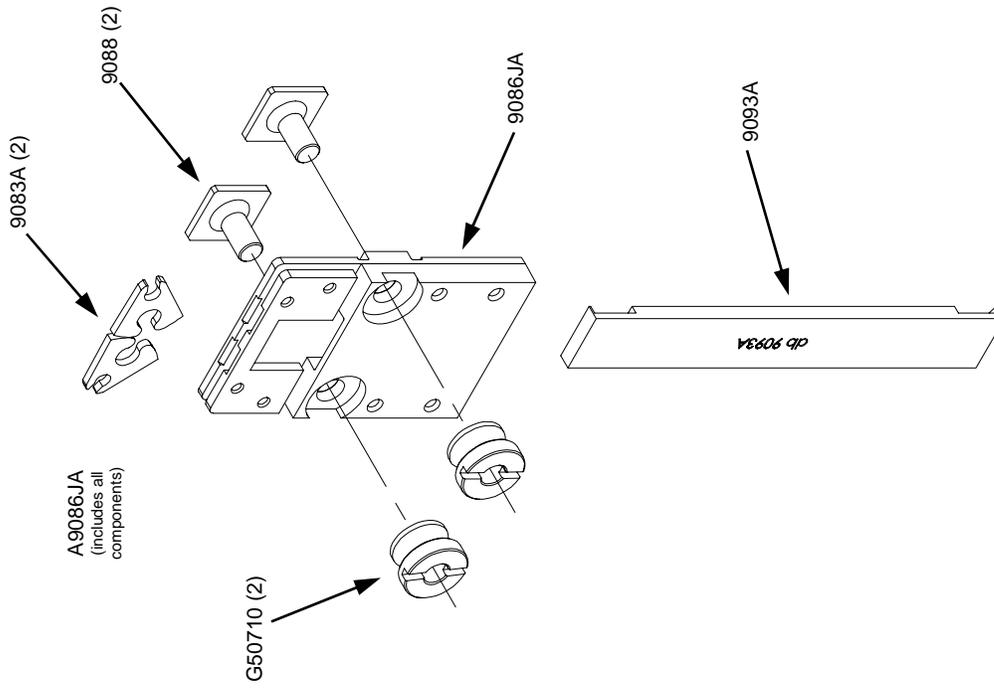
Wire Holder Assembly



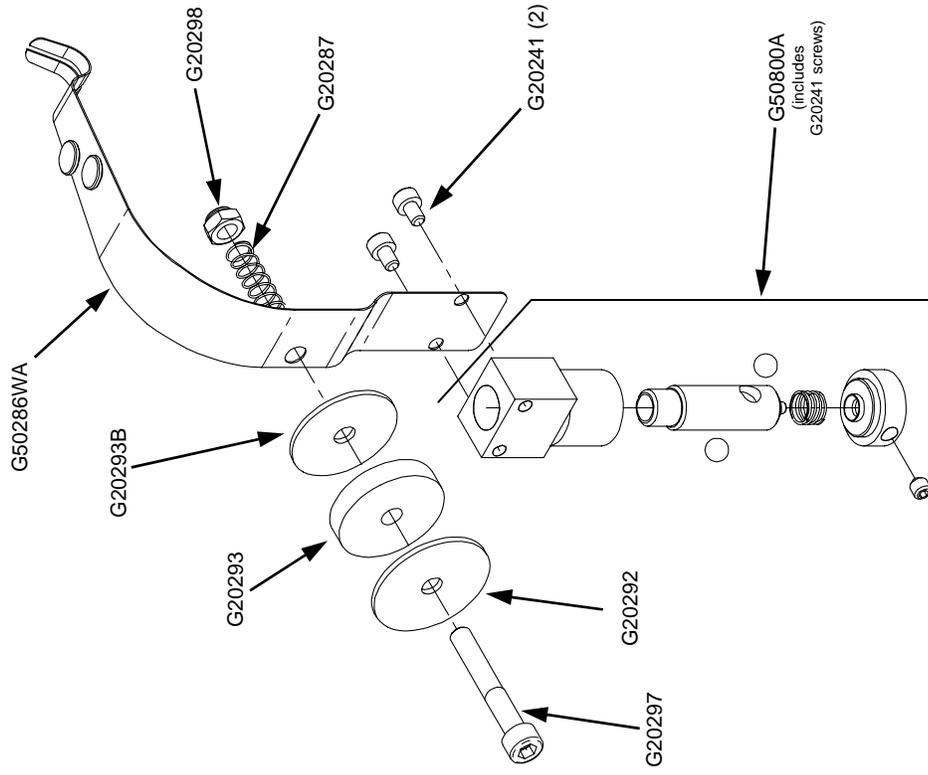
Driver and Bender Bars



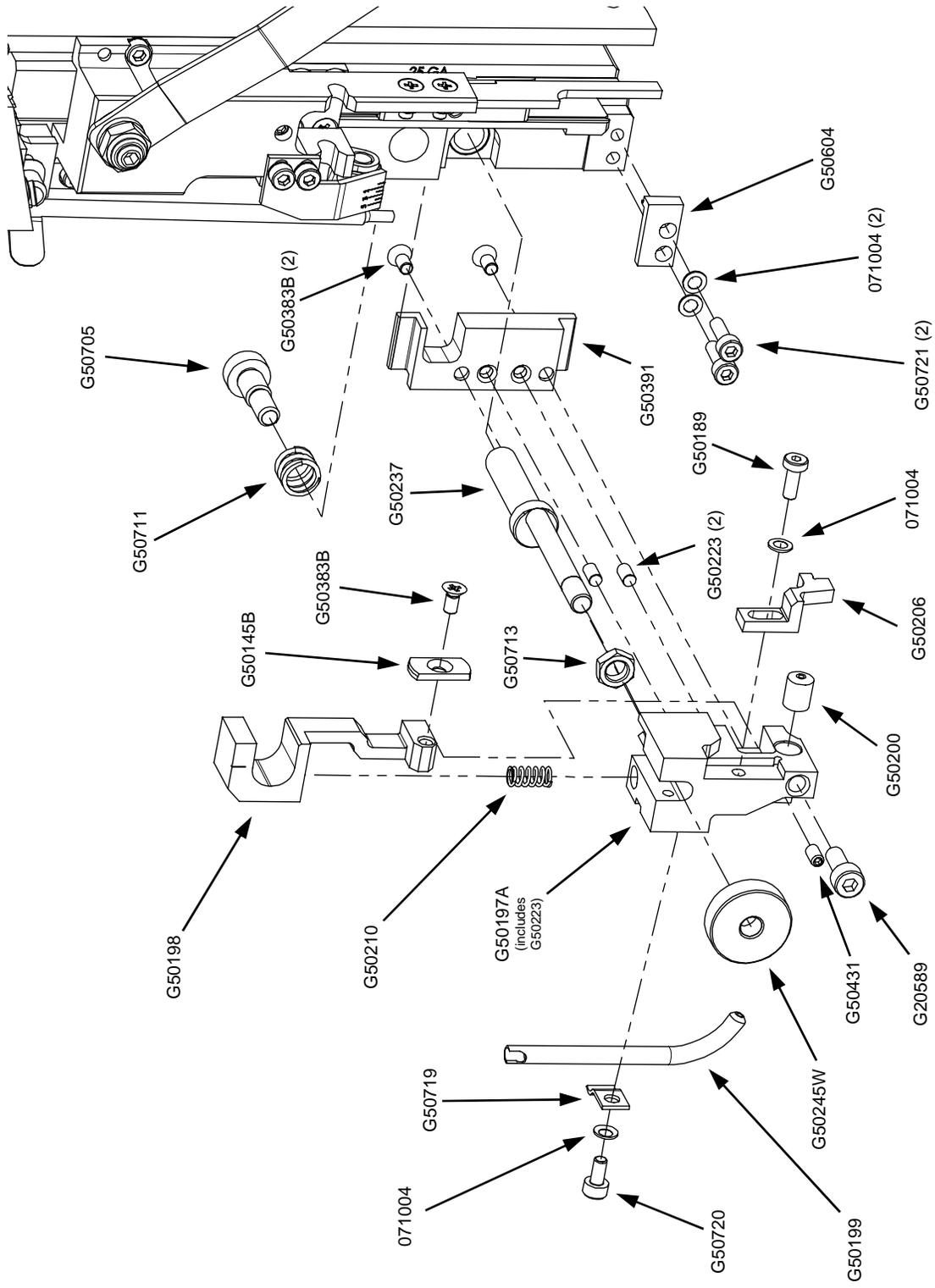
Clincher Plate Assembly



Wire Guide Bracket and Spring



Cutter Box Assembly

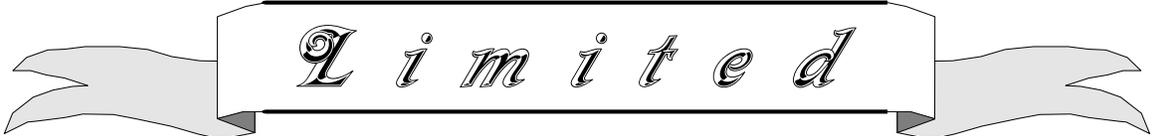
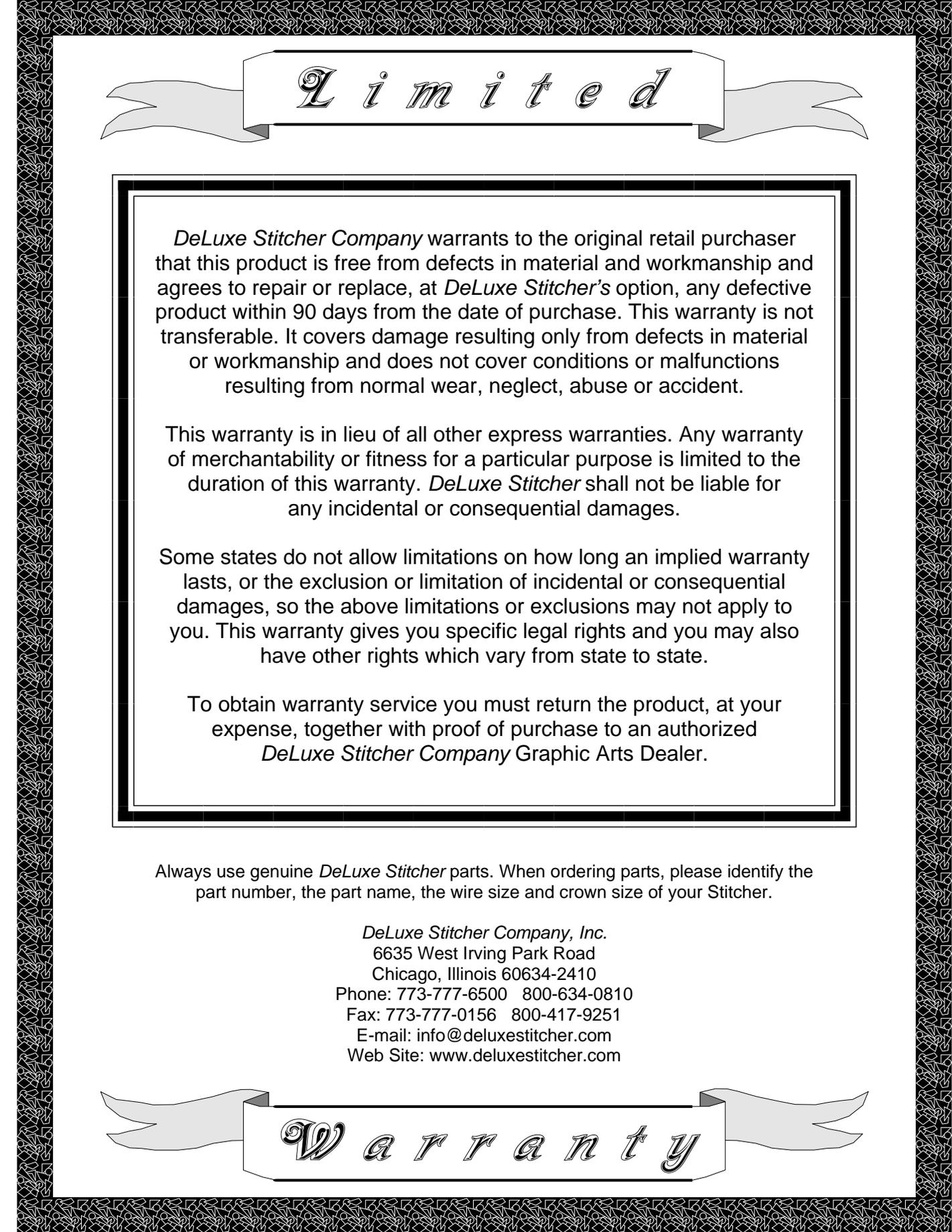


Part / Number Description Cross-Reference

A9086JA	Clincher Plate Assy.—Thick	1	G50111A	Feed Pinion Assembly	1
G20121	Feed Release Plunger	1	G50112	Small Feed Gear	1
G20140	Follower Ball Bearing	2	G50114	Feed Gear Pin	1
G20165	Driving Slide Spring	1	G50117	Forming Pin Cam	1
G20169B	Driving Slide Plunger Screw Ecc.	1	G50119A	Feed Release Handle Assembly	1
G20179	Screw M3x0.5x4	1	G50120	Feed Release Handle Bushing	1
G20190	Screw M3x0.5x10	2	G50126	Screw M5x0.8x25	1
G20191	Screw M4x0.7x8	4	G50127	Feed Rack	1
G20226	Hex Nut M4x.7	1	G50128	Pinion Washer	1
G20233	Cutter Operating Lever Roller	1	G50129	Large Feed Gear Washer	1
G20236	Tube Pivot Screw	1	G50130	Feed Adjustment Block	1
G20241	Screw M4x0.7x6	2	G50131	Feed Slide	1
G20272	Screw M5x0.8x12	1	G50132	Feed Lever	1
G20274	Hex Jam Nut, M6x1	1	G50132A	Feed Lever Assembly	1
G20275	Ball Spring Plunger	1	G50135	Wire Holder Pivot Pin	1
G20287	Wire Oiler Felt Spring	1	G50136	Feed Gear Bracket	1
G20290	Flat Washer, M5	2	G50137	Feed Gear Clutch	1
G20292	Wire Oil Felt, Washer	1	G50138	Feed Pinion Bearing	2
G20293	Wire Oiler Felt	1	G50141	Wire Guide Bar	1
G20293B	Wire Oiler Felt, Thin	1	G50142	Screw M3x0.5x6	1
G20297	Screw M6x1.0x40	1	G50143	Pivot Block	1
G20298	Nylock Lock Nut, M6x1	2	G50144A	Middle Wire Tube Assembly	1
G20360	Hex Key Wrench 3.0mm	1	G50145B	Moving Cutter	1
G20364	Open End Wrench 7.0mm	1	G50147BA	Bender Bar	1
G20374	Hex Key Wrench 2.0mm	1	G50147BAA	Bender Bar Assembly	1
G20515	Dowel Pin M6x14	1	G50148	Bender Bar Friction Plate	1
G20520	Ribbed Lock Washer M6	1	G50151	Driver Bar	1
G20522	Screw M6x1.0x5, Nylon	1	G50152	Driver - 25 Wire	1
G20573	Feed Rack Adjustment Knob	1	G50153	Driver Retaining Screw	2
G20578	Rack Adjustment Knob Detent	1	G50159B	Friction Plug	1
G20579	Screw M4x0.7x6	2	G50160B	Bender Bar Friction Spring	1
G20589	Screw M4x0.7x10	1	G50161B	Friction Plug Bushing	1
G20615	Screw M5x0.8x8	1	G50162B	Driving Slide	1
G50100A	Bonnet Assembly - G5	1	G50162CA	Driving Slide Assembly	1
G50101	Clamp Block	1	G50163	Cutter Operating Cam	1
G50102	Mounting Block - Keyed	1	G50164C	Plunger	1
G50110	Large Feed Gear	1	G50169	Driving Slide Eccentric	1
G50110A	Large Feed Gear Assembly	1	G50170	Hex Nut, M10	

Part / Number Description Cross-Reference

G50171	Screw M6x1.0x6	1	G50368W	Feed Release Handle Cap-Orange	1
G50174	Feed Rack Adjustment Stud	1	G50383B	Screw M3x0.5x6	7
G50181W	Upper Wire Tube	1	G50391	Cutter Box Mounting Plate	1
G50182	Feed Gear Plate	1	G50394	Flat Washer M8	4
G50183	Wire Holder Retaining Spring	1	G50397	Shoulder Bolt M8x20	1
G50186	Feed Gear Friction Spring	1	G50399	Screw M3x0.5x8	2
G50187	Feed Gear Friction Pad	1	G50431	Screw M3x0.5x6	1
G50189	Screw M3x0.5x10	1	G50559	Wire Holder	1
G50197A	Cutter Box Assembly	1	G50559A	Wire Holder Assembly	1
G50198	Cutter Operating Slide	1	G50604	Cutter Box Guide Plate	1
G50199	Lower Wire Tube	1	G50617	Wire Holder Retain. Spring Washer	2
G50200	Fixed Wire Cutter	1	G50646	Cutter Box Eccentric Bearing	2
G50206	Wire Straightener	1	G50665	Wire Holder Adjustment Screw	1
G50210	Cutter Operating Spring	1	G50666	Clincher Alignment Gage, G5	1
G50223	Dowel Pin M3x6	4	G50695	Screw M6x1.0x20	1
G50228A	Manual Feed Gear Tool	1	G50703	Feed Lever Spring Screw	1
G50230	Cutter Operating Lever	1	G50705	Shoulder Screw M6x8	2
G50230A	Cutter Operating Lever Assembly	1	G50708	T-Handle Hex Key Wrench	1
G50232	Dowel Pin	1	G50710	Clincher Plate Nut	2
G50235	Dowel Pin M5x12	1	G50711	Cutter Box Ecc. Screw Spring	2
G50237	Cutter Box Adjusting Eccentric	1	G50713	Hex Jam Nut M5	1
G50244	Tube Clip	1	G50714	Feed Lever Spacer	1
G50245W	Cutter Box Adjustment Knob	1	G50716	Mounting Block Handle	1
G50252	Wire Hook	1	G50717	Hex Nut M3x0.5	2
G50253	Wire Hook Spring	1	G50718	Feed Gear Spring	1
G50254	Wire Holder Spring Screw	1	G50719	Lower Tube Clip	1
G50255	Dowel Pin M3x10	1	G50720	Screw M3x0.5x6	9
G50256	Scale	1	G50721	Screw M3x0.5x10	6
G50262A	Small Feed Gear Shaft Assembly	1	G50722	Feed Release Handle Stop	1
G50264	E-Ring 6mm	2	G50800A	Wire Anti-Back Up Unit - M6 Tube	1
G50266	Dowel M5x10	1	042001	Screw M5x0.8x8	2
G50268	Feed Lever Spring	1	071004	Lock Washer Ribbed	17
G50286WA	Wire Guide Spring Asy-Watkiss	1	2215	Driving Shaft Connector	1
G50320BA	Driving Slide Assembly-Crank Drive	1	9083A	Clincher Point - Thick, Round	2
G50321	Crank Link Screw	1	9086JA	Clincher Plate - Thick, Round	1
G50331BA	Forming Pin Assembly	1	9088	Clincher Plate Binder Bolt	2
G50366	Bonnet Clamp Pin	1	9093A	Clincher Slide - Thick	1
G50367	Head Mounting Bolt, M8	1			



Limited

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

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

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

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

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

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Warranty

NOTES

