



# DELUXE STITCHER

COMPANY INC.

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

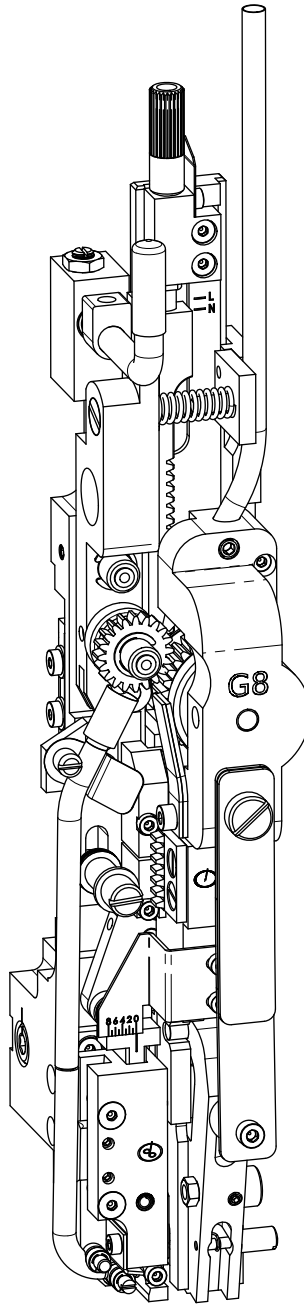
Crown Size: 1/2" (13.5 mm)

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

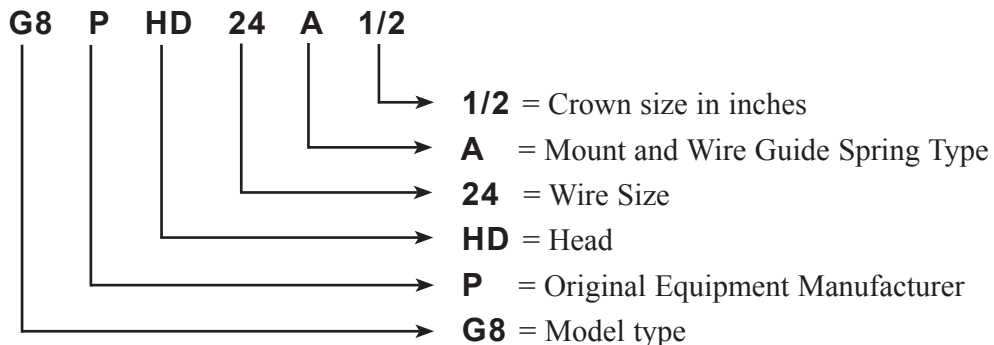
Examples of Replacement Heads for OEM Users\*:

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

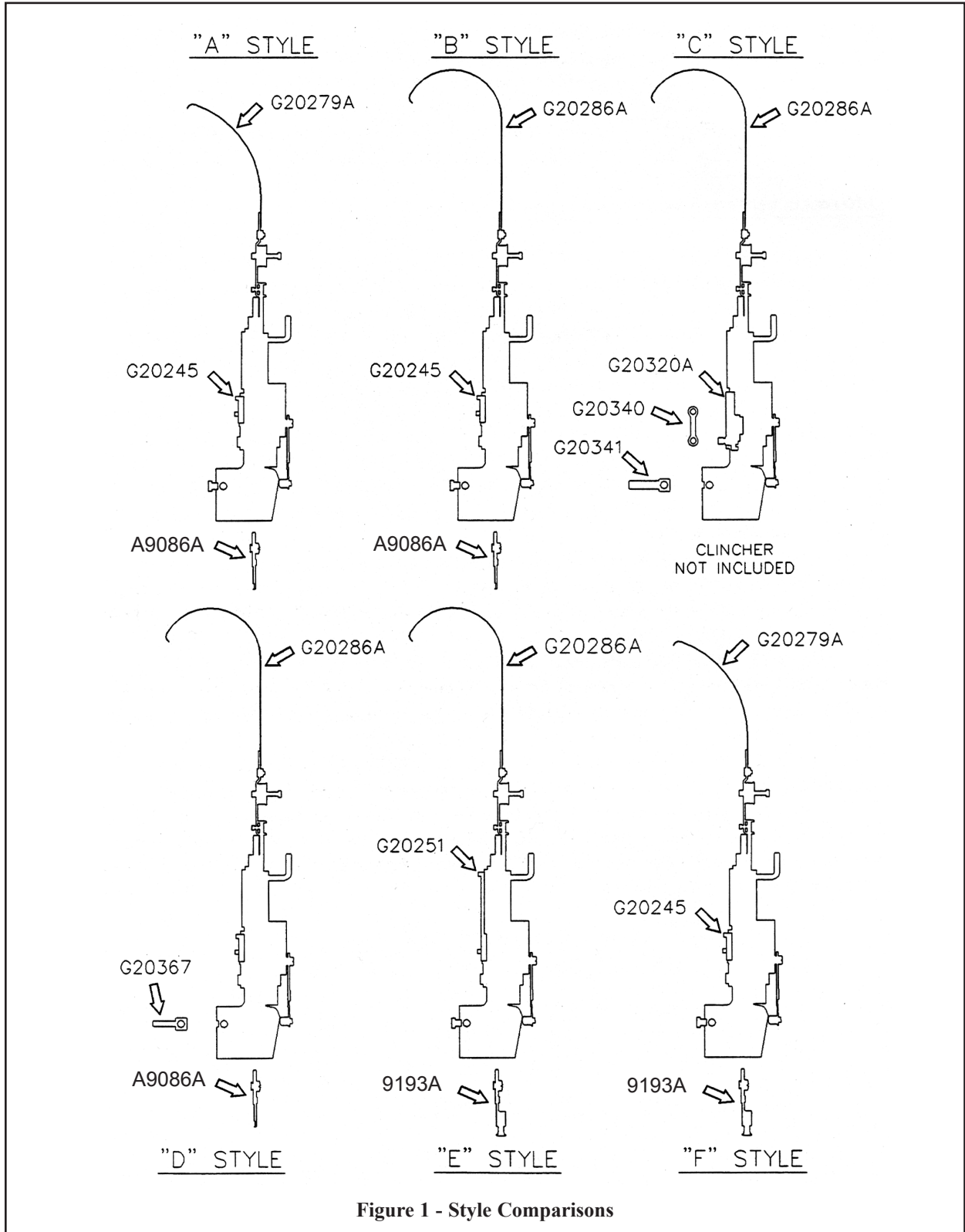
\* These are just a few examples of the replacement heads available for these OEM's.

## 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 ..... 13 lbs (5.9 kg)

Box Size ..... 21 x 10 x 6

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

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

**Wire Types** ..... 23 through 28 round or

..... 20x24,20x25 and 21x25 flat

..... (24 gauge round standard)

..... 25 gauge only for Loop

**Crown Sizes** ..... 1/2" (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

..... and others

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

 **WARNING**



# Dimensions

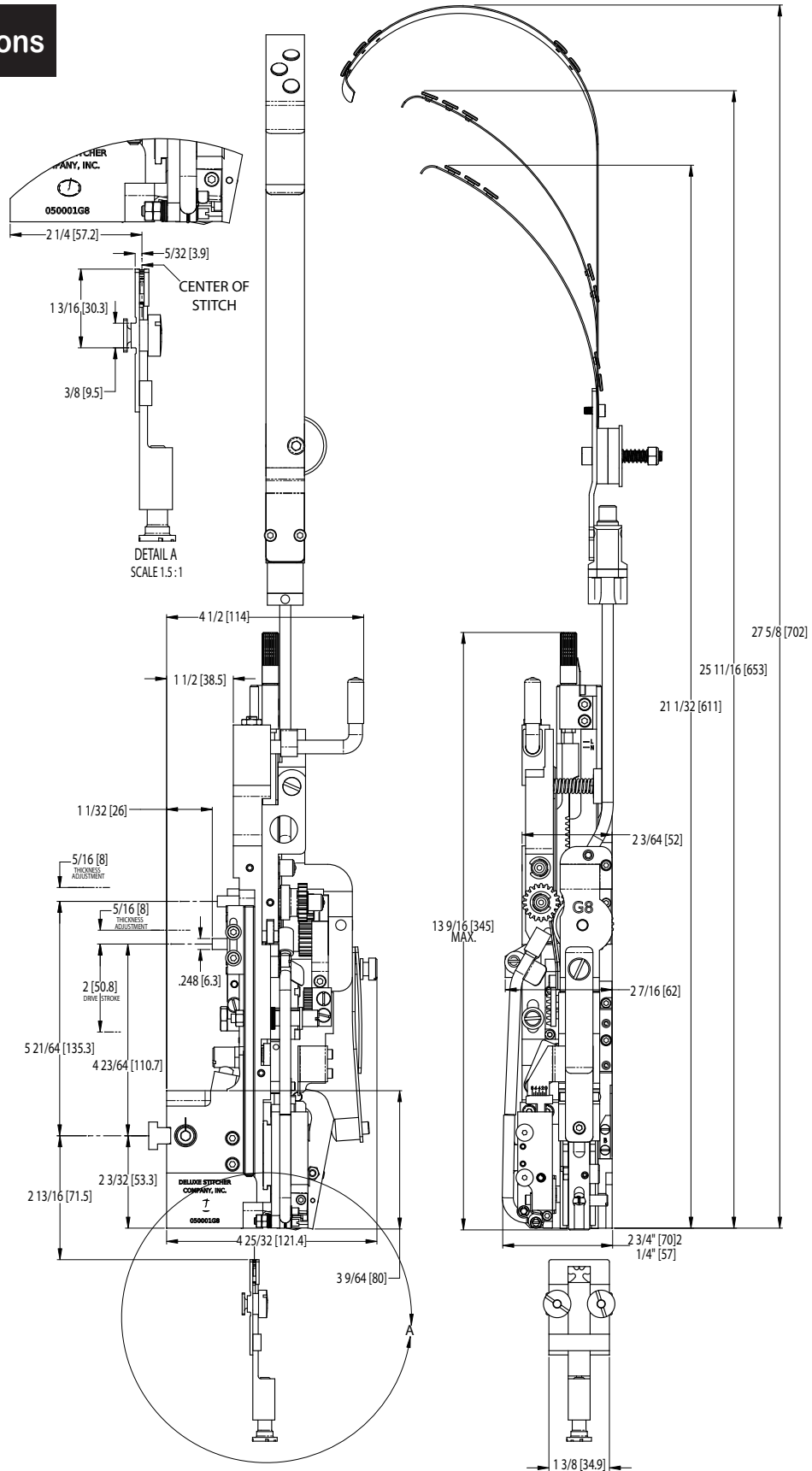


Figure 1

## 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

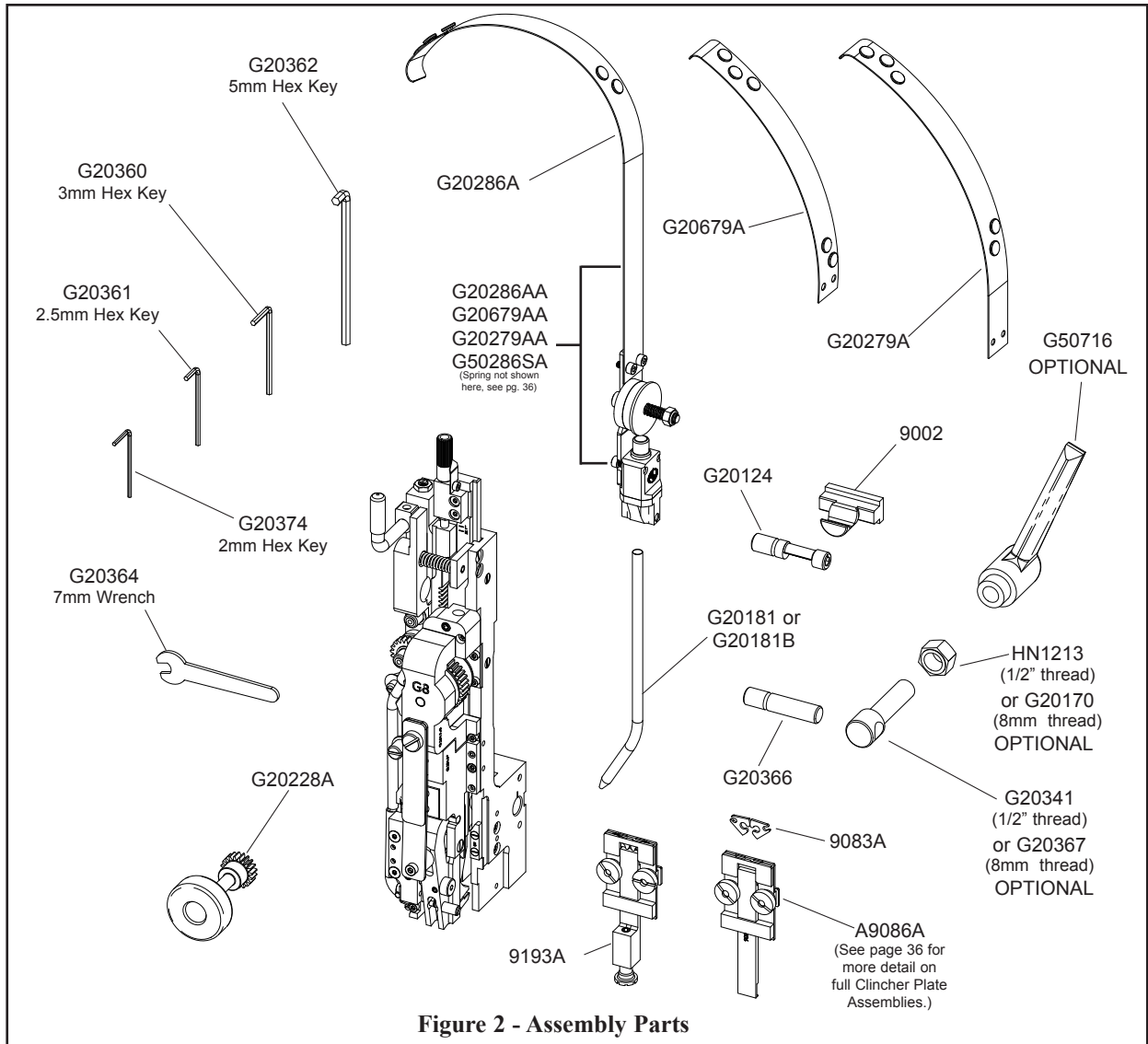
As you carefully unpack the head, check to make sure all components were delivered and are in good working order. Refer to **Figure 2** in this manual for reference to the following pieces:

- 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**

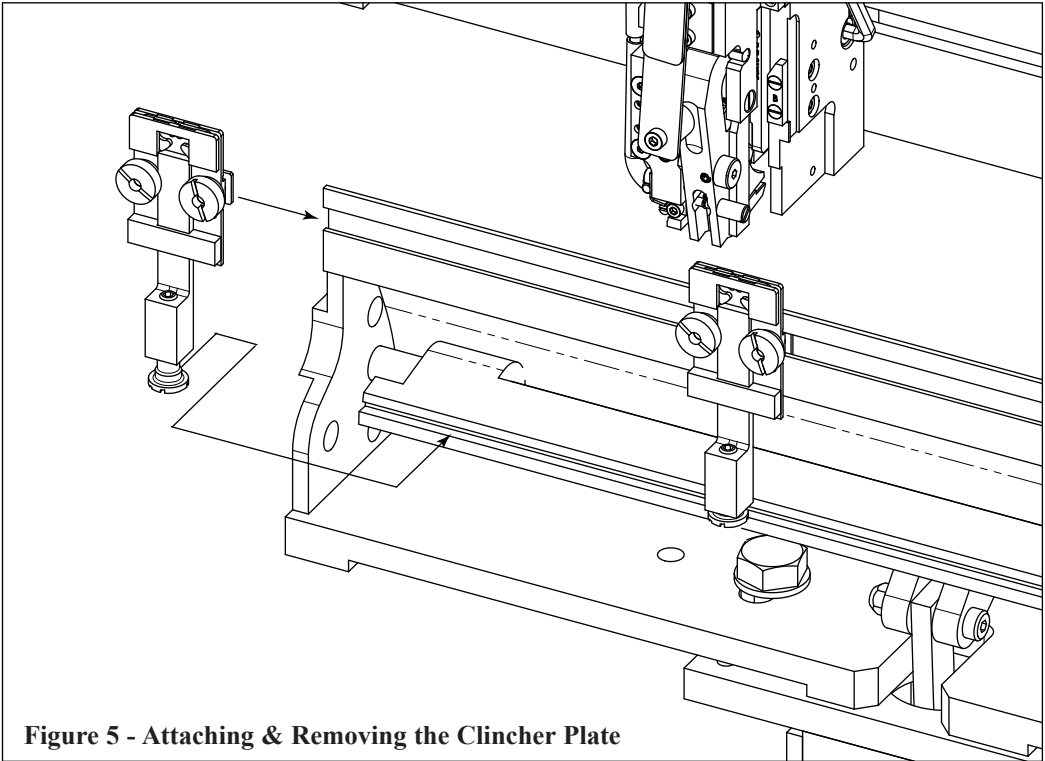
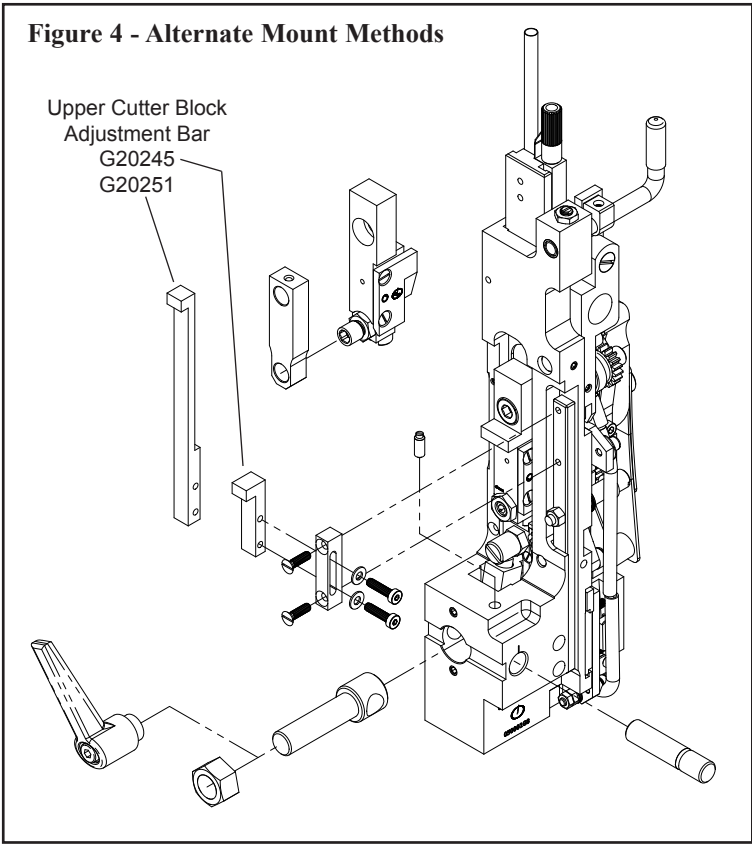
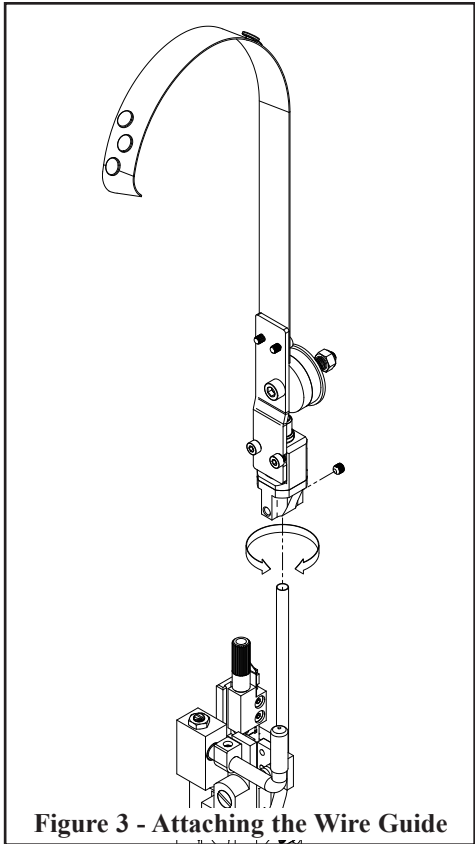
# Assembly Parts

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



**Figure 2 - Assembly Parts**

**Mounting**



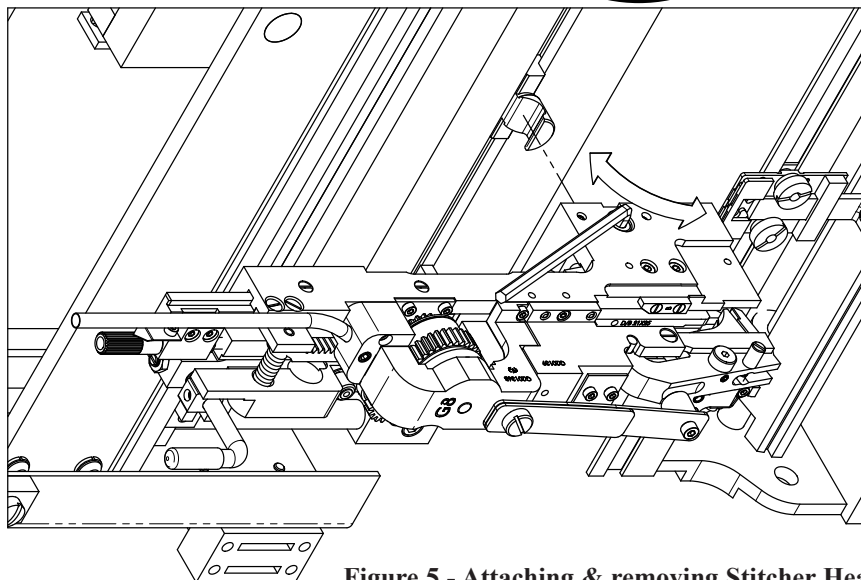
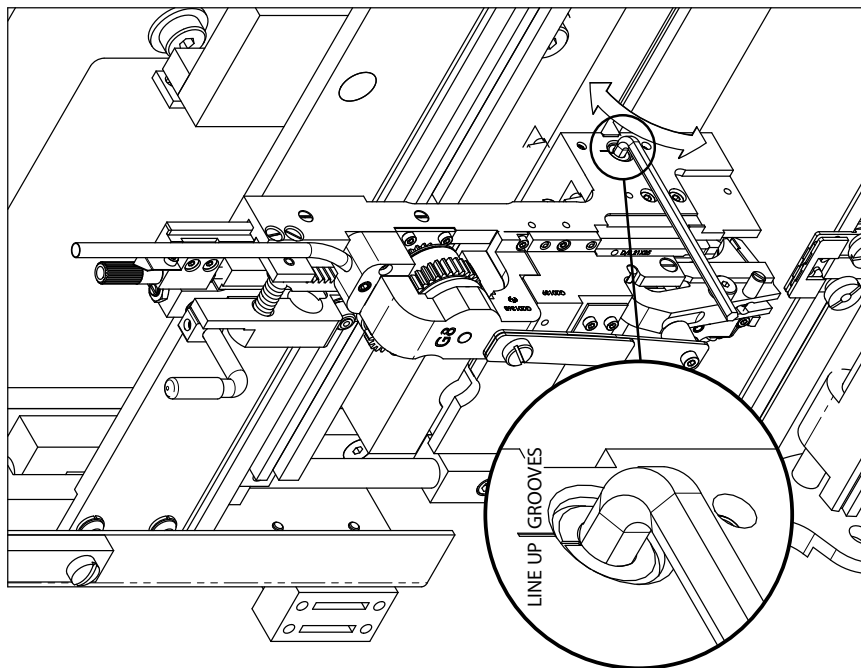
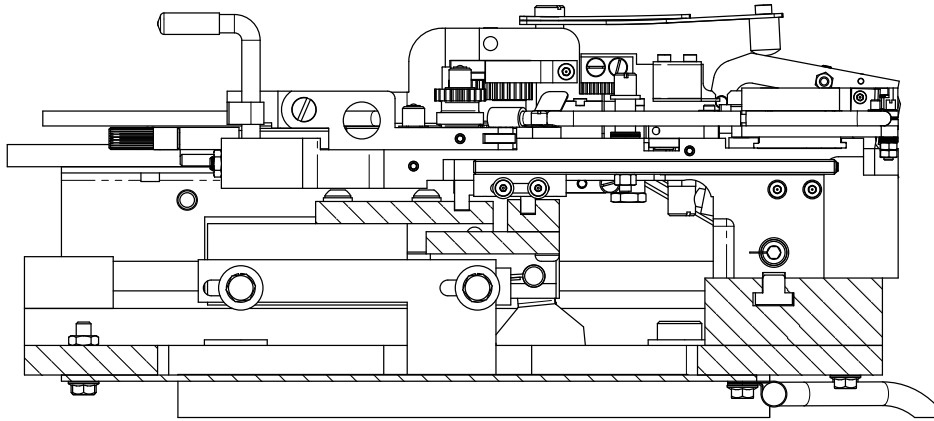
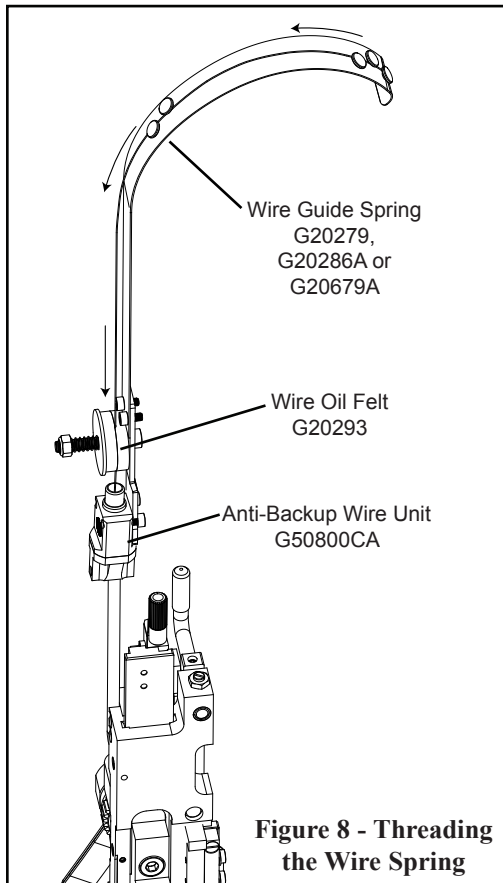
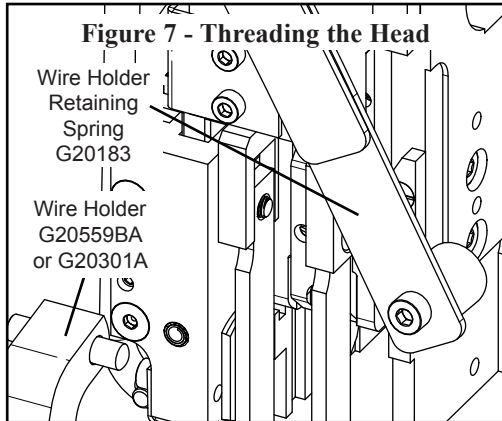


Figure 5 - Attaching & removing Stitcher Heads

## Operation

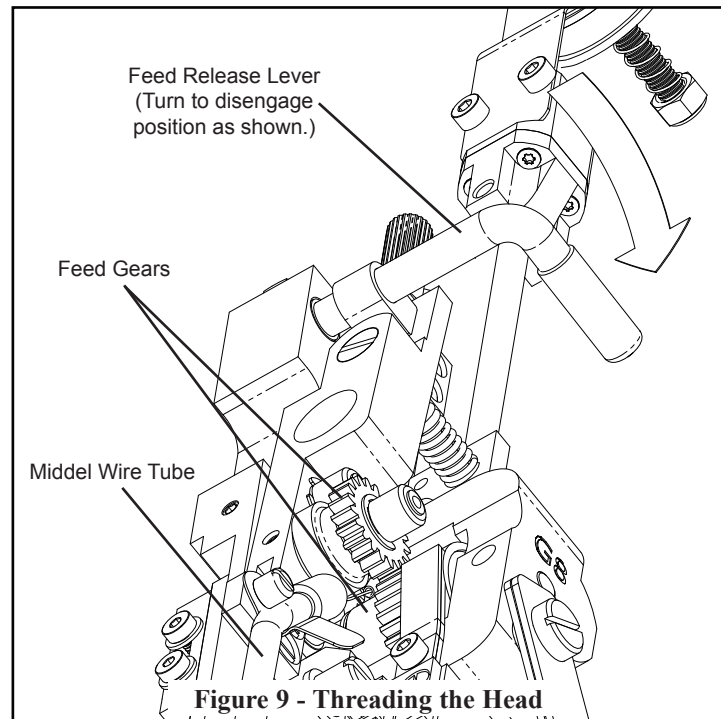
### Wire Threading (Figures 7 - 13)



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).

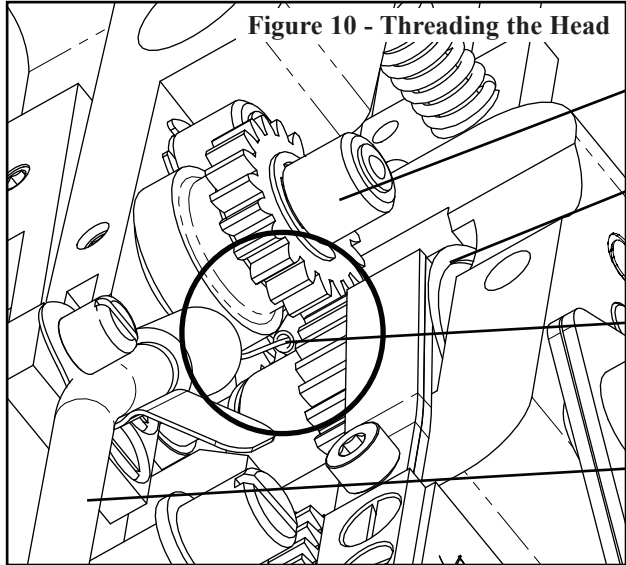
3. Turn the Feed Release Handle clockwise (Figure 9) to disengage the Feed Gears and guide the wire into the Middle



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.**

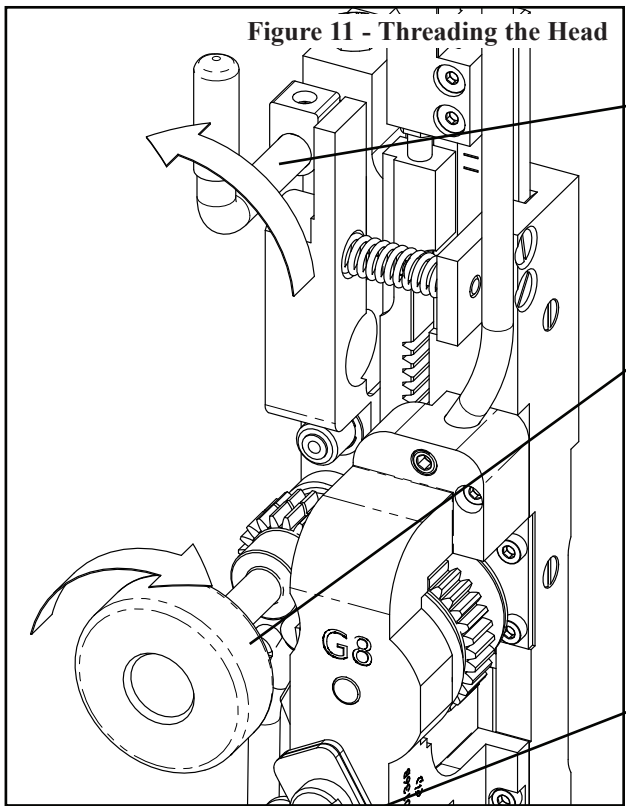


Small Feed Gear  
G20112

Large Feed Gear  
G20110A

Wire

Middle Wire Tube  
G20144A

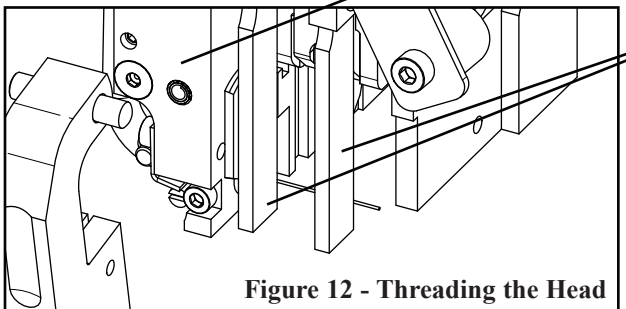


**Figure 11 - Threading the Head**

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

Adjustment Handle  
G20228A

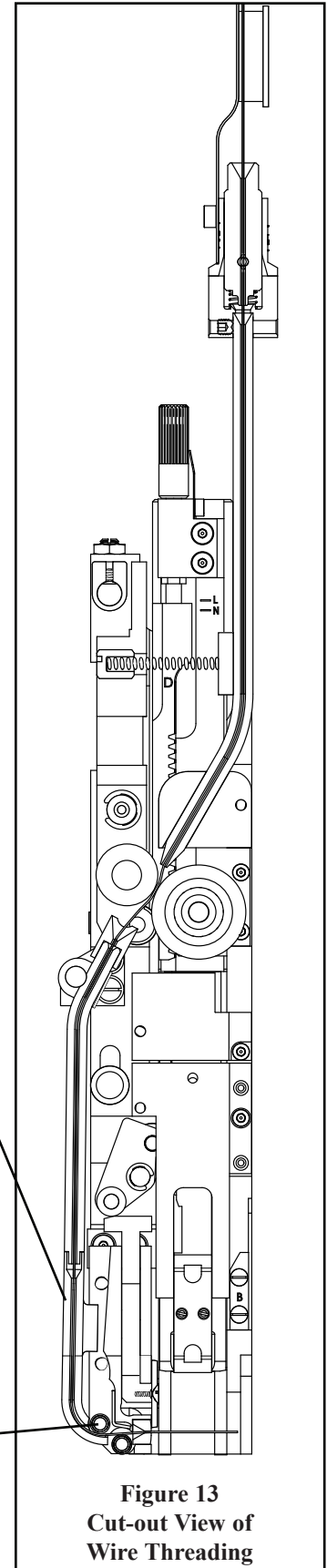
Cutter Block  
G20197A



**Figure 12 - Threading the Head**

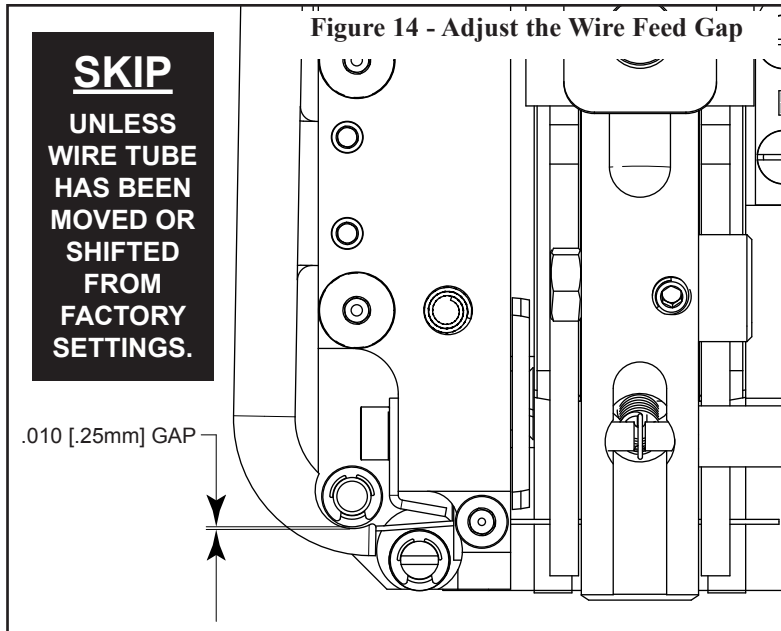
Wire Guides  
G20541

Wire Straightener  
Eccentric  
G20206

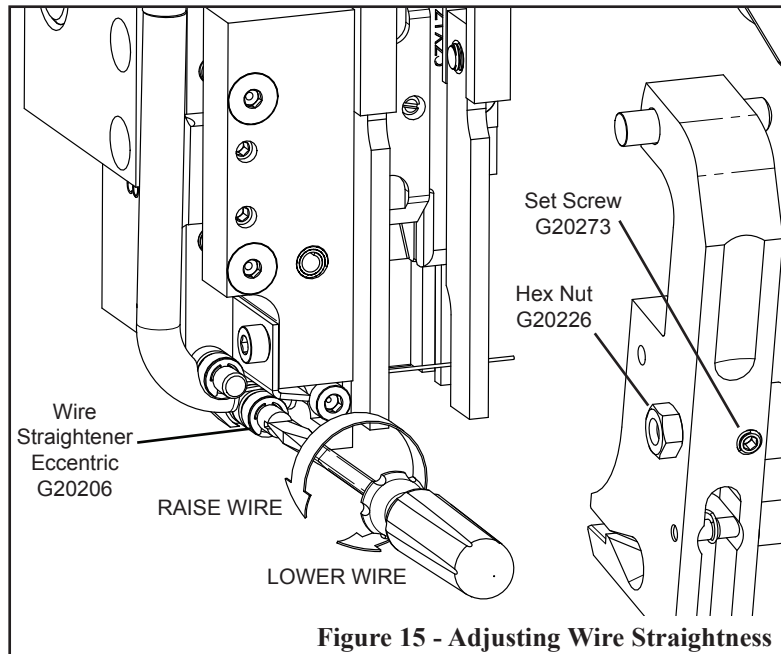


**Figure 13  
Cut-out View of  
Wire Threading**

## Adjusting Wire Straightness (Fig. 14-17)

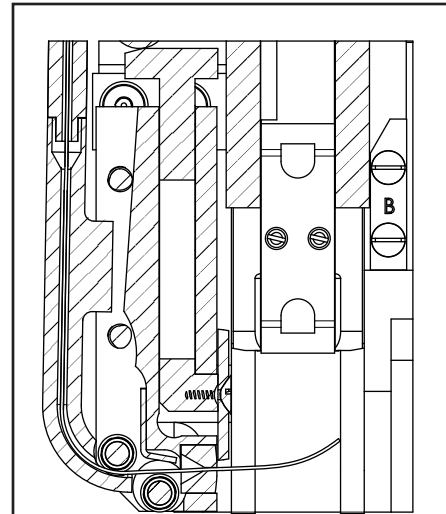


Note: Use a metal shim to set gap will simplify this step.

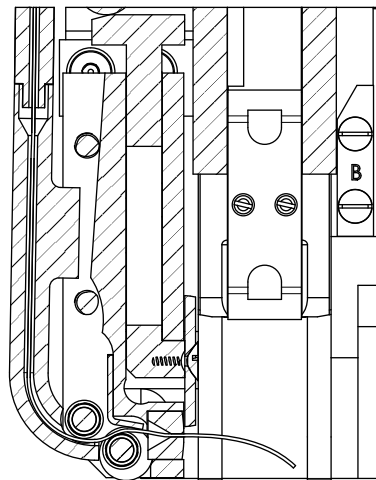


### Horizontal Adjustment (Figures 15-16)

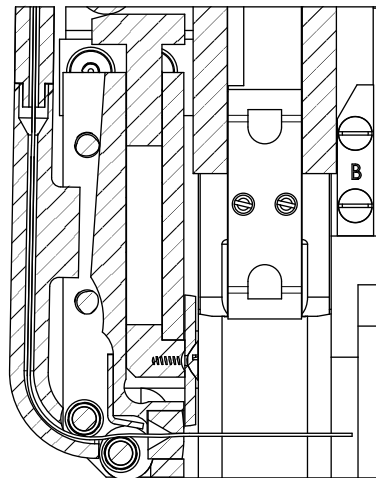
Observe the direction the wire is moving as it emerges. Use a slotted head screwdriver on the Wire Straightener Eccentric in the Cutter Block to adjust the wire. If the wire is curved upwards, turn the Wire Straightener Eccentric clockwise. If the wire is feeding downward, turn the Eccentric counter-clockwise.



**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.

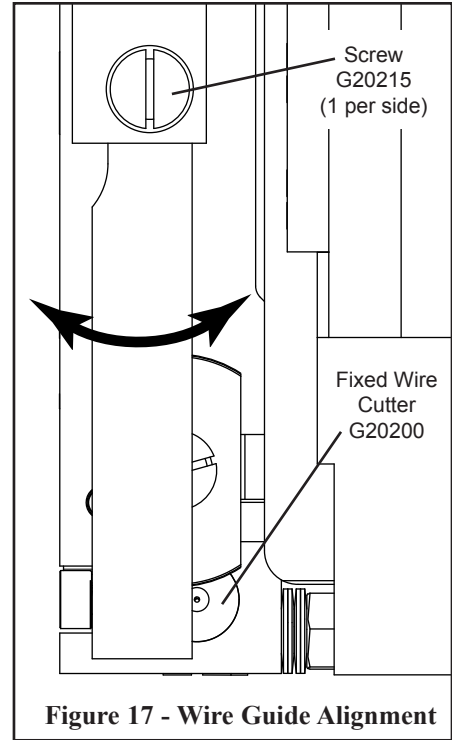
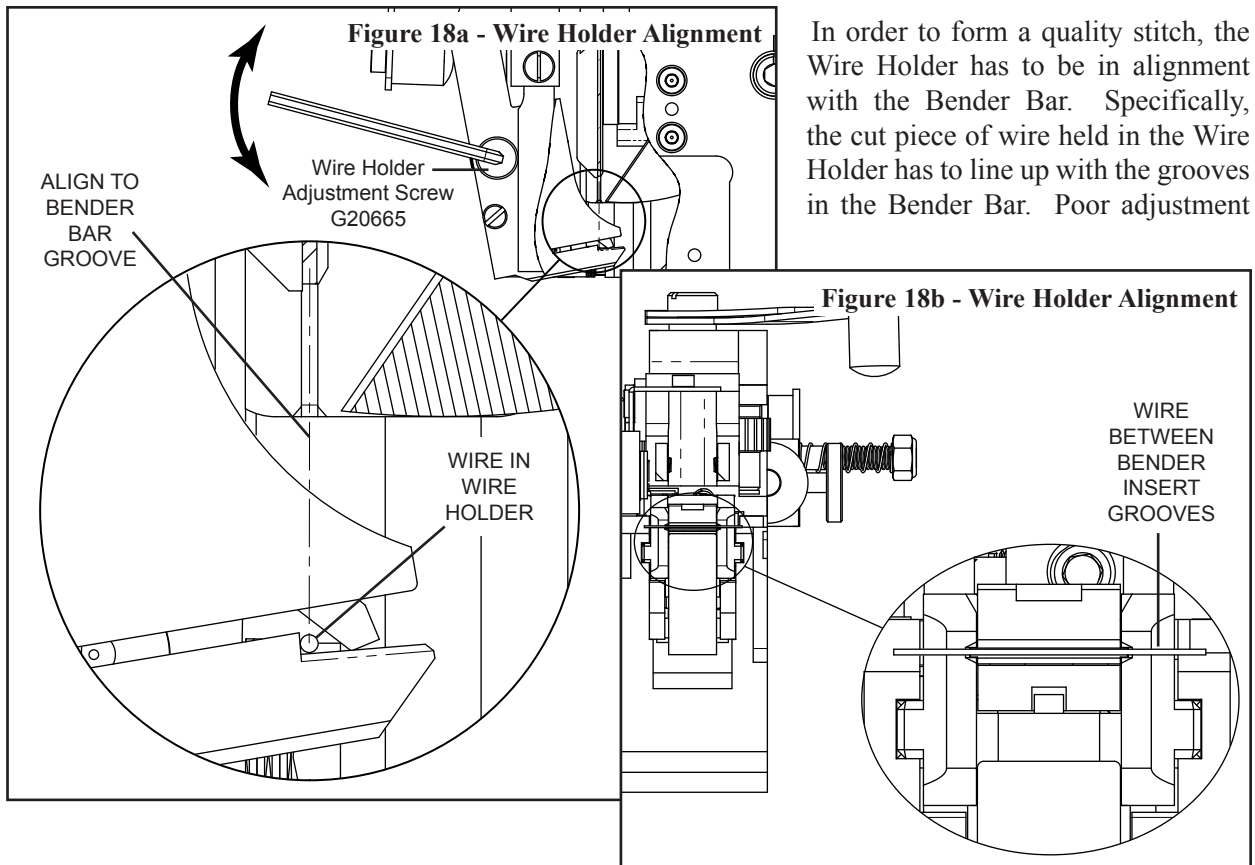


Figure 17 - Wire Guide Alignment

### Aligning the Wire Holder (Figure 18a & b)



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

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)

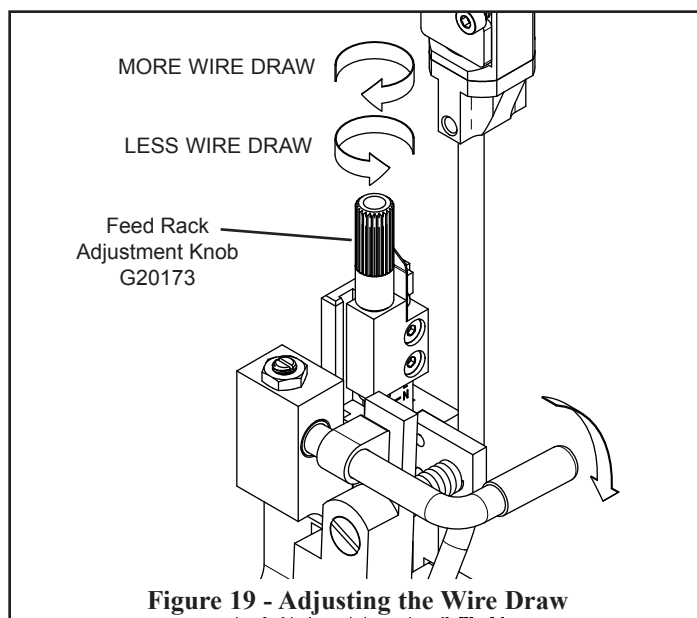


Figure 19 - Adjusting the Wire Draw

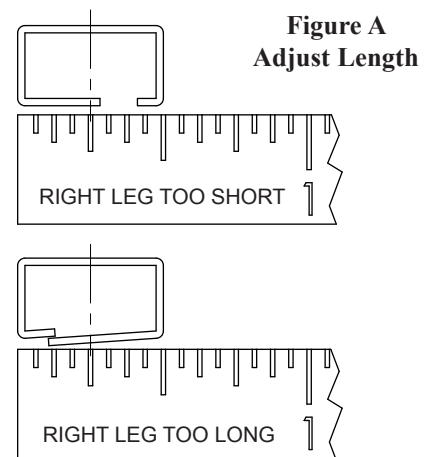


Figure A  
Adjust Length

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.

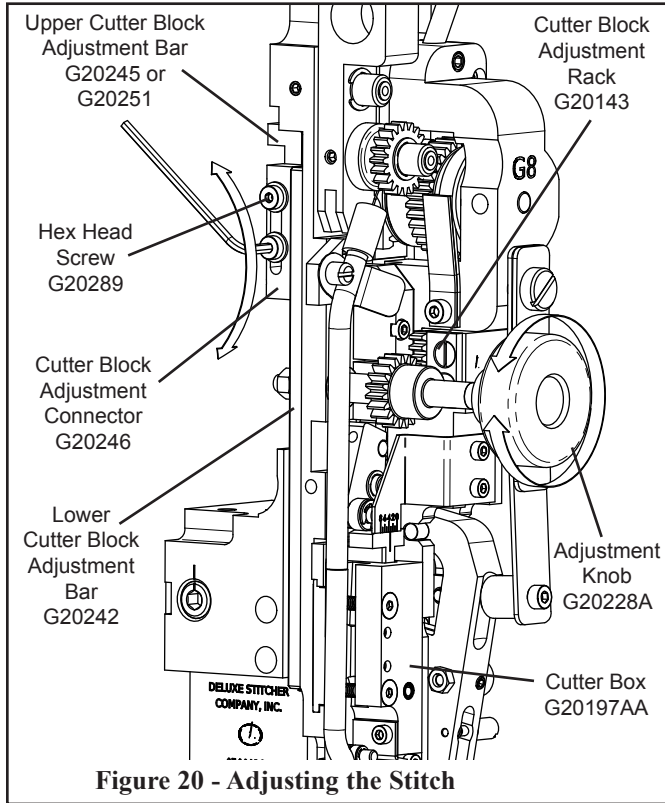
### Setting the Stitch Gap (Or Adjusting the Wire Draw)

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)

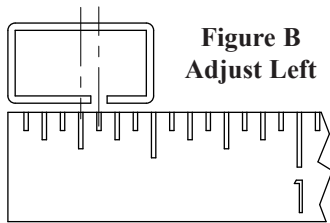
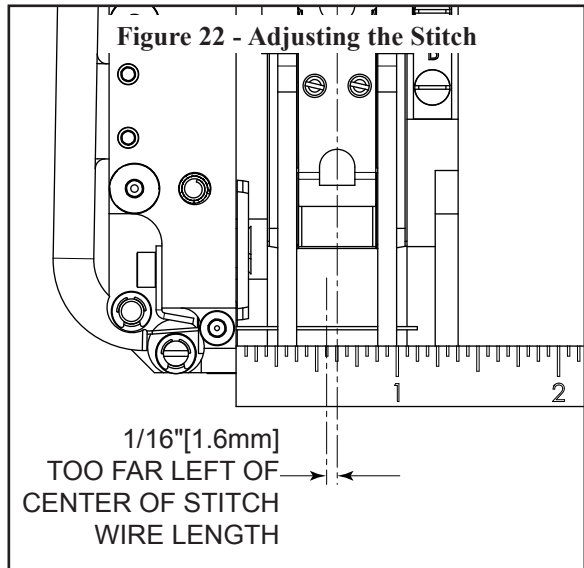
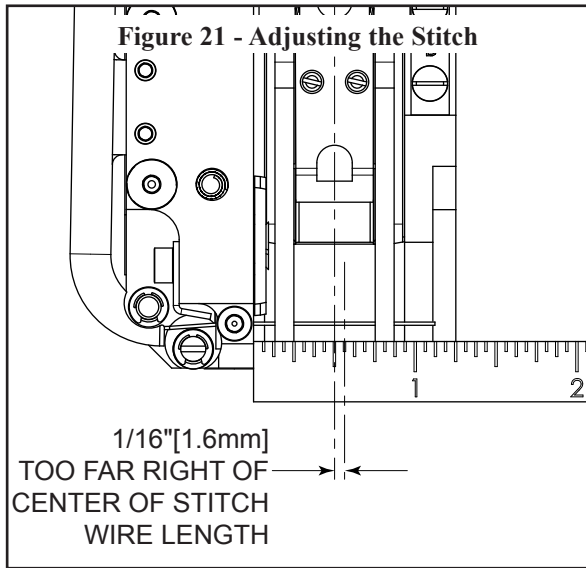
### Centering the Stitch Gap (Or Setting Equal Length Legs)

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.

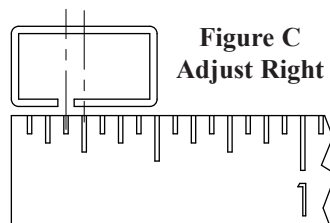


For **G8 Heads mounted to a machine with an adjuster rail**, loosen the two (2) Hex Head Screws securing the Lower Cutter Block Adjustment Bar and Cutter Block Adjustment Connector to the Upper Cutter Block Adjustment Bar (both versions shown in Fig. 4). **For all G8 style Heads**, place the Adjustment 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.

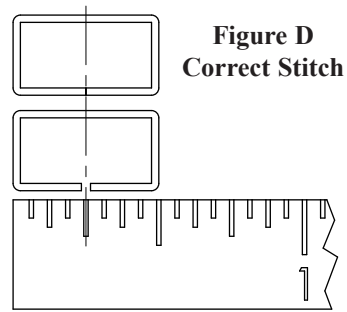
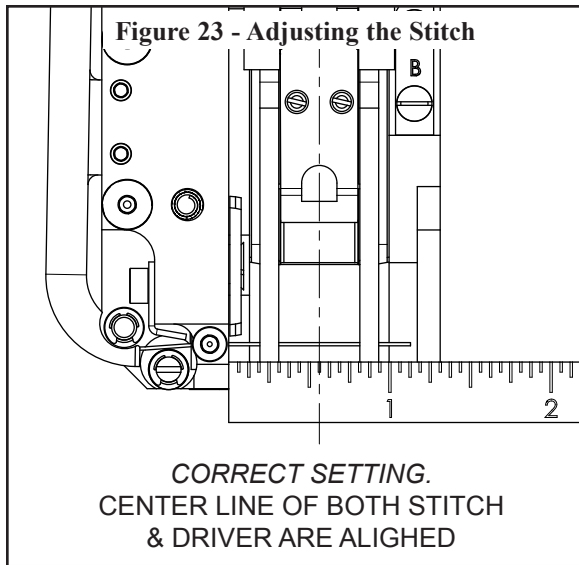
**⚠ WARNING**  
**Always disconnect the power supply before making any adjustments or servicing the head.**



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)

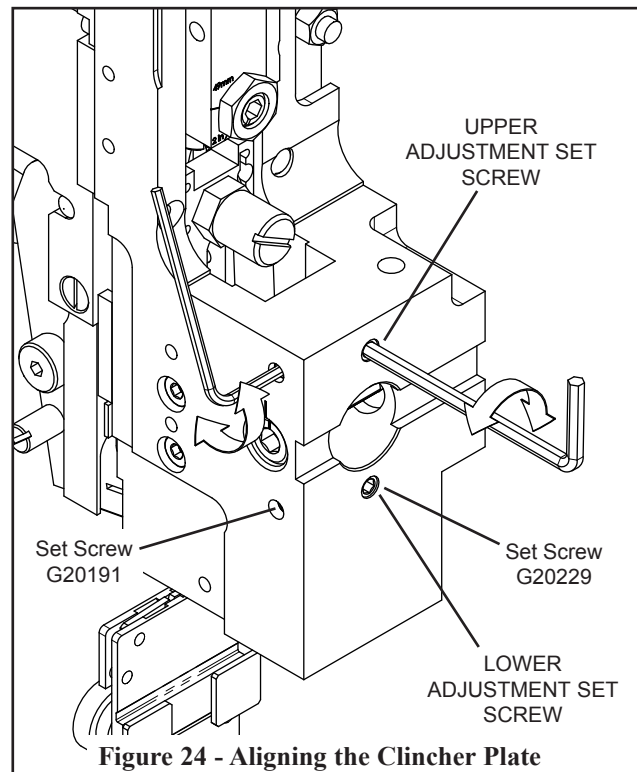
In order to produce properly clinched staples, the center of the Clincher Plate (round or flat, thick or thin) must be exactly in line with the Driver both left-to-right and front-to-back.

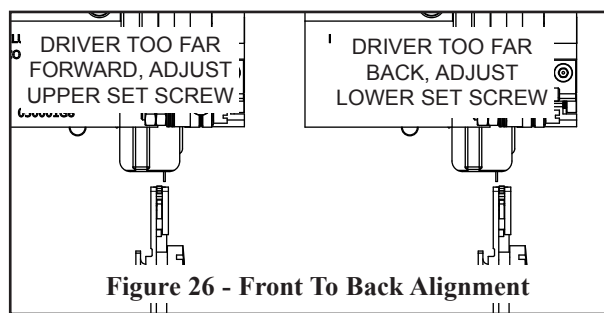
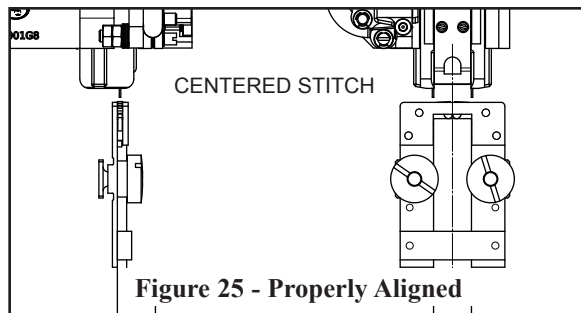
#### Front-to-Back Adjustment

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.

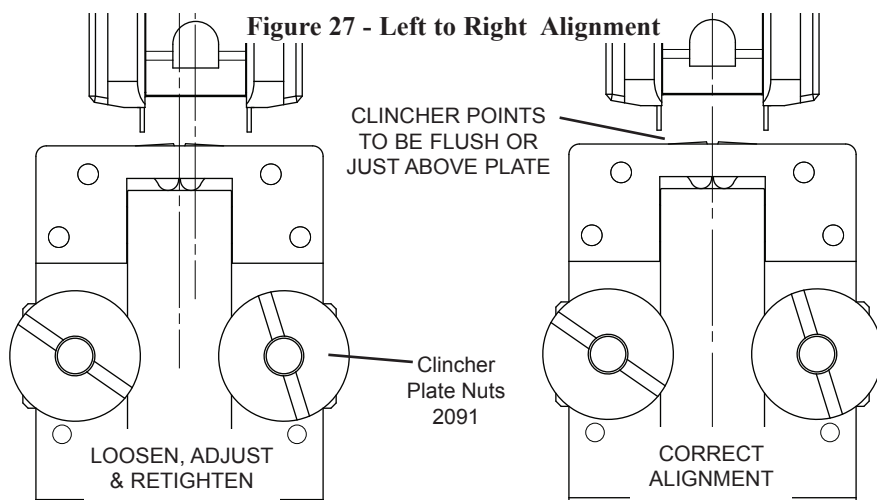




Slight adjustments to the Set Screws make significant differences in position. Once the position is set, tighten the two (2) Socket Head Set Screws in the side of the Stitcher Head.

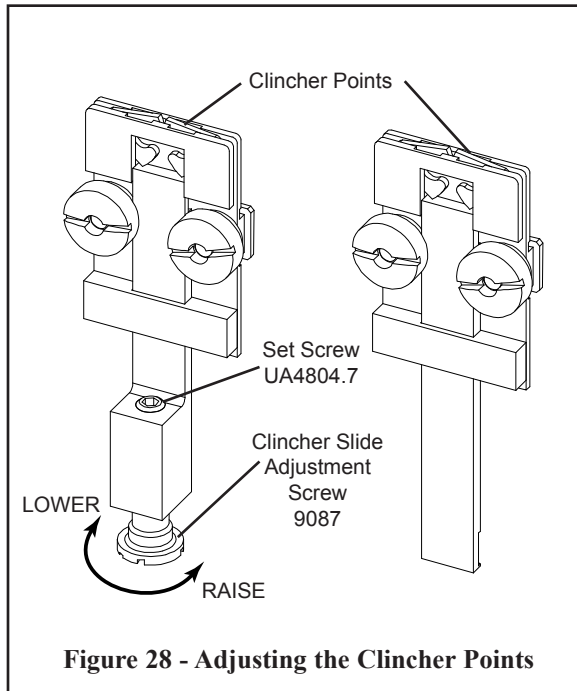
### Left-to-Right

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.*

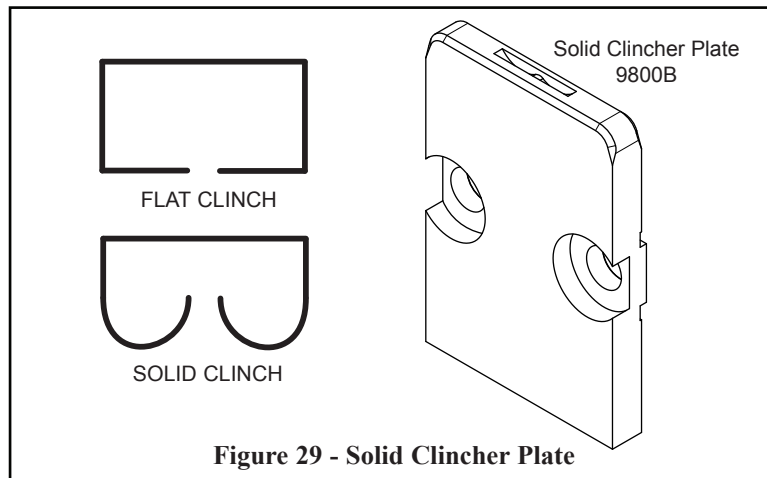
To adjust the Clincher Points, loosen the Set Screw on the top of the Clincher Slide (9084B). Turn the Clincher Slide Adjustment Screw clockwise to lower the Clincher Points and counter-clockwise to raise them. Once set, reighten the Set Screw.

*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.

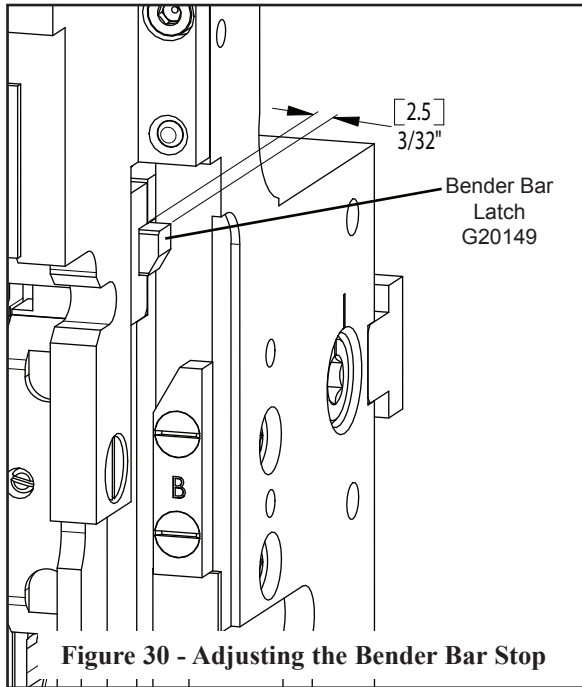


**Figure 29 - Solid Clincher Plate**

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

**⚠ WARNING**

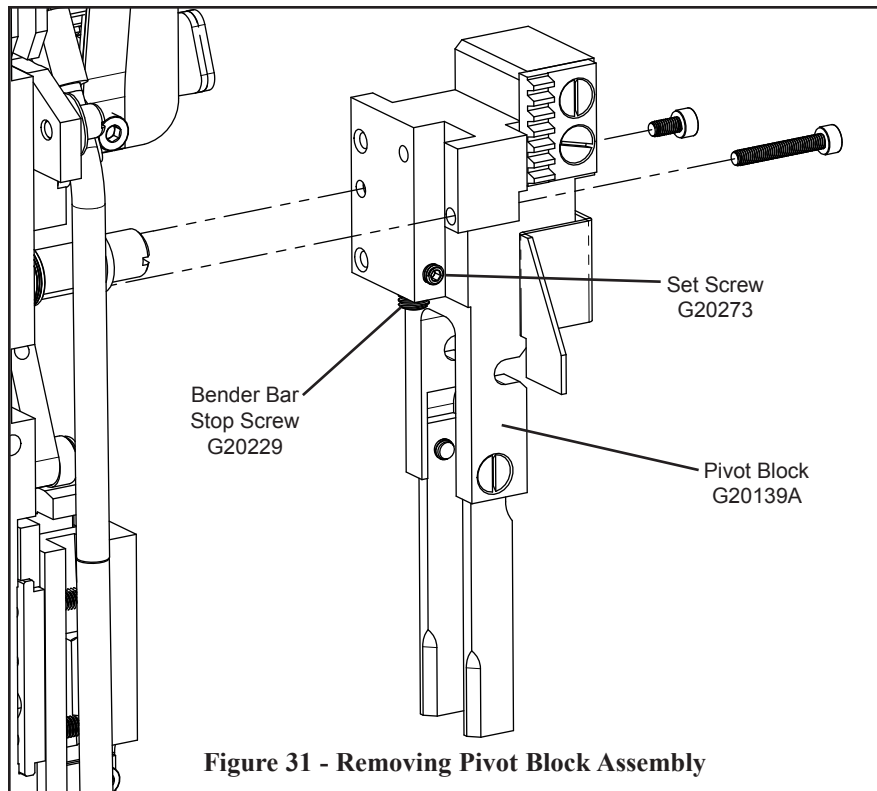
## Adjusting the Bender Bar Stop (Figures 29-31)

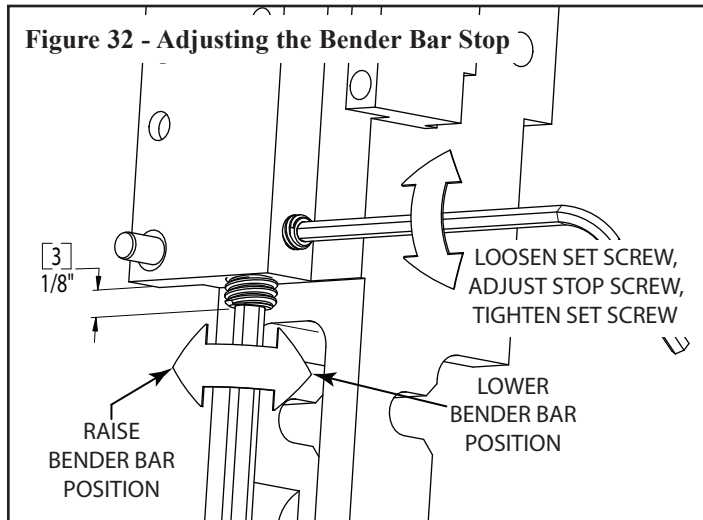


The Bender Bar Stop is set at the factory. The Stop controls the position of the Bender Bar Latch at the top of the stitcher head's stroke. If the Latch does not fall within the proper area of the Driver Bar, partially formed stitches will result or the G8 will jam.

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.

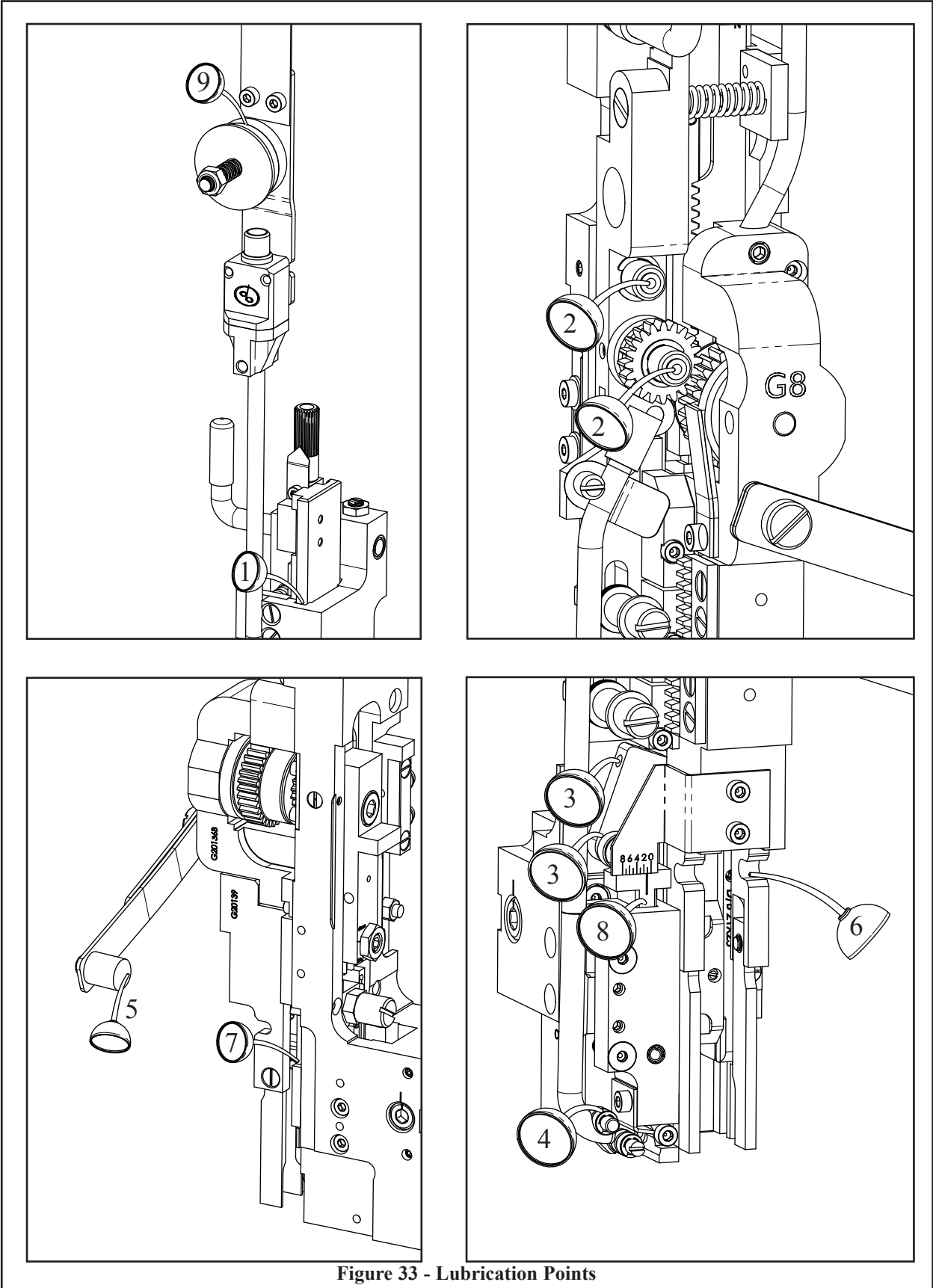
## Maintenance

### 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.





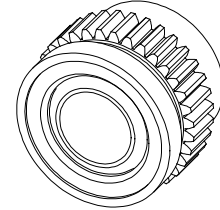
## Cleaning

**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**

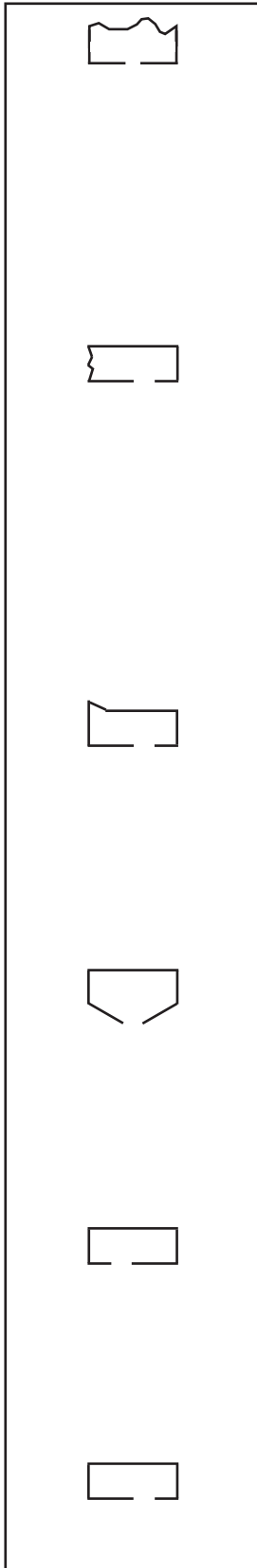
## Ordering Spare Parts

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 35)

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.

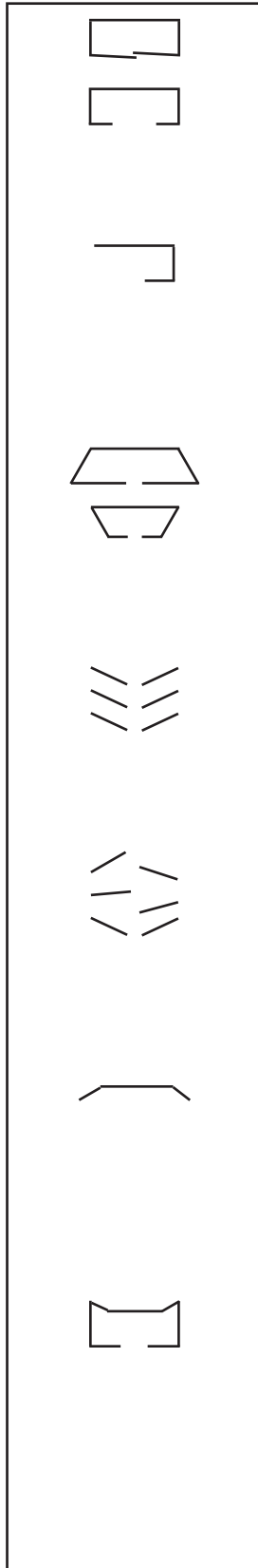
**PROBLEM:** Left Leg Too Short / Right Leg Too Long

**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 35 - 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

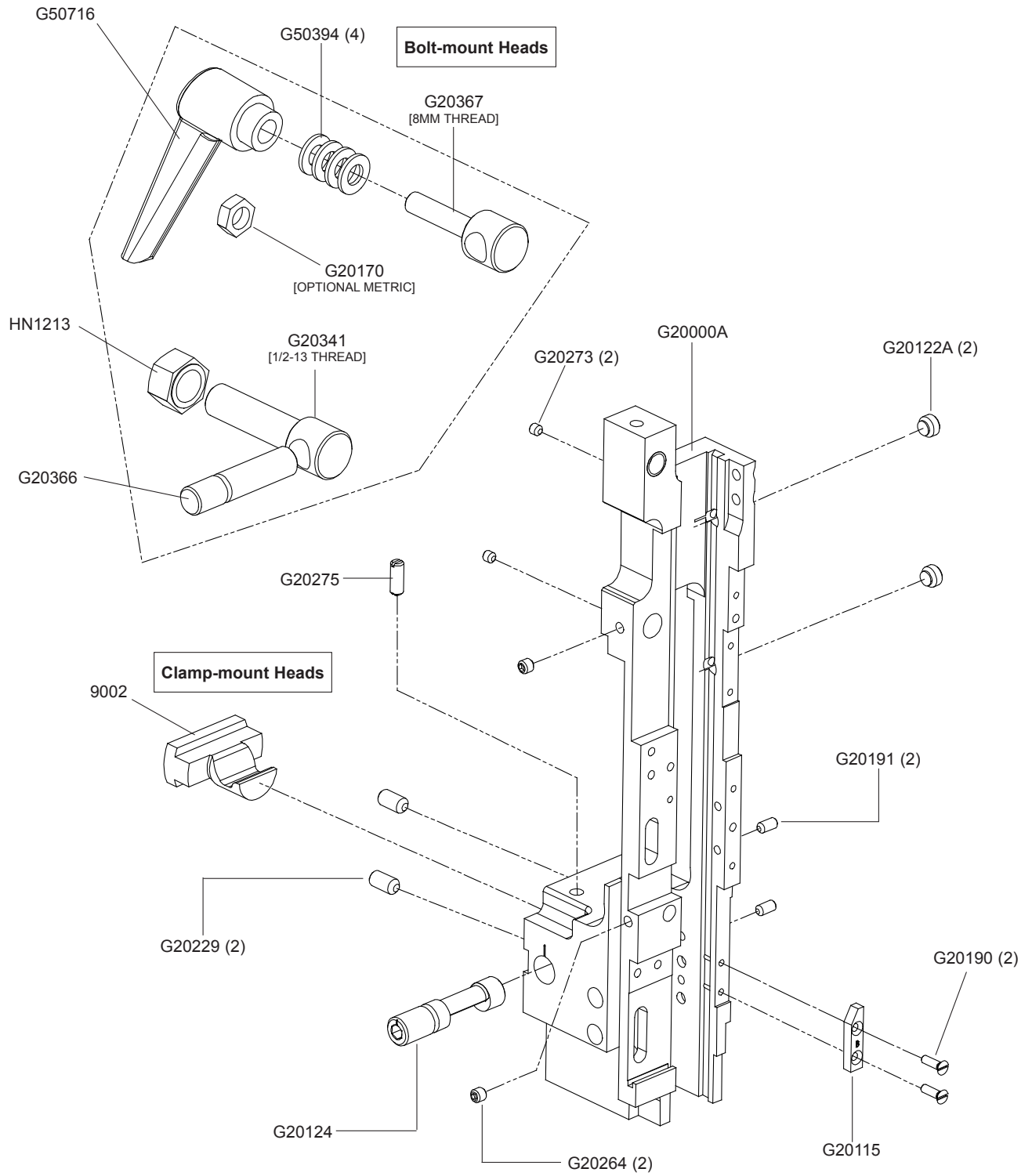
**SOLUTION:** Align the Wire Holder with the grooves in the Bender Bar (See page 15). Check the tensile strength and size of the wire being used.

**PROBLEM:** No wire being drawn

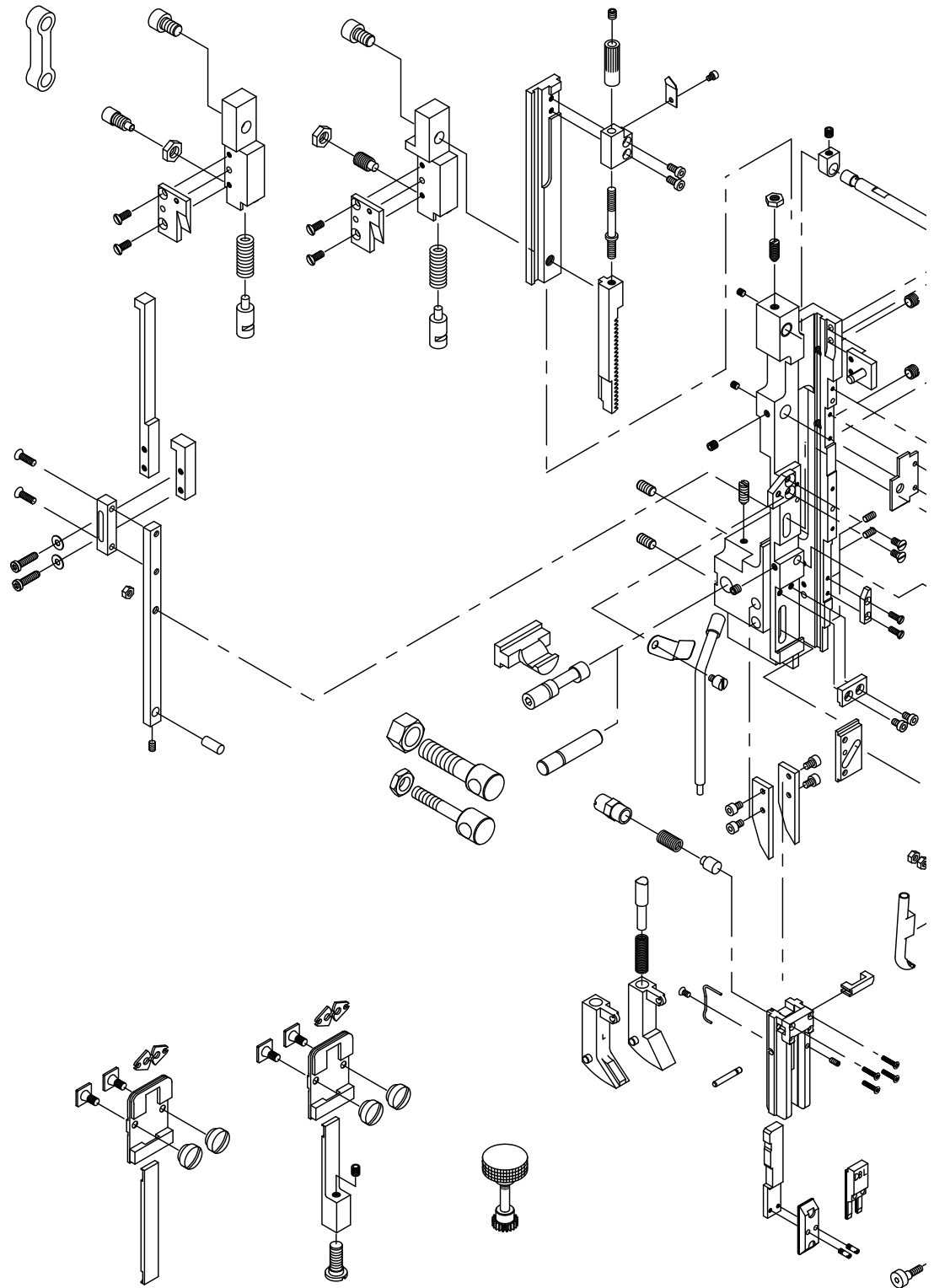
**SOLUTION:** Make sure the Feed Release Handle is turned to the “on” position and the Feed Gears engaged. (See page 13)

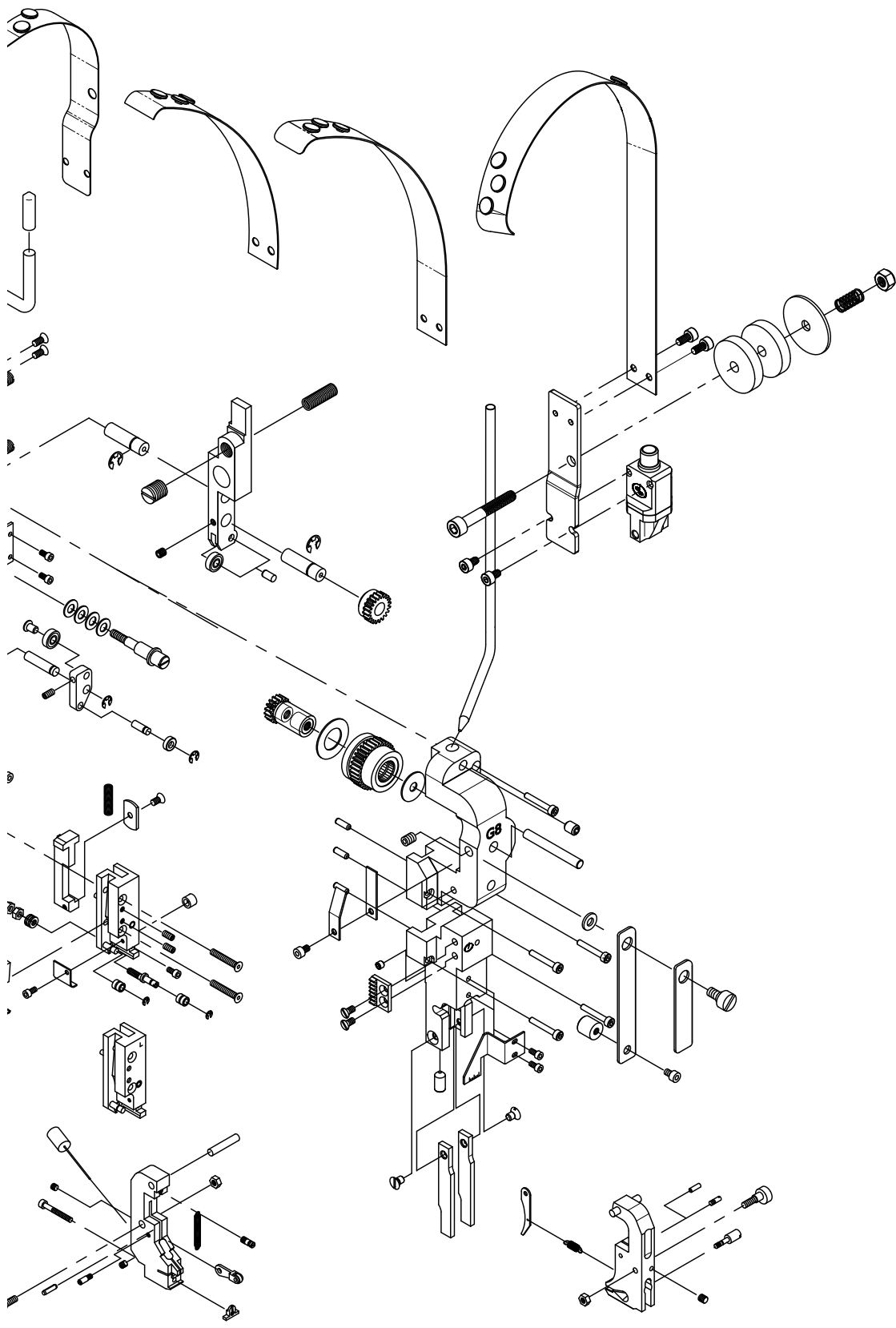
Figure 35 - Troubleshooting

# Bonnet Sub-Assembly

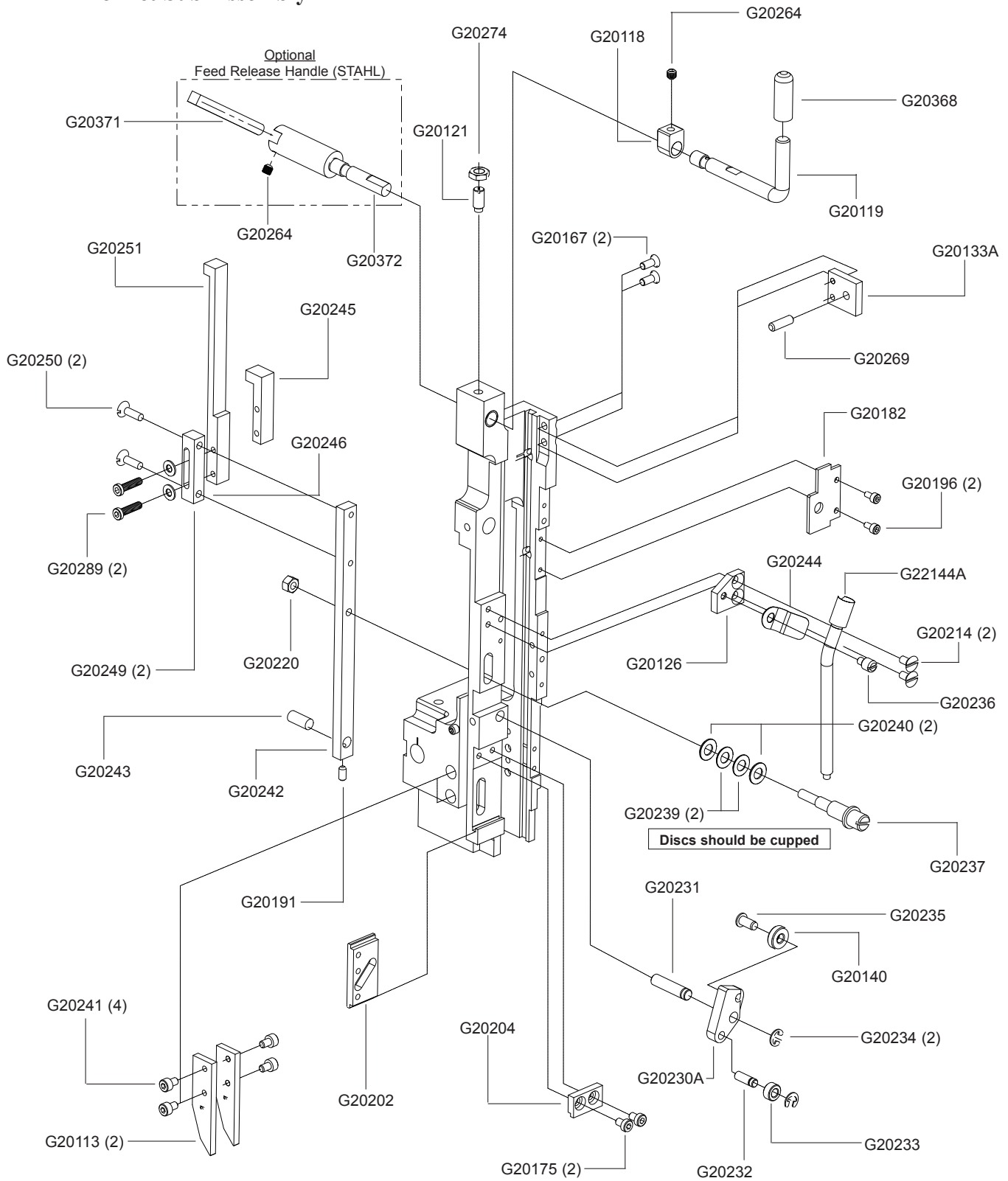


# The G8 Stitcher Head



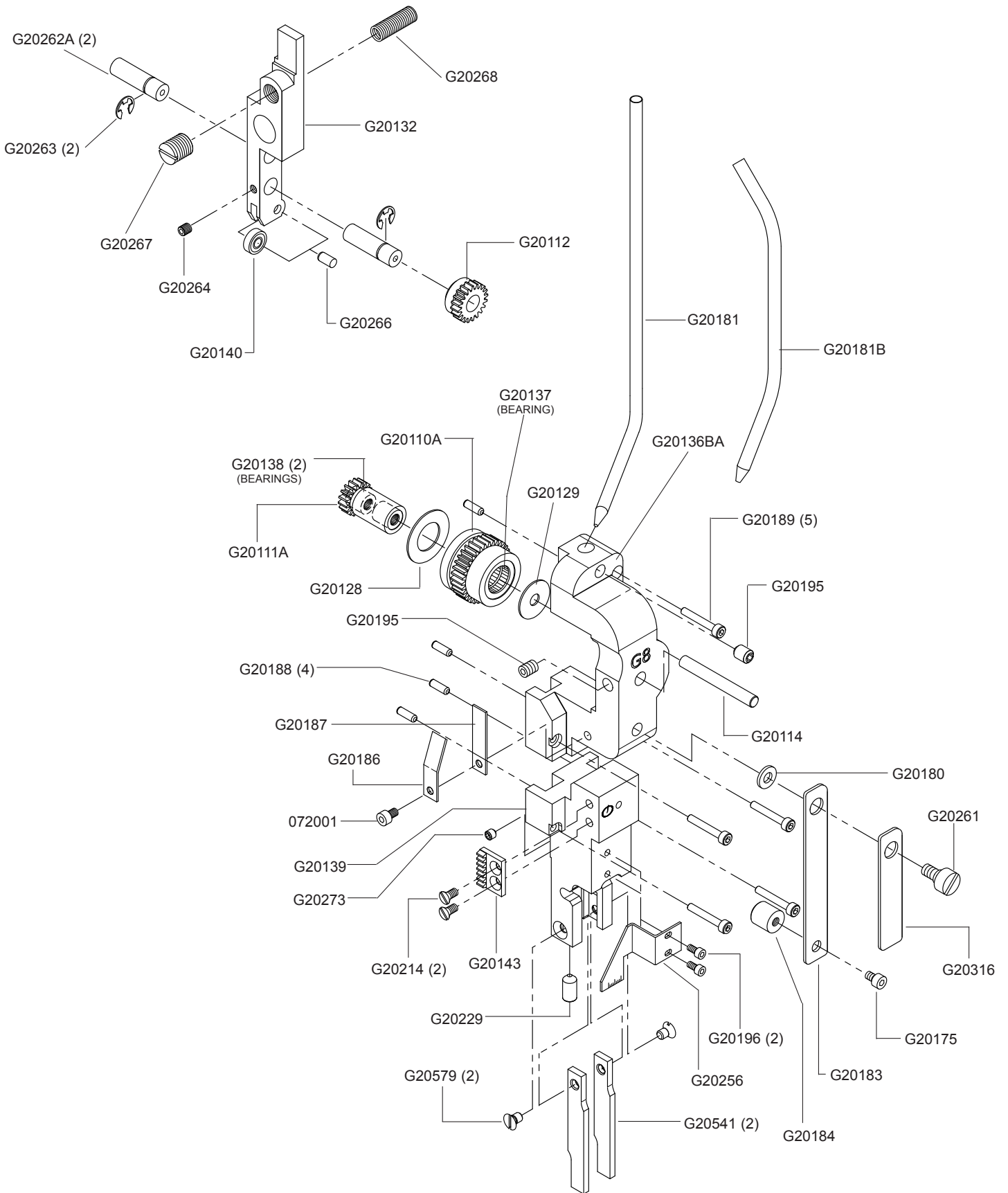


# Bonnet Sub-Assembly

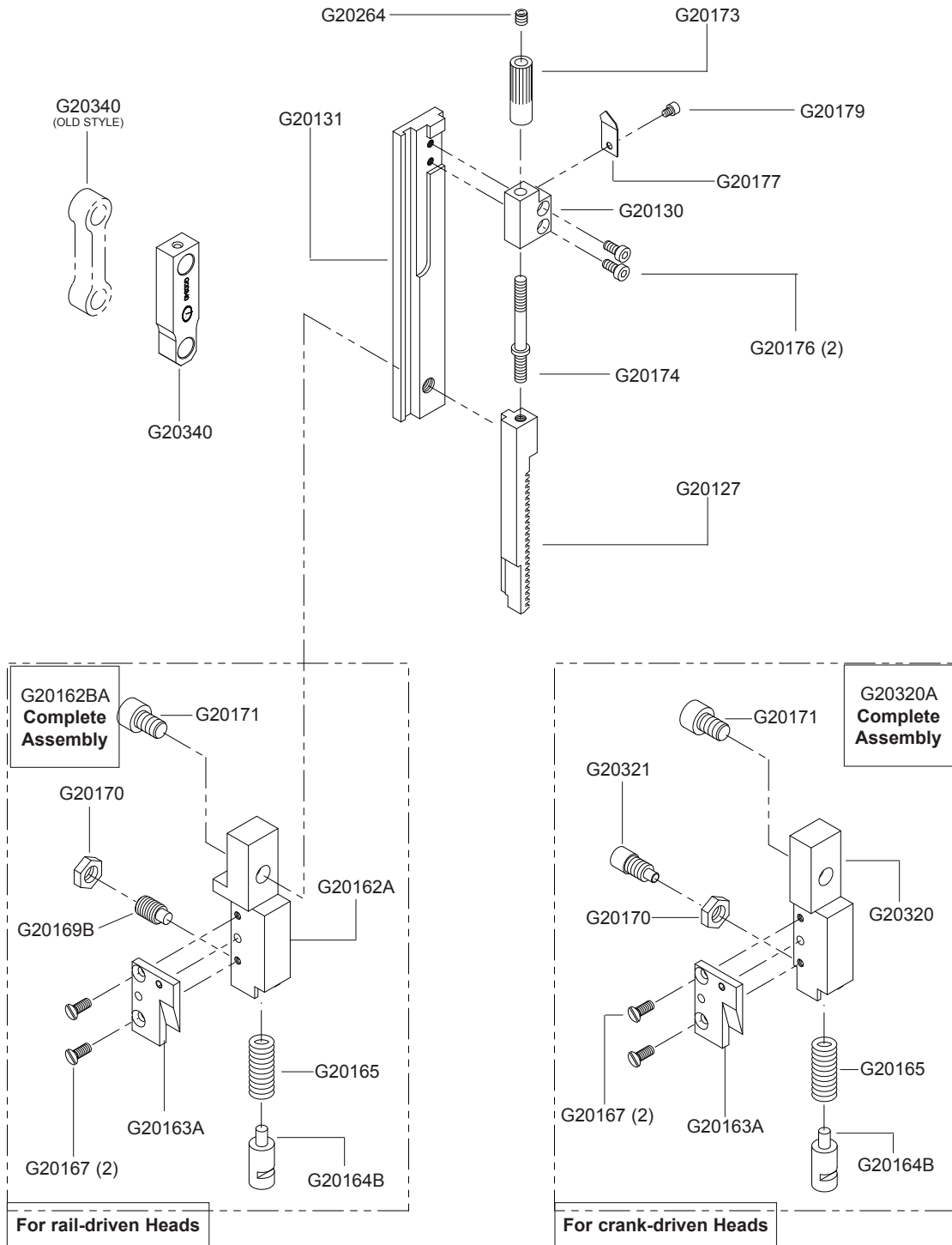




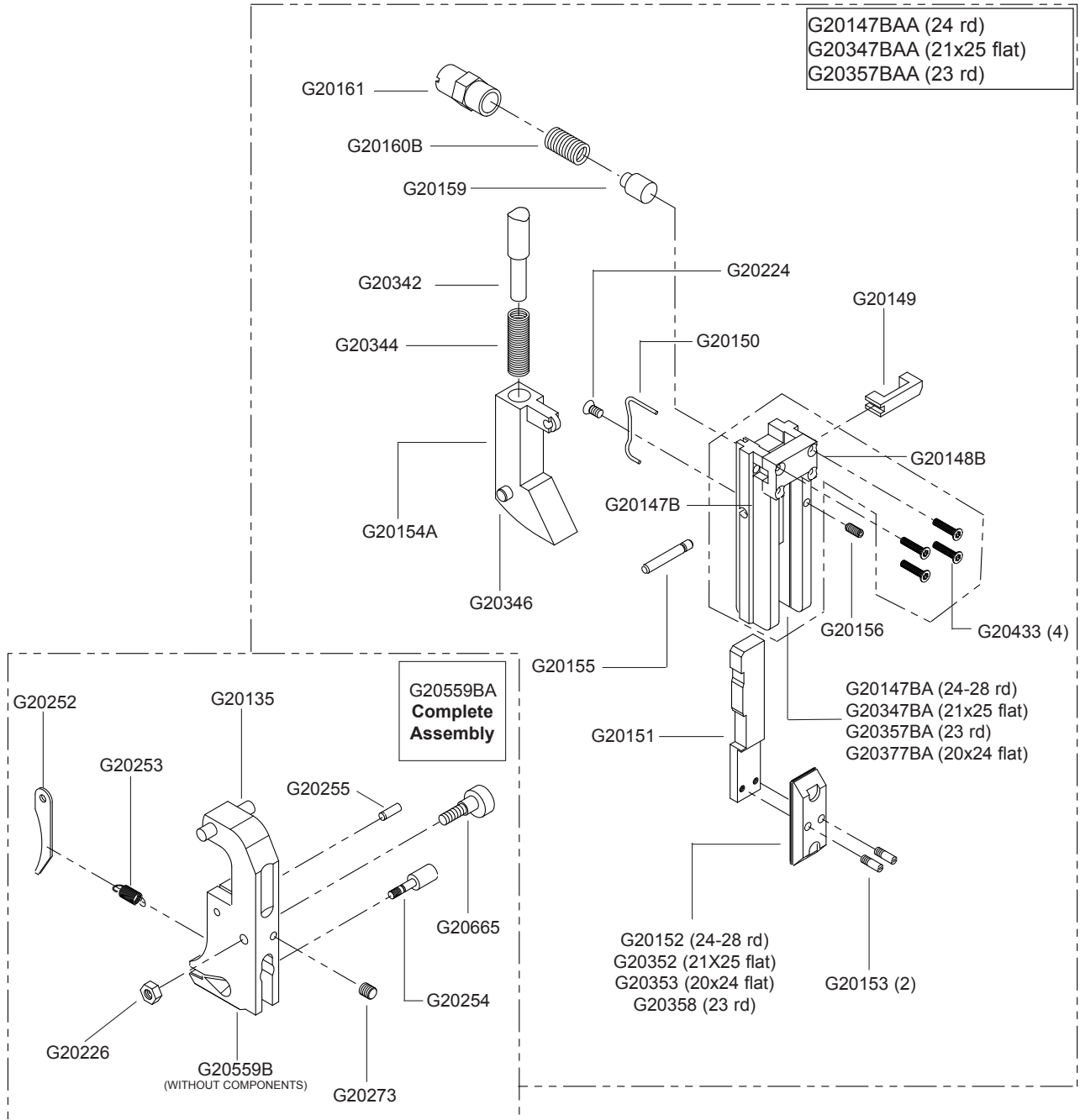
# Feed Lever and Feed Gear Assemblies



# Driving and Feed Slide Assemblies

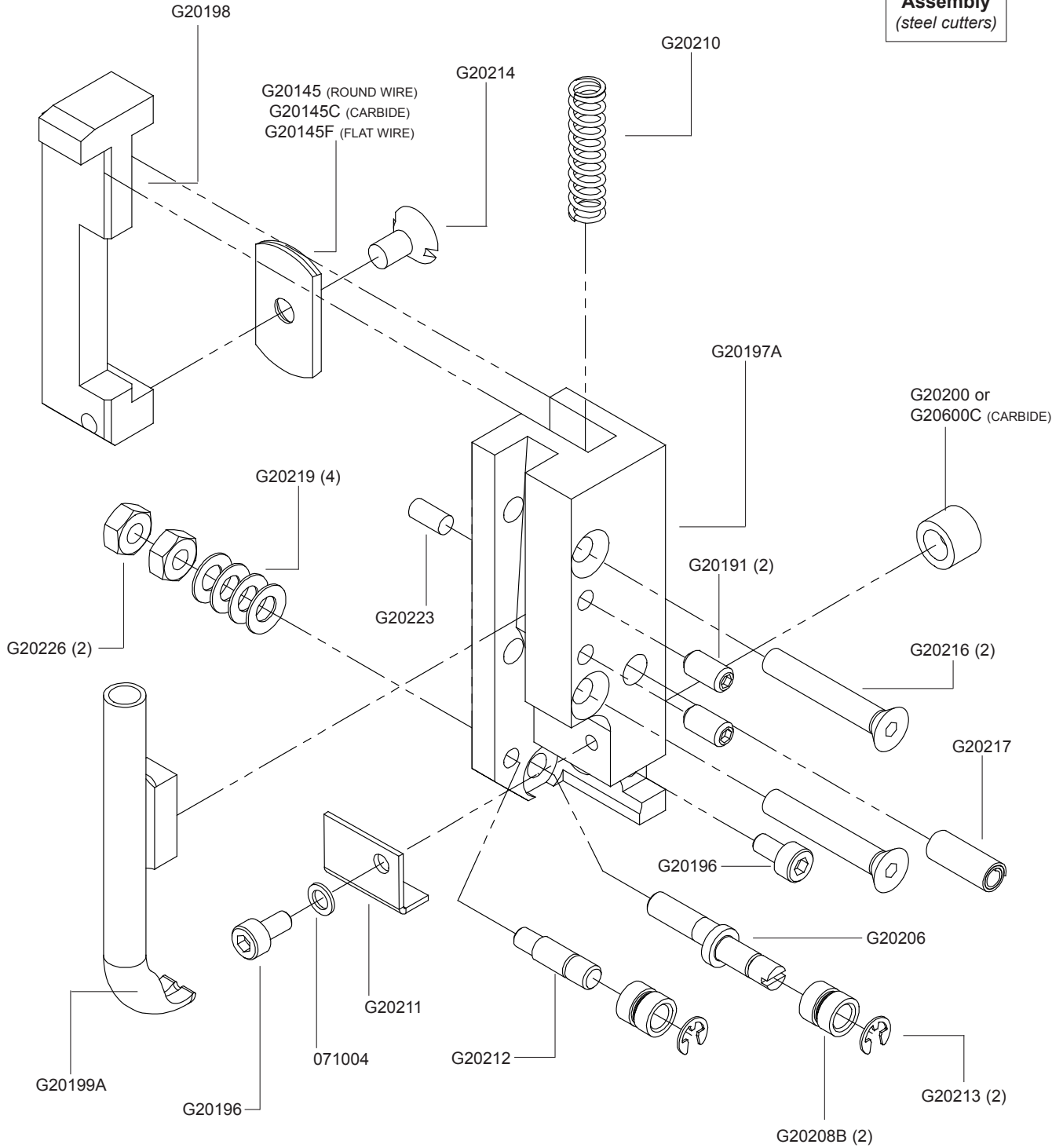


## Bender Bar and Wire Holder Assemblies

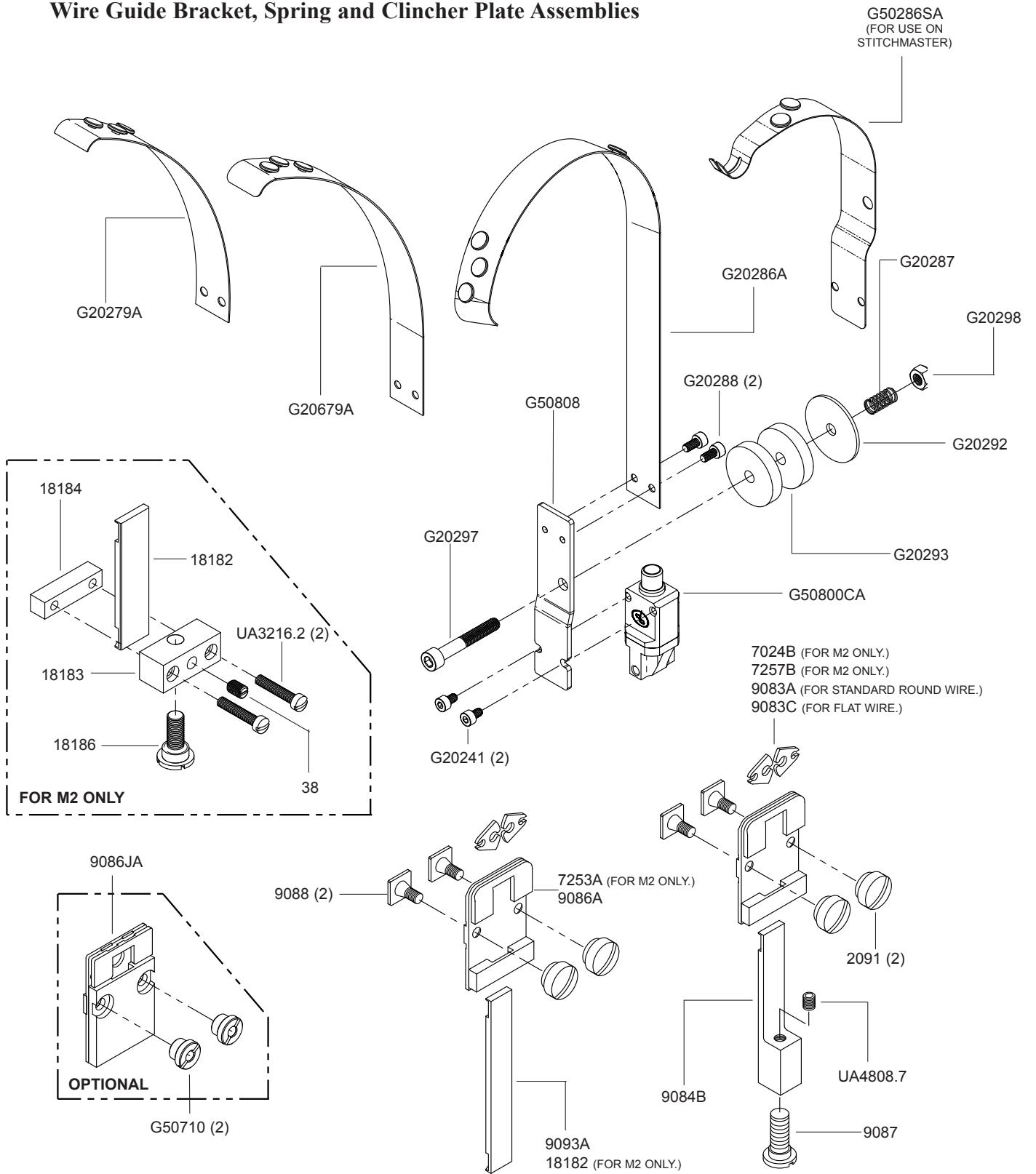


# Cutter Block Assembly

**G20197AA  
Complete  
Assembly  
(steel cutters)**

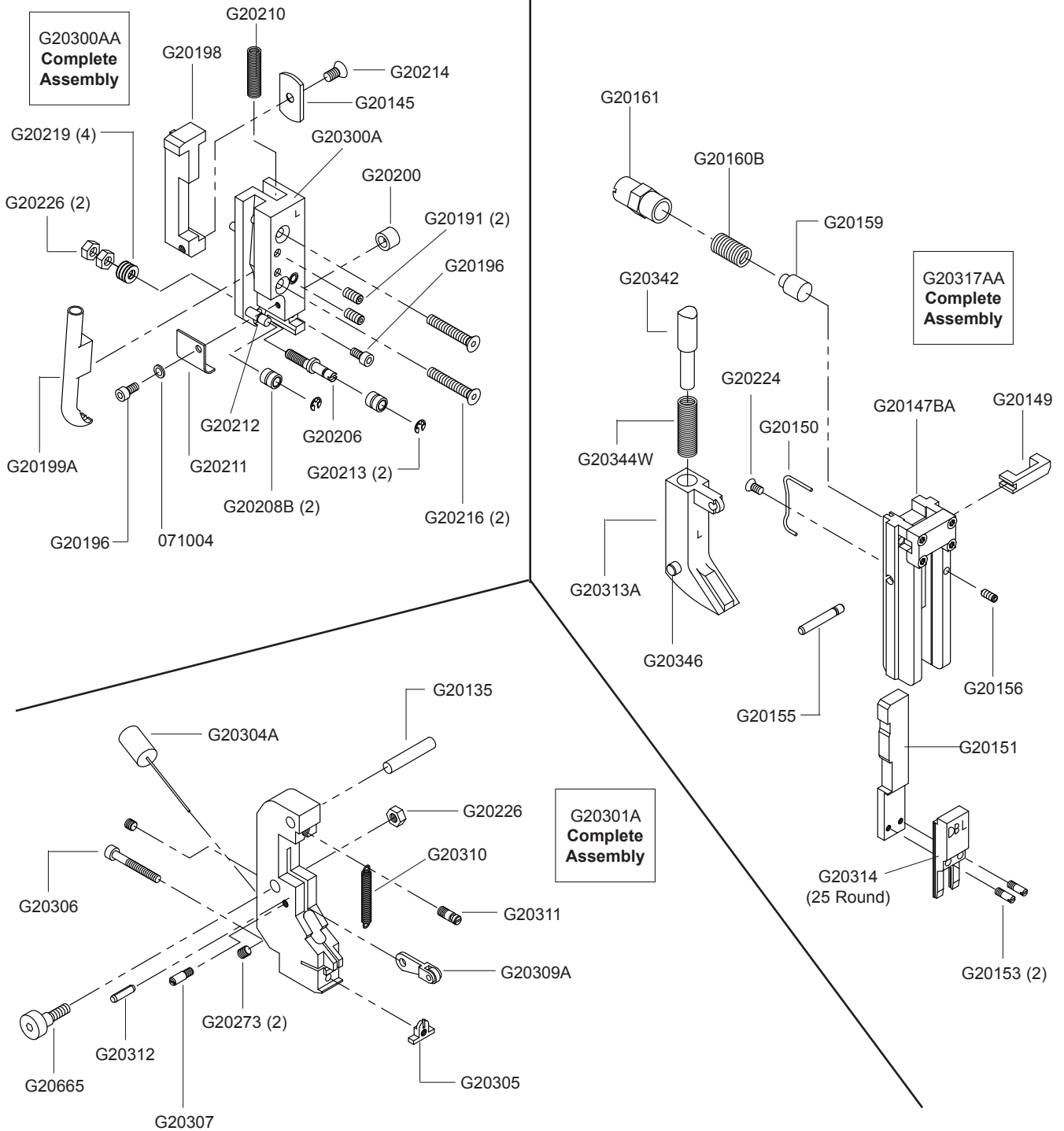


# Wire Guide Bracket, Spring and Clincher Plate Assemblies



# Loop Stitch Kit

G8KL Loop Conversion Kit includes all parts shown below.



## Part Number / Description Cross-Reference

072001	Screw M4x0.7x8	1	G20130	Feed Adjustment Block	1
071004	Lock Washer, M3	1	G20131	Feed Slide	1
18182	Clincher Slide	1	G20132	Feed Lever	1
18183	Clincher Slide Adjustment Block	1	G20133A	Feed Release Spring Block Assembly	1
18184	Clincher Slide Block Clamp	1	G20135	Dowel Pin M5x24	1
18186	Clincher Slide Adjustment Screw	1	G20136BA	Feed Gear Bracket Assembly	1
2091	Clincher Plate Binder Nut	2	G20137	Roller Clutch Bearing	1
38	Clincher Slide Adjustment Screw	1	G20138	Feed Pinion Bearing	2
7024B	Clincher Point - Flat	2	G20139	Pivot Block Insert	1
7253A	Clincher Plate Assembly - 1/2	1	G20140	Follower Ball Bearing	1
7257B	Clincher Point - Round	2	G20143	Cutter Block Adjustment Rack	1
9002	Bonnet Clamp Block	1	G20144A	Middle Wire Tube Assembly	1
9083A	Clincher Point - Thick, Round	2	G20145	Moving Cutter - Round Wire	1
9083C	Clincher Point - 20x24, Flat	2	G20145C	Moving Cutter - Carbide	1
9084B	Adjustable Clincher Slide	1	G20145F	Moving Cutter - Flat Wire	1
9086A	Clincher Plate - Thick	1	G20147BA	Bender Bar Assembly, 24W	1
9086JA	Clincher Plate - Thick	1	G20148B	Latch Housing, Removable	1
9087	Clincher Slide Adjusting Screw	1	G20149	Bender Bar Latch	1
9088	Clincher Plate Binder Bolt	2	G20150	Bender Bar Latch Spring	1
9093A	Clincher Slide - Thick	1	G20151	Driver Bar	1
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

## Part Number / Description Cross-Reference

G20171	Screw M8x1.25x12	1	G20220	Hex Nut M5x.8	1
G20173	Feed Rack Knob - Knurled	1	G20223	Dowel Pin 1/8x1/4	1
G20174	Feed Rack Adjustment Stud	1	G20224	Bender Bar Latch Spring Screw	1
G20175	Screw M4x.7x6 SHCS	3	G20226	Hex Nut M4x.7	2
G20176	Screw M4x.7x12 SHCS Low Head	2	G20228A	Adjustment Handle Assembly	1
G20177	Feed Rack Adj Knob Pointer	1	G20229	Set Screw M6x1x12	2
G20179	Screw M3x.5x4, SHCS	1	G20230A	Cutter Operating Lever Assembly	1
G20180	Flat Washer M6	1	G20231	Cutter Operating Lever Pivot Pin	1
G20181	Upper Wire Tube	1	G20232	Cutter Operating Lever Roll Pin	1
G20182	Feed Gear Shaft Plate	1	G20233	Cutter Operating Lever Roller	1
G20183	Wire Holder Retaining Spring - Long	1	G20234	E-Ring- 3/16"	1
G20184	Wire Holder Retaining Spring Foot	1	G20235	Follower Bearing Shaft	1
G20186	Feed Gear Friction Spring	1	G20236	Tube Pivot Screw	1
G20187	Feed Gear Friction Strip	1	G20237	Cutter Block Adjustment Stud	1
G20188	Dowel Pin, 1/8"x3/8"	4	G20239	Disc Washer Spring	2
G20189	Screw M3x.5x20	3	G20240	Cutter Block Adjustment Washer	2
G20190	Screw M3x.5x10- FHMS- Slotted	4	G20241	Screw M4x0.7x6 SHCS	4
G20191	Screw, M4x.7x8 SHSS	5	G20242	Cutter Adjustment Bar - Lower	1
G20195	Set Screw M6x1x8	2	G20243	Dowel Pin 1/4x9/16	1
G20196	Screw M3x.5x6 SHCS	8	G20244	Tube Pivot Clip	1
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	G20256	Cutter Block Scale	1
G20211	Cutter Wire Shield	1	G20261	Wire Holder Retaining Spring Screw	1
G20212	Wire Straightener Roll Stud	1	G20262A	Feed Lever Pin Assembly	2
G20213	Wire Straightener Roll Clip	2	G20263	Feed Lever E-Ring	2
G20214	Screw M4x0.7x8 FHMS	5	G20264	Screw M5x.8x5 SHCS	5
G20216	Screw M4x.7x25 SFHS	2	G20266	Follower Bearing Pin	1
G20217	Spirol Pin M5x12	1	G20267	Feed Lever Bushing	1
G20219	Wire Straightener Disc Spring	4	G20268	Feed Lever Spring	1



## Part Number / Description Cross-Reference

G20269	Spirol Pin 3/16x5/8	1	G20346	Supporter Guide Pin	1
G20273	Screw M4x.7x4 SHSS	2	G20347BA	Bender Bar Assembly,21x25	1
G20274	Hex Jam Nut, M6x1	1	G20352	Driver, 21x25W	1
G20275	Ball Spring Plunger	1	G20353	Driver, 20x24W	1
G20279A	Wire Guide Spring Assembly - Short	1	G20357BA	Bender Bar Assembly, 23W	1
G20286A	Wire Guide Spring Assembly - Long	1	G20358	Driver, 23W	1
G20287	Wire Oiler Felt Spring	1	G20360	Hex Key Wrench 3.0mm	1
G20288	Screw, M4x.7x8 SHCS	4	G20361	Hex Key Wrench 2.5mm	1
G20289	Screw M4x.7x16	2	G20362	Clamp Wrench 5.0mm	1
G20292	Wire Oil Felt Washer	1	G20364	Open End Wrench	1
G20293	Wire Oiler Felt	1	G20366	Rear Clamp Pin	1
G20297	Screw, M6x1x40 SHCS	1	G20367	Rear Mounting Bolt	1
G20298	Nylock Lock Nut, M6x1	1	G20368	Feed Release Handle Cap	1
G20300A	Cutter Block Assembly - Loop	1	G20371	Feed Release Handle	1
G20301A	Wire Holder Assembly - Loop	1	G20372	Feed Release Shaft	1
G20304A	Wire Hook Assembly - Loop	1	G20374	Hex Key Wrench 2.0mm	1
G20305	Anvil - Loop	1	G20377B	Bender Bar, 20x24W	1
G20306	Screw M3x.5x25-SHC	1	G20433	Screw, M2.5x.45x12	4
G20307	Lever Pivot Pin	1	G20541	Wire Guide Bar	2
G20309A	Wire Holder Lever Assembly - Loop	1	G20559BA	Wire Holder Assembly 1/2	1
G20310	Wire Holder Roller Lever Spring	1	G20579	Screw, M4x0.7x6-FHM-Slotted	2
G20311	Spring Anchor Screw	1	G20600C	Fixed Cutter - Carbide	1
G20312	Spirol Pin M3x12	1	G20665	Wire Holder Eccentric Adj Screw	1
G20313A	Supporter Assembly - Loop	1	G20679A	Wire Guide Spring Assembly-Medium	1
G20314	Driver - Loop	1	G50286SA	Wire Guide Spring Assembly-Short	1
G20316	Wire Holder Retaining Spring - Short	1	G50394	Flat Washer - M8	1
G20320	Driving Slide - Crank Drive	1	G50710	Clincher Plate Nut	2
G20320A	Driving Slide Assembly	1	G50716	Mounting Block Handle	1
G20321	Crank Link Screw	1	G50800CA	Anti-Wire Backup Unit	1
G20323A	Cutter Operating Ramp Assembly	1	G50808	Wire Spring Guide Clamp Plate	1
G20340	Crank Drive Link	1	HN1213	Bonnet Stud Nut	1
G20341	Rear Mounting Bolt	1	UA3216.2	Clincher Slide Block Screw	2
G20342	Supporter Spring Plunger	1	UA4808.7	Set Screw, 1/4-28x1/2", SH	1
G20344	Supporter Spring	1			
G20344B	Supporter Spring - Heavy	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.

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.

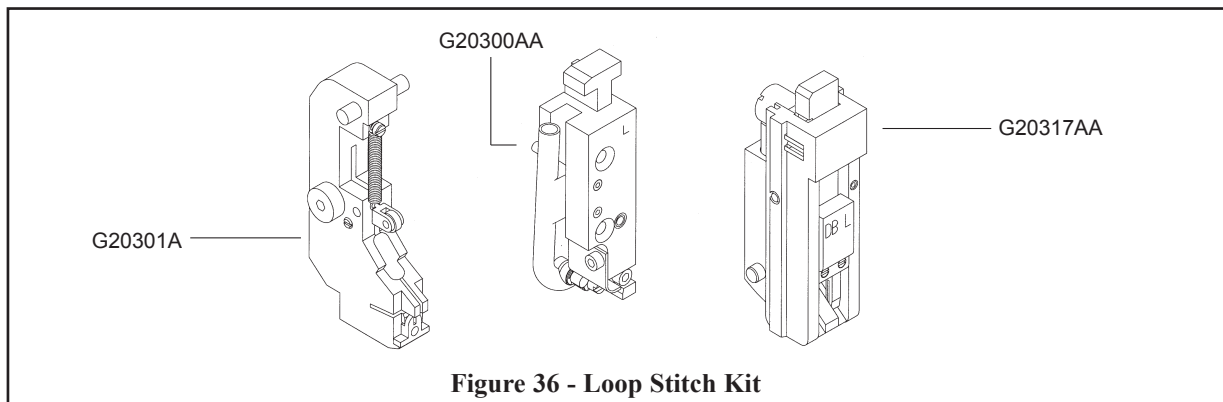
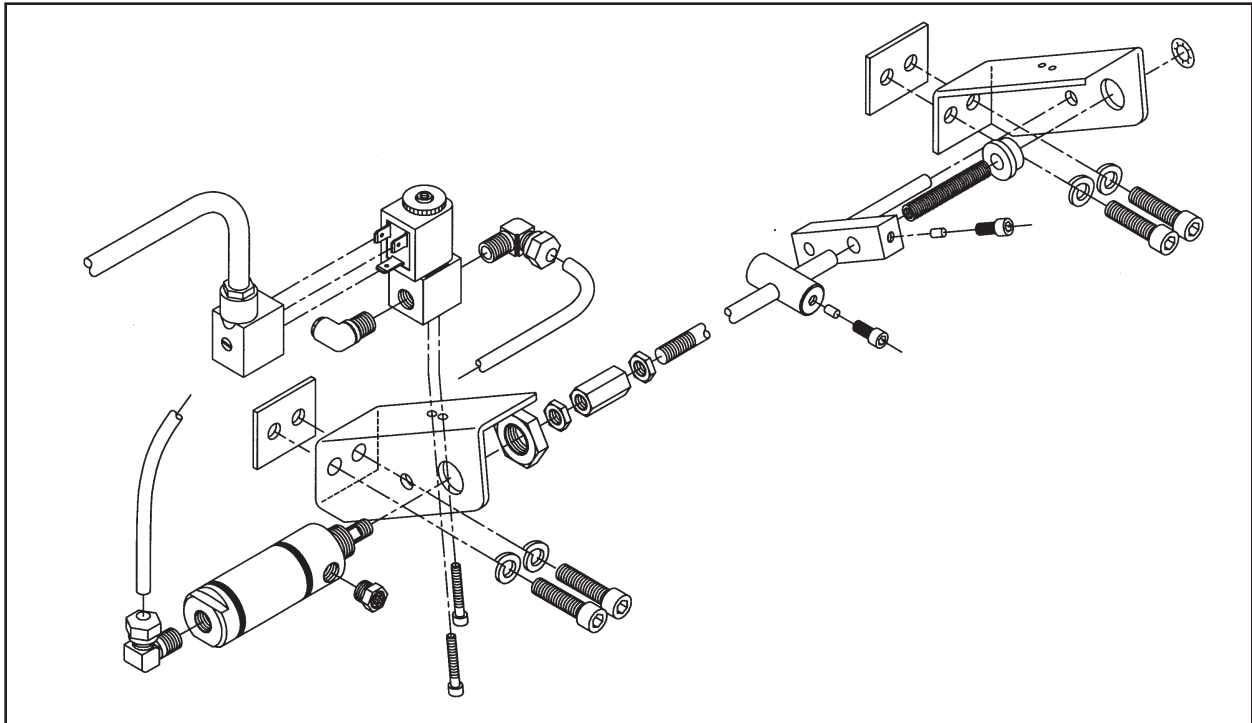


Figure 36 - Loop Stitch Kit

## 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](mailto:info@deluxestitcher.com)  
Web Site: <http://www.deluxestitcher.com>

# 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 : \_\_\_\_\_

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 : \_\_\_\_\_

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
Lever Pivot Pin	G20307

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.



