

DELUXE STITCHER

C O M P A N Y I N C .

Machine Serial Number : _____

Head Serial Numbers : _____

Date Purchased : _____

Model 18AW Stitcher

OPERATION AND MAINTENANCE MANUAL

18-AW Stitcher...with Motor...230V and 50HZ
18-CW Stitcher.....without Motor

Before using this Stitcher, all operators must study this manual and follow the safety warnings and instructions. Keep these instructions with the 18-AW Stitcher for future reference. If you have any questions, contact your local DeLuxe Stitcher Graphic Arts Representative or Distributor.

WARNING!

Model 18-AW Stitcher

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 without all guards in place. The stitcher will not operate without the front guard closed properly. 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 supply before any disassembly work.

Specifications

Weight

Shipping Weight	1300 lbs (590 kg) with four heads
Wire Spool	5 lbs. (2.3 kgs) or 10lbs. (2.6 kgs) optional
Foot Switch	4.5 lbs. (2.0 kgs)

Physical Dimensions

Height	77" (195.6 cm)
Width	55" (139.7 cm)
Depth	26" (66.0 cm)

Stitching Capacity Two Sheets to 9/16" (14 mm)
. at 20# paper stock (75 grams/inch²)

Wire Types 20-28 Round and 20x24, 20x25,
. 21x25 and 19x21-1/2 Flat

Throat Depth Unlimited

Introduction

To obtain satisfactory results from a wire stitcher, it is necessary that it be properly installed and adjusted, regularly lubricated and carefully maintained.

In case of any serious trouble, you should notify the nearest sales office, sending samples of the defective work and describing the trouble in detail. Report the serial number and model of the machine when corresponding so that it may be quickly identified.

WARNING

**Do not operate the 18AW until all Guards are in place.
Always turn power off before any assembly or
disassembly work or when making adjustments.**

Installation

Carefully inspect the condition of the crate in which the 18AW arrive. If it is broken and there is evidence that the machine may be damaged, immediately notify the carrier Claim Department as well as the DeLuxe Stitcher office from which the machine was purchased. Uncrate the machine carefully - do not use large crowbars which may damage small parts. Move the machine to the spot where it will be used. The 18-AW should be placed where the operator will have sufficient light for efficient operation. Level the machine with shims and, if necessary, lagging it to the floor.

Remove the Belt Guard (see Belt Guard instructions on page 6). See that the Motor is free to revolve when the large Pulley or Flywheel is turned by hand. Examine the name plate on the Motor to determine if the specifications meet your requirements. If they do not, notify the DeLuxe Stitcher office immediately. When you are satisfied that the Motor specifications are correct but before attempting to operate the machine under power, it should be turned over a few times by hand with the Clutch engaged.

WARNING

**Never operate the 18AW with wire feeding and no stock above the
Clinchers. Serious damage may result if this practice is followed.**

Setting up the Machine

Refer to the “Instructions and Parts List Manual” for the stitcher heads for instructions on attaching the heads to the machine and for threading and straightening the wire. As each successive head is installed, the 18AW should be turned over at least once by hand.

The Clincher Plates must be in exact alignment with the forming and driving parts of the heads. If they are not, loosen the screws securing the Retaining Plates and adjust their position. The Clincher Points can be removed by loosening the screws enough to allow the Clincher Slide to be pushed down past the lips of the Clincher operating bar. The Points can then be swung into a vertical position and removed. When replacing the Clincher Points, push them down as far as possible within the Clincher Plate so they catch the notch of the Clincher Slide. To ensure good stitching, Clincher Plates and Points should be kept free from dirt and paper build-up. The staple’s clinch can be made tighter or looser by adjusting the Screws in the Adjustable Clincher Slides or at the end of the Clincher Operating Bar. Care should be taken to adjust these Screws equally so that one end of the Bar is not higher than the other. Back Gauges are held to this Bar by a screw catch so they may more easily slide along the Bar or be removed altogether. The Bar is held to the Table by a screw under each end of the Table and can be adjusted forward or back to suit the work.

To adjust the 18AW for thickness, place the work under the the thickness gauge, located just over the right hand end of the Table. This gauge is held up and out of the way by a spring catch when not in use. Turn the Crank on the right side of the Stitcher, until the thickness gauge is tight on the work. The Crank is also secured by a spring catch and should be removed or placed at the bottom of its movement when the proper capacity adjustment is obtained. If it is left in a horizontal position, the Crank may loosen while the machine is running, thus changing the adjustment.

Be sure to use the proper size stitching wire. The 18AW Stitcher comes standard with parts for 20x24 gauge wire which provides a stitching capacity up to 9/16” (1/16” minimum). 20x25, 21x25, 24 gauge round and 25 gauge round wires may also be used in these standard wire parts. Parts for other wire sizes may be obtained on special order. When stitching through more than 3/8” 20x24 gauge wire is recommended. The Stitching Wire must be of high quality and of the correct dimensions in order to obtain the best results.

Lubrication

The 18AW should be thoroughly lubricated before operation and should be lubricated frequently while in use. It is recommended that oil equivalent to SAE 10 is used in the following locations:

- The bearings at each end of the Pinion Shaft and Cam Shaft
- The top and bottom of both Driver Links
- The six (6) Cam Rolls
- The Clincher Cam Levers and Clincher Operating Levers and Links
- The back of the gib at each side of the Machine to lubricate the Bender and Driver Slides
- The Bender Slide Guide at the inside of the Cam Rolls, located at the top of the Machine

When the Machine is in use, oil the Clutch through the Pulley Washer, at least once a day with a few drops of SAE 10 oil. Also, place a few drops of oil through the slot in the Brake and Clutch Bands which is located under the Adjusting Screw (2340B). Never let the Clutch run dry.

Operating Speed

The 18AW Stitcher will produce a high quality of work when the Rails operating the Stitcher Heads are operating at a speed between 125 and 150 strokes per minute. Do not operate the machine at a greater speed without contacting the DeLuxe Stitcher Engineering Department.

Belt Guard

To remove the Plastic Belt Guard, press in on one side tab while prying out the locking face. This will release the first tab. Next, pull up slightly on the bottom of the Guard to release the top tab. The Guard should now be free to lift off the remaining tabs on the Mounting Plate.

To reassemble, interlock the bottom tab and one side tab. Pull up slightly on the bottom of the Guard to interlock the top tab, then squeeze the Mounting Plate and Guard together to lock the remaining tabs.

Operation and Adjustments

If it should become necessary to readjust the Clutch, the following instructions should be observed:

Friction Clutch and Brake (See Figure 1)

With the power off, remove the Plastic Belt Guard (see page 6). Take off the Drive Pulley Washer (18281CA), located on the Pulley end of the Shaft by removing the Screw (2349). Slide the Drive Pulley (18487) away from the Belt Guard Mounting Plate, far enough to expose the Clutch Band Adjusting Screw (2340B) and Lock Screw (UA5028.1). Loosen the Lock Screw and with the Clutch engaged, turn the Adjusting Screw to obtain 1/8" to 3/16" of free movement between the Clutch Pawl (456H2) and the Clutch Sleeve (18282E) as indicated in Figure 1. Turn the Adjusting Screw counter-clockwise to increase free movement and clockwise to decrease free movement. Tighten the Lock Screw, but only until the Screw's head contacts the Clutch Band. Reassemble the Drive Pulley and Pulley Washer. Be sure to turn the Machine over by hand to disengage the Clutch.

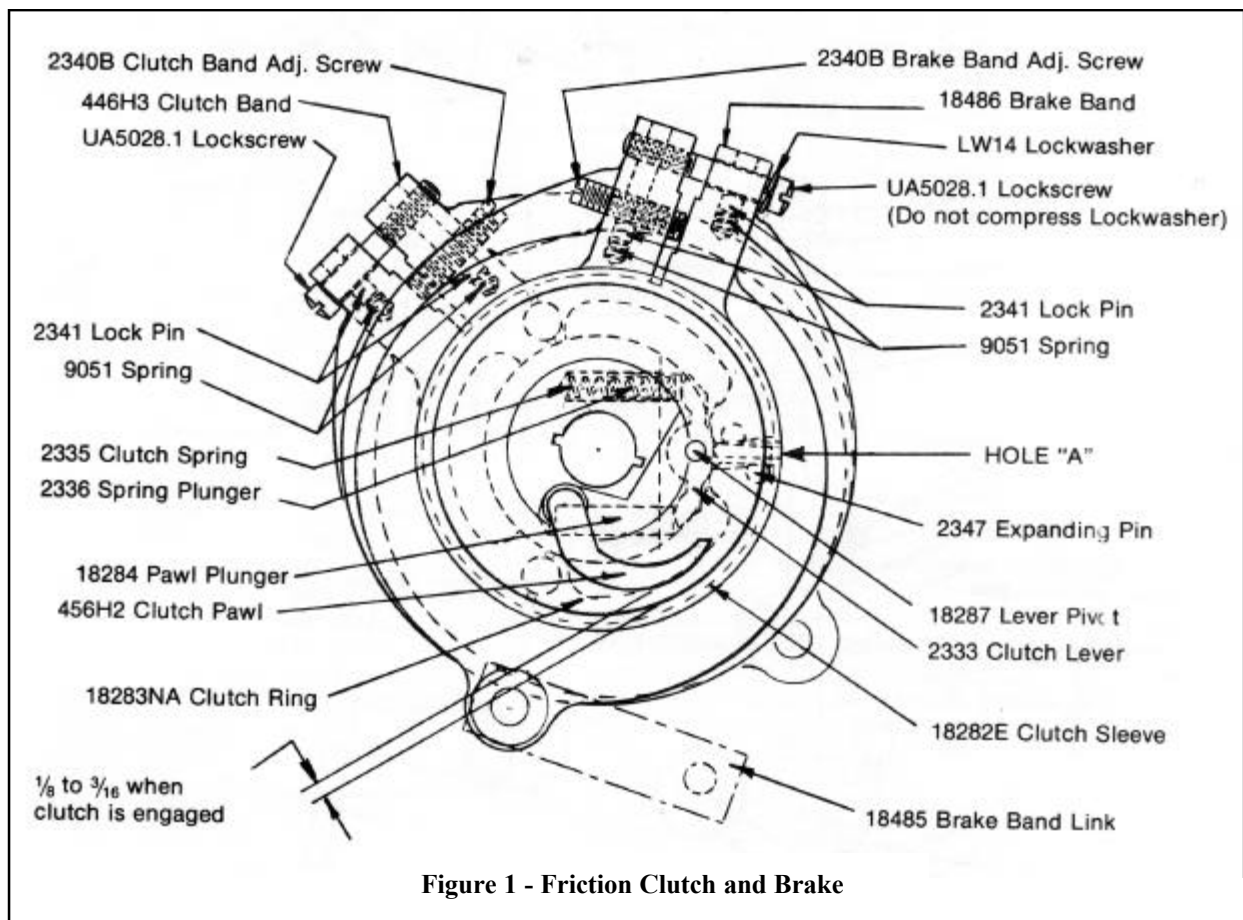


Figure 1 - Friction Clutch and Brake

With the power turned on, actuate the Foot Pedal. When the Pedal is released, the CLutch Sleeve should stop with Hole “A” (see figure 1) approximately horizontal to the floor. If the Sleeve does not stop in this position, loosen the Brake Band Locking Screw (UA5028.1) and turn the Brake Band Adjusting Screw (2340B) in our out slightly until the stopping position is correct. Tighten the Locking Screw only until it contacts the Lock Washer (LW14); do not over tighten. Access the Brake Band Adjusting Screws through the cut-out in the Belt Guard Mounting Plate.

Part Number / Description Cross-Reference

ITEM NO.	DESCRIPTION	ITEM NO.	DESCRIPTION
12	Adjustment Rail Dowel	2350	Driving Pulley Washer Screw Lock
14	Treadle Shaft Arm Spring	HN3816.2	Driving Rail Block Screw Check Nut
35	Stop Plunger Lever Spring	7155	Spool Stud
36	Treadle Shaft Arm, Spring Pin	7200	Treadle Shaft Arm Stop Pin
36	Clincher Operating Lever Spring Pin	9051	Brake Band Adj. Screw Lock Spring
38	Clincher Operating Bar Set Screw Binder	9051B	Thickness Gauge Catch Spring
63	Back Gauge Bar Screw	17282	Spool Bar Bracket
63	Work Stop Screw	18030	Bender Slide Guard
66	Driving Pinion Key	18031	Guard Spacer
030	Adjusting Screw Spring	18032	Clincher Cam Guard
174	Spool Stud Washer, Small	18201	Frame - Left
406	Clincher Operating Lever Spring Pin	18202	Frame - Right
406	Stop Plunger Spring Pin	18208B	Base - Left
0014	Clincher Operating Lever Spring	18209B	Base - Right
0087	Work Table Catch Spring	18210	Base Tie Rod
134-65	Clincher Rail Bar Lever Shaft Collar	18213	Bonnet Rail
134-65	Drive Pinion Shaft Collar	18217A	Bender Rail
134-65	Treadle Shaft Collar	18222	Bender Rail Slide - Left
FI 73	Mounting Plate Spacer	18223	Bender Rail Slide - Right
228-13	Mounting Plate Spacer Washer	18224	Bender Rail Slide Cam Roll
228-69	Clincher Operating Bar Link Spacer	18225	Bender Rail Slide Cam Roll Stud
446H3	Clutch Band Assembly	18230	Driving Rail
456H2	Driving Clutch Pawl	18231	Driving Rail Gib
2245	Spool Stud Washer, Large	18233	Driving Rail Conn.
2293	Treadle Link Lever Pin	18234	Driving Rail Connector Pin
2293	Work Table Catch Pivot Pin	18235AR	Driving Rail Connector Block - Right
2293	Adjustment Wedge Dowel	18235AL	Driving Rail Connector Block - Left
2302	Thickness Gauge Stop Screw	18236	Driving Rail Connector Block Screw
2306	Back Gauge Catch Screw	18237	Driving Rail Connector Bushing
2306	Adjusting Screw Ball Spring Screw	18238	Driving Shaft
2333	Driving Clutch Lever	18239	Driving Shaft Half Bushing
2335	Driving Clutch Lever Spring	18241A	Driving Shaft Bracket - Left
2336	Driving Clutch Lever Spring Plunger	18242A	Driving Shaft Bracket - Right
2340B	Brake and Clutch Band Adj. Screw	18243	Shaft Bracket Cap
2341	Brake Band Adj. Screw Lock	18245	Driving Gear
2343	Brake Band Link Stud	18246	Driving Shaft Key
2347	Driving Clutch Ring Expanding Pin	18247	Driving Gear Guard
2349	Driving Pulley Washer Screw	18251	Clincher Cam - left

ITEM NO.	DESCRIPTION	ITEM NO.	DESCRIPTION
18252	Clincher Cam - right	18333A	Adjustment Link Assembly - Left
18253	Driving Shaft Key	18334A	Adjustment Link Assembly - Right
18255A	Bender Cam - Left	18335	Adjustment Link Cap
18256A	Bender Cam - Right	18337	Adjustment Link Shoe
18257	Driving Shaft Key	18339	Adjustment Wedge - Left
18258	Bender Cam Crank Pin	18340	Adjustment Wedge - Right
18259	Crank Pin Washer	18341	Adjustment Wedge Connection
18262	Driving Pinion	18345	Adjustment Screw
18265A	Driving Pinion Shaft	18346	Adjustment Screw Block
18266	Driving Pinion Shaft Bushing	18348	Adjustment Crank
18267	Driving Pinion Guard	18349	Adjustment Crank Lock
18272	Bender Rail Slide Follower Roll	18353	Thickness Gauge
18273	Bender Rail Slide Follower Roll Stud	18354	Thickness Gauge Stud
18274	Bender Rail Slide Follower Roll Bushing	18356	Thickness Gauge Catch
18275	Bender Rail Slide Guide - right	18358	Thickness Gauge Bar
18276	Bender Rail Slide Guide - left	18360	Thickness Gauge Bar Guide
18281CA	Driving Pulley Washer	18363	Clincher Rail
18282E	Driving Clutch Sleeve	18365	Clincher Operating Bar
18283NA	Driving Clutch Ring	18370	Clincher Operating Lever
18284	Driving Clutch Pawl Plunger	18371	Clincher Operating Lever Shaft
18287	Driving Clutch Lever Pivot Pin	18377	Clincher Operating Link
18295	Brake Band Link Post	18378	Clincher Operating Link Stud - long
18297	Stop Plunger	18379	Clincher Operating Link Stud - short
18298B	Stop Plunger Lever	18382	Clincher Cam Lever - Left
18299B	Stop Plunger Lever Pivot Pin	18383	Clincher Cam Lever - Right
18300	Stop Plunger Lever Connection	18384	Clincher Cam Lever Stud - Left
18301	Stop Plunger Lever Conn. Pin	18385	Clincher Cam Lever Stud - Left
18304	Treadle Link Lever	18386	Clincher Cam Lever Stud Roll
18305	Treadle Link Lever Pivot	18387	Clincher Cam Lever Stud Roll Stud
18308	Treadle Link Lever Roll	18389	Work Table
18309	Treadle Link Lever Roll Stud	18391	Work Table Bracket
18310	Treadle Link	18392	Work Table Catch
18312	Treadle Link Guide Screw	18398	Motor Bracket
18313	Treadle Link Guide Screw Bushing	18400	Back Gauge
18318	Treadle	18402	Back Gauge Catch
18319B	Treadle Shaft	18405	Back Gauge Bar
18322	Treadle Shaft Arm	18412	Spool Bar
18328A	Adjustment Rail	18414	Spool Bar Bracket Brace

ITEM NO.	DESCRIPTION	ITEM NO.	DESCRIPTION
18419	Work Stop - left	UA5112.1	Mounting Plate Screw
18420	Work Stop Right	UA5112.1	Spool Bar Bracket Screw - Bottom
18422	Wire Guide Spring Bracket Bar	UA5112.1	Spool Bar Bracket Brace Screw
18475	Head Guard	UA5112.1	Driving Pinion Guard Screw
18476	Head Guard Mounting Bar	UA5116.1	Driving Rail Gib Screw
18477	Mounting Screw Spacer	UA5120.2	Wire Guide Spring Bracket Bar Screw
18482	Belt Guard Mount Plate Bracket	UA5120.2	Clincher Operating Bar Screw
18483	Belt Guard Mounting Plate	UA5120.2	Spool Bar Bracket Screw - Top
18485	Brake Band Link	UA5140.1	Mounting Plate Screw
18486	Brake Band Assembly	UA5804.1	Clincher Rail Bar Lever Shaft Collar Screw
18487A	Driving Pulley	UA5804.1	Treadle Shaft Collar Screw
19275	Adjusting Screw Washer	UA5808.3	Driving Pinion Screw
36671	Belt Guard	UA5812.3	Bender Rail Screw
85202	Oiler	UA5816.2	Driving Gear Guard Screw
850687	Motor Pulley	UA5820.1	Clincher Operating Bar Set Screw
850688	V-Belt	UA5824.1	Thickness Gauge Bar Guide Screw
HN1213	Bender Rail Slide Follower Roll Stud Nut	UA5828.2	Adjustment Rail Screw
HN3816	Clincher Operating Link Stud Nut	UA5828.2	Adjustment Screw Block Screw
HN3816	Thickness Gauge Stud Nut	UA5832.1	Thickness Gauge Bar Screw
HN3816	Spool Stud Nut	UA8124.1	Motor Bracket Screw
HN3824.4	Stop Plunger Lever Pivot Pin Nut	UA6112.1	Spool Bar Screw - Top
HN51618	Belt Guard Mt. Plate Nut	UA8516.1	Treadle Shaft Arm Set Screw
HN51618	Driving Gear Guard Screw Nut	UA6116.1	Spool Bar Screw - Bottom
HN51618	Wire Guide Spring Bracket Bar Screw Nut	UA9120.1	Base Tie Rod Screw
HN51618.2	Adjusting Screw Block Screw Nut	UA6116.1	Adjustment Wedge Screw
LW12	Bonnet Rail Screw Lock Washer	UA9132.1	Frame Screw
LW14	Bender Slide Guard Lock Washer	UA6120.1	Work Table Screw
LW58	Tie Rod Screw Lock Washer	UB2912.3	Stop Plunger Lever Connector Pin Cotter
LW516	Brake Band Lock Washer	UA6132.1	Bender Rail Slide Guide Screw
PW12	Motor Bracket Screw Washer	UB3916.1	Clincher Cam Lever Stud Cotter
PW516	Mounting Plate Screw Washer	UA6816.1	Treadle Set Screw
PW516	Clincher Operating Bar Screw Washer	UB3916.1	Bender Cam Crank Pin Cotter
PW516	Wire Guide Spring Bracket Bar Screw Washer	UA6820.3	Clincher Rail Screw
UA3814.4	Head Guard Mounting Screw	UB5632.1	Driving Pinion Taper Pin
UA4808.3	Bender Slide Guard Screw	UA8124.1	Bonnet Rail Screw
UA4820.1	Adjustment Link Shoe Screw	UB6136.1	Bonnet Rail Dowel
UA4840	Bender Slide Guard Screw		
UA5028.1	Brake & Clutch Band Lock Screw		

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.

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