

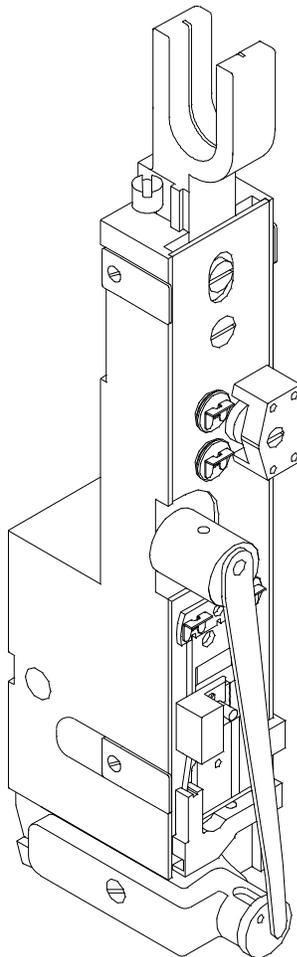
**ISP** Stitching & Bindery Products

A Division Of Samuel Strapping Systems

OWNERS  
MANUAL

# ***MAGNATEK***

***ISP*** Stitching & Bindery Products



# CONTENTS

## **Section 1 INTRODUCTION**

1. Model and Serial Number
2. Product Specifications

## **Section 2 SAFETY PRECAUTIONS AND PROCEDURES**

3. Safety
3. Safety Guards/Cover

## **Section 3 ASSEMBLIES, LUBRICATION, INSTALLATION**

4. Before Unpacking
4. After Unpacking
4. Assembly
4. Threading wire and adjusting wire straighteners
5. Lubrication

## **Section 4 OPERATION**

6. General Stitching
6. Changing Work Thickness

**USE ONLY REPLACEMENT  
PARTS DESIGNED AND  
MANUFACTURED BY ISP  
SPECIFICALLY FOR YOUR  
MAGNATEK STITCHER**

## **Section 5 MAINTENANCE, TROUBLE SHOOTING AND ADJUSTMENT**

7. General
7. Recommended Spare Parts
7. Cleaning and oiling
7. Stitching Adjustments
7. To Equalize Both Legs of Stitch
8. Trouble Shooting-MAGNATEK Head
12. Insufficient or Excessive Compression
12. Clincher
13. Head/Clincher Alignment
13. Bender bar
14. Bender bar Friction Plug
14. Driver Bar
15. Driver
15. Bender Bar Latch
15. Grip, Grip Release Slide and Faceplate
16. Wire Cutters
17. Wire cutter Operating Slide
17. Proper Wire
17. Rotator
18. Wire Straighteners
19. Supporter
19. Tension Pawl
20. Dismantling Magnatek Head

## **Section 6 PARTS LIST**

22. MAGNATEK Head Stitcher

# Section 1

## INTRODUCTION

Here are the instructions on how to install, operate, maintain, and make repairs on your...

# MAGNATEK STITCHER HEAD

Stitcher Head Serial Number \_\_\_\_\_ Stitcher Head Wire Size \_\_\_\_\_

Stitcher Head Part Number \_\_\_\_\_

Stitcher Head Crown Width \_\_\_\_\_

**When ordering parts or requesting information, please state: Quantity required, part number, part name, model, wire size, crown width, stitcher head part number, and stitcher head serial number.**

The Magnatek Stitching Head has been engineered and developed to provide you with the finest equipment available for your stitching needs. With proper care and maintenance it will give you years of satisfactory efficient service. This manual shows you how to get top performance from your stitcher and is divided into 7 major sections.

Read the Magnatek Manual thoroughly. Study it carefully. Best stitching performance will be assured, if all the adjustments are made as instructed.

# PRODUCT SPECIFICATIONS

Unit Weight:	Lbs.		
	4.5 lbs.		
Unit Envelope Size:	Height	Length	Width
Magnatek Head Without Wire Guide:	11 in.	3.12 in.	1.82 in.

---

## Notes

## **Section 2**

### **SAFETY PRECAUTIONS AND PROCEDURES**

#### **SAFETY**

1. Make sure electrical power is turned off before performing any adjustment or maintenance.
2. Keep hand, tools, hair, and clothing clear of stitching area.
3. Become familiar with the moving components of your machine. Keep fingers away from areas that could pinch or cut.
4. Wear adequate safety equipment for eye and face protection. Observe your plant safety rules.
5. Practice “good housekeeping” in your work area. Keep it as clean and uncluttered as possible.
6. A well maintained machine is a safer machine. Clean and lubricate the machine at regular intervals. Check machine daily for broken or worn parts. Replace as necessary. **DO NOT** attempt to operate the machine if a part is broken.
7. Route all electrical cables away from pedestrian transportation lanes.
8. Make sure adequate safety guards and covers are in place. If you are unsure how to safely operate or maintain your Stitcher, contact your Service Representative.

#### **DANGER**

**KEEP HANDS CLEAR OF  
STITCHING AREA**

#### **CAUTION**

**FOR YOUR SAFETY, MAKE  
SURE ALL COVERS ARE  
PROPERLY IN PLACE BEFORE  
OPERATING MACHINE**

## Section 3

### ASSEMBLY, LUBRICATION, INSTALLATION

#### Note:

These instructions must be followed to insure proper installation, efficient operation and the prevention of serious damage to your stitcher.

#### Before Unpacking:

Examine the outside of the crate or carton for any visible damage. If damaged DO NOT UNPACK THE STITCHER. Notify the carrier who delivered the stitcher.

#### After Unpacking:

Examine your stitcher carefully for any damage in transit. If damaged, DO NOT INSTALL THE STITCHER. Notify your nearest representative and the carrier who delivered your stitcher.

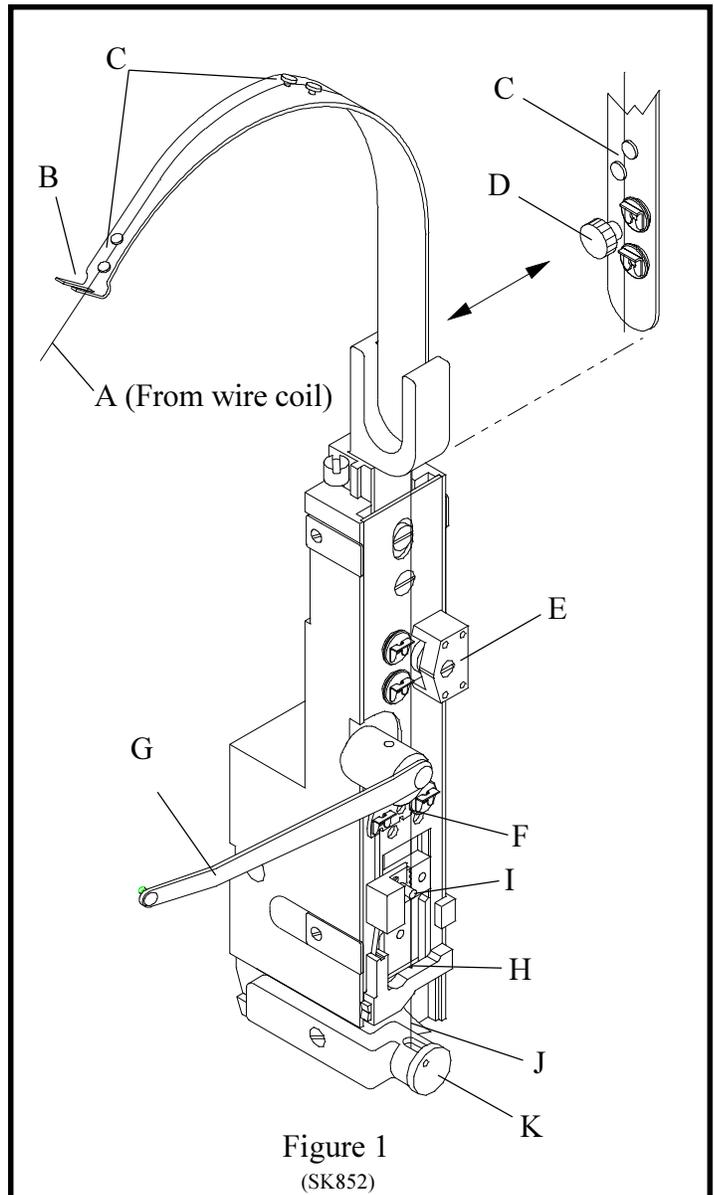
Make certain that you get a signed copy of the Carrier Inspector's Report of the damage incurred.

### ASSEMBLY

1. Clamp or bolt the Magnatek head to your machine
2. Install Wire Guide Spring into wire guide bracket of Magnatek Head.

### THREADING WIRE AND ADJUSTING WIRE STRAIGHTENERS (See fig. 1)

1. Draw wire (Index A) by hand, from the coil.
2. Thread the wire through the slot (Index B) at the end of the wire guide spring, through the wire guides (Index C), through the upper wire straightener (Index D), and through the lower wire straightener (Index E).



3. Release the rotator operating spring (Index G) from the rotator and swing it to the left. Remove Rotator (Index K).
4. Thread the wire between the tension pawl and tension roll (Index F). Feed the wire through the wire cutter lead-in hole (Index H) in the bottom of the face plate.
5. Push grip post to left to open the grip (Index I). Insert wire and release the post so that the grip engages the wire for feeding into the rotator.
6. To check adjustment, hold open grip (Index I) and pull about 1 1/2 feet of wire from below face plate. Cycle machine once by hand to cut wire. Cycle machine again by hand to observe wire straightness. The wire (Index J) should point straight down, prior to being cut.

7. Adjust the upper wire straightener, beginning at position shown, (Index D) so that the wire points straight down. Adjust the lower wire straightener, beginning at the 3:00 o'clock position, (Index E) so that the wire (Index J) feeds straight down.
8. Replace the rotator and rotator operating spring.

**NOTE:**

**When changing coils or wire sizes, check straighteners to insure proper wire feed.**

**STITCHING HEAD  
LUBRICATION:  
(FIGURE 2)**

Important! The stitching head must be lubricated before each spool of wire (50,000 to 70,000 stitches). Use **ISP** lubricant #CA9640.

- A. Inject lube into hole, or remove and lube shaft.
- B. Remove rotator spring and lube shaft.
- C. Inject a small amount of lube on cam surface of driver bar above and below grip housing.
- D. Wipe area clean, and inject a small amount of lube on grip release cam.
- E. Wipe driver clean, and apply a layer of lube.
- F. Inject lube into cutter operating slide.
- G. Very important! Remove rotator and clean inside of rotator holder.
- H. Carefully clean the rotator and apply lube to its body.
- I. Apply lube to the rotator's ramp.

For heavy duty applications, periodically disassemble the head and clean the parts. Lightly lube all sliding surfaces using **ISP** lubricant #CA9640. Double check lube points A through I.

**CAUTION**

**Do not operate stitcher until operating instructions have been read and understood-do not operate stitcher at anytime without work under the head.**

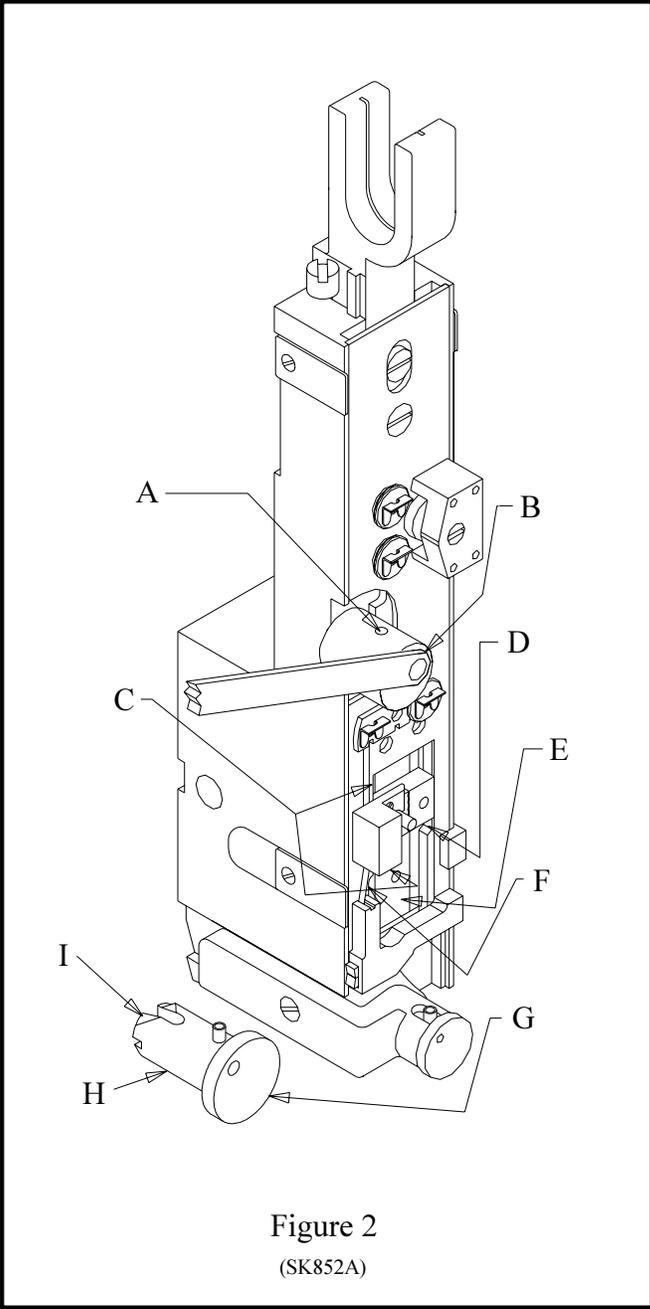


Figure 2  
(SK852A)

# Section 4

## OPERATION

### General:

After having properly installed and set up the machine, it is now ready for stitching. It is recommended that each operator be instructed as to correct operating procedure and normal adjustments necessary for varying work conditions.

### WARNING

Prevent accidents by following these rules:

1. Do not put your hands near area to be stitched when machine is operating.
2. Turn the power off when the stitcher is not in use.

### CAUTION

AVOID DAMAGE TO YOUR STITCHER BY FOLLOWING THESE RULES:

1. Never operate your stitcher with wire feeding unless you have work material between the clinchers and formers.
2. Do not drive one stitch on top of another.

### Changing Work Thickness: (Figure 3)

Changing work thickness will probably require a change of the wire draw length used to make a stitch. This is done by raising or lowering the face plate. Change face plate position as follows:

1. Switch off power, loosen the face plate screw (Index A).
2. Turn grip release lever (Index B) clockwise to raise face plate for more wire draw or counter clockwise to lower face plate for less wire draw.

NOTE: Raising face plate too high may: (1.) Prevent the grip from closing and drawing wire; (2.) Prevent proper compression resulting in a loose stitch.

3. Retighten faceplate screw.

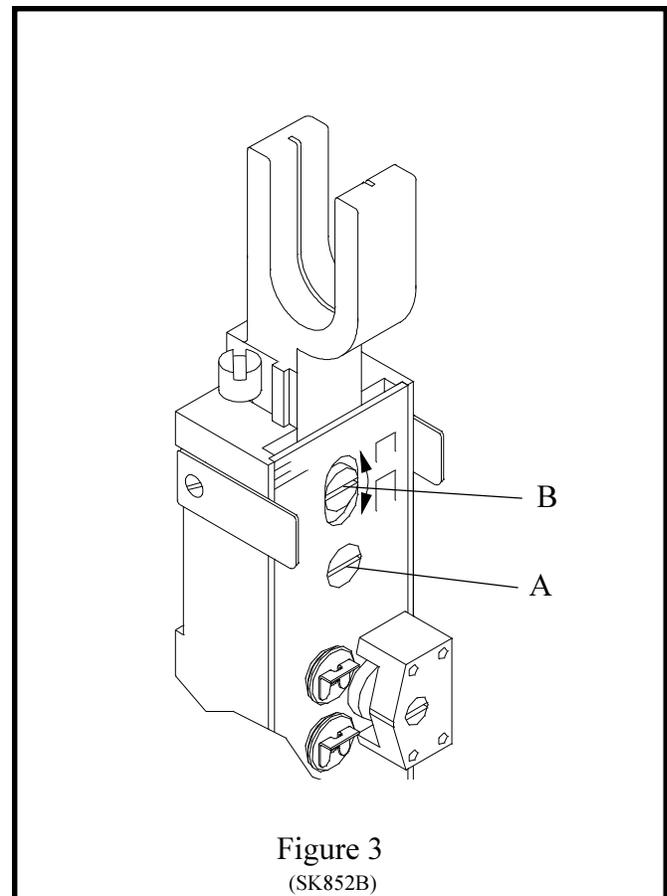


Figure 3  
(SK852B)

# Section 5

## MAINTENANCE, TROUBLE SHOOTING AND ADJUSTMENTS

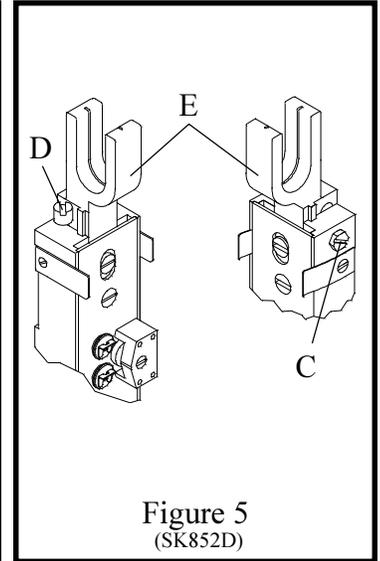
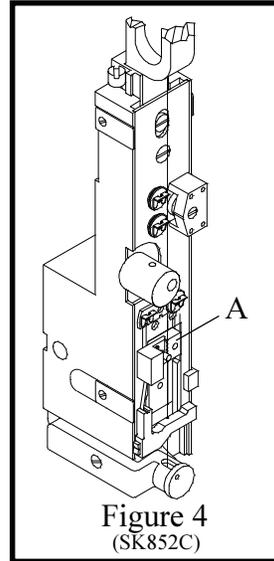
### General

The Magnatek Stitcher is a friction-type head which depends on smooth sliding friction and proper timing to function correctly. Preventative maintenance will go far to insure trouble-free operation. Avoid production down time by keeping your stitcher lubricated and in top working condition at all times.

### Recommended Spare Parts

Like any equipment that has moving parts, certain parts of your stitcher will be subjected to more wear than others and require replacement. The following listing includes all the parts required for minimum maintenance and good operation.

<u>PART NAME</u>	<u>QTY.</u>
Wire Cutters	2
Grip	1
Grip Spring	1
Driver	1
Tension Roll Clip	2
Rotator	1
Clincher Points	2



### Caution

**MAKE ALL ADJUSTMENTS WITH THE POWER OFF AND THE STITCHING HEAD IN NEUTRAL POSITION! (Fig. 4)**

**In neutral position, the wire grip assembly (Index A) is stopped at the top of the slot in the face plate.**

### Stitching Adjustments

Best stitching performance will be assured if all adjustments are made so that you get the following results:

1. Good Cut-Off
2. Uniform Wire Draw
3. Equal Leg Length
4. Proper Clincher Alignment
5. Sufficient Compression

### To Equalize Both Legs of Stitch (Figure 5)

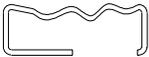
1. Loosen the wire guide locking bolt (Index C).
2. Turn adjusting screw (Index D) clockwise to shorten left leg of stitch; counter clockwise to lengthen left leg.
3. Tap bracket (Index E) down before tightening screw (Index C).

# Magnatek Head Trouble Shooting

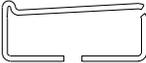
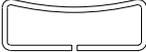
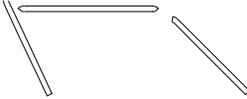
## HERE'S HOW A PERFECT STITCH LOOKS



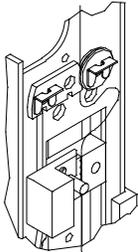
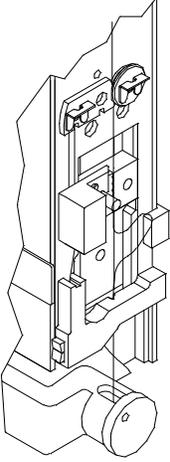
Should stitches appear in any form other than illustrated, one or more kinds of mechanical trouble may have caused the malformation. The possible causes and remedies are given for each kind of mechanical trouble and are listed under each section. The remedies are indexed to the Adjustments Section which gives more detailed information about your stitcher, the mechanical trouble that may occur and suggested remedies. Unless you recognize the correct cause, check each possible cause given.

TROUBLE	POSSIBLE CAUSE	REMEDY
<b>A. Defective Stitches</b>		
<p>1. One or both legs buckled.</p>  <p>NOTE: Since buckled legs are often concealed in the work and may appear the same as a short leg, always remove two or more stitches to see which is occurring.</p>  <p>2. Wrinkled crown.</p>	<ol style="list-style-type: none"> <li>1. Clincher is worn or improperly aligned.</li> <li>2. Insufficient compression.</li> <li>3. Unequal leg length</li> <li>4. Burred stitch leg.</li> <li>5. Incorrect wire size.</li> <li>6. Worn bender bar.</li> </ol>	<p>"B,C" Page 12,13</p> <p>"A" Page 12</p> <p>See "To Equalize Both Legs of Stitch" Page 7</p> <p>"J" Page 16</p> <p>"L" Page 17</p> <p>"D" Page 13</p>
<p>3. Length of one leg varies</p> 	<ol style="list-style-type: none"> <li>1. Leg Lengths not adjusted properly</li> <li>2. Gripper is worn or dirty</li> <li>3. Grip release slide is worn</li> <li>4. Broken wire guide spring (Figs 20 page 22)</li> <li>5. Excessive tension on wire straightener</li> <li>6. Worn Driver bar</li> <li>7. Worn Tension Pawl or weak tension pawl spring</li> <li>8. Weak or broken grip spring</li> </ol>	<p>See "To Equalize Both Legs of Stitch" Page 7</p> <p>"I" Page 15</p> <p>"I" Page 15</p> <p>Replace</p> <p>"N" Page 18</p> <p>"F" Page 14</p> <p>"P" Page 19</p> <p>"I" Page 15</p>

# Magnatek Head Trouble Shooting

TROUBLE	POSSIBLE CAUSE	REMEDY
<p>4. Corner of crown distorted or fractured</p> 	<ol style="list-style-type: none"> <li>1. Excessive compression</li> <li>2. Broken driver end</li> <li>3. Worn bender bar</li> <li>4. Clincher improperly aligned or worn</li> <li>5. Incorrect wire size</li> </ol>	<p>"A" Page 12            "G" Page 14            "D" Page 13            "B,C" Page 12,13            "L" Page 17</p>
<p>5. Stitch crown not flat and legs not bent into work</p> 	<ol style="list-style-type: none"> <li>1. Insufficient compression</li> </ol>	<p>"A" Page 12</p>
<p>6. One or both legs turn out</p> 	<ol style="list-style-type: none"> <li>1. Clincher improperly aligned</li> <li>2. Dull cutters</li> </ol>	<p>"C" Page 13            "J" Page 16</p>
<p>7. Flat piece of wire</p> 	<ol style="list-style-type: none"> <li>1. Rotator is dirty</li> <li>2. Improperly adjusted lower wire straightener</li> <li>3. Broken or worn rotator</li> <li>4. Improperly aligned rotator</li> </ol>	<p>"M" Page 17            "N" Page 18            "M" Page 17            "M" page 17</p>
<p>8. Stitches come out in pieces</p> 	<ol style="list-style-type: none"> <li>1. Improperly aligned rotator</li> <li>2. Weak rotator operating spring</li> <li>3. Improperly adjusted upper wire straightener</li> <li>4. Incorrect wire size</li> <li>5. Wire jammed in bender bar grooves</li> </ol>	<p>"M" Page 17            "M" Page 17            "N" Page 18            "L" Page 17            "D,G" Page 13,14</p>
<p>9. Both sticher legs are either too long or too short</p> 	<p>Face plate not adjusted properly</p>	<p>See "Changing Work Thickness" Page 6</p>

# Magnatek Head Trouble Shooting

TROUBLE	POSSIBLE CAUSE	REMEDY
<b>B. WIRE BUCKLES</b>		
<p>1. Wire buckles above the grip and below the tension pawl</p>  <p style="text-align: center;">(SK852E)</p>	<ol style="list-style-type: none"> <li>1. Worn driver bar</li> <li>2. Worn bender bar latch</li> <li>3. Worn or broken bender bar friction plug and/or spring</li> </ol>	<p>"F" Page 14</p> <p>"H" Page 15</p> <p>"E" Page 14</p>
<p>2. Wire Buckles above the wire cutters and below the grip</p>  <p style="text-align: center;">(SK852E)</p>	<ol style="list-style-type: none"> <li>1. Improperly aligned rotator</li> <li>2. Worn or broken wire cutters</li> <li>3. Burrs on rotator</li> <li>4. Improperly adjusted lower wire straightener</li> <li>5. Worn or broken wire cutter operating slide</li> <li>6. Wire cutter slot in face plate worn</li> </ol>	<p>"M" Page 17</p> <p>"J" Page 16</p> <p>"M" Page 17</p> <p>"N" Page 18</p> <p>"K" Page 17</p> <p>"J" Page 16</p>
<b>C. GRIP</b>		
<p>1. Grip does not close</p>	<p>1. Face plate is too high</p>	<p>See "Changing Work Thickness" Page 6.</p>

# NOTES

## CAUTION

**Turn Power OFF Before  
making Any Adjustments**

### A. Insufficient or Excessive Compression

Proper compression of work between the clincher and the bender bars is necessary so that the stitch penetrates the work material and clinches correctly. To test for compression, drive several stitches into sample work material. With proper compression, stitches hold the work together firmly and the clinched legs do not overlap. In the following instances, either one or all of the conditions may exist: with insufficient compression, stitch legs overlap, crown of the stitch is fractured, and the work mutilated. The method for obtaining proper wire draw and compression is detailed in the Operation Section on Page 6 under the heading, "Changing Work Thickness".

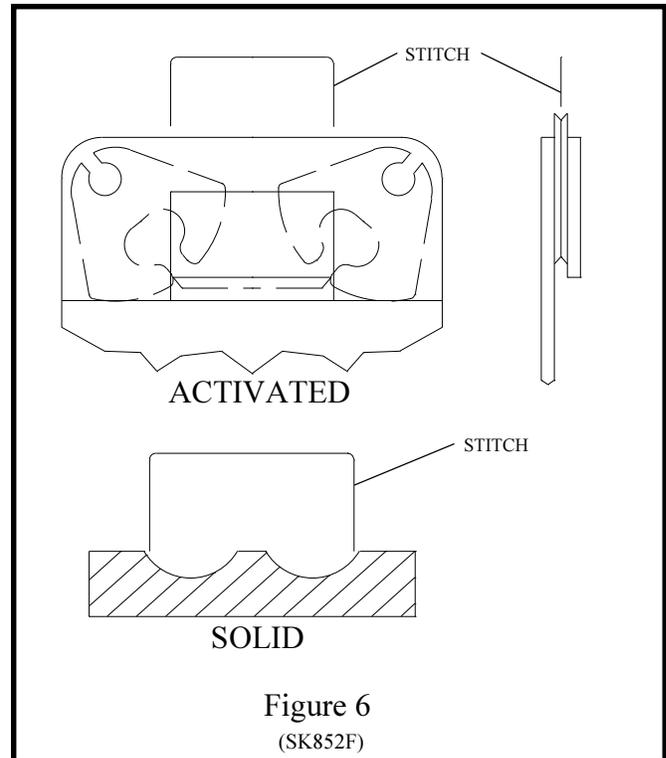
### B. Clincher (Figure 6)

The purpose of the clincher is to turn the legs of the stitch back after they have penetrated the work material. There are two types of clinchers:

1. Solid (stationary) Type-makes a loop clinch.
2. Activated (moving) Type-makes a flat clinch.

With the Solid (stationary) Type clincher, the legs of the stitch must strike the clincher at the same time and with equal spacing from the outside edges of the grooves. The grooves in the clincher should be smooth. Any interference (particularly worn or pitted grooves), which change the original radii, will cause the stitch legs to buckle and/or the corners of the crown to fracture.

With the Activated (moving) Type clincher, the stitch legs must enter the clincher at the same time



and with equal spacing from each side. When the stitch legs have penetrated the work material, the moving clinchers are raised to bend the legs towards each other and up flat against the work. The clincher points must bend both legs of the stitch against the work with the same force. Clincher points must always move freely and not bind. Dirt, wire chips, etc. will cause the points to bind.

The clincher points are in a retracted position in the clincher box until the stitch legs penetrate the work material. After the legs penetrate, the clincher points move upward to give a neat, flat clinch against the bottom surface of the work material. If the clincher points remain in the up position, the legs of the next stitch cannot penetrate the work material, causing the stitch legs to buckle and/or the corners of the crown to fracture. Examine the clincher points, clincher slide for possible binding. Clean and oil.

If clincher points rise too high, they fracture the stitch legs and/or mar the work. If the points do not rise high enough, the legs will not clinch flat. Adjust the height of the clincher points. For most work the clincher points should rise to be level with the top of the clincher housing.

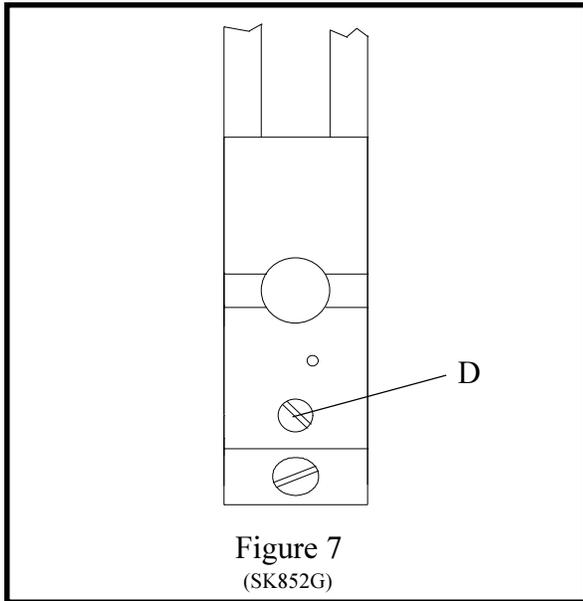


Figure 7  
(SK852G)

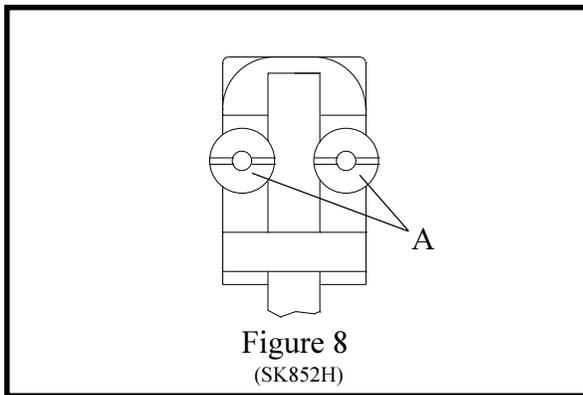


Figure 8  
(SK852H)

### C. Head/Clincher Alignment (Figure 7)

To test alignment: Drive several stitches into a section of material identical to that which is to be stitched. The clinched legs should be identical and aligned with each other. If the legs are not in alignment make one of the following adjustments:

1. To adjust for front-to-rear alignment: (Fig. 7)
  - a. Turn power off. Cycle the stitcher by hand until legs of the stitch appear just below the bender bar to determine if the head should be moved to the front or rear.
  - b. Remove stitcher from machine.
  - c. Turn the head aligning screw (Index D) clockwise to move the head backward; counterclockwise to move the head forward.
  - d. Install stitcher head on machine.

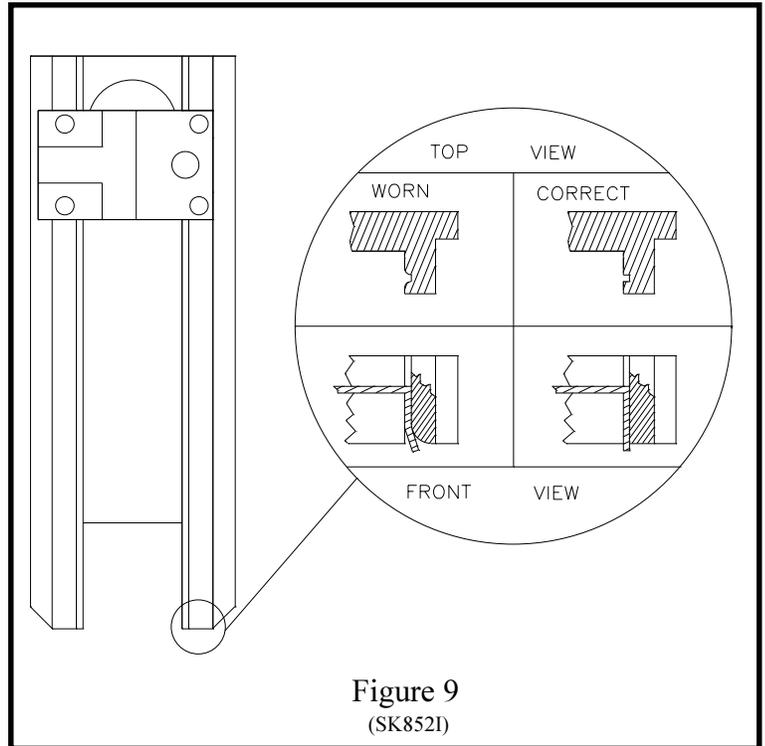


Figure 9  
(SK852I)

2. To adjust for side-to-side alignment: (Fig. 8)
  - a. Turn power off. Cycle the stitcher by hand until legs of the stitch appear just below the bender bar to determine how far the head or clincher should be moved to the side.
  - b. Loosen clincher plate binder nuts (Index A).
  - c. Move clincher to left or right as required.
  - d. Tighten binder nuts.

### D. Bender Bar (Figure 9)

The bender bar bends the wire over the rotator and forms it into an unclinched stitch. The legs of the stitch are guided towards the work material by the bender bar grooves. The legs of the unclinched stitch should be perpendicular to the crown. When the bender bar grooves become worn, the legs tend to flare out (Figure 9) as they emerge from the grooves. This causes the legs to strike the clincher improperly. As a result, one or both legs will crumple and a broken driver bar or a broken bender bar can result. If the lower end of the bender bar grooves become chipped, it will not support the wire and may cause the stitch to break at the crown. Replace the bender bar assembly (See "H" page 15 or Fig. 10). Other bender bar functions are related to wire cutting ("J" page 16), and driving ("G" page 14).

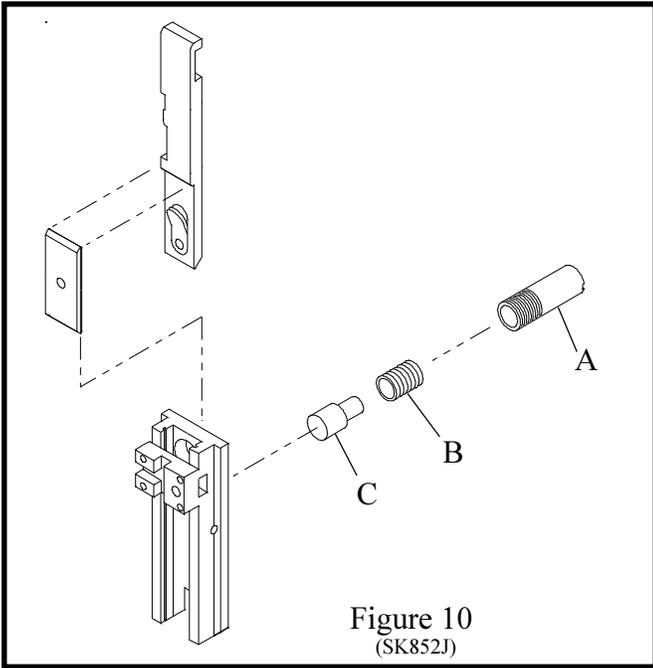


Figure 10  
(SK852J)

### E. Bender Bar Friction Plug And/Or Spring (Fig.10)

Two parts furnish pressure to coordinate movement of driver bar and bender bar. If pressure is insufficient, proper timing is not maintained for the action of the grip. As a result, wire feeds backwards. Replace the plug and/or spring.

To replace bender bar friction plug and/or bender bar friction spring:

1. Remove bender bar assembly by following steps 1 through 16 of "Dismantling Magnatek Stitching Head", Pages 20 and 21.
2. Remove bender bar friction bushing (Index A). Bender bar friction plug (Index C) and spring (Index B) will be released forward from bender bar assembly.
3. Replace plug and/or spring and reassemble.

### F. Driver Bar (Figure 11)

The driver bar (Index A) has several functions:

1. It imparts the downward thrust from the driving slide assembly (Index B) to the bender bar assembly (Index C) and the driver (Index D).
2. It returns these parts to the neutral position on the upstroke.

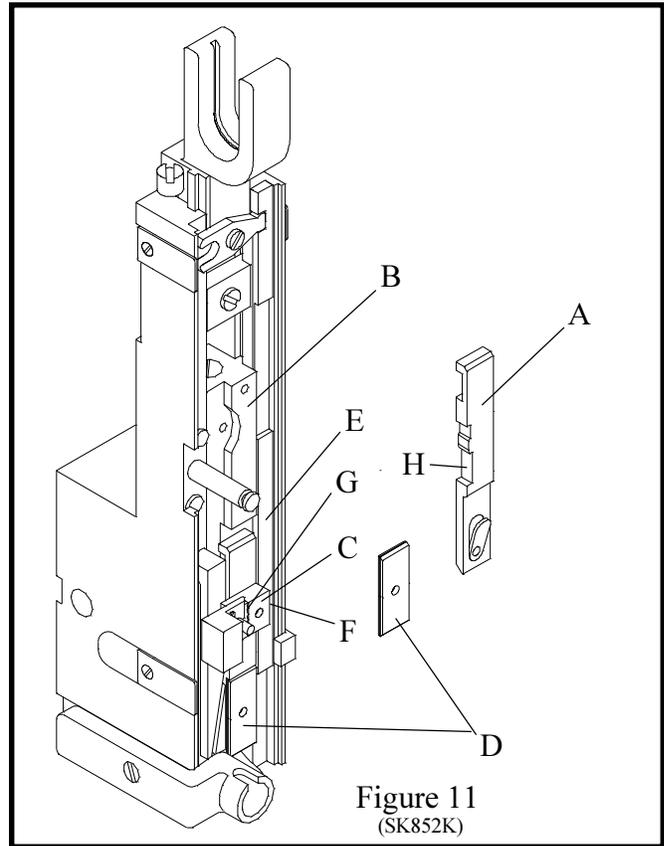


Figure 11  
(SK852K)

3. In conjunction with the grip release slide (Index E), it controls the movement of the bender bar latch (Index F) that opens and closes the grip (Index G).

If the notches (Index H) at the top left side of the driver bar become worn, the grip will not remain open on the upstroke. As a result the wire feeds backwards and buckles above the grip and below the tension pawl. Worn notches can also cause uneven wire draw. Replace the driver bar. While driver bar is out for inspection check the driver end retaining spring for proper tension and to make certain there is not dirt lodged behind it.

The notches shown on left side of driver bar play an important part in function of bender bar assembly therefore, corners should be free of dirt and notches not marred.

### G. Driver

The driver rides within the bender bar grooves as part of the bender bar assembly. As this assembly reaches the lower contact point of the cam in the grip release slide, the bender bar latch is forced inward, releasing the wire grip and permitting the bender bar assembly to continue downward with

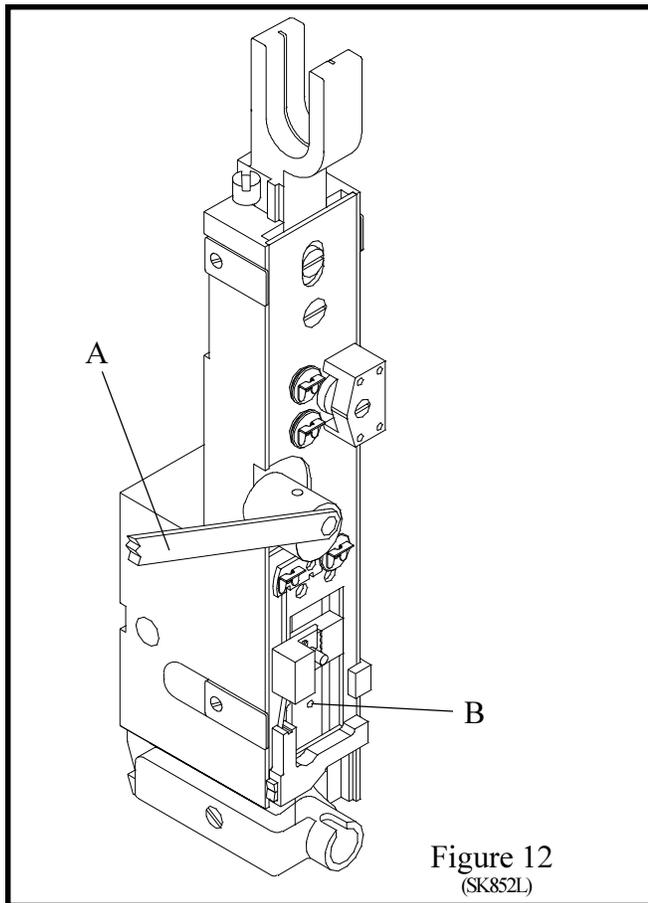


Figure 12  
(SK852L)

the driver riding on top of the formed stitch. When the bender bar is stopped against the work material, the driver continues downward to exert pressure on the crown of the stitch, driving it through the work material.

If the driver is chipped it allows the legs of the stitch to back up into the broken area. This causes the corner of the crown to fracture or a "spike" section to protrude above the crown. A chipped driver is usually the result of driving a stitch on top of another stitch. A worn driver often causes deformed stitches or fracturing at the corners of the crown. The driver is reversible for longer use.

Occasionally, a stitch is caught behind the driver. This causes improper alignment of the driver. As a result, successive stitches are distorted at the crown. Remove the driver and clean the bottom portion of the driver bar.

### To remove the driver: (Figure 12)

1. Cut the wire at the bracket and pull the loose end out.

2. Swing the rotator operating spring (Index A) to the left.
3. Remove the rotator.
4. Insert a pointed object into the hole (Index B) on the driver and press in on the high end of the spring which is located behind it.
5. Slide the driver down and out of the head.
6. Clean, reverse or replace the driver.
7. Reassemble.

## H. Bender Bar Latch

The bender bar latch opens and closes the grip and is actuated by the grip release slide and driver bar. If the contact points of the latch become worn, timing of the grip is erratic and uneven wire feed results. A dirty latch will decrease pressure of the grip on the wire. This causes wire slippage. Clean or replace the latch.

## I. Grip, Grip Release Slide and Face Plate: (Figure 13)

The grip spring (Index A) exerts pressure on the benderbar latch (Index B) to close the grip (Index C) at the start of the down stroke. The grip release slide (Index D) actuates the bender bar latch at point X to open the grip after the correct amount of wire has been fed to make a stitch. The serrated teeth on the grip must be sharp or slippage will occur, producing uneven wire draw.

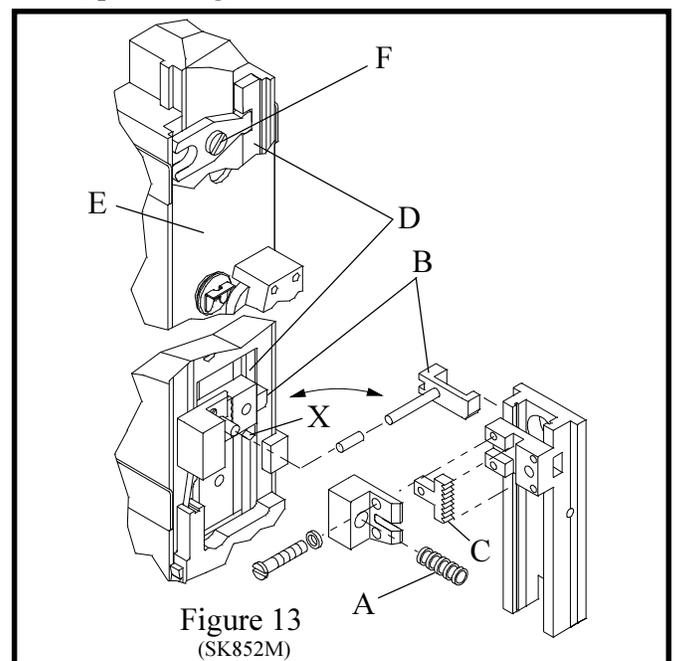


Figure 13  
(SK852M)

When the face plate (Index E) is adjusted (See "Changing Work Thickness", page 6) a pivotal action (at point F) changes the position of the grip slide. When the face plate is raised, it moves the grip release slide down. The gripper can then remain closed longer, on the down stroke, feeding more wire for the stitch. When the face plate is lowered, it moves the grip release slide up. The gripper will open sooner on the down stroke, feeding less wire for the stitch.

If the grip is weak, uneven wire draw will result. Replace the grip spring. If the contact points on the grip release slide and/or the bender bar latch are worn, wire adjustment will not remain accurate.

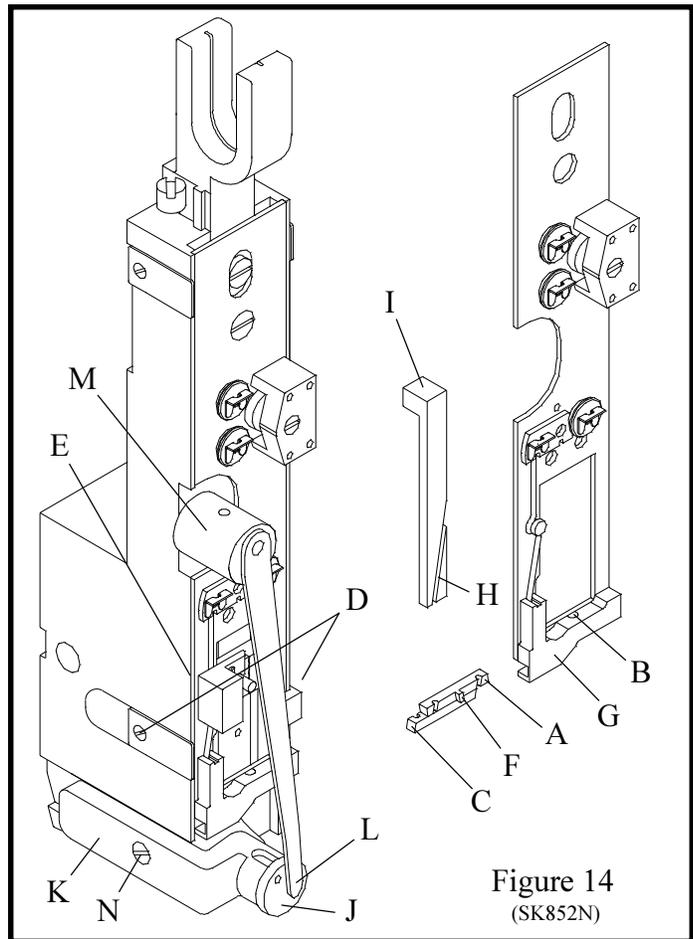
The face plate stops the bender bar assembly at the top of its stroke and allows the bender bar latch to close the grip. When the face plate is too high, too much of the upstroke has been used before the bender bar hits the face plate. In the remaining portion of the upstroke, the driver bar cannot continue upward enough to release the bender bar latch so that it can close the grip.

## J. Wire Cutters: (Figure 14)

The purpose of the wire cutters is to shear the wire cleanly. There are two wire cutters, upper and lower. The upper wire cutter (Index A) receives wire from the grip through the wire cutter lead-in-hole (Index B). It also serves as the cutoff die. The lower wire cutter (Index C) is the cutting knife. If the cutter breaks, it will cover the lead-in hole. This prevents the wire from feeding into the rotator. If the cutting surfaces become worn, burrs will result on the end of the wire. This prevents the wire from feeding into the rotator. As a result, the wire buckles between the cutters and the wire grip. Reverse, interchange or replace the cutters.

### To reverse, Interchange or Replace the Wire Cutters:

1. Loosen both face plate retaining clips (Index D) at bottom of bonnet.
2. Spring the face plate out 1/8" while holding the cutter slide in position (Index E).
3. Slide the cutters out to the left.



4. Reverse, interchange or replace the cutters.

## NOTE

While installing the cutters, make sure that (1): lip on upper cutter (Index F) fits into the recess behind the face plate (Index G) and (2): that the lip on the bottom cutter fits into the slot (Index H) in the wire cutter operating slide (Index I).

The wire cutter operating slide actuates the lower wire cutter. If the slide is worn or broken, the wire cutter is not actuated. Replace the operating slide. The slot in the lower part of the face plate contains the wire cutter and maintains a close fit for wire shearing. If this slot becomes oversized, the wire will not be cut off. Replace face plate. **To Replace Face Plate (See Steps 1 through 8, "K" page 17).**

## NOTE: (Figure 15)

**The lug (Index C) in the faceplate must match the slot (Index D) in the grip release adjusting lever (Index E) or damage to the head may result.**

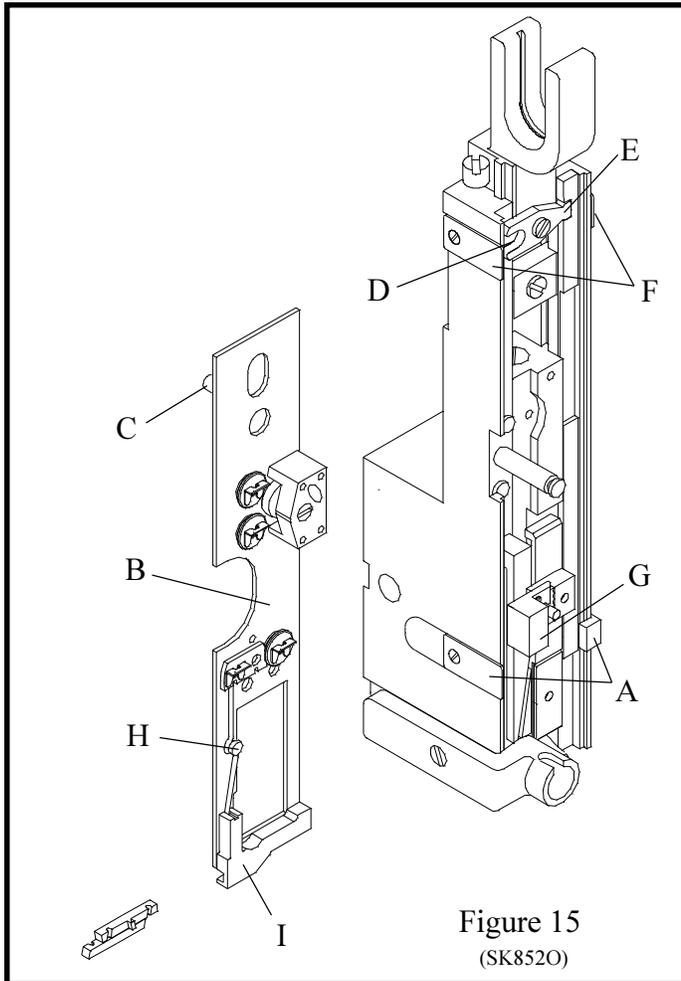


Figure 15  
(SK8520)

## K. Wire Cutter Operating Slide

The wire cutter operating slide actuates the lower wire cutter which acts as the cutting knife. If the slide is worn or broken, the wire cutter is not actuated. Replace the operating slide.

To Replace The Wire Cutter Operating Slide:

1. Cut the wire at the bracket and pull the loose end out.
2. Remove the stitcher head assembly.
3. Lift end of spring (Index L, Figure 14) out of rotator.
4. Swing the spring up to disengage it and lift out.
5. Slip the rotator operating cam (Index M, Figure 14) forward and off the stud.
6. Pull the rotator forward.
7. Loosen the two face plate retaining clips (Index A, Figure 15) and rotate them downward.

8. Push two face plate retaining clips (Index F) outward while lifting face plate up to release face plate.
9. Position grip spring housing (Index G) between tension pawl spring retainer (Index H) and cutter housing (Index I).
10. Remove face plate (Index B) by sliding face plate to the left and lifting up.
11. Remove the cutter operating slide (Index I, Figure 14).
12. Insert a new cutter operating slide.
13. Reassemble

## L. Proper Wire

Depending on which Magnatek head is being used the wire range may be: 25 to 30 gauge round; 24 gauge round; 20x25 or 21x25 flat. 120,000 to 159,000 psi tensile strength bookbinders wire should be used.

If the wire used is larger than the bender bar grooves were designed for, it will fracture at the stitch corners and come out in pieces. Also, serious damage to the stitcher may result. If the wire used is smaller than the bender bar grooves were designed for, the legs of the stitch do not fit snugly in the grooves and may tend to buckle when they strike the work material because they are not fully supported.

## M. Rotator (Figure 14)

The rotator (Index J) (1) receives the wire from the cutoff die, (2) holds the wire while it is being cut, then (3) turns it to a horizontal position, moves it under the bender bar grooves and (4) supports the wire while it is being formed into a "U-shaped" stitch.

The wire lead-in-funnel of the rotator must be aligned with the wire as it comes through the wire cutters. If the rotator is improperly aligned, the wire hits the rotator and buckles. Adjust upper two wire straighteners until wire slips past rotator. Burrs on the rotator prevent the wire from entering the rotator. This causes wire buckling. Remove the rotator and polish the lead-in radius.

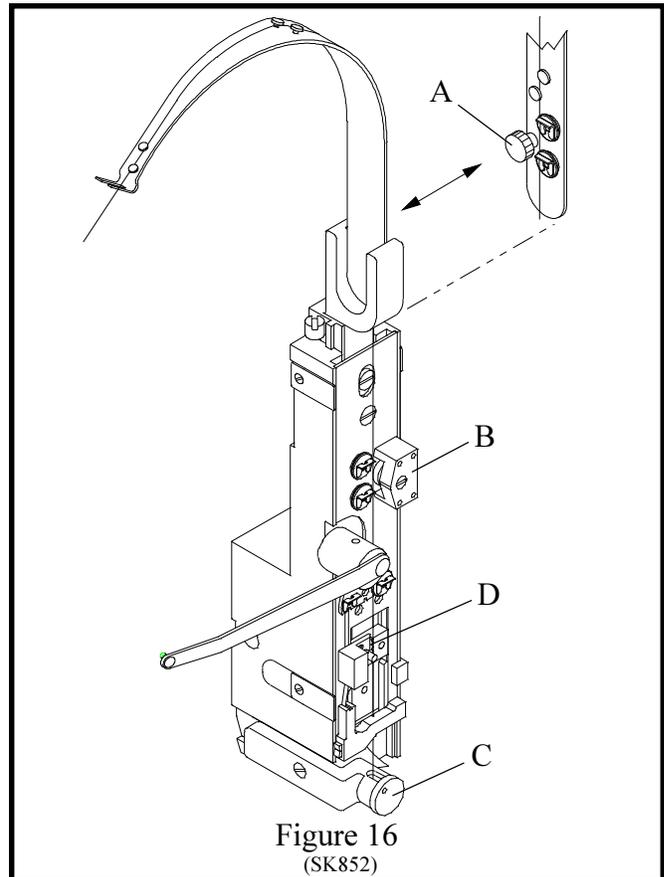
The magnets in the rotator hold the wire firmly in the rotator. If a magnet is broken or chipped the wire may fall out. To determine if the rotator has the proper holding strength, remove the rotator and insert a cut length of wire in the rotator. Hold rotator between thumb and forefinger. Attempt to jar wire loose by hitting heel of hand on top of table or against other hand. With proper magnetic holding force wire will remain in rotator. With insufficient holding force wire will fall from rotator. Replace the rotator.

The rotator holder and rotator operating spring are responsible for alignment of the wire beneath the bender bar grooves. The position of the rotator holder determines how far the rotator is pushed forward under the bender bar by the rotator operating spring (Index L, Figure 14). A weak spring will not push the rotator in far enough and with this improper alignment the bender bar will knock the wire from the rotator or will shear the wire into pieces. To secure proper alignment, check the position of the rotator holder and the tension applied by the rotator operating spring. Make any necessary adjustment of the rotator holder or replace the rotator operating spring if weak.

The wire is fed into the rotator and held for forming. If the rotator is dirty, the wire is not gripped securely enough and drops out. Remove and clean the rotator. If the edges over which the wire is formed are sharp, the corners of the stitch crown will fracture. Remove the rotator and polish the edges with a fine emery cloth.

To remove, Adjust or Replace the Rotator Holder:

1. Swing the rotator operating spring to the left.
2. Remove the rotator.
3. Loosen the rotator holder screw (Index N, Figure 14).
4. Adjust the rotator holder screw.
5. Reassemble.



## N. Wire Straighteners: (Figure 16)

All coils of stitching wire have a certain amount of bundle curve. The purpose of a wire straightener is to remove this curve. There is both an upper wire straightener (Index A) and a lower wire straightener (Index B) on all Magnatek Model Stitchers. See "Threading Wire and Adjusting Wire Straighteners" page 4.

The upper wire straightener should feed wire parallel to the faceplate. This insures that the wire will properly enter the rotator and will be aligned with the grooves in the bender bar.

If the wire is not parallel to the face plate the wire is sheared in the rotator as the bender bar descends. Adjust the upper wire straightener.

The lower wire straightener directs the wire straight down so that it enters the rotator (Index C). If the wire is not straight enough it hits the rotator and buckles. Adjust the lower wire straightener so that

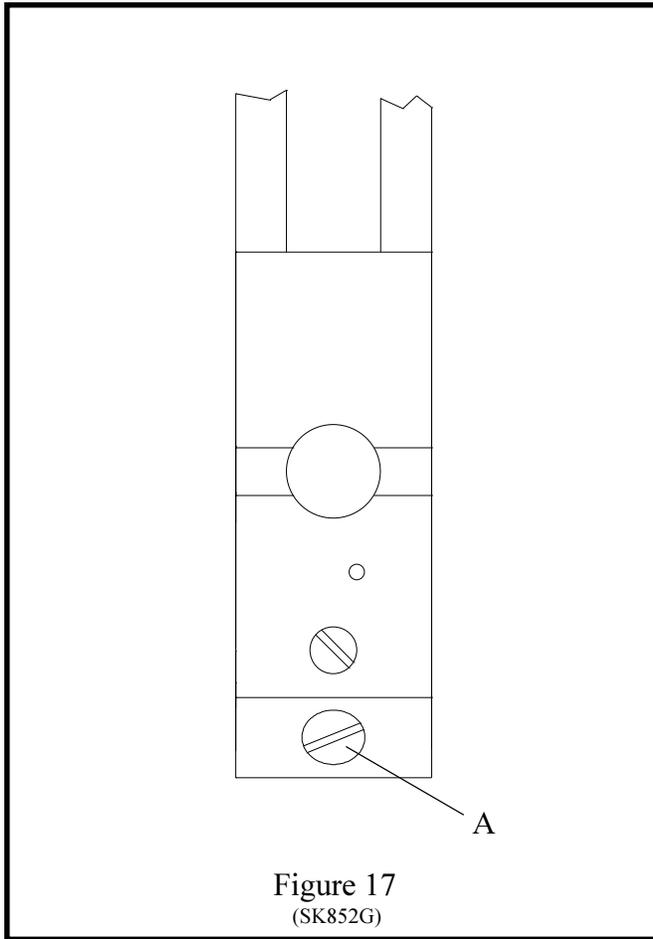


Figure 17  
(SK852G)

the wire points straight down as in figure 16. Improper straightening of the wire can also cause the stitch legs to buckle or turn out because they strike the clincher improperly. Excessive tension on the wire straightener prevents the grip (Index D) from feeding the wire smoothly. This causes variation in leg length.

### NOTE:

Check the wire straighteners when changing the coils to insure the accurate feeding of wire.

### O. Supporter

The supporter furnishes the necessary support to the inside surface of the stitch so that it does not buckle as it is being driven into the work material. A lack of (or insufficient) support will often cause the stitch crown to wrinkle or the legs of the stitch to buckle. Tighten the supporter spring bushing (Index A, Figure 17) or replace the spring.

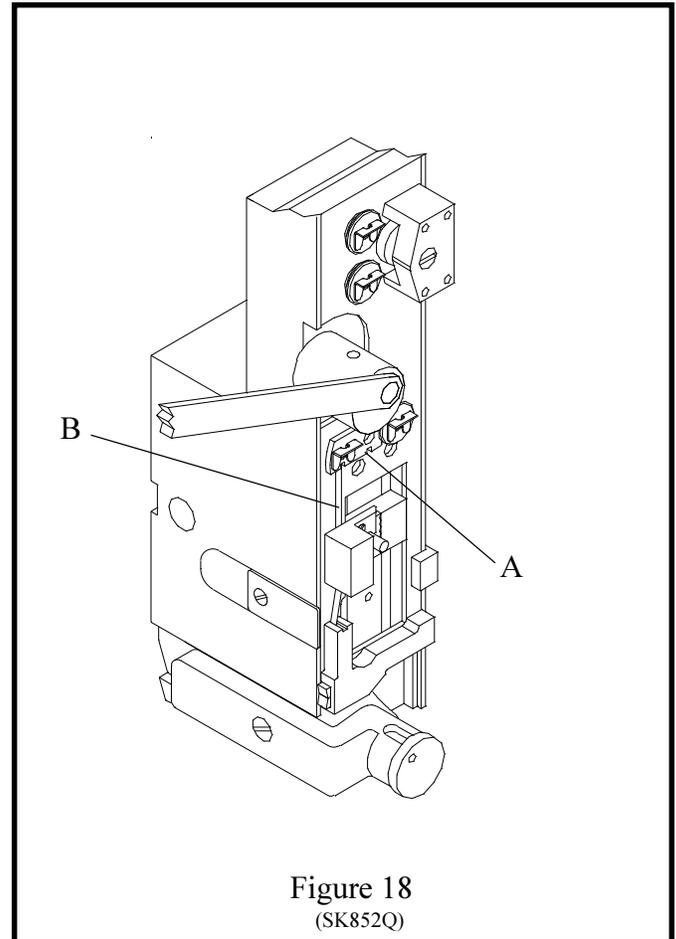


Figure 18  
(SK852Q)

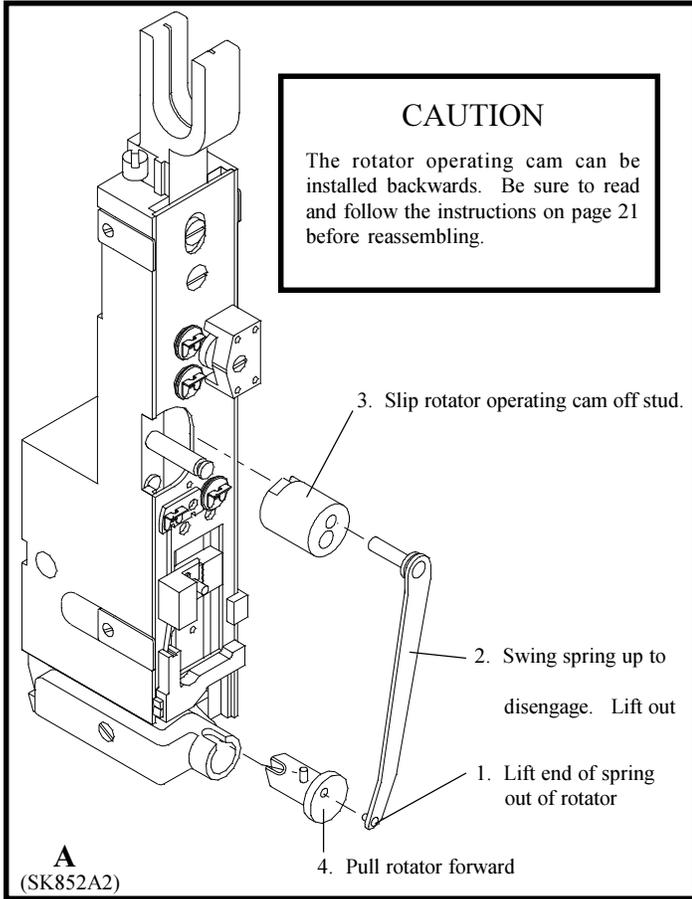
If the corners of the top surface of the supporter are too sharp, or nicked, the corners of the stitch crown will fracture. If operating properly the supporter should function as follows:

1. When the bender bar touches the work material and the legs of the stitch are about to leave the bender bar grooves the supporter should be touching the underside of the crown.
2. As the stitch is driven through the work the supporter is gradually retracted by the driver. It should remain under the crown of the stitch until the last instant before the crown touches the work material.

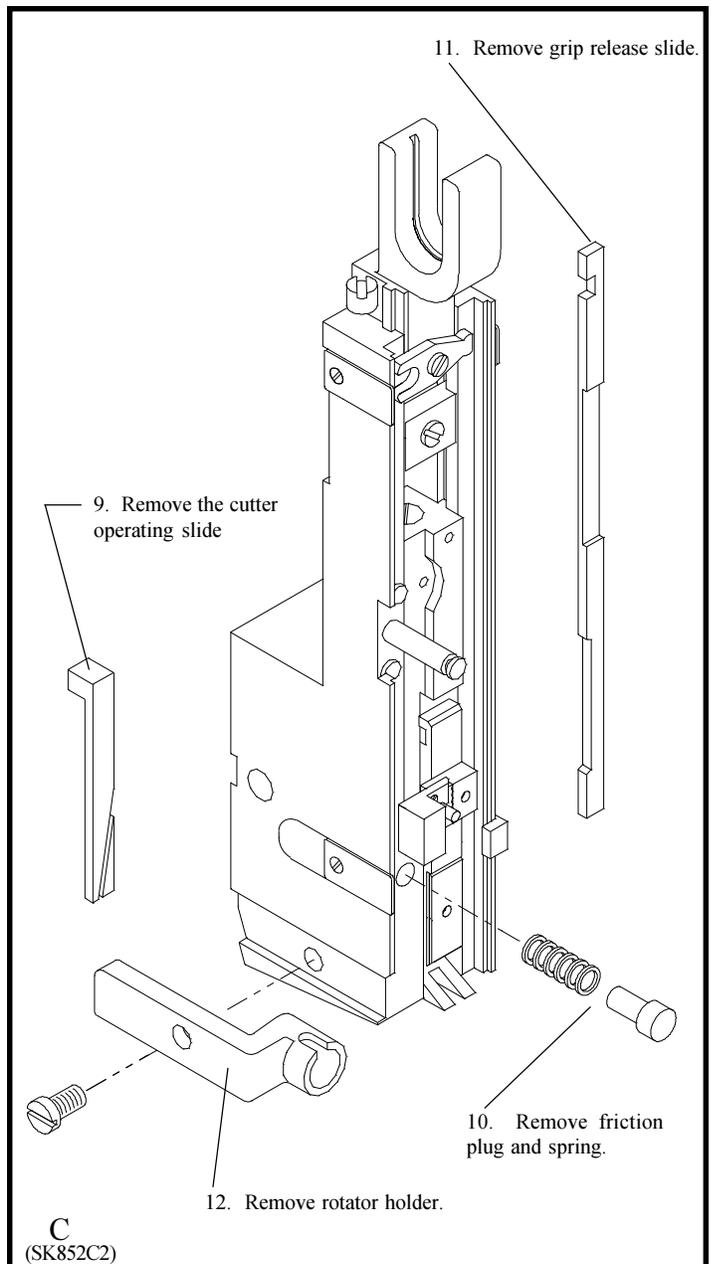
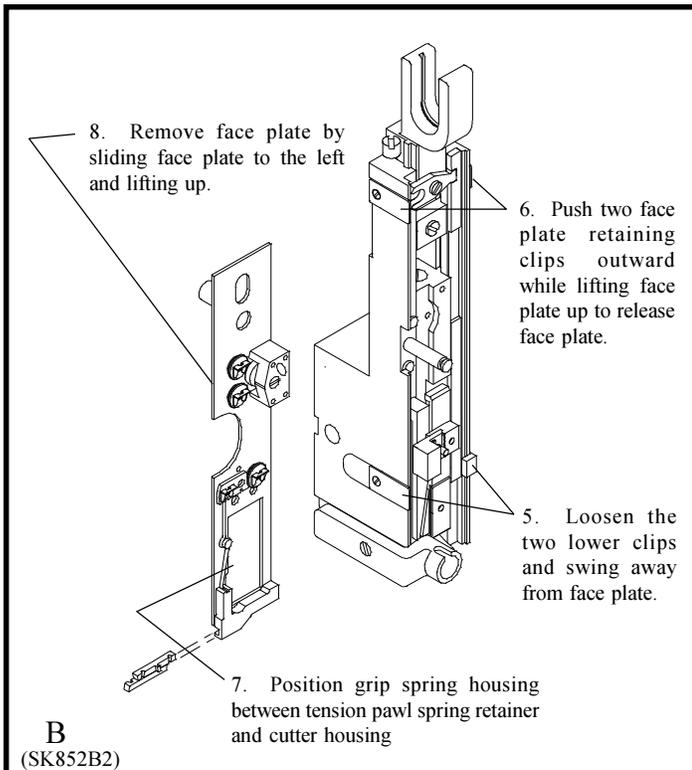
### P. Tension Pawl: (Figure 18)

The tension pawl (Index A) and spring (Index B) apply pressure on the wire to prevent back feed. If the pawl becomes worn or the spring becomes weak, the wire feeds backwards resulting in a short wire draw. Reverse or replace the tension pawl and/or spring.

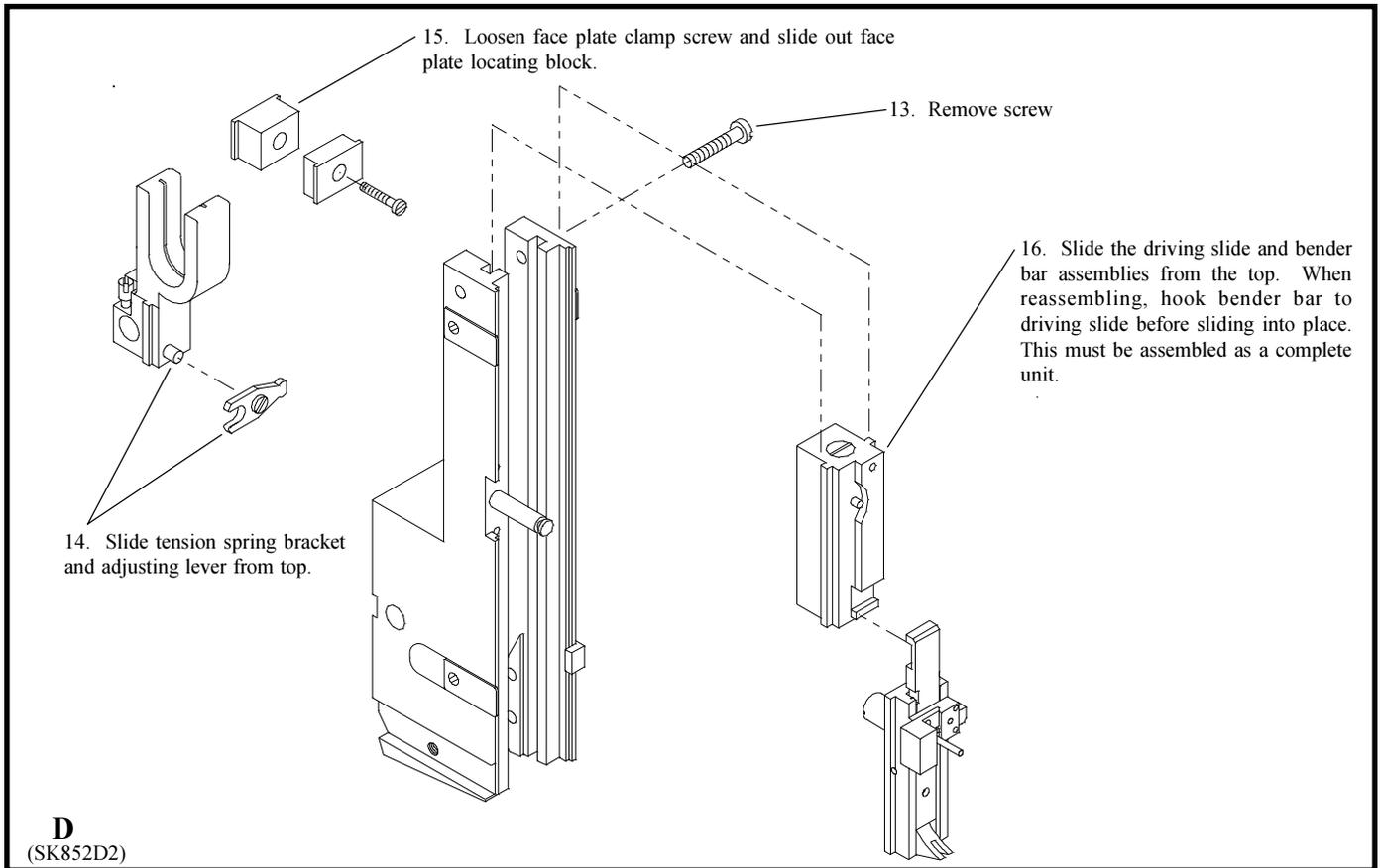
# DISMANTLING MAGNATEK STITCHING HEAD



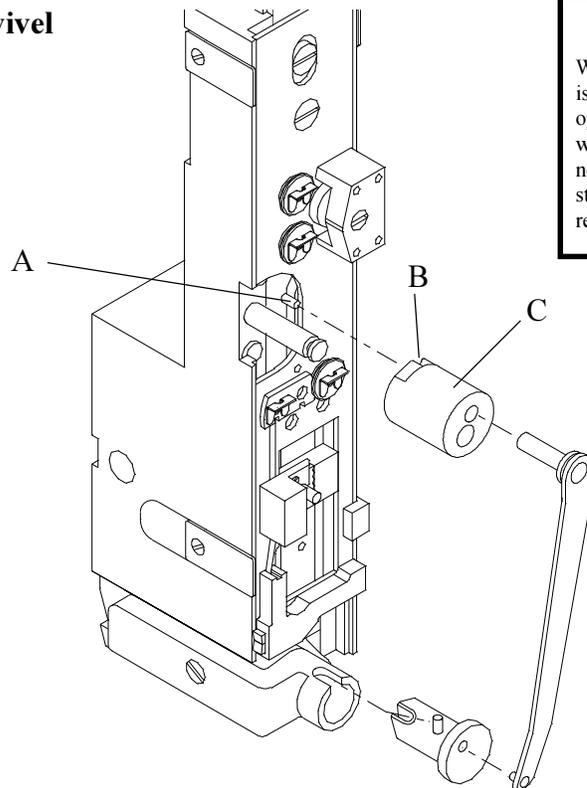
**CAUTION**  
As a precautionary measure-When removing the head from any stitching machine make **SURE** that the power to the machine has been turned **OFF** or disconnected.



# DISMANTLING/REASSEMBLING MAGNATEK HEAD



## How To Install Swivel Operating Cam



### Caution

When reassembling, make certain that pin (Index A) is visible and is aligned with slot (Index B) of rotator operating cam (Index C). If not assembled in this way, the bonnet casting will crack or break on the next cycle under power. It is recommended that the stitcher be turned over by hand to test that proper reassembly procedure has been followed.

# Section 6

## PARTS LIST

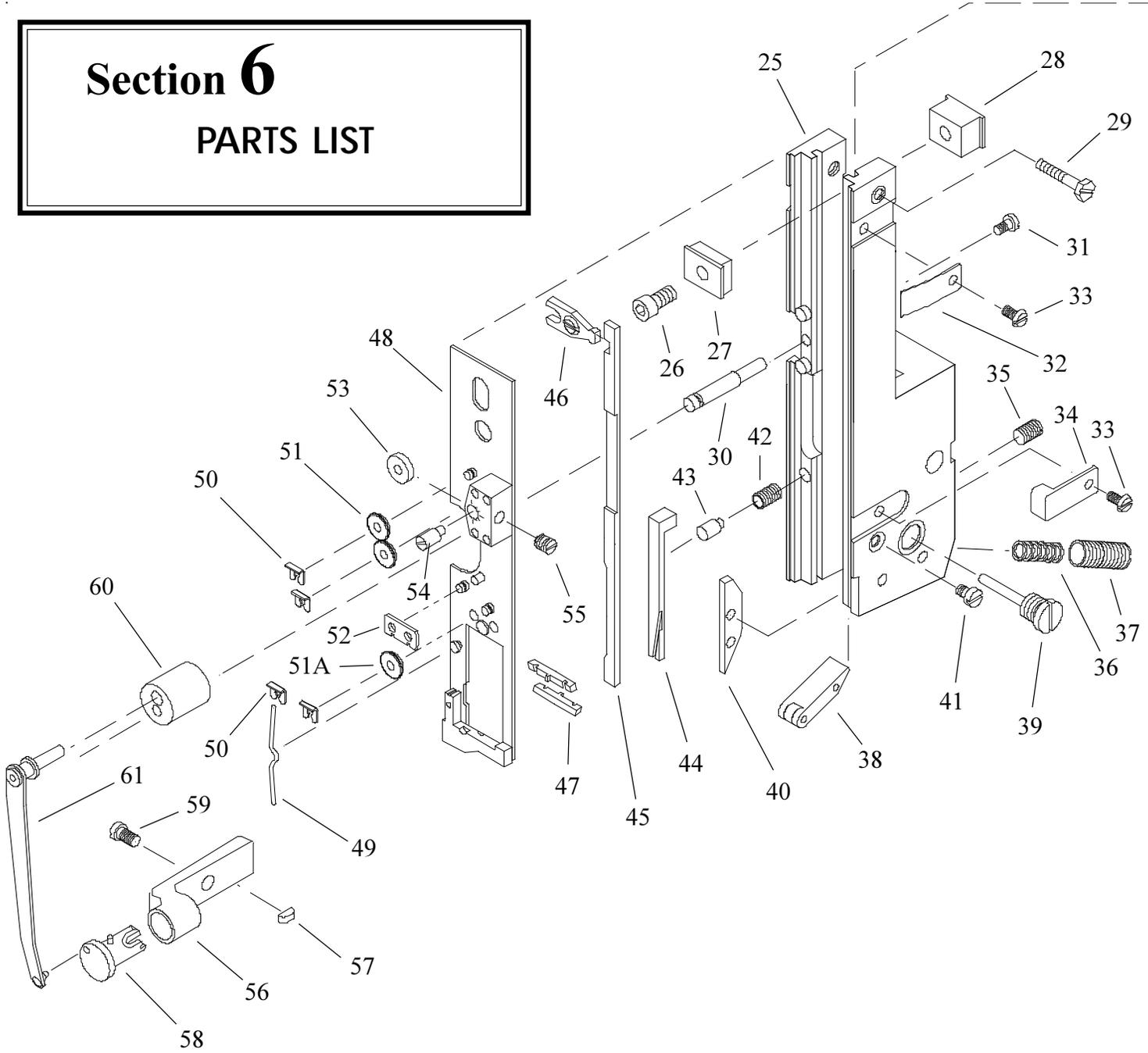
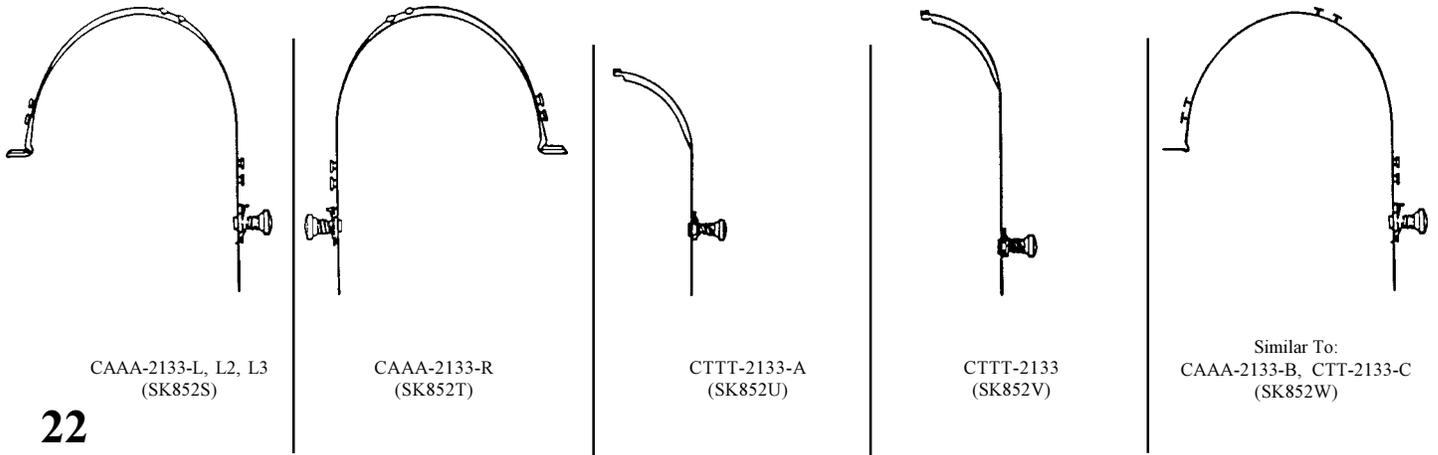


Figure 19  
(SK852R)

### Wire Guide Springs Figures 20



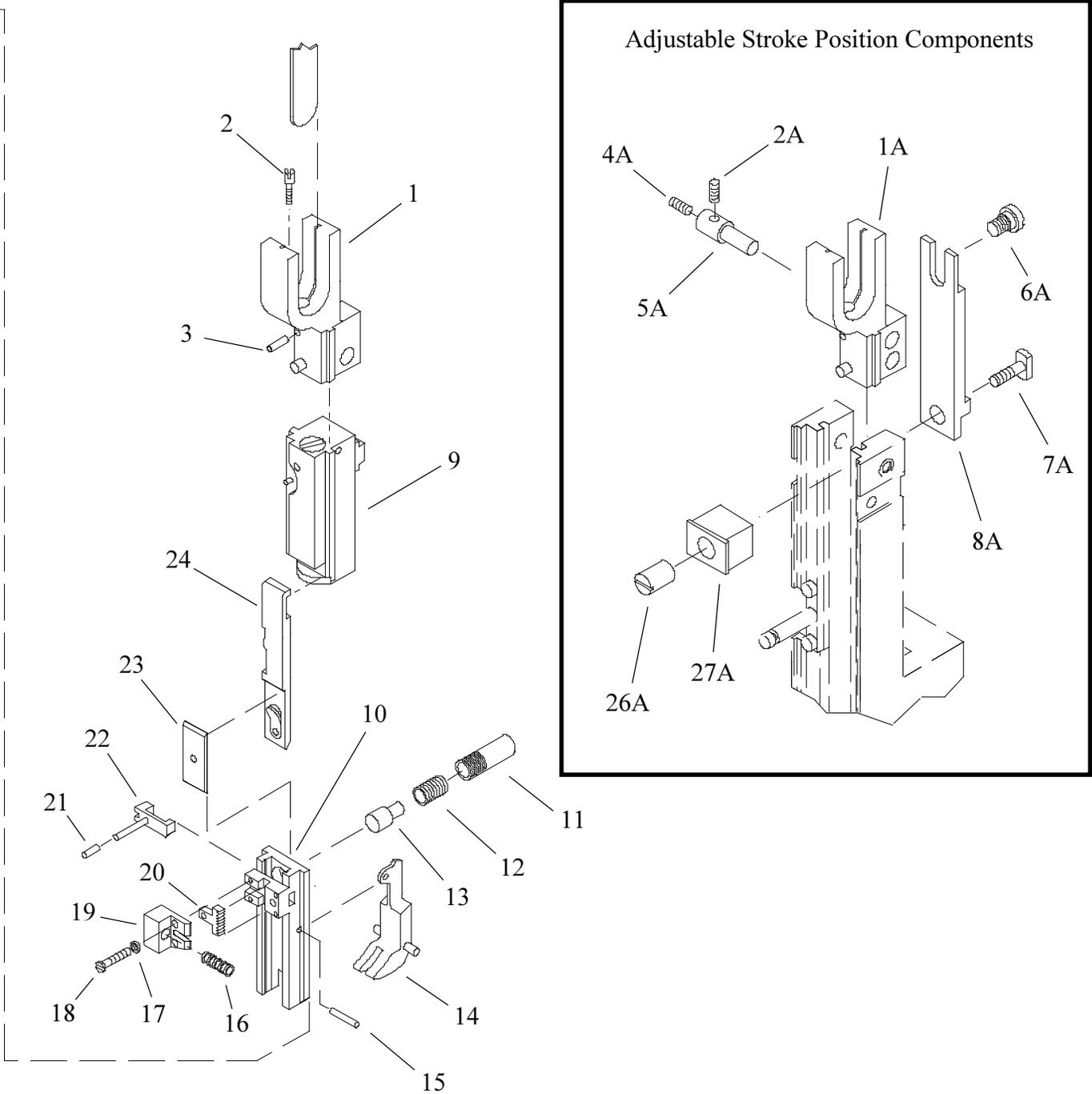
CAAA-2133-L, L2, L3  
(SK852S)

CAAA-2133-R  
(SK852T)

CTTT-2133-A  
(SK852U)

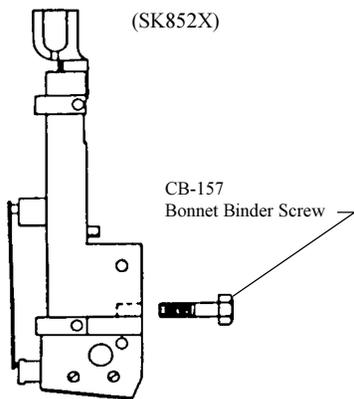
CTTT-2133  
(SK852V)

Similar To:  
CAAA-2133-B, CTT-2133-C  
(SK852W)

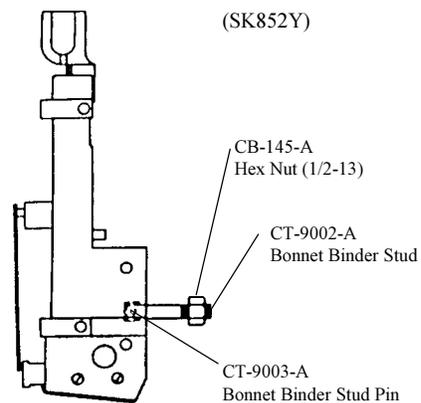


Bolt-On and Clamp-On Heads Figures 21

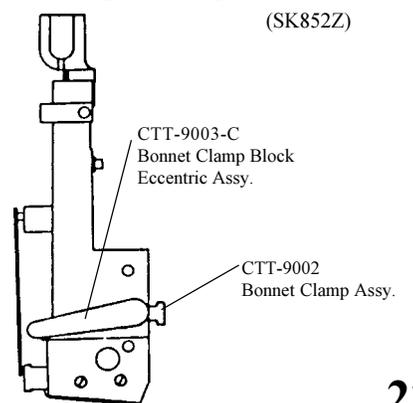
Bolt-On-Type Head  
(SK852X)



Bolt-On-Type Head  
(SK852Y)



Clamp-On-Type Head  
(SK852Z)



# MAGNATEK HEAD

## PARTS LIST

ITEM	PART NO.	DESCRIPTION	QTY
1	CAA9074Z	WIRE GUIDE BRACKET ASSEMBLY	1
1A	CTT2615B	WIRE GUIDE BRACKET ASSEMBLY	1
2	CA9076	WIRE GUIDE SPRING BRKT ADJ SCREW	1
2A	CT56	WIRE GUIDE SPRING BRKT ADJ SCREW	1
3	CA9077	WIRE GUIDE SPRING BRKT SET SCREW	1
4A	CT1060	SET SCREW	1
5A	CT2616	WIRE GUIDE BRACKET ADJ. SCREW STUD	1
6A	CT2614	FACE PLATE ADJ. SLIDE GUIDE STUD	1
7A	CT2612	FACE PLATE LOCATING BLOCK STUD	1
8A	CT2610	FACE PLATE ADJUSTING SLIDE	1
9	See TABLE 1	DRIVING SLIDE ASSEMBLY	1
		NOTE: The Driving Slide Assembly includes the following parts:	
		DRIVING SLIDE (ONLY)	1
a,c,d,f		CA-2623 (standard)	
b		CT-2623 (2 sheets to .125 in. thick work)	
e		CA-2623-B (pin holds in driving slide spring)	
		DRIVING SLIDE SPRING PLUNGER	1
a,b,c,d,f		CA-2007	
e		CA-2007-A	
		DRIVING SLIDE SPRING	1
a,b,c,d,f		CA-9006	
e		CA-9006-A	
		DRIVING SLIDE SPRING SCREW	1
a,b,c,d,f		CA-9021-A	
		DRIVING SLIDE SPRING PIN	1
e		D-37327-F	
		DRIVING SLIDE ROTATOR OP. PIN	1
all		CA-9028	
		DRIVING SLIDE SPRING SCREW LOCK PIN	1
a,b,c,d,f		CA-9028-A	
10		BENDER BAR ASSY. COMPLETE	1
a	CAAA9013W	1/2" Cr., 25 to 30 rd. wire	
b	CAAA9013A2	1/2" Cr., 25 to 30 rd. wire (McCain)	
c	CAAA9013G2	1/2" Cr., 24 rd. wire	
d	CAAA9013J2	1/2" Cr., 20-21 x 25 wire	
e	CAAA-9013L2	1/2" Cr., 24 rd. wire (McCain)	
f	CAAA9013Q2	1/2" Cr., 22 Rd. wire	
g	CAAA9513H	3/8" Cr., 25 to 30 rd. wire	
h	CAAA9513K	3/8" Cr., 20-21x25 wire	

ITEM	PART NO.	DESCRIPTION	QTY
		NOTE: The above Bender Bar Assembly includes the following items through item 24	
		BENDER BAR SUB ASSEMBLY	1
a	CAA9013U	1/2" Cr., 25 to 30 rd. wire	
b	CAA9013Z	1/2" Cr., 25 to 30 rd. wire (McCain, Macey)	
c	CAA9013F2	1/2" Cr., 24 rd. wire	
d	CAA9013H2	1/2" Cr., 20-21 x 25 wire	
e	CAA9013K2	1/2" Cr., 24 rd. wire (McCain)	
f	CAA9013P2	1/2" Cr., 22 rd. wire	
g	CAA9513G	3/8" Cr., 25 to 30 rd. wire	
h	CAA9513K	3/8" Cr., 20-21x25 wire	
11	CA9115	BENDER BAR FRICTION PLUG BUSHING	1
12	CA9113A	BENDER BAR FRICTION PLUG SPRING	1
13	CA9112A	BENDER BAR FRICTION PLUG	1
14		SUPPORTER ASSEMBLY	1
	CAA9026	1/2" Cr.	
	CAA9526	3/8" Cr.	
15	CA9029	SUPPORTER PIVOT PIN	1
16	CA168	EXTERNAL GRIP SPRING	1
17	CB371K	LOCKWASHER	1
18	CA9024A	GRIP HOUSING RETAINING SCREW	1
19	CT413A	GRIP SPRING HOUSING	1
20	CA9015D	GRIP	1
21	CA173	PLASTIC PIN CAP	1
22		BENDER BAR LATCH	1
	CAA9014E	(All Except McCain)	
	CAA9014F	(McCain)	
23		DRIVER	1
	CA9009	1/2" Cr. 24 to 30 Rd.	
	CA9009C	1/2" Cr. 20x25 & 21x25 wire	
	CA9509	3/8" Cr. 24 to 30 Rd.	
	CA9509F	3/8" Cr. 21x25 wire	
24		DRIVER BAR ASSEMBLY	1
	CAA9012A	1/2" Cr.	
	CAA9012D	1/2" Cr. (McCain)	
	CAA9512A	3/8" Cr.	

TABLE 1

(For use in determining customer's Driving Slide Assembly)

ITEM	PART NO.	DESCRIPTION	Driving Slide Style/Use	Lug Style
9		DRIVING SLIDE ASSEMBLY		
a	CTT2623		standard, raised lug	.187 lg. rectangular (CT2602)
b	CTT2623A		lowered lug for 2 sheets to .125 in. thick work	.187 lg. rectangular (CT2602)
c	CTT2623C		standard, raised lug	.25 lg. rectangular (CT2602A)
d	CAA2623		standard, raised lug	round (CA2103) w/.031 thk. washer (CT32B)
e	CAA2623C		pin (D37327F) holds in driving slide spring	round (CA2103) w/.031 thk. washer (CT32B)
f	CAA2623D		standard, raised lug	round (CA2103B) w/.079 thk. washer

\* Contact **ISP** customer service for Magnatek heads not listed

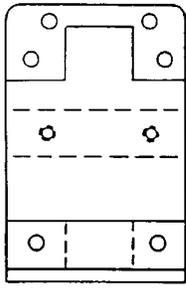
# MAGNATEK HEAD

## PARTS LIST

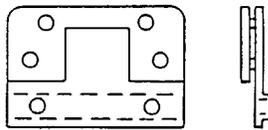
ITEM	PART NO.	DESCRIPTION	QTY
25		BONNET CASTING SUB ASSEMBLY	1
		*Magnatek Heads that use bonnet sub assembly	
	CAA2004	CAA2004	
	CAA2004B	CAA2004J	
	CAA2004E	CAA2504G,L,R, CAA2004F,G	
	CTT2604	CTTT2604,A,C,E,F,G,O,U,E2,R2, H3,P3,R3,G4,H4,J4,R10	
	CTT2604A2	CTTT2604A2	
	CTT2604P	CTTT2604P2	
	CTT2604H	CTTT2604M3	
	CTT2604L	CTTT2604Q3	
	CTT2604N	CTTT2604T3,V3	
	CTT2604G	CTTT2604U3	
26	CT2608	FACE PLATE LOCATING BLOCK SCREW	1
26A	CT2613	FACE PLATE LOCATING BLOCK NUT	1
27	CT2606	FACE PLATE LOCATING CLAMP	1
27A	CT2611	FACE PLATE ADJ. SLIDE BLOCK	1
28	CT2607	FACE PLATE LOCATING BLOCK	1
29	CA9075	WIRE GUIDE BRACKET SCREW	1
30	CA9127	ROTATOR OPERATING CAM STUD	1
31	CA9058	ROTATOR OPERATING CAM STUD SCREW	1
32	CA9056C	FACE PLATE RETAINING CLIP	3
33	CA2081	FACE PLATE RETAINING CLIP SCREW	4
34	CA9056C	FACE PLATE RETAINING CLIP	1
35	CT9109	BONNET ALIGNING SCREW 0 to 2 as req'd.	
36	CA9032	SUPPORTER SPRING	1
37	CA9037	SUPPORTER SPRING BUSHING	1
38		SUPPORTER SPRING LEVER ASSEMBLY	1
	CAA9036	Standard (1.625 in. long)	
	CAA9036A	Special (1.494 in. long)	
	CAA9036B	Special (1.312 in. long)	
39	CA9034	SUPPORTER SPRING LEVER SCREW	1
40		SUPPORTER GUIDE PLATE	1
	CA9030	All except listed below. 2 Qty. used on: CAA2004F,G	
	CA9030A	2 Qty. used on: CTTT2604A2 (McCain)	
41	CA9081	SUPPORTER GUIDE PLATE SCREW	1
42	CA9051A	WIRE CUTTER OPERATING SLIDE FRICTION PLUG SPRING	1
43	CA9050A	WIRE CUTTER OPERATING SLIDE FRICTION PLUG	1
44		WIRE CUTTER OPERATING SLIDE	1
	CA9049	1/2" Cr. (All 1/8", .155", 3/16" capacity heads, and CTTT2604F4,H4 heads.)	
	CA9049A	1/2" Cr. (All other 1/2" Cr Heads not listed above)	
	CA9549	3/8" Cr.	
45		GRIP RELEASE SLIDE	
	CA9022	1/2" Crown	1
	CA9522	3/8" Crown	1
46		FACE PLATE ADJUSTING LEVER	1
	CA9025	For Non-Slotted Face Plates	
	CA9025D	For Slotted Face Plates	
47	CA9048	WIRE CUTTER	2

ITEM	PART NO.	DESCRIPTION	QTY
48		FACE PLATE ASSEMBLY	1
	CAA2132H	1/2" Crown, Slotted	
	CAA2132K	1/2" Crown, No Slot	
	CAA2132L	1/2" Crown, Fixed (Bypass)	
	CAA2579C	3/8" Crown, Slotted	
	CAA2579D	3/8" Crown, No Slot	
NOTE: The above face plate assemblies include indexes 48 to55			
48		FACE PLATE SUB ASSEMBLY	1
	CAA2132H	1/2" Crown, Slotted	
	CAA2132K	1/2" Crown, No Slot	
	CAA2132L	1/2" Crown, Fixed (By-Pass)	
	CAA2579C	3/8" Crown, Slotted	
	CAA2579D	3/8" Crown, No Slot	
49	CA9134	TENSION PAWL SPRING	1
50	CA9124	TENSION ROLL CLIP	4
51	CA9103C	WIRE STRAIGHTENER ROLL	2
51A	CA9103A	CHECK PAWL ROLLER	1
52	CA9098	TENSION PAWL	1
53	CA9065A	STRAIGHTENER ECCENTRIC ROLL	1
54	CA9066A	WIRE STRAIGHTENER ECCENTRIC	1
55	CA172	ECCENTRIC FRICTION LOCKING SCREW	1
56		ROTATOR HOLDER	1
	CA9043H	1/2" CR., 25 TO 30 RD. WIRE, TAPERED END	
	CA9043E	3/8" CR., 25 TO 30 RD. WIRE, R.H. MOUNT	
	CA9543A	3/8" CR., 25 TO 30 RD. WIRE	
	CA9043A	1/2" CR., 25 TO 30 RD. WIRE	
	CA9043C	1/2" CR., 20-21X25 WIRE	
57	CB75B	KEY, WOODRUFF (for use with CA-9043-H Rotator Holder only)	1
58		MAGNETIC ROTATOR	1
	CAA9038M	1/2" CROWN	
	CAA9538M	3/8" CROWN	
59		ROTATOR HOLDER SCREW	1
	CA9044A	all except below	
	CA9044B	CTTT2604W2,Y2,Z2,A3,X3,R7 CAA2004K	
60		ROTATOR OPERATING CAM	1
	CA9163C	standard oiling	
	CA9163D	inverted oiling	
61	CAA9046A	ROTATOR OPERATING SPRING ASSEMBLY	1

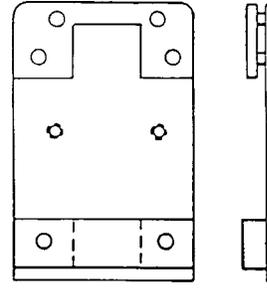
## CLINCHER PLATE ASSEMBLIES



TYPE A  
(SK852F2)



TYPE B  
(SK852G2)



TYPE C  
(SK852H2)

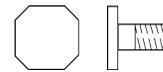
CROWN SIZE	CLINCHER POINT	TYPE	CLINCHER PLATE ASSY.
------------	----------------	------	----------------------

3/8	CA-9583-A Thick	A	CTT-9586-A
3/8	CA-9583-A Thick	C	CAA-2589-B
1/2	CA-9083 Thin	A	CTT-9086
1/2	CA-9083-A Thick	A	CTT9086-A
1/2	CA-9083 Thin	A	CTTT-9086*
1/2	CA-9083-A Thick	A	CTTT9086-A**
1/2	CA-9083 Thin	B	CTT-9086-B
1/2	CA-9083-A Thick	B	CTT9086-F
1/2	CA-9083 Thin	C	CAA-2089
1/2	CA-9083-A Thick	C	CAA-2089-A



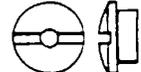
CA-2090  
STUD

(SK852J2)



CT-9088  
BINDER  
BOLT

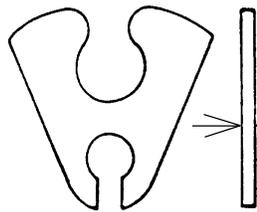
(SK852K2)



CA-2091  
NUT

(SK852L2)

\* Includes CA-9083, CTT-9086, CT-9093, CA-2091, CT-9088.  
 \*\* Includes CA-9083-A, CTT-9086-A, CT-9093-A, CA-2091, CT-9088.

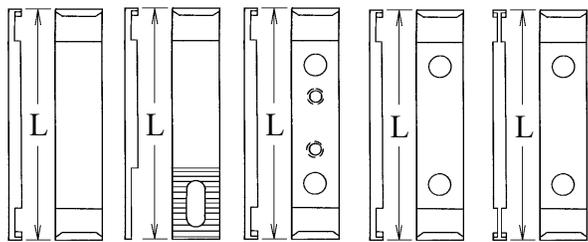


(SK852I2)

### CLINCHER POINT

1/16 Nominal, CA-9583-A, Thick, 3/8 Crown  
 1/16 Nominal, CA-9083-A, Thick, 1/2 Crown  
 1/32 Nominal, CA-9083, Thin, 1/2 Crown

### CLINCHER SLIDES



D

(SK852M2)

E

(SK852N2)

F

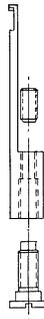
(SK852O2)

G

(SK852P2)

H

(SK852Q2)



J

(SK852R2)

TYPE	L	CLINCHER SLIDE	CLINCHER POINT
------	---	----------------	----------------

D	3-17/32	CT-9093	Thin
D	3-37/64	CT-9093-A	Thick
E	5-9/16	CT-9093-R	Thin
E	5-9/16	CT-9093-S	Thick
F	3-31/64	CA-2095-A	Thick
G	12-25/32	CA-2095-A	Thick
H	12-25/32	CA-2095	Thin
J	3-17/32 Adjustable	CTT-9093-Y	Thin/Thick

# Notes

WHEN ORDERING PARTS, PLEASE STATE: QUANTITY REQUIRED, PART NUMBER, PART NAME, WIRE SIZE AND CROWN WIDTH OF YOUR STITCHER.

## **ISP** Stitching & Bindery Products

A Division Of Samuel Strapping Systems

USA:  
3911 S. Memorial Dr. Racine, WI 53403  
**1-800-345-6641 1-262-589-5421**  
**Fax: 1-262-598-5426**  
**[www.ispstitching.com](http://www.ispstitching.com)**