ADJUSTMENTS

Clinching: In setting the clincher (7) located in the front of the arm, loosen the set screw, which locks the arm adjusting screw. Turn the adjusting screw counter-clockwise slightly, thus lowering the arm. Place some work on the arm and make one stitch. (Never drive staples one on top of the other as this may clog the machine and result in unnecessary damage for which the manufacturer cannot be held responsible). Examine the clinched staple, if too loose turn the arm adjusting screw clockwise until the clinc is satisfactory, then lock the adjusting screw. Avoid adjusting the arm too high, as this will cause the anvil and supporter (8) to stick in the work and retard production. When inserting a new clincher be sure to align the clincher grooves with the staple. This is done as follows: Insert the new clincher and turn the machine over manually until the legs of the staple are just above the top of the clincher. Then move the clincher to the right or left until the grooves are approximately in line with the legs of the staple. The turn the machine until the legs enter the grooves of the clincher, after which the clincher must be clamped firmly in place.

Feed Rolls: The feed rolls (5) are adjusted as follows: The left hand feed roll is set at the factory, so that it will start to feed wire when the former on its upward stroke is just above the cutter clamp, and must never be changed. The right hand feed roll is adjusted to vary the length of wire as required. This is accomplished by loosening the feed roll clamp screw (9) and turning the feed roll clockwise to decrease as desired. Make certain that the feed roll is locked tightly after adjusting. Cutters: The former cutter, part number 1004, is attached to the lower left end of the former, part number 15005, and must be changed whenever the length of the wire is changed or the cutters become dull. These cutters are stocked in several thicknesses as shown in the parts list. The former cutter can be removed by detaching the stationary cutter clamp and turning the machine until the former is in its lowest position. When reassembling the stationary cutter clamp make certain that the cutter clamp and the stationary cutter (10) are set tightly against the former cutter before tightening the cutter clamp screw (11).

REVERSIBLE PARTS

Both cutters have four cutting edges and can be changed when the edges become dull. The driver is double ended and can be reversed when necessary.

DRIVE

The machine is equipped with a "V" belt drive, which operates at approximately 350 RPM. An adjustable motor base is provided to compensate for stretch in the "V" belt. Do not allow oil or grease to contact the belt as this will cause slippage.

LUBRICATION

The bearings in the machine are self-lubricating. (Do not use grease) Oilers are provided to permit occasional lubrication at these points. The other working parts of the machine should be lubricated with a good grade of oil and grease regularly. Do not over lubricate the forming and driving mechanism, as the lubricant will mark the work.

WRENCHES

A set of three special wrenches is furnished with each machine as follows:
1 number 1045 for clincher and motor base.
1 number 1046 for wire tube.
1 number 1047 for adjusting clutch ring
By carefully adhering to the above instructions, many years of satisfactory service will be derived from the machine.
Before attempting to operate the machine, remove the rust preventive, which is used to protect the finished surfaces during shipment. Check the voltage and current on the motor nameplate. These values must be the same as that of the electrical service with which the machine is to be used.

Step on the foot pedal and turn the machine over manually by means of the large pulley in the rear. The machine must turn freely.

**WIRE**
Wire is furnished in either of two standard forms; namely spool wound (plastic or wooden) or coil wound on paper cores. A special detachable spool is furnished for use with the latter. In the spool wound form the wire is ready for use as received; however, in the coil form the wire must be put into the detachable spool. This is done as follows: Remove the wrapper from the wire (but do not cut the binding wires), unscrew the loose flange of the detachable spool and place the coil on the spool with the end of the coil at the top pointing to the right when looking at the solid flange of the spool.

**THREADING THE MACHINE**
Place the spool on the spool stud so that the wire will unwind from the top with the end pointing toward the machine. If coil wound wire is used, hold the end of the wire firmly with one hand and cut the binding wires and bend them back over the flanges. Clip off the end of the wire to remove kinks and facilitate threading. **WARNING:** Do not let go of the end of the wire as the spool will immediately unravel and become entangled. In threading, pass the end of the wire through the loop at the top of the wire guide spring (1), and down into the top of the wire tube (2). Push the wire through the tube and into the slot in the stationary cutter clamp (3). A wire check (4) is provided just above the feed rolls (5), its purpose is to prevent the wire from moving backward after feeding. It is of the utmost IMPORTANCE that the wire is in the wire check at all times to ensure even feeding of the wire. The wire is placed in the wire check by pushing the long end of the wire check pawl (6) upward. Release the wire checkpawl and the machine is ready for operation.

**CAPACITY**
The stitching range of this machine is from zero to 3/16 inch in thickness. It is necessary to make adjustments to cover the entire range. However, the machines are generally set to the desired thickness before leaving the factory.
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<td>Former Guide Plate</td>
<td>1016</td>
<td>Wire Check Body</td>
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<td>Former &amp; Driver Link</td>
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Model L
Operating Instructions & Parts List

NO.  NAME
1033  Clutch Ring Spring
1034  Clutch Trip Lever Pivot Pin
1035  Clutch Trip Lever Spring
1036  Clutch Ratchet
1037  Solid Clincher
1037-A Solid Clincher (Double-end)
1037-B Four Position Clincher
1037-C 3-1/8" Ig. Clincher
1042  Solid Pulley
1043  "V" Belt (Not Shown)
1044  Main Shaft Collar
1045  Wrench for clincher and motor base
1046  Wrench for wire tube
1047  Wrench for adjusting clutch ring

NO.  NAME
1048  Wrench for stationary cutter clamp
1049  Main Shaft Bushing
1442  Solenoid Link
1443  Solenoid Plunger Pin
15001  Front Plate Assembly
15003  Main Shaft Assembly
15004  Feed Roll Shaft Assembly
15005  Former Assembly
15006  Drive Shoe Assembly
15007  Clutch Ring Assembly
15008  Clutch Trip Lever Assembly
15009  Clutch Retaining Lever Assembly
15010  Wire Guide Spring Assembly
15012  Driving Pulley Bushing Assembly