WIDE CROWN STITCHER

1 3/8 INCH CROWN .037 x .074 WIRE

OPERATING INSTRUCTIONS

AND PARTS MANUAL

Conforms to OSHA requirements in the U.S.A.

FOR INSTALLATION / MAINTENANCE / ADJUSTMENT

IDEAL

IDEAL STITCHER DIVISION

W. R. PABICH

MANUFACTURING COMPANY INC.

2323 N. Knox Avenue/Chicago 60639

Phone 312/486-4141

WIRE

STITCHERS

STANDARD & SPECIAL MACHINES AND STITCHING WIRE

IMPORTANT

THE IDEAL STITCHER FURNISHED YOU IS A

Model _____

Serial No. _____

Wire Size _____

Crown Width _____

Cutter Blade Size _____

Motor: _____ **HP.** _____ **RPM** _____ **PHASE**

When ordering parts or requesting information
please supply the information outlined above
or send a sample of the staple you are using.

The CROWN of a staple is measured INSIDE the legs. 

The leg LENGTH is measured top to bottom.

INSTALLATION INSTRUCTIONS

EXAMINATION: Before uncrating, examine your stitcher for any visible damage in transit. If damaged, **do not uncrate the machine.** Notify the carrier or trucking company and your Ideal Stitcher representative.

UNCRATING STITCHER: (A) Remove the end of the crate at which the motor is located. (B) Remove the two bolts which hold the base of the stitcher to bottom of crate. (C) Remove the cross brace which holds the stitcher in position in upper half of the crate. (D) Pull the stitcher from the crate by grasping the heavy cast iron column and motor bracket, or pull on the pulley guard.

AFTER THE MACHINE IS REMOVED from the crate, DO NOT PULL OR PUSH ON THE POST OR ARM OF THE STITCHER, as this can put the clincher block out of adjustment.

LOCATION FOR STITCHER: Place it on a level and solid footing to prevent excessive vibration. This is necessary when the machine is not bolted to the floor.

CHECK MOTOR: The type of motor for your machine was specified on your purchase order. Check the motor specification plate before connecting the stitcher to electric current.

LUBRICATION: When the machine is shipped from our factory, it is coated with an oil base rust preventitive, which need not be cleaned prior to operation. Your stitcher should be lubricated at all oiling points indicated in red on the machine. Use SAE 20 Oil for all lubrication. The machine should be oiled at least once, with a few drops of oil, every 8 operating hours.

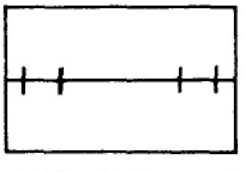
THE MOTOR should not be oiled until the first 2000 hours of operation have been completed; and then every 1000 hours thereafter.

MOUNTING THE WIRE SPOOL BRACKET: After removing the wire spool, bracket, and spool holder from the crate, mount your wire spool bracket as shown on drawing A 10012-A (page 3). There are 2 hexagon head screws furnished with the bracket for mounting.

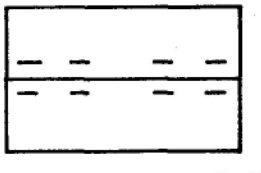
TO INSTALL WIRE ON THIS SPOOL HOLDER, push and turn hand wheel knob (A 662-D41) on coil holder 1/4 turn. This will allow front flange (A 662-D36) to be removed. Place the coil of wire over the coil holder spindle. Be sure that the wire will unravel from the TOP of the coil. Replace the front flange, pushing on hand knob and turning 1/4 turn until it locks in place. Cut binding wires or tape holding the end of the wire, so that the coil does not unravel. Cut approximately 6 inches of wire from the end, so that you have a straight piece of wire to lead down around the wire tension control spring (Part No. A 662-D12), and into the wire check (AA 336); as shown on drawing A 10011-A (page 2). It will be necessary to push down on the wire check collar (Part No. A 120) which releases the 2 wire check pins (A 119), allowing the wire to be threaded down between the pins; and then between the feed wheels, and into the curved wire feed tube (Part No. AA 349); then through the cutter tube (Part No. A 8316). See that the wire runs through the machine until it emerges a few inches from the right hand side of the head.

PROCEDURE TO START STITCHING: Machine is set at the factory to stitch 2 thicknesses of 275 point board, or the particular sample submitted by the customer. Switch on power and place scrap piece of corrugated material on top of clincher block. Step on pedal to make one staple, so that the surplus piece of wire in the machine, is ejected. Stitcher is now ready for operation.

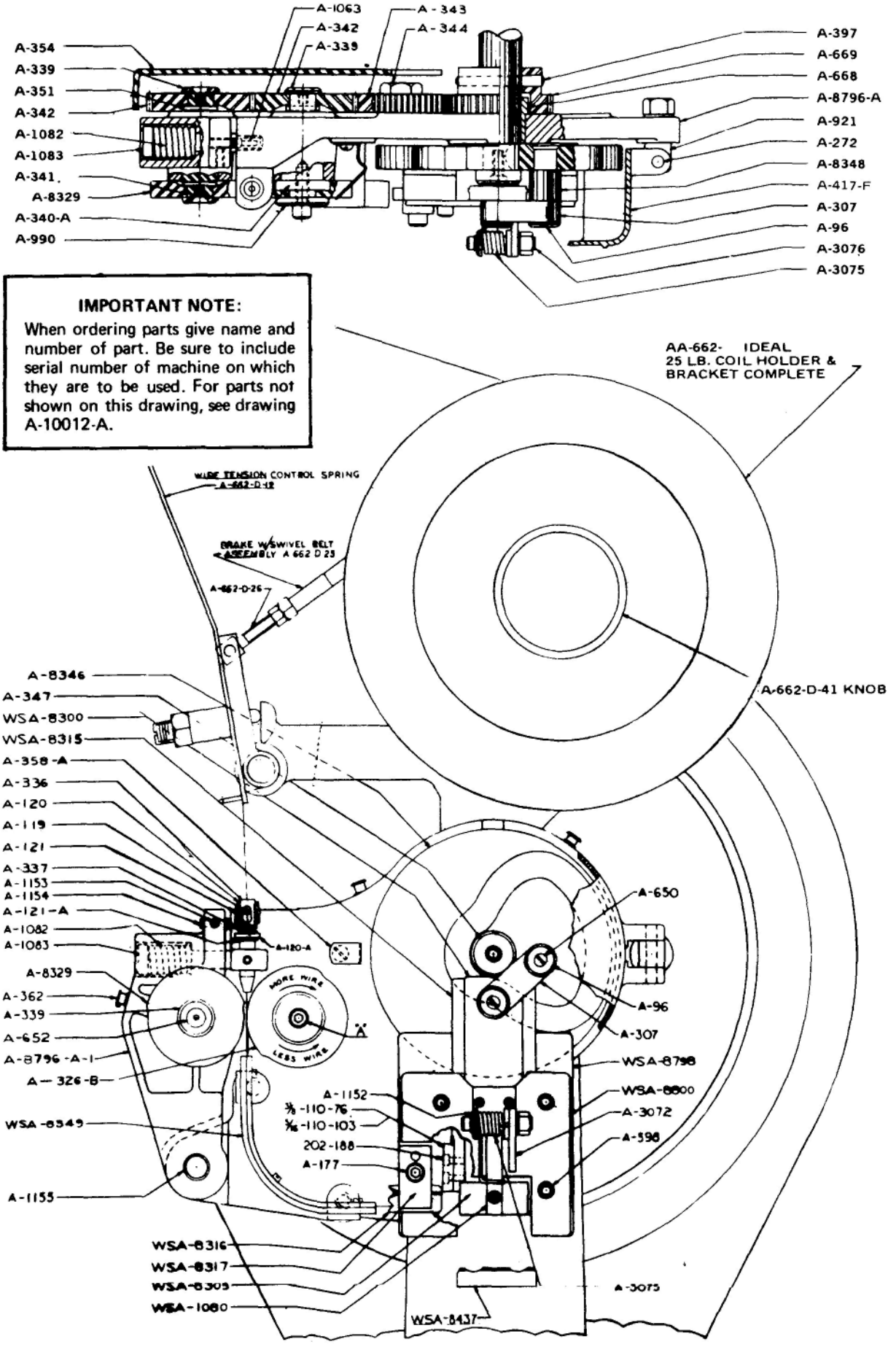
PLACE BOX OVER POST: Press down on foot pedal gradually until post is located in an upright position. Then press pedal down the rest of the way to engage the clutch. The machine will continue to stitch until the pedal is raised, disengaging the main pulley from the clutch. Removal of the foot from the pedal, allows the post to come forward, so that the box can be removed.



PLACING THE STAPLES 5 INCHES APART
is approved by Uniform Freight Classification, Rule 41, and The National Container Committee. Direction and placement pattern can be varied.

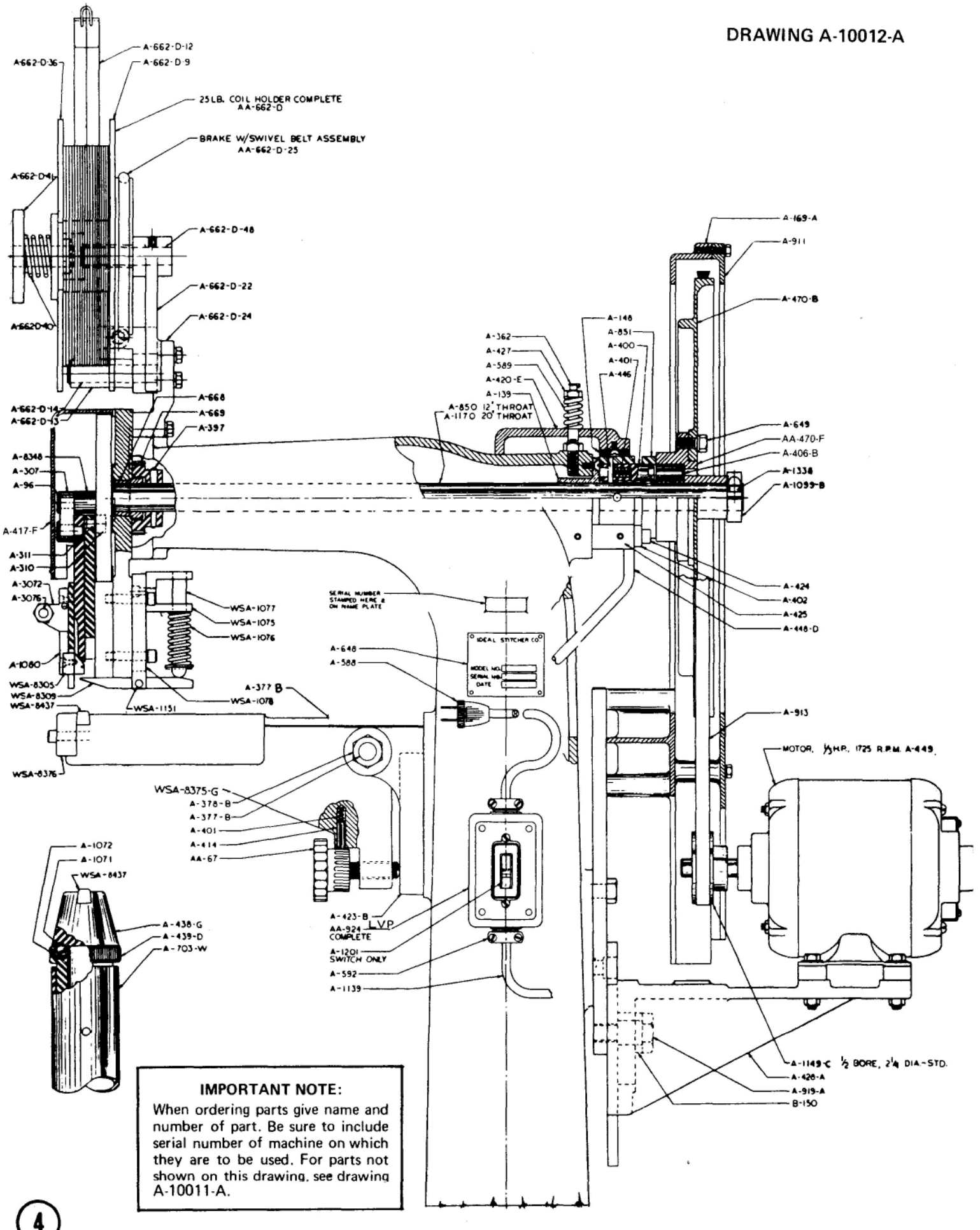


DRAWING A-10011-A



PARTS LIST FROM DRAWING A-10011-A

A-96	Connection Washer
A-119	Wire Check Pin
A-120	Check Sleeve
A-120-A	Check Washer
A-121	Check Pin Retainer
A-121-A	Check Spring Retainer
A-177	Cutter Tube Clamp Screw
A-272	Cam Guard Hinge Pin
A-307	Driver Connection
A-326-B	R. H. Feed Wheel
A-336	Wire Check Body
AA-336-2	Wire Check Complete
A-337	Wire Check Spring
A-339	Feed Wheel Washer L. H.
A-340-A	R. H. Feed Wheel Shaft
A-341	L. H. Feed Wheel Shaft
A-342	Feed Wheel Gear
A-343	Head Idler Gear
A-344	Head Idler Gear Screw
A-347	Former Cam Retaining Washer
A-351	Feed Wheel Gear Pin
A-354	Head Gear Guard
A-358-A	Cam Guard Cover Latch
A-362	1/4" Drive Oiler
A-397	Feed Drive Gear Pin
A-417-F	Cam Cover, Standard L. H. Head
A-598	Face Plate Screws
A-650	Driver Connection Screw
A-652	Feed Wheel Washer Screw
AA-662-D	25# Coil Holder complete with Mounting Bracket
A-662-D12	Spring, Wire Tension Control
A-662-D25	Belt Assembly, Brake with Swivel
A-662-D26	Stud & Lock Nut, Brake Tension Swivel
A-662-D44	Cam, Spool Lock
A-668	Head Plate Bushing
A-669	Head Drive Gear
A-921	Cam Guard Stud
A-990	R. H. Feed Wheel Washer
A-1063	Feed Roll Hinge Stop
WSA 1080	Anvil Post, Wide Crown
A-1082	Feed Roll Hinge Spring
A-1083	Feed Roll Shoulder Bolt
A-1152	Washer
A-1153	Feed Roll Hinge Set Screw
A-1154	Feed Roll Hinge Screw
A-1155	Feed Roll Hinge Pin
A-3072	Anvil Bracket (Anvil in front of machine)
A-3075	Anvil Spring
A-3076	Anvil Spring Stud
WSA 8300	Driver 1-3/8" Wide Crown Stitcher
WSA 8305	Anvil
WSA 8315	Former W. Roller & Pin
WSAA 8315	Former & Driver Assy.
WSA 8316	Cutter Tube
WSA 8317	Cutter Tube Clamp
A 8329	L. H. Feed Wheel
A-8346	Former Cam
A-8348	Former Cam Stud
WSA 8349	Wire Guide
WSA 8437	Clincher Block
A-8796-A	Standard L. H. Head Plate
A-8796-A1	L. H. Feed Roll Hinge
WSA 8798	Slide Box
WSA 8800	Face Plate
110-76	3/8" Cutter Blade
110-103	5/16" Cutter Blade
202-188	Cutter Blade Screws



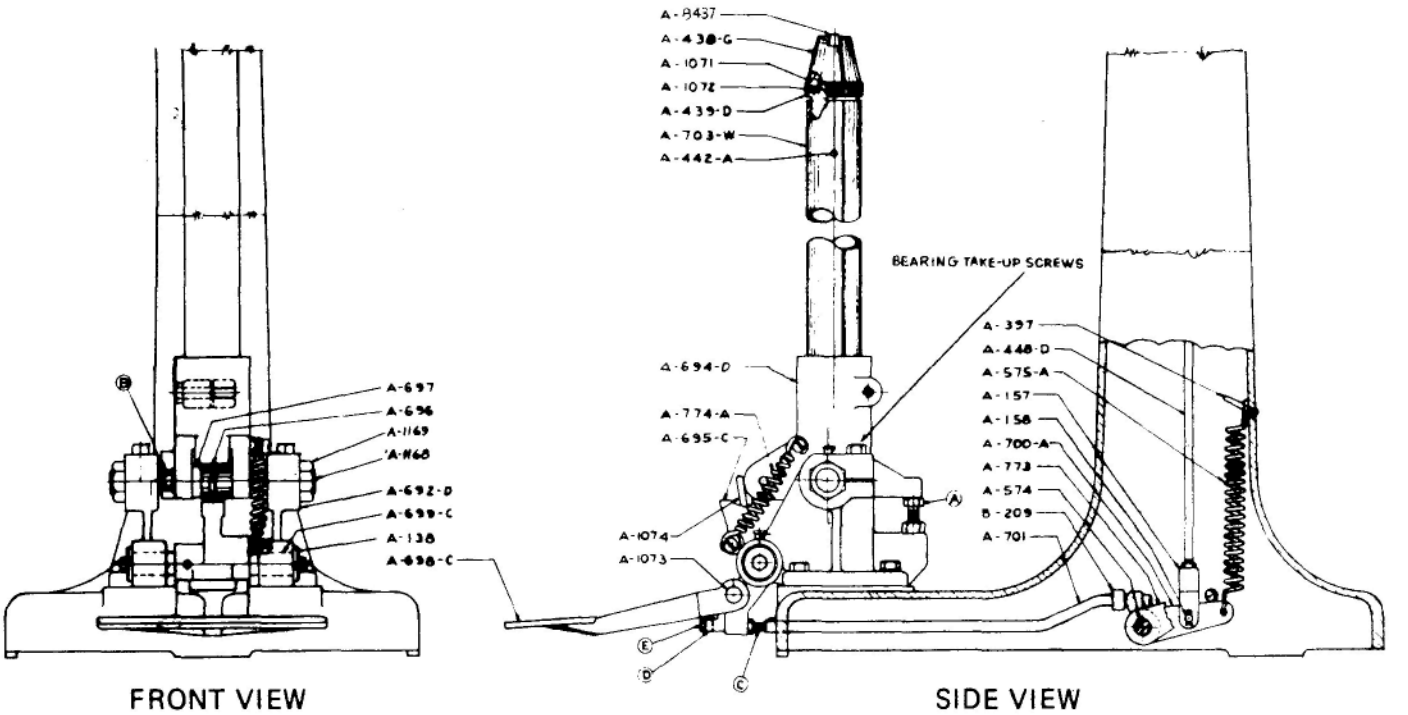
IMPORTANT NOTE:

When ordering parts give name and number of part. Be sure to include serial number of machine on which they are to be used. For parts not shown on this drawing, see drawing A-10011-A.

PARTS LIST FROM DRAWING A-10012-A

AA-67	Clincher Arm Adjusting Knob
A-96	Driver Connection Washer
A-139	Shaft Bushing, Rear
A-148	Brake Shoe Lining
B-150	Motor Bracket Washer
A-169-A	Drive Pulley Guard
A-307	Driver Connection
A-310	Former Roller
A-311	Former Roller Pin
A-362	Oiler
A-377-B	Clincher Arm Fulcrum Bolt
A-397	Feed Drive Gear Pin #4 Taper x 2" Long
A-399	Adjusting Knob Lock Nut
A-400	Clutch Pin
A-401	Clutch Pin Spring
A-402	Clutch Plate
A-406-B	Drive Pulley Pins (2 required)
A-417-F	Cam Cover
A-420-D	Brake Shoe
AA-420-D	Brake Shoe with Lining
A-424	Clutch Release Latch Pin
A-425	Clutch Plate Collar
A-427	Brake Adjusting Screw and Oiler
A-428-A	Motor Bracket
A-438-G	Clincher Block Holder
A-439-D	Clincher Block Adjusting Nut
A-446	Clutch Pin Guide Stud
A-448-D	Clutch Trip Rod
A-449	1/3 HP 60 Cycle Single Phase 115 VAC Motor
A-470-B	Main Drive Pulley
AA-470-F	Drive Pulley Hub with 2 A-406 Pins
A-589	Brake Shoe Spring
A-649	Pulley Hub Screw
AA-662-D	25# Coil Holder complete with Motor Bracket
A-662-D9	Rear Plate
A-662-D12	Wire Tension Spring
A-662-D13	Braking Block
A-662-D14	Braking Block Shaft
A-662-D22	Main Casting
A-662-D24	Spool Bracket Mounting
A-662-D25	Brake with Swivel Assembly
A-662-D36	Face Plate
A-662-D40	Face Plate Release Spring
A-662-D41	Face Plate Release Knob
A-662-D48	Main Spool Shaft
A-668	Head Plate Bushing
A-669	Head Drive Gear
A-703-W	Clincher Post for 12" Throat Machine
A-703-X	Clincher Post for 20" Throat Machine
A 850	Drive Shaft approximately 23" long for 12" Throat Machine
A 851	Clutch Hub with A-446 Guide Stud
A-911	Drive Pulley Guard Cover
A-913	Vee Belt
A-918	Motor Base Support
A-919-2	Motor Base Stud
AA924LVP	Low Voltage Switch and Relay
A-1071	Clincher Head Stop Ball
A-1072	Clincher Head Stop Ball Spring
WSA 1075	Supporter Plunger Bracket
WSA 1076	Supporter Plunger Spring
WSA 1077	Supporter Plunger
WSA 1078	Supporter Plunger Bracket Plate
A 1080	Anvil Post
A-1099-B	Shaft End Clamp Collar
A-1149-C	Motor Pulley 1/2" Bore, 2-1/4" O.D.
WSA 1151	Supporter Pin
A-1170	Drive Shaft, approximately 32-1/8" long for 20" Throat Machine
A-1338	Lock Screw for Clamp Collar
A-3072	Anvil Bracket
A-3076	Anvil Spring Stud
WSA 8305	Anvil
WSA 8309	Supporter
A-8346	Former Cam
A-8348	Former Cam Stud
WSA 8375 G	Clincher Arm for 12" Throat Machine
WSA 8376	Clincher Arm Clamp
WSA 8437	Clincher Block

DRAWING A-10009-AB



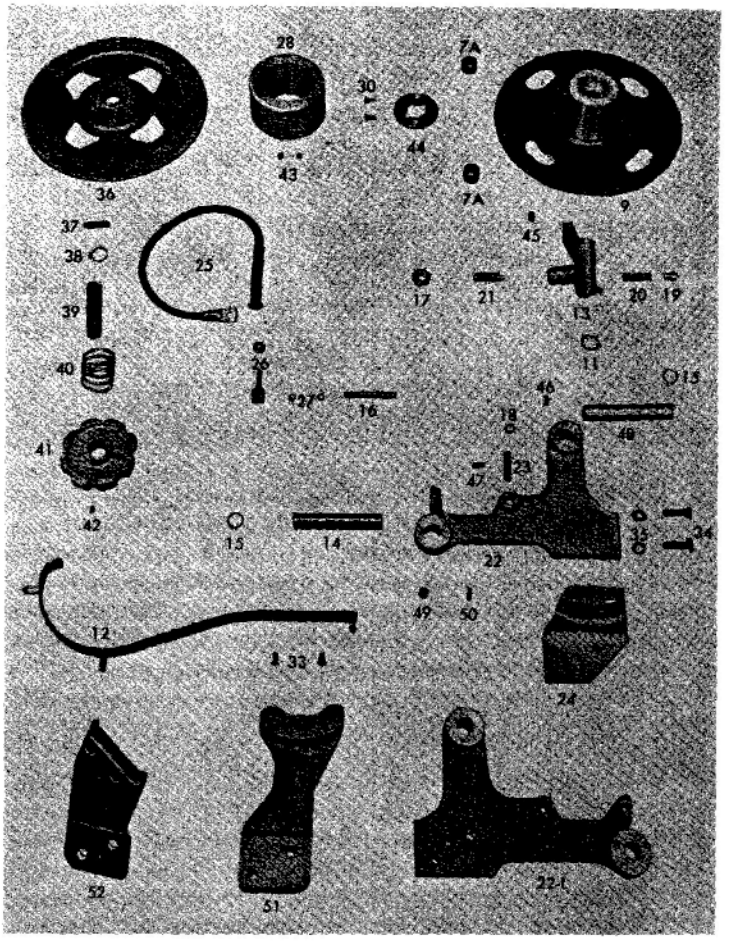
PARTS LIST FOR DRAWING A-10009-AB

A-138	Washer
A-157	Clevis—Clutch Rod
A-158	Clevis Pin—Clutch Rod
B-209	Set Collar
A-397	Taper Pin #4 x 2"
A-437	Clincher Block
A-438-G	Clincher Block Holder
A-439-D	Clincher Block Adjusting Nut
A-448-D	Clutch Shifter Rod
A-574	Clutch Shifter Shaft
A-575-A	Shifter Rod Arm Spring
A-692-D	Clincher Post Base
A-694-D	Clincher Post Bracket
A-695-C	Clincher Post Cam
A-696	Clincher Post Cam Roll
A-697	Cam Roll Bushing
A-698-C	Treadle
A-699-C	Treadle Shaft
A-700-A	Clutch Shifter Rod Arm
A-701	Clutch Operating Rod
A-703-W	Clincher Post
A-773	Clutch Shifter Arm Stop Lever
A-774-A	Clincher Post Spring
A-1071	Ball—Clinch Block Adjusting Nut
A-1072	Spring Clinch Block Adjusting Nut
A-1073	Treadle Pin
A-1074	Pin to hold Post in Stitching Position (Use for Stitching Flat Work Only)
A-1168	Clincher Post Bracket Trunnion
A-1169	Hex Nuts for Trunnion (2 required)

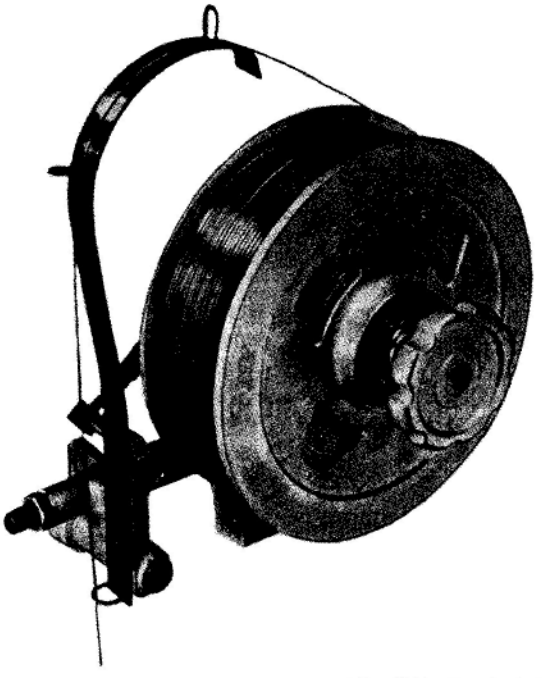
AA-662D / 25 POUND CONTROLLED WIRE COIL HOLDER

Can also be used with 5 and 10 pound coils.

A-662-D-7A	Bearing, Oilite
A-662-D-9	Rear Plate, Spool Holder
A-662-D-11	Lock Washer, Main Shaft
A-662-D-12	Spring, Wire Tension Control
A-662-D-13	Braking Block, Tension Spring
A-662-D-14	Shaft, Braking Block
A-662-D-15	Lock Ring, Main and Block Shaft
A-662-D-16	Stud, Brake Swivel Connecting
A-662-D-17	Lock Nut, Brake Tension Adjusting Screw
A-662-D-18	Lock Ring, Brake Belt Anchor Stud
A-662-D-19	Plunger, Brake Tension Spring
A-662-D-20	Spring, Brake Tension
A-662-D-21	Screw, Brake Tension Adjusting
A-662-D-22	Main Casting, Spool Bracket (R.H.)
A-662-D-22L	Main Casting, Spool Bracket (L.H.)
A-662-D-23	Stud, Brake Belt Anchor
A-662-D-24	Mount, Spool Bracket (Inland)*
A-662-D-25	Belt Assembly, Brake w/Swivel
A-662-D-26	Stud and Lock Nut, Brake Tension Swivel
A-662-D-27	Lock Ring, Brake Swivel Stud
A-662-D-28	Spacer, 3-3/4" Core
A-662-D-30	Screw, Flat Head (2-1/2" Core)
A-662-D-31	Screw, Flat Head (3-3/4" Core)
A-662-D-33	Screw, Flat Head
A-662-D-34	Cap Screw, Hex Head (Inland 2" length) (Bliss 1-1/2" length)
A-662-D-35	Lock Washer
A-662-D-36	Face Plate, Spool Holder
A-662-D-37	Roll Pin, Face Plate Release Assy.
A-662-D-38	Lock Ring, Face Plate Release Assy.
A-662-D-39	Shaft, Face Plate Release Assy.
A-662-D-40	Spring, Face Plate Release Assy.
A-662-D-41	Knob, Face Plate Release Assy.
A-662-D-42	Set Screw, Knob
A-662-D-43	Set Screw, Spacer (3-3/4" Core)
A-662-D-44	Cam, Spool Lock
A-662-D-45	Set Screw, Brake Swivel Connecting Stud
A-662-D-46	Set Screw, Main Shaft
A-662-D-47	Set Screw, Brake Belt Anchor Stud
A-662-D-48	Shaft, Main Spool
A-662-D-49	Set Screw, Brake Block Shaft
A-662-D-50	Roll Pin, Block Stop
A-662-D-51	Mount, Spool Bracket
A-662-D-52	Mount, Spool Bracket



Numbers following the D letters on parts list . . . show on parts photograph . . .



STITCHER ADJUSTMENT AND MINOR REPAIR PROCEDURE

STAPLE LEG ADJUSTMENT. The standard leg length is approximately 9/16" when the machine is shipped from the factory. This accommodates anywhere from two to four thicknesses of single wall corrugated. For proper stitching, the legs of the staple should be equal. The length of the left leg is determined by the thickness of the cutter blade, part No. 110-103 (A 8304). The length of the right leg is controlled by the right hand feed wheel, A 326-B, which also controls the total length of wire fed into the machine, used to make a staple.

IF THE RIGHT LEG IS TOO LONG, then the feed wheel lock screw is loosened and the feed wheel turned proportionately towards less wire so that the right leg of the staple will be reduced. If the right leg is too short, then the opposite procedure is used, with the right hand feed wheel being turned towards "More Wire." This wheel is shown on drawing A-10011-A.

IF THE STAPLE LEG SIZE IS TO BE CHANGED, it is not only necessary to change the cutter blade thickness, but also adjust the wire feed so that the right leg will be changed accordingly.

CLINCHER BLOCK ADJUSTMENT. With the switch turned off and the post in position, place a sample of the work to be stitched on top of the clincher block. Step on the foot pedal and slowly turn the pulley by hand to engage the clutch, which will move the former and driver mechanism downward. When this mechanism is at its lowest point, the material should be held snugly between the clincher block and the end of the former. If it is too tight, you can lower the clincher block by unlocking the lock screw in the knurled clincher block adjusting nut, part No. A 439-D. If it is too loose, bring the clincher block adjusting nut up so that the material is compressed enough to hold the material firmly. Remove foot from pedal and continue to turn pulley until machine is in its neutral position.

IF MACHINE IS NOW TURNED ON, a clicking noise may result. Drive one stitch by power with material in place to catch the staple. Clicking noise, which was due to turning machine over by hand, will disappear.

CUTTER TUBES A 8316. When inserting a new cutter tube, be certain that the machine is in the idle position, with the FORMER and DRIVER at the highest point of its travel. Insert the tube with the lower slotted side toward the back of the machine. Push the cutter tube into the head of the machine until it touches the CUTTER BLADE. Hold lightly in that position when tightening the cutter tube lock screw A 177 securely.

IF THE MACHINE REPEATS. The brake shoe or band is wearing or has loosened up. To eliminate this trouble, merely tighten the brake screw or band, part No. A 427.

IF THE CLUTCH PIN CLICKS AFTER THE MACHINE IS OPERATING, the brake shoe or band is too tight or too loose. Loosen up a bit on the brake adjusting screw, part No. A 427 so that the oil hole in the clutch, part No. A 851 is pointed directly upward.

PROPER BRAKING. When the machine is braking properly, the oil hole in the clutch hub, part No. A 851, will stop at the top.

IF A STRAIGHT PIECE OF WIRE or a partially formed staple falls out of the machine on to the box, this is usually caused by the anvil torsion spring being loose so that the anvil kicks forward prematurely at the moment of cut off. This is corrected by turning stud No. A 3076 to exert more tension on to the spring. To do this, insert an Allen wrench into the left hand side of the anvil spring stud and hold it firmly while the nut on the right hand side is loosened with a wrench. When the nut is loose, you can push the Allen wrench downward approximately a quarter turn and hold it in that position while the nut is retightened. Do not exert too much pressure, as you will shorten the overall length of the spring, reducing its effectiveness. If the spring has become set or overwound, it will be necessary to replace it with a new spring.

IF THE CROWN OF THE STAPLE cracks at the corners, this can be caused by too much compression due to the clincher block being too high or possibly having the corner of the driver end chipped. Reduce the compression of the staple by lowering the clincher block slightly. If this does not remedy the condition, check the end of the driver that pushes the staple through the material.

IF BOTH LEGS OF THE STAPLE are spread out so far that they miss the clincher block, it is caused by the grooves in the former having become worn.

IF ONE LEG MISSES the clincher block, it may be that the clincher block is out of line or that there is a burr on the wire at the time the wire is cut off, which diverts the leg as it travels through the material.

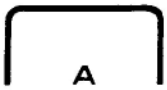
TO LINE UP THE CLINCHER BLOCK with the staple, turn the power to off position, step on the pedal and while the post is in an upright position, slowly turn the flywheel in the direction of the arrow until the former mechanism moves to its lowest position and slowly continue to turn the flywheel until the staple legs emerge out of the former. See that the legs are captured by the curvature of the clincher block. If the clincher block is to one side, loosen the clincher block locking screw and move the clincher block accordingly. Tighten the screw firmly after the block is lined up.

THIS CHART CAN BE YOUR "FIRST AID"

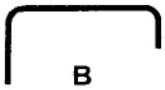
in quickly solving reasons for imperfect stitches and making the right adjustment for improving the stitching operation. Most stitching defects are caused by improper adjustments. These staple illustrations will tell you what is wrong. Keeping a most perfect staple will result in better stitching.

For illustration purposes, staples are shown with straight legs. Actually, blank staples made on a machine will have the legs of the staple spread out, due to the inherent springback characteristic contained in the wire. In the actual stitching operation, the material being stapled will support the legs as soon as they protrude out of the former; so that the staple legs will penetrate straight through the material and contact the clincher block

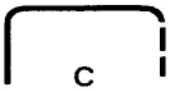
CAUTION: Before analyzing defective stitches, check for correct wire dimensions.



PERFECTLY FORMED BLANK STAPLE. Both legs of equal length.



RIGHT LEG TOO SHORT. Turn right hand feed wheel in "More Wire" direction. If right leg is too long, turn right hand feed wheel in "Less Wire" direction.



RIGHT LEG VARIES IN LENGTH. Left leg remains constant. Can be due to:

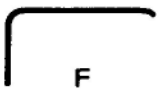
1. Worn Feed Wheels
2. Wire check AA-336 not working.

HUMP IN STAPLE CORNER OR CROWN broken at corner can be due to:

1. Worn Feed Wheels
2. Clincher block out of line.
3. Wire too hard.

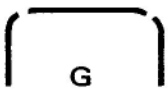
LEG BUCKLES. Can be due to:

1. Dull cutters.
2. Clincher block out of line.

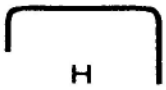


RIGHT LEG MISSING; due to:

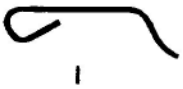
1. Improper feed adjustment.
2. Wire leaving slot in anvil, caused by improper line-up of WSA 8349.



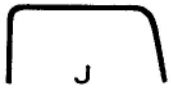
BROKEN STAPLE LEGS; can be caused by improper tension on anvil spring A 3075; or spring has set itself, requiring replacement with a new spring.



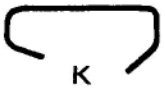
LEGS UNEVEN. Adjust right hand feed roll to shorten or lengthen right hand staple leg, as explained on page 7.



EITHER LEG NOT CLINCHING. Clincher block is out of line.



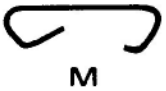
BOTH LEGS NOT CLINCHING. Caused by clincher post A-703 being released too quickly.



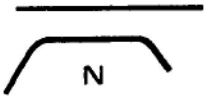
LEGS NOT PENETRATING WORK. Clincher block may be too low, or both legs may have to be increased as explained on page 8.

STAPLE LEGS FRACTURED. May be caused by:

1. Too much compression; remedied by lowering clincher block slightly.
2. End of driver broken, requiring replacement of WSA 8300.
3. Worn former legs. Replace WSA 8315.
4. Anvil corners too sharp. Round the corners slightly with emery cloth.
5. Wire too hard. Check by replacing with a new coil.



UNEVEN CLINCHING. One staple leg shorter than the other. Adjust feed wheels accordingly.



STRAIGHT PIECE OF WIRE or partially formed staple. A 3075 anvil spring is too loose, requiring replacement (if spring has set itself due to too much tension).

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IDEAL

IDEAL STITCHER DIVISION

W. R. PABICH
MANUFACTURING COMPANY INC.
2323 N. Knox Avenue Chicago 60639
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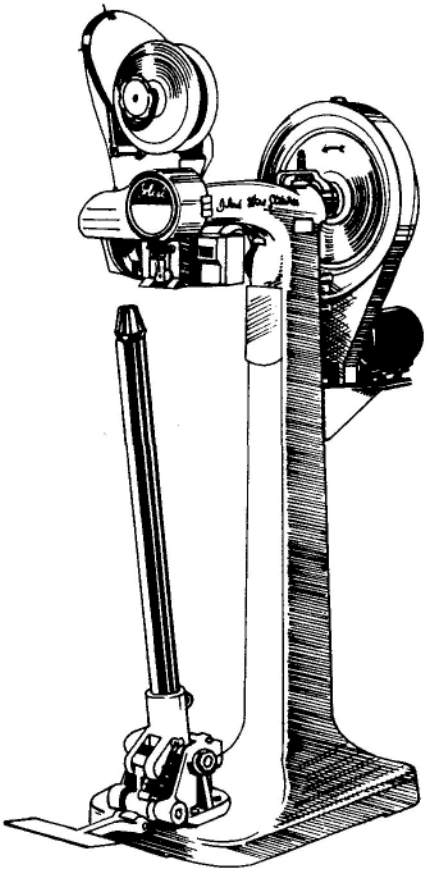
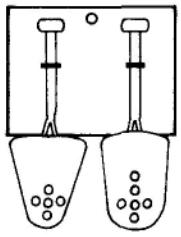
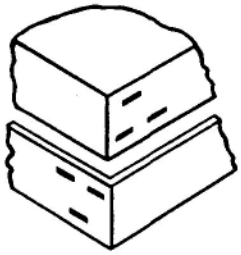
WIRE
STITCHERS

W. R. PABICH MFG. CO. INC.
2323 N. Knox Avenue, Chicago, IL 60639
Phone: 312/486-4141
TWX 910 221 5345
(Our answer back is "IDEAL SEAL CGO."
Our cable address outside of the U.S.,
Mexico and Canada is "IDEAL SEAL.")

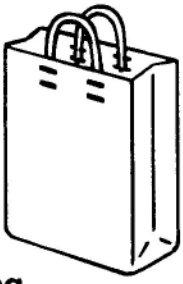




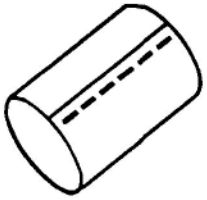
Carding Stitchers

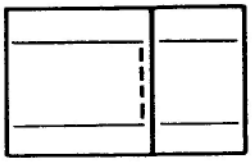


Arm Stitchers

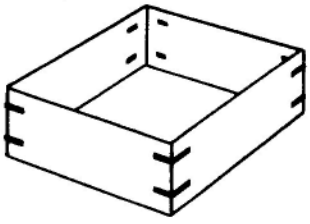


Bag Handle Stitchers



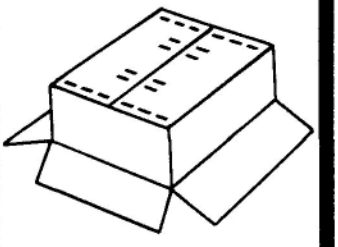


90° Angle Stitchers

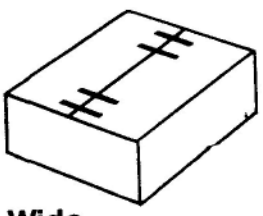


Corner Stitchers

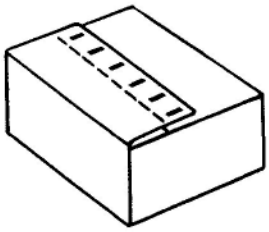
Custom designed stitchers



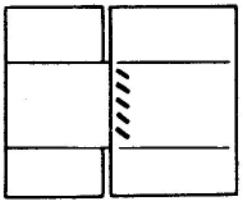
Bottom Stitchers



Wide Crown Stitchers



Top Stitchers



45° Angle Stitchers