NEW JERSEY
WIRE STITCHING MACHINE
DIVISION OF PRECISION AUTOMATION CO., INC.

Model L Operating Instructions & Parts List

1841 Old Cuthbert Rd.
Cherry Hill, NJ 08034
Tel: 856-365-0196
Fax: 856-365-0197

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 overlubricate 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.

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Before attempting to operate the machine, remove the rust preventitive, 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.

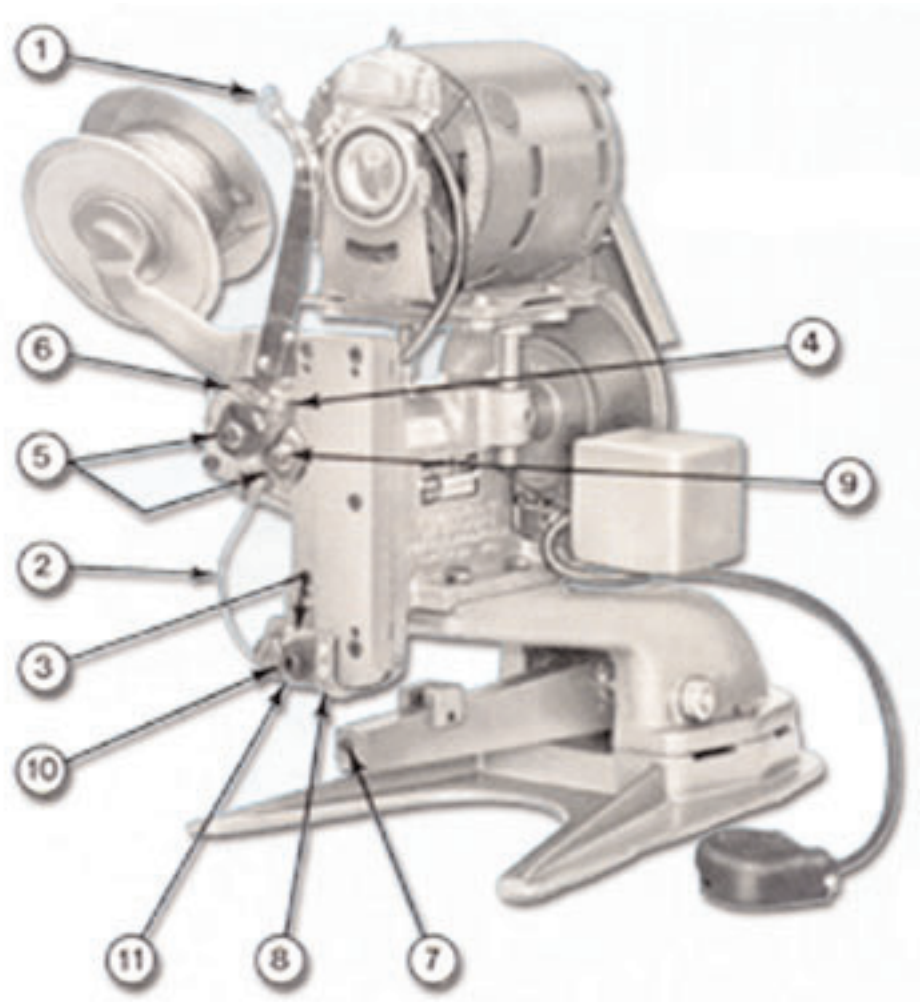
Step on the foot pedal and turn the machine over manually by means of the large pulley in the rear. The machine must turn freely.

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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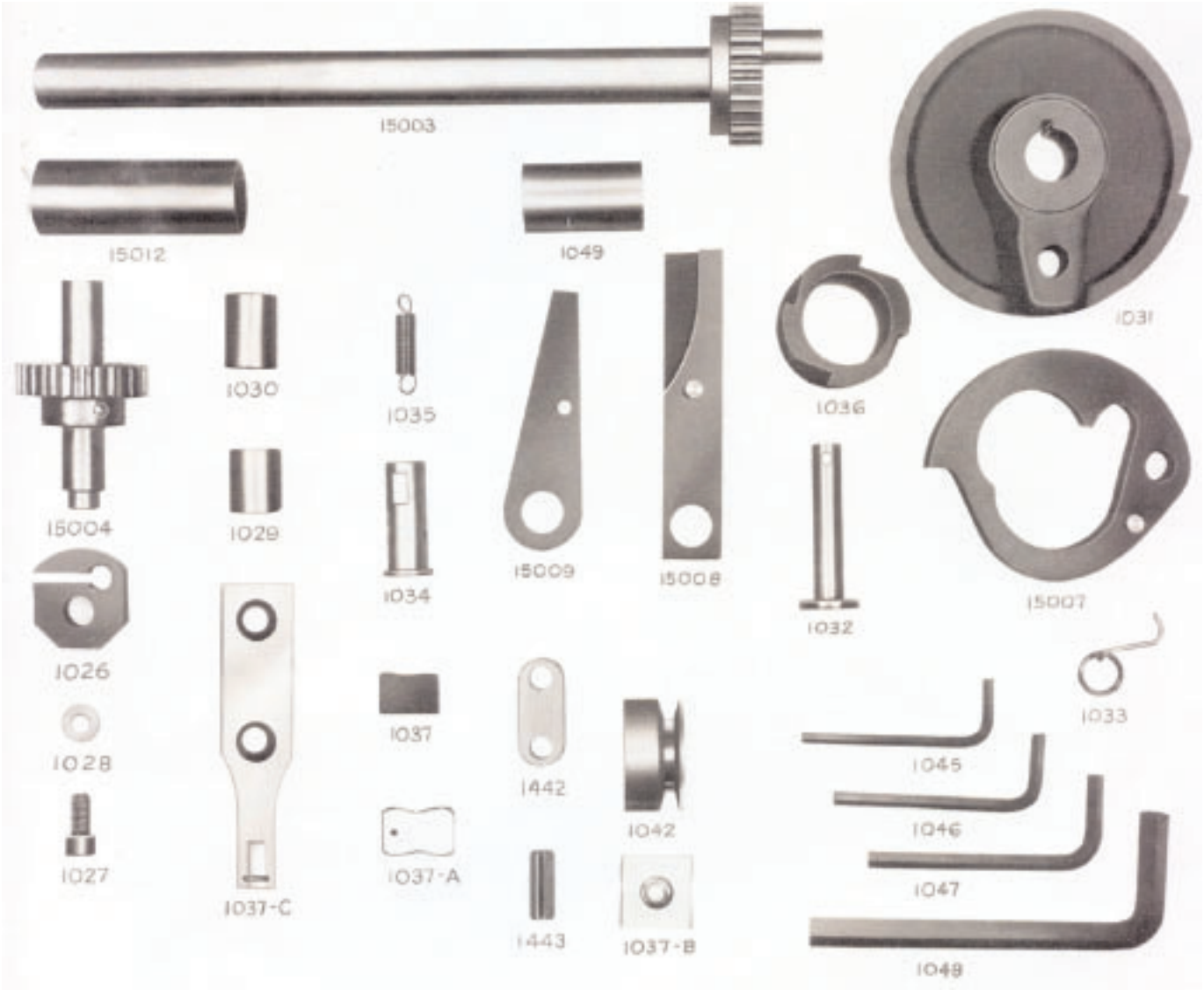
NO.	NAME
1002	Former Guide Plate
1003	Former & Driver Link
1004-1	Former Cutter 1/16 thk.
1004-2	Former Cutter 1/8 thk.
1004-3	Former Cutter 3/16 thk.
1004-4	Former Cutter 1/4/ thk.
1005	Stationary Cutter
1006	Stationary Cutter Clamp
1007	Stationary Cutter Clamp Screw
1008	Stationary Cutter Clamp Washer
1009	Driver
1010	Driver Shoe Pin
1011	Anvil & Supporter
1012	Anvil & Supporter Pivot Pin
1013	Anvil & Supporter Plunger
1014	Anvil & Supporter Plunger Spring
1015	Anvil & Supporter Stop

NO.	NAME
1016	Wire Check Body
1017	Wire Check Pawl
1018	Wire Check Body Screw
1019	Wire Check Pawl Screw
1020	Wire Check Spring
1021	Wire Tube
1022	Wire Tube Adjusting Screw
1023	Wire Tube Clamp Screw
1024	Wire Tube Clamp Screw Nut
1025	Wire Tube Clamp Screw Washer
1026	Feed Roll
1027	Feed Roll Clamp Screw
1028	Feed Roll Clamp Washer
1029	Feed Roll Shaft Bushing Front
1030	Feed Roll Shaft Bushing Rear
1031	Clutch Disc
1032	Clutch Ring Pin



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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" lg. 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