

DELUXE STITCHER

C O M P A N Y I N C .

Machine Serial Number : _____

Head Serial Number : _____

Date Purchased : _____

Model M30 Stitchers

OPERATION AND MAINTENANCE MANUAL

M30-BST Stitcher230V and 50HZ

Before using this Stitcher, all operators must study this manual and follow the safety warnings and instructions. Keep these instructions with the M30 Stitcher for future reference. If you have any questions, contact your local DeLuxe Stitcher Graphic Arts Representative or Distributor.

Specifications

Weight

Shipping Weight	700 lbs (318 kg)
Wire Spool	5 lbs. (2.3 kgs) or 10lbs. (2.6 kgs) optional
Foot Switch	4.5 lbs. (2.0 kgs)
Table	27 lbs. (12.3 kgs)

Physical Dimensions

Height	66.5" (168.9 cm)
Width	
With Table	30" (76.2 cm)
Without Table	22" (55.9 cm)
Depth	30" (76.2 cm)

Stitching Capacity	Two Sheets to 1-1/4" (32 mm)
.....	at 20# paper stock (75 grams/meter ²)

Wire Types	20-25 Round and 20x24, 20x25
.....	21x25, 19x21-1/2 and
.....	18x20 Flat

Throat Depth

Flat or Saddle	20" (50.8 cm)
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Side Stops	9-30" (22.9 cm-76.2 cm)
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Power Requirements

M30-AST	115VAC 60 Hz
M30-BST	230VAC 50 Hz

Minimum Recommended Circuit Capacity

M30-AST	10.7 A
M30-BST	7.1 A

Always disconnect the power supply before making any adjustments or servicing the stitcher.



Recommended Wire Sizes (Figure 6)

The wire sizes that can be used on the M30 as well as recommended uses are listed below. Note that when size changes, several parts on the Head will have to be changed to accommodate the wire size change. Instructions for changing these parts are detailed later in this manual. Wire gauges smaller than the specific size for which the head is set can still be used, but the maximum capacity for the machine will not be reached. For example, if the Head is set for 19x21-1/2 gauge wire, it will still function properly with 20x24 gauge wire, but the stitching capacity will drop. Please refer to Figure 6 stitching capacities of different wire gauges.

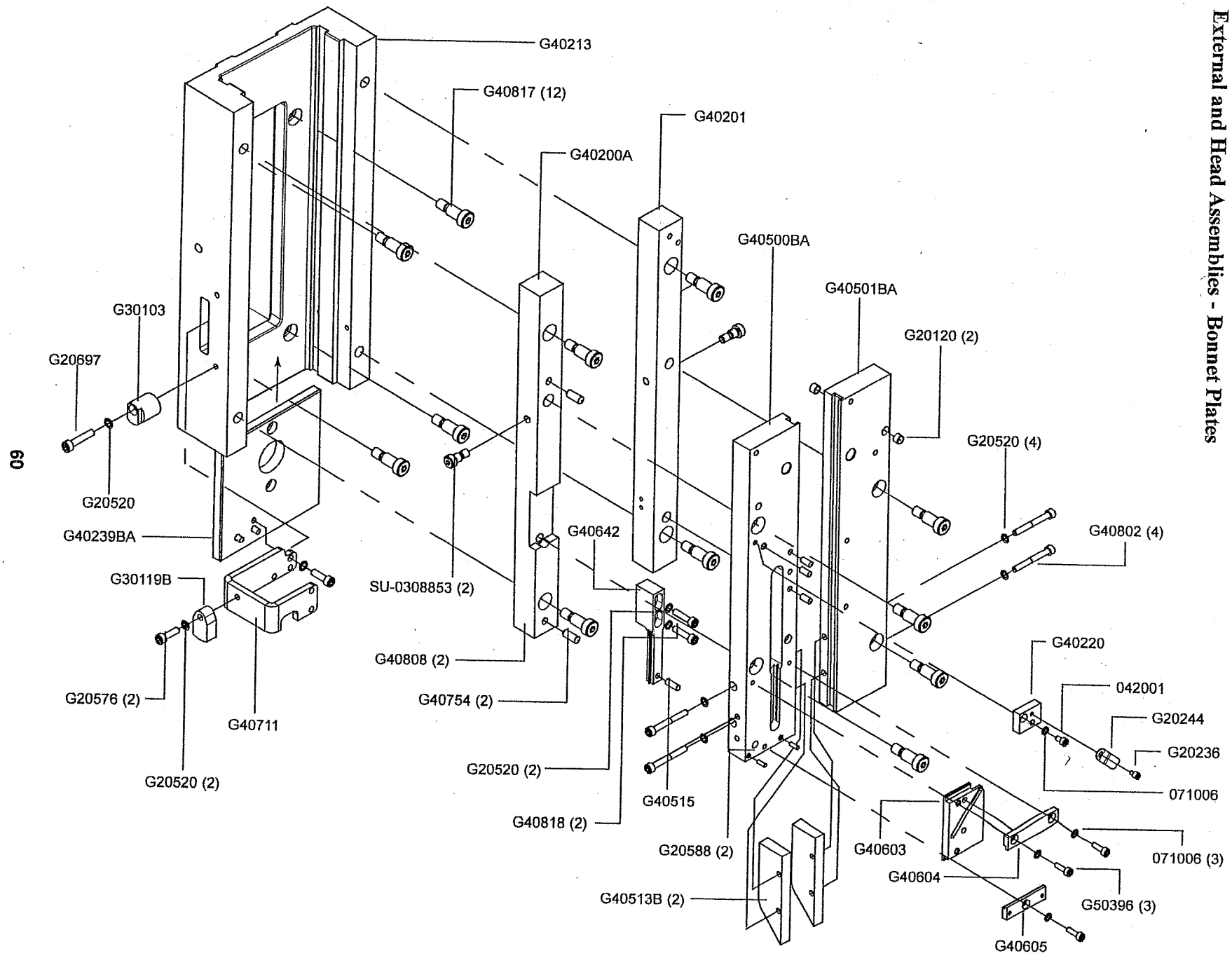
Two types of Clincher Points are available for the M30. When running round wire, use the Clincher Points with part number G40955R. For flat wire, use the Clincher Points with part number G40955F.

When stitching stock over 20# it is possible that high tensile wire will be required, which is available in 21x25, 20x24, 19x21-1/2, and 18x20 flat wire sizes. Note that high tensile wire may cause increased wear on certain parts. For any stock over 33# or coated, it is recommended that 19x20-1/2 or 18x20 flat wire be used. Refer to Figure 6 for a general overview of suggested wire sizes to use for specific stitch capacities.

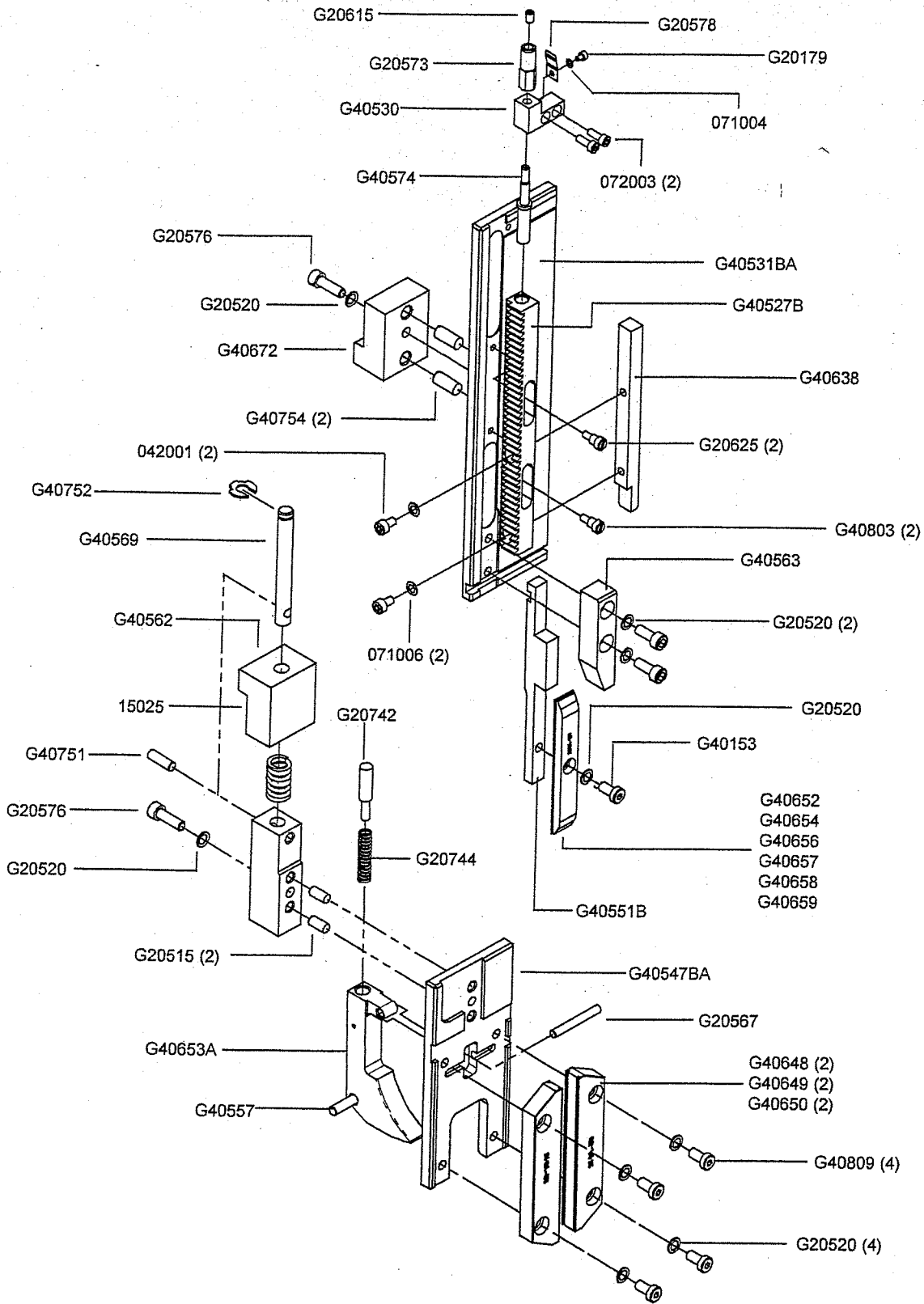
Wire Gauge	Type of Work	20# Stock
Install G40755R Clincher Points for:		
25 Round	Light Flat or Saddle	2-20 Sheets
24 Round	Light Flat or Saddle	2-30 Sheets
23 Round	Light Flat or Saddle	2-60 Sheets
21 Round	Medium Flat or Saddle	2- 80 Sheets
20 Round	Medium Flat or Saddle	20-100 Sheets
Install G40755F Clincher Points for:		
21 x 25 Flat	Medium Flat Only	Over 50 Sheets 1/4"- 3/8"
20 x 25 Flat	Heavy Flat Only	Over 50 Sheets 1/4"- 1/2"
20 x 24 Flat	Heavy Flat Only	Over 50 Sheets 1/4"- 3/4"
19 x 21 1/2 Flat	Heavy Flat Only	1/2"- 7/8" and Heavy Paper
18 x 20 Flat	Heavy Flat Only	7/8"- 1-1/4" and Heavy Paper

Figure 6 - Recommended Wire Sizes

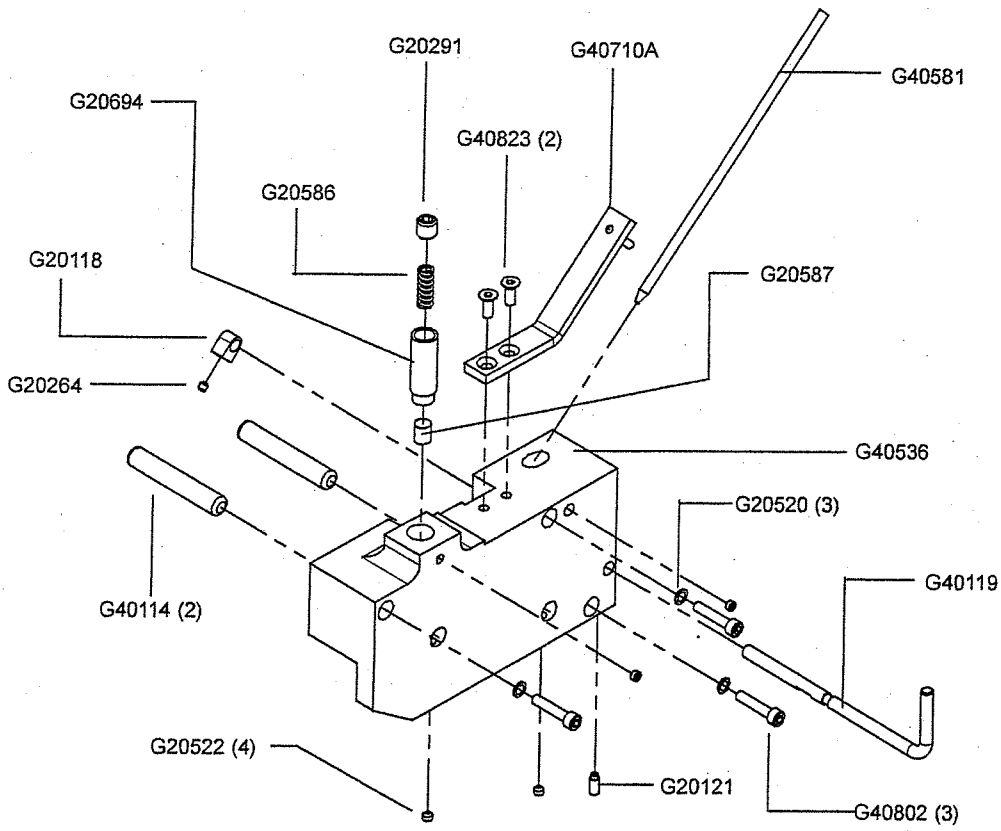
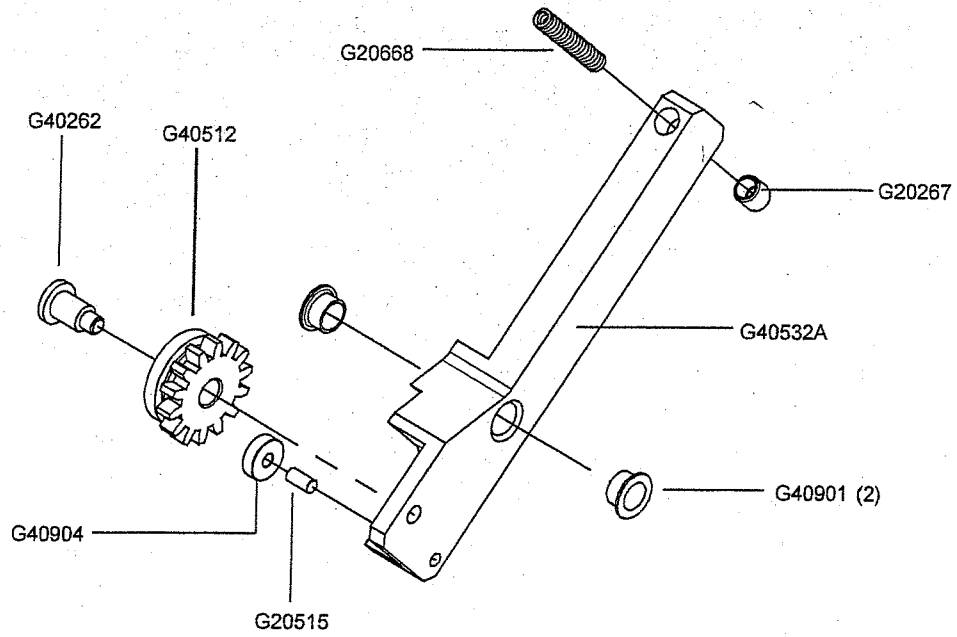
External and Head Assemblies - Bonnet Plates



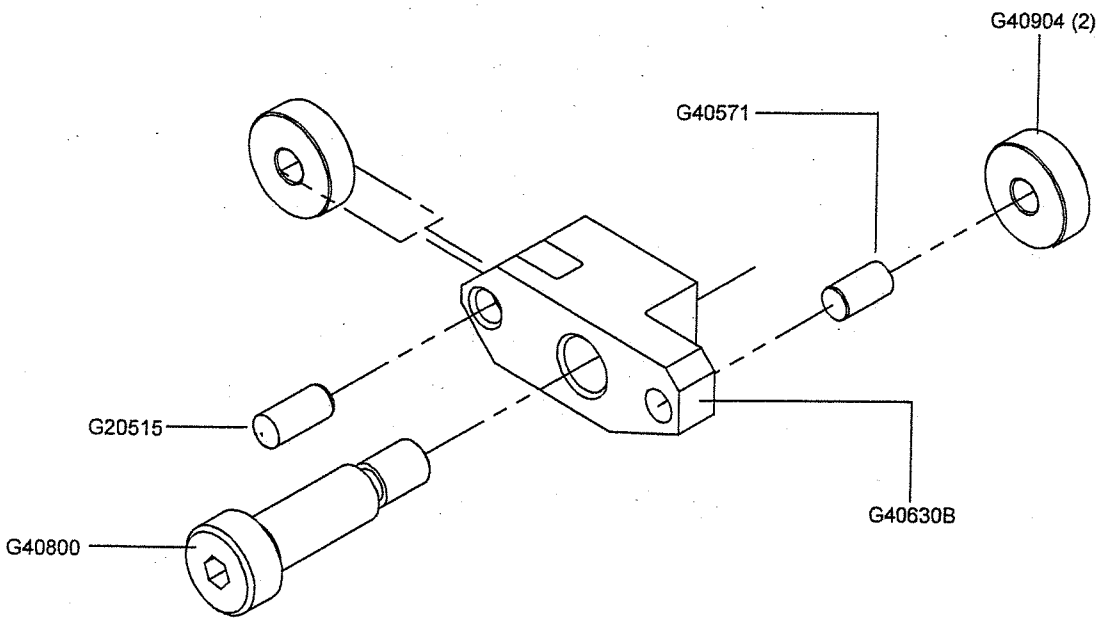
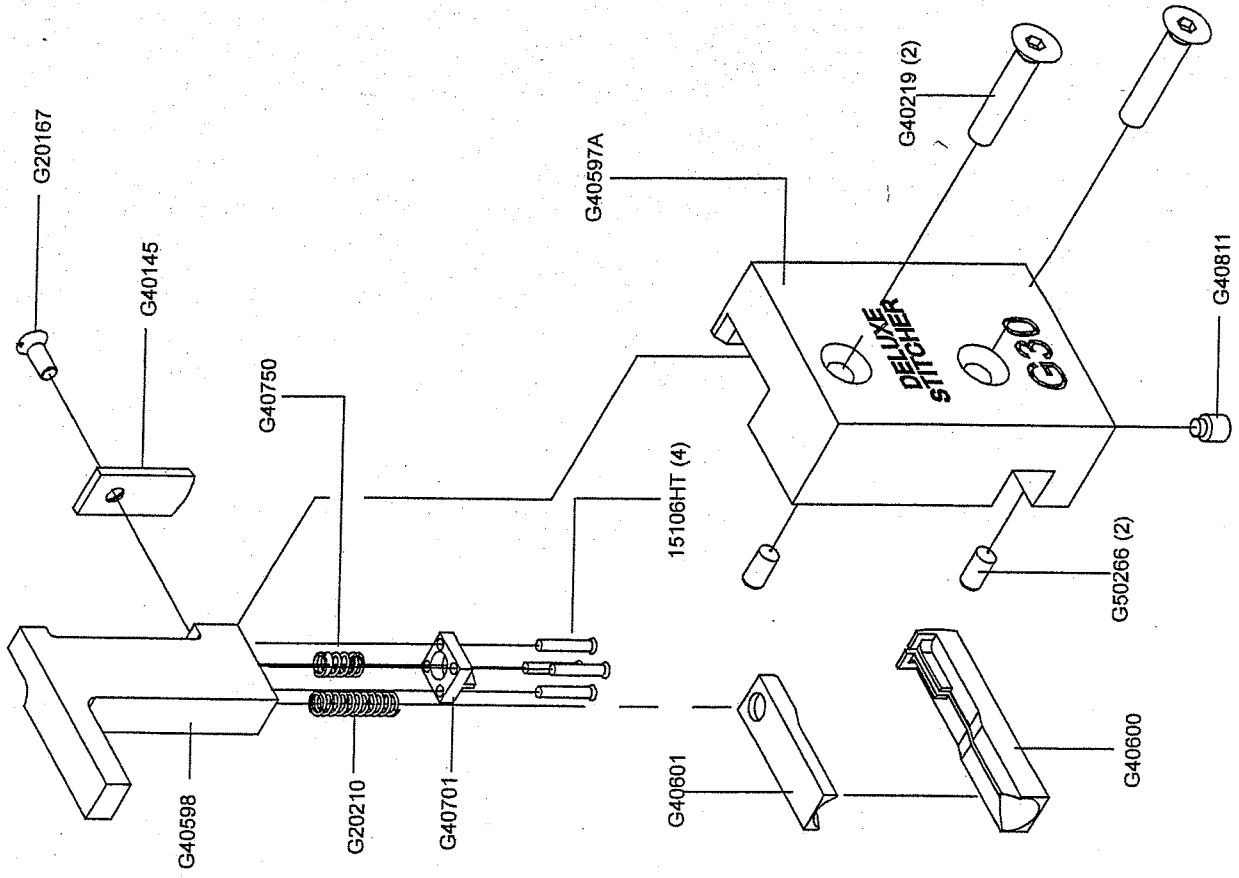
External and Head Assemblies - Feed Slide and Bender Bar



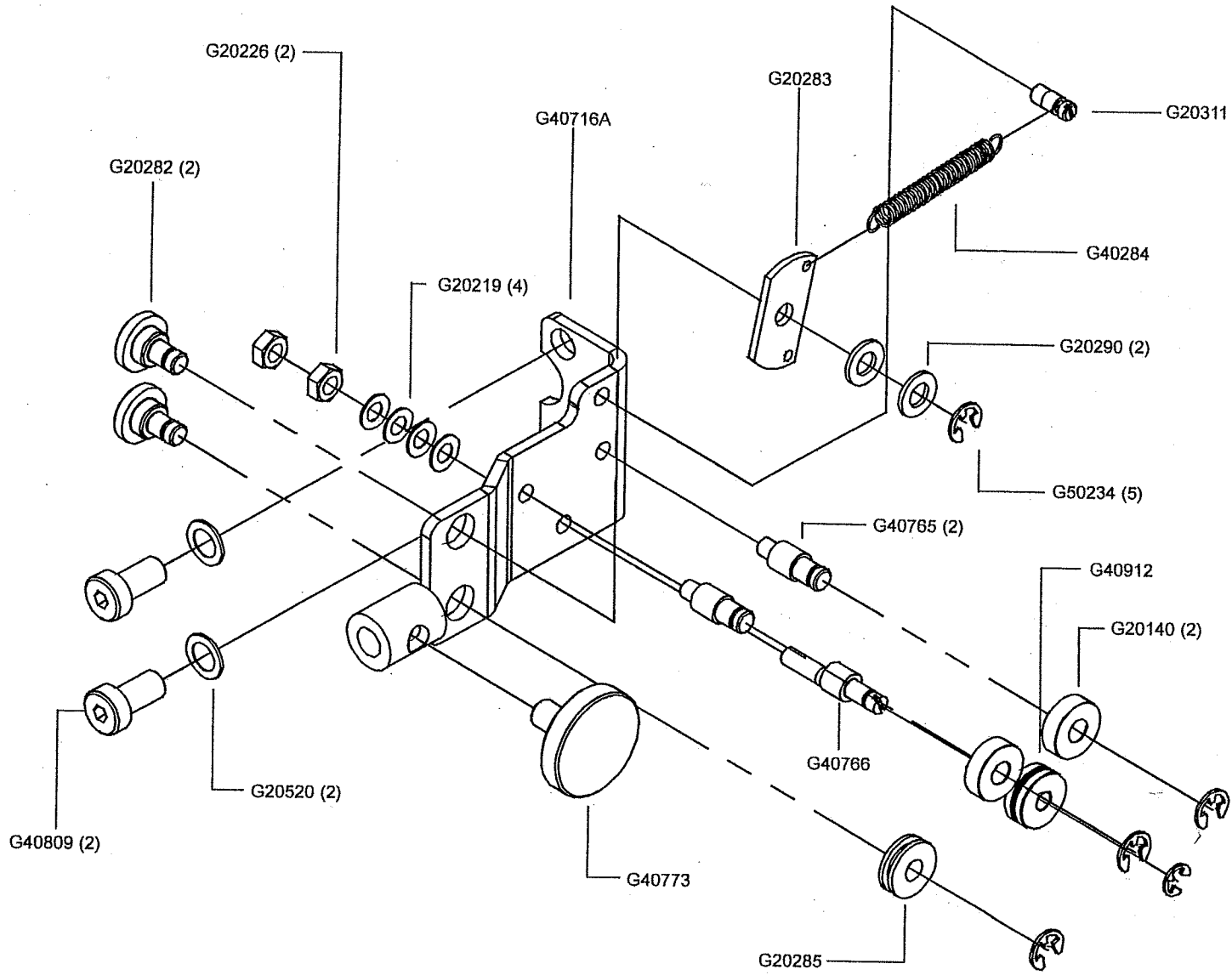
External and Head Assemblies - Feed Lever & Feed Gear Bracket



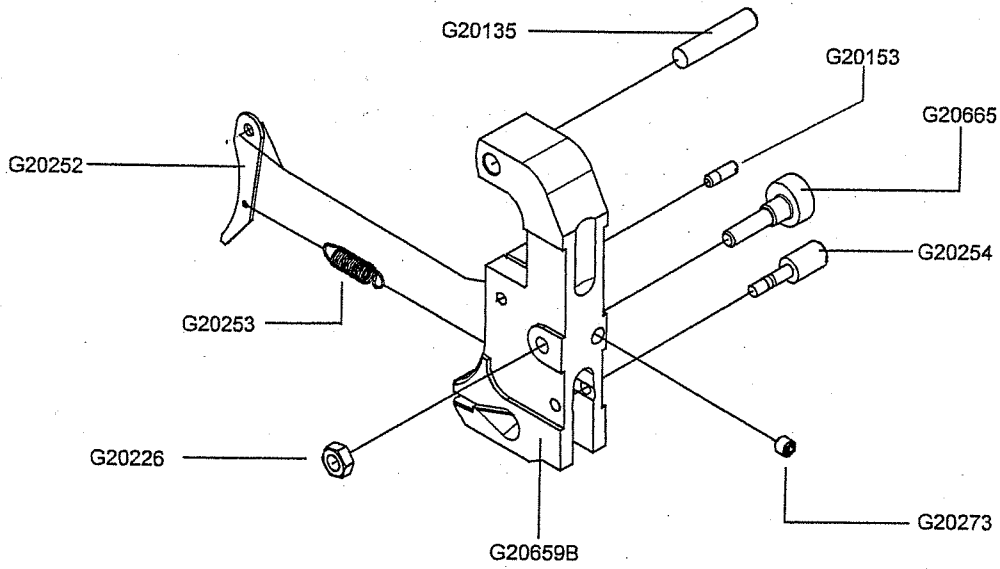
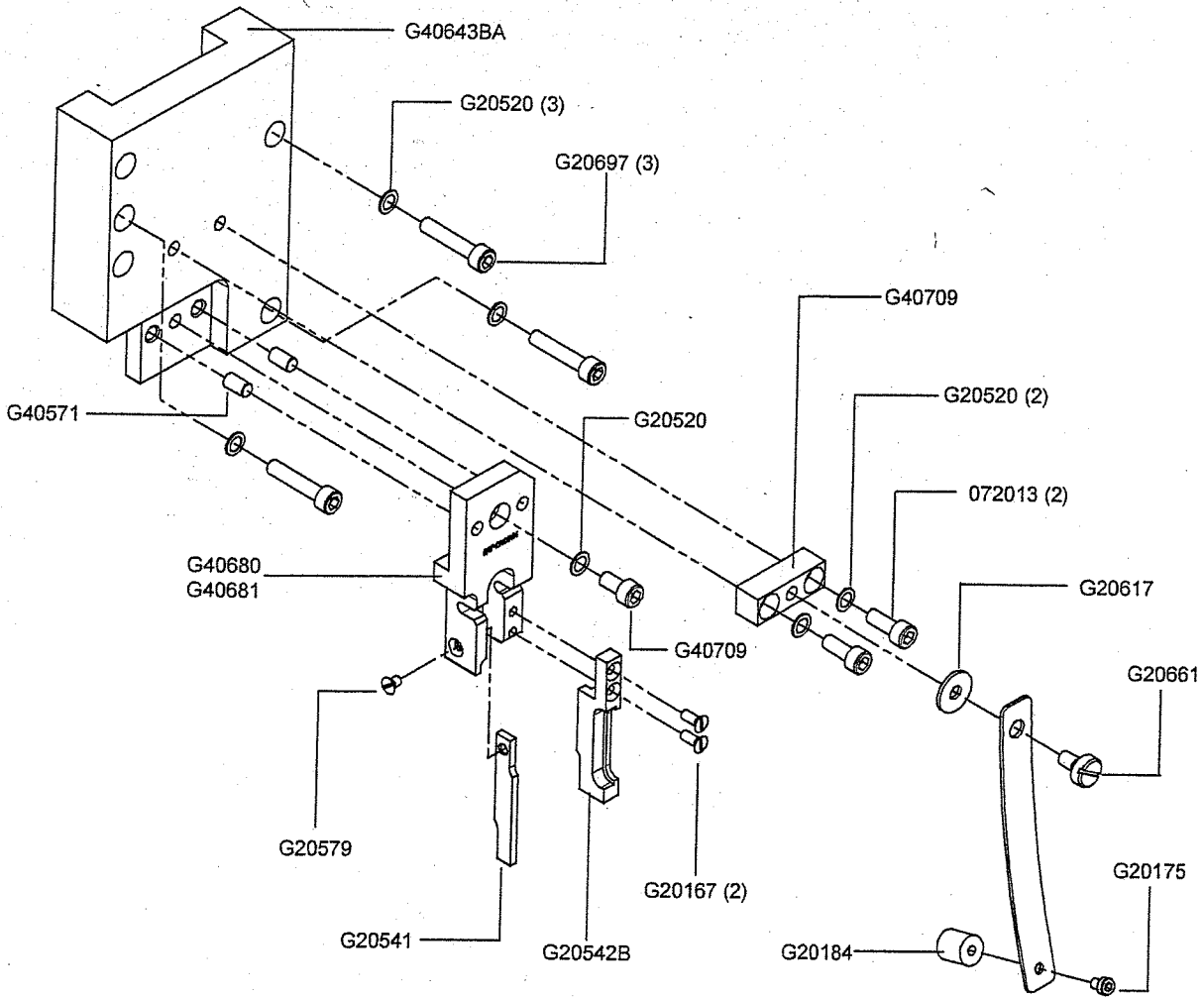
External and Head Assemblies - Cutter Box & Cutter Operating Lever



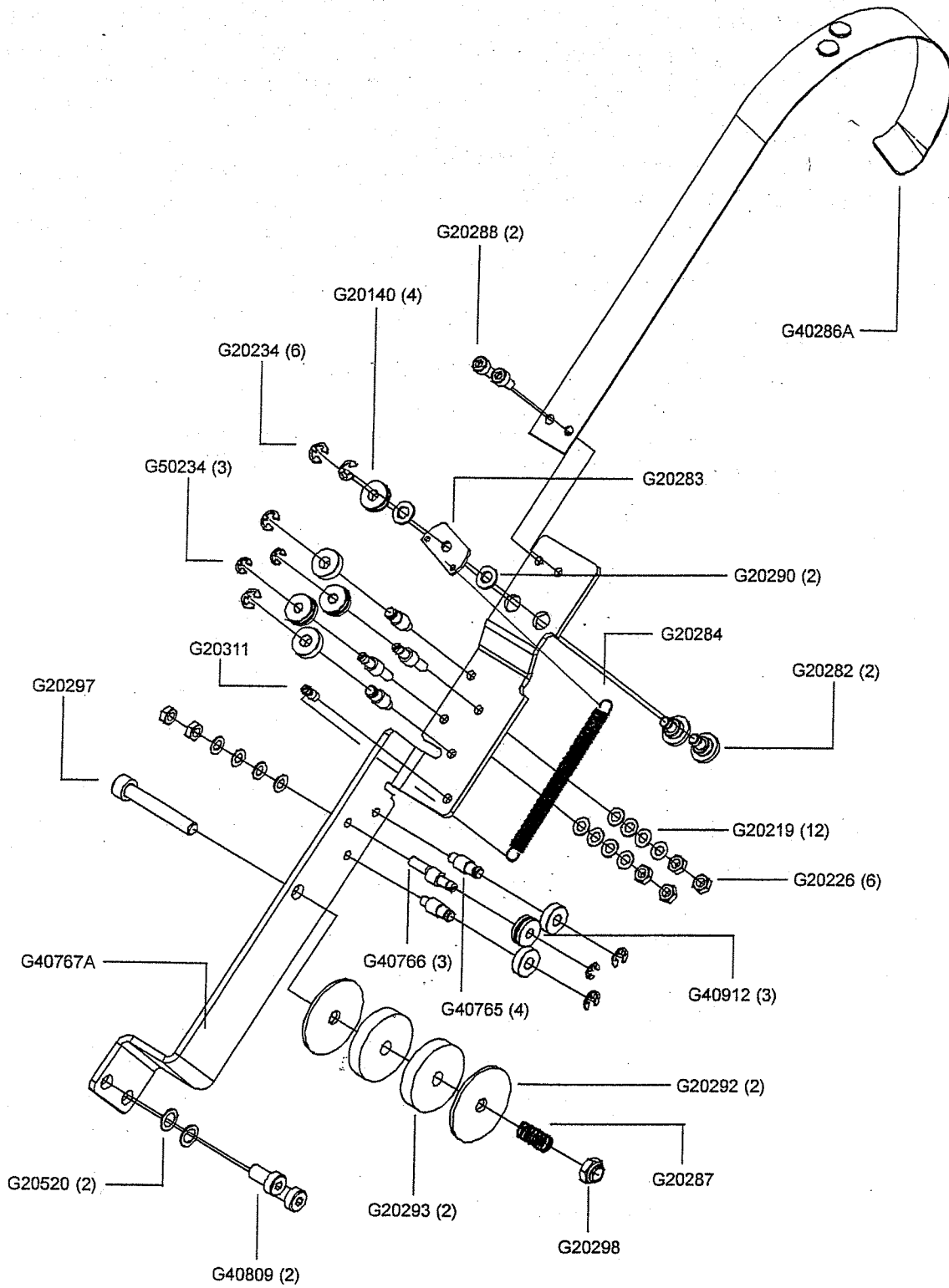
External and Head Assemblies - Lower Wire Straightener



External and Head Assemblies - Pivot Block & Wire Holder



External and Head Assemblies - Wire Guide Spring



Part Number / Description Cross-Reference

PART NO.	DESCRIPTION	QUANTITY	PART NO.	DESCRIPTION	QUANTITY
042001	Screw M5x.8x8	3	85982	Lock Nut 1/2	1-2
071004	Lock Washer Ribbed	2	86243	Power Cord - 115V	1
071005	Lock Washer Ribbed M4	2	88038	Nylon Cable Clamp	1
071006	Lock Washer Ribbed M5	6	9070	Wire Straightener Eccentric Pointer	1
072003	Screw M4x0.7x12	2	AF203	Lock Washer 5/16 Hel	2
072004	Screw M6x1.0x12	1	AF207	Lock Washer 1/2 Helical Spring	1
072006	Screw M6x1.0x30	2	AF223	Flat Washer 5/16	4
072012	Screw M6x1.0x20	2	B554	Torsion Spring	2
072013	Screw M6x1.0x22	2	FC9633	Anchor Spacer	1
18183	Clincher Slide Adjustment Block	1	FC9656A	Clutch Anchor	1
18184	Clincher Slide Block Clamp	1	G20118	Feed Release Handle Cam	1
18186	Clincher Slide Adjustment Screw	1	G20121	Feed Release Plunger	1
19211/2G5	Wire Spool - Galvanized	1	G20135	Dowel Pin M5x24	1
35	Clincher Slide Link Spring	1	G20140	Follower Ball Bearing	4
36	Pin	1	G20153	Driver Retaining Screw	1
406	Clincher Operating Lever Spring Screw	1	G20167	Screw M4x.7x10	3
63	Work Guide Screw	2	G20171	Screw M8x1.25x12	2
7423C	Work Stop - Large	2	G20175	Screw M4x.7x6, with Nylon Patch	1
7645A	Table Support Bracket Asy - RH	1	G20179	Screw M3x.5x4	1
7645LA	Table Support Bracket Asy - LH	1	G20184	Wire Holder Retaining Spring Foot	1
7648	Table Support	2	G20190	Screw M3x.5x10	2
7675	Belt Guard	1	G20195	Screw M6x1.0x8	4
7676	Belt Guard	1	G20210	Cutter Operating Spring	1
7678B	Drive Pulley - 4L	1	G20219	Wire Straightener Disc Spring	8
7679	Drive Pulley Washer	2	G20226	Hex Nut M4x.7	4
7690	Tension Spring	1	G20234	E-Ring 3/16	4
7691	Set Collar - Reamed	1	G20236	Tube Pivot Screw	1
7693	Spool Stud	1	G20244	Tube Pivot Clip	1
850303B	Terminal Strip - Holes	1	G20250	Screw M4x.7x14	2
850307	Power Cord - 230V	1	G20252	Wire Hook	1
850313	Footswitch Guard	1	G20253	Wire Hook Spring	1
850314	Strain Relief	2-3	G20254	Wire Hook Spring Screw	1
850315	Strain Relief Nut	2-3	G20267	Feed Lever Bushing	1
850316	RFI Filter	1	G20273	Screw M4x.7x4, with Nylon Patch	1
850318	Footswitch, Wired	1	G20274	Hex Jam Nut, M6x1	2
850319B	Safety Switch, Wired	1	G20282	Tension Pawl Pivot Pin	2
850322BA	Starter Assembly 3/4 - 115V	1	G20283	Tension Pawl	1
850323BA	Starter Assembly 3/4 - 230V	1	G20284	Tension Pawl Spring	1
850337	Wire Terminal Ring	1	G20285	Tension Pawl Roller	1
850344A	Motor 3/4 HP - 115V	1	G20286A	Wire Guide Spring Assembly - Long	1
850344B	Motor 3/4 HP - 230V	1	G20287	Wire Oiler Felt Spring	1
850674	Electric Clutch - 230V	1	G20288	Screw M4x0.7x8	2
850677	Electric Clutch, Heavy Duty - 115V	1	G20290	Flat Washer, M5	2
850730C	V-Belt	1	G20292	Wire Oil Felt Washer	2
850731	Pulley	1	G20293	Wire Oiler Felt	2
850732	Pulley	1	G20297	Screw M6x1.0x40	1
851005	Strain Relief	1	G20298	Nylock Lock Nut, M6x1	1
85128	Connector 3/8	3			

Part Number / Description Cross-Reference

PART NO.	DESCRIPTION	QUANTITY	PART NO.	DESCRIPTION	QUANTITY
G20311	Spring Anchor Screw	1	G30118	Belt Guard Bracket	1
G20360	Hex Key Wrench 3.0mm	1	G30119B	Adjuster Gauge	1
G20364	Open End Wrench	1	G30124	Actuator Key Bracket	1
G20368	Feed Release Handle Cap	1	G30127	Starter Mounting Flange	1
G20515	Dowel Pin M6x14	3	G30128	Hand Wheel	1
G20520	Ribbed Lock Washer M6	45	G30159	Screw 1/2-20x1-1/4	2
G20522	Screw M6x1.0x5	7	G30163	Self Tapping Screw	1
G20530	Feed Rack Block	1	G30176	Screw M4x.7x25	2
G20541	Wire Guide Bar - Left	1	G30183	Self Tapping Screw	2
G20542B	Wire Guide Bar - Right	1	G30415	Tool Kit Hanger	1
G20566	Screw M4x0.7x20	4	G40013A	Pivot Arm Assembly	1
G20567	Dowel Pin M5x40	2	G40017A	Crank Housing Connecting Link Assy	1
G20570	Spirol Pin M5x20	1	G40037A	Clincher Upright Link Assembly	1
G20573	Feed Rack Adjustment Knob	1	G40043A	Clincher Lever Assembly	1
G20574	Feed Rack Adjustment Stud	1	G40044	Clincher Mounting Plate	1
G20576	Screw M6x1.0x20	11	G40100	Adjuster Crank Shaft Insert	1
G20578	Rack Adjustment Knob Detent	1	G40101	Compression Adjustment Yoke	1
G20579	Screw M4x0.7x6	1	G40102	Adjustment Shaft	1
G20583	Wire Holder Retaining Spring	1	G40114	Feed Gear Shaft	2
G20586	Feed Gear Friction Spring	1	G40119	Feed Release Handle	1
G20587	Feed Gear Friction Plug	1	G40128	Rear Feed Gear Spacer	1
G20588	Dowel Pin M4x12	2			
G20589	Screw M4x0.7x10	1	G40129	Large Feed Gear Washer	2
G20615	Screw M5x0.8x8	1	G40135	Head Guard	1
G20617	Washer M6x18x1.6	1	G40145	Moving Cutter	1
G20625	Feed Rack Guide Screw, Nylon	2	G40153	Driver Retaining Screw	1
G20626	Screw M4x0.7x16	2	G40174	Small Clincher Arm Spacer	1
G20659BA	Wire Holder Assembly 5/8	1	G40200A	Mounting Bar Assembly - Left	1
G20661	Wire Holder Retaining Spring Screw	1	G40201	Mounting Bar - Right	1
G20665	Wire Holder Eccentric Screw	1	G40202	Upper Bearing Block - Horizontal	1
G20668	Feed Lever Spring	1	G40203A	Upper Bearing Block Assy - Vertical	1
G20691	Screw M12x1.75x12	1	G40207A	Adjustment Shaft Block Assembly	1
G20694	Feed Gear Friction Bushing	1	G40208A	Adjustment Shaft Support Brkt Assy	1
G20697	Screw M6x1.0x30	5	G40211	Bender Rail	1
G20742	Supporter Plunger	1	G40212	Driving Rail	1
G20744	Supporter Spring	1	G40213	Head Mounting Block	1
G30002	Side Cover Plate - Left	1	G40219	Screw M6x1.0x30	2
G30006A	Bearing Housing Assembly	1	G40220	Spring Clip Block	1
G30007B	Crank Shaft	1	G40231	Upper Gear Shaft	1
G30048	Motor Mounting Plate	1	G40235A	Bender Cam Plate Assembly	1
G30053	Bearing 1/2x1/2	6	G40236A	Driver Cam Plate Assembly	1
G30054	Bearing 5/8x3/4	1	G40237	Crank Pin	1
G30063	Shoulder Screw 5/8x1	1	G40238	Crank Arm	1
G30064	Shoulder Screw 3/4x1-1/4	1	G40239BA	Crank Housing Slide Plate Assembly	1
G30067	Bolt 3/8-16x1	4	G40240A	Crank Housing Assembly	1
G30099B	Adjustment Crank Housing	1	G40242	Head Drive Shaft	1
G30103	Adjuster Stop	2	G40262	Small Feed Gear Shaft	1
G30117B	Motor Cover	1	G40284	Lower Tension Pawl Spring	1

Part Number / Description Cross-Reference

PART NO.	DESCRIPTION	QUANTITY	PART NO.	DESCRIPTION	QUANTITY
G40301	Drive Cam Gear	1	G40701	Wire Hold	1
G40302	Drive Gear	3	G40702	Large Clincher Arm Spacer	1
G40402	Screw M5x0.8x16	3	G40703	Cam Follower Stud	1
G40500BA	Bonnet Plate Assembly - Left	1	G40704	Lower Bearing Block	1
G40501BA	Bonnet Plate Assembly - Right	1	G40705	Vertical Drive Shaft	2
G40510A	Large Feed Gear Assembly	1	G40708	Bearing Mounting Plate	1
G40511A	Wire Feed Pinion Assembly	1	G40709	Wire Holder Spring Block	1
G40512	Small Feed Gear	1	G40710A	Feed Lever Spring Bracket Assembly	1
G40513B	Supporter Guide Plate	2	G40711	Cutter Box Adjustment Link	1
G40515	Dowel Pin M6x18	1	G40716A	Lower Wire Straightener Bracket	1
G40520	Wire Spool Mounting Bracket	1	G40716AA	Lower Wire Straight Brkt, Complete	1
G40527	Feed Rack	1	G40750	Wire Hold Spring	1
G40531BA	Feed Slide Assembly	1	G40751	Dowel Pin M6x20	1
G40532A	Feed Lever Assembly	1	G40752	E-Ring - Heavy Duty	1
G40536	Feed Gear Bracket	1	G40753	Lock Collar	2
G40537	Feed Gear Clutch	1	G40754	Dowel Pin M8x20	2
G40547BA	Bender Bar Assembly	1	G40755	Clincher Pad Guide Shaft	2
G40551B	Driver Bar	1	G40756	Spring Pin M4x24	1
G40557	Dowel Pin M6x50	1	G40757	Dowel Pin M10x28	1
G40562	Bender Slide Block	1	G40758	E-Ring 12mm	1
G40563	Cutter Operating Cam	1	G40759	Keyway - 8mm x 1/2	1
G40564A	Bender Slide Pin Block Assembly	1	G40760	Keyway - 6mm x 3/4	2
G40569	Bender Slide Pin	1	G40761	Keyway - 6mm x 1-1/2	3
G40571	Dowel Pin M6x12	1	G40763	Keyway - 8mm x 3/4	1
G40581	Upper Wire Tube	1	G40764	E-Ring 1/2	3
G40597A	Cutter Block Assembly	1	G40765	Wire Straightener Roll Stud	4
G40598A	Cutter Operating Slide Assembly	1	G40766	Straightener Eccentric	3
G40599A	Lower Wire Tube Assembly	1	G40767A	Upper Wire Straightener Brkt Asy	1
G40600	Fixed Wire Cutter	1	G40767AA	Upper Wire Straight Brkt - Complete	1
G40601	Fixed Cutter Cover	1	G40768	Clevis Pin 1/2x1-1/2	1
G40603	Cutter Box Guide Plate	1	G40769	Clevis Pin 1/2x2	2
G40604	Upper Cutter Box Guide Plate	1	G40770	Hitch Pin	3
G40605	Lower Cutter Box Guide Plate	1	G40771	Dowel Pin M4X10	2
G40630BA	Cutter Operating Lever Assembly	1	G40765	Wire Straightener Roll Stud	2
G40638	Feed Rack Cam	1	G40766	Straightener Eccentric	1
G40642	Cutter Box Adjustment Slide	1	G40773	Thumbscrew - Knurled	1
G40643BA	Wire Holder Pivot Block 5/8	1	G40800	Shoulder Screw M10x25	1
G40648	Bender Insert 5/8 - 20x24 & 23 Wire	2	G40802	Screw M6x1.0x50	7
G40649	Bender Insert 5/8 - 19x21-1/2 & 24 Wire	2	G40803	Screw M6x1.0x16	8
G40650	Bender Insert 5/8 - 18x20 & 20 Wire	2	G40804	Screw M8x1.25x16	27
G40652	Driver 5/8 - 24 Wire	1	G40808	Screw M6x1.0x12 - Dog Point	2
G40653BA	Supporter Assembly 5/8	1	G40809	Screw M6x1.0x12 - Low Head	10
G40654	Driver 5/8 - 23 Wire	1	G40810	Shoulder Screw	1
G40656	Driver 5/8 - 20x24 Wire	1	G40811	Screw M6x1.0x8 - Dog Point	8
G40657	Driver 5/8 - 19x21-1/2 Wire	1	G40812	Screw M8x1.25x16 - Low Head	1
G40658	Driver 5/8 - 20 Wire	1	G40813	Shoulder Screw	2
G40659	Driver 5/8 - 18x20 Wire	1	G40814	Shoulder Screw	1
G40672	Feed Slide Block	1	G40815	Screw M8x1.25x12	1

Part Number / Description Cross-Reference

PART NO.	DESCRIPTION	QUANTITY	PART NO.	DESCRIPTION	QUANTITY
G40816	Screw M8x1.25x25	2	M-TOOL KIT	Kit - M-Series Tool	1
G40817	Shoulder Screw M12x20	12	M11009	Plastic Washer	1
G40818	Screw M6x1.0x25	2	P2582	Connector 3/8x90 Degrees	3
G40820	Shoulder Screw M6x10	2	P2731	Thumb Screw 1/4-20x3/4	1
G40821	Screw 1/2-13x1	1	P7507	Screw 1/4-20x3/4	4
G40823	Screw M6x1.0x16	2	P7863	Retaining Ring	1
G40851	Lock Washer Ribbed M8	3	PG10219	Terminal 1/4x90.	5
G40901	Feed Lever Pivot Bearing	1	PG10271	Washer 9/16	1
G40902	Upper Drive Shaft Bearing	2	PW10	Washer	2
G40903	Worm Shaft Bearing	2	PW10.3	Flat Washer 3/16	5
			PW12.1	Washer Black 1/2	1
G40905	Clincher Cam Follower	1	PW12.4	Washer Black 1/2	4
G40906	Ball Bearing	1	PW14	Flat Washer	8
G40907	Drive Shaft Coupling	1	PW14.2	Washer Zinc	4
G40908	Crank Bushing	2	PW14.6	Washer	4
G40909	Head Drive Shaft Bearing	1	PW38	Washer	5
G40911A	U-Joint & Splined Shaft Assembly	1	SU-0308853	Screw 3/8X3/8	2
G40912	Grooved Straightener Roller	2	SW14.1	Lock Washer	3
G40950AA	Clincher Pad Assembly	1	SW516.3	C'Sunk Lock Washer	1
G40952A	Clincher Back Plate Assembly	1	UA1428.1	Set Screw 1/4-28X1/4	3
G40954	Clincher Front Plate	1	UA3216.2	Clincher Slide Block Screw	2
G40955F	Clincher Point - Flat	2	UA3806.2	Screw 10-32x3/8	2
G40955R	Clincher Point - Round	2	UA3806.9	Screw 10-32x3/8	3
G40956A	Clincher Base Assembly	1	UA3808.2	Screw 10-32x1/2	2
G40957	Clincher Adjustment Shaft	1	UA3810.10	Shoulder Screw 1/4x5/8	2
G40958	Clincher Adjustment Worm Gear	1	UA4810.1	Screw 1/4-20x5/8	3
G40959	Clincher Height Adjust Handle	1	UA4812.7	Screw 1/4-20x3/4	3
G40960	Worm Shaft	1	UA4828.3	Set Screw - Cup Point	4
G40961	Clincher Adjusting Worm	1	UA5112.1	Screw 5/16-18x3/4	1
G40962	Table Pivot Shaft	1	UA5120.2	Screw 5/16-18x1-1/4	2
G40964A	Work Table Assembly	1	UA5812.7	Screw 5/16-18x3/4	2
G40973	Work Guide	1	UA6112.1	Screw 3/8-16x3/4	4
G40975	Clincher Upright Extension	1	UA6116.1	Screw 3/8-16x1	4
G40976	Clincher Slide	1	UA8164	Screw 1/2-13x4	1
G50125	Screw M5x0.8x20	3			
G50234	E-Ring 4mm	2			
G50266	Dowel M5x10	2			
G50396	Screw M5x.8x12	3			
HN1024	Nut 10-24	2			
HN1213.2	Hex Jam Nut 1/2-13	2			
HN1420.2	Hex Jam Nut 1/4-20	4			
HN3816	Hex Nut 3/8-16	1			
HN51618	Hex Nut 5/16-18	1			
HN51618.2	Hex Jam Nut 5/16-18	2			
KN1032	Kep Nut 10-32	2			
KN1420	Kep Nut 1/4	1			
LW14	Lock Washer	4			
LW38	Lock Washer	9			