

**ISP** Stitching & Bindery Products

OWNERS  
MANUAL



**ISP** Stitching & Bindery Products

Model B2000

# *Stitch'n Fold*

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## INTRODUCTION

Simple Operation: Just load your booklet and it is automatically jogged, stitched, folded, and discharged onto an accumulating output conveyor. Side stitching, corner stitching, and folding projects, with or without stitching, are easily accomplished.

Advanced Technology: *Stitch'n Fold* uses ISP's patented magnetic stitching head technology, providing the reliability and economy of wire stitching. Dual sets of folding rollers assure consistent, professional results. For safety, interlocked access guards prevent machine operation when open.

Improved Productivity: With *Stitch'n Fold*, you can jog, stitch, and fold more than 65,000 booklets at a maximum speed of 2,300 finished booklets per hour - without stopping to reload staples. *Stitch 'n Fold's* variable work thickness capacity handles from 2 sheets to a one hundred page booklet with no setup changes or adjustments.

Lower Operating Costs: The *Stitch'n Fold* replaces expensive preformed staples with inexpensive bookbinding wire; you save on material costs and nonproductive downtime.

## SPECIFICATIONS - MODEL: B2000

Unit Weight:	235 Pounds
Speed:	Up to 2,300 booklets per hour (any size)
Capacity:	2 to 25 sheets of 20# bond (100 page book)
Re-load:	65,000 booklets per spool of wire
Paper Size:	Min. 4.75" x 8.5"    Max. 12.5" x 18"    (also: A5 to A3)
Booklets:	4.25" x 5.5", 5.5" x 8.5", 8.5" x 11", 4.75" x 4.75 "CD", & metric sizes (All booklets with or without trim stock on one or three sides)
Stitch Space:	5.5" on 8.5" or 11" tall books    2.75" on 5.5" tall books
Counter:	Resettable 6-digit electronic counter
Folder:	Knife folder with dual folding rollers
Squaring:	Side jog plus full length tape feed
Output:	Continuous conveyor
Footprint:	16.25" x 22.5"
Dimensions:	Height 25"    Width 21"    Depth 52"
Modes:	Stitch and Fold, Stitch, Fold, Corner Stitch, Side Stitch
Electrical:	Standard outlet - 115 Volts, 60 Hz, 10 Amps    (1/4 HP)

# Stitch'n Fold

## SAFETY

### SAFETY PRECAUTIONS AND PROCEDURES

1. Make sure electrical power is turned off before performing any adjustment or maintenance.
2. Keep hands, hair, tools, 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. 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.
5. See "SAFETY GUARDS" below! If you are unsure how to safely operate your Bookletmaker, contact your Service Representative.



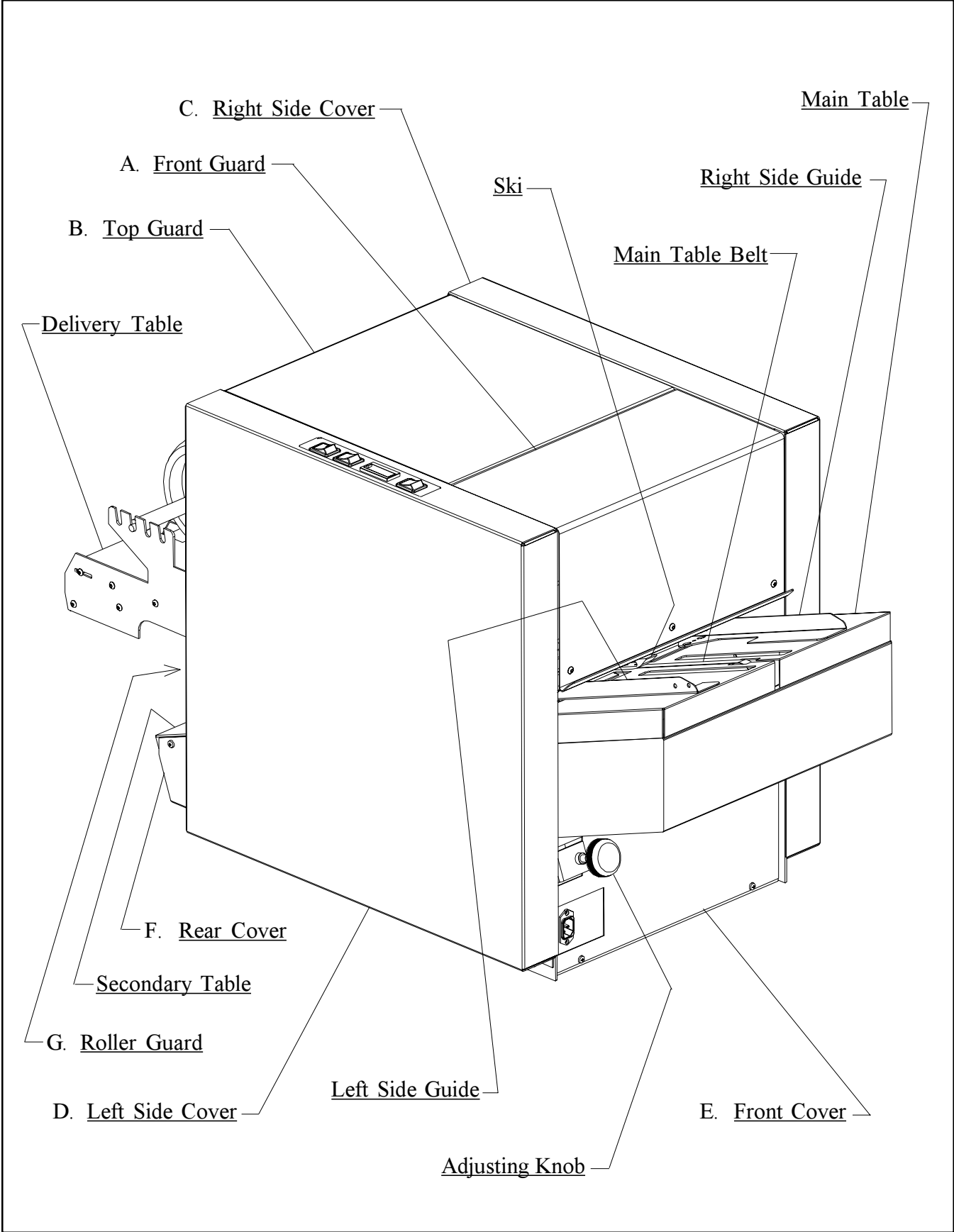
**KEEP HANDS CLEAR OF STITCHING AREA AND ANY MOVING PARTS!**

**NEVER OPERATE MACHINE WITHOUT ALL GUARDS IN PLACE!**

### SAFETY GUARDS

- A. Front Guard: Blocks access to the stitching heads and their point of operation. An electrical interlock keeps the machine turned off unless this hinged guard is closed. Do not stick your fingers under the front guard!
- B. Top Guard: Blocks access to mechanism that drives the stitching heads. An electrical interlock keeps the machine turned off unless this guard is closed. Do not stick your fingers under the top guard!
- C. Right Side Cover: Blocks access to mechanisms that can pinch or cut.
- D. Left Side Cover: Blocks access to dangerous electric voltage and mechanisms that can pinch or cut. Be sure to disconnect electrical power before removing this cover.
- E. Front Cover: Blocks access to dangerous electric voltage and mechanisms that can pinch or cut. Be sure to disconnect electrical power before removing this cover.
- F. Rear Cover: Blocks access to low voltage connections and mechanisms that can pinch or cut. Do not stick your fingers beyond this cover!
- G. Roller Guard: Blocks access to a pinch points. Do not stick your fingers beyond this cover!

**ASSEMBLY DRAWING**



# Stitch'n Fold

## INSTALLATION

### BEFORE UNCRATING:

Examine the crate for visible damage. If the crate is damaged, the machine might be damaged. Notify the carrier who delivered the machine.

### UNCRATING THE MACHINE:

Carefully remove the machine from its container. Lift the machine by grasping its strong framework. Tugging on cables, covers, or other delicate components could cause damage.

Examine the machine for damages incurred during shipping. Do not install a damaged machine. Notify the carrier immediately, and be sure to get a signed copy of the Carrier Inspector's Report of the damage incurred. Your service representative will assist you in determining the cost of repairs.

### ELECTRICAL POWER:

The power cord can be plugged into any 115V, 60 Hz, 1 Phase, 15 Amp circuit. The machine draws less than 10 amps.

### LOADING & THREADING WIRE:

Use only approved stitching wire, part number 415-0225. Open the top guard to reach the wire spool studs. Remove the first retaining pin on each stud. While holding back the white brake pad, mount the coil of stitching wire so the wire comes off upward from the backside, and replace the pin.

Thread the wire upward through the large opening in the spring lever assembly, over the curved section of the lever, and through the slot in the lever. Continue to thread the wire over the large roller on top of the stitcher head, through the straightening rollers, into the check pawl, and down past the gripper. (For easier threading, temporarily turn straightening roller to "OFF" position.) Guide the wire about 1/8" into the hole in the top of the cutter.

When both heads are threaded, the machine is ready to operate. However, it will take two cycles before proper stitches are produced. See instructions in the stitching head owners manual for detailed instruction on threading wire.

## PREVENTIVE MAINTENANCE

### LUBRICATION:

Disconnect electrical power. Next, remove the front cover and both side covers.

Use SAE-20 oil to lubricate porous bronze bearings, plastic bearings, chains, and shafts.

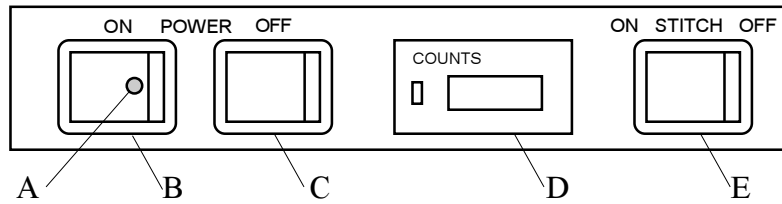
Use approved stitcher head lubricant, part number CA9640, to lubricate the stitching heads every time a new coil of stitching wire is loaded. Clean and lubricate the magnetic rotator. Lubricate the driver bar and the bender bar latch. See stitching head owners manual for detailed lubrication instructions.

### CLEANING:

Use alcohol to clean the belts.

Use a 50-50 mixture of alcohol and water to clean the folding rollers.

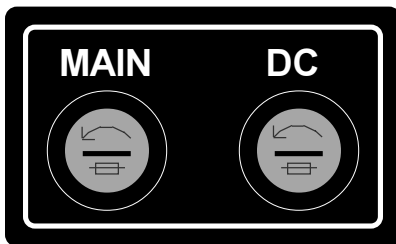
## MAIN CONTROL PANEL



- A. Pilot Light: Glows to indicate that electrical power is turned on.
- B. Power On: Black rocker switch turns on power. Pilot glows, motor runs, and belts move.
- C. Power Off: Red rocker switch turns off power.
- D. Counter: Digital counter records the number of sets that pass through the machine. A manual reset button returns the counter to zero after each job. The reset button can be locked to prevent accidental reset.
- E. Stitch On/Off: Selector switch chooses mode of operation: "On" for stitching jobs or "Off" for folding without stitching.

Note: Opening the front or top guards shuts off the machine. It must be restarted as above.

## FUSE PANEL



Lift open the front guard. The fuse panel is located on the left side wall. Use a small screw driver to open each fuse holder.

- A. Main Fuse: Fuse protects entire machine. If this fuse fails, power cannot be turned on. Replace with 10 amp ceramic time-delay fuse, ISP #RBM1239F.
- B. DC Fuse: Fuse protects transformer. If this fuse fails, none of the 24VDC components will operate. Replace with proper .75 amp fuse, ISP #RBM1267F.

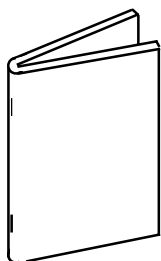
# Stitch'n Fold

## OPERATION & SETUP

### Bookletmaking & Basic Adjustments

See Following Sections For Corner Stitching Or Side Stitching

#### BOOKLETMAKING



##### STITCHING HEADS:

Make sure the stitching heads are mounted in the proper positions to match the paper size. For 5.5" x 8.5" (also A5) paper, the heads must be mounted in the two positions closest to the belt on the main table. One head is mounted just to the left of the belt, and the other head is mounted just to the right of the belt. These head locations will provide a stitch spacing of 2.75". For 8.5" x 11" or 11" x 17" (also: A4 or A3) paper, each head is mounted in the second position to the left and the right of the center belt. These head locations provide 5.50" stitch spacing.

To move a stitching head to a new position, first lift open the top guard. Loosen and remove the knob/bolt from the back of the head. Pull the head forward until it comes off of the locating pin, and slide it over to the desired location. Slip the head onto the new locating pin, and be sure that the driving lug on the upper backside of the head engages the slot in the head driving bar. Replace the knob/bolt (and its washer and lockwasher), and tighten it securely.

##### PAPER WIDTH:

Adjust the side guides for paper width. For instance, if 8.5" x 11" paper is being used to make a 5.5" x 8.5" booklet, the side guides must be set for the 8.5" width. First, lift open the front guard.

To verify adjustment, place a sheet of paper on the main table between the side guides, and pull the right side guide to the left until it stops at the fully jogged position.

##### PAPER LENGTH:

Adjust the gates for paper length. For instance, for 8.5" x 11" paper, the gates must be set for the 11" length. Place a sheet of paper on the main table between the side guides and slide it under the ski until it stops against the first gate. While holding the paper against the gate, turn the adjusting knob under the left hand side of the table until the paper is aligned with the 11" mark on the scale. (Clockwise rotation moves the paper out.) This single adjustment takes care of both the stitching gate and the folding gate. Also, see Timer Gate Adjustment on page 11.

Adjust the booklet tray at the end of the delivery table to match the booklet size. Loosen the knob under the tray, and slide the tray to the proper position.

Finally, adjust the position of the delivery table wheels. There are four sets of slots in the frame for positioning the shaft and wheels; choose a position that suits the booklet size. Just lift the shaft and wheels and set the ends of the shaft into the appropriate pair of slots.

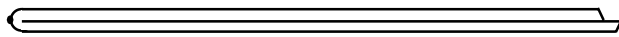
Loosen the thumb screw on each side guide, and slide each guide sideways until its outer edge is aligned with the 8.50" mark on the setup scale.



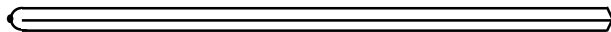
## OPERATION & FINE ADJUSTMENT:

Turn on power and select "STITCH ON". Square up a set of paper sheets by hand, and lay the front edge on the table between the side guides. Push until the front edge is under the ski, and then let go. The set will be automatically stitched, folded, and ejected onto the output conveyor.

Check the finished booklet. If the stitches are properly located on the fold, but the fold is off center (see end view below), adjust the gates by turning the crank until sets will fold precisely in half.

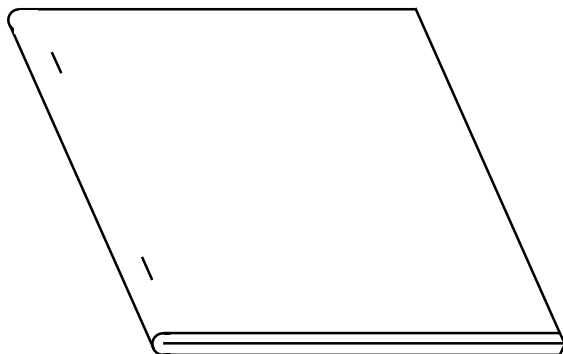


Off Center Fold

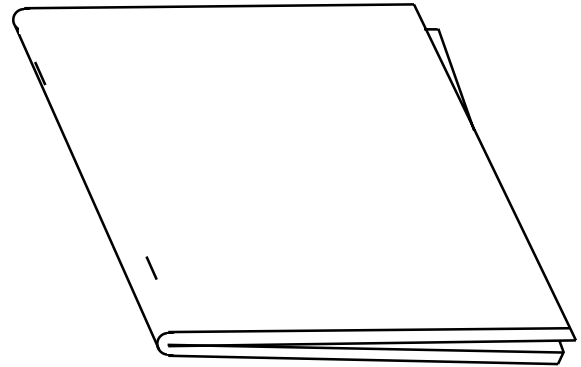


Proper Fold

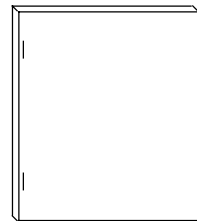
If the stitches are off the fold (see below), open the booklet flat and measure to see if the stitches are centered on the length of the paper. Turn the crank until stitches are placed precisely on the center of the paper. Next, remove the rear cover and locate the two wing nuts below the back end of the secondary table. Turn both wing nuts equally in small increments until booklets will fold precisely on the stitches.



Finally, if the fold is not quite square (see below), the wing nuts can be adjusted individually.



## **SIDE STITCHING**



Side stitching can be done with 5.5" x 8.5" or 8.5" x 11" (also: A4 or A5) paper. In either case, mount the heads for 5.50" stitch spacing.

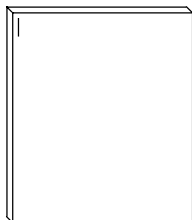
Adjust the side guides for paper length. For instance, if 8.5" x 11" paper is being side stitched, the side guides must be set for the 11" length. Align the outer edge of each side guide with the 11" mark on the table scale.

Adjust the stitching gate for paper width. For instance, for 8.5" x 11" paper, the gate must be set for the 8.5" width. First, lift open the front guard. Place a sheet on the table between the side guides, and slide it under the ski until it stops against the gate. Turn the crank until the trailing edge of the paper is just in front of the clinchers. An alternative method is to set the gate for making booklets with 11" x 17" paper and then turning the crank clockwise to back out the gate about 1/8".

Lower the folding gate by pressing the toggle switch located on the secondary table. The side stitched sets will drop off the end of the secondary table unfolded.

# Stitch'n Fold

## CORNER STITCHING



Corner stitching can be done with 5.5" x 8.5" or 8.5" x 11" (also: A4 or A5) paper. In all cases, mount one head in the far left position. The other head may be removed or left in any position without wire.

Two accessory guides must be mounted on the left hand side for corner stitching. First, adjust the standard left side guide as far as possible to the left. Using thumb screws and wing nuts, attach the corner stitch guide (9" long sheet metal part) to the two holes in the left side guide.

Next, lift open the top guard. Using two thumb screws, attach the corner stitch bar (11" long bar) to two holes in the table on the far left. The angle on the bar should face the front and middle of the machine. Adjust the left side guide until the corner stitch guide is aligned with the corner stitch bar.

Adjust the right side guide for paper length. For instance, if 8.5" x 11" paper is being corner stitched, the side guide must be set for the 11" length. Align the outer edge of the right side guide with the table scale as follows:

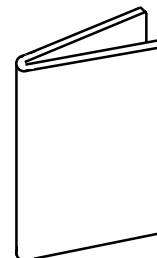
11" paper	11" mark
8.5" paper	6" mark
A4 paper	12.38" mark
A5 paper	6.54" mark

Adjust the stitching gate for paper width. For instance, for 8.5" x 11" paper, the gate must be set for the 8.5" width. First, lift open the front guard. Place a sheet on the table between the side guides, and slide it under the ski until it stops against the gate. Turn the crank until the trailing edge of the paper is just in front of the clinchers.

Lower the folding gate by pressing the toggle switch located on the secondary table. The side stitched sets will drop off the end of the secondary table unfolded.

Index Number	Part Number	Part Name	Number Required
1	RBM1634F	Corner Stitch Guide	1
2	CGG44B	Thumb Screw 10-32 x 3/8	2
3	RBM1702F	Wing Nut 10-32	2
4	RBM1322F	Corner Stitch Bar	1
5	CGG44	Thumb Screw 10-32 x 5/8	2

## FOLDING ONLY

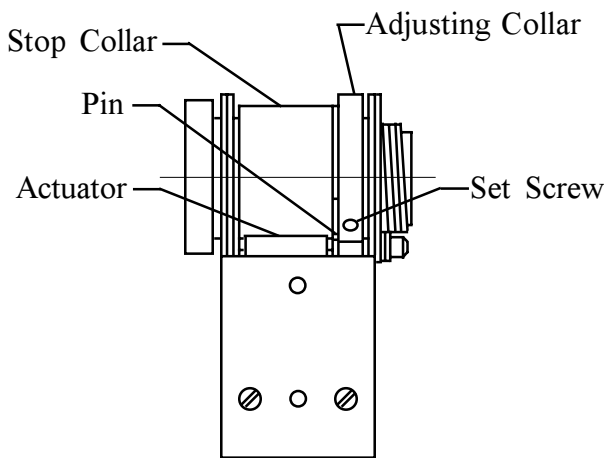


Adjust the machine for paper size according to the instructions for bookletmaking. However, the stitching heads may be left in any mounting positions. On the control panel, select "STITCH OFF".

## ADJUSTMENTS

### STITCHING CLUTCH

The stitching heads are controlled by a single revolution wrap spring clutch. This clutch must be adjusted to stop the stitching heads in the proper position. First disconnect electrical power. Then remove the front cover and the right side cover. The clutch is located inside the cabinet on the shaft toward the left side, and it is bronze and black in color.



Clutch In Neutral Position

Remove stitching wire from the stitching heads. Trip the clutch by pulling down on the actuator with the tip of a small screw driver. On the right hand side of the machine, slowly turn the large spoked wheel clockwise until the first set screw in the adjusting collar is facing forward. Use a 5/64 hex wrench to loosen the set screw. Continue to turn the wheel until the second set screw is facing forward; loosen the screw.

Turn the wheel until the stop on the stop collar hits the actuator. Now turn the wheel until the proper stopping position is reached. Watch the stitching heads on the up stroke. When the bender bars reach the top of the windows in the face plates, turn the wheel slightly more. Be sure that both wire grips are still open. This is the proper stopping position. If you have gone too far, just continue to turn the wheel until you return to the proper position.

Finally, while still in the proper stopping position, trip the clutch and turn the wheel until one of the set screws is facing forward. Carefully hold the adjusting collar so that the stop collar pin is centered in the opening in the adjusting collar. Tighten the set screw securely. Turn the wheel and trip the clutch, if necessary, until the second set screw can be tightened.

### CAM for 3LS

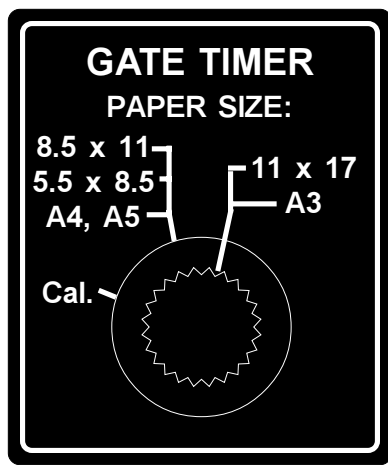
The cam for 3LS, which signals the stitch gate to operate, is to the right of the stitching clutch. To assure proper stitch alignment, the stitching heads should contact the work before the gate goes down. To prevent repeat stitching, the gate must pull the stitch start limit switch, 4LS, down away from the work before the clutch completes a full cycle.

First, be sure the stitching clutch has been adjusted properly. Then, trip the clutch and turn the spoked wheel clockwise until the stitcher heads just reach the clinchers. Loosen set screw on cam, and rotate the cam until it is just about to trip the limit switch. Tighten the cam in this position.

# Stitch'n Fold

## GATE TIMER

The adjusting knob for the gate timer is located on the back of the machine's left side cover. It controls the amount of time that the stop gate is held down each cycle after the stitches have been driven into the booklet. Longer booklets need more time to get past the gate, and the next cycle cannot start until the gate has returned.



For 11" x 17" paper, set the knob as shown. The knob can be left in this position for any other paper size with feed rates up to 2,300 booklets per hour. For faster feed rates with smaller paper, turn the knob to the 8.5x11 position.

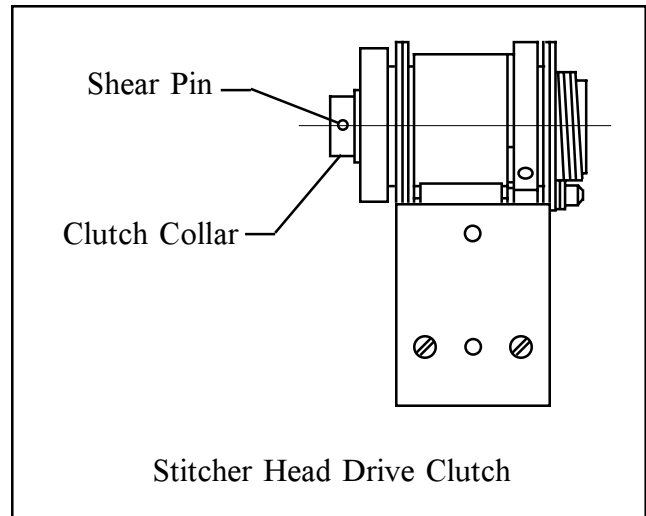
The stitch gate must be down long enough for booklet to pass over. If the gate comes up too soon, the gate limit switch could get tripped causing a double stitch. Turn the knob slightly clockwise.

If the stitch gate stays down longer than necessary and the feed rate is high, booklets will pass through the stitching station without getting stitched. Turn the knob slightly counter clockwise.

Once the adjustment is fine tuned, the knob can be calibrated by loosening its set screw and aligning the mark on the knob with the appropriate paper size. To return the factory calibration, first turn the knob all the way counter clockwise. Then loosen the knob and align it with the "Cal." mark.

## REPLACEMENT OF CLUTCH SHEAR PIN

1. Unplug machine. Remove side covers and front cover.
2. See exploded view of head drive shaft on page 22. Disconnect the pull rods from both head drive cranks (#16). Remove the left side head drive crank by first driving out roll pin (#17).
3. Mark the position of the side jog actuator cam (#38), then loosen both set screws. If the unit has the optional activated clinch feature, loosen the set screws on its cam.
4. Remove screws (#29) from the switch and clutch bracket (#28), and gently lay the bracket down. There is no need to remove wires.
5. Release the idlers on both drive pulley belts.
6. The head drive shaft (#15) should now move freely from left to right. Move the shaft to the right just enough to get an allen wrench on the three socket head screws (#26) holding the head drive pulley (#22) to the clutch. Remove all three.
7. Slide the head drive pulley (#22) and the knife drive pulley (#24) to the left.
8. A collar on the stitch clutch (#25) should now be visible. A pin (#32) connects the collar to the shaft. Remove the sheared pin and replace. Note: If the stitch clutch is being replaced, the new clutch will only have a hole through one side of its collar. You must align the hole in the stitch clutch collar with the existing hole in the stitch head drive shaft. Then, using a 1/8" drill bit, drill through the existing holes and the far wall of the clutch collar. Then drive in the new shear pin.
9. Reassemble by reversing the disassembly procedure.



# Stitch'n Fold

## TROUBLE SHOOTING

### PROBLEM:

### SOLUTION:

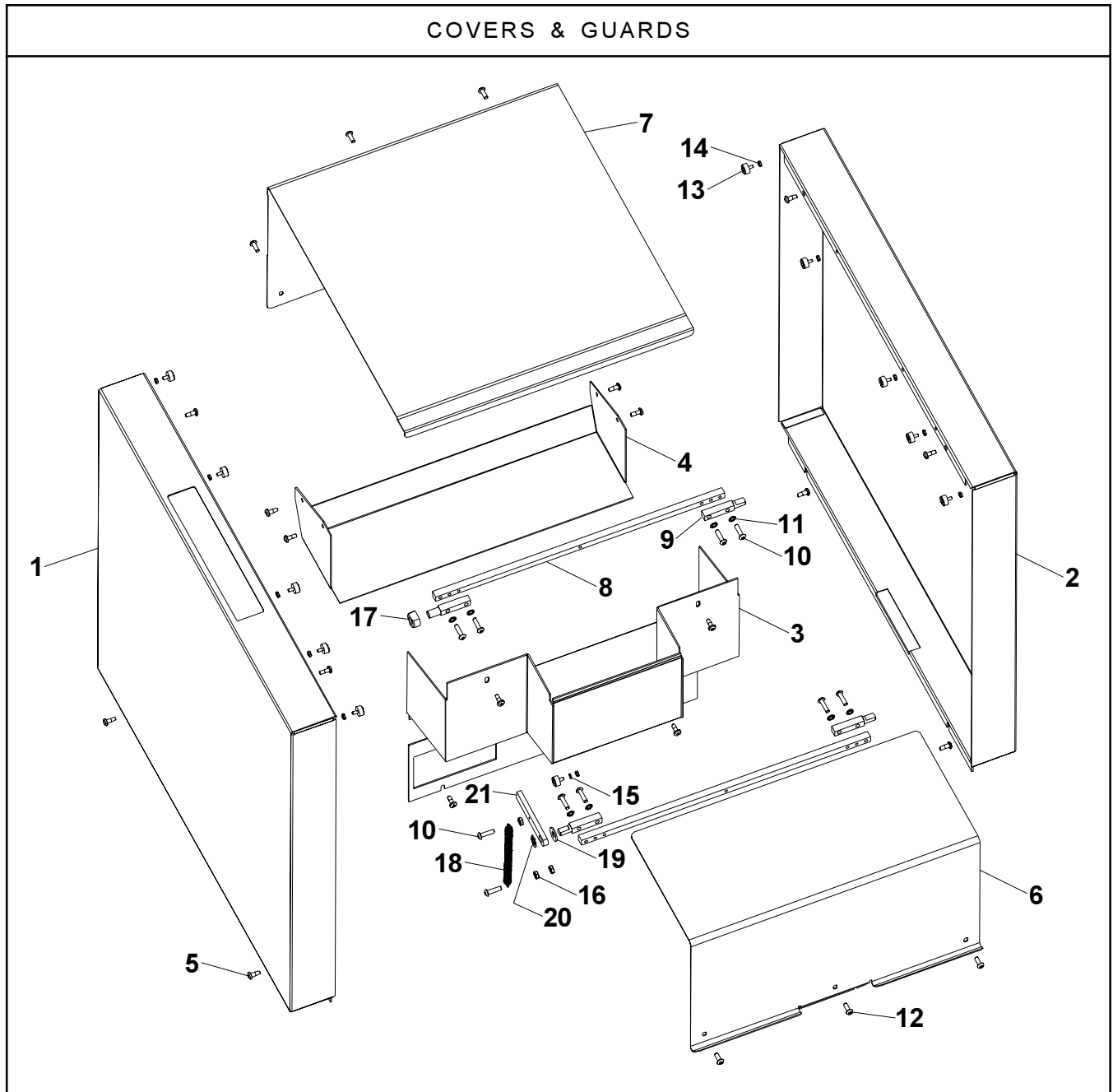
1. Unit will not turn on.	<ol style="list-style-type: none"><li>1. Plug unit into appropriate power supply.</li><li>2. If there is no green light:<ol style="list-style-type: none"><li>a. Check for proper line voltage. (115V or 220V)</li><li>b. Check the "Main" fuse.</li><li>c. Make sure front and top guards are closed.</li></ol></li></ol>
2. Book remains in stitching position.	<ol style="list-style-type: none"><li>1. Make sure motor and belt are running. If not, see problem 1.</li><li>2. Check the "DC" fuse.</li><li>3. Check the connection to the stitch gate microswitch (4LS).</li><li>4. Turn to Stitch "off" position:<ol style="list-style-type: none"><li>a. If stitch gate drops when putting a set through the machine, check connections to the stitch clutch.</li><li>b. If stitch gate doesn't drop when putting a set through, check the stitch gate microswitch (4LS).</li></ol></li></ol>
3. Book moves slowly through the machine.	<ol style="list-style-type: none"><li>1. Make sure when feeding the book that it gets under the side guides.</li><li>2. Spray furniture polish or wax on the entry and through the machine. Caution: Do not get polish or wax on paper drive belt.</li></ol>
4. Inconsistent fold.	<ol style="list-style-type: none"><li>1. Use a 50-50 mixture of rubbing alcohol and water to clean all four folding rollers.</li><li>2. Use a 50-50 mixture of rubbing alcohol and water to clean paper drive belt.</li><li>3. Check and tighten the set screws in all five sprockets that drive the folding rollers. (Three on left side; two on right.)</li><li>4. Make sure that the spring loaded folding rollers are freely springing out and back.</li><li>5. Check the folding knife for bends or waviness. Straighten or replace the knife.</li></ol>
5. Stitches are not square to book.	<ol style="list-style-type: none"><li>1. Make sure the stitch stops are square to the clinchers.</li><li>2. Make sure the side guides are square to the stops.</li></ol>
6. Stitch heads cycle and stop in the down position.	<ol style="list-style-type: none"><li>1. Adjust the stitch clutch according to page 11.</li></ol>

**PROBLEM:**

**SOLUTION:**

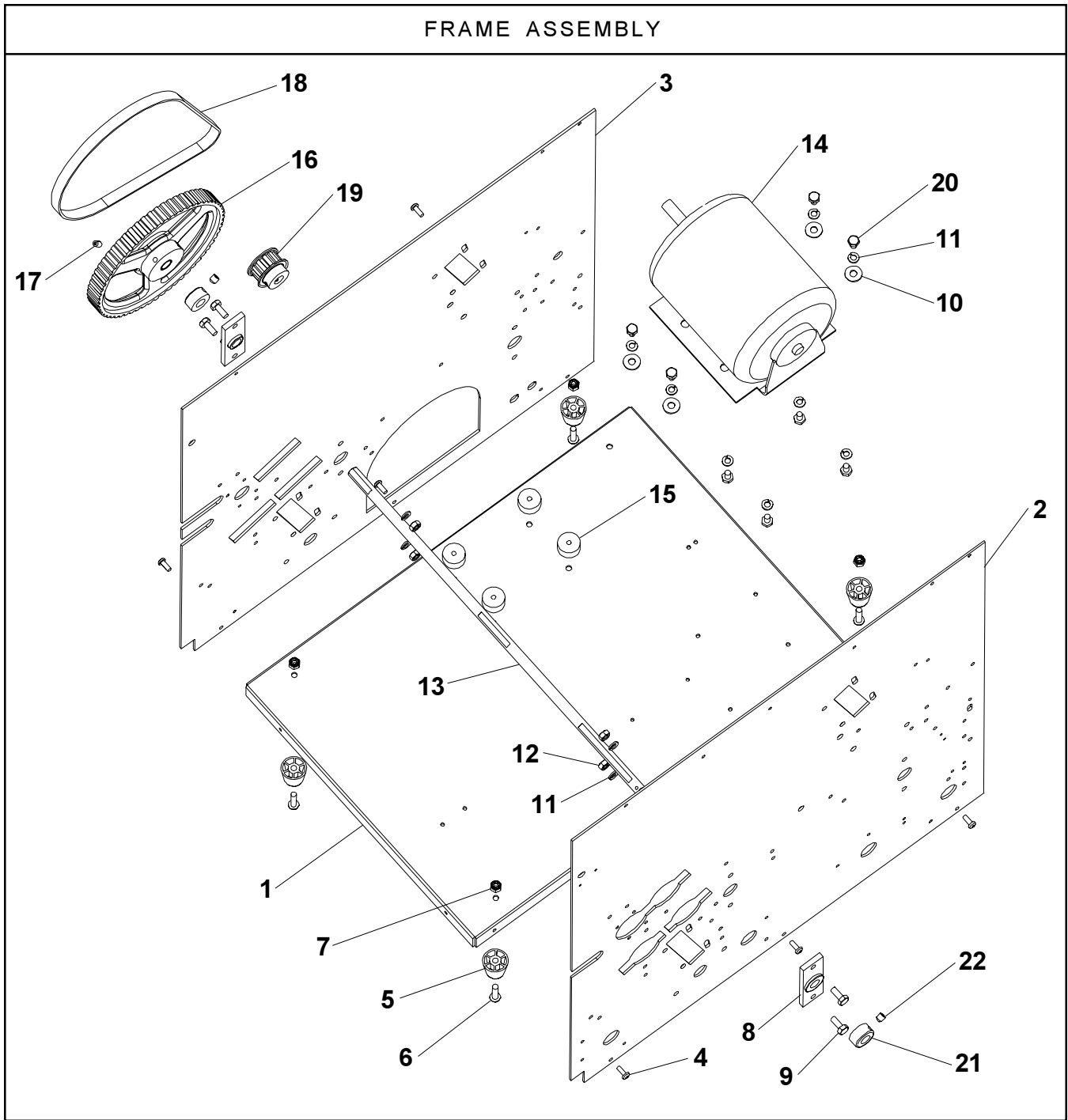
<p>7. Stitch heads won't cycle.</p>	<ol style="list-style-type: none"> <li>1. Make sure that Stitch on/off switch is in "on" position.</li> <li>2. Check stitch clutch solenoid to see if it is activating when triggered by the stitch gate microswitch (4LS):             <ol style="list-style-type: none"> <li>a. If solenoid is activating and heads still don't cycle, check stitch clutch shear pin. See page 13.</li> <li>b. If solenoid is not activating, check the stitch clutch connections. There should be 24VDC to the solenoid when it is triggered by 4LS. If the solenoid fails to activate when 24VDC is applied, replace the stitch clutch.</li> </ol> </li> </ol>
<p>8. Loud banging/clicking noise when stitch heads cycle.</p>	<ol style="list-style-type: none"> <li>1. Lubricate head per the "External Lubrication Sheet" provided with the stitch heads. (Lubrication instructions also appear in the <i>EZ Thread Owners Manual</i>.) <b>Pay special attention to the rotator lubrication.</b></li> </ol>
<p>9. Double stitch.</p>	<ol style="list-style-type: none"> <li>1. Adjust cam for 3LS according to page 11.</li> <li>2. Adjust the stitch clutch according to page 11.</li> <li>3. Check stitch gate timer setting; see instructions on page 12. The gate should stay down until the tail end of the book clears the stitch gate.</li> <li>4. Check for sluggish operation of stitch gate. If there is binding or the return spring is too strong, the gate will fail to pull the stitch start limit switch, 4LS, away from the paper causing repeat stitching.</li> </ol>
<p>10. Booklet folded but not stitched.</p>	<ol style="list-style-type: none"> <li>1. Make sure that Stitch on/off switch is in "on" position.</li> <li>2. Check that you are not feeding the books so fast that the gate has not come back up to receive the next book in time. In that case, adjust stitch gate timer setting per instructions on page 12.</li> </ol>

# Stitch'n Fold



Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1575F	LH Cover	1	13	RBM1316F	Rubber Bumper	11
2	RBM1574F	RH Cover	1	14	CB720	Nut #6-32	11
3	RBM1697F	Front Cover	1	15	CK50	Lockwasher #6	1
4	RBM1676F	Back Cover	1	16	CB278	Nut #10-32	3
5	RBM1324F	Pan Hd Scr 10-32 x 1/2	16	17	RBM1686F	Interlock Cam	1
6	RBM1602F	Front Guard	1	18	RBM1694F	Extension Spring	1
7	RBM1658F	Top Guard	1	19	CB2125	Nylon Washer	1
8	RBM1607F	Guard Bracket	2	20	RBM1586F	Retaining Ring	1
9	RBM1687F	Guard Hinge	4	21	RBM1688F	Spring Arm	1
10	CG26C	Button Hd Scr 10-32 x 3/4	10				
11	CB988	Lockwasher #10	8				
12	RBM1490F	Tamper-Proof Scr 10-32 x 1/2	6				

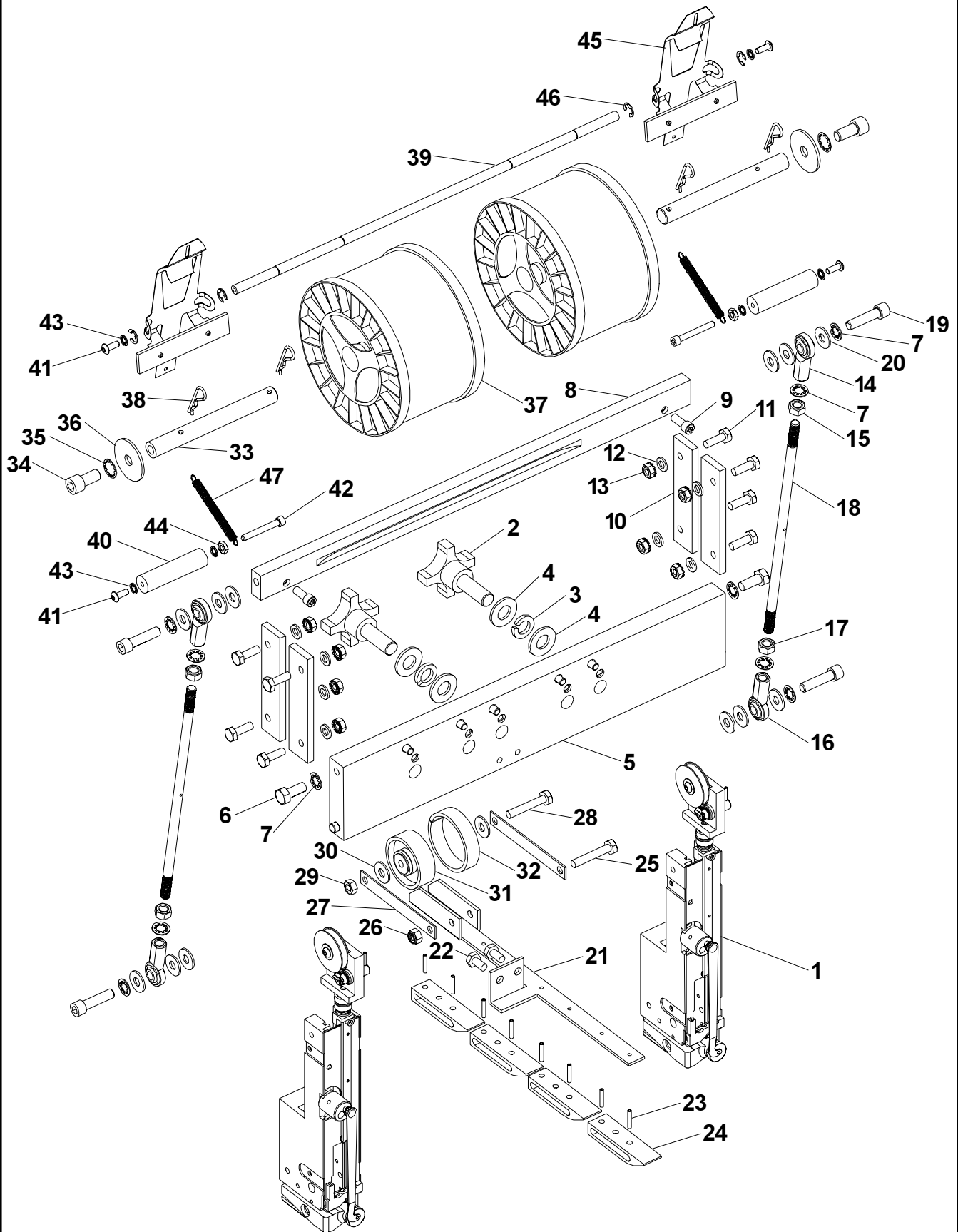




Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1529F	Frame Bottom	1	12	CB493	Nut 1/4-20	4
2	RBM1566F	LH Side Frame	1	13	RBM1543F	Tape Drive Shaft (also page 21)	1
3	RBM1565F	RH Side Frame	1	14	RBM1201F	Motor (also page 30)	1
4	RBM1324F	Pan Hd Scr 10-32 x 1/2	6	15	RBM1301F	Motor Mount	4
5	RBM1202F	Bumper Foot	4	16	RBM1046A	Tape Drive Pulley Assy	1
6	RBM1252F	Rd Hd Scr 1/4-20 x 1	4	17	CB59	Set Scr 1/4-20 x 1/2	2
7	CB860C	Elastic Stop Nut 1/4-20	4	18	RBM1209F	Motor Belt	1
8	RBM1480A	Bearing Assy	2	19	RBM1208F	Motor Pulley	1
9	CB487	Hex Hd Scr 1/4-20 x 3/4	4	20	RBM1382F	Hex Hd Scr 1/4-20 x 3/8	8
10	CB718	Washer 1/4	4	21	RBM1657F	Collar	2
11	RBM1519F	Lockwasher 1/4	12	22	RBM1399F	Set Screw 5/16-18 x 5/16	2

# Stitch'n Fold

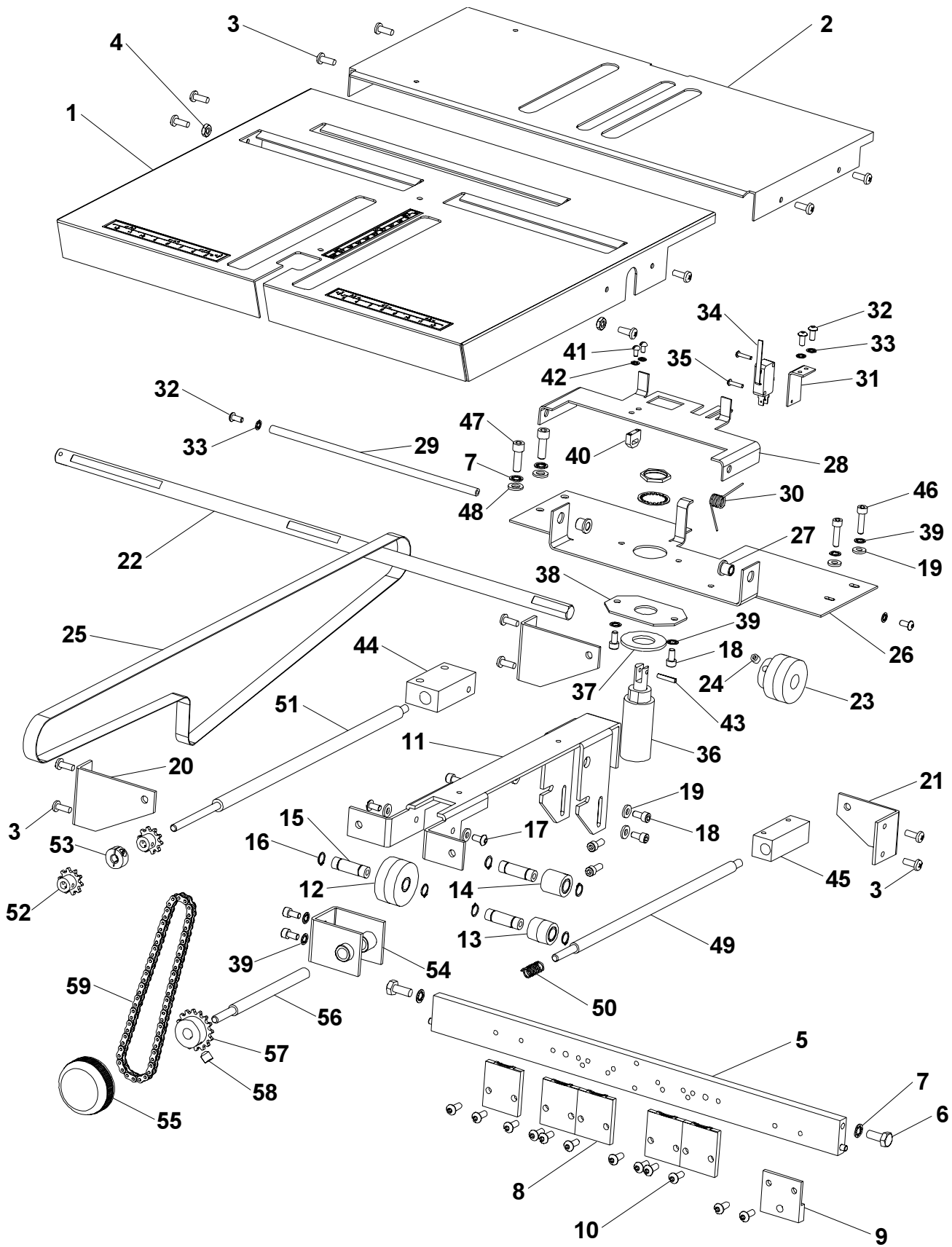
## HEAD DRIVE ASSEMBLY



Index Number	Part Number	Part Name	Number Required
1	CAA2004W	EZ Thread Stitcher Head	2
2	RBM1321A	Knob Assy	2
3	CB734	Lockwasher 1/2	2
4	RBM1630F	Washer 1/2	4
5	RBM1530A	Head Support Bar Assy	1
6	CB606	Hex Hd Scr 5/15-18 x 3/4	2
7	CB895	Lockwasher 5/16	10
8	RBM1550F	Head Actuating Bar	1
9	CB325	Soc Hd Scr 1/4-20 x 1/2	2
10	RBM1564F	Head Drive Wear Strip	4
11	CB487	Hex Hd Scr 1/4-20 x 3/4	8
12	CB806	Washer	8
13	RBM1617F	Keps Nut 1/4-20	8
14	RBM1220F	RH Rod End	2
15	CB418	RH Nut 5/16-24	2
16	RBM1221F	LH Rod End	2
17	RBM1262F	LH Nut 5/16-24	2
18	RBM1037F	Head Connecting Rod	2
19	CB110A	Soc Hd Scr 5/16-18 x 1 1/4	4
20	CB718	Washer	12
21	RBM1659F	Ski Bracket	1
22	CK31	Hex Hd Scr 1/4-20 x 1/2	2
23	CA9028A	Roll Pin 1/8 x 11/16	8
24	RBM1342F	Paper Ski	4
25	CB764	Hex Hd Scr 1/4-20 x 1 1/2	1
26	CB860C	Elastic Stop Nut 1/4-20	1
27	RBM1660F	Roller Arm	2
28	RBM1361F	Plastic Screw 1/4-20 x 1 1/2	1
29	CB411	Plastic Nut 1/4-20	1
30	CB806	Washer	2
31	CB1247A	Roller	1
32	RBM1344F	Foam Tire	1
33	RBM1642F	Wire Spool Stud	2
34	CB314A	Soc Hd Scr 3/8-16 x 3/4	2
35	RBM1520F	Lockwasheer 3/8	2
36	CA46	Washer	2
37	415-0225	Stitching Wire (Two Spools)	1
38	CK176	Hairpin	4
39	RBM1644F	Shaft	1
40	RBM1656F	Spacer	2
41	CG26A	Button Hd Scr 10-32 x 1/2	4
42	MF337	Soc Hd Scr 10-32 X 1 1/2	2
43	CB988	Lockwasher #10	6
44	CB278	Nut 10-32	2
45	RBM1646A	Spring Lever Assy	2
46	RBM1645F	E-Ring	4
47	CK250	Spring	2

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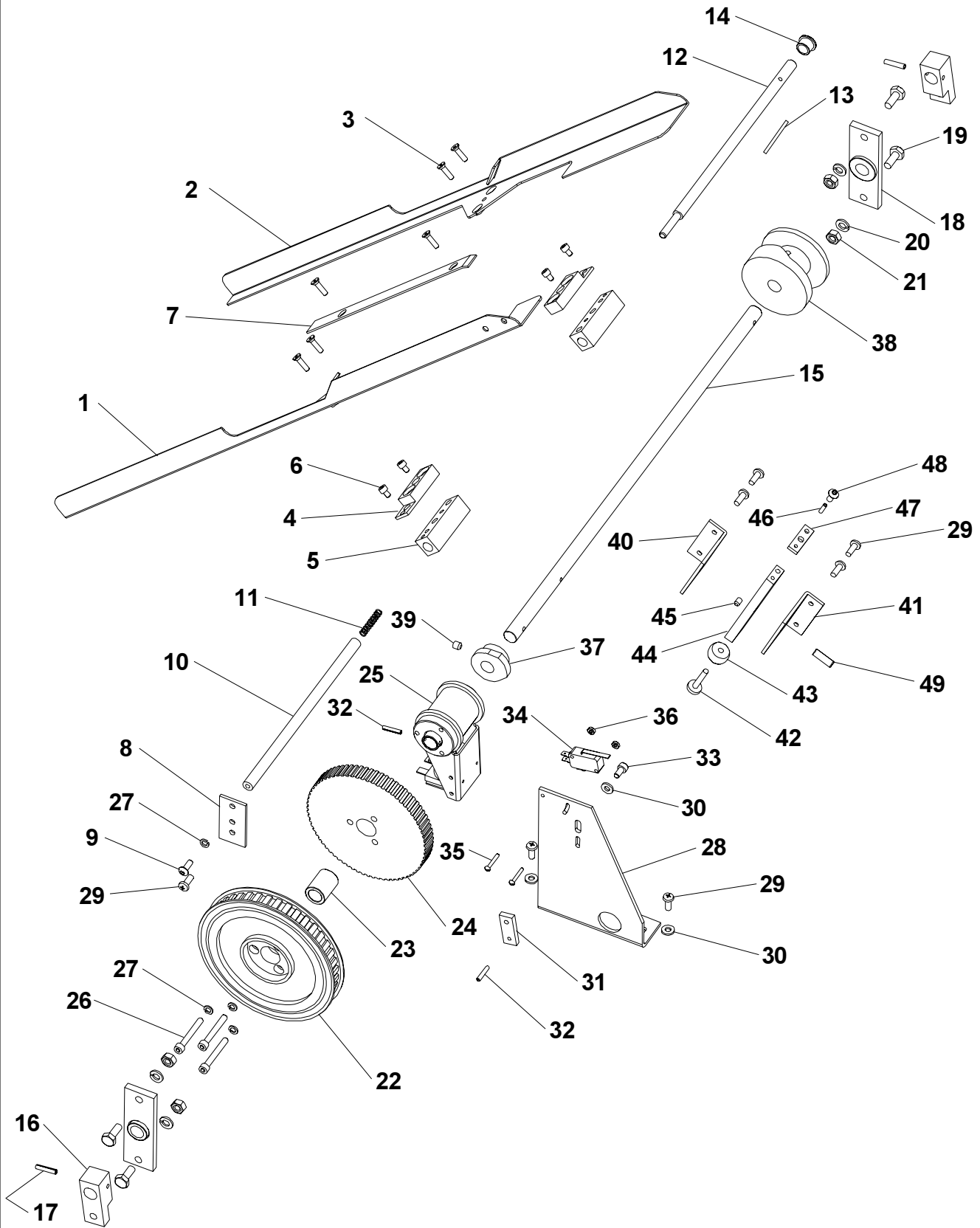
## MAIN TABLE ASSEMBLY



Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1528A	Main Table	1	31	RBM1506F	Switch Bracket	1
2	RBM1615F	Gate Table	1	32	CG26N	Button Hd Scr 8-32 x 3/8	4
3	RBM1324F	Pan Hd Scr 10-32 x 1/2	14	33	CB988A	Lockwasher #8	4
4	CB278	Nut 10-32	2	34	RBM1310F	Microswitch (also page 30)	1
5	RBM1551A	Clincher Bar	1	35	RBM1327F	Rd Hd Scr 4-40 x 1/2	2
6	CB487A	Hex Hd Scr 1/4-20 x 5/8	2	36	RBM1234F	Solenoid (also page 30)	1
7	RBM1519F	Lockwasher 1/4	4	37	CE17	Washer	1
8	CT9086X	Clincher	5	38	RBM1507F	Back Up Plate	1
9	RBM1024F	RH Front Bracket	1	39	CB988	Lockwasher #10	6
10	CG26A	Button Hd Scr 10-32 x 1/2	12	40	RBM1272F	Solenoid Pivot Bracket	1
11	RBM1600F	Center Pulley Bracket	1	41	CB287A	Rd Hd Scr 6-32 x 1/4	2
12	RBM1627A	Center Belt Pulley Assy	1	42	CK50	Lockwasheer #6	2
13	RBM1101A	Crowned Idler Assy	1	43	CA9028A	Roll Pin 1/8 x 11/16	1
14	RBM1340A	Flat Idler Assy	1	44	RBM1598F	LH Guide Block	1
15	RBM1614F	Idler Shaft	3	45	RBM1601F	RH Guide Block	1
16	CB837B	Retaining Ring 3/8	6	46	CB651B	Soc Hd Scr 10-32 x 3/4	2
17	CG26	Button Hd Scr 10-32 x 3/8	2	47	CB51	Soc Hd Scr 1/4-20 x 3/4	2
18	CB651F	Soc Hd Scr 10-32 x 3/8	8	48	CB806	Washer 1/4	2
19	CB1262	Washer #10	8	49	RBM1547F	Stop Carriage Rod	1
20	RBM1549F	LH Bracket	2	50	RBM1667F	Spring	1
21	RBM1548F	RH Rear Bracket	1	51	RBM1591F	Stop Carriaiage Screw	1
22	RBM1543F	Tape Drive Shaft	1	52	RBM1269F	Sprocket 10T	2
23	RBM1096F	Table Drive Pulley	1	53	RBM1311F	Split Collar	1
24	CB141	Set Scr 1/4-20 x 1/4	1	54	RBM1635A	Knob Bracket Assy	1
25	RBM1536F	Table Belt	1	55	RBM1224F	Knob	1
26	RBM1482F	Stop Carriage	1	56	RBM1669F	Knob Shaft	1
27	RBM1249F	Plastic Bearing	2	57	RBM1216F	Sprocket 16T	1
28	RBM1483F	Stop Platform	1	58	RBM1399F	Set Scr 5/16-18 x 5/16	1
29	RBM1313F	Gate Shaft	1	59	RBM1670F	Chain - 62L	1
30	RBM1666F	Torsion Spring	1				

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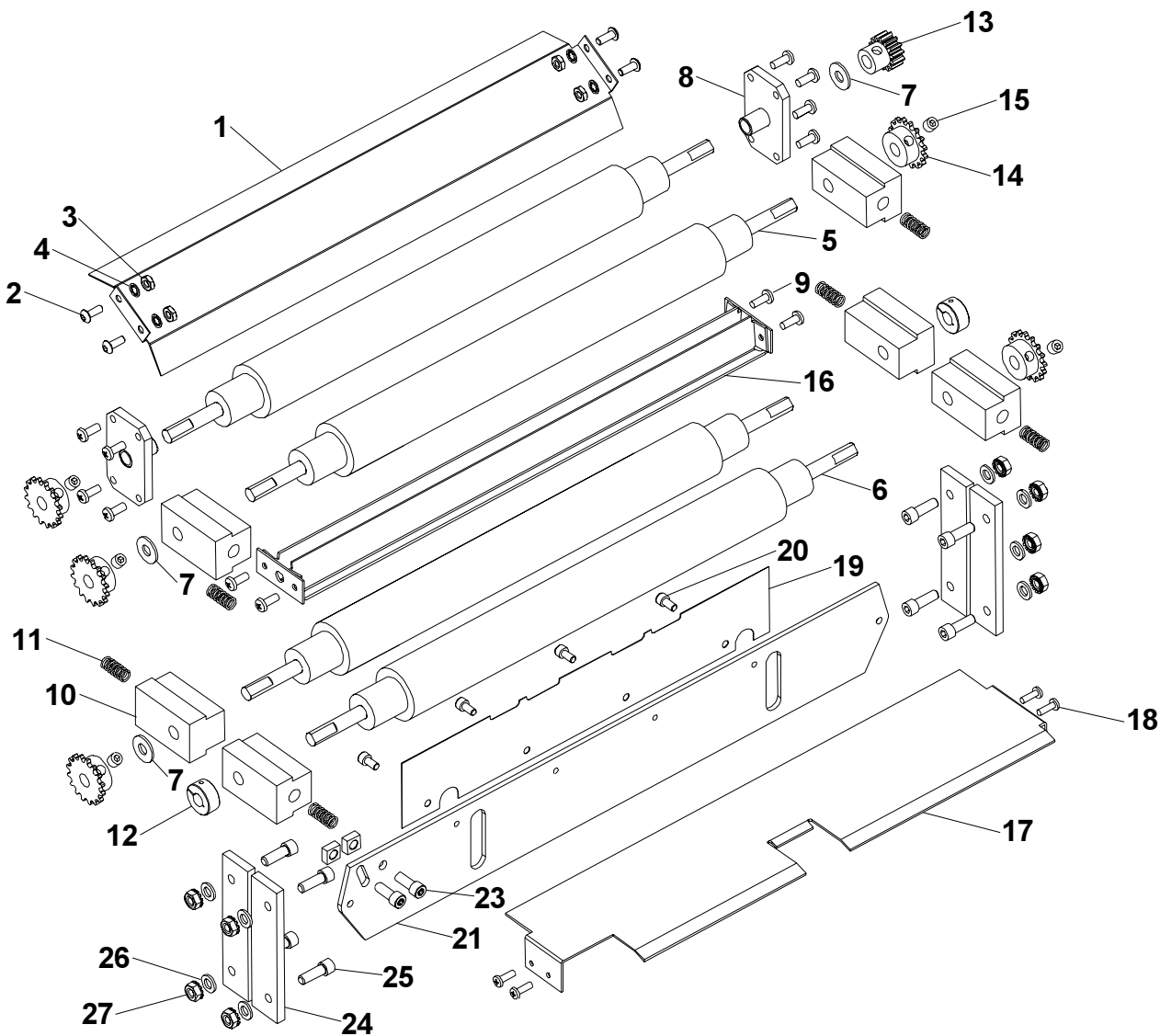
## HEAD DRIVE SHAFT ASSEMBLY



Index Number	Part Number	Part Name	Number Required
1	RBM1629F	LH Side Guide	1
2	RBM1628F	RH Side Guide	1
3	RBM1329F	Flat Hd Scr 8-32 x 5/8	6
4	RBM1624F	Side Guide Bracket Spacer	2
5	RBM1623F	Side Guide Bracket	2
6	CB56M	Soc Hd Scr 8-32 x 1/4	4
7	RBM1622F	Belt Bed	1
8	RBM1651F	Plate	1
9	CG26A	Button Hd Scr 10-32 x 1/2	1
10	RBM1540F	Stationary Guide Shaft	1
11	RBM1229F	Spring	1
12	RBM1539F	Moveable Guide Shaft	1
13	CB835G	Roll Pin	1
14	RBM1250F	Plastic Bearing	1
15	RBM1542F	Head Drive Shaft	1
16	RBM1637F	Head Drive Crank	2
17	RBM1663F	Roll Pin 5/32 x 3/4	2
18	RBM1480A	Bearing Assy	2
19	CB487	Hex Hd Scr 1/4-20 x 3/4	4
20	RBM1519F	Lockwasher 1/4	4
21	CB493	Nut 1/4-20	4
22	RBM1047F	Head Drive Pulley	1
23	RBM1254F	Bearing	1
24	RBM1297F	Knife Drive Pulley	1
25	RBM1227F	Clutch (also page 30)	1
26	MF337	Soc Hd Scr 10-32 x 1 1/2	3
27	CB988	Lockwasher #10	4
28	RBM1596F	Switch & Clutch Bracket	1
29	RBM1224F	Pan Hd Scr 10-32 x 1/2	7
30	CB1262	Washer #10	3
31	RBM1265F	Clutch Pin Block	1
32	CA9028A	Roll Pin	2
33	CB651F	Soc Hd Scr 10-32 x 3/8	1
34	RBM1225F	Microwitch (3LS) (also page 30)	1
35	RBM1328F	Rd Hd Scr 4-40 x 3/4	2
36	CG13	Nut 4-40	2
37	RBM1126F	Switch Cam	1
38	RBM1559F	Actuator Cam	1
39	CB141	Set Screw 1/4-20 x 1/4	3
40	RBM1091F	LH Bracket	1
41	RBM1090F	RH Bracket	1
42	RBM1086F	Roller Stud	1
43	RBM1085F	Roller	1
44	RBM1084F	Actuator Bar	1
45	D22872F	Set Scr 10-32 x 1/4	1
46	CB835P	Roll Pin	1
47	RBM1087F	Actuator Bar Extension	1
48	CG26	Button Hd Scr 10-32 x 3/8	1
49	CB1201	Dowel Pin	1

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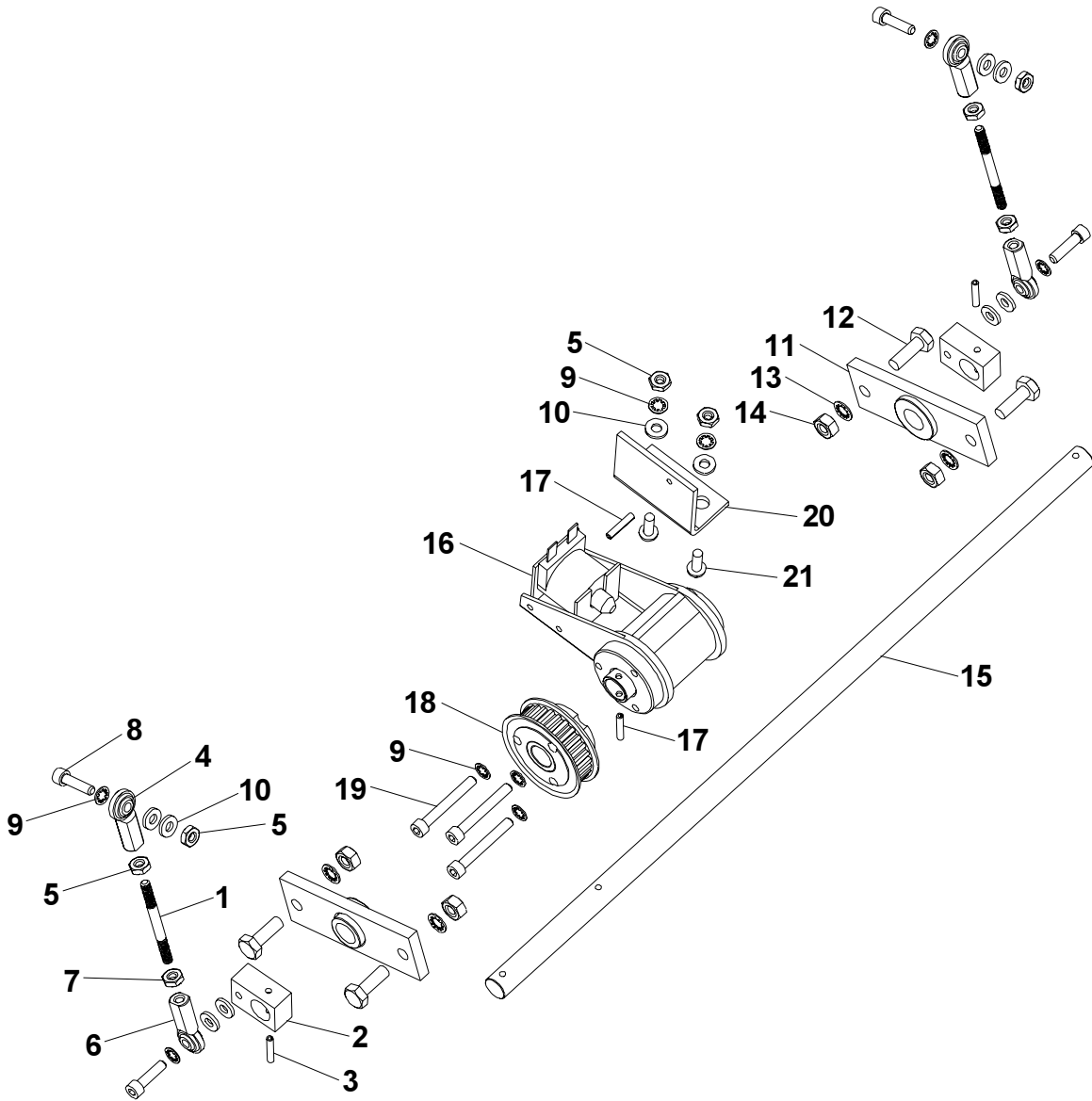
## ROLLERS & KNIFE ASSEMBLY



Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1535F	Book Deflector	1	16	RBM1568A	Book Guide Assy	1
2	CG26A	Button Hd Scr 10-32 x 1/2	4	17	RBM1533F	Spacer Table	1
3	CB278	Nut 10-32	4	18	RBM1323F	Pan Hd Scr 8-32 x 1/2	4
4	CB988	Lockwasher #10	4	19	RBM1621F	Folding Knife	1
5	RBM1552A	Upper Folding Roll Assy	2	20	CB651F	Soc Hd Scr 10-32 x 3/8	4
6	RBM1553A	Lower Folding Roll Assy	2	21	RBM1534F	Knife Support	1
7	CB2125	Nylon Washer 7/16 (3/4 O.D.)	3	22	RBM1616F	Square Nut 1/4-20	2
8	RBM1613A	Bearing Block Assy	2	23	CB325	Soc Hd Scr 1/4-20 x 1/2	2
9	RBM1324F	Pan Hd Scr 10-32 x 1/2	12	24	RBM1564F	Head Drive Wear Strip	4
10	RBM1589F	Bearing Housing	6	25	CB487	Hex Hd Scr 1/4-20 x 3/4	8
11	RBM1667F	Folding Roll Spring	6	26	CB806	Washer	8
12	RBM1312F	Split Collar	2	27	RBM1617F	Keps Nut 1/4-20	8
13	RBM1579F	14T Gear	1				
14	RBM1216F	Folding Sprocket (also page 27)	5				
15	RBM1399F	Set Screw 5/16-18 x 5/16	5				



**KNIFE SHAFT ASSEMBLY**



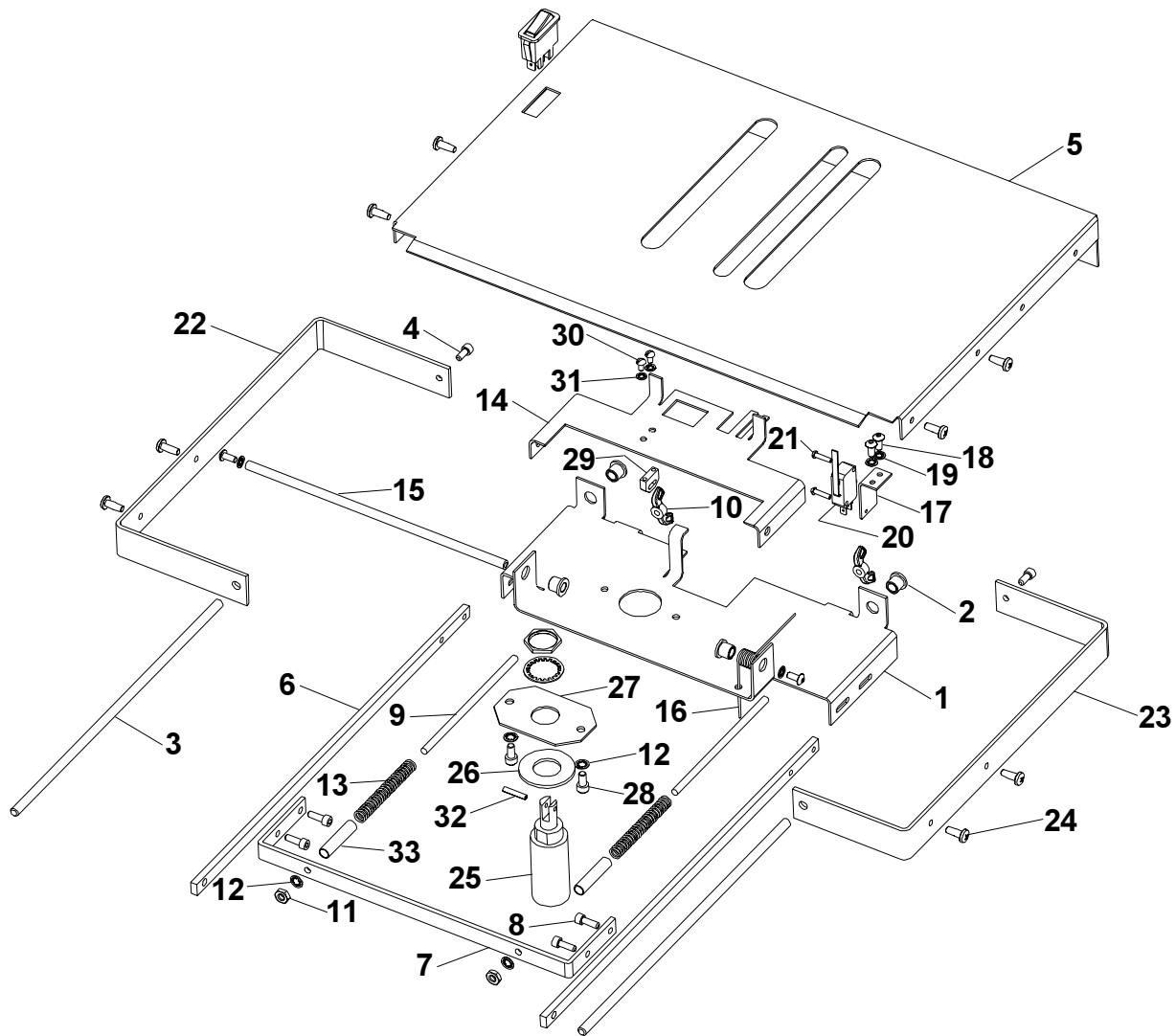
Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1036F	Knife Connection Rod	2	12	CB487	Hex Hd Scr 1/4-20 x 3/4	4
2	RBM1637F	Knife Drive Crank	2	13	RBM1519F	Lockwasher 1/4	4
3	CA9028A	Roll Pin 1/8 x 11/16	2	14	CB493	Nut 1/4-20	4
4	RBM1222F	RH Rod End	2	15	RBM1541F	Knife Drive Shaft	1
5	CB278	RH Nut 10-32	6	16	RBM1227F	Clutch (also page 30)	1
6	RBM1223F	LH Rod End	2	17	CA9028A	Roll Pin 1/8 x 11/16	2
7	RBM1263F	LH Nut 10-32	2	18	RBM1206A	Pulley Assy	1
8	CB651B	Soc Hd Scr 10-32 x 3/4	4	19	MF337	Soc Hd Scr 10-32 x 1 1/2	3
9	CB988	Lockwasher #10	9	20	RBM1597F	Knife Clutch Bracket	1
10	CB1262	Washer #10	10	21	RBM1324F	Pan Hd Scr 10-32 x 1/2	2
11	RBM1480A	Bearing Assy	2				



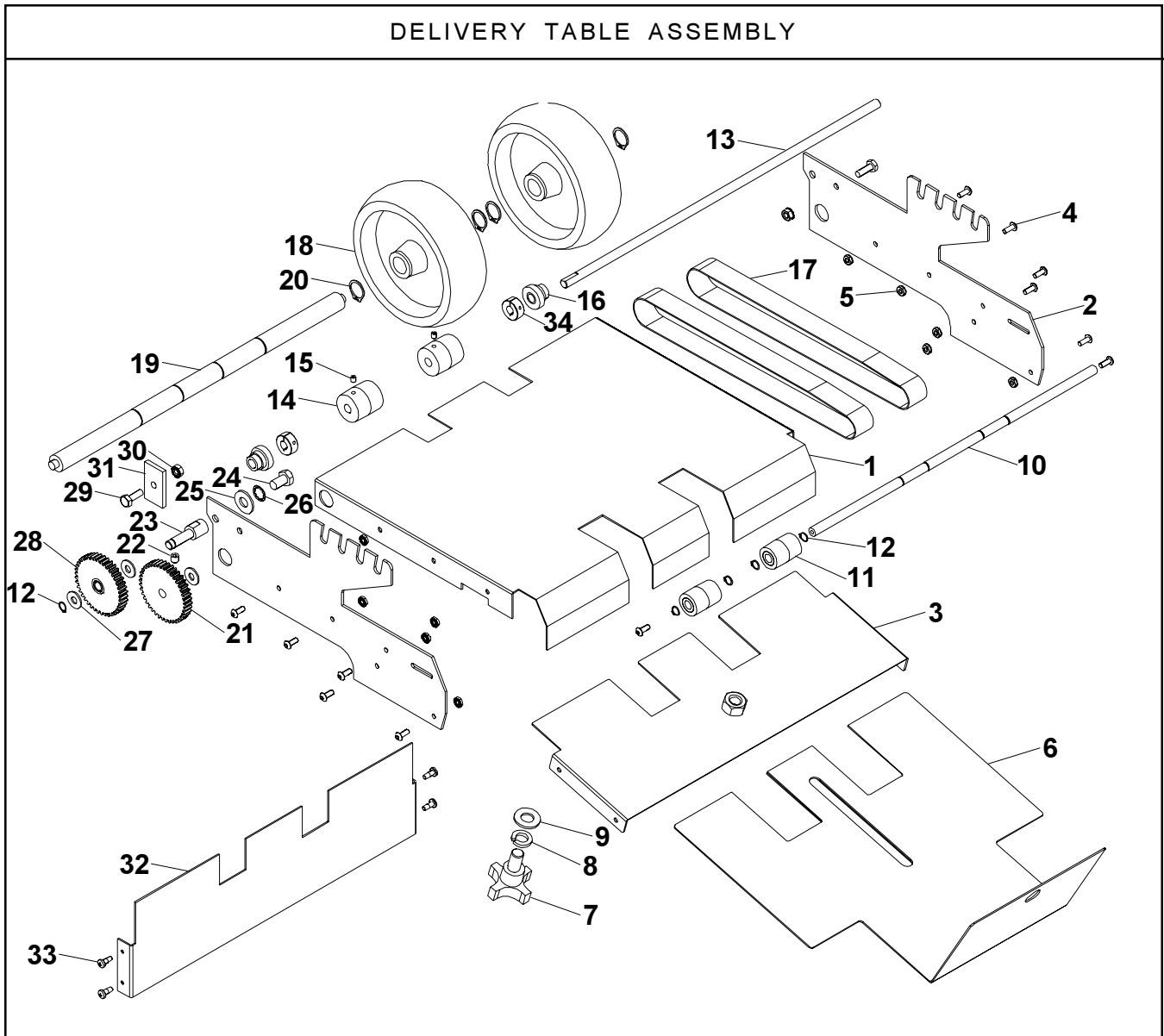
Index Number	Part Number	Part Name	Number Required
1	RBM1211F	Timing Belt 3/8" Wide	1
2	RBM1210F	Timing Belt 1/2" Wide	1
3	D44958F	Soc Hd Scr 1/4-20 x 2 1/2	1
4	RBM1519F	Lockwasher 1/4	5
5	CB718	Washer	4
6	RBM1294F	Knife Idler Shaft	1
7	RBM1291F	Idler Roll	1
8	RBM1295F	Idler Spacer	1
9	RBM1673F	Chain - 44L	1
10	RBM1207F	Reducer Pulley 10 Teeth	1
11	CB837B	Retaining Ring 3/8	4
12	RBM1045F	Idler Bracket Stud	2
13	RBM1044A	Idler Bracket Assy	4
14	CB988	Lockwasher #10	6
15	CG26	Button Hd Scr 10-32 x 3/8	2
16	CB629B	Soc Hd Scr 1/4-20 x 1 1/4	3
17	RBM1293F	Stitcher Idler Shaft	1
18	RBM1360F	Idler Roll	1
19	CB860B	Elastic Stop Nut 10-32	4
20	CB278	Nut 10-32	4
21	CG26C	Button Hd Scr 10-32 x 3/4	4
22	RBM1231F	Idler Spring	4
23	CB606	Hex Hd Scr 5/16-18 x 3/4	1
24	CB895	Lockwasher 5/16	1
25	CB2125	Nylon Washer 7/16 (3/4 O.D.)	4
26	RBM1288F	Sprocket Stud	1
27	RBM1286A	Dual Sprocket Assy	1
28	CT32	Washer	1
29	RBM1218A	Idler Sprocket Assy	4
30	RBM1289F	Idler Stud	2
31	CB328	Hex Hd Scr 3/8-16 x 5/8	1
32	CB889	Washer 3/8	1
33	CB179	Lockwasher	1
34	RBM1662F	Idler Shaft	1
35	RBM1399F	Set Screw 5/16-18 x 5/16	5
36	RBM1216F	Folding Sprocket	5
37	CK31	Hex Hd Scr 1/4-20 x 1/2	1
38	RBM1633F	Idler Shaft (mount on bearing)	1
39	RBM1217F	Drive Sprocket	1
40	CA9028A	Roll Pin 1/8 x 11/16	1
41	RBM1674F	Chain - 156L	1
42	RBM1670F	Chain - 62L	1

# Stitch'n Fold

## SECONDARY TABLE ASSEMBLY

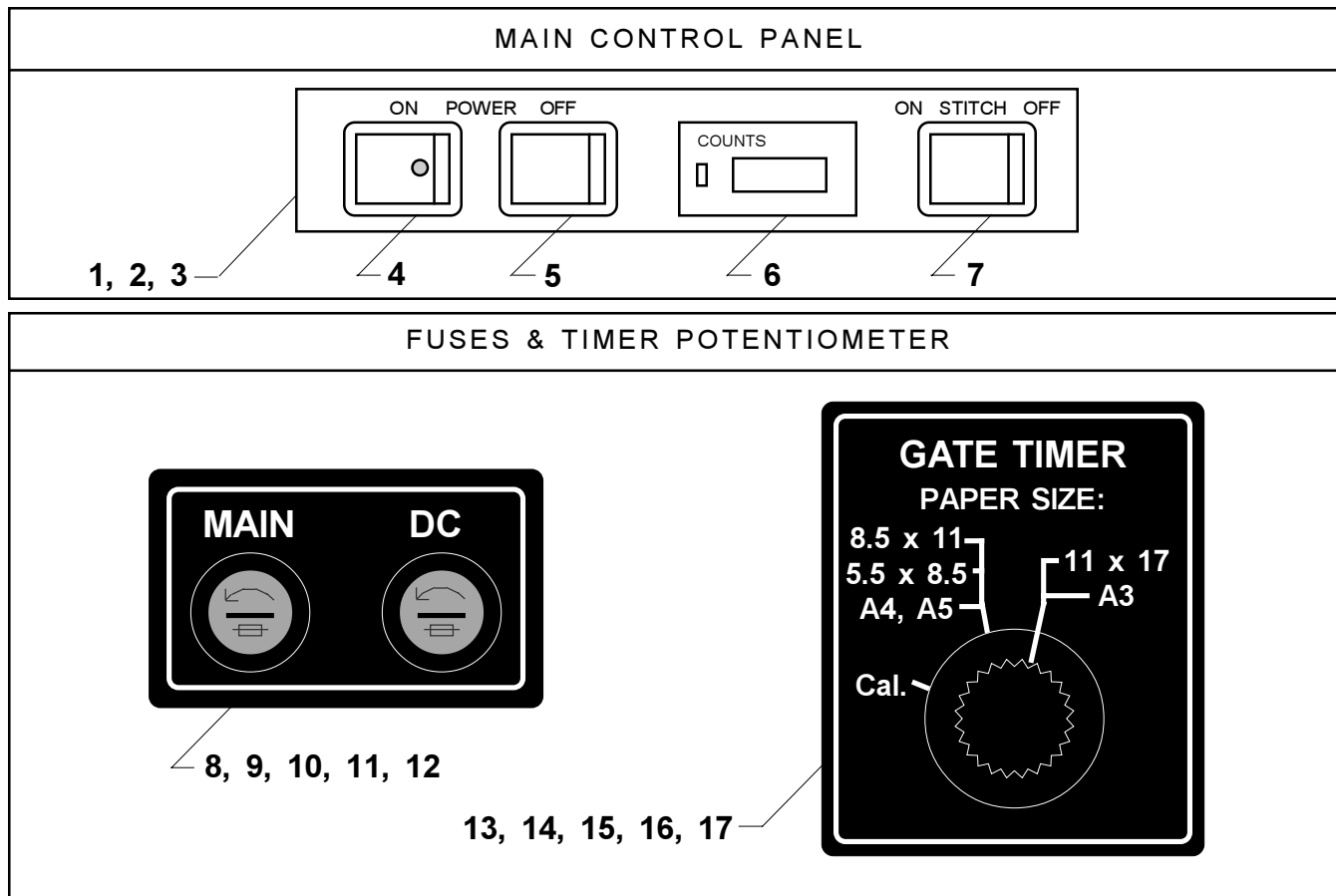


Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1555F	Stop Carriage	1	19	CB988A	Lockwasher #8	2
2	RBM1249F	Plastic Bearing	4	20	RBM1310F	Microswitch (also page 30)	1
3	RBM1588F	Guide Rod	2	21	RBM1327F	Rd Hd Scr 4-40 x 1/2	2
4	D30676F	Soc Hd Cap Scr 8-32 x 3/8	2	22	RBM1560F	U-Bracket LH	1
5	RBM1587F	Secondary Table	1	23	RBM1561F	U-Bracket RH	1
6	RBM1556F	Adjusting Bar	2	24	RBM1324F	Pan Hd Scr 10-32 x 1/2	8
7	RBM1664F	Stud Bracket	1	25	RBM1567F	Solenoid (also page 30)	1
8	D30523F	Soc Hd Cap Scr 8-32 x 1/2	4	26	CE17	Washer	1
9	RBM1665F	Adjusting Stud	2	27	RBM1507F	Back Up Plate	1
10	RBM1308F	Wing Nut 10-32	2	28	CB651F	Soc Hd Cap Scr 10-32 x 3/8	4
11	CB278	Nut 10-32	2	(2 screws connect item 6 to items 44 & 45 page 20)			
12	CB988	Lockwasher #10	4	29	RBM1272F	Solenoid Pivot Bracket	1
13	RBM1305F	Spring	2	30	CB287A	Rd Hd Scr 6-32 x 1/4	2
14	RBM1483F	Stop Platform	1	31	CK50	Lockwasher #6	2
15	RBM1313F	Gate Shaft	1	32	CA9028A	Roll Pin 1/8 x 11/16	1
16	RBM1518F	Torsion Spring	1	33	RBM1685F	Spacer	2
17	RBM1506F	Switch Bracket	1				
18	CG26N	Button Hd Scr 8-32 x 3/8	4				



Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1537F	Delivery Table	1	18	RBM1426F	Wheel	2
2	RBM1569F	Mounting Bracket	2	19	RBM1570F	Wheel Shaft	1
3	RBM1538A	Delivery Bracket Assy	1	20	CB837R	Retaining Ring 3/4	4
4	CG26A	Button Hd Scr 10-32 x 1/2	12	21	RBM1580F	36T Gear	1
5	RBM1661F	Keps Nut 10-32	12	22	RBM1399F	Set Screw	1
6	RBM1684A	Booklet Stacker Assy	1	23	RBM1662F	Shaft	1
7	RBM1438A	Stud/Knob Assy	1	24	CB328	Hex Hd Scr 3/8-16 x 5/8	1
8	CB734	Lockwasher 1/2	1	25	CB179	Washer	1
9	RBM1630F	Washer 1/2	2	26	RBM1520F	Lockwasher	1
10	RBM1572F	Idler Shaft	1	27	CB2125	Nylon Washer	3
11	RBM1073A	Idler Pulley Assy	2	28	RBM1581A	18T/40T Double Gear Assy	1
12	CB837B	Retaining Ring	5	29	CB487	Hex Hd Scr 1/4-20 x 3/4	2
13	RBM1544F	Drive Shaft	1	30	RBM1617F	Keps Nut 1/4-20	2
14	RBM1072F	Drive Pulley	2	31	RBM1641F	Bracket	1
15	D22872F	Set Scr 10-32 x 1/4	2	32	RBM1675F	Roller Guard	1
16	RBM1075A	Bearing Block Assy	2	33	RBM1324F	Pan Hd Scr 10-32 x 1/2	4
17	RBM1425F	Delivery Belt	2	34	RBM1312F	Split Collar	2

# Stitch'n Fold



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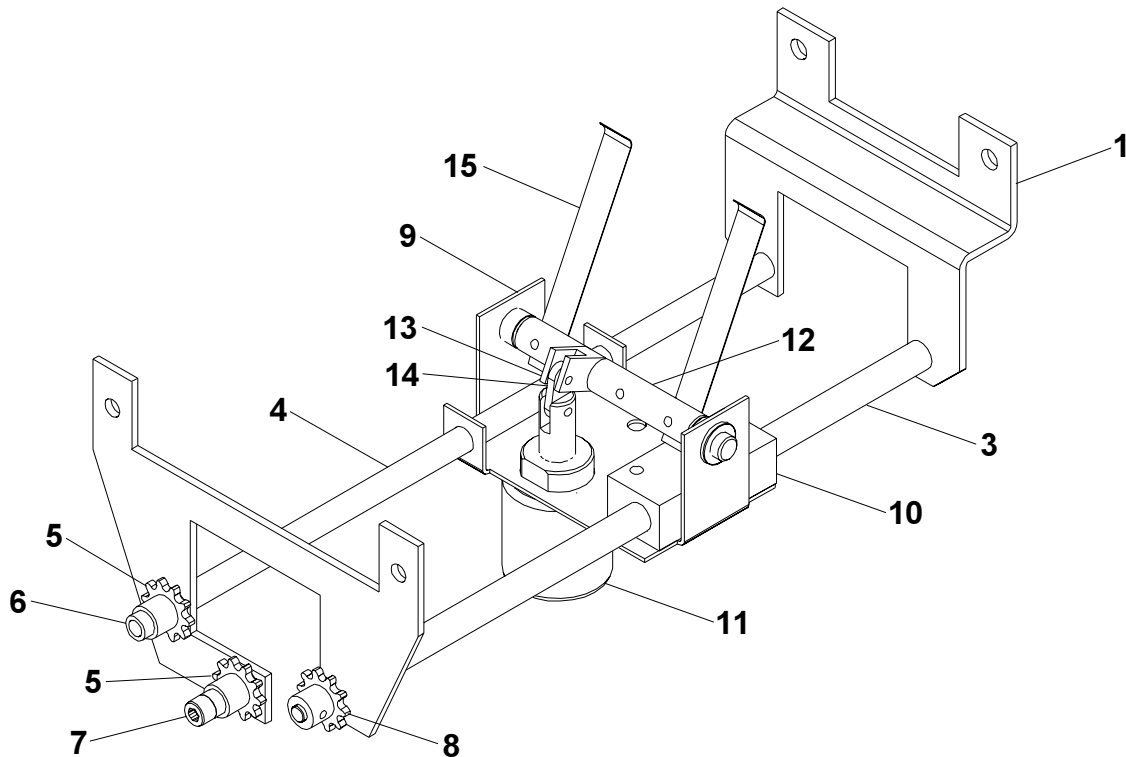
Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1672F	Main Control Panel Decal	1	29*	RBM1201F	Motor	1
2	RBM1573F	Bracket	1	30*	RBM1225F	Microswitch (3LS)	1
3	RBM1324F	Pan Hd Scr 10-32 x 1/2	2	31*	RBM1310F	Microswitch (4LS, 5LS)	1
4	RBM1577F	Black Momentary Switch	1	32*	RBM1277F	Interlock Switch (1LS, 2LS)	2
5	CG136	Red Momentary Switch	1	33*	RBM1328F	Rd Hd Scr 4-40 x 3/4	4
6	RBM1445F	Counter	1	34*	CG13	Nut 4-40	4
7	CG138	Black Selector Switch	1	35*	RBM1428F	Rubber Grommet	6
8	RBM1671F	Fuse Holder Decal	1	36*	RBM1640F	Relay Bracket	1
9	RBM1619F	Fuse Holder Body	2	37*	RBM1324F	Pan Hd Scr 10-32 x 1/2	2
10	RBM1620F	Fuse Holder Carrier	2	38*	CB2454	Power Relay (1CR)	1
11	RBM1239F	Main Fuse 10A	1	39*	CB287E	Rd Hd Scr 6-32 x 1/2	4
12	RBM1267F	DC Fuse .75A	1	40*	CB720	Nut 6-32	4
13	RBM1418F	Timer Potentiometer	1	41*	RBM1416F	Timer - Single Shot	1
14	RBM1611F	Potentiometer Bracket	1	42*	RBM1417F	Timer Socket	1
15	RBM1324F	Pan Hd Scr 10-32 x 1/2	2	43*	D32127F	Rd Hd Scr 6-32 x 3/4	2
16	RBM1419F	Potentiometer Knob	1	44*	CB720	Nut	2
17	RBM1452F	Gate Timer Decal	1	45*	RBM1501A	Transformer	1
18*	RBM1353F	Power Cord	1	46*	RBM1323F	Pan Hd Scr 8-32 x 1/2	2
19*	RBM1668F	Power Cord Bracket	1	47*	RBM1298F	Rectifier	1
20*	RBM1323F	Pan Hd Scr 8-32 x 1/2	2	48*	RBM1324F	Pan Hd Scr 10-32 x 1/2	1
21*	RBM1495F	Power Inlet	1	49*	RBM1234F	Stitch Gate Solenoid	1
22*	CB808	Flat Hd Scr 5-40 x 3/8	2	50*	RBM1567F	Fold Solenoid	1
23*	D27398F	Elastic Stop Nut	2	51*	RBM1227F	Clutch (Stitch, Fold)	2
24*	RBM1240F	Terminal Block	2	52*	RBM1443F	Quencharc (QA)	1
25*	D32127F	Rd Hd Scr 6-32 x 3/4	4	53*	CB285R2	Fold On/Off Switch	1
26*	CB720	Nut 6-32	4				
27*	CB1070B	Green Ground Screw	1				
28*	RBM1711F	Ground Label	1				

\* Not shown; see Schematic.



# Stitch'n Fold

## TAIL JOG ASSEMBLY (OPTIONAL)

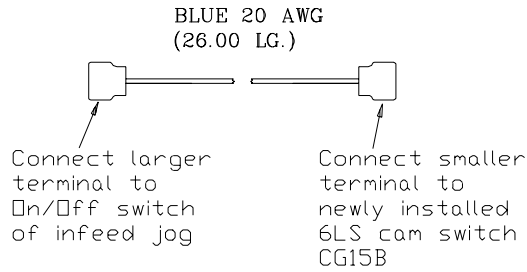


Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1625	Front Jog Plate	1	12	RBM1626F	Jog Shaft	1
2	RBM1606F	Rear Jog Plate	1		RBM1250F	Bushing, .375 Dia	2
	CB325	Soc Hd Scr 1/4-20 x 1/2	4		RBM1586F	Retaining Ring	2
	RBM1519F	Lockwasher 1/4	4		RBM1375F	Extension Spring	1
3	RBM1599F	Threaded Guide Rod	1		CB206B	Flat Hd Scr 8-32 x 5/8	1
4	RBM1603F	Guide Rod	1		CB719	Nut, 8-32 Hex	1
	CB651F	Soc Hd Scr 10-32 x 3/8	1	13	RBM1368F	Jog Crank	1
	CB988	Lockwasher #10	1		CB56X	Soc Hd Scr 8-32 x 1 3/8	1
5	RBM1218A	12 Tooth Sprocket	2		CB719	Nut, 8-32 Hex	1
	RBM1683F	Back Jog Chain	1	14	RBM1374F	Jog Link	1
6	CB651D	Soc Hd Scr 10-32 x 1 1/4	1		CB56P	Soc Hd Scr 5-40 x 3/4	2
	RBM1289F	Idler Stud	1		D27398F	Nut, 5-40 Elastic Stop	2
	CB988	Lockwasher #10	1	15	RBM1631F	Jog Finger	2
	CB1262	Washer #10	1		D30523F	Soc Hd Scr 8-32 x 1/2	2
7	CB629B	Soc Hd Scr 1/4-20 x 1 1/4	1		D14267F	Lockwasher, No. 8	2
	RBM1289F	Idler Stud	1		CBB283E2	Wire Assy (page 33)	1
	CB806	Washer 1/4	1		CBB283F2	Wire Assy (page 33)	1
	CB718	Washer 1/4	1		CBB283G2	Wire Assy (page 33)	1
	RBM1617F	Keps Nut 1/4-20	1		CBB283H2	Wire Assy (page 33)	1
8	RBM1269C	10 Tooth Sprocket	1		CB285R2	Jog On/Off Switch	1
	CB806	Washer 1/4	2		RBM1440F	Spacer	1
9	RBM1610F	Jog Bracket	1		CB651	Soc Hd Scr 10-32 x 1/2	2
	CB492	Flat Hd Scr 1/4-20 x 1 1/4	1		CB278	Nut, 10-32 Hex	2
	CB493	Nut 1/4-20 Hex	2		CG15B	Switch	1
10	RBM1632F	Guide Block	1		CG14B	Rd Hd Scr 4-40 x 5/8	2
	CG26	Button Hd Scr 10-32 x 3/8	2		RBM1638F	Cam	1
	CB988	Lockwasher #10	2			(Cam replaces Crank, RBM1637F, on left side.	
11	RBM1371A	Solenoid and Components	1			See page 23.)	
	CB2063	Washer 1 ID x 1 1/2 OD	1				

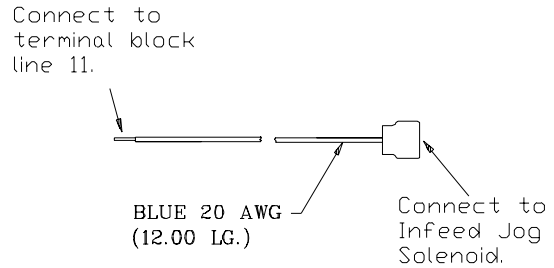


**WIRE ASSEMBLIES INCLUDED  
FOR JOGGER CIRCUIT**

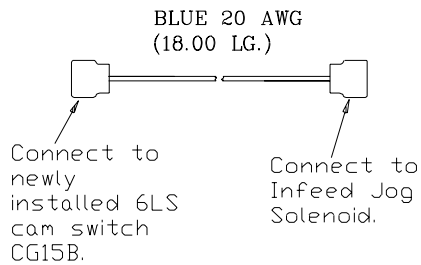
CBB283G2 WIRE ASSEMBLY (Line 23)



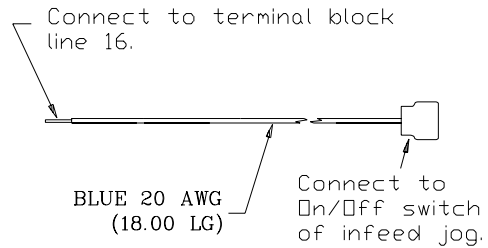
CBB283E2 WIRE ASSEMBLY (Line 11)



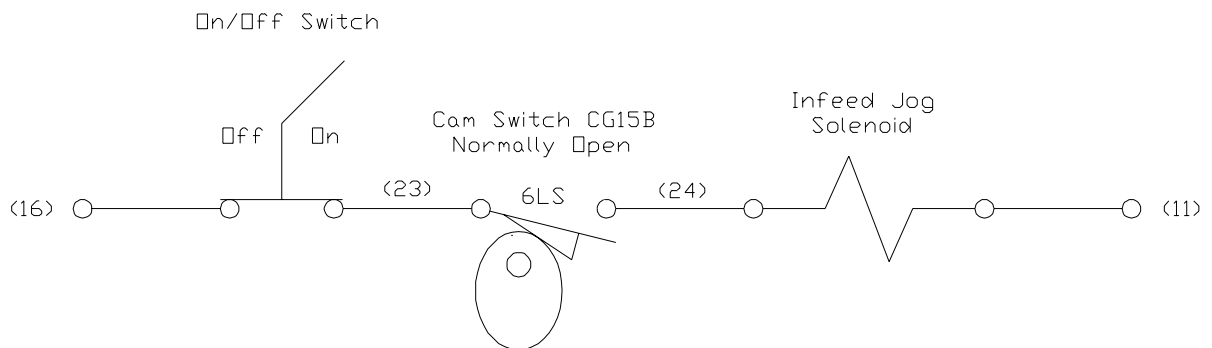
CBB283H2 WIRE ASSEMBLY (Line 24)



CBB283F2 WIRE ASSEMBLY (Line 16)

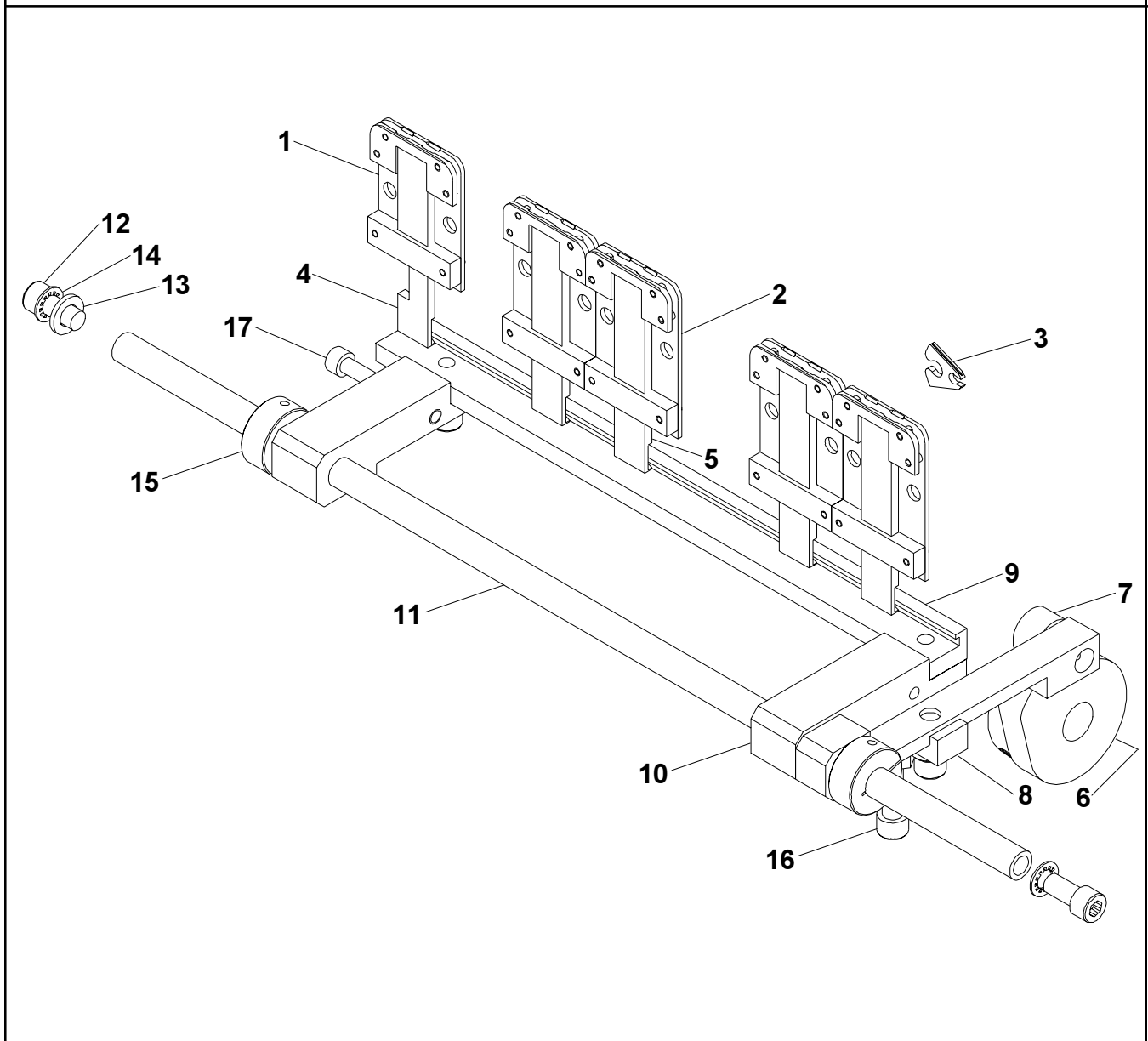


**INFEED JOGGER CIRCUIT**



# Stitch'n Fold

## ACTIVATED CLINCH (OPTIONAL)



Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1453F	Short Clincher Assy	1	11	RBM1639F	Shaft	1
2	RBM1457F	Clincher Assy	4	12	CB325	Soc Hd Scr 1/4-20 x .625	5
3	CA9083A	Clincher Point (inside Assy's)	10	13	CB806	Washer 1/4	5
4	RBM1460F	Short Clincher Slide	1	14	RBM1519F	Lockwasher 1/4	5
5	RBM1461F	Clincher Slide	4	15	RBM1312F	Split Collar	2
6	RBM1521F	Clincher Cam	1	16	CT365	Soc Hd Scr 1/4-20 x 1.750	1
	CB155	Set Scr 5/16-18 x .500	2		CB493	Nut 1/4-20	2
7	RBM1703A	Cam Arm Assy	1	17	MF337	Soc Hd Scr 10-32 x 1.500	1
8	RBM1464F	Arm Adjuster	1		CB278	Nut 10-32	1
9	RBM1458F	Slider Base	1		RBM1694F	Extension Spring	1
10	RBM1463F	Clincher Arm	2				



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