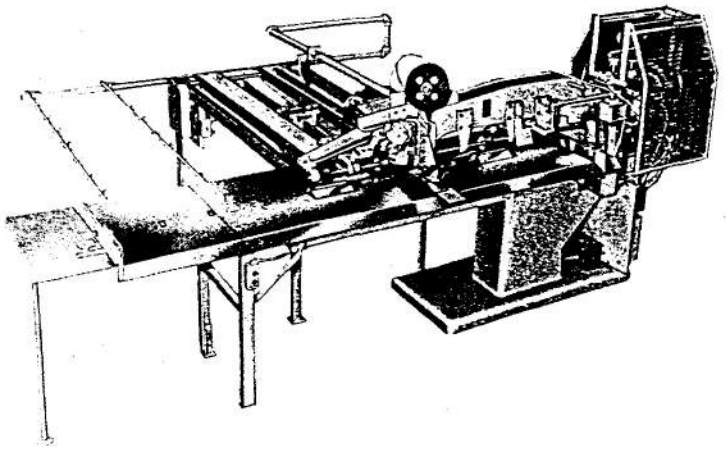
INSTRUCTIONS AND PARTS LIST
OF THE
RSCA 585H, AND 585J
AUTOMATIC
BOSTITCH WIRE STITCHERS

DO NOT START THIS MACHINE or make any adjustments until you have read the instruction book carefully.



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INDEX

INSTALLATION, ADJUSTMENT AND MAINTENANCE
of
BOSTITCH RSCA 585H, & 585J STITCHERS

MODEL 585H – HIGH BASE – 54" TABLE HEIGHT – HAND FEED OPERATION WITH OR WITHOUT ELEVATOR
MODEL 585J – LOW BASE – 38" TABLE HEIGHT – HAND FEED OPERATION WITH OR WITHOUT ELEVATOR

SIZE OF WIRE: – RIBBON
WIDTH OF STAPLES: – 7/16"
STITCHES PER MINUTE: – UP TO 400
H.P. 1 – 1725 R.P.M.

This machine is designed to stitch boxes up to a combined thickness of ⅝" (two thicknesses).

Care must be taken that the wire used is the proper size for the Former and Driver furnished with the machine.

NOTE: This book does not include head instructions. It should be used in conjunction with "Instructions and Parts List for Bliss Heads."

INTRODUCTION

A Wire Stitcher, like any other machine, will give satisfactory results to its owner only if properly installed, regularly lubricated, intelligently adjusted and carefully maintained. Moving parts will wear in time and require replacement, while others may break through accident. Trained service men are available but not always to be had at a moment's notice, and a knowledge of the functions of the more important parts of the stitcher is therefore most desirable for every person responsible for its operations, in order to know what to do in case of trouble.

We have, therefore, gathered together the combined experience of our experts in this line and have attempted to present the information in a manner that will make it quickly available and readily understood.

We would urge, however, in any case of serious difficulty, that you notify our nearest sales office, sending samples of the defective work and describing the trouble in detail, so as to obtain the benefit of their experience in arriving at the proper solution. **Be sure to report the serial number and model of the machine** when corresponding with regard to equipment, so that same may be identified quickly.

ESSENTIAL POINTS IN STITCHING

The legs of the staple must be the same length.

The same amount of wire must be fed at each revolution.

The wire must enter the gripper freely.

The cutter knife and cutter tube must be sharp and properly adjusted.

The open-head device or clincher must be adjusted for the thickness of board to be stitched.

The wire spool must be free to turn and wire must not be allowed to become tangled.

The machine must be KEPT CLEAN AND PROPERLY OILED. An inspection of machine will readily disclose places to be oiled. Be sure to check for oiling parts that are beneath the table.

INSTALLATION

All fixed adjustments of your machine were properly made before shipment, and to put it into service it is only necessary to clean off the grease, see that the machine is properly and completely oiled, thread the machine with the proper size wire, and make the necessary adjustments for box to be stitched.

Any machine can be seriously damaged during its installation if it is not properly set up, and we recommend close adherence to the following procedure:

After uncrating machine, examine carefully for any breakage in transit. If such be found, do not attempt to run the machine, but report at once to the selling agent. If service man is present, let him examine machine and then report to the manufacturer.

Place the machine on a level floor, using shims under the base if it is necessary to prevent any movement or rocking. **Examine the nameplate on motor and see that its specifications are the same as those of the power to be used.** Unless these requirements are met with, do not attempt to operate the machine.

See that motor is free to revolve when large pulley 585012 is turned by hand. Be sure that the V-Belt is under proper tension, lowering motor platform slightly if too tight, or raising it if belts run loose. After any adjustment, see that the motor plate screws are tight.

Make ground connection between stitcher and conveyor as shown on Diagram No. 13, page 43A.

Connect power to disconnect switch and start motor running: NOTE! Before starting motor, be sure that the main clutch is not engaged. In other words, flywheel 585012 (Photo No. 10) should turn freely without turning over the stitcher head or mechanism in the rear of the machine.

After the motor is started, see that it runs freely, without undue noise, and that the large pulley rotates clockwise as viewed from the front of the machine. Should it rotate counter-clockwise, motor wiring should be reconnected by an electrician in order to reverse the direction of rotation.

NOTE:—Before oiling the machine, making any adjustments, or putting wire into the stitcher head, **be sure that the motor is shut off.**

Be sure that the machine is oiled thoroughly at all points before operating. See "Lubrication" for directions and list of points.

Next set the open-head device (Photo No. 2) for the thickness of stock to be stitched. Open-head can be raised and lowered by means of screws UA6824.1 and UA6520.1.

WIRE THREADING AND FEED.

Place a spool of wire of proper size on the spool holder, the wire leading to the left from top of spool. Remove Oiler Felt 70H from Oiler 69H. Put wire into small hole in the Oiler and push through wire feed tube and into head. Place Oiler Felt around the wire and Oiler. Saturate felt with oil. Adjust tension on brake by turning Brake Support Stud to the right for increased tension and to the left for decreased tension.

Note:—If tension is too great the wire will bind and catch between the coils and thus may cause uneven staple legs. If too loose, the spool may unwind, causing snags in the wire.

Cut binding wires on wire coil and bend same back over edge of spool, holding free end of wire in the hand to prevent unwinding and tangling. Cut off bent and twisted end of the wire, using hand cutter 133H on stitcher head and then straighten out about 6" by drawing through the fingers.

The end of the wire to be inserted in the machine must be just as straight as possible. See page 5 BSA 486.

CAUTION: Never operate the machine with wire feeding and with no board above clincher. Serious damage may result from this too frequent practice.

CAUTION: Before running machine be sure that rubber feed rollers are not set too close so as to put excessive load on operating parts. See page 3, for instructions for setting.

Start motor and drive some staples into board, and, if necessary, adjust clincher height to get desired tightness of clinching.

LUBRICATION

The machine should be oiled at the beginning of each eight-hour run. The oil holes and oil cups are easily found on the stitcher head and on the machine. NOTE:—An examination underneath the table will disclose a few additional places to oil. In addition to the above oiling, the following points should be oiled frequently.

1. Supporter unit on stitcher head.
2. Spool holder spindle.
3. Anvil (Gripper) 119H and anvil throwout block 123H.
4. Auxiliary brake lever 25490 (Photo No. 11) between lever and brake hold down roll assembly 25762A.
5. High speed disk clutch yoke shifting shoes (Photo No. 6) and tooth clutch yoke shifting shoes (Photo No. 7), also see Diagram No. 11 for additional oiling of H.S. clutch unit.
6. Squirt oil occasionally onto ratchet 585160 (Photo No. 8) and surrounding parts.
7. When running the lower box feed rubber rollers loose on the shaft be sure that they are greased.
8. There are other parts, etc., to be lubricated which will be pointed out in other sections of this book.

OPERATION

Before attempting to make the necessary adjustments required for various sizes of boxes, etc., a brief outline as to how the machine works should be of help.

Assuming that the machine has been set up for the required number of staples, proper location of side gauges, etc., and the motor started:

Blanks are folded and fed into and through the openhead device to the feed rollers. These rollers are revolving at a high rate of speed and feed the box up to the trip gauge which, by means of a switch and a solenoid, causes the main clutch to be engaged. Just prior to the clutch being engaged, the high speed rollers are brought to a stop and these rollers are then moved step by step to act as the staple spacing feed rollers. When the last staple is made or driven, the rollers are again revolved at the same high speed shown above, to eject the box and be ready to feed the next box up to the trip gauge. The conversion of the rollers from high speed to intermittent feed and from intermittent feed back to high speed is practically instantaneous. When the last staple of a box has been driven and the feed roller conversion has taken place, the main clutch is disengaged, thus leaving the stitcher head and other mechanism inoperative until a new box is inserted in the feed rollers, which are at this time running at high speed.

LOCATING FIRST STAPLE

Referring to Photo No. 3, the trip gauge plate unit can be seen.

Screws UA5110.1 in the trip gauge plate 585101A should be loosened. Only one screw is shown on photo but the other screw is on the opposite side.

With the screws loosened, simply slide the trip plate unit forward or backward until the back edge of the trip gauge plate as shown at (B) registers with a mark on the scale on bar 585177A that corresponds to the distance from the end of the flap to location of first staple in box. Tighten screws firmly, making sure that the trip gauge plate does not bind in the stripper member 585021.

It will be noted that there is a stripper member which moves integrally with the trip plate unit. This member should at all times be free to move and should be remeshed with the trip plate member in case it has been necessary to disassemble this unit for repairs, etc.

CAUTION:—Shut motor off before making trip gauge adjustment.

TO SET SIDE GAUGES
(For Models #585H & #585J)

Refer to photo No. 6.

Loosen handwheel screws 229-56 on front and rear side gauges 585234A, 585235A, 585236A and

585237A. Fold and insert box through open-head. Locate box in proper relation to open-head for stitch required and bring side gauges up to edges of box. Do not set gauges so tight as to cause binding action on the box.

TO SET END FLAP DEFLECTORS

Refer to photo No. 1 and photo No. 2.

These deflectors 25951A and 25660 are used to guide leading end of box under front of trip gauge unit. It is only necessary to readjust these deflectors for particular cases such as going from one extremity of box thickness to another—', etc.

To adjust deflector 25951A (photo No. 2) loosen screw "A" and move front end or end nearest trip gauge up or down as required. Do not set so as to cause too much pressure on the box. Tighten screw firmly.

To adjust deflector 25660 (photo No. 1) loosen screw "A" and move front end or end nearest trip gauge up or down as required. Do not set so as to cause too much pressure on the box. Tighten screw firmly.

TO SET FEED ROLLERS FOR THICKNESS OF BOX

Loosen lock nut 25752A (photo No. 10) and back out screw 25499A approximately ¼" to ⅜". Turn hand screw 25445A (photo No. 10) to raise or lower rollers to setting desired. This opening should be such as will obtain satisfactory spacing of staples with screw 25499A left in the backed out position mentioned above. This applies more particularly when using the Last Staple Register Unit.

On certain types of boxes where the front or leading edge of the box is being damaged excessively by its contact with the trip gauge, the following steps should be taken.

1. Increase the opening between the rollers so as to obviate or diminish the damage.
2. If this increased opening causes poor spacing of staples, turn screw 25499A until it just contacts lever 25500, and lock with nut 25752A.

NOTE:—Rollers must be in down position when making above adjustments.

CAUTION:—Do not have rollers set to give more pressure than is required to satisfactorily step feed the box.

TO SET MACHINE FOR NUMBER OF STAPLES REQUIRED

There are two ways to set machine for number of staples.

The first method to be described is known as the "Dial" or "Counter Method".

The second method to be described is known as the "Last Staple Register Method". Under this method, the unit is set so as to locate the last staple in the exact position required, regardless of the spacing that takes place between the first and the last staples.

Normally, the first method would be used on those types of boxes having a small number of staples, or boxes where the proper location of the last staple is easy to obtain and maintain.

The first method can also be used as an emergency measure during the time the Last Staple Register Unit may be temporarily out of order.

With the first method, the machine can be set for a range of 3 to 45 staples inclusive.

DIAL OR COUNTER METHOD OF SETTING MACHINE FOR NUMBER OF STAPLES REQUIRED

Before setting machine as per description below, the following steps must be taken.

Items 1 through 4 apply only if machine has been set up to use "Last Staple Register Method".

1. Remove part 585246 (photo No. 9). **Do not loosen screws in the clamp member 585247.**
2. Loosen screw (A) (photo No. 3), push lever 585194 down to horizontal position, and lock in this position with part 585306.
3. Unhook spring 585244 (photo No. 14) from cam lever 585193A.
4. By means of latch lever 585034A (photo No. 15) unlock gate 585036, and push gate down so boxes can pass over it.

Referring to dial 585112A (photo No. 9) it will be noticed that it is calibrated in multiples of 5, i.e., 5-10-15, etc. Each notch in this dial represents one staple. To set for number of staples required, simply pull lever 585004 (photo No. 9) out of notch and turn arm to point where arrow (A) can be inserted into notch representing the number of staples required. The numbers stamped on dial can be used as a quick means of determining correct notch for number of staples required. For example, if 12 staples are required, pull out lever 585004, turn and insert arrow (A) into two notches past the mark No. 10 on the dial.

TO SET MACHINE FOR SPACING BETWEEN STAPLES UNDER THE DIAL OR COUNTER METHOD

Refer to photo No. 7.

Loosen nut HN71614, and turn adjusting screw knob 585065A, which moves indicator 585174 to spacing desired. Moving indicator towards inner end of arm 585014 will increase distance between staples, and moving indicator towards outer end of arm will shorten distance between staples. **Tighten nut HN71614.**

Several settings may be required to obtain spacing desired, and spacing should be checked with machine running boxes.

The maximum and minimum spacing that can be obtained is 2⅝" and ⅞" respectively.

Brake band 25089A is to prevent over-travel of step feed rollers. Adjustment can be made by brake band adjusting nut. However, it is seldom necessary to adjust brake and CARE SHOULD BE USED NOT TO HAVE BRAKE SET TOO TIGHT, as it will put undue load on motor and parts.

Brake band composed of parts 25929, 25539A and 25930A shown on photo No. 11 and called auxiliary brake unit, is also for the purpose of preventing over-travel of the feed rollers when they are acting as step feed rollers. This brake is adjusted by turning the Brake Hold Down Roll Assembly, 25762A to give pressure required. Both

of these brakes act to control the accuracy of the staple spacing. CARE SHOULD BE USED NOT TO HAVE THESE BRAKES SET TOO TIGHT. KEEP BRAKES FREE FROM OIL!

See section of this text devoted to poor staple spacing and remedy.

Assuming that the machine has been set up for a box according to the preceding instructions, the machine is ready to run.

TO SET MACHINE FOR TIE STITCH WHEN USING THE DIAL OR COUNTER METHOD

Refer to photo No. 8 and diagram No. 5.

Two more staples than used for single stitching are required when tie stitching is used.

After setting staple selector dial to number of staples required, set mark (representing number of staples required and corresponding with staple dial setting) on sleeve 585128 (photo No. 8) to mark on lock sleeve 25424A, and tighten screw in sleeve 25424A. This setting applies whenever the number of staples is changed.

Pull down lever 585146 (photo No. 8).

The above directions constitute setting for tie stitch.

If lever 585146 is not pulled down, the only result will be that the first box only will not have a tie stitch at the front end. If sleeve 585128 is not set properly, the result will be that two or more consecutive tie stitches will be made and resetting to proper mark will correct this.

When going from tie stitch to single stitches, loosen screw in sleeve 25424A, so that the cam is inoperative and ready to be set when tie stitching is again desired.

Pull lever 25212A up.

If the tie stitch spacing is not as desired, loosen nut (C) on 585190 (Tie Stitch Latch Block), (diagram No. 5), and turn screw (D) to increase or decrease the spacing. Turning screw in increases space, and turning screw out decreases space. Tighten nut (C) when adjustment is finished.

There will probably be a slight difference in the spacing of the first and last tie stitches, the first tie stitch being spaced slightly closer than the last tie stitch. This should cause no concern as it is the normal operation of the machine.

Screw 25658B (diagram No. 5), located in bracket 585368A, is used for making the spacing of the staples in the last tie stitch on the box more nearly the same as in the first tie stitch.

This adjustment is seldom needed and should ONLY BE MADE when DIFFERENCE between spacings of first and last tie stitch is radically different.

If an adjustment need be made, loosen lock nut HN 51618, and then turn machine over by hand until the connecting rod 585006A is at the very end of its down stroke. Turn screw 25658B up until it just contacts the connecting rod. Tighten lock nut HN 51618 firmly and recheck setting by turning machine over by hand to see that there is no binding action with the connecting rod and screw. NOTE: If this adjustment is not made correctly, it will cause the connecting rod or other members to break when machine is run by power.

LAST STAPLE REGISTER UNIT

The Last Staple Register Unit is used in all cases where the proper location of the last staple is difficult to maintain.

This unit can be used on boxes where the minimum dimension from the leading edge of the box to the last staple is not less than eleven (11") inches. The maximum depth of boxes that this unit will handle is as follows:

60 inches with 24 inch end flaps and
81 inches with 3 inch end flaps.

LAST STAPLE REGISTER METHOD OF SETTING MACHINE FOR SPACING AND NUMBER OF STAPLES

There are two phases for set-up using this method to locate the last staple. One for single stitching and one for tie stitching.

For SINGLE STITCH SET-UP proceed as follows:

1. Referring to photo No. 3, be sure that cam lever 585194 is in the unlocked or vertical position. In other words, the part 585306 is located and held by screw (A) so that lever 585194 is free to move.
2. Be sure that spring 585244 (photo No. 14) is hooked to cam lever 585193A.
3. Obtain measurement from leading edge of box to where last staple is to be located.
4. Slide Last Staple Register Unit on bar 585310A (photo No. 14) so that end of unit carriage (see "A" photo No. 15) is set to scale on bar to correspond to dimension required for location of the last staple. Lock unit firmly in place with screws on top end of unit. NOTE: This is an approximate adjustment and a slight readjustment of unit may be required.
5. Make sure that cam lock 585246 (photo No. 9) is firmly attached to the cam lock hub 585247, and engaged in slot with cam 585184A.
6. Set staple dial lever 585004 (photo No. 9) to insert arrow (A) in No. 3 notch on dial 585112A.

NOTE: **Regardless of size or number of staples in box, when using the Last Staple Register Unit for SINGLE STITCH OPERATION,** the staple dial lever 585004 is always **set at No. 3 notch on dial 585112A.**

With the Last Staple Register Unit, the number of staples required in a box is obtained by setting the staple spacing unit, so that the staple spacing will accumulate to the desired amount. The spacing should be such that the correct number or one over the correct number will be obtained. When using this system, it will be noted that the next to the last staple will vary from the average spacing to a spacing close to or touching the last staple. It will be noted, however, that the last staple is in the correct position. If this pattern happens too frequently, a slight adjustment in the staple spacing will correct this condition.

TO SET MACHINE FOR TIE STITCH WHEN USING THE LAST STAPLE REGISTER METHOD

1. Set staple dial lever 585004 (photo No. 9) inserting arrow (A) in No. 4 notch on dial 585112A.

2. Set tie stitch cam sleeve 585128 (photo No. 8) with No. 4 mark coinciding with the mark on lock sleeve, 25424A and tighten screw in sleeve 25424A.

NOTE: The staple dial and tie stitch cam are **always set at No. 4 notch and mark regardless of the number of staples to be driven when setting up the tie stitch for use with the Last Staple Register Unit.**

3. Pull down lever 585146 (photo No. 8).

All other instructions for setting of tie stitch are the same as described on page 4, starting with directions "If lever 585146 is not pulled down, etc., etc." and continuing through the "Note: If this adjustment is not made correctly, etc., etc."

TROUBLES AND THEIR REMEDY

Box does not feed accurately, thus causing poor spacing of staples.

This section applies to both the "Counter" system and the "Last Staple Register" system, but more particularly when using the "Dial" or "Counter" system. However, items No. 1, No. 2 and No. 3 below apply equally to both systems.

Remedy:—

Check to see if the lower feed rollers are loose on the shaft. If so, and boxes are being stitched square enough, then tighten these rollers.

Check for sufficient pressure of feed rollers. If pressure is not enough, make adjustment to bring rollers together. See page 3 for instructions to set feed rollers for thickness of box.

Check to see that brakes controlling overthrow of feed clutch and feed rollers are set properly. See page 3 for these instructions.

See that the feed rollers are clean and free from oil or other substances which could cause slippage. If feed rollers are badly worn down, they should be replaced. See that side gauges and deflectors are not set too tight and that box is free to move through openhead, etc.

Sometimes the 2nd staple is on top, or almost, of the 1st staple. This could be caused:

#1—By trip gauge not lifting up enough to clear box.

#2—By worn teeth or improper engagement of step feed tooth clutch #25435, photo No. 7.

#3—Box feed roller ratchet clutch may be worn —too much oil or dirt inside.

WHEN THE MACHINE PUTS IN THE WRONG NUMBER OF STAPLES

This section applies to both the "Counter" system and the "Last Staple Register" system, but more particularly to the "Dial" or "Counter" system. However, items (a) and (c) below apply equally to both systems.

(a) It may be because staple dial 585112A (photo No. 9) is not returned to starting position; in which case more tension on drum spring 25110 is required.

To change tension on drum spring 25110. Loosen nut and back out screw (A) photo 9. Caution: Before allowing screw, which rests in a hole in the spring case 25029, to come out of hole, insert a rod in one of the other holes in the spring case and hold it firmly to check movement of spring case. With the screw (A) out of the hole the spring case can be turned by means of the rod to amount of tension required, after which screw (A) should be screwed into nearest hole in spring case and nut firmly locked.

The spring tension should be only great enough to return staple dial 585112A when operating on 3 or 4 staples.

If wound too tightly the spring may break when operating with the higher bracket of staples, i.e., 25 to 45 staples.

As a new machine wears in this adjustment should be checked occasionally to see that no more tension is being used **than required to operate on 3 staples.**

(b) If the staple dial 585112A (photo No. 9) rebounds on return, it can cause one less staple than dial is set for. Remedy (1): turn brake screw 25294A, (diagram No. 2), to put more tension on brake spring. Remedy (2): this trouble may also be overcome by reducing the tension of drum spring. Refer to section (a) in this group to change tension of drum spring.

(c) Incorrect number of staples may also be due to incorrect setting of the screw that contacts the staple dial control switch LSY (photo No. 9). In other words, the screw is contacting the switch too soon and should be backed out to correct position.

If the staple count is one greater than the dial is set for, it is because the screw contacts the switch too late and should be turned in to correct position.

This could also be due to clutch repeating one revolution. If so, turn brake rheostat (A) up by degrees until corrected. (See photo No. 17.) See section entitled, *"Clutch and Brake Adjustments."*

Sometimes an extra staple is driven in the box because the weight of the trip gauge laying on the box causes it to be moved forward and trips main clutch. Reduce the weight of the trip gauge by means of adjusting springs 585365 (photo No. 3). Springs 585365 are made stronger by hooking ends into a higher hole on parts 585076A and 585077A.

BOX IS STITCHED WITH 1st STAPLE QUITE A DISTANCE AWAY FROM ITS PROPER LOCATION AND THE LEADING END OF BOX SHOWS NO MARKS, etc., from hitting the trip gauge plate.

If a check shows that the trip gauge plate is properly set, then the reason for the trouble is that the box has been fed so close to the preceding box that the trip gauge plate cannot drop between the boxes, and the clutch is being tripped later by the box as it passes under the trip gauge plate which is resting on box.

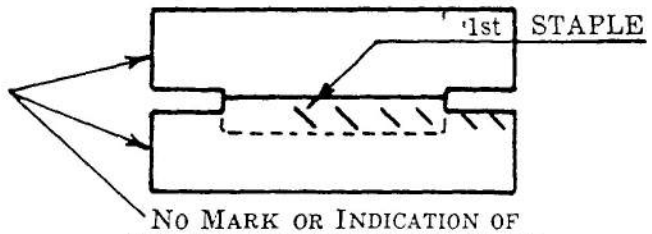
Remedy:—

Hook springs 585365 into a lower hole on parts 585076A and 585077A (photo No. 3). This will allow trip gauge plate to drop quicker.

If, however, because this spring has been made weaker, there is a tendency for the boxes to retrip machine as they are sliding under the trip gauge plate, then it may be necessary to readjust #210-297 trip gauge return spring to make it a little stronger.

The simplest solution to this problem would be to have operator slow down a little.

ILLUSTRATION OF BOX SHOWING ABOVE TROUBLE –



NO MARK OR INDICATION OF BOX HITTING TRIP GAUGE PLATE

BOXES COME THROUGH MACHINE WITH THE 1st STAPLE O.K., BUT THE 2nd STAPLE AND OTHERS SHOW DEFORMATION OR BOX TEARING AT STAPLE POSITIONS. The staple spacing may also be very erratic. These troubles nearly always are the result of faulty functioning of the mechanisms that are supposed to keep the box feed rollers from revolving at a high speed during the cycle of stapling.

Remedy:—

1. Check the switch (called the high speed clutch switch) on right hand side of trip gauge unit to see if electrically correct. Check for broken wire, poor electrical contacts, etc. When checking switch, also check to see that all nuts, etc., in this unit are tight and are in place.

2. Check Solenoid No. 3 (photo No. 5) to see if it operates when switch plunger is depressed.

NOTE:—This solenoid is operated through relay CR1, and contacts CR1-2. See cable diagram.

3. If above items are correct, then check to see if the switch plunger is being depressed enough by the lever 585109A (photo No. 3) when the trip gauge unit is pulled all the way back. The switch plunger should be almost seated when correct. (See "R.H. or High Speed Roller Clutch Switch Adjustment", page 9.)

4. Solenoid is kept energized by lever 585020 (photo No. 3) when the auxiliary brake shaft has moved link 585088 to cause lever 585109A to operate switch plunger.

CAUTION:—Do not make any adjustments so that the switch plunger is fully depressed to a solid condition.

5. When the above items have been checked and are functioning O.K. and trouble still occurs then check to see that the auxiliary brake shaft 585104A (photo No. 10) is properly locked during the cycle of stapling. This lock is shown on photo No. 4 by members 25480A, 25535. The function of this lock is to stop the motions of the trip gauge lifter lever, the auxiliary brake, and the up and down motion of the feed rollers during the cycle of stapling. It also functions to keep the high speed clutch disengaged by means of lever 585020 (photo No. 3), which, through link 585088, operates lever 585109A to keep switch lever depressed, thus keeping solenoid energized and the high speed clutch disengaged during the stapling cycle. If the auxiliary brake shaft lock does not lock up or stay locked, then the high speed clutch switch plunger is allowed to move out so that the circuit is broken and H.S. clutch is caused to function, thus making the box feed rollers revolve at high speed during the stapling cycle, which causes box to move and tear when formers are still on box.

To determine if lock is working properly, have machine in neutral, trip clutch, and turn over by hand with box between feed rollers. This will put pressure on the locking mechanism and take out the natural spring of parts, shaft, etc., so that adjusting of the lock will be correct for working conditions.

When the machine has been turned over so that the lever 25484B (photo No. 10) is on the high point of cam 585124, then lever 25480A (photo No. 4) should slip over or lock on the lower part of 25535 (photo No. 4). At this point, there should be a little clearance on the locking members.

If an adjustment of this lock has to be made, loosen screw on side of member 25535 and screw on top of same member. Move part 25535 to necessary clearance for positive lock and tighten screw on side. Turn screw on top so that it contacts lever 585196 and tighten nut firmly. When making this adjustment, try to keep clearance between locking members at a minimum, but regardless, be sure that lock takes place under actual working conditions.

If staple deformation or box tearing or former scuff marks still exist after remedies shown above have been applied, stitcher head may be out of time with step feed mechanism due to broken tooth on bevel gears or main drive shaft twisted or broken. If main drive shaft is broken, stitcher head will fail to operate. See "Instructions for removing main drive shaft, bevel gears, etc.", page 8.

BOX FAILS TO TRIP MACHINE FOR STAPLING CYCLE, ETC.

1. Roll pressure may not be enough. In which case the feed rollers will not cause box to move trip gauge unit to engage clutch switch.

2. Check to see that clutch rheostat, (D), (photo No. 17) is adjusted high enough to give clutch proper torque or pulling power. See section entitled, *"Clutch and Brake Adjustments."*

3. Main clutch switch (located on L.H. side of trip gauge unit) may be faulty or screw operating same may be improperly adjusted. See "L.H. or Main clutch trip switch adjustment", page 9.

4. See photo No. 17 and Wiring diagram. Check fuses FB2. Check to see that relay CR6 functions to release brake and engage clutch.

5. Check for all wire connections from switch to relay, etc. Also check for brush condition on clutch collector ring.

Box does not throw-out satisfactorily.

1. Check side gauges to see if they are too tight.
2. Check roll pressure to see if it is enough.
3. Check to see if trip gauge plate unit bears too heavily on box. If so, adjust the lifter spring 25079A (photo No. 3) to take some of the weight of trip gauge plate unit off the box. To make these springs stronger, hook into higher holes on parts 585076A and 585077A.
4. Check auxiliary throwout roller 585349A, (photo No. 12), for proper adjustment. See page 10 for adjustment instructions.

Boxes being stitched out of square.

These invariably are boxes whose stitching seams are so short or weak as to make a box that can be easily racked or twisted out of shape. Remedy:—

1. Loosen lower L.H. feed roller 25639BA (photo No. 1) and try box through machine, leaving roller loose.
2. If adjustment 1 does not fully correct trouble, then loosen collars on each side of the roller, and move roller nearer to the center.
3. Loosen lower R.H. feed roller 25640BA (photo No. 1) if adjustments 1 and 2 do not correct the troubles.
4. Moving lower R.H. feed roller closer to center helps on some boxes.
5. Decreasing the feed roll pressure may help.
6. The collars on each side of the lower feed rollers are to be used for keeping the lower feed rollers (when set to run loose on shaft) in place to which they are set.

Note:—Do not run with loose rollers unless required for above reason, as poor spacing might result on larger or harder-to-feed boxes.

Note:—Be sure that these rollers are well greased when running loose on shaft.

7. Check to see that the deflectors on the open-head unit are not set too low as this will put too much pressure on panel of box, tending to force it back out of square. Do not use any more roller pressure than is required to feed box in and out and space staples properly.

Front end of boxes being excessively broken down due to impact with trip gauge unit.

On some types of boxes it will not be possible to eliminate all tendency of front end of boxes to be smashed in or broken down. However, difficulties in this respect may be greatly helped or eliminated entirely on some boxes by reducing the pressure of the box feed rollers. Reduction of pressure, however, should not go beyond that which is required to obtain satisfactory spacing of staples. See section entitled, "To set feed rollers for thickness of box", for changing the pressure of feed rollers, page 3.

Boxes come out of machine with no staples.

1. CHECK FOR FAULTY WIRE FEED; Wire may be tangled on spool; Wire feed clutch may be faulty.
2. May be because operator is feeding boxes too fast in relation to the trip gauge or target dropping down. In that case, hook springs into a lower hole on parts 585076A and 585077A (photo No. 3). This will allow trip gauge to drop quicker.

Scuffing of Box.

If the box shows indications of scuffing approximately 3" ahead of first staple, it may be due to wrong relationship of main clutch switch and high speed clutch switch (located on trip gauge unit) timing. See "Switch adjustment (on trip gauge unit) main clutch and high speed clutch", page 9.

Trip gauge fails to raise up enough to come off box when box is fed against trip gauge plate.

This is an indication of too much load on trip gauge operating parts.

1. Check to see that feed rollers are not set up with too much pressure.
2. Check to see that auxiliary brake hold down roll assembly 25762A (photo No. 11) is not set for too much pressure.
3. Check to see that lifter arm 585019 (photo No. 3) raises trip gauge plate high enough to clear box by inserting box into feed rollers and turning machine over by hand.

If trip gauge plate does not clear box, check the following:

1. With machine in neutral be sure that drop roller adjusting screw 25499A (photo No. 10) contacts drop lever 25500. Now put box into feed rollers making certain that rollers are set to proper pressure to feed box to trip gauge plate.
2. Trip clutch and turn machine over by hand until trip gauge lifter arm 585019 (photo No. 3) has lifted trip gauge plate up to its highest point.
3. Loosen screws in arm 585019.
4. Screw down the Brake Hold Down Roll Assembly 25762A (photo No. 11) to put extra tension on brake. Pull up on trip gauge lifter arm 585019 until trip gauge plate can go no further. Tighten the two screws in arm 585019.
   Check to see that the bottom of trip gauge plate is even or slightly above the bottom of stripper.
5. **Back out Brake Hold Down Roll Assembly 25762A to normal brake pressure!**

ADJUSTMENT AND MAINTENANCE OF STITCHER

Electric Clutch and Brake Unit. Installation and Adjustment.

Refer to diagram No. 6 in 585 stitcher instruction book and Warner Electric Brake and Clutch Service Manual.

Whenever it may be necessary to remove the electric clutch and brake from the stitcher or to install a new clutch and brake unit, the instructions given on diagram No. 6 (585 stitcher instruction book) must be followed. The clutch and brake service manual shows the amount of permissible wear up to the point when the unit is worn out, together with other essential information.

To supplement the instructions given on diagram No. 6, when reassembling parts, drive pulley 585012 should be pushed tightly against collar (A) and then securely locked by means of eccentric collar (B).

If it should be necessary to install a new rear section drive shaft 585086A, (diagram No. 4), shaft can easily be removed after disassembling pulley, clutch, brake, etc. and loosening screws in coupling 585082A (diagram No. 4). When reassembling shaft in coupling 585082A, make sure that screws in coupling are firmly tightened.

Clutch and Brake Adjustments

The main control box contains the rheostats for adjusting the clutch and brake for proper operation.

The clutch rheostat (D) (photo No. 17) is set at approximately No. 70 to No. 100 graduation.

The brake includes an over excitation unit to provide for maximum braking efficiency. It is recommended that the stitcher be operated with this unit in operation except for certain conditions described below.

To put this unit into operation, simply move switch lever (B), (photo No. 17) to "ON" position and set brake rheostat (A) at approximately No. 50 graduation, or such graduation as will stop formers in non interfering position with box being fed through openhead.

If for any reason the stitcher is run at a slower speed, which would cause the over excitation unit to stop the stitcher too soon, change brake rheostat to a lower setting. If, after adjusting rheostat to a lower setting, stitcher still stops too soon, move switch lever (B), (photo No. 17) to "OFF" position and adjust brake rheostat to obtain proper stopping of stitcher.

If the over excitation unit fails to operate due to lamp (C) burning out or for any other reason, move switch lever (B) to "OFF" position and increase adjustment of brake rheostat (A).

Should the maximum adjustment of rheostat then fail to stop stitcher soon enough, stitcher speed must be reduced until the over excitation unit is again operating satisfactorily.

NOTE: The brake and clutch rheostats should in all cases be set only high enough to obtain satisfactory starting and stopping of stitcher so as not to shorten the life of the brake and clutch.

Switch Adjustment for Electric Clutch Disengagement and Brake Engagement at End of Stapling Cycle

When lever 585002A (photo No. 9) has been depressed by lever 585004, as last staple is being driven, adjust screw (C) (photo No. 8) to operate switch LS4 to disengage clutch and energize brake to stop machine.

To Remove or Change Main Drive Belt

Refer to photo No. 10.

Remove handwheel 585121. Loosen two top screws of outboard shaft bearing. 85678 so that guard bracket 585289A can be lifted free of bracket 585016. Remove bracket 585016, disconnect and remove chain 85579. Main drive belt 85278 can now be removed.

INSTRUCTIONS FOR REMOVING MAIN DRIVE SHAFT (FRONT SECTION), BEVEL GEARS, ETC.

1. Take off openhead assembly by removing two screws UA6824.1 (photo No. 2).
2. Remove head by unscrewing three (3) head bolts in rear of head.
3. Remove Feed Roller bracket, 585022, (photos Nos. 2 and 11) by first driving the two dowel pins out through the bottom of bracket 25021CA (photo No. 2). Remove screws holding brackets 585022 and 25021CA to the head casting. The bracket will come off by pulling or tapping same to rear.
4. Before removing part 500L5 (photo No. 1), BE CAREFUL TO CATCH THE OIL, which is in the angle gear housing, in a container. BE SURE THAT OIL IS PUT BACK INTO ANGLE GEAR HOUSING WHEN PARTS ARE REASSEMBLED.
5. Remove head casing 500L5 (photo No. 1).
6. Remove angle gear housing. It will probably be necessary to use a thin chisel, screw driver or like tool to break this housing loose at the joint. Pull this housing directly off the dowel pins.
7. Loosen screws in shaft coupling 585082A (Diagram No. 4).
8. Pull gear and front section of main shaft out and any necessary repairs or replacements can be made.
9. To reassemble insert main shaft and bevel gear into coupling 585082A (Diagram No. 4), regardless of position of square on end of shaft or teeth in gear, and tighten screws firmly in coupling.
10. Turn the machine over by hand in normal driving direction until the screw holes in eccentric and connecting rod, (Diagram No. 5), are in line. (See also Diagram No. 3.) Now mesh the two bevel gears so that the driver bar link hole, (A, diagram No. 3), is to the right of vertical centerline going through holes (E) and (F), as shown on Diagram No. 3.

This location is very important, as this is the correct timing for the stitcher head in relation to the step feed clutches.

NOTE: Be sure foregoing condition is obtained with the backlash or play taken out of bevel gears; i.e., with gears fully meshed and head cam turned by hand counterclockwise until backlash is out, see that the hole (A) is to the right as described above.

11. Now reassemble balance of parts making sure that trip gauge is level and square with table.
12. When all parts are completely reassembled, trip machine and turn over by hand for final check. See that formers are just off the blank on their way up when feed rollers start to act to step feed boxes and that the Trip Gauge Plate 585101A, clears the bottom of the stripper so boxes can pass under trip gauge plate. If adjustment has to be made, refer to items Nos. 1, 2, 3, 4 and 5 on page 7, under section, "If trip gauge plate does not clear box, check the following." If above conditions are met,

then machine is correctly adjusted and can be run by power.

Trip Gauge Setting and Adjustment.

Refer to diagram No. 12.

After the initial setting of the trip gauge, no further adjustment can be made except for squaring with table by using the clearance in the bolt holes. The bottom edge of the Trip Gauge Plate 585101A should be as near parallel with top of table as possible.

The trip gauge should be set so that when the Trip Gauge Plate 585101A is resting on top of the table, or the 3/16" thick plate as provided on latest machines, the centerline of pivot (A) will be on a line parallel with the table and passing through centerline of pivot (B) or not more than 1/16" higher than pivot (B). Under no circumstances should pivot (A) be lower than pivot (B).

Check to see that when Trip Gauge Plate 585101A is in the lower position, top edge of plate is still above lower edge of stripper, 585021 (photo No. 3).

Also check to see that lower edge of Trip Gauge Plate 585101A is above bottom edge of stripper 585021, when trip gauge plate is in its highest position.

Switch Adjustment (on Trip Gauge Unit) — Main Clutch and High Speed Clutch.

These two switches (LSA and LS3) are located on the trip gauge unit as shown on photo No. 3.

The R.H. switch or high speed roller clutch switch (looking from the discharge end of machine) is the one that stops the box feed rollers from revolving at high speed. This switch also engages the step feed tooth clutch.

The L.H. or opposite switch causes the main driving clutch to be engaged.

The adjusting of these two switches is as follows: (Note: Under no circumstances allow switch plungers to bottom or come to solid position.)

1. **R.H. or High speed feed roller clutch switch adjustment.**
   With machine in neutral (normal stopping position when clutch is disengaged under power) **shut off motor.**
2. Pull trip gauge unit all the way back. Adjust screw (C) diagram #7, until switch plunger is depressed to approximately 1/16" of bottoming.

L.H. or Main clutch trip switch adjustment.

1. Pull trip gauge unit back until lever 585109A, diagram No. 7, just contacts switch plunger. NOTE:—Screw (C) must be adjusted as per item 2 (paragraph above) before this instruction can be followed.
2. With this setting, adjust main clutch switch operating screw so that there is approximately 1/16" clearance between screw and main clutch trip switch plunger.
   If the above adjustments have been correctly made it will be noticed that the high speed roller clutch switch is contacted before the main clutch switch.

Safety Switch Adjustment.

Referring to photo No. 8 note switch LS1. This switch is connected into the motor current. On lever 585002A (photo No. 9), a screw is located which operates against the plunger of switch LS1. This screw is adjusted so that it contacts the switch plunger, breaking the circuit one dial (585112A) movement later than switch LSY, which controls the number of staples. In the event that switch LSY fails to work, switch LS1 will open the motor current and machine will stop.

Staple Dial Switch Adjustment.

Have machine in neutral position with main switch ON, but motor switch OFF.

Press the top button on switch (A) (photo No. 10). This will release the brake so that the machine can be turned over by hand.

Set lever 585004 in No. 3 notch in staple dial 585112A.

Turn the stitcher over by hand two full revolutions. Continue to turn and at end of the connecting rod's next down stroke, have screw (C) (photo No. 9), operate switch LSY to stop staple count.

Run machine by power, trip clutch and check staple count. If obtaining more staples than dial is set for, turn screw in slightly. If obtaining less staples than dial is set for, back screw out slightly.

Auxiliary Brake Shaft Lock Lever 25480A Adjustment.

Refer to photo No. 4.

1. Trip clutch and turn machine by hand to high point of auxiliary brake cam 585124, so that auxiliary brake shaft lock is fully engaged.
2. With this setting, adjust screw (A) in the auxiliary brake lock lever arm 25480A to just contact the plate on end of link 585118A.
3. Lock nut firmly.

Ratchet Cam 585180A Release Stop Screw (A) Adjustment.

Refer to photo No. 7 and diagram No. 1.

1. Turn machine by hand one full revolution until connecting rod is at high point.
2. Pull ratchet cam 585180A in direction shown on diagram No. 1. Make sure that staple dial return stop disc 25419 is against stop 25422.
3. Adjust screw (A) to make setting as shown at (B).
4. Lock nut firmly.

NOTE: If screw 25308 (diagram No. 1) is removed from Staple Dial Return Stop 25422 for any reason, make certain that spacer 585277 is in place between stop 25422 and bracket 25299A when parts are reassembled.

High Speed Disc Clutch Adjustment.

Refer to photos No. 5 and No. 6.

1. Loosen two screws in clutch fork 585380.
2. Raise clutch lever 585192A by hand until a measurement of 5/8" to 11/16" is obtained between the bottom of the head on the solenoid plunger and the top of the solenoid frame.

This cannot be done unless all backlash is taken out of the entire linkage.

3. Lock clutch fork 585380 when above setting has been obtained. After locking, check to see that the 5/8" to 11/16" measurement is maintained.
4. Adjust screw 585233 to permit lever 585192A to raise up approximately 1/16" further than the 5/8" to 11/16" solenoid setting. This is to allow for wear on clutch plates.
5. Tighten lock nut on screw 585233.
6. To readjust for clutch wear, loosen screws in clutch fork and adjust as per paragraphs 1, 2, 3, 4 and 5 above.

Setting of Tooth Clutch Step Feed Mechanism.

Refer to diagram No. 10.

1. With machine in idle and neutral position, have clutch fork 25591 loose on shaft.
2. Have fork 25591 firmly press the sliding member of tooth clutch into full engagement with stationary member of clutch 25438.
3. At the same time push on solenoid plunger (A) so that it is firmly seated. At this point, lock fork 25591 tightly on shaft.
4. Adjust stop screw 585276 so that when clutch is disengaged, an opening of approximately .035" to .040" as shown at (B) is obtained.
5. Spring 251354, in spring link assembly 585381A, must be adjusted to be strong enough to hold tooth clutch firmly engaged when doing long and heavy boxes. This adjustment is made by means of nut 251359. Be careful, however, that spring is not so strong that solenoid plunger cannot fully seat itself at end of stroke. This applies when the tooth clutch is being engaged and also when it happens that the teeth come on top of each other. In this case, the solenoid plunger must also seat itself, hence the spring must yield accordingly.

Auxiliary Throw Out Roller.

The auxiliary throw out roller 585349A (photo No. 12), is essential for transferring certain types of boxes from the stitcher to the conveyor. This applies particularly to small boxes and to any other type of box where unsatisfactory transfer of boxes to the conveyor is experienced.

This roller should not have too much pressure on the box as scuffing or crushing of box may occur.

To check pressure of roll on box, put machine in neutral and slide box by hand between roller 585349A and conveyor belt 85289 (photo No. 12). Box should push through easily with roller turning. If box shows signs of being crushed or excessive pressure is required to push box between roller and belt, the unit must be adjusted to reduce the pressure.

Adjustment of Auxiliary Throw Out Roller.

With machine in neutral, loosen screw (A) sufficiently so that lever 585348 (photo No. 12) is completely free on auxiliary brake shaft 585104A.

CAUTION: If lever 585348 is not completely free on shaft when adjustment is made, shaft 585104A may turn slightly which could cause the trip gauge and other parts on auxiliary brake shaft to be incorrectly set.

Raise or lower lever 585348 so that roller puts proper pressure on box when roller is in lowest position. Tighten screw (A) securely.

To take up any extra thickness as box passes under roll, a spring 11244 is provided. Loosen lock nuts (B) and adjust spring pressure for best operation. Do not allow spring 11244 to be adjusted to a solid condition.

Examination of roller will disclose that it is made in two pieces bolted together. The purpose of this is to permit removal of roller so that it can be placed on opposite side of Hold Down Bar 585364. This would be required in some cases for small panel boxes.

SETTING FOR LAST STAPLE REGISTER CAM AND SWITCH MECHANISM ON STITCHER

Refer to diagram No. 9.

Have machine in neutral position with main or master switch ON but the motor switch OFF. Press the top button on switch (A) (photo No. 10). This will release the brake so that the machine can be turned over by hand. Have Cam Lock Hub 585247 loose on shaft by loosening clamping screws. Be sure that Cam Lock 585246 is engaged in slot (C) of cam 585184A.

Turn machine over by hand until check pawl 585120 just clicks over tooth during the indexing of the second tooth or on the second down stroke of the connecting rod. In this position, turn Cam Lock Hub 585247 and Cam (A) 585184A so that cam lobe (D) contacts Cam Block 585173A and moves switch lever 585028A until 1/16" dimension is obtained as shown at (E). At this point adjust screw (F) in switch lever 585028A to energize stop count solenoid 85173, or No. 2 on cable diagram.

NOTE: Solenoid must stay energized when switch is contacted.

Bring machine back to neutral and run machine under power. Trip clutch and check to see that the 1/16" dimension referred to above is maintained during the stapling cycle. In other words, check to see that, as the second staple is driven, solenoid 85173 becomes energized, and stays energized during stapling cycle, to operate lever 585183A which stops Ratchet 585160 from indexing.

LAST STAPLE REGISTER EMERGENCY SWITCH

The left hand single push button switch located at the end of stitcher table is an emergency switch. It is used to stop the stitcher (when Last Staple Register Unit is in operation) stapling cycle in the event there is no box to contact the Last Staple Register Gate, or box does not reach gate, to shut off the machine.

LAST STAPLE REGISTER GATE UNLOCK ADJUSTMENT

Refer to photos No. 9 and No. 15. Note: Shut off all current.

With Last Staple Register Cams and switch mechanism properly set as described on page 10, adjust screw (E) (photo No. 9) as follows:

Have screw (E) operate switch LSX one tooth movement (of staple dial 585112A) after the inside lever 585028A has been depressed to operate its switch.

This will energize solenoid 85173, or No. 5 on cable diagram, to pull lever 585034A out of lock engagement with register gate. Put current on and check operation.

ADJUSTMENT OF SWITCHES LSG, LSZ AND LSGG ON LAST STAPLE REGISTER UNIT

(See photo No. 16.)

(a) Have machine set up for use with Last Staple Register Unit.

(b) Have machine in neutral position with the main or master switch ON but the motor switch OFF.

This will permit the solenoids to be energized so that last staple register switches can be properly set.

Adjustment of Gate Return Solenoid Switches LSG and LSGG

Refer to photo No. 16.

See that Cam Lever 585194 is in full upright position.

Screw (E) should be set so that switch LSGG is not operated in this position, but does operate the switch at the first movement downwardly of Cam Lever 585194.

See that screw (D) does not operate switch LSG when Cam Lever 585193A is in neutral or off position.

See that register gate 585036 is in neutral and locked position and that solenoid No. 6 (photo No. 15) is energized to hold gate in place.

Adjust screw (D) so that when finger and cam 585193A (photo No. 14) has been moved into and approximately flush with recess in gate, the switch LSG will be operated to de-energize the solenoid acting to hold gate in vertical position.

Adjustment of Staple Resume Count Switch LSZ

See Notes (a) and (b) above.

Before this adjustment is made, check to see that the Screws (D) and (E), (Photo No. 16) are in neutral position, i.e.: The Screws do not operate Switches LSG and LSGG.

The above applies to either the original style as per Photo No. 16 or the improved style of Switch operation, as shown on Diagram, Page 28A.

Refer to Photo No. 16, Page 28, and Diagram, Page 28A.

For the improved style of Switch Operation use Sections 1 and 2 below. For the original style of Switch operation, use Section 1 only.

1. Move Cam Lever 585193A into recess in Gate 585036. This will operate Switch LSG to de-energize Solenoid No. 6 (Photo No. 15), releasing Gate 585036. Push Gate back until Gate touches the Register Gate Latch, part 585204 (Photo No. 15) With Gate in this position, continue to push Gate against Spring 585250 and adjust Screw (F) so that Switch LSZ will just break contact when Spring 585250 has been approximately one half compressed.
2. Adjust Screw "B", (Diagram, Page 28A) so that Screw "F" just contacts the Switch Plunger without depressing the Plunger when Trigger "A" is not in contact with Operating Cam. Torsion Spring (C), (Diagram, Page 28A) should be adjusted only to minimum amount necessary to keep Trigger (A) in correct position as shown.

After making the above adjustments, clearance between Trigger and Cam must be checked as follows:

Release Gate Latch and Push Gate 585036 down to a position so that Cam Block 585226 is adjacent to Trigger "A". See Diagram, Page 28A.

When Cam Trigger "A" is depressed as far as it will go in direction indicated by arrow, a gap of .015" to .025" should be obtained to insure that Trigger "A" can return to neutral position.

ADJUSTMENT OF HOLD DOWN BAR 585364

Refer to photos Nos. 12, 13 and 14.

This bar is used to prevent the front or leading edge of the stitched boxes from going over the top of the Last Staple Register Gate 585036.

The bar should be adjusted as follows:

1. Turn stitcher over by hand until high point of Auxiliary Brake Cam 585124 (photo No. 4) has caused auxiliary brake shaft to lift trip gauge target in up position.
2. Lever 585266A (photo No. 12) is adjustable on the auxiliary brake shaft. Lever 585262A is adjustable up and down at (A) (photo No. 13).
3. By means of these adjustments, set bar 585364 so that the bottom of the bar is approximately flush with the top of the register gate 585036. Bar should meet this condition for the entire maximum and minimum setting of the register gate.
4. Bring machine back to neutral position.

NOTE:—In cases where the stitched box is so small that it won't span the conveyor belts, the following procedure should be carried out.

1. Remove the entire Last Staple Register unit.

CAUTION:—When removing this unit, be careful not to drop the unit or otherwise damage it.

2. Move one or both conveyor belts closer together as required. Means for adjusting the belts have been provided by slots at each end of the belt units.
3. Removal of the Last Staple Register Unit requires setting the stitcher for the Dial or Counter system or method of operation. See section entitled, "Dial or Counter Method of Setting machine for number of staples required", page 3.

STITCHING WIRE

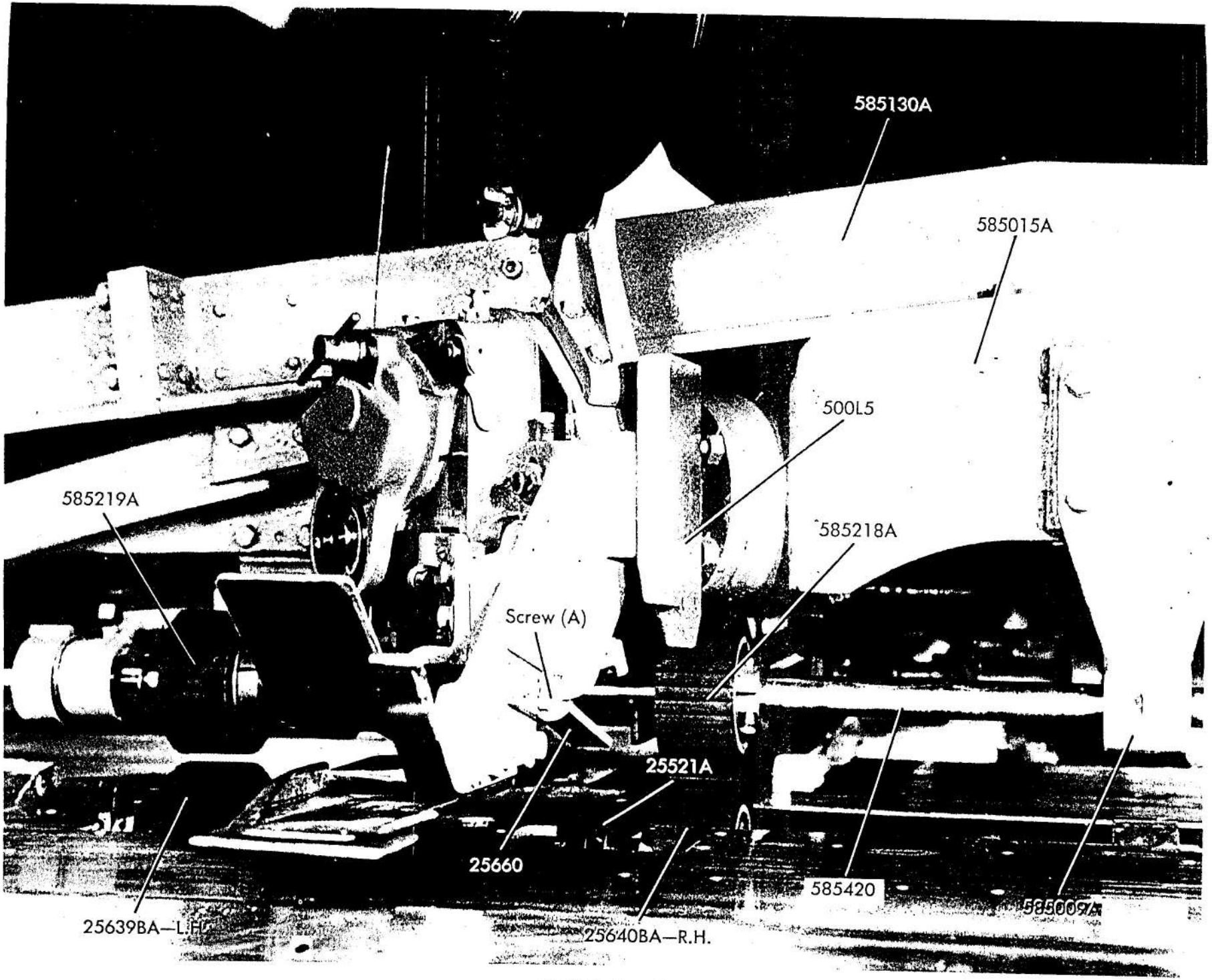
It is essential that a suitable size of stitching wire be employed for the work at hand. If wire is too light, it will buckle and will not penetrate the stock.

Wire must be of good quality and of proper hardness, otherwise it will bend or buckle.

Wire must not be oversize or it will stick in the formers and driver and refuse to feed.

Wire must be clean, without rough edges. The latter will wear the wire tubes and former grooves unduly. Some coated wire flakes off particles, which collect in the wire tubes and may even clog them completely, in which case, they should be removed and cleaned by inserting a piece of round wire and pushing out the plug.

NOTES


585130A
585015A
500L5
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585218A
Screw (A)
25521A
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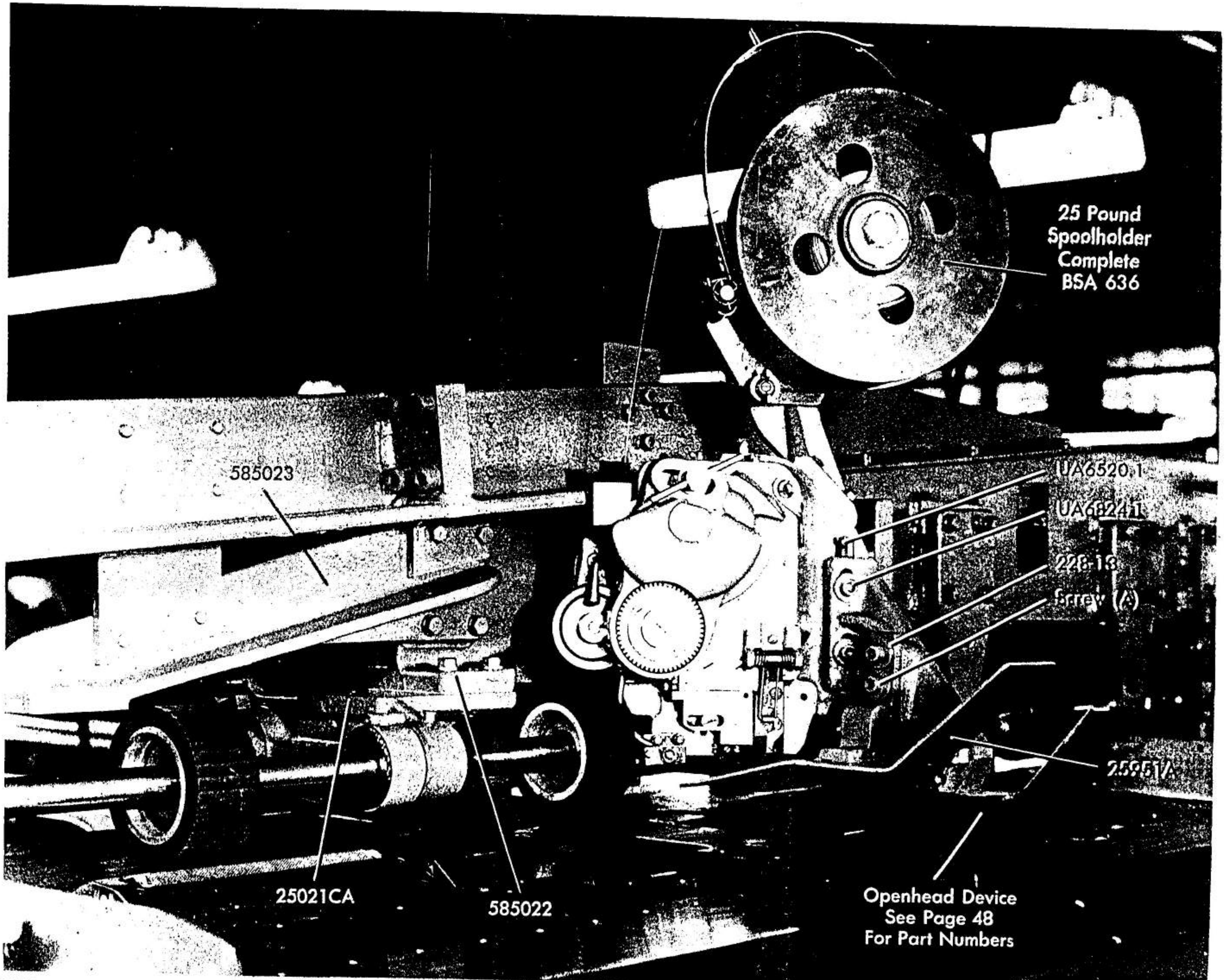
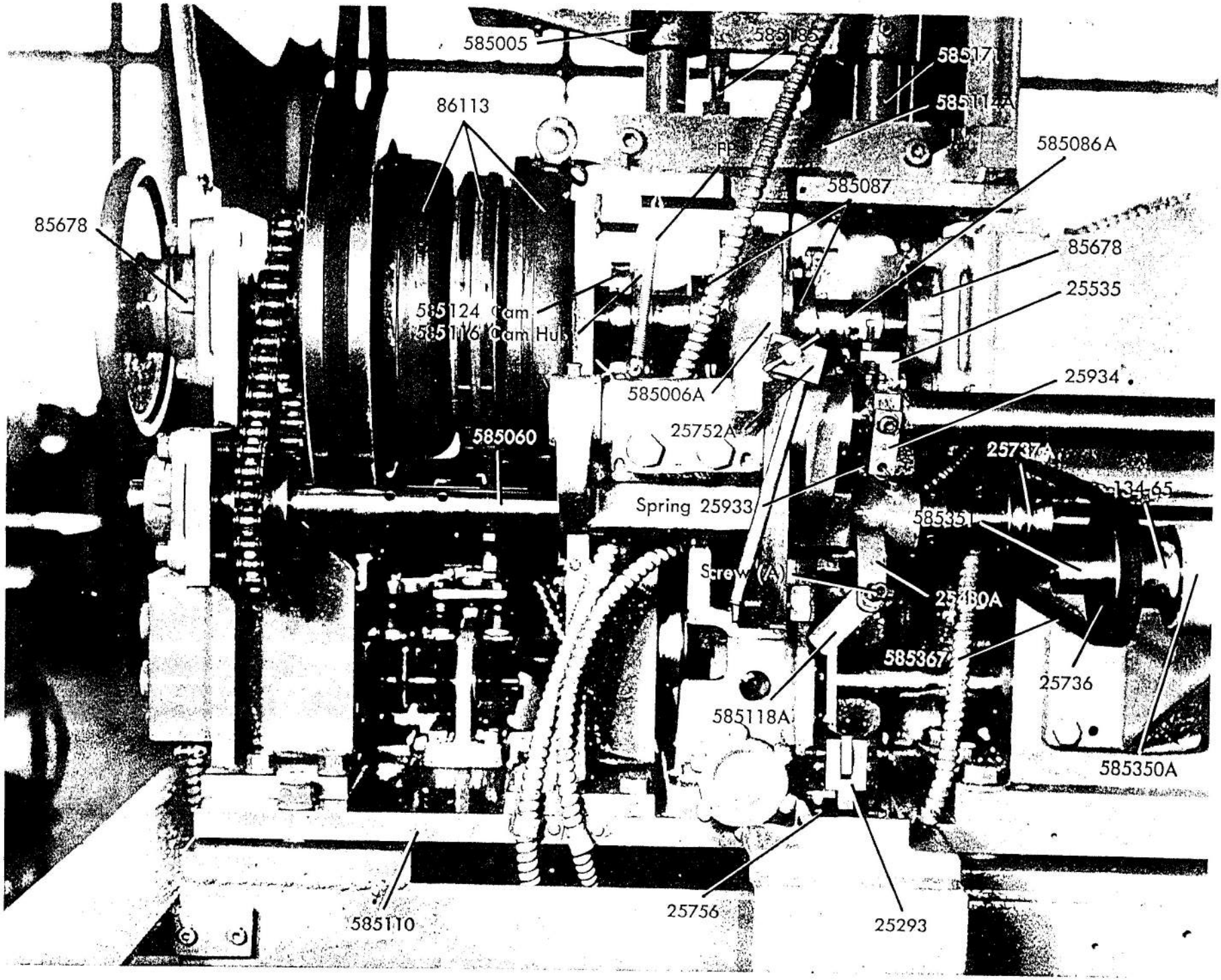
585420
25639BA—L.H.
25640BA—R.H.

PHOTO No. 1


25 Pound
Spoolholder
Complete
BSA 636
585023
UA6520.1
UA6824.1
228-13
Screw (A)
25951A
25021CA
585022
Openhead Device
See Page 48
For Part Numbers


585005
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85678
585124 Cam
585116 Cam Hub
585060
585086A
585087
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Spring 25933
585350A
585118A
585110
25756
25293
25736

PHOTO No. 4

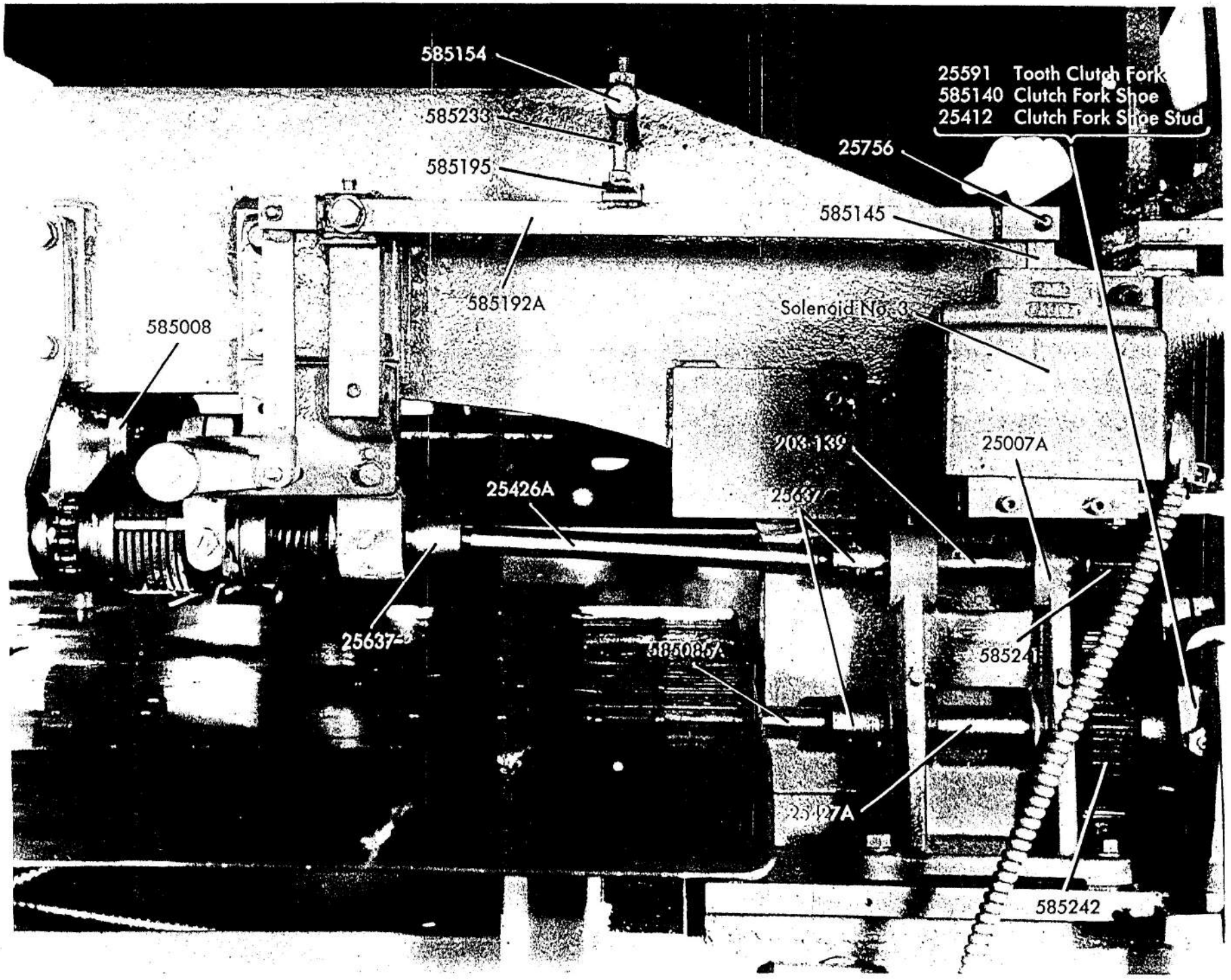
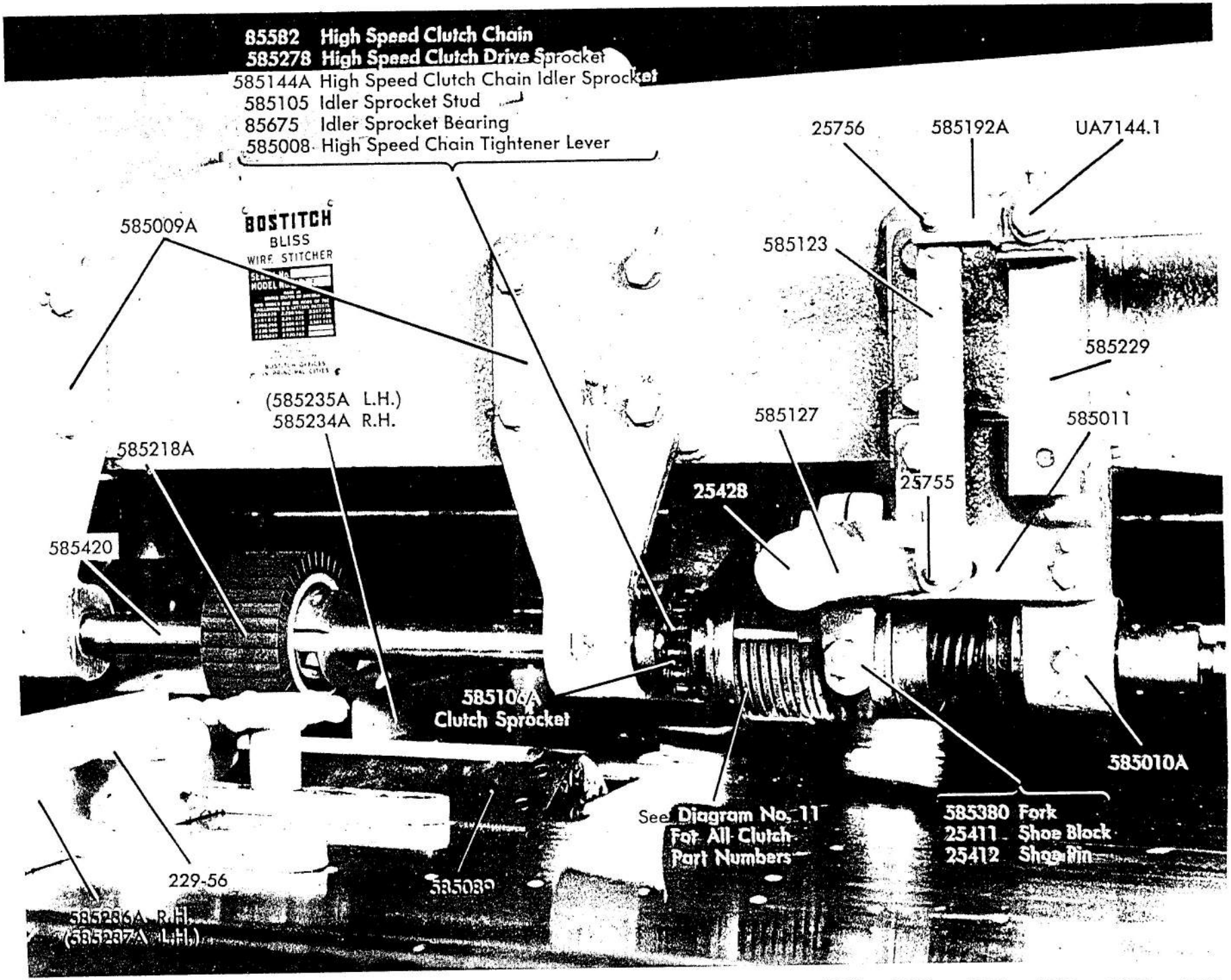

585154
585233
585195
585192A
585008
25591 Tooth Clutch Fork
585140 Clutch Fork Shoe
25412 Clutch Fork Shoe Stud
25756
585145
Solenoid No. 3
203-139
25007A
25426A
25637
585242

PHOTO No. 5


85582 High Speed Clutch Chain
585278 High Speed Clutch Drive Sprocket
585144A High Speed Clutch Chain Idler Sprocket
585105 Idler Sprocket Stud
85675 Idler Sprocket Bearing
585008 High Speed Chain Tightener Lever
25756
585192A
UA7144.1
585009A
BOSTITCH
BLISS
WIRE STITCHER
585123
585229
(585235A L.H.)
585234A R.H.
585127
585011
585218A
25428
25755
585420
585106A
Clutch Sprocket
585010A
See Diagram No. 11
For All Clutch
Part Numbers
585380 Fork
25411 Shoe Block
25412 Shoe Pin
229-56
585088
585286A R.H.
(585287A L.H.)

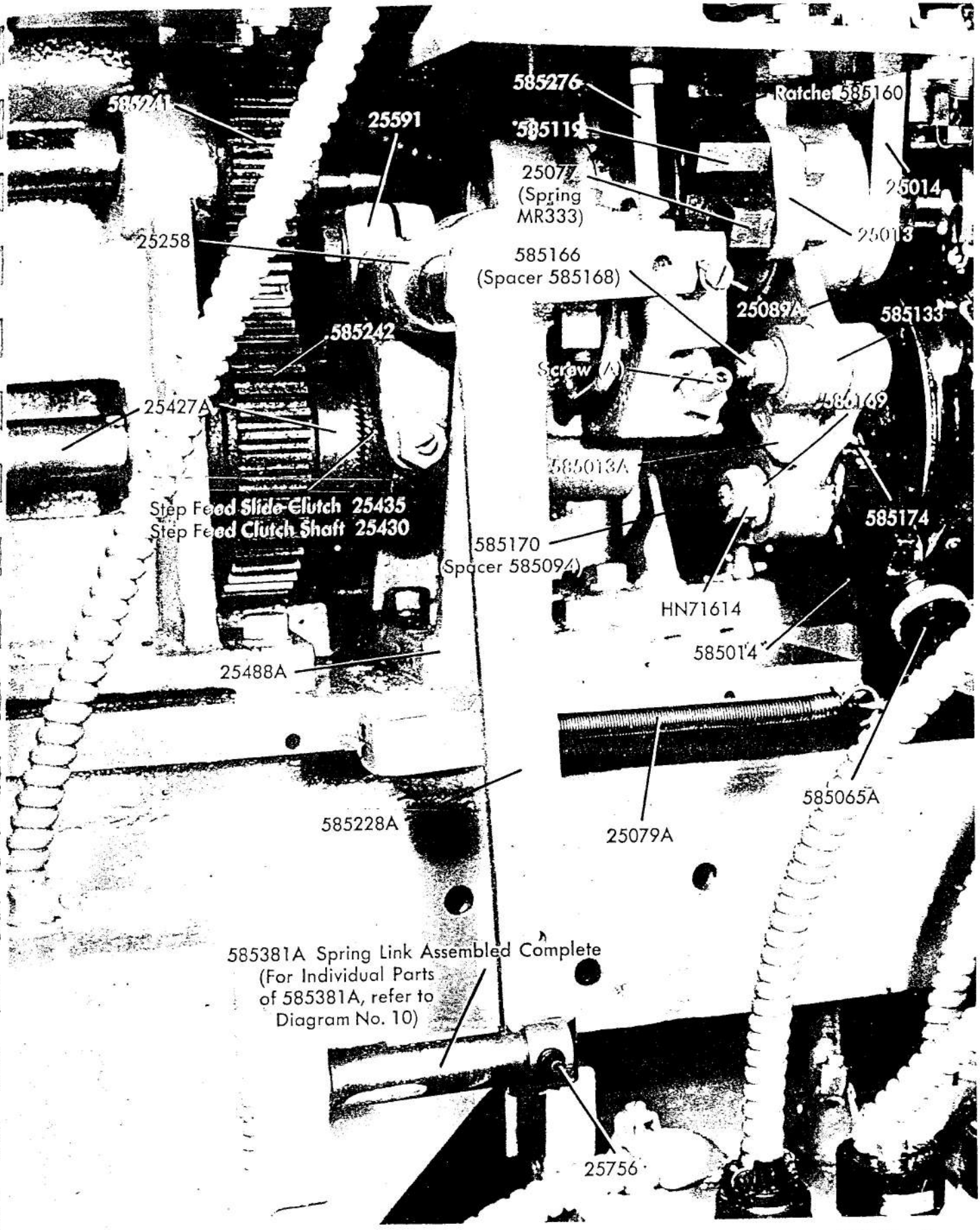
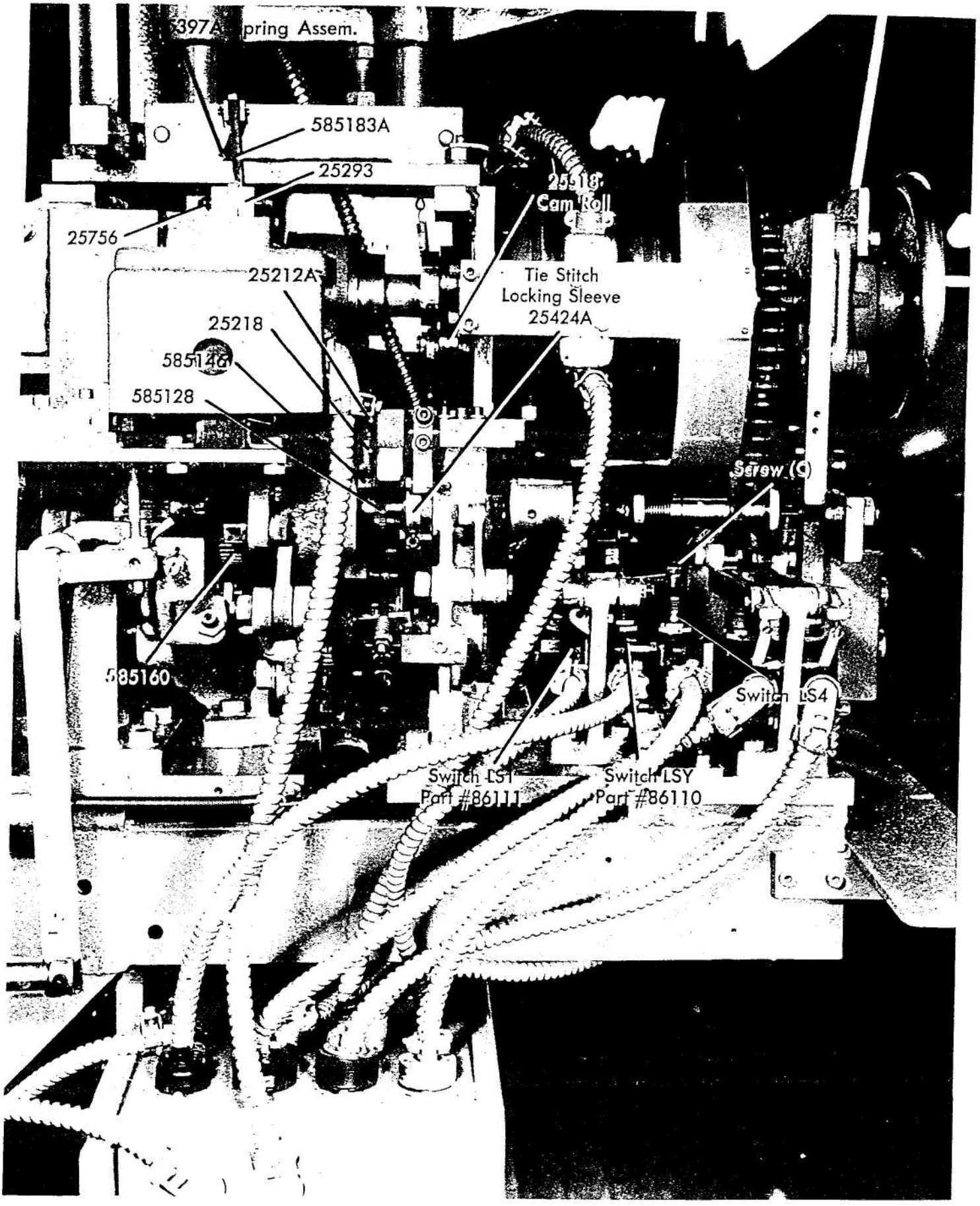

585276
Ratchet 585160
585241
25591
585119
25077
(Spring
MR333)
25014
25013
25258
585166
(Spacer 585168)
25089A
585133
585242
Screw (A)
25427A
586169
585013A
Step Feed Slide Clutch 25435
Step Feed Clutch Shaft 25430
585174
585170
(Spacer 585094)
HN71614
585014
25488A
585065A
585228A
25079A
585381A Spring Link Assembled Complete
(For Individual Parts
of 585381A, refer to
Diagram No. 10)
25756

PHOTO No. 7


397A Spring Assem.
585183A
25293
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25212A
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585128
25518
Cam Roll
Tie Stitch
Locking Sleeve
25424A
Screw (C)
585160
Switch LS4
Switch LS1
Part #86111
Switch LSY
Part #86110

PHOTO No. 8

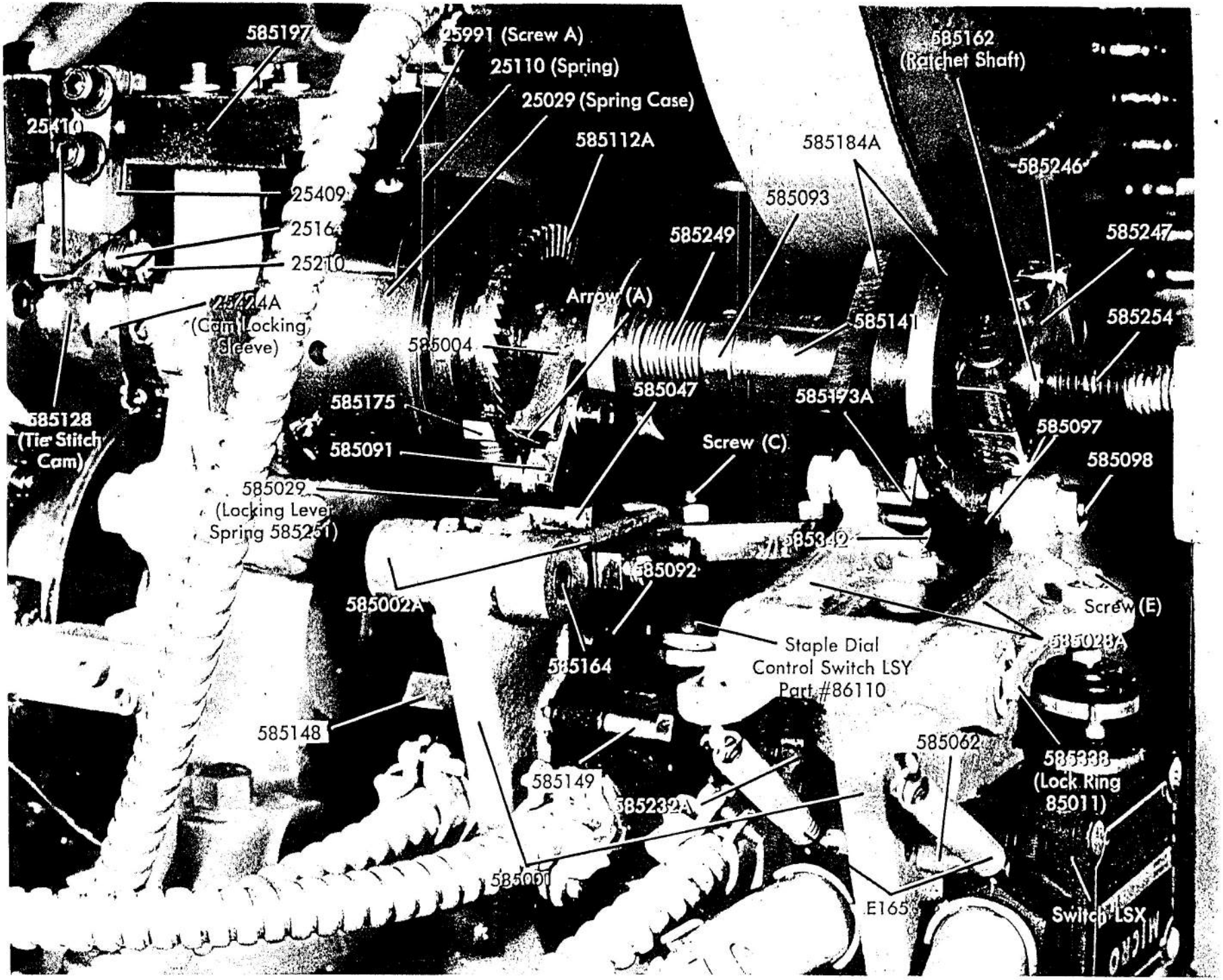

585197
25991 (Screw A)
25110 (Spring)
25029 (Spring Case)
585162
(Ratchet Shaft)
25410
585112A
585184A
585246
25409
585093
25164
585249
585247
25210
Arrow (A)
25224A
(Cam Locking
Sleeve)
585141
585254
585004
585047
585175
585193A
585128
(Tie Stitch
Cam)
585091
Screw (C)
585097
585098
585029
(Locking Lever
Spring 585251)
585342
585092
585002A
Screw (E)
585028A
Staple Dial
Control Switch LSY
Part #86110
585164
585148
585062
585338
(Lock Ring
85011)
585149
585232A
585001
E165
Switch LSX

PHOTO No. 9

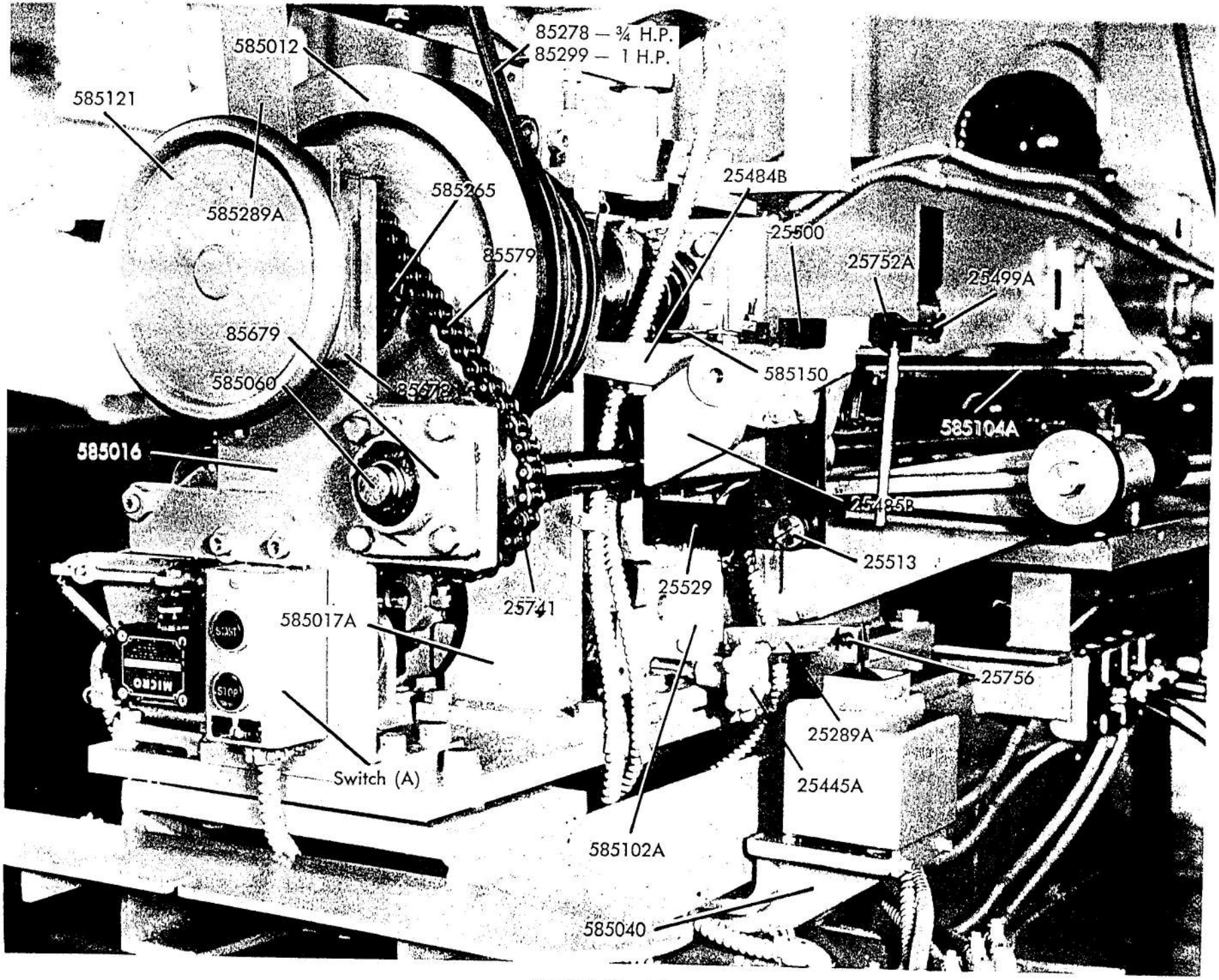

585012
85278 — ¾ H.P.
85299 — 1 H.P.
585121
585289A
585265
25484B
25500
25752A
25499A
85579
85679
585150
585060
585104A
585016
25485B
25513
25529
25741
585017A
25756
25289A
25445A
Switch (A)
585102A
585040

PHOTO No. 10

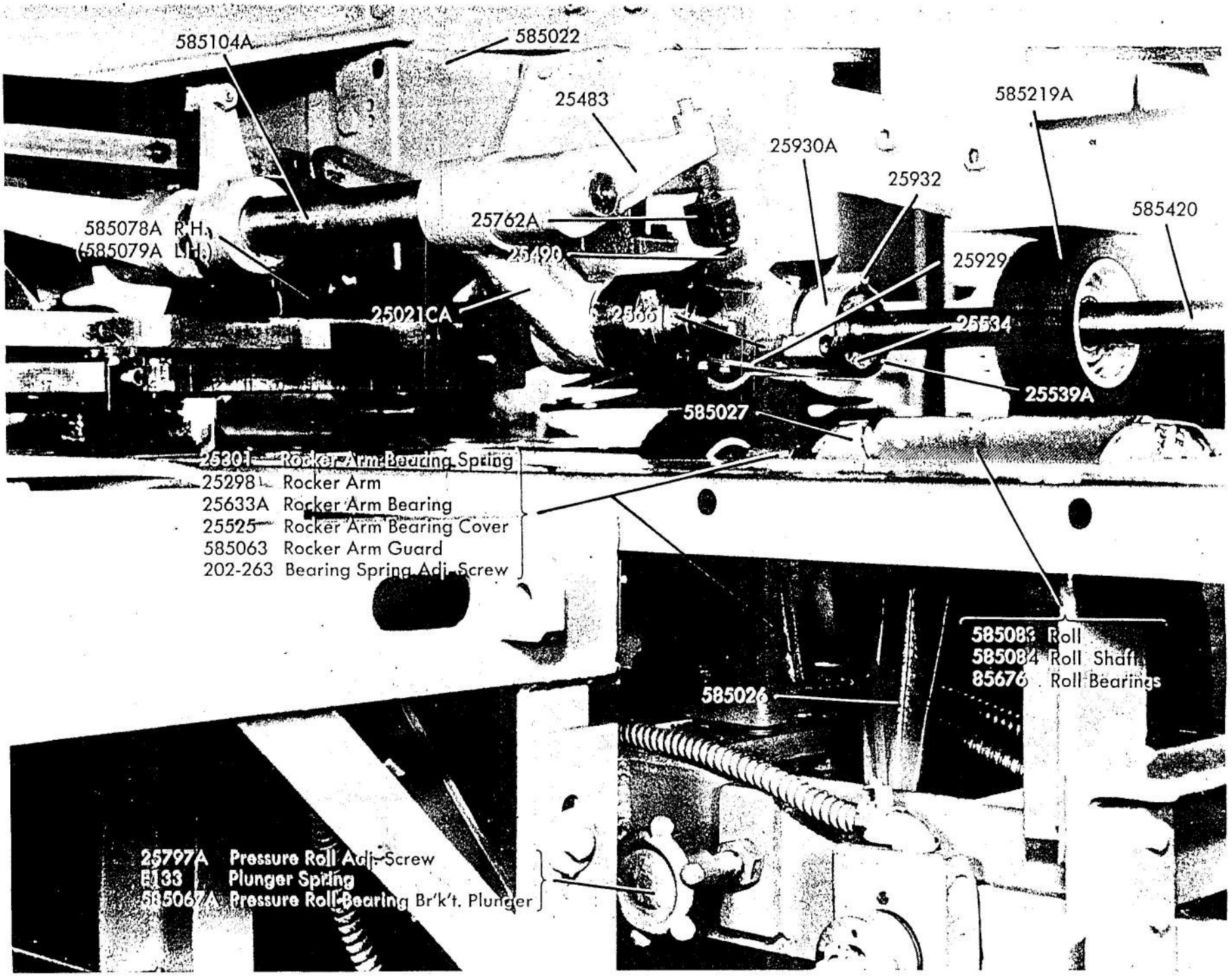

585104A
585022
25483
585219A
25930A
25932
585420
585078A R.H.
(585079A L.H.)
25762A
25490
25929
25021CA
25534
25539A
585027
25301 Rocker Arm Bearing Spring
25298 Rocker Arm
25633A Rocker Arm Bearing
25525 Rocker Arm Bearing Cover
585063 Rocker Arm Guard
202-263 Bearing Spring Adj. Screw
585083 Roll
585084 Roll Shaft
85676 Roll Bearings
585026
25797A Pressure Roll Adj. Screw
E133 Plunger Spring
585067A Pressure Roll Bearing Br'k't. Plunger

PHOTO No. 11

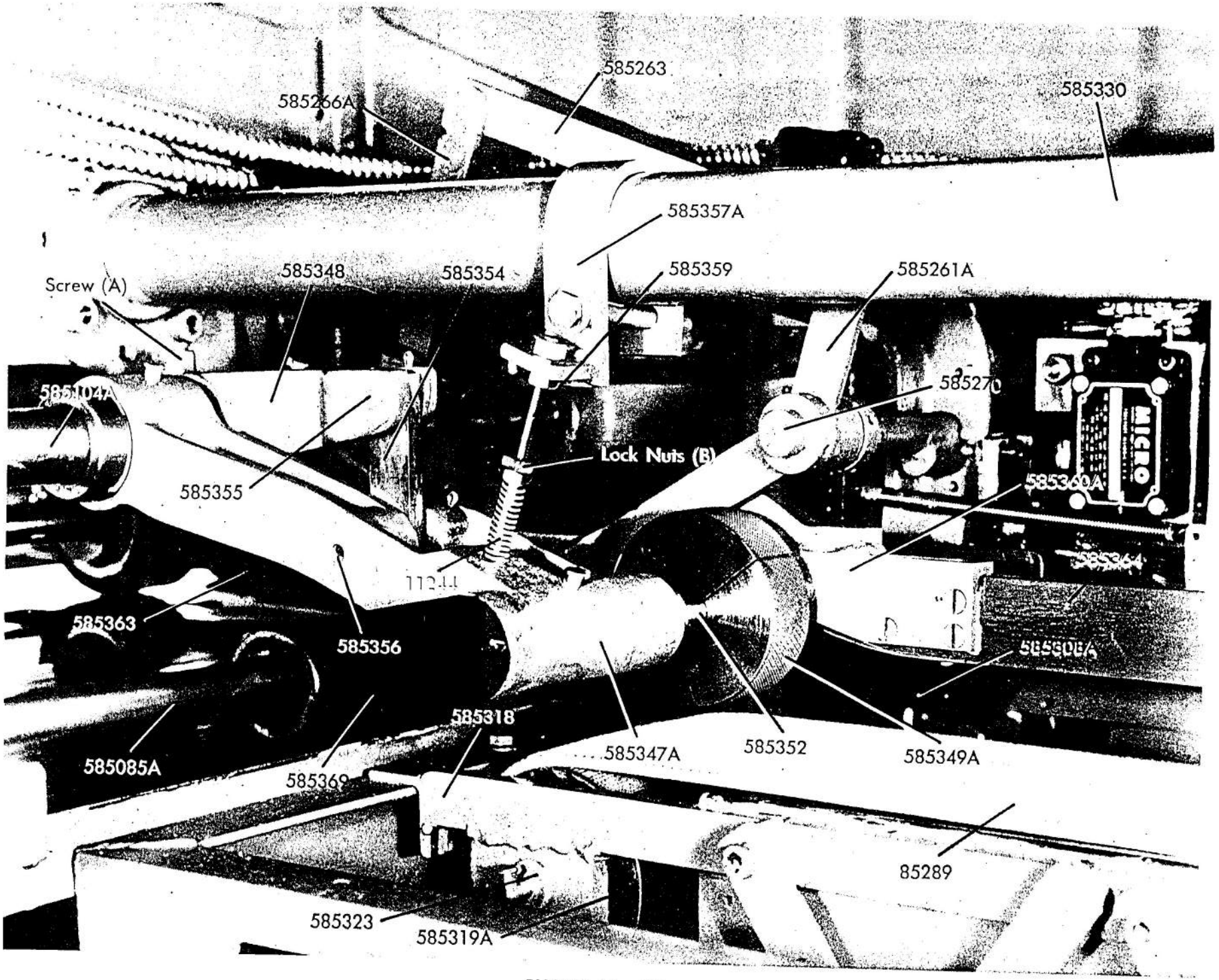

585263
585330
585266A
585357A
585348
585354
585359
585261A
Screw (A)
585270
Lock Nuis (B)
585355
585360A
585363
585356
585318
585085A
585369
585347A
585352
585349A
85289
585323
585319A

PHOTO No. 12

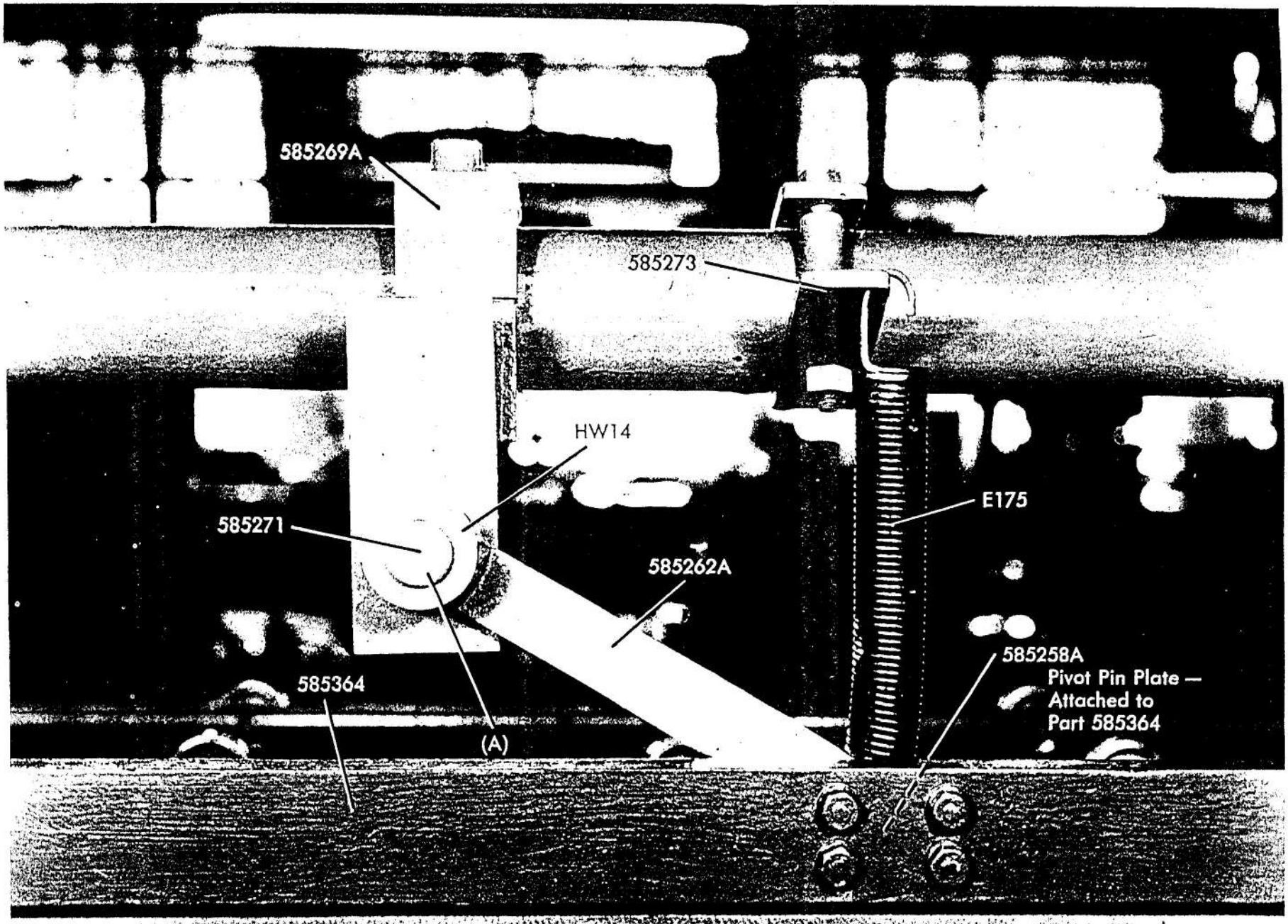

585269A
585273
HW14
E175
585271
585262A
585258A
Pivot Pin Plate —
Attached to
Part 585364
585364
(A)

PHOTO No. 13

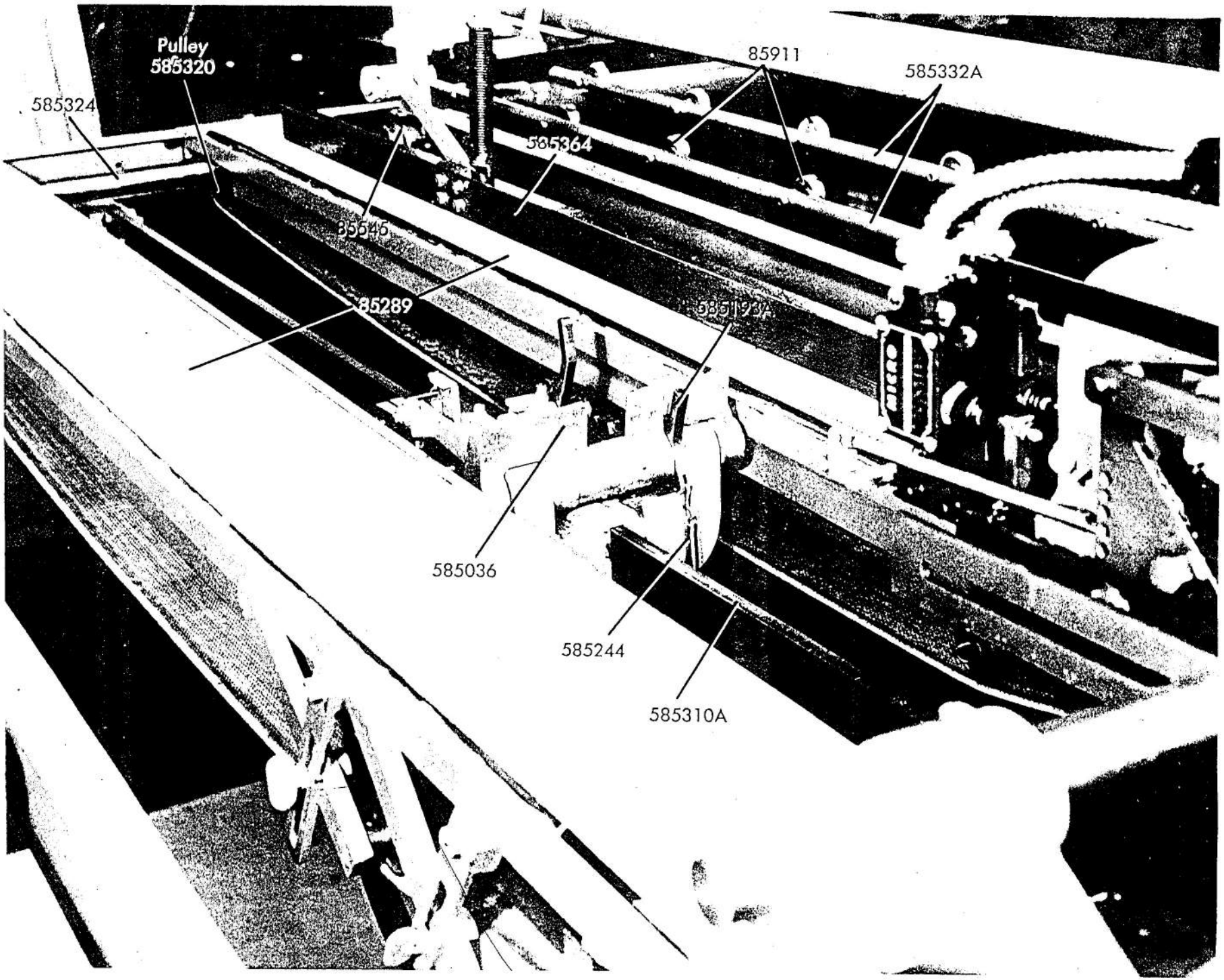

Pulley
585320
585324
85911
585332A
585364
85545
85289
585193A
585036
585244
585310A

PHOTO No. 14

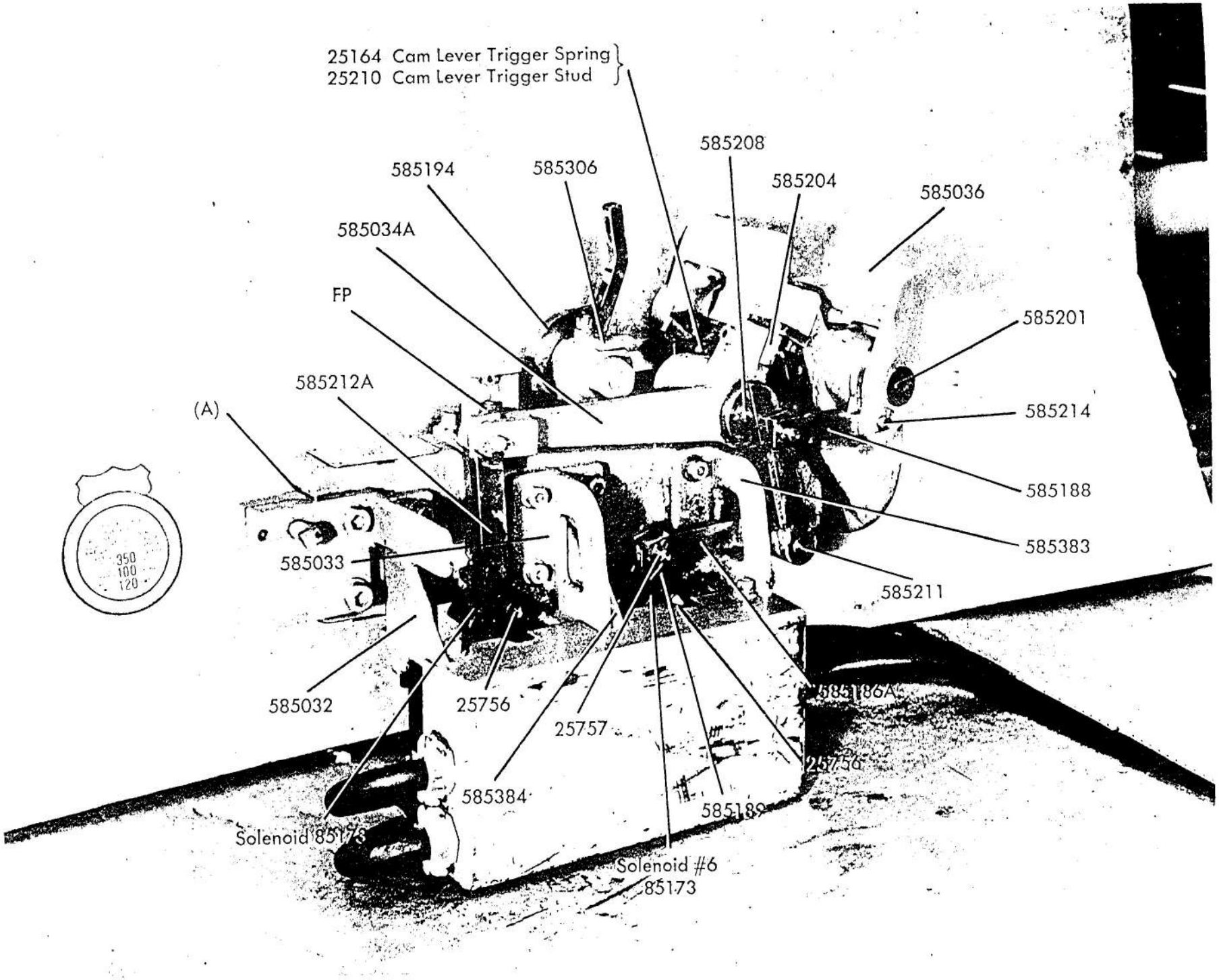

25164 Cam Lever Trigger Spring
25210 Cam Lever Trigger Stud
585208
585194
585306
585204
585036
585034A
FP
585201
585212A
(A)
585214
585188
585383
585033
585211
585032
25756
25757
585186A
25756
585384
585189
Solenoid 85173
Solenoid #6
85173

PHOTO No. 15

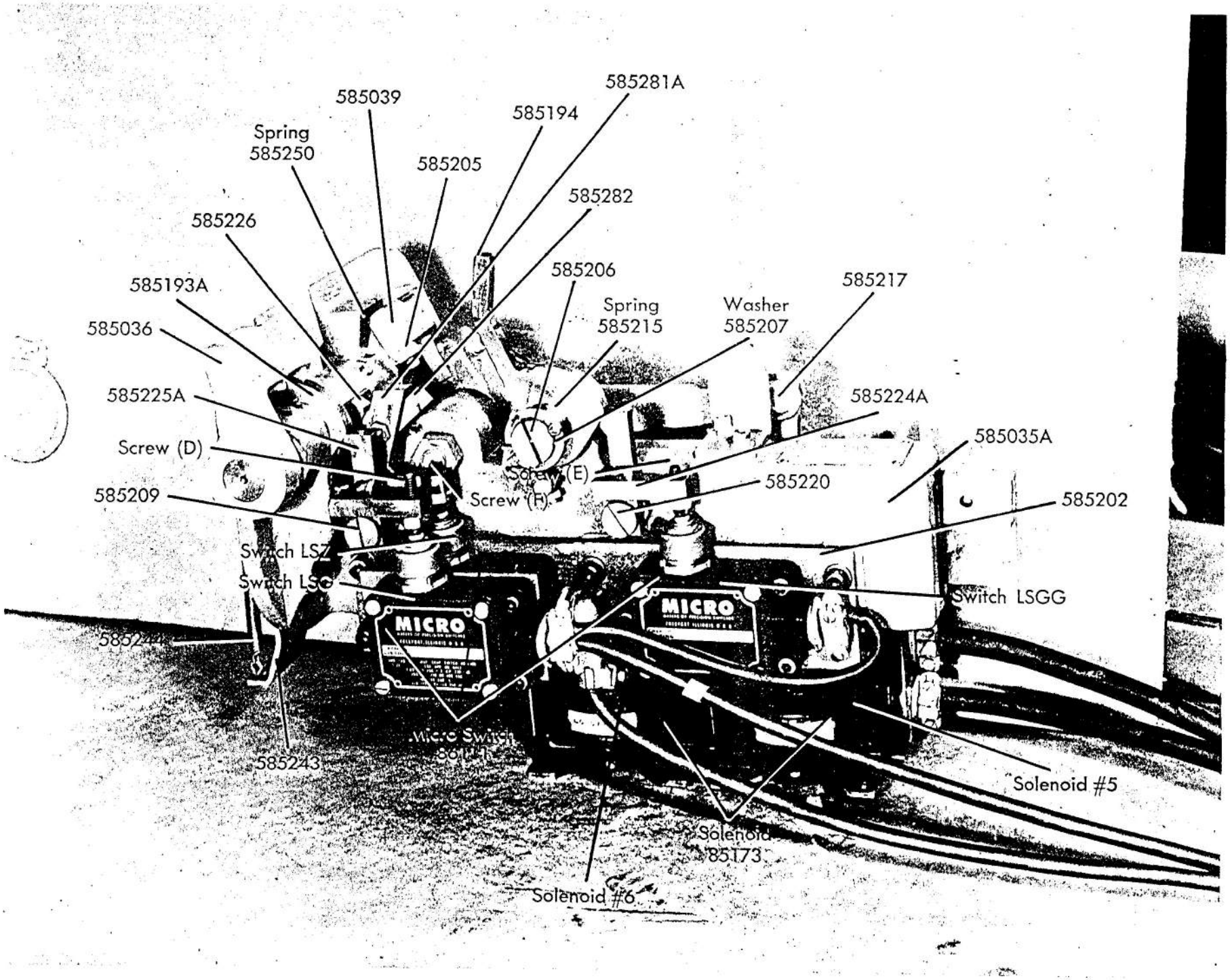
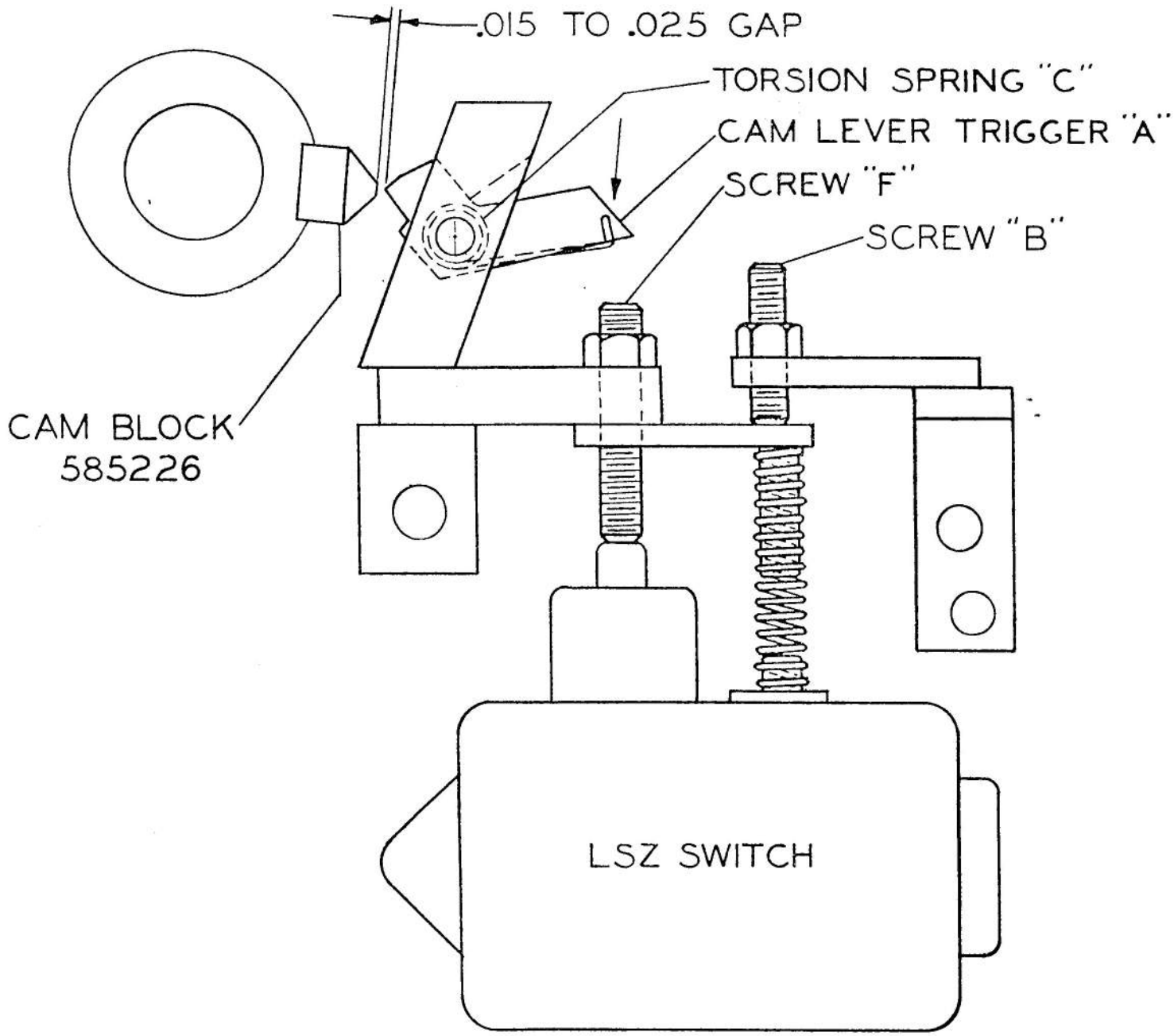
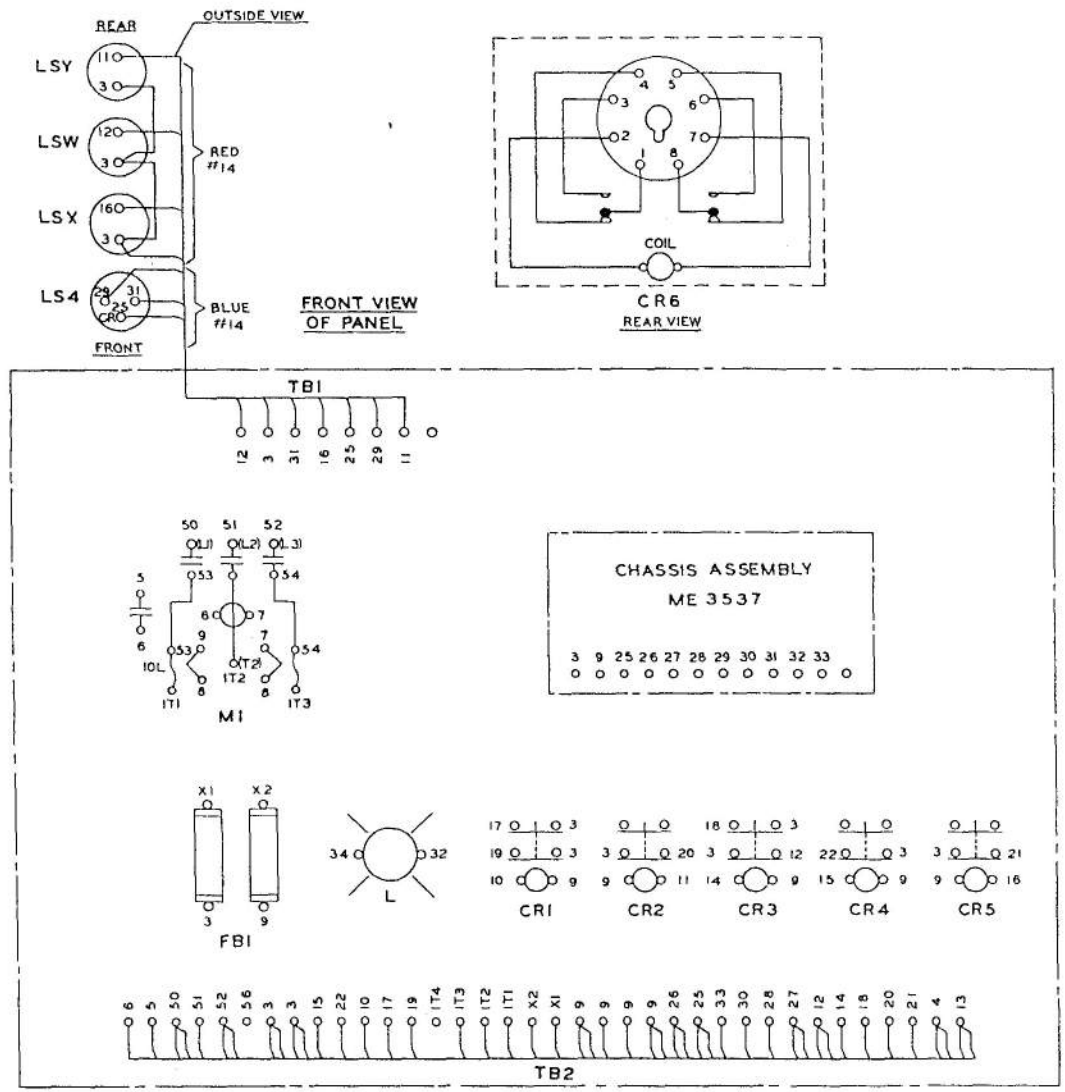

585281A
585039
585194
Spring
585250
585205
585282
585226
585206
585193A
585217
Spring
585215
Washer
585207
585036
585225A
585224A
585035A
Screw (D)
Screw (E)
585220
585209
Screw (F)
585202
Switch LSZ
Switch LSC
Switch LSGG
585244
MICRO
MICRO
Micro Switch
585243
Solenoid #5
Solenoid
85173
Solenoid #6

PHOTO No. 16



LAST STAPLE RESUME COUNT SWITCH DIAGRAM



PANEL INTERNAL CONNECTIONS

WIRE	DEVICE	SIZE	COLOR	WIRE	DEVICE	SIZE	COLOR
X1	TB2-FB1	14	R	11	TB1-CR2	14	R
X2	TB2-FB1			12	TB1-CR3		
3	TB2-TB2				CR3-TB2		
	TB2-FB1			14	TB2-CR3		
	FB1-PCU			15	TB2-CR4		
	PCU-CR5			16	TB1-CR5		
	CR5-CR4			17	TB2-CR1		
	CR4-CR1			18	TB2-CR3		
	CR1-CR1			19	TB2-CR1		
	CR1-CR2			20	TB2-CR2		
	CR2-CR3			21	TB2-CR5		
	CR3-CR3			22	TB2-CR4		R
	CR3-TB1			25	TB1-PCU		BL
5	TB2-M1				PCU-TB2		
6	TB2-M1			26	TB2-PCU		
	M1 -M1			27	TB2-PCU		
7	M1 -10L			28	TB2-PCU		
8	10L -10L			29	TB1-PCU		
9	TB2-TB2			30	TB2-PCU		
	TB2-TB2			31	TB1-PCU		
	TB2-TB2			32	L -PCU		
	TB2-PCU			33	TB2-PCU		
	PCU-FB1			34	L -PCU	14	BL
	FB1-10L			50	TB2-M1	12	B
	10L -CR1			51	TB2-M1		
	CR1-CR4			52	TB2-M1		
	CR4-CR5			53	M1 -10L		
	CR5-CR2			54	M1 -10L		
	CR2-CR3			IT1	TB2-10L		
10	TB2-CR1	14	R	IT2	TB2-M1		
				IT3	TB2-10L	12	B

NOMENCLATURE	BOSTITCH PART NUMBERS
C1,C2 CAPACITORS	86186
CR1,2,3,4,5-CONTROL RELAYS-ALLEN BRADLEY	86181
CR6 CONTROL RELAY-POTTER BRUMFIELD	86185
RELAY SOCKET-AMPHENOL	86187
FB1-FUSE BLOCKS	86192
BUSS FUSE	86195
LAMP SOCKET	86188
M1-LINE CONTACTOR-MAGNETIC STARTER SWITCH	86180
P1,2-POTENTIOMETERS	86184
R1,2-RECTIFIERS	86183
SW1-OVEREXCITATION TOGGLE SWITCH	86189
TB1,2-TERMINAL BOARDS	86190
TB3-TERMINAL BOARD	86248
TRANS.1 2-TRANSFORMERS 10L-OVERLOADS	86182
LS4-HUBBELL 3 WIRE FLUSH BASE	86193
LSW,LSX,LSY-HUBBELL 2WIRE FLUSH BASE	86194
FUSE HOLDER-GENERAL ELECTRIC	86247

COLOR CODE

AC CONTROL-RED (R)
DC CONTROL-BLUE (BL)
AC POWER-BLACK (B)

CONTROL BOX INTERNAL CONNECTIONS—585 STITCHER

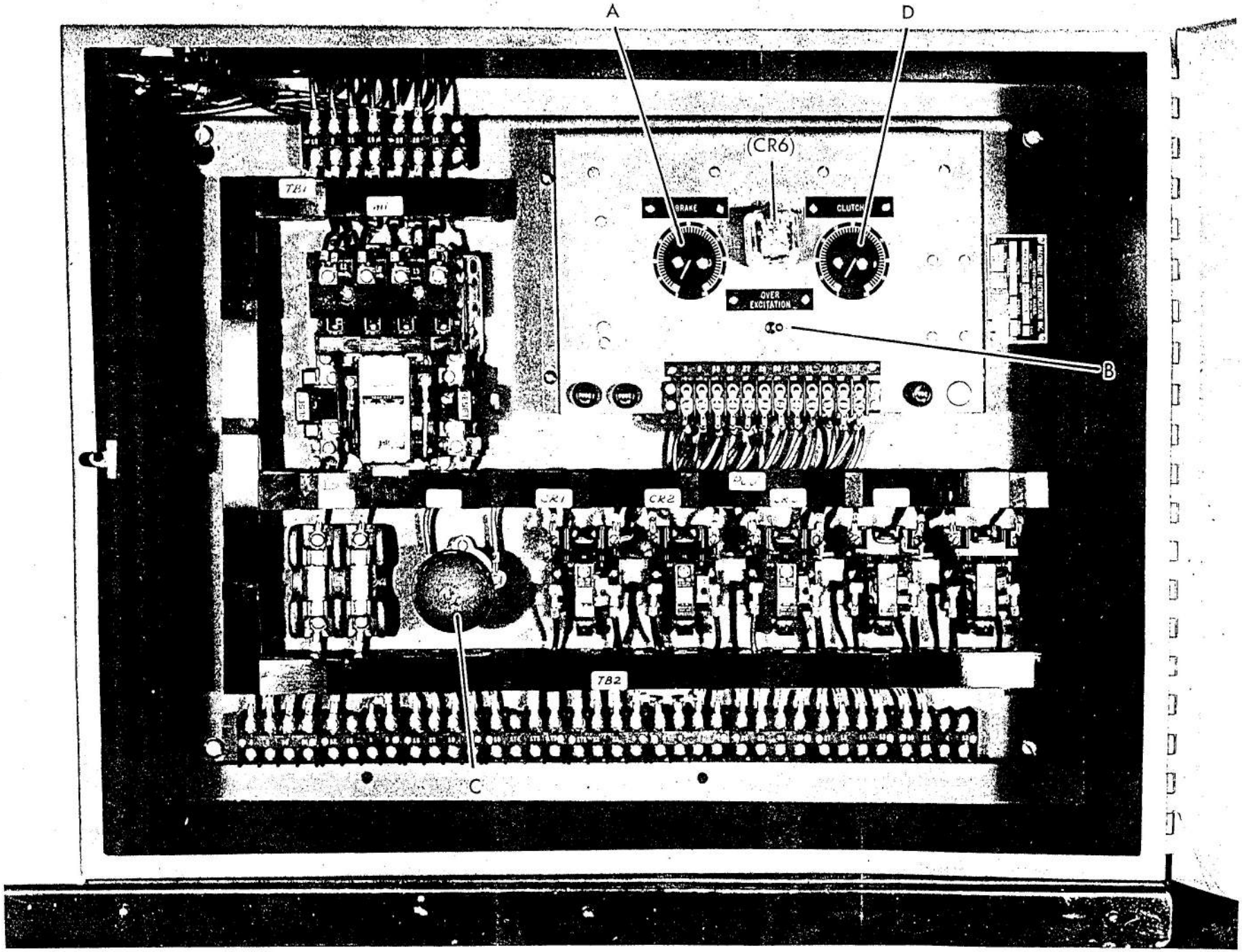
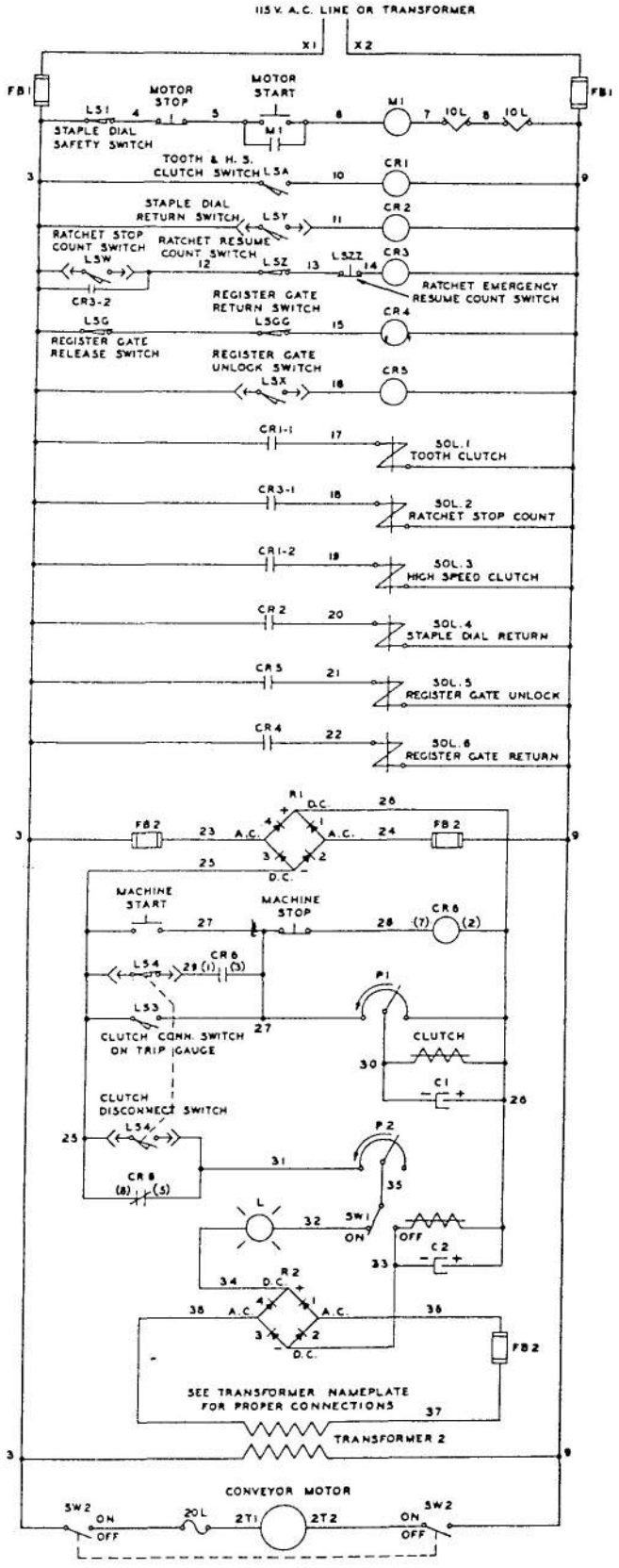
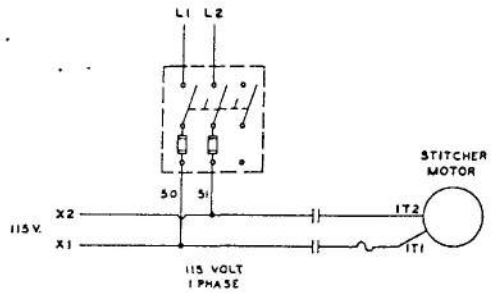
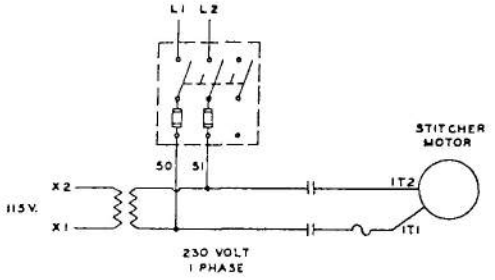
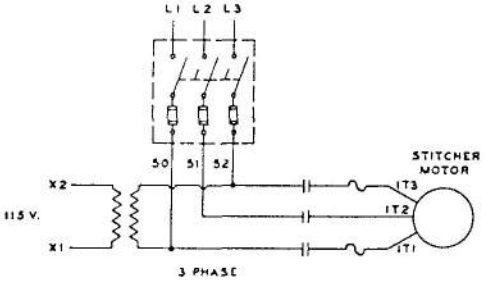


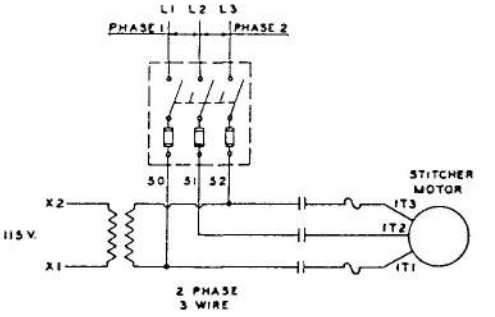
PHOTO No. 17

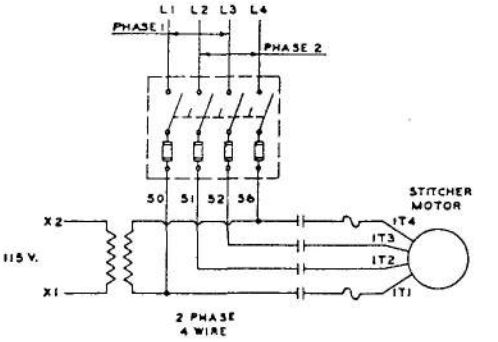




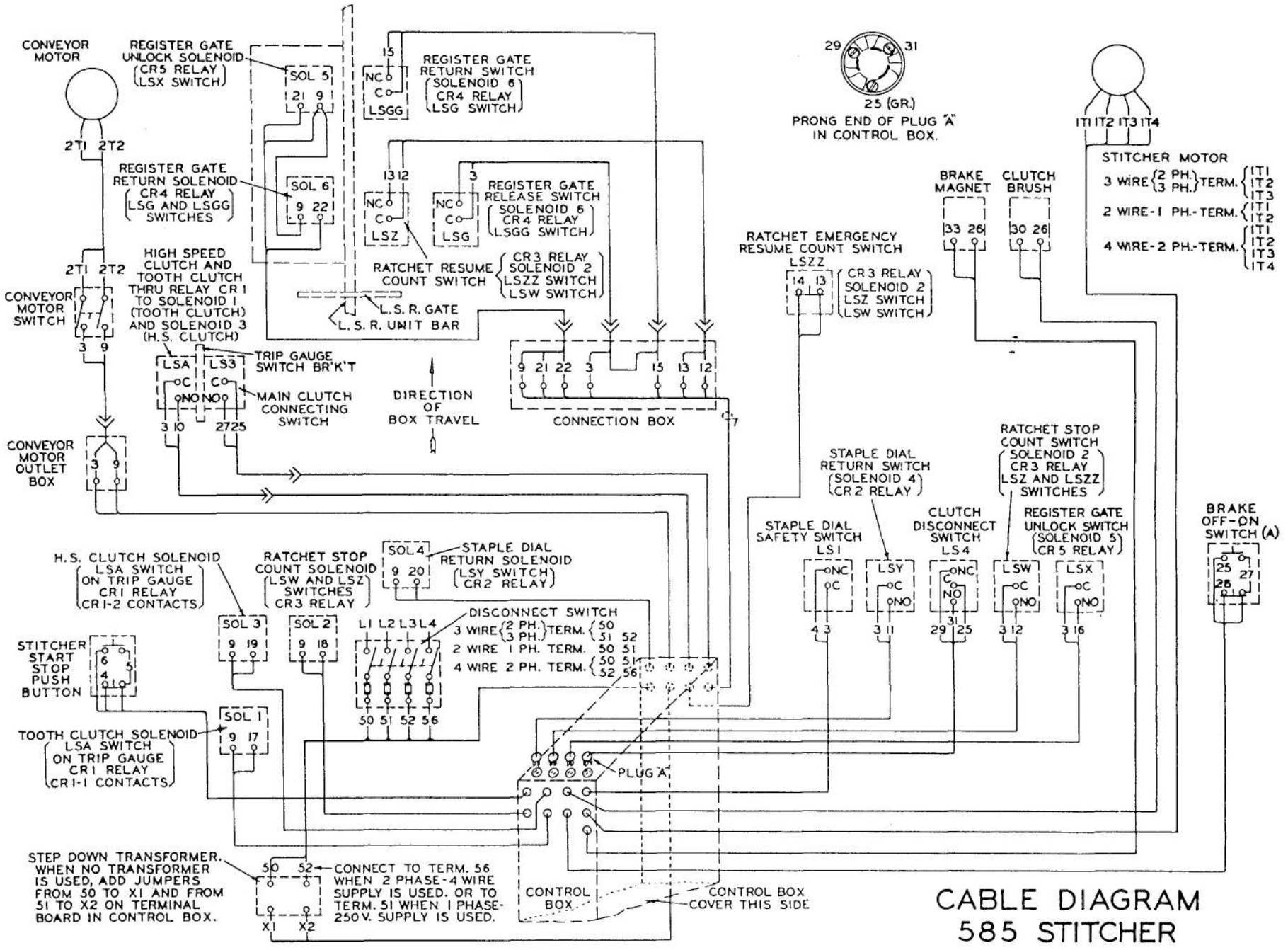








ELEMENTARY WIRING DIAGRAM
585 STITCHER



CABLE DIAGRAM
585 STITCHER

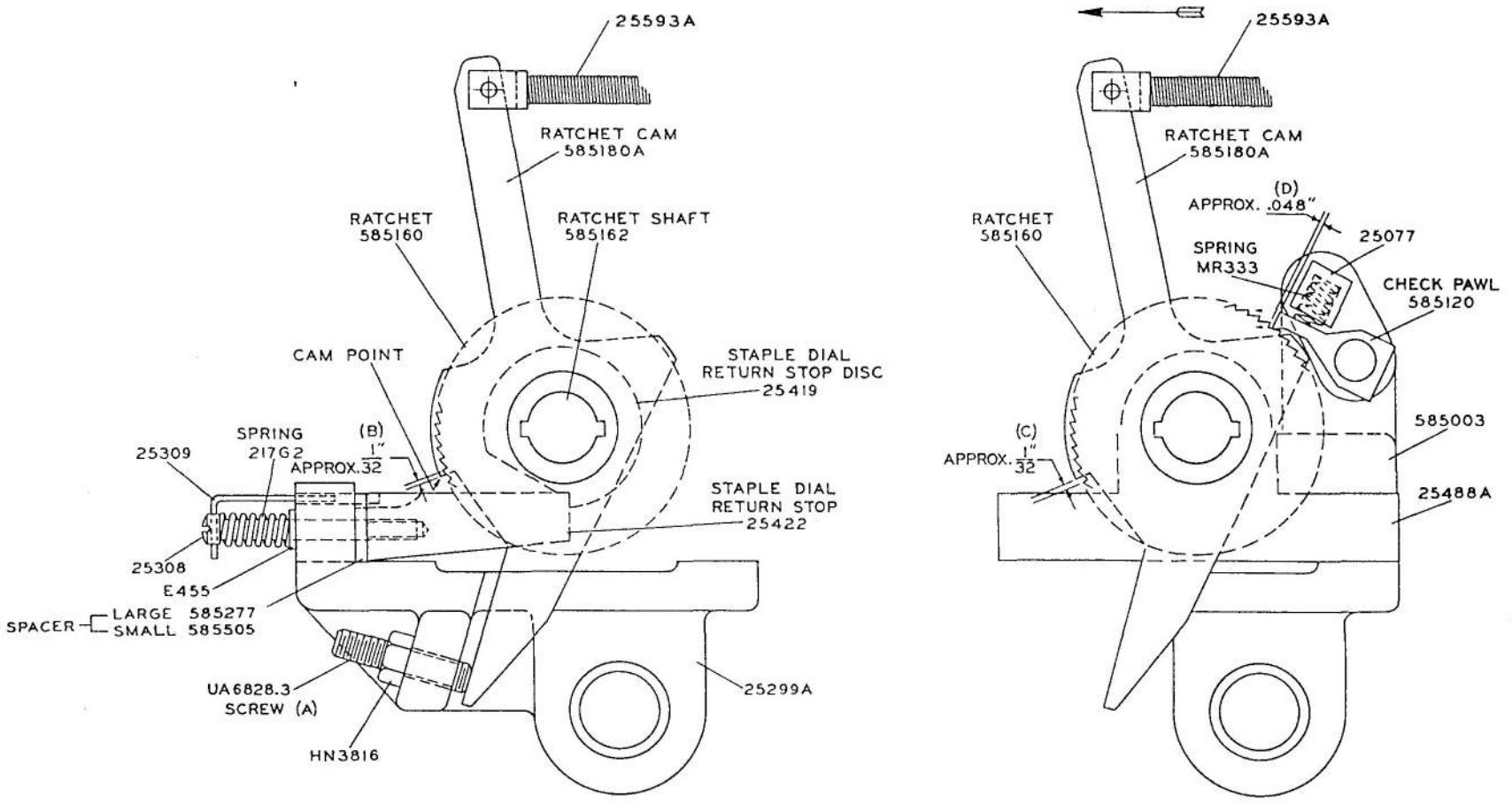
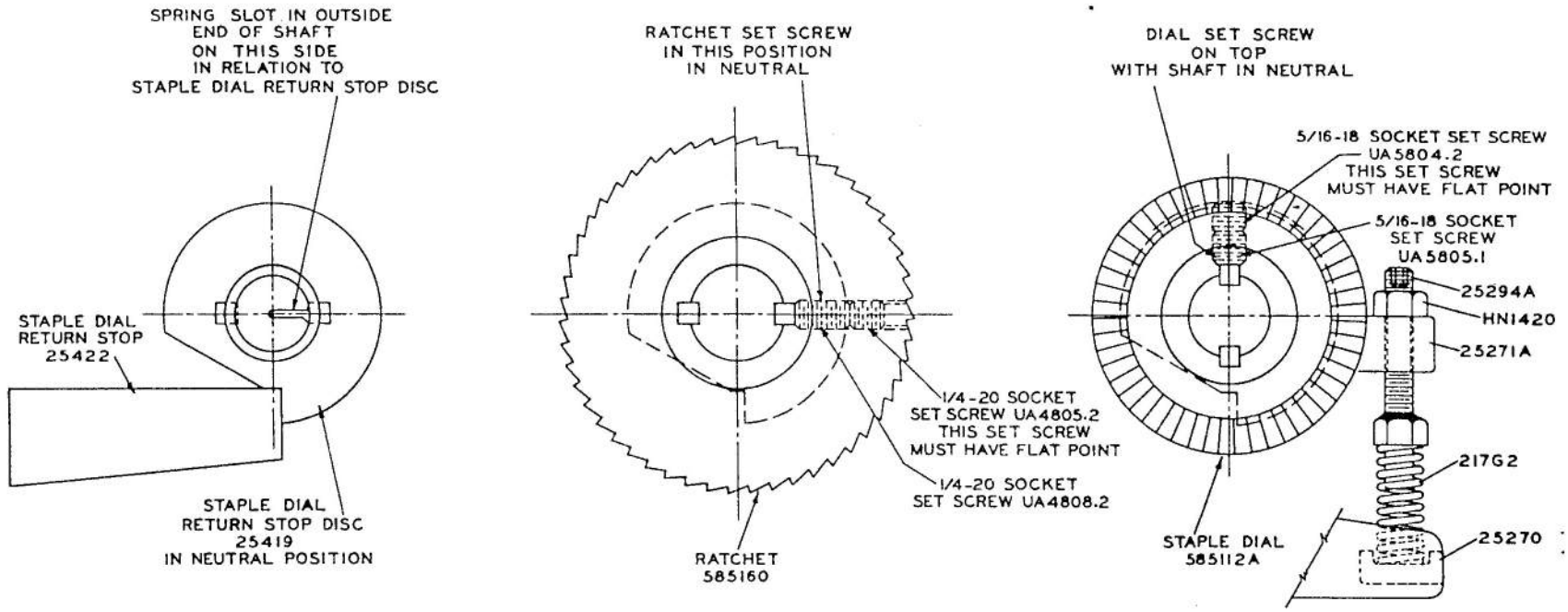

25593A
RATCHET CAM
585180A
RATCHET
585160
RATCHET SHAFT
585162
CAM POINT
STAPLE DIAL
RETURN STOP DISC
25419
SPRING
217G2
25309
(B)
1"
APPROX. 32
STAPLE DIAL
RETURN STOP
25422
25308
E455
SPACER
LARGE 585277
SMALL 585505
UA6828.3
SCREW (A)
HN3816
25299A
25593A
RATCHET CAM
585180A
(D)
APPROX. .048"
25077
RATCHET
585160
SPRING
MR333
CHECK PAWL
585120
585003
(C)
1"
APPROX. 32
25488A

DIAGRAM I



PARTS AND KEY RELATIONSHIP ON RATCHET SHAFT

DIAGRAM 2

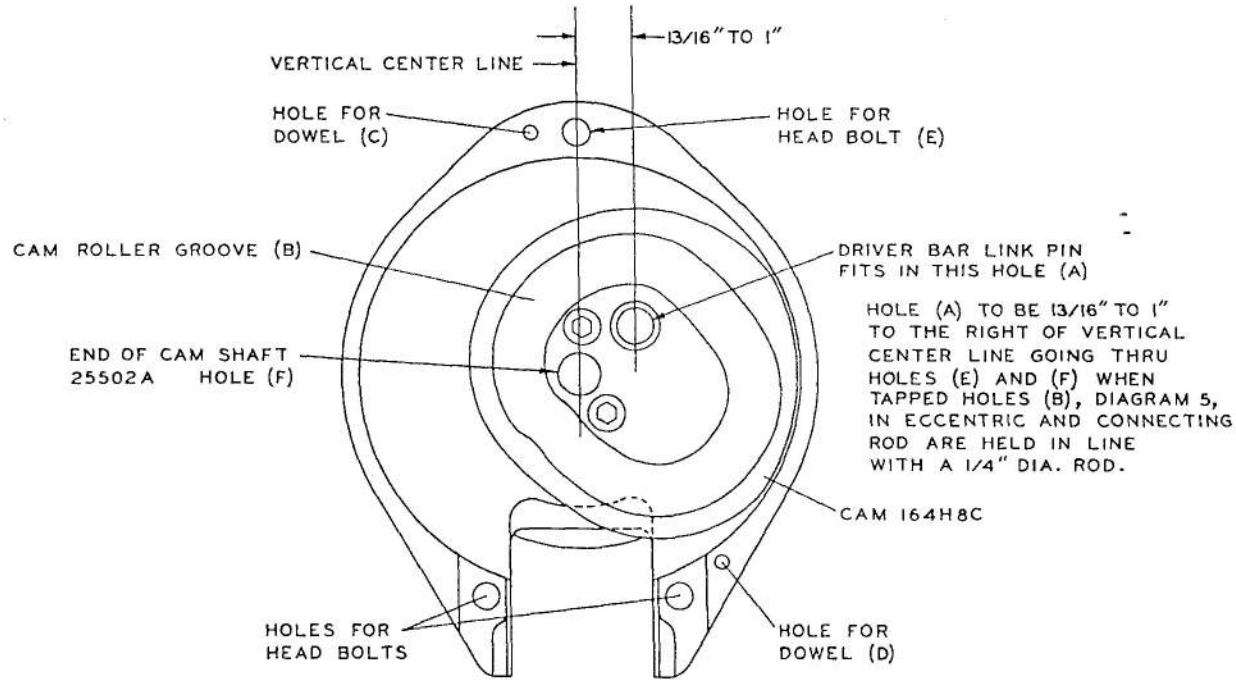

13/16" TO 1"
VERTICAL CENTER LINE
HOLE FOR DOWEL (C)
HOLE FOR HEAD BOLT (E)
CAM ROLLER GROOVE (B)
DRIVER BAR LINK PIN FITS IN THIS HOLE (A)
HOLE (A) TO BE 13/16" TO 1" TO THE RIGHT OF VERTICAL CENTER LINE GOING THRU HOLES (E) AND (F) WHEN TAPPED HOLES (B), DIAGRAM 5, IN ECCENTRIC AND CONNECTING ROD ARE HELD IN LINE WITH A 1/4" DIA. ROD.
END OF CAM SHAFT 25502A HOLE (F)
CAM 164H8C
HOLES FOR HEAD BOLTS
HOLE FOR DOWEL (D)

DIAGRAM 3

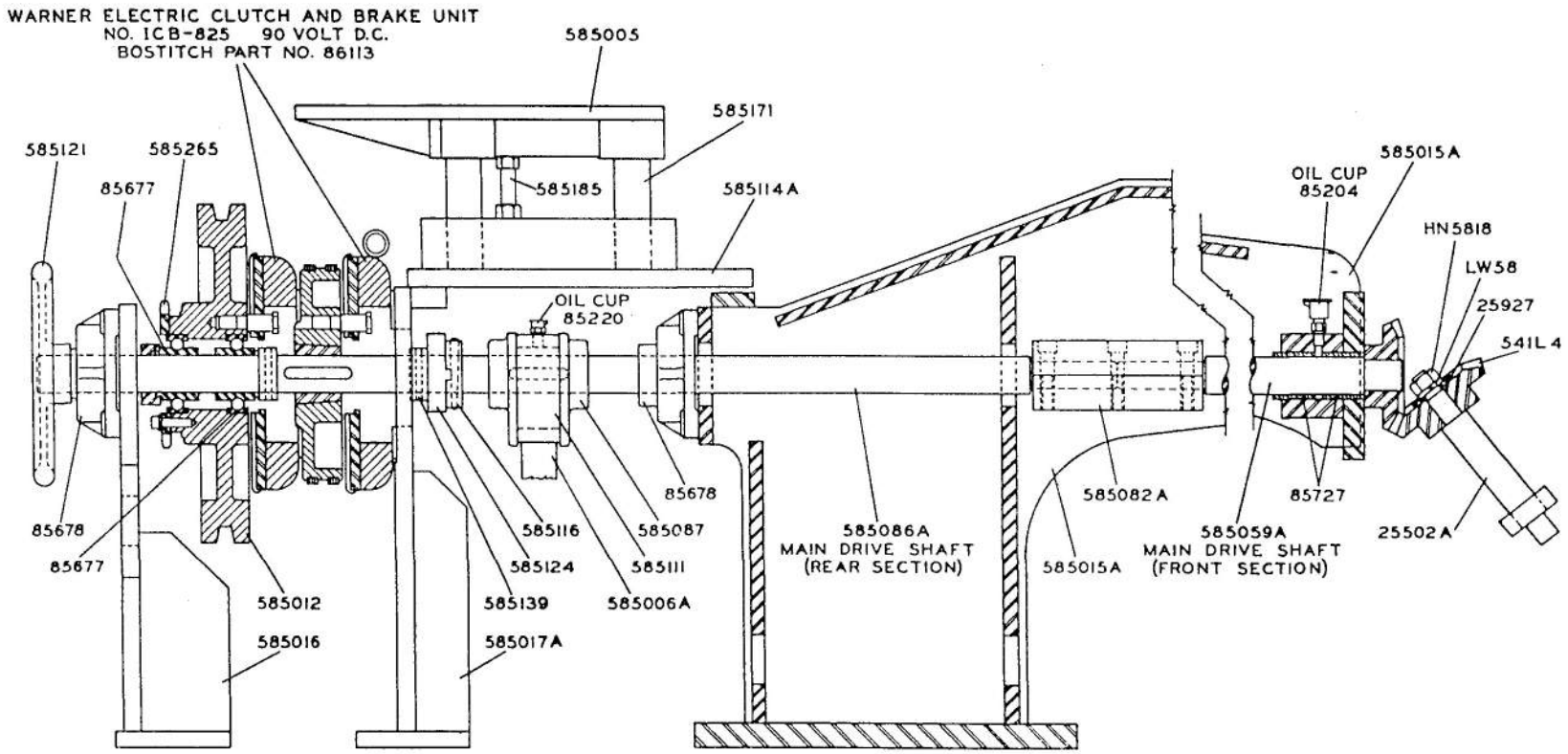
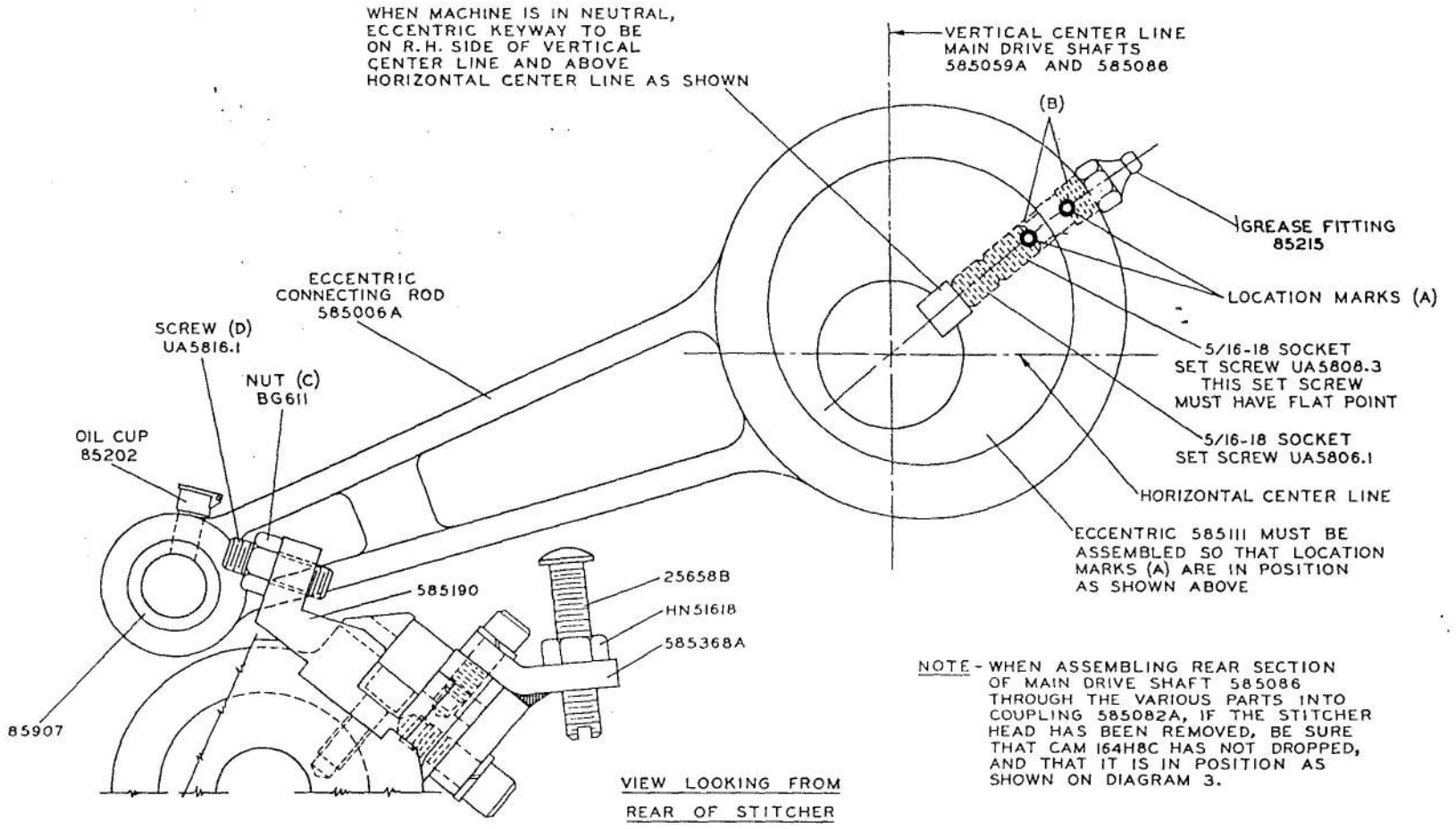
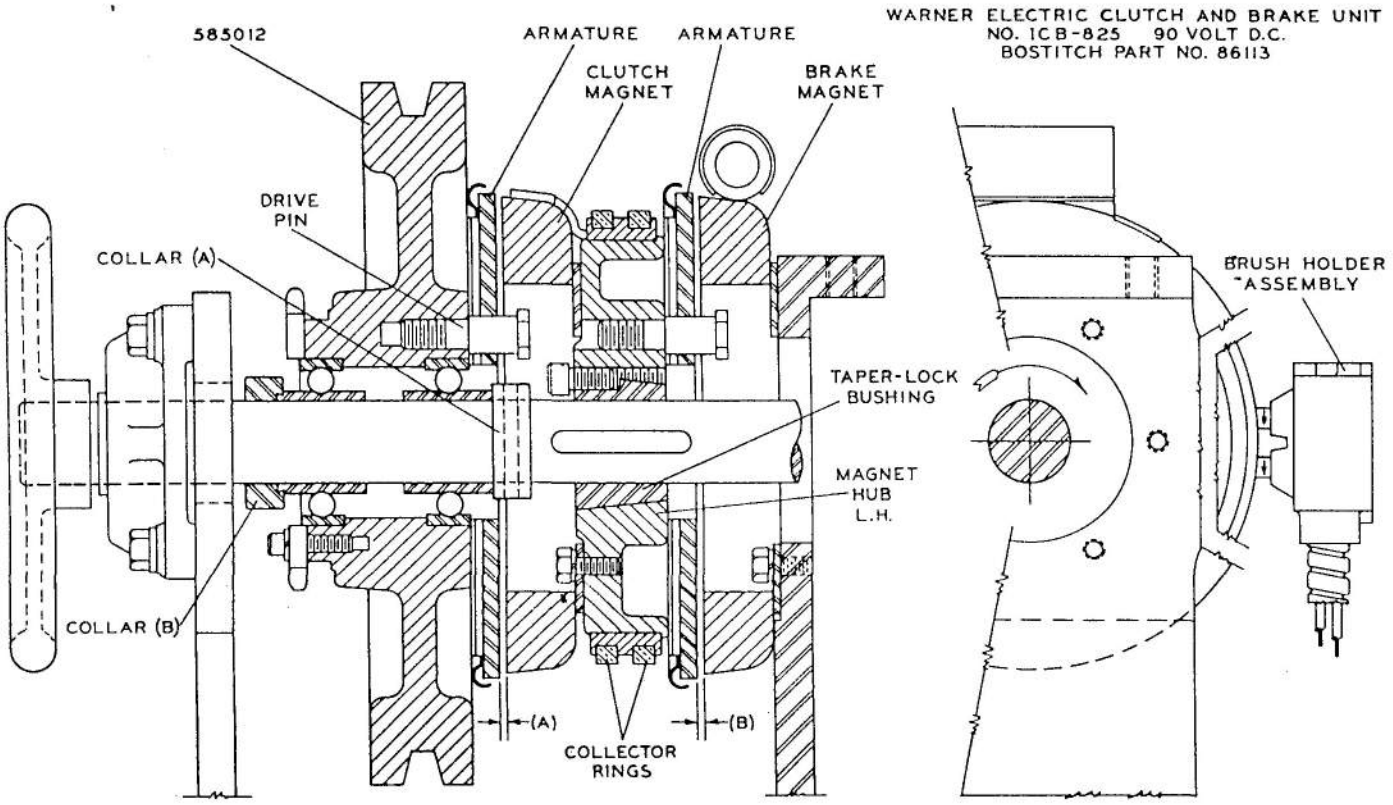

WARNER ELECTRIC CLUTCH AND BRAKE UNIT
NO. ICB-825 90 VOLT D.C.
BOSTITCH PART NO. 86113
585005
585171
585121
585265
85677
585185
585114A
OIL CUP
85220
OIL CUP
85204
585015A
HN5818
LW58
25927
541L4
85678
85677
585116
585124
585139
585012
585016
585087
585111
585006A
585017A
85678
585086A
MAIN DRIVE SHAFT
(REAR SECTION)
585082A
585015A
85727
585059A
MAIN DRIVE SHAFT
(FRONT SECTION)
25502A

DIAGRAM 4



NOTE - WHEN ASSEMBLING REAR SECTION OF MAIN DRIVE SHAFT 585086 THROUGH THE VARIOUS PARTS INTO COUPLING 585082A, IF THE STITCHER HEAD HAS BEEN REMOVED, BE SURE THAT CAM 164H8C HAS NOT DROPPED, AND THAT IT IS IN POSITION AS SHOWN ON DIAGRAM 3.

DIAGRAM 5



DIMENSIONS (A) AND (B) FOR THE INSTALLATION OF A NEW CLUTCH AND BRAKE UNIT SHOULD BE 1/16" RESPECTIVELY. IF CLUTCH AND BRAKE UNIT FOR ANY REASON HAS TO BE REMOVED AFTER BEING IN OPERATION AND IS TO BE REASSEMBLED TO MACHINE, THE FOLLOWING INSTRUCTIONS SHOULD BE CAREFULLY CARRIED OUT.

1 - BEFORE REMOVING, MEASURE AND MAKE A RECORD OF DIMENSIONS (A) FOR CLUTCH AND (B) FOR BRAKE.

2 - WHEN REASSEMBLING, LOCATE CLUTCH AND BRAKE TO (A) AND (B) DIMENSIONS AS NOTED IN ITEM 1.

UNLESS THIS IS DONE THE CLUTCH MAGNET AND THE BRAKE ARMATURE WILL NOT BE LOCATED CORRECTLY.

DIAGRAM 6

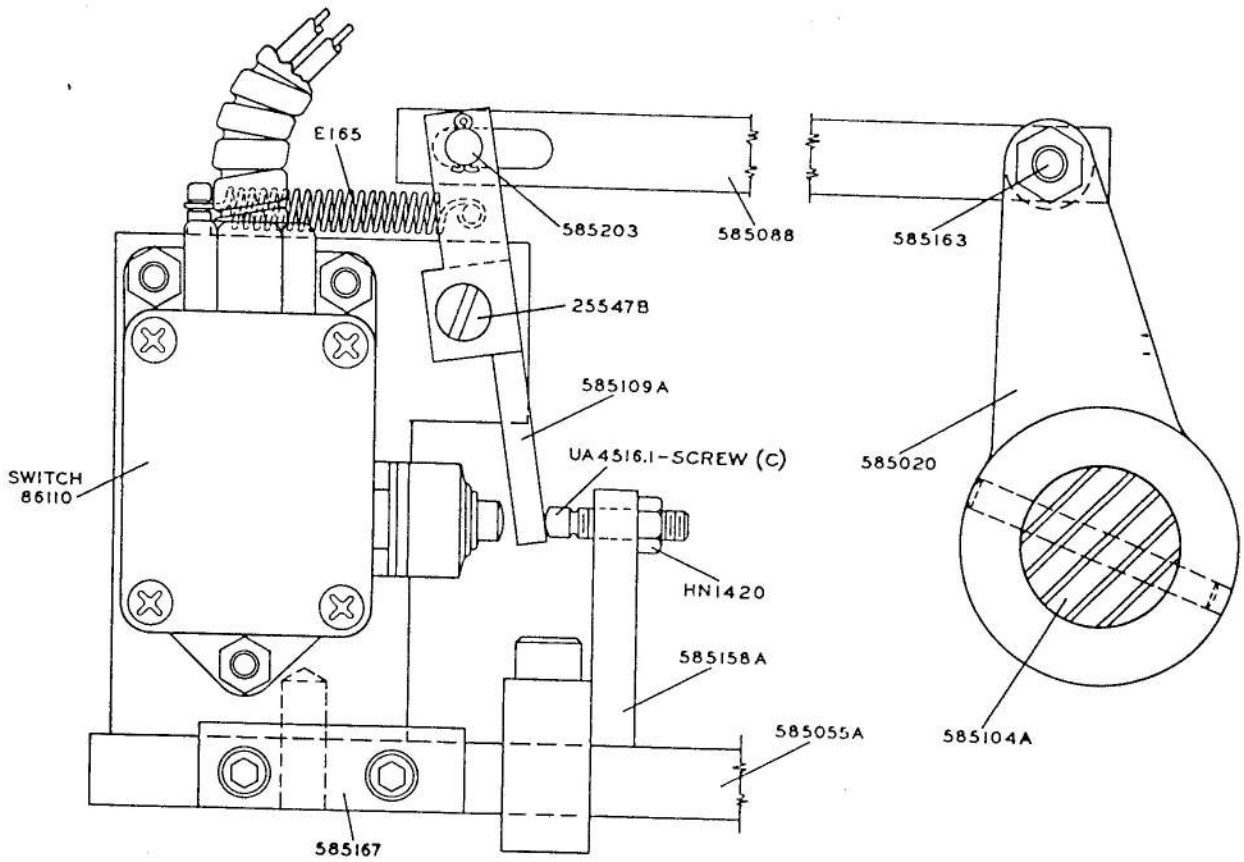
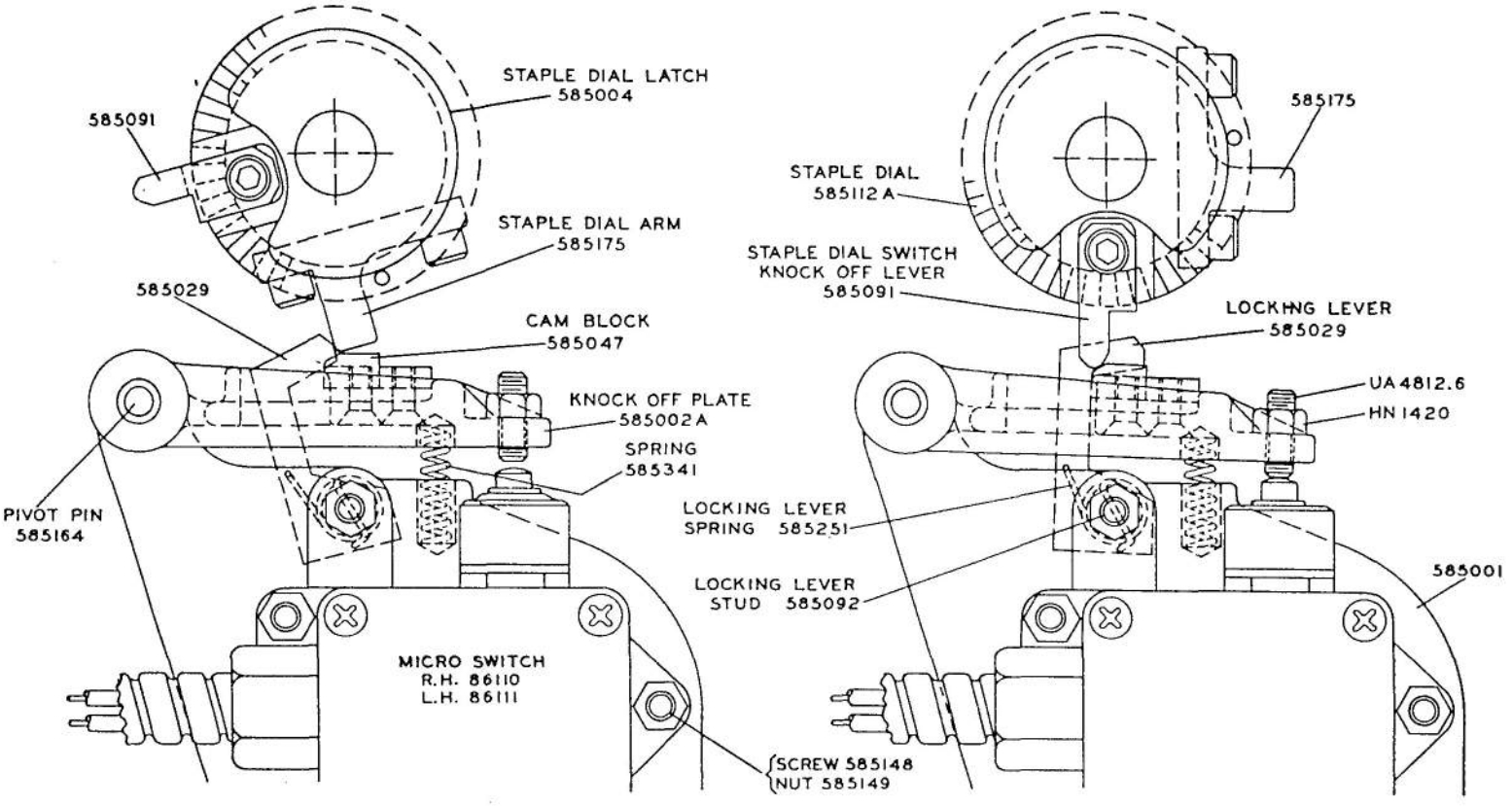

E165
585203
585088
585163
25547B
585109A
SWITCH
86110
UA4516.1-SCREW (C)
585020
HN1420
585158A
585055A
585104A
585167

DIAGRAM 7



STAPLE DIAL RETURN MECHANISM

DIAGRAM 8

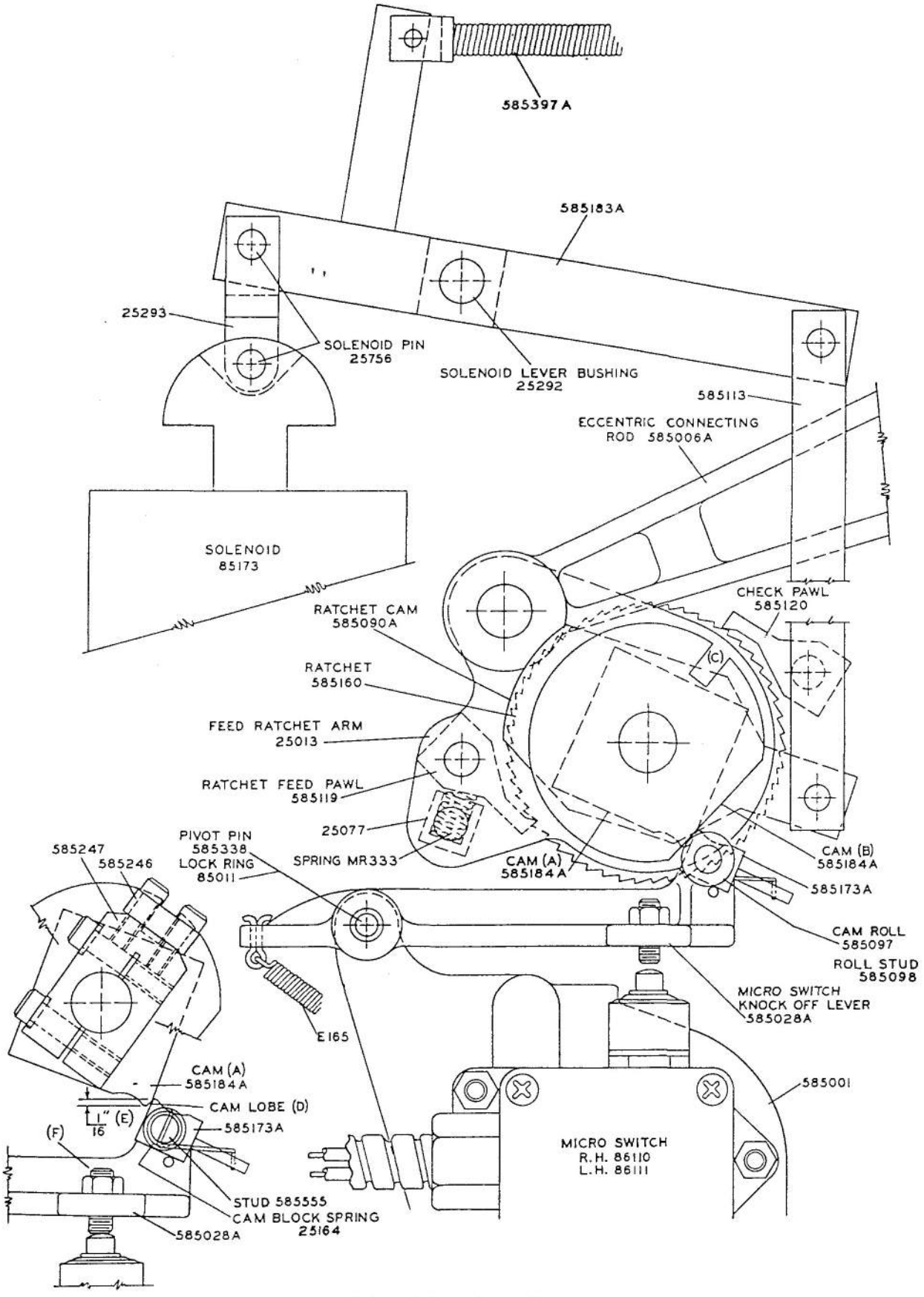

585397A
585183A
25293
SOLENOID PIN
25756
SOLENOID LEVER BUSHING
25292
585113
ECCENTRIC CONNECTING
ROD 585006A
SOLENOID
85173
CHECK PAWL
585120
RATCHET CAM
585090A
(C)
RATCHET
585160
FEED RATCHET ARM
25013
RATCHET FEED PAWL
585119
25077
SPRING MR333
PIVOT PIN
585338
LOCK RING
85011
585247
585246
CAM (A)
585184A
CAM (B)
585184A
585173A
CAM ROLL
585097
ROLL STUD
585098
MICRO SWITCH
KNOCK OFF LEVER
585028A
E165
585001
MICRO SWITCH
R.H. 86110
L.H. 86111
CAM (A)
585184A
CAM LOBE (D)
1/16" (E)
585173A
(F)
STUD 585555
CAM BLOCK SPRING
25164
585028A

DIAGRAM 9

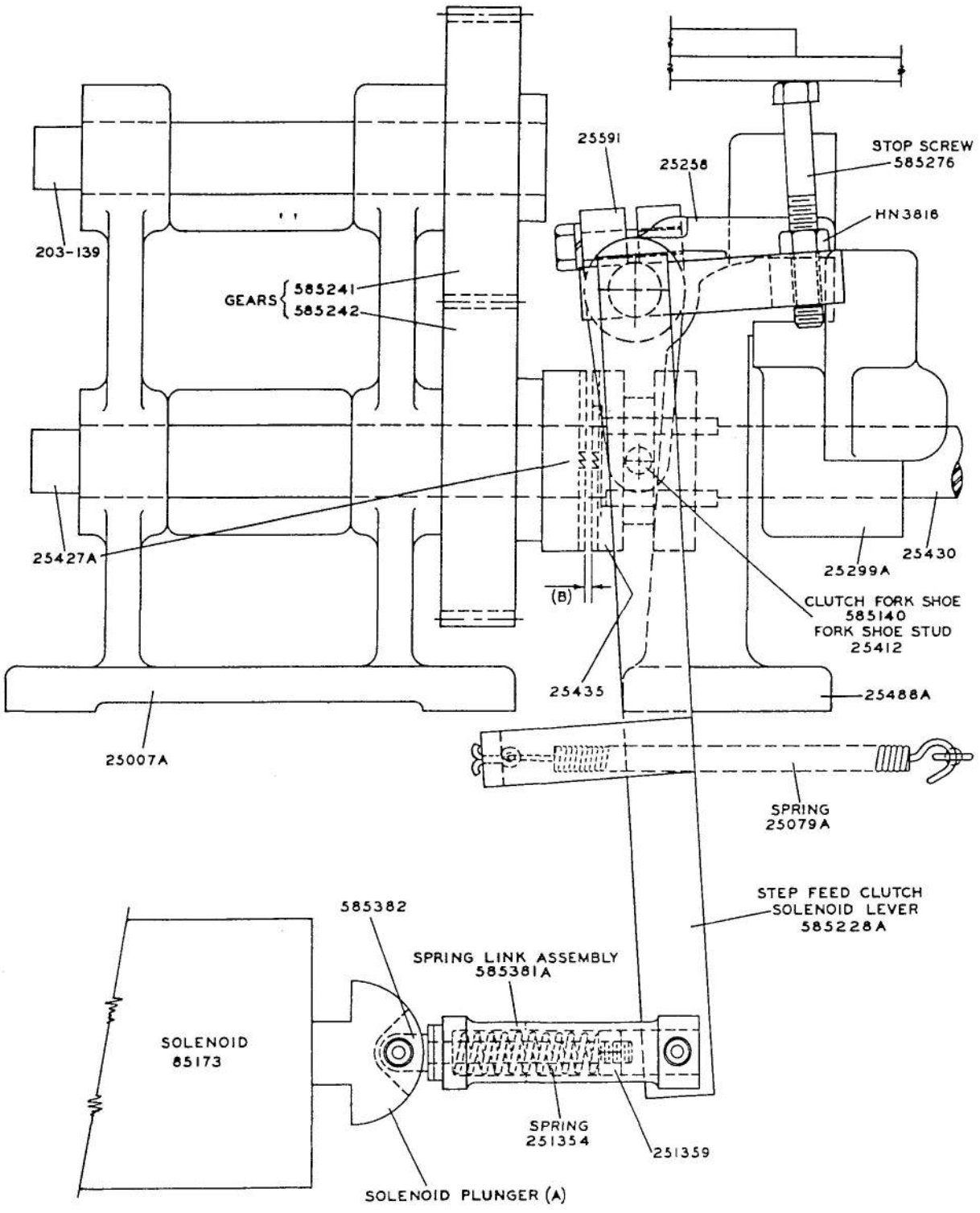

25591
STOP SCREW
585276
25258
HN3816
203-139
GEARS { 585241
585242
25427A
25299A
25430
(B)
CLUTCH FORK SHOE
585140
FORK SHOE STUD
25412
25435
25488A
25007A
SPRING
25079A
STEP FEED CLUTCH
SOLENOID LEVER
585228A
585382
SPRING LINK ASSEMBLY
585381A
SOLENOID
85173
SPRING
251354
251359
SOLENOID PLUNGER (A)

DIAGRAM 10

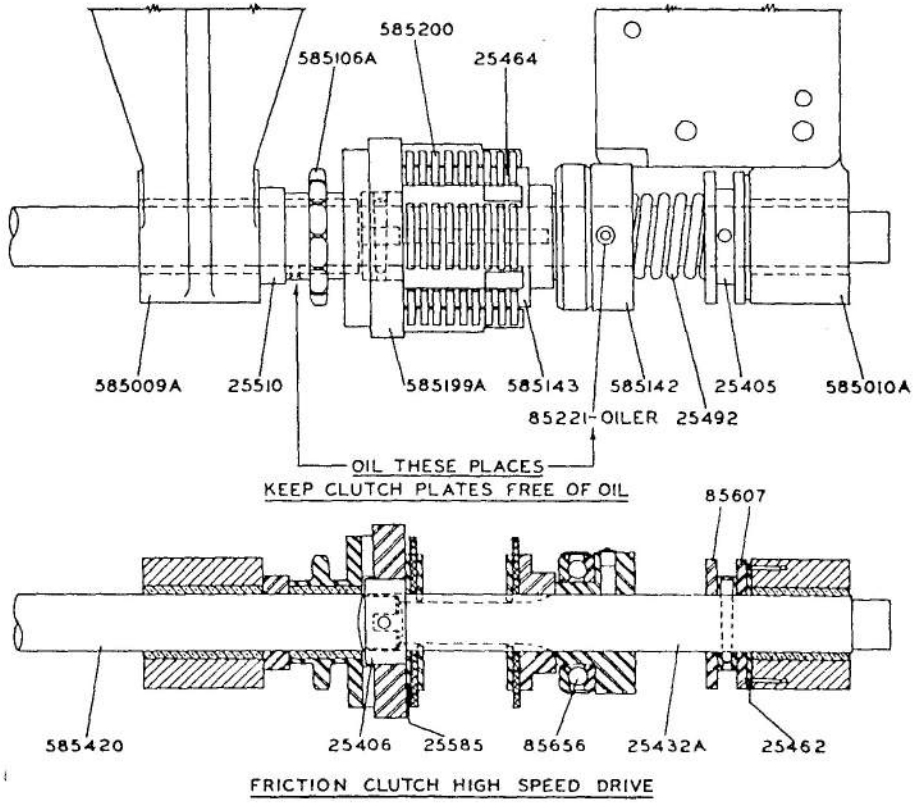

585200
585106A
25464
585009A
25510
585199A
585143
85221-OILER
585142
25492
25405
585010A
OIL THESE PLACES
KEEP CLUTCH PLATES FREE OF OIL
85607
585420
25406
25585
85656
25432A
25462
FRICTION CLUTCH HIGH SPEED DRIVE

DIAGRAM II

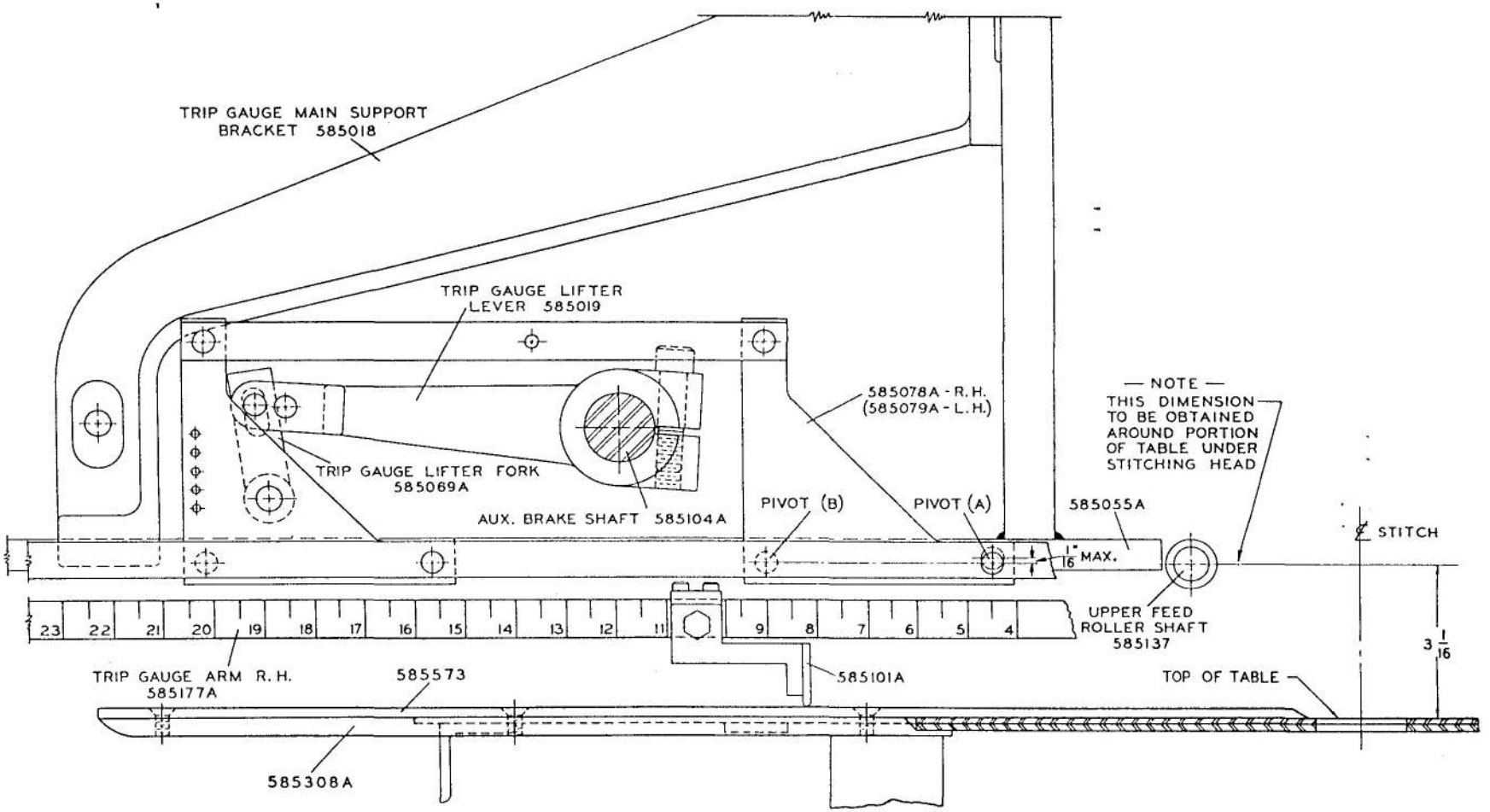

TRIP GAUGE MAIN SUPPORT BRACKET 585018
TRIP GAUGE LIFTER LEVER 585019
585078A - R.H. (585079A - L.H.)
— NOTE — THIS DIMENSION TO BE OBTAINED AROUND PORTION OF TABLE UNDER STITCHING HEAD
TRIP GAUGE LIFTER FORK 585069A
AUX. BRAKE SHAFT 585104A
PIVOT (B)
PIVOT (A)
585055A
1/16 MAX.
℄ STITCH
UPPER FEED ROLLER SHAFT 585137
23 22 21 20 19 18 17 16 15 14 13 12 11 9 8 7 6 5 4
TRIP GAUGE ARM R.H. 585177A
585573
585101A
TOP OF TABLE
3 1/16
585308A

DIAGRAM 12

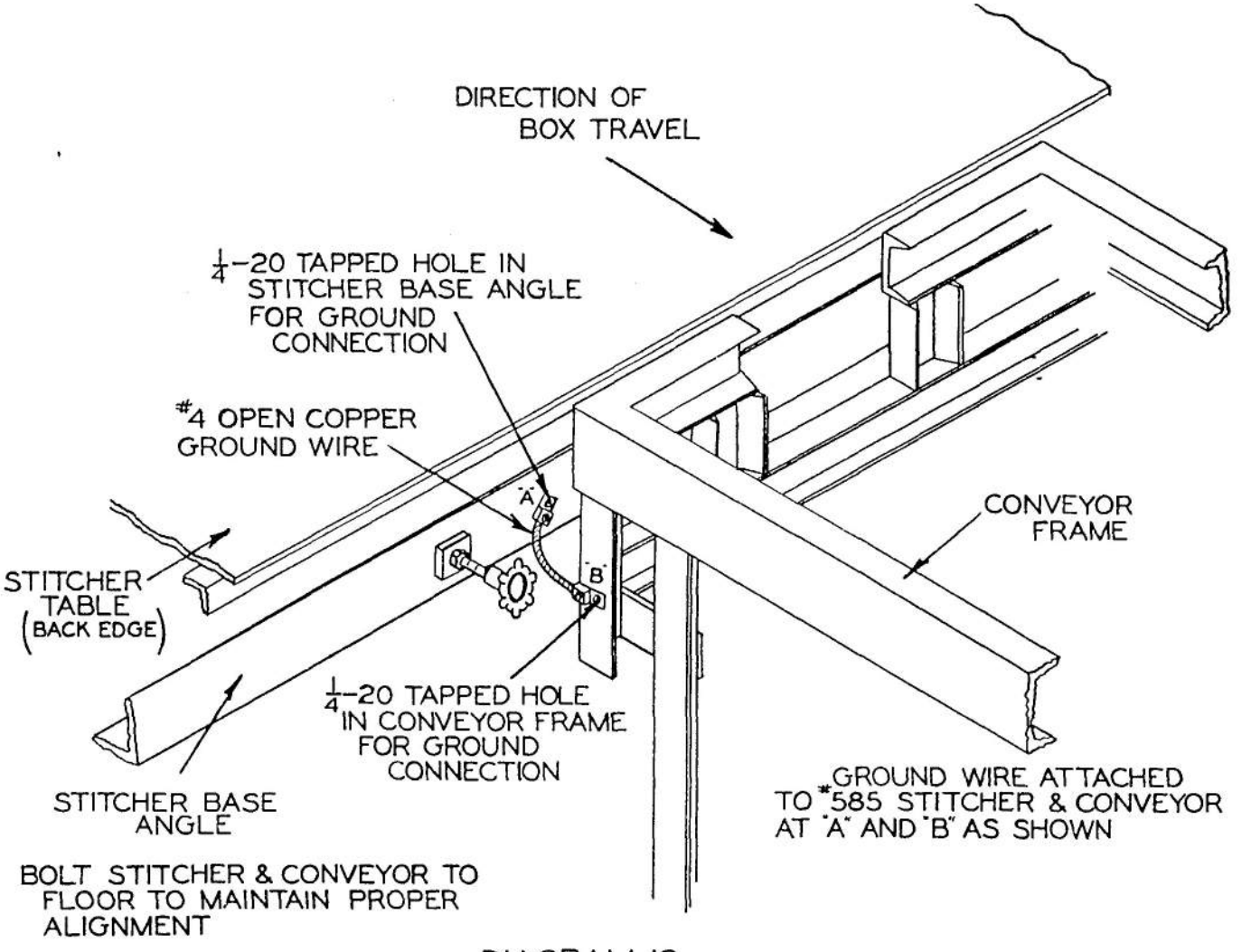
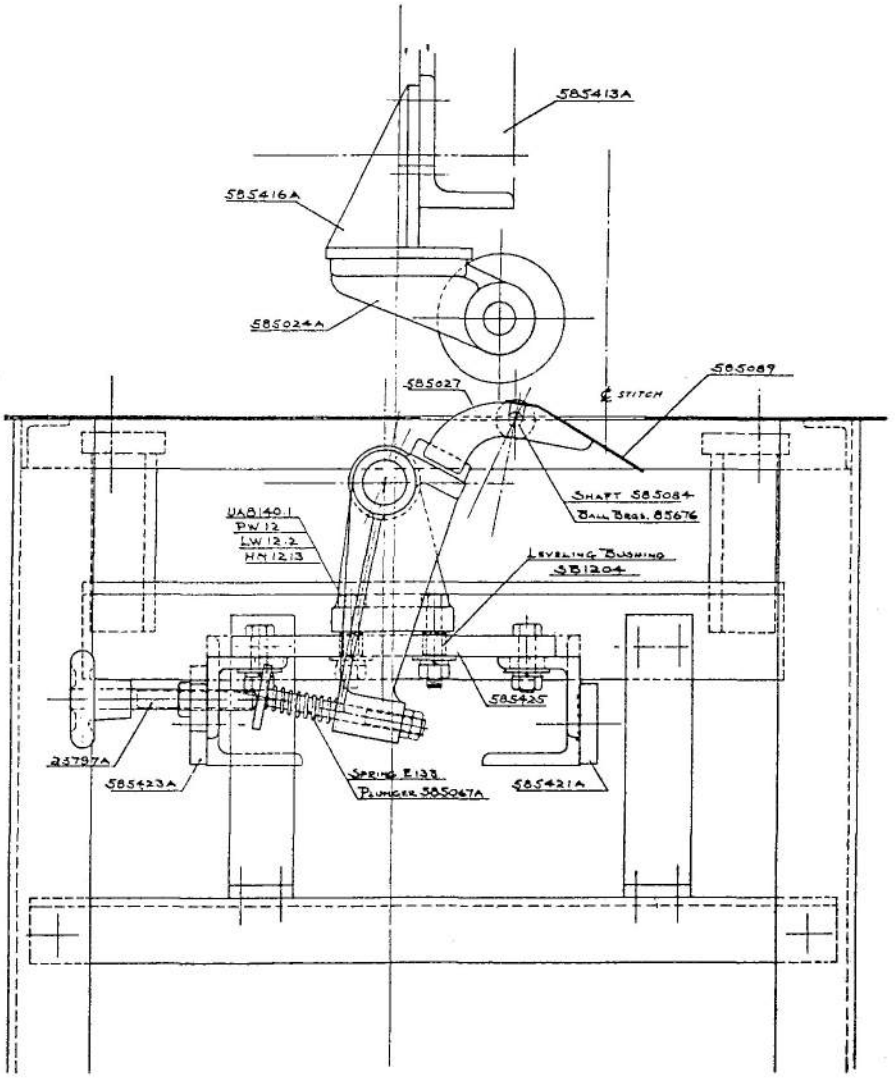
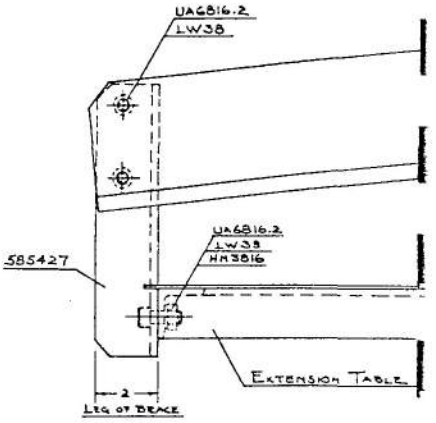

DIRECTION OF BOX TRAVEL
¼-20 TAPPED HOLE IN STITCHER BASE ANGLE FOR GROUND CONNECTION
#4 OPEN COPPER GROUND WIRE
A
B
CONVEYOR FRAME
STITCHER TABLE (BACK EDGE)
¼-20 TAPPED HOLE IN CONVEYOR FRAME FOR GROUND CONNECTION
STITCHER BASE ANGLE
GROUND WIRE ATTACHED TO #585 STITCHER & CONVEYOR AT "A" AND "B" AS SHOWN
BOLT STITCHER & CONVEYOR TO FLOOR TO MAINTAIN PROPER ALIGNMENT

DIAGRAM 13

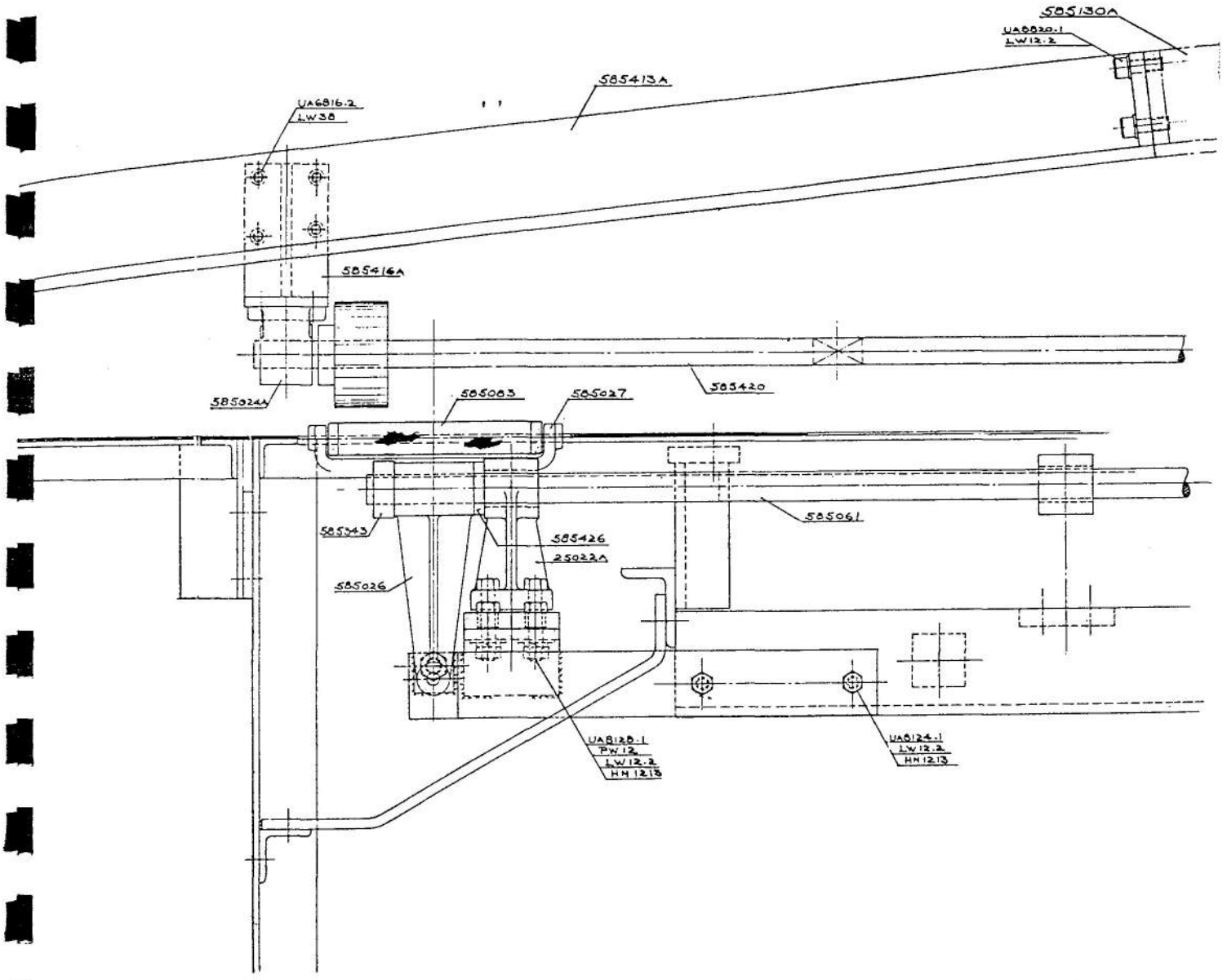
LIST OF PARTS INCLUDED IN EXTENSION FEED ROLL UNIT – FOR #585 STITCHER

Part No.	*Quantity*	*Part Name*
585413A	1	Feed Roll Bearing Bracket Support
MR76	2	Spacer
585416A	1	Feed Roll Bearing Bracket
585420	1	Upper Step Feed Roller Shaft
585421A	1	Bearing Plate Bracket — Front
585423A	1	Bearing Plate Bracket — Rear
585425	1	Bearing Plate
SB1204	4	Leveling Bushing
25022A	1	Rocker Shaft Bearing
585426	1	Spacer
585026	1	Pressure Roll Bearing Bracket
585027	1	Pressure Roll Bearing
585083	1	Pressure Roll
85676	2	Pressure Roll Ball Bearing
585084	1	Pressure Roll Shaft
585089	1	Deflector Plate
585067A	1	Pressure Roll Bearing Bracket Plunger
25797A	1	Pressure Roll Adj. Screw
585343	1	Collar
E133	1	Plunger Spring
585427	1	Feed Roll Brg. Bracket Support Brace
25534	1	Auxiliary Brake Drum
134-65	1	Collar
UA3806.4	4	#10 – 32 x 3/8 Flat Soc. Cap Screw
UA5120.2	3	5/16 – 18 x 1¼ Hex Head Screw
UA6816.2	8	3/8 – 16 x 1 Soc. Cap Screw
UA6120.1	4	3/8 – 16 x 1¼ Hex Head Screw
UA8820.1	4	½ – 13 x 1¼ Soc. Cap Screw
UA8124.1	4	½ – 13 x 1½ Hex Head Screw
UA8128.1	4	½ – 13 x 1¾ Hex Head Screw
UA8140.1	4	½ – 13 x 2½ Hex Head Screw
HN3816	6	3/8 – 16 Hex Nut
HN1213	12	½ – 13 Hex Nut
HN1213.2	2	½ – 13 Hex Jam Nut
HN5818.2	1	5/8 – 18 Hex Jam Nut
PW12	8	½ Plain Washer
LW516	3	5/16 Lock Washer
LW38	12	3/8 Lock Washer
LW12.2	16	½ Lock Washer
UB2920.1	2	3/32 x 1¼ Cotter Pin
UB4624.1	1	#4 x 1½ Taper Pin
UB4632.3	1	#4 x 2 Taper Pin


585413A
585416A
585024A
585027
℄ STITCH
585089
SHAFT 585084
BALL BRGS. 85676
UA8140.1
PW 12
LW 12.2
HN 12.13
LEVELING BUSHING
SB1204
585435
23797A
585423A
SPRING E133
PLUNGER 585067A
585421A


UA6816.2
LW38
UA6816.2
LW38
HN3816
585427
EXTENSION TABLE
2
LEG OF BRACE

DIAGRAM


505130A
UA8820-1
LW12.2
585413A
UA6816.2
LW38
585416A
585024A
585063
585027
585420
585061
585343
585426
25023A
585026
UA8128-1
PW12
LW12.2
HN12.13
UA8124-1
LW12.2
HN12.13

14

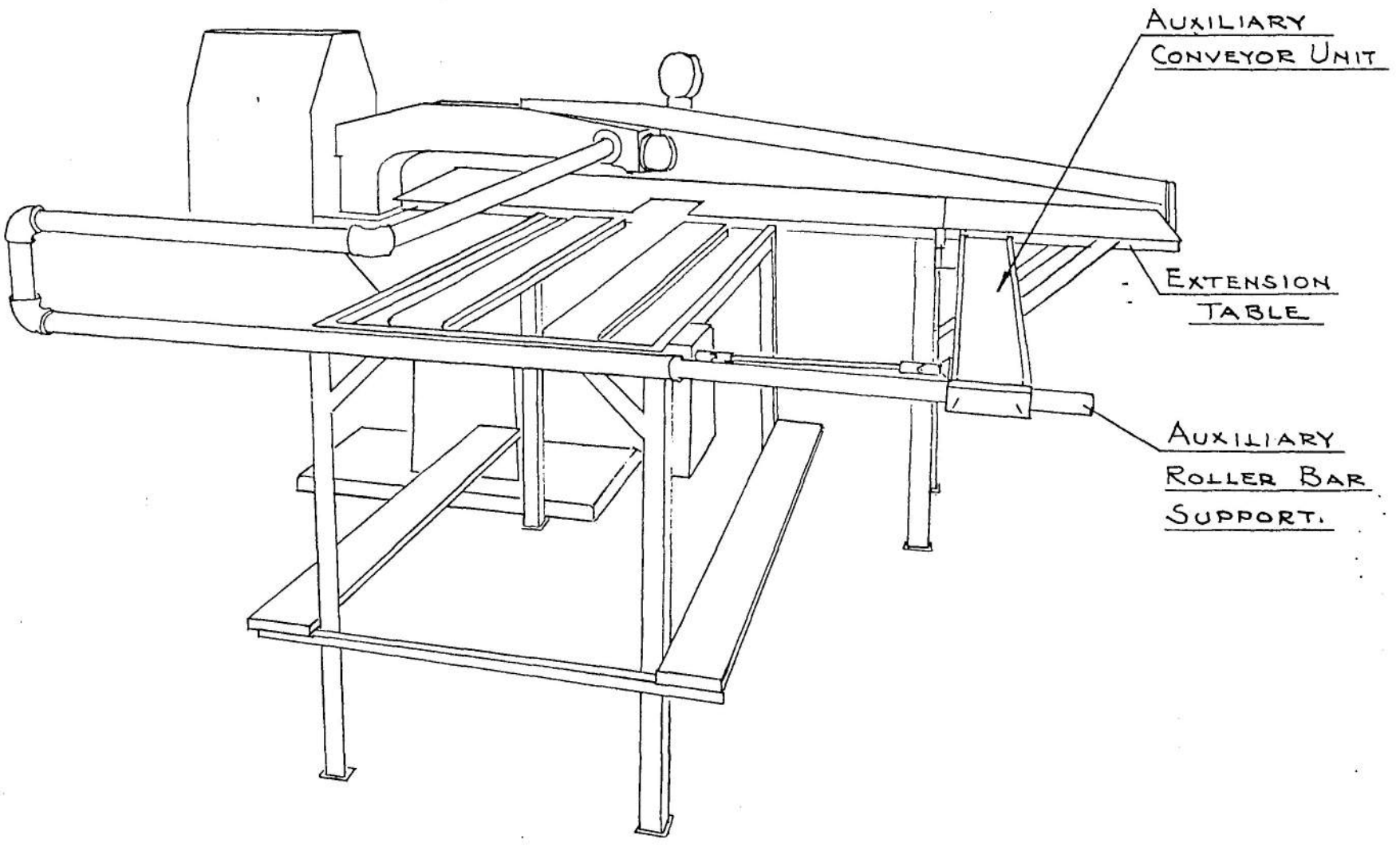

AUXILIARY
CONVEYOR UNIT
EXTENSION
TABLE
AUXILIARY
ROLLER BAR
SUPPORT.

DIAGRAM 15

PARTS LIST
AUXILIARY CONVEYOR UNIT

Part No.	*Quantity*	*Part Name*
585436	1	Auxiliary Conveyor Belt Frame
585319A	1	Conveyor Pulley (Idler)
585320	1	Conveyor Pulley (Driver)
585336	1	Conveyor Pulley Key
585321	2	Conveyor Pulley Spacer (Idler)
585322	2	Conveyor Pulley Spacer (Driver)
585437	1	Aux. Conveyor Pulley Idler Shaft
585438	1	Aux. Conveyor Pulley Drive Shaft
585439	1	Idler Shaft Retainer Plate
585440	2	Idler Shaft Take-up
85549	2	Drive Shaft Bearing
85289	1	Conveyor Belt
585441	1	Auxiliary Conveyor Universal Shaft
585442	1	Universal Joint
585443	1	Universal Joint
UA5116.1	8	5/16 — 18 x 1 Hex Head Screw
UA4408.1	2	1/4 — 20 x 1/2 Flat Head Screw
UA4805.1	2	1/4 — 20 x 5/16 Socket Set Screw
UA6816.4	2	3/8 — 16 x 1 Socket Set Screw
UA6812.3	2	3/8 — 16 x 3/4 Thumb Screw
HN3816	2	3/8 — 16 Hex Nut
HN1213	4	1/2 — 13 Hex Nut
LW516	8	5/16 Lock Washer
UB4120.2	3	.218 x 1 1/4 Roll Pin
85226	2	Gits Oiler
UB3920.1	2	3/16 x 1 1/4 Cotter Pin

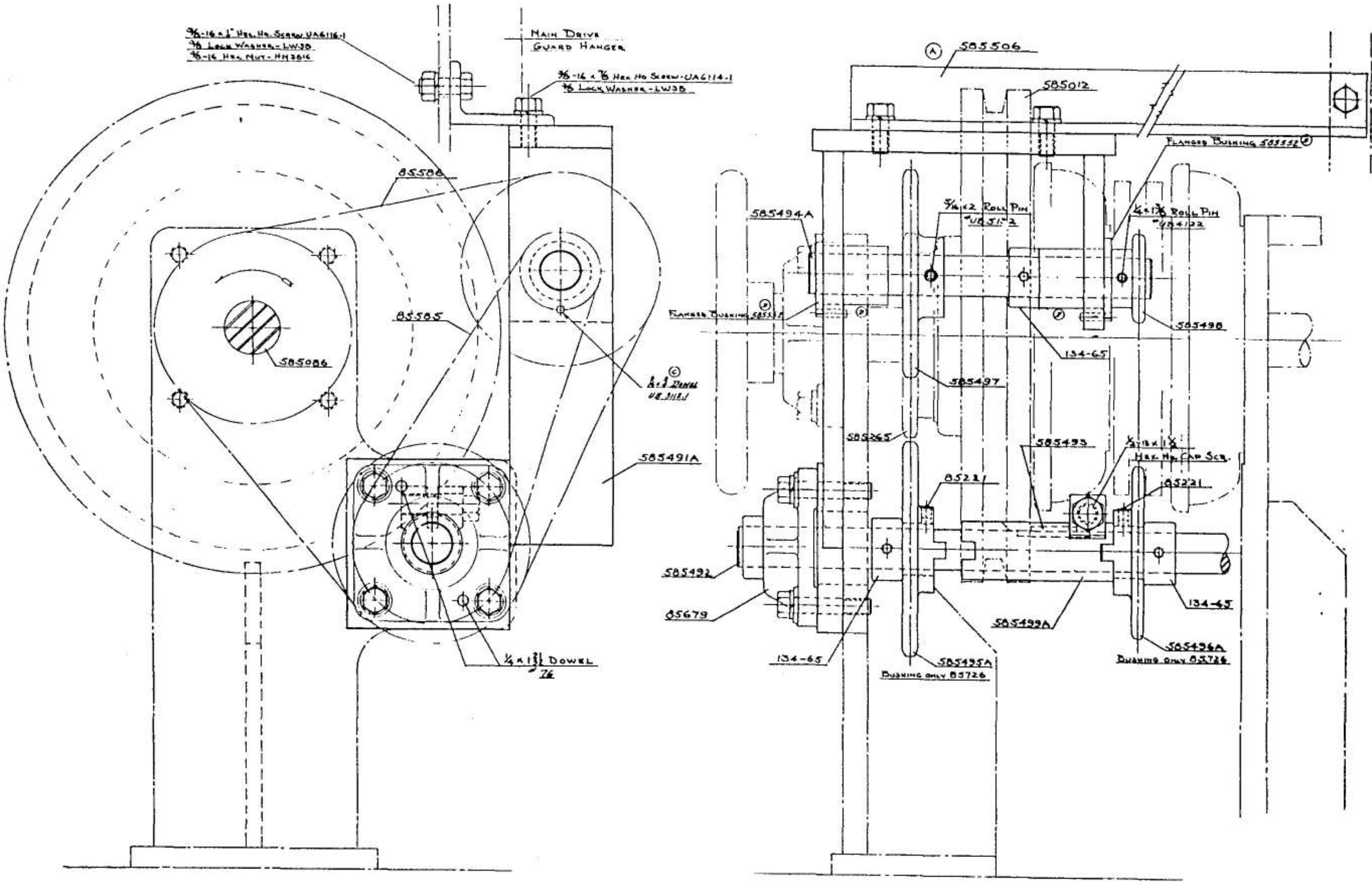

3/8-16 x 1" Hex. Hd. Screw UA6116-1
3/8 Lock Washer - LW38
3/8-16 Hex. Nut - HN3816
Main Drive
Guard Hanger
3/8-16 x 7/8 Hex Hd Screw-UA6114-1
3/8 Lock Washer - LW38
85586
85585
585086
585491A
1/4 x 1 3/4 Dowel
585506
585012
Flanged Bushing 585552
585494A
5/16 x 2 Roll Pin
1/4 x 1 3/8 Roll Pin
Flanged Bushing 585551
585498
134-65
585497
585265
585493
Hex. Hd. Cap Scr.
85221
585492
85679
585499A
134-45
585496A
Bushing only 85726
134-65
585495A
Bushing only 85726

DIAGRAM 16

OPERATING INSTRUCTIONS: SLOW SPEED FEED ROLL DRIVE UNIT

The operation of this unit is controlled by making two simple adjustments.

With the Clutch Sleeve #585499A clamped in place over Key #585493, and with Jaws engaged with Sprocket #585495A, the Roller Drive Shaft will be driven at standard or normal speed.

With this adjustment of the Clutch Sleeve, the belt driving the Auxiliary Throw Out Roller must be run in the 3″ O.D. or 1 to 1 ratio grooves of the Double Groove Pulleys for normal auxiliary throw out roller speed.

To drive the Feed Rollers at ane half of their normal speed, loosen the clamping screw on Clutch Sleeve, slide and turn Sleeve so that Sleeve jaws engage with smaller Sprocket #585496A, and clamp Sleeve in place over key in shaft.

With this adjustment of the Clutch Sleeve, the belt driving the Auxiliary Throw Out Roller must be run in the 4″ and 2″ O.D. or 2 to 1 Ratio grooves of the Double Groove Pulleys, in order to maintain the normal or constant speed of the Auxiliary Throw Out Roller.

PARTS LIST – SLOW SPEED FEED ROLL DRIVE UNIT ON #585 STITCHERS

Part No.	*No. Required*	*Name of Part*
#585491A	1	Slow Speed Feed Roll Drive Bracket
#585492	1	High Speed Roller Drive Shaft
#585493	1	High Speed Shaft Clutch Sleeve Key
#585494A	1	Intermediate Feed Roll Drive Shaft
#585495A	1	H.S. Sprocket On Feed Roll Drive Shaft
#585496A	1	L.S. Sprocket On Feed Roll Drive Shaft
#585497	1	Driven Sprocket – Int. Feed Roll Dr. Shaft
#585499A	1	Dual Speed Clutch Sleeve
#585501	1	Aux. Throw-Out Driving Pulley
#585502	1	Aux. Throw-Out Driven Pulley
#85586	1	High Speed Roller Drive Chain
#85577	1	High Speed Drive Chain Offset Link
#85476	1	High Speed Drive Chain Conn. Link
#85585	1	Slow Speed Roller Drive Chain
#85583	1	Slow Speed Drive Chain Conn. Link
134-65	3	Collar
UA6132.1	4	3/8 – 16 x 2 Hex. Head Screw
UA8124.1	1	1/2 – 13 x 1 1/2 Cap Screw Hex. Hd.
UA5808.1	2	5/16 – 18 x 1/2 Socket Set Screw
UA5804.1	3	5/16 – 18 x 1/4 Socket Set Screw
LW38	7	3/8 Lock Washer
UB5132	1	.312 x 2 Roll Pin
76	2	1/4 x 1 7/32 Dowel Pin
585506	1	Angle Brace
UA6114.1	2	3/8 – 16 x 7/8 Hex. Head Cap Screw
UA6116.1	1	3/8 – 16 x 1 Hex. Head Cap Screw
HN3816	1	3/8 – 16 Hex. Nut

PARTS RECOMMENDED FOR CUSTOMER'S STOCK

STITCHER PARTS

585218A	Upper Step Feed Rollers—R.H. (2 per Machine)
585219A	Upper Step Feed Rollers—L.H. (2 per Machine)
25639BA	L.H. Lower Feed Roller (1 per Machine)
25640BA	R.H. Lower Feed Roller (1 per Machine)
185H3C	Clincher 7/16" Crown
UA1405.2	Clincher Screw
85173	Solenoid 110V, 60 Cycle (6 per Machine)
86110	Micro Switch—R.H. (3 per Machine)
86111	Micro Switch—L.H. (7 per Machine)
85278	V-Belt—Main Drive ¾ H.P. Motor
85299	V-Belt—Main Drive 1 H.P. Motor
85288	V-Belt—Conveyor Drive
585367	Belt—Auxiliary Throw Out Roller Drive
85285	Belt Hook for Auxiliary Throw Out Drive Belt
25110	Ratchet Return Spring
25014	Ratchet Auxiliary Arm
585180A	Ratchet Cam
25593A	Ratchet Cam Spring
585119	Ratchet Pawl (Feed)
585120	Ratchet Pawl (Check)
585301	Ratchet Key (2 per Machine)
585006A	Connecting Rod
585133	Tie Stitch Arm
25070	Tie Stitch Latch
585190	Tie Stitch Latch Block
FP	Auxiliary Brake Lever Spring and Latch Lever Spring
194-20	Ratchet Wheel
199-72	Step Feed Ratchet Rollers (7 per Set)
210-197	Step Feed Ratchet Rollers Springs (7 per Set)
25539A	Auxiliary Brake Band—Central
25929	Auxiliary Brake Band—Left End
25930A	Auxiliary Brake Band—Right End
251348	Spring Link Case
251354	Solenoid Spring
251359	Solenoid Link Nut
210-297	Trip Gauge Unit Return Spring
25756	Solenoid Pin (11 per Machine)
25755	Solenoid Pin (1 per Machine)
25757	Solenoid Pin (1 per Machine)
25411	High Speed Clutch Fork Shoe (2 per Machine)
585140	Step Feed Clutch Fork Shoe (2 per Machine)
25492	High Speed Clutch Spring
BHL485	485 Bliss Head Long Draw
25164	Brake Switch Lever Spring
585200	High Speed Clutch Plate (9 per Machine)
25301	Feed Roll Rocker Arm Bearing Spring (2 per Machine)
25079A	Solenoid Lever Spring
25658B	Tie Stitch Adjusting Screw
585156	Trip Gauge Lifter Lever Pin
E165	High Speed Switch Lever Spring and Knock Off Lever Spring (3 per Machine)
585175	Staple Dial Arm
585013A	Roller Clutch Drive Link
585166	Roller Clutch Drive Link Stud
585170	Feed Adjustment Clamping Screw
E175	Hold Down Bar Spring
186-247	Ratchet Cover Plate
MR333	Ratchet Pawl Spring
585397A	Ratchet Cam Spring Assem.—L.S.R.
585244	Cam Spring
585204	Latch Lever Block
585215	Gate Cam Spring
585250	Gate Spring
585205	Register Cam Latch Block
585249	Staple Dial Spring
585097	Cam Roll
585098	Cam Roll and Cam Block Stud (2 per Machine)
585251	Locking Lever Spring
585341	Micro Switch Knock Off Plate Spring
585570A	Trip Gauge Weight Relief Spring Assem. (2 per Machine)
E133	Pressure Roll Plunger Spring
11244	Auxiliary Throw Out Roller Spring
86181	Control Relay for all Solenoids—115V. —60 Cycle (5 per Machine)
86185	Relay for Clutch—Brake Unit (inside Control Box)—90V.—D.C. (1 per Machine)
86184	Potentiometer for Clutch—Brake Unit (2 per Machine)
86195	"Buss"—Glass Tube Fuse—1 Amp.—250V. (3 per Machine)

COMPONENT PARTS OF
RSCA 585 SERIES AUTOMATIC STITCHERS

FP	Auxiliary Brake Lever Spring and Latch Lever Spring
BSA67A	Allen Wrench for Step Feed Roller and Tie Stitch Cam Lock
MR75	Solenoid Lever Pivot Screw Washer
76	Tie Stitch Pivot
MR76	Bracket Support Spacer
E133	Plunger Spring
134-65	Collar—1" Diam. Hole
134-65B	Collar—⅞" Diam. Hole
138-19	Ratchet Cover
164H8C	Drive Cam
E165	High Speed Switch Lever Spring and Knockoff Lever Spring
174	Table Washer
E175	Hold Down Bar Spring
185H3C	Clincher (7/16" Crown)
UA1405.2	Clincher Screw
UA1406.3	Clincher Screw for Open Head
186-247	Ratchet Cover Plate
194-20	Ratchet Wheel
199-72	Ratchet Roll
202-263	Drop Roller Arm Bearing Spring Adj. Screw
203-139	Reverse Gear Shaft
207-56	Drop Roller Arm Bearing Slide
210-197	Ratchet Roll Spring
210-297	Trip Gauge Return Spring
217G2	Brake Takeup Spring or Staple Dial Brake Spring
217-191	Head Casing Stud—Long
217-192	Head Casing Stud—Short
228-13	Openhead Bracket Screw Washer
229-56	Side Gauge Hand Wheel
MR333	Ratchet Pawl Spring
C451	Shakeproof Screw in 25021CA
E455	Ratchet Stop Block Spring Washer
500L5	Head Casing
501L	Elbow Assembly
541L4	Head Drive Shaft Bevel Gear
BG611	Tie Stitch Latch Block Nut
0087	Drop Roller Adjusting Screw Lock Spring
SB1204	Leveling Bushing
2335B	Cam Lever Spring
2341	Drop Roller Adjusting Screw Lock Pin
UA3308.2	Openhead Hinge Screw
11244	Auxiliary Throw-out Roller Spring
19277	Fork Bracket Dowel
25013	Feed Ratchet Arm
25014	Ratchet Auxiliary Arm
25021CA	Top Feed-Roll Shaft Hanger
25022A	Drop Roller Shaft Bracket
25029	Ratchet Return Spring Case
25070	Tie Stitch Latch
25071	Brake Take-up Screw
25074	Feed Ratchet Arm Pin
25076	Ratchet Pawl Pivot
25077	Ratchet Pawl Spring Post
25079A	Solenoid Lever Spring
25080	Spring Pin
25089A	Brake Band (Box Feed Clutch)
25091	Brake Take-up Screw Bar
25110	Ratchet Return Spring
25115	Throw-out Shaft Sprocket Key
25149	Breather Pipe
25153	Trip Gauge Clamp Bar Spacer
25164	Tie Stitch Trigger Spring, Cam Lever Trigger Spring and Cam Block Spring
25196	Tie Stitch Pawl Spring
25208	Tie Stitch Latch Shaft
25210	Tie Stitch Trigger Stud and Cam Lever Trigger Stud
25211	Tie Stitch Latch Lifter Stud
25212A	Tie Stitch Lock
25218	Tie Stitch Latch Spring
25258	High Speed Clutch Fork Bracket
25270	Staple Dial Brake Lever
25271A	Roller Clutch Bearing Bracket
25273	Staple Dial Brake Disc
25286	Staple Dial Friction Stud
25288	Staple Dial Brake Lever Stud
25289A	Staple Control Solenoid Lever
25292	Solenoid Lever Bushing
25293	Solenoid Link
25294A	Staple Dial Friction Adjusting Screw
25298	Drop Roller Arm
25299A	Step Feed Clutch Bracket
25301	Drop Roller Arm Bearing Spring
25304	Ratchet Spring Swivel Pin
25308	Staple Dial Return Stop Screw
25309	Staple Dial Return Stop Screw Retainer
25405	High Speed Clutch Shaft Collar
25407	Tie Stitch Trip Sleeve Block
25409	Tie Stitch Trigger Plate
25410	Tie Stitch Trigger
25411	High Speed Clutch Fork Shoe
25412	High Speed Clutch Fork Shoe Stud and Step Feed Clutch Fork Shoe Stud
25419	Staple Dial Return Stop Disc
25421	High Speed Clutch Lever Bushing
25422	Staple Dial Return Stop
25424A	Tie Stitch Trip Sleeve
25426A	Universal Feed Shaft (Upper)
25427A	Step Feed Gear Shaft
25428	High Speed Disc Clutch Fork Shaft
25430	Step Feed Clutch Shaft
25432A	High Speed Clutch Shaft
25435	Step Feed Slide Clutch
25445A	Drop Roller Adj. Screw—Lower
25462	High Speed Clutch Thrust Washer—Small
25464	High Speed Clutch Steel Disc
25480A	Aux. Brake Lock Arm
25481	Drop Roller Lever—Lower
25483	Aux. Brake Operating Lever
25484B	Aux. Brake Lever
25485B	Aux. Brake Shaft Bracket
25488A	Ratchet Shaft Bearing Bracket
25490	Aux. Brake Operating Drum Arm
25492	High Speed Clutch Spring
25499A	Drop Roll Adj. Screw—Upper
25500	Drop Roller Lever—Upper
25502A	Head Cam Shaft
25503	Staple Dial Friction
25506	Step Feed Clutch Key
25510	Collar for Shafts 585137 and 585060
25512A	Aux. Brake Stub Shaft
25513	Drop Roller Lever Stud
25514	Drop Roll Bumper Washer

25515	Auxiliary Brake Lock Bar
25516	Drop Roller Adj. Screw Bumper Washer
25518	Aux. Brake Cam Roller
25519	Aux. Brake Lever Pin
25521A	Lower Feed Roller Collar
25525	Drop Roller Arm Bearing Cap Cover
25529	Drop Roller Link
25534	Aux. Brake Drum
25535	Aux. Brake Lock
25537	Aux. Brake Operating Drum
25539A	Aux. Brake Band—Central
25547B	High Speed Switch Lever Stud
25570	Trip Gauge Plate Block Cap
25571	Trip Gauge Clamp Piece
25585	High Speed Clutch Thrust Washer—Large
25591	High Speed Tooth Clutch Fork
25593A	Ratchet Pawl Cam Spring Assem.
25606	Side Gauge Angle Plate—R.H.
25610	Side Gauge Angle Plate—L.H.
25633A	Drop Roller Arm Adj. Bearing
25635C	Solenoid Guard
25636	Aux. Brake Band Anchor
25637	Universal Shaft End
25639BA	Lower Step Feed Roller—L.H.
25640BA	Lower Step Feed Roller—R.H.
25645B	Solenoid Guard Bracket
25658B	Tie Stitch Adj. Screw
25660	Box Deflector—Right Side
25661	Aux. Brake Band Right End Stud
25736	Aux. Throw Out Driven Pulley
25737A	Aux. Throw Out Driving Pulley
25741	High Speed Roller Drive Shaft Sprocket
25752A	Drop Roller Lock Nut Assem.
25755	Solenoid Operating Link Fulcrum Pin
25756	Solenoid Link Pin
25757	Gate Solenoid Link Pin
25762A	Aux. Brake Hold Down Roll Assem.
25780	Roller Wheel Support
25797A	Pressure Roll Adj. Screw
25927	Head Cam Shaft Washer
25929	Aux. Brake Band—Left End
25930A	Aux. Brake Band—Right End
25932	Aux. Brake Band Hinge Pin
25933	Aux. Brake Lock Arm Spring
25934	Aux. Brake Lock Arm Spring Plate
25991	Spring Case Tension Screw
251348	Spring Link Case
251352	Leather Washer
251353	Steel Washer
251354	Solenoid Spring
251359	Solenoid Link Nut
251409	Oiler Plate
585001	Staple Dial Micro Switch Bracket
585002A	Micro Switch Knockoff Plate
585003	Check Pawl Bracket
585004	Staple Dial Latch
585005	Motor Plate
585006A	Eccentric Connecting Rod
585551A	High Speed and Aux. Brake Shaft Bracket
585008	High Speed Chain Tightener Lever
585009A	Upper Roller Shaft Bearing Bracket
585010A	High Speed Clutch Shaft Bearing
585011	High Speed Clutch Fork Bracket
585012	Drive Pulley
585013A	Roller Clutch Drive Link
585014	Feed Clutch Arm
585015A	Body
585016	Outboard Bearing Bracket
585017A	Brake Magnet Bracket Assembly
585018	Trip Gauge Main Support Bracket
585019	Trip Gauge Lifter Lever
585020	High Speed Switch Hold on Lever
585021	Trip Gauge Stripper
585022	Feed Roller Bracket
585024A	Feed Roller Extension Bearing
585025	Clamp Block (L.S.R.)
585026	Pressure Roll Bearing Bracket
585027	Pressure Roll Bearing
585028A	Micro Switch Knockoff Lever
585029	Locking Lever
585030B	Base (585H)
585030C	Base (585J)
585031	Table (585H and 585J)
585032	Solenoid Bracket (L.H.)
585033	Solenoid Bracket (R.H.)
585034A	Latch Lever
585035A	L.S.R. Slide Bracket
585036	L.S.R. Gate
585039	Register Gate Latch
585040	Staple Control Solenoid Bracket
585044A	Table Leg (Adjustable)
585045	Table Leg—Front (585J)
585046	Table Leg—Rear (585J)
585047	Knockoff Plate Cam Block
585048	Cross Tie For Legs
585049	Leg Brace
585055A	Trip Gauge Horizontal Support
585058A	Trip Gauge Slide Plate
585059A	Main Drive Shaft—Front Section
585060	High Speed Roller Drive Shaft
585061	Drop Roller Shaft
585062	Spring Pin
585063	Drop Roller Arm Guard
585065A	Feed Adjusting Screw
585067A	Pressure Roll Bearing Bracket Plunger
585069A	Trip Gauge Lifter Fork
585076A	Rear Lever (R.H.)
585077A	Rear Lever (L.H.)
585078A	Front Lever (R.H.)
585079A	Front Lever (L.H.)
585082A	Main Shaft Coupling
585083	Pressure Roll
585084	Pressure Roll Shaft
585085A	Universal Feed Shaft—Lower
585086A	Main Drive Shaft—Rear Section
585087	Eccentric Collar
585088	High Speed Switch Lever Link
585089	Deflector Plate
585090A	Last Staple Register Ratchet Cam
585091	Staple Dial Switch Knockoff Lever
585092	Locking Lever Stud
585094	Feed Adj. Clamping Screw Spacer
585097	Cam Roll
585098	Roll Stud
585101A	Trip Gauge Plate Assembly
585102A	Operating Mechanism Bearing Bracket
585103	Brake Band Bracket
585104A	Aux. Brake Shaft
585105	Idler Sprocket Stud
585106A	High Speed Clutch Sprocket
585109A	High Speed Switch Lever
585110	Base Plate
585111	Eccentric
585112A	Staple Dial

585113 Ratchet Cam Link
585114A Motor Plate Bracket
585115 Solenoid Bracket
585116 Aux. Brake Cam Hub
585118A Ratchet Cam Link
585119 Ratchet Pawl (Feed)
585120 Ratchet Pawl (Check)
585121 Drive Shaft Handwheel
585122 Solenoid Bracket
585123 Clutch Fork Link
585124 Aux. Brake Cam
585127 Solenoid Operating Link Fulcrum
585128 Tie Stitch Cam
585130A Trip Gauge Support Angle
585131 Feed Roller Extension Bracket Support
585133 Tie Stitch Arm
585135 Table Leg—Front (585H)
585136 Table Leg—Rear (585H)
585138 Base Plate Spacer
585140 Clutch Fork Shoe
585141 Ratchet Shaft Spacer
585142 High Speed Clutch Sleeve
585143 Clutch Sleeve Bearing Plate
585144A High Speed Clutch Chain Idler Sprocket
585145 High Speed Clutch Solenoid Link
585146 Tie Stitch Latch Lifter
585147 Tie Stitch Latch Lifter Cam Plate
585148 Micro Switch Screw
585149 Micro Switch Screw Nut
585150 Spring Holder
585151 Brush Holder Bracket
585153A Drive Pulley Guard
585154 High Speed Clutch Lever Stop Bar
585156 Trip Gauge Lifter Lever Pin
585158A Trip Gauge Mounting Unit
585160 Staple Selector Ratchet
585161 Trip Gauge Upper Arm
585162 Ratchet Shaft
585163 Hold On Switch Link Stud
585164 Knockoff Plate Pivot Pin
585165 Staple Dial Key
585166 Roller Clutch Link Stud
585167 Trip Gauge Stop Block
585168 Roller Clutch Link Stud Spacer
585169 Feed Adj. Clamping Screw Washer
585170 Feed Adj. Clamping Screw
585171 Motor Plate Support Post
585173A Cam Block
585174 Feed Adj. Pointer
585175 Staple Dial Arm
585177A Trip Gauge Arm—R.H.
585178A Trip Gauge Arm—L.H.
25007A Reverse Gear Bearing Bracket
585180A Ratchet Cam
585183A Solenoid Lever
585184A Last Staple Register Cam Assembly
585185 Motor Plate Adj. Screw
585186A Gate Return Bell Crank
585188 Bell Crank Link
585189 Gate Solenoid Link
585190 Tie Stitch Latch Block
585192A High Speed Clutch Lever
585193A Gate Solenoid Cam
585194 Gate Solenoid Cam
585195 High Speed Clutch Lever Pad
585197 Tie Stitch and Spring Cage Bracket
585199A High Speed Clutch Drive Ring
585216B Solenoid Guard
585200 High Speed Clutch Plate
585201 Gate Shaft
585202 Micro Switch Plate
585203 High Speed Switch Link Pin
585204 Latch Lever Block
585205 Register Gate Latch Block
585206 Cam Stud
585207 Cam Spring Washer
585208 Latch Lever Stud
585209 Cam Lever Stud
585210 Cam Stud Spacer
585211 Bell Crank Stud
585212A Latch Solenoid Link
585214 Gate Link Stud
585215 Gate Cam Spring
585217 Latch Lever Link Stud
585218A Upper Step Feed Roller—R.H.
585219A Upper Step Feed Roller—L.H.
585220 Cam Lever Stud
585221 Lower Feed Roller Shaft
585224A Cam Lever
585225A Cam Lever
585226 Cam Block
585228A Step Feed Clutch Solenoid Lever
585229 High Speed Clutch Lever Bracket
585230 High Speed Clutch Solenoid Bracket
585232A Micro Switch Bracket
585233 High Speed Clutch Lever Stop Screw
585234A Rear Side Gauge—R.H.
585235A Rear Side Gauge—L.H.
585236A Front Side Gauge—R.H.
585237A Front Side Gauge—L.H.
585239A Table Filler Plate
585240 Micro Switch Plate
585241 Step Feed Roll Drive Gear—Upper
585242 Lower Feed Shaft Gear
585243 Cam Stop and Spring Bracket
585244 Cam Spring
585245 Cam Spring Hook
585246 Cam Lock
585247 Cam Lock Hub
585248 Cam Plate Screw
585249 Staple Dial Spring
585250 Gate Spring
585251 Locking Lever Spring
585253 Ratchet Shaft Support Bracket
585254 Ratchet Shaft Support
585258A Pivot Pin Plate—Rear
585261A Front Lever
585262A Rear Lever
585263 Lever Link
585265 Drive Pulley Sprocket
585266A Operating Lever
585269A Stud Bracket Hub
585270 Front Lever Stud
585271 Rear Lever Stud
585273 Spring Bracket
585276 Solenoid Lever Stop Screw
585277 Staple Dial Return Stop Spacer (Large)
585278 High Speed Clutch Drive Sprocket
585281A Cam Lever
585282 Cam Lever Trigger
585301 Engaging Arm and Ratchet Shaft Key
585302 Eccentric Key and Taperlock Bushing Key
585303 Conveyor Frame
585304A Conveyor Frame Leg (585J)
585305A Conveyor Frame Leg (585H)

585306 Gate Cam Locking Plate
585308A Table Extension Bar
585310A Last Staple Register Unit Bar
585315A Conveyor Motor Bracket
585318 Conveyor Belt Frame
585319A Conveyor Pulley (Idler)
585320 Conveyor Pulley (Driver)
585321 Conveyor Pulley Spacer (Idler)
585322 Conveyor Pulley Spacer (Driver)
585323 Conveyor Pulley Idler Shaft
585324 Conveyor Pulley Drive Shaft
585330 Hold Down Bar Bracket
585331 Aux. Roller Bar Support
585332A Conveyor Aux. Roller Bar
585336 Conveyor Pulley Key
585337 Drive Pulley Key
585338 Knockoff Lever Pivot Pin
585339 Trip Gauge Upper Arm Tie Rod
585340 Trip Gauge Front Lever Tie Rod
585341 Micro Switch Knockoff Plate Spring
585343 Collar
585345A Trip Gauge Return Spring Bracket
585346 Trip Gauge Return Spring Adj. Screw
585347A Aux. Throw-Out Roller Lever
585348 Aux. Throw-Out Lifting Lever
585349A Aux. Throw-Out Roller
585350A Aux. Throw-Out Roller Drive Shaft Bracket
585351 Aux. Throw-Out Roller Drive Shaft
585352 Aux. Throw-Out Roller Shaft
585353 Collar
585354 Aux. Throw-Out Roller Lifting Link
585355 Link Pin (in 585348)
585356 Link Pin (in 585347A)
585357A Aux. Throw-Out Roller Spring Bracket
585359 Aux. Throw-Out Roller Spring Adj. Rod
585360A Hold Down Bar Yoke
585363 Hold Down Bar (Front)
585364 Hold Down Bar (Rear)
585570A Trip Gauge Weight Relief Spring Assem.
585368A Tie Stitch Adj. Screw Plate
585369 Universal Shaft End Cover
585370 Control Box Bracket—Upper
585372A Control Box Bracket—Lower (585H Only)
585373 Control Box Bracket—Lower (585J Only)
585374A Conveyor Frame Leg—R.H. Front (585H Only)
585375A Conveyor Frame Leg—L.H. Front (585H Only)
585376 Cat Walk Support (585H Only)
585377 Cat Walk R.H. (585H Only)
585378 Cat Walk L.H. (585H Only)
585380 High Speed Disc Clutch Fork
585381A Spring Link—Assem.—Complete
585382 Solenoid Link
585383 Gate Solenoid Bracket—R.H.
585384 Gate Solenoid Bracket—L.H.
585395 Gate Cam Stop Plate
585397A Ratchet Cam Spring Assem.—L.S.R.
585398 Outboard Stud Support
585399 Outboard Stud Support Plate
585400 Gate Bumper Screw Plate
585401 Extension Table
585420 Upper Step Feed Roller Shaft
585505 Staple Dial Return Stop Spacer (Small)
585508 Jack Shaft (Conveyor)
585509 Jack Shaft and Motor Plate (Conveyor)
585510 Jack Shaft Key (Conveyor)
585553 Trip Gauge Lifter Fork Stud
585559A Adjusting Scr. Bracket
585560 Spring Retaining Washer
585573 Trip Gauge Target Support Plate
85296 Jack Shaft Pulley (Conveyor)
*Check for current requirements.

85297 V-Belt—Motor to Jack Shaft (Conveyor)
85681 Jack Shaft Bearing (Conveyor)
585403 Push Button Station Bracket
85006 Rubber O Ring
85011 Lock Ring
85173 Solenoid—110V—60 cy.—A.C.
85251 Openhead Hinge
85278 Vee Belt (Main Drive)
85288 Vee Belt (Conveyor Drive)
85289 Conveyor Belt
85291 Conveyor Drive Shaft Pulley
85295 Conveyor Motor Pulley
585367 Belt (Throw-Out Roller)
85285 Belt Fastener
85400 Push Button Station
85464* Transformer { 220V to 110V—60 Cy. / 440V to 110V
85465* Transformer 550 to 110V—60 Cy. } 60 Cy. Transformer
85466* Transformer { 220V to 110V / 440V to 110V } for 50 Cy. Current
85467* Transformer 550V to 110V } 60 Cy. Transformer
85468* Transformer { 220V to 110V—25 Cy. / 440V to 110V } for 50 Cy. Current
85469* Transformer 550V to 110V—25 Cy.
85476 High Speed Roller Chain Link
85545 Conveyor Drive Shaft Bearing
85579 High Speed Roller Chain
85582 High Speed Clutch Chain
85583 H.S. Clutch Chain Conn. Link
85584 H.S. Clutch Chain Offset Link
85607 High Speed Clutch Sleeve Washer
85656 High Speed Clutch Sleeve Bearing
85675 Idler Sprocket Bearing
85676 Pressure Roll Bearing
85677 Main Drive Pulley Bearing
85678 Main Drive Shaft Bearing
85679 High Speed Shaft Bearing
85835 Operating Mech. Bearing Bracket Bushing—1" hole and Top Feed Roll Shaft Hanger Bushing—Front
85837 Reverse Gear Bearing Bracket and High Speed Clutch Shaft Sprocket Bushings
85840 Top Feed Roll Shaft Hanger Bushing—Back
85841 Drop Roller Shaft Bracket Bushing
85848 Aux. Brake Lock Arm Bushing
85850 Drop Roller Arm Adjust Bearing Bushing
85904 Head Casing Bushing and Operating Mech. Bearing Bracket Bushing—1⅛" hole
85907 Connecting Rod Bushing
85911 Extension Table Roll and Conveyor Aux. Roller
86038 Conveyor Motor Circuit Breaker
86246 Main Control Box
86110 Micro Switch—R.H.
86111 Micro Switch—L.H.
86113 Warner Electric Brake and Clutch
86226 Conveyor Motor
86127 Push Button Station (Single)

MOTOR PULLEYS

585585 Motor Pulley—Std.—400 R.P.M. (1725 R.P.M. Motor) ¾ H.P.
585433A Motor Pulley—Std.—400 R.P.M. (1725 R.P.M. Motor) 1 H.P.
585586 Motor Pulley—400 R.P.M. (1425 R.P.M. Motor) ¾ H.P.
585432A Motor Pulley—400 R.P.M. (1425 R.P.M. Motor) 1 H.P.

STANDARD OPENHEADS

25187 Openhead Bracket
25578A R.H. Rigid Openhead
251009 R.H. Rigid Openhead Unit
251430A L.H. Rigid Openhead
251399 L.H. Rigid Openhead Unit
25678A L.H. Openhead Bracket

RSCA 585 STITCHER PARTS LIST
BY SECTIONS OR UNITS

BASE AND TABLE PARTS

585030B	Base (585H)
585030C	Base (585J)
585031	Table (585H and 585J)
585239A	Table Filler Plate
585045	Table Leg—Front (585J)
585046	Table Leg—Rear (585J)
585135	Table Leg—Front (585H)
585136	Table Leg—Rear (585H)
585044A	Table Leg—Adjustable
585401	Extension Table
85911	Extension Table Roller
25780	Roller Wheel Support
585403	Push Button Station Bracket
585234A	Rear Side Gauge—R.H.
585235A	Rear Side Gauge—L.H.
585236A	Front Side Gauge—R.H.
585237A	Front Side Gauge—L.H.
25606	Side Gauge Angle Plate—R.H.
25610	Side Gauge Angle Plate—L.H.
229-56	Side Gauge Hand Wheel

BODY PARTS

585110	Base Plate
585015A	Body
501L	Elbow Assembly
500L5	Head Casing
217-191	Head Casing Stud—Long
217-192	Head Casing Stud—Short
25149	Breather Pipe
SB1204	Leveling Bushing

MAIN DRIVE

585016	Outboard Bearing Bracket
85678	Main Drive Shaft Bearing
585017A	Brake Magnet Bracket Assembly
585086A	Main Drive Shaft—Rear Section
585059A	Main Drive Shaft—Front Section
585082A	Drive Shaft Coupling
25502A	Head Cam Shaft Assembly
541L4	Head Cam Shaft Gear
25927	Head Cam Shaft Gear Washer
164H8C	Cam
585012	Drive Pulley
85677	Drive Pulley Ball Bearing
585265	Drive Pulley Sprocket
585114A	Motor Plate Bracket
585185	Motor Plate Adjusting Screw
585171	Motor Plate Support Post
585005	Motor Plate
585121	Hand Wheel
585151	Clutch Brush Holder Bracket
585585	Motor Pulley (Std. 400 R.P.M.) ¾ H.P. Motor
585433A	Motor Pulley (Std. 400 R.P.M.) 1 H.P. Motor
85278	V-Belt (Main Drive) ¾ H.P. Motor
85299	V-Belt (Main Drive) 1 H.P. Motor
585302	Taperlock Bushing Key

TRIP GAUGE PARTS

585018	Trip Gauge Main Support Bracket
585055A	Trip Gauge Horizontal Support
585167	Trip Gauge Stop Block
585058A	Trip Gauge Slide Plate
25153	Trip Gauge Clamp Bar Spacer
585553	Trip Gauge Lifter Fork Stud
585573	Trip Gauge Target Support Plate
585158A	Mounting Unit
585076A	Rear Lever—R.H.
585077A	Rear Lever—L.H.
585078A	Front Lever—R.H.
585079A	Front Lever—L.H.
585340	Front Lever Tie Rod
585177A	Trip Gauge Arm—R.H.
585178A	Trip Gauge Arm—L.H.
585161	Upper Arm
210-297	Trip Gauge Return Spring
585021	Trip Gauge Stripper
585101A	Trip Gauge Plate Assembly
25570	Trip Gauge Plate Block Cap
25571	Trip Gauge Clamp Piece
585069A	Trip Gauge Lifter Fork
585019	Trip Gauge Lifter Lever
585156	Trip Gauge Lifter Lever Pin
585109A	High Speed Switch Lever
585203	High Speed Switch Link Pin
585088	High Speed Switch Lever Link
25547B	High Speed Switch Lever Stud
585020	High Speed Switch Hold On Lever
585163	Hold On Switch Link Stud
585130A	Trip Gauge Support Angle
585345A	Trip Gauge Return Spring Bracket
585346	Trip Gauge Return Spring Adjusting Screw
585570A	Trip Gauge Weight Relief Spring Assem.
E165	High Speed Switch Lever Spring

UPPER STEP FEED SHAFT AND HIGH SPEED CLUTCH PARTS

25007A	Reverse Gear Bearing Bracket
585009A	Upper Roller Shaft Bearing Bracket
585010A	High Speed Clutch Shaft Bearing
585011	High Speed Clutch Fork Bracket
585229	High Speed Clutch Lever Bracket
585022	Feed Roller Bracket
25021CA	Top Feed Roll Shaft Hanger—Front
585024A	Feed Roller Extension Bearing
585131	Feed Roller Extension Bracket Support
585241	Step Feed Roll Drive Gear—Upper
203-139	Reverse Gear Shaft
25637	Universal Shaft End
25426A	Universal Feed Shaft—Upper
25432A	High Speed Clutch Shaft
585420	Upper Step Feed Roller Shaft
25510	Collar (On Shaft 585420)
585106A	High Speed Clutch Sprocket
585199A	High Speed Clutch Drive Ring
25585	High Speed Clutch Thrust Washer—Large
585200	High Speed Clutch Plate
25464	High Speed Clutch Steel Disc
585143	Clutch Sleeve Bearing Plate
585142	High Speed Clutch Sleeve
85656	High Speed Clutch Sleeve Ball Thrust Bearing
25492	High Speed Clutch Spring
85607	High Speed Clutch Sleeve Washer
25462	High Speed Clutch Thrust Washer—Small
25405	High Speed Clutch Shaft Collar

585184A	Cam Assembly
585247	Cam Lock Hub
585246	Cam Lock
585254	Ratchet Shaft Support
585253	Ratchet Shaft Support Bracket
585118A	Ratchet Cam Link
25289A	Staple Control Solenoid Lever
25292	Solenoid Lever Bushing
25756	Solenoid Link Pin
25293	Solenoid Link
585040	Staple Control Solenoid Bracket
585240	Micro Switch Plate
585001	Staple Dial Micro Switch Bracket
585002A	Micro Switch Knock Off Plate
585341	Micro Switch Knock Off Plate Spring
585164	Knock Off Plate Pivot Pin
585047	Knock Off Plate Cam Block
585029	Locking Lever
585092	Locking Lever Stud
585251	Locking Lever Spring
585148	Micro Switch Screw
585149	Micro Switch Screw Nut
585232A	Micro Switch Bracket
585001	Last Staple Register Micro Switch Bracket
585062	Spring Pin
585028A	Micro Switch Knock Off Lever (L.S.R.)
585338	Knock Off Lever Pivot Pin
85011	Lock Ring
E165	Knock Off Lever Spring
585098	Roll Stud
585173A	Cam Block
25164	Cam Block Spring
585097	Cam Roll
585555	Cam Block Stud

DROP ROLLER PARTS

25022A	Rocker Shaft Bracket
585061	Drop Roller Shaft
25633A	Drop Roller Arm Adjusting Bracket
207-56	Drop Roller Arm Bearing Slide
202-263	Drop Roller Arm Bearing Spring Adjusting Screw
585063	Drop Roller Arm Guard
25525	Drop Roller Arm Bearing Cap Cover
25481	Drop Roller Lever—Lower
25500	Drop Roller Lever—Upper
25529	Drop Roller Link
25513	Drop Roller Lever Stud
25445A	Drop Roller Adjusting Screw—Lower
25499A	Drop Roller Adjusting Screw—Upper
25516	Drop Roller Adjusting Screw Bumper Washer
25514	Drop Roller Bumper Washer
2341	Drop Roller Adjusting Screw Lock Pin
0087	Drop Roller Adjusting Screw Lock Spring
25752A	Lock Nut Assembly
25301	Drop Roller Arm Bearing Spring

TIE STITCH PARTS

76	Tie Stitch Pivot
BG611	Tie Stitch Latch Block Nut
585133	Tie Stitch Arm
25070	Tie Stitch Latch
585190	Tie Stitch Latch Block
25164	Tie Stitch Trigger Spring
25196	Tie Stitch Pawl Spring
25208	Tie Stitch Latch Shaft
25211	Tie Stitch Latch Lifter Stud
25210	Tie Stitch Trigger Stud
25212A	Tie Stitch Lock
25218	Tie Stitch Latch Spring
25407	Tie Stitch Trip Sleeve Block
25409	Tie Stitch Trigger Plate
25410	Tie Stitch Trigger
25658B	Tie Stitch Adjusting Screw
25424A	Tie Stitch Trip Sleeve
585128	Tie Stitch Cam
585197	Tie Stitch and Spring Cage Bracket
585146	Tie Stitch Latch Lifter
585147	Tie Stitch Latch Lifter Cam Plate
585248	Cam Plate Screw
585368A	Tie Stitch Adjusting Screw Plate

AUXILIARY BRAKE PARTS

585102A	Operating Mechanism Bearing Bracket
25485B	Auxiliary Brake Shaft Bracket
585551A	High Speed and Auxiliary Brake Shaft Bracket
585104A	Auxiliary Brake Shaft
25484B	Auxiliary Brake Lever
25535	Auxiliary Brake Lock
25480A	Auxiliary Brake Lock Arm
25518	Auxiliary Brake Cam Roller
25519	Auxiliary Brake Cam Roller Pin
585124	Auxiliary Brake Cam
585116	Auxiliary Brake Cam Hub
25515	Auxiliary Brake Lock Bar
25934	Auxiliary Brake Lock Arm Spring Plate
25933	Auxiliary Brake Lock Arm Spring
FP	Auxiliary Brake Lever Spring
25483	Auxiliary Brake Operating Lever
25537	Auxiliary Brake Operating Drum
25512A	Auxiliary Brake Stub Shaft
25490	Auxiliary Brake Operating Drum Arm
25762A	Auxiliary Brake Hold Down Roll Assembly
25534	Auxiliary Brake Drum
25539A	Auxiliary Brake Band—Central
25636	Brake Band Anchor
25930A	Auxiliary Brake Band—Right End
25929	Auxiliary Brake Band—Left End
25661	Auxiliary Brake Band Stud—Right End
25932	Auxiliary Brake Band Hinge Pin

ECCENTRIC FEED

585006A	Eccentric Connecting Rod
585111	Eccentric
585302	Eccentric Key
585087	Eccentric Collar

PRESSURE ROLL PARTS

585026	Pressure Roll Bearing Bracket
585027	Pressure Roll Bearing
585083	Pressure Roll
85676	Pressure Roll Ball Bearing
585084	Pressure Roll Shaft
585089	Deflector Plate
585067A	Pressure Roll Bearing Bracket Plunger
25797A	Pressure Roll Adjusting Screw
E133	Plunger Spring
585343	Collar

LAST STAPLE REGISTER UNIT

585035A	Last Staple Register Slide Bracket

2335B	Cam Lever Spring
585560	Spring Retaining Washer
585559A	Adjusting Scr. Bracket
25658B	Gate Stop Screw
585395	Gate Cam Stop Plate
585398	Outboard Stud Support
585399	Outboard Stud Support Plate
585400	Gate Bumper Screw Plate
585025	Clamp Block
585036	Last Staple Register Gate
585201	Gate Shaft
585193A	Gate Solenoid Cam
585250	Gate Spring
585226	Cam Block
585243	Cam Stop and Spring Bracket
585245	Cam Spring Hook
585244	Cam Spring
585039	Register Gate Latch
585205	Register Gate Latch Block
585034A	Latch Lever
585208	Latch Lever Stud
585204	Latch Lever Block
585212A	Latch Solenoid Link
585217	Latch Lever Link Stud
FP	Latch Lever Spring
585186A	Gate Return Bell Crank
585211	Bell Crank Stud
585188	Bell Crank Link
585214	Gate Link Stud
585189	Gate Solenoid Link
25757	Gate Solenoid Link Pin
25756	Solenoid Pin
585281A	Cam Lever
585282	Cam Lever Trigger
25210	Cam Lever Trigger Stud
25164	Cam Lever Trigger Spring
585225A	Cam Lever
585209	Cam Lever Stud
585210	Cam Stud Spacer
585194	Gate Solenoid Cam
585206	Cam Stud
585215	Gate Cam Spring
585207	Cam Spring Washer
585224A	Cam Lever
585220	Cam Lever Stud
585033	Solenoid Bracket—R.H.
585032	Solenoid Bracket—L.H.
585383	Gate Solenoid Bracket—R.H.
585384	Gate Solenoid Bracket—L.H.
585202	Micro Switch Plate
585310A	Last Staple Register Unit Bar
585308A	Table Extension Bar
585306	Gate Cam Locking Plate

CONVEYOR AND HOLD DOWN BAR

585303	Conveyor Frame
585304A	Conveyor Frame Leg (585J)
585305A	Conveyor Frame Leg (585H)
585374A	Conveyor Frame Leg—R.H. Front (585H only)
585375A	Conveyor Frame Leg—L.H. Front (585H only)
585315A	Conveyor Motor Bracket
585508	Jack Shaft (Conveyor)
585509	Jack Shaft and Motor Plate (Conveyor)
585510	Jack Shaft Key (Conveyor)
85295	Motor Pulley (Conveyor)
85296	Jack Shaft Pulley (Conveyor)
85297	V-Belt—Motor to Jack Shaft (Conveyor)
85681	Jack Shaft Bearing (Conveyor)
86226	Conveyor Motor
585318	Conveyor Belt Frame
585319A	Conveyor Pulley—Idler
585320	Conveyor Pulley—Driver
585321	Conveyor Pulley Spacer—Idler
585322	Conveyor Pulley Spacer—Driver
585323	Conveyor Pulley Idler Shaft
585324	Conveyor Pulley Drive Shaft
585337	Drive Pulley Key
85545	Drive Shaft Flange Bearing
85289	Conveyor Belt
85291	Drive Shaft Pulley
85288	Vee Belt (Conveyor Drive)
85911	Auxiliary Roller
585332A	Auxiliary Roller Bar
585331	Auxiliary Roller Bar Support
585266A	Hold Down Bar Operating Lever
585261A	Front Lever
585263	Lever Link
585270	Front Lever Stud
585269A	Stud Bracket Hub
585262A	Rear Lever
585271	Rear Lever Stud
585258A	Pivot Pin Plate (Rear)
585273	Spring Bracket
E175	Hold Down Bar Spring
585360A	Hold Down Bar Yoke
585363	Hold Down Bar (Front)
585364	Hold Down Bar (Rear)

AUXILIARY THROW OUT ROLLER

585350A	Auxiliary Throw Out Roller Drive Shaft Bracket
585351	Auxiliary Throw Out Roller Drive Shaft
25637	Universal Shaft End
25737A	Auxiliary Throw Out Driving Pulley
25736	Auxiliary Throw Out Driven Pulley
585348	Auxiliary Throw Out Roller Lifting Lever
585354	Auxiliary Throw Out Roller Lifting Link
585355	Link Pin (in 585348)
585356	Link Pin (in 585347A)
585357A	Auxiliary Throw Out Roller Spring Bracket
585359	Auxiliary Throw Out Roller Spring Adjusting Rod
585367	Belt
85285	Belt Fastener
585085A	Universal Shaft
585352	Auxiliary Throw Out Roller Shaft
585349A	Auxiliary Throw Out Roller
585347A	Auxiliary Throw Out Roller Lever
11244	Auxiliary Throw Out Roller Spring
585369	Universal Shaft End Cover

PREVENTATIVE MAINTENANCE CHECK LIST

In order to obtain the maximum efficiency of these machines, and to keep "Down Time" to a minimum, the following check list is recommended.

NOTE: If necessary, refer to various sections in this book and the Bliss Head Instruction Book, for more detailed instructions of items below.

A. Oil stitcher every eight hours of operation.

B. Lubricate grease fittings every 40 hours of operation.

DAILY

Start the stitcher motor and allow machine to run free for about two (2) minutes. This will allow all moving parts to operate in idling position. Trip the stitching mechanism, without feeding wire, about five (5) times and then engage wire and trip once more. Machine is now ready for stitching boxes.

1. Each unit should be oiled every 8-hour run. Use a good grade of oil such as #20 S.A.E. or equivalent. The wire feed clutch should be oiled with a light oil such as 3-in-1 or the equivalent.
2. Check wire feed clutch at end of daily run to see that it is free of gummy oil, grit and wire scrapings. If not, disassemble clutch, clean with kerosene or a good oil solvent and lubricate the rollers with 3-in-1 oil or equivalent.
3. Check operation of all Micro switches to see that they are properly adjusted and make certain that the plungers do not bottom.
4. Box feed clutch brake and auxiliary brake should be cleaned daily as excessive oil on the brakes may cause too great a variation in the spacing of staples.
5. Check tension on staple dial return spring. Tension should be no more than is necessary to operate efficiently when dial is set for 3 staples.
6. The 72 tooth step feed slide clutch should have a clearance of .035" to .040" when clutch is disengaged or in neutral. Adjust to maintain this clearance.
7. The auxiliary brake needs just enough pressure to remove any back lash in the upper feed rolls during the stitching cycle. Any undue strain will cause a load on the motor.
8. The ratchet feed clutch brake band needs just enough pressure to hold the ratchet case from over-traveling during the connecting rod travel or the step feed motion.
9. All solenoids to be kept free of oil and grease. Replace mushroomed plungers.
10. The high speed clutch micro switch must contact but not bottom when the box pushes the target fully to the rear. The main clutch micro switch to make contact $\frac{1}{16}$" later than the high speed switch. This will allow the feed rolls to stop and hold the box before the main clutch is put into action.
11. Keep oil in elbow up to inspection level using 600W oil. Check monthly.
12. Keep standard springs on all moving parts. Replace stretched or broken springs by springs listed in Instruction Manual.
13. Keep on hand an ample supply of parts as recommended in stitcher Instruction Manual.