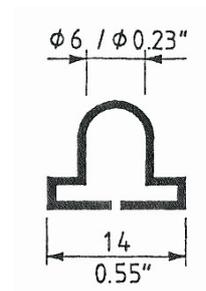
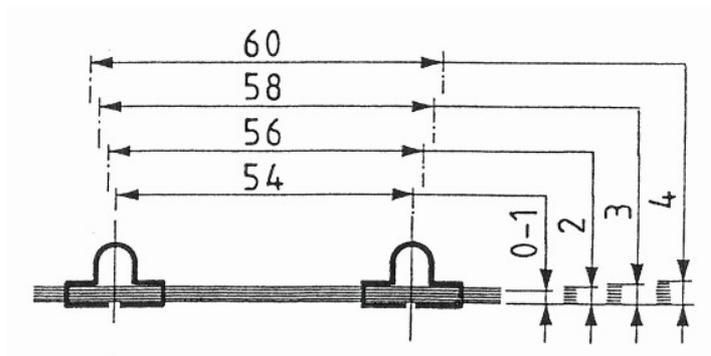


Standard loop stitching

Distances between staples and stitching thickness in mm

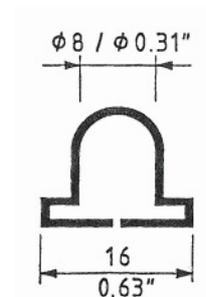
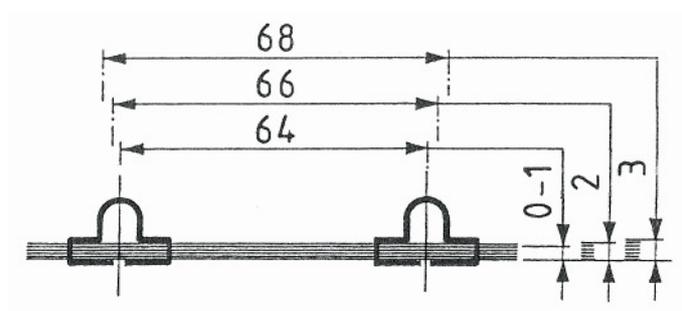


Round stitching wire:

No. 24 - 26
0,60 - 0,50 mm ϕ
0.024 - 0.020 in. ϕ

Loop stitching

Distances between staples and stitching thickness in mm



Round stitching wire:

No. 24 - 26
0,60 - 0,50 mm ϕ
0.024 - 0.020 in. ϕ

ATTENTION!

Please only use name brand steel, in normal or extra high tension steel versions, depending on usage. By heavy scuffing of wire, scuff resistibility causes wire guides to clog.

I. General and Services

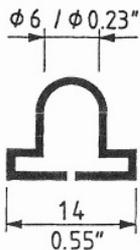
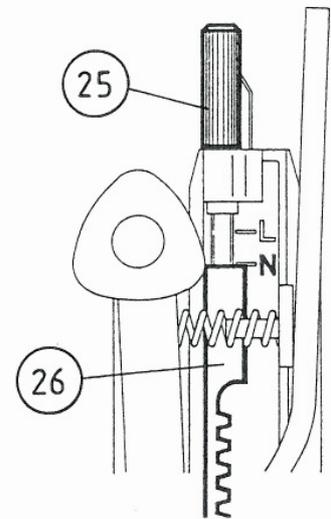
10. Basic setting of wire length

The adjustment is necessary only once, and that is when the stitching head is installed and compression is set. A slight correction is only necessary if you change the stitching wire thickness.



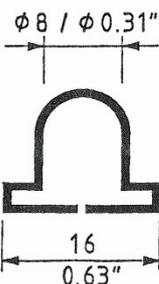
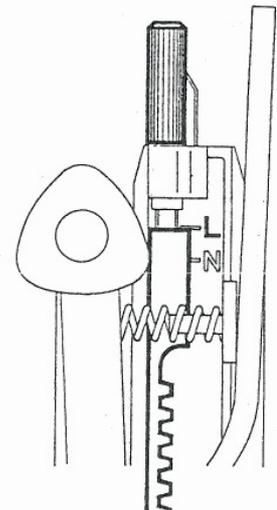
Standard stitching

The required length of wire for 2-page stitching is approx. 26 mm. Set the stitching aggregate for 2-page stitching. Turn knurled nut **25** until the upper edge of the tooth rack **26** indicates „N“.
* Afterwards fine adjustment..



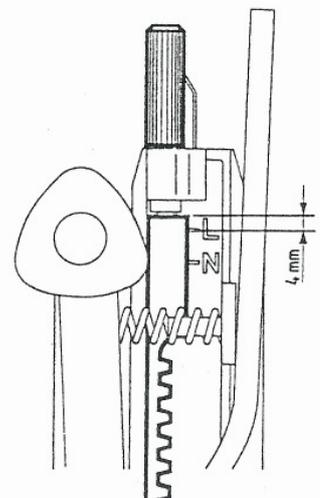
Standard loop-stitching

The required length of wire for 2-page stitching is approx. 32 mm. Set the stitching aggregate for 2-page stitching. Turn knurled nut **25** until the upper edge of the tooth rack **26** indicates „L“.
* Afterwards fine adjustment.



8 mm loop-stitching

The required length of wire for 2-page stitching is approx. 40 mm. Set the stitching aggregate for 2-page stitching. Turn knurled nut **25** until upper edge of the tooth rack **26** is approx. 4 mm over „L“. * Afterwards fine adjustment.



* Fine Adjustment

knurled nut **25** turned to the right
= longer wire

knurled nut **25** turned to the left
= shorter wire

II. Conversion of the UNIVERSAL 52/8



For standard loop stitching a change part set
Art.-No. 05 52 940 consisting of the following parts is needed:



Art.-No. 38 63 418 L	leaf spring, short
Art.-No. 99 63 402 L	cutting block, cpl.
Art.-No. 99 63 408 L	bender, cpl.
Art.-No. 99 63 410 L	former, cpl.

For the 7 mm loop stitching a change part set
Art.-Nr. 05 52 944 consisting of the following parts is needed:



Art.-No. 31 63 442 L 7/8	shoe tongue curve, flat
Art.-No. 38 63 418 L	leaf spring, short
Art.-No. 99 63 402 L	cutting block, cpl.
Art.-No. 99 63 455 L 7	former, cpl.
Art.-No. 99 63 458 L 7	bender, cpl.

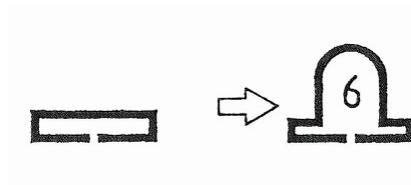
For the 8 mm loop stitching a change part set
Art.-No. 05 52 942 consisting of the following parts is needed:



Art.-No. 31 63 442 L 7/8	shoe tongue curve, flat
Art.-No. 38 63 418 L	leaf spring, short
Art.-No. 99 63 402 L	cutting block, cpl.
Art.-No. 99 63 435 L 8	former, cpl.
Art.-No. 99 63 440 L 8	bender, cpl.

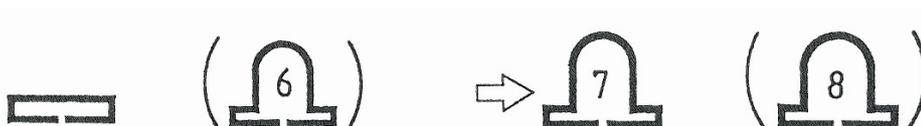
II.a Conversion from standard-stitching to standard loop-stitching

(see page 27)



Pivot the leaf spring **23** sideways and remove the former **14** . Remove hexagon socket head cap screw **45** and the corresponding carrier **46** . Pull out the bender **31** downwards. Install bender **31** for standard loop-stitching and make sure that the latch (see chapter 12, pos. 35) is pressed a bit into the bender. Install carrier **46** and tighten hexagon socket head cap screw **45** again. Loosen both slotted countersunk head screws **38** from the cutting block **39** and exchange the cutting block for standard loop-stitching. Tighten slotted counter-sunk head screws **38** again. Install former **14** for standard loop-stitching (watch right adjustment of former, see chapter 11) and put the short leaf spring **23X** on the leaf spring **23** with the prevailing torque type hexagon nut **57** . Pivot back leaf spring **23** .

II.b Conversion from standard-stitching to loop-stitching 7mm and 8mm



Pivot the leaf spring **23** sideways and remove the former **14** . Remove hexagon socket head cap screw **45** and the corresponding carrier **46** . Pull out the bender **31** downwards. Loosen the hexagon socket head cap screws **51** on both sides of the stitching head. Exchange shoe tongue curves **52** with the flat shoe tongue curves for 7 mm or 8 mm loop-stitching. Tighten hexagon socket head cap screws **51** . Install bender **31** for 7 mm or 8 mm loop-stitching and make sure that the latch (see chapter 12, Pos. 35) is pressed a bit into the bender. Install carrier **46** and tighten hexagon socket head cap screw **45** again. Loosen both slotted countersunk head screws **38** from the cutting block **39** and exchange the cutting block for 7 mm or 8 mm loop-stitching. Tighten slotted countersunk head screws **38** again. Install former **14** (watch right adjustment of former, see chapter 11) for 7 mm or 8 mm loop-stitching and put the short leaf spring **23X** on the leaf spring **23** with the prevailing torque type hexagon nut **57** . Pivot back leaf spring **23** .

