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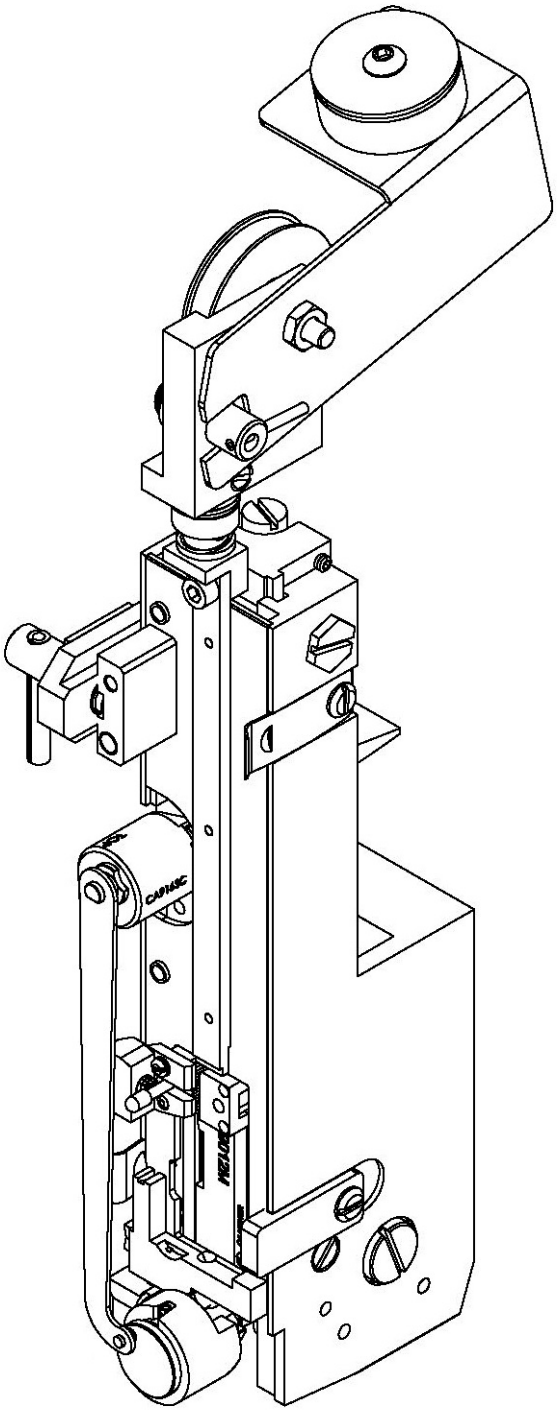
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MBM CORPORATION

MBM EZ Thread

for SF2 Bookletmaker



Owners manual

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SAFETY PRECAUTIONS AND PROCEDURES

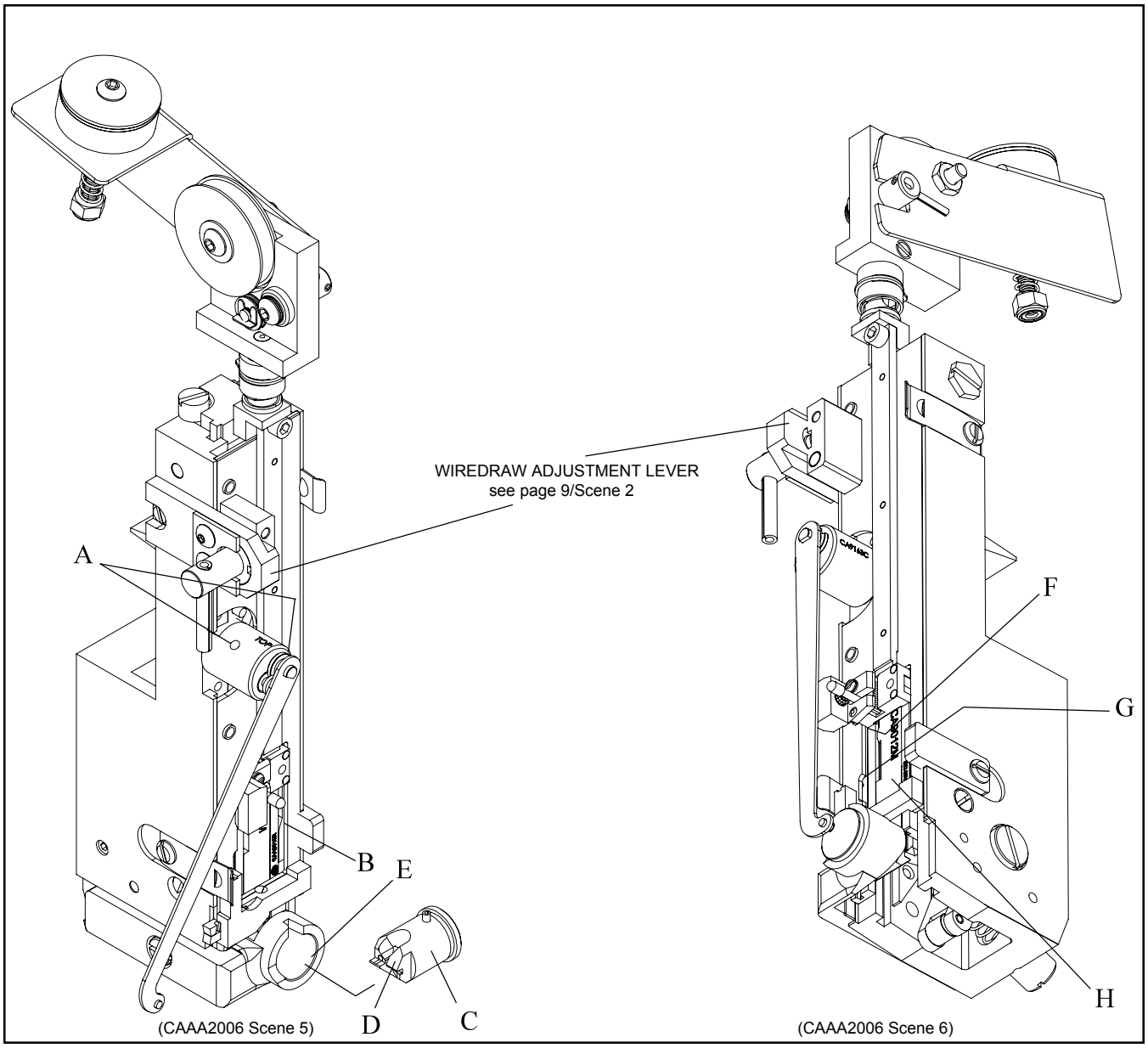
1. *Make sure electrical power is turned off before performing any adjustment or maintenance.*
2. *Keep hands, hair, tools, and clothing clear of stitching area.*
3. *Become familiar with the moving components of your machine. Keep fingers away from areas that could pinch or cut.*
4. *A well maintained machine is a safer machine. Clean and lubricate the machine at regular intervals. Check machine daily for broken or worn parts. Replace as necessary. DO NOT attempt to operate the machine if a part is broken.*
5. *If you are unsure how to safely operate your Bookletmaker, contact your Service Representative.*



KEEP HANDS CLEAR OF STITCHING AREA!



Be sure your stitcher or collator has adequate guards to keep fingers out of the *EZ Thread's* point of operation.



STITCHING HEAD LUBRICATION

Typically, the 1/2 inch crown stitcher will run for 1,000,000 cycles without additional lubrication. However, the following procedure used after each spool of wire will assure optimum life and performance. Use **ISP** lubricant #CA9640.

A. Inject lube into hole, or remove and lube shafts.

B. Wipe area clean and inject a small amount of lube into cam area.

C. Remove rotator, wipe rotator clean and lube rotator body.

D. Apply lube to rotator ramp.

E. Wipe clean inside of rotator holder.

F. Inject a small amount of lube into cam area of driver bar.

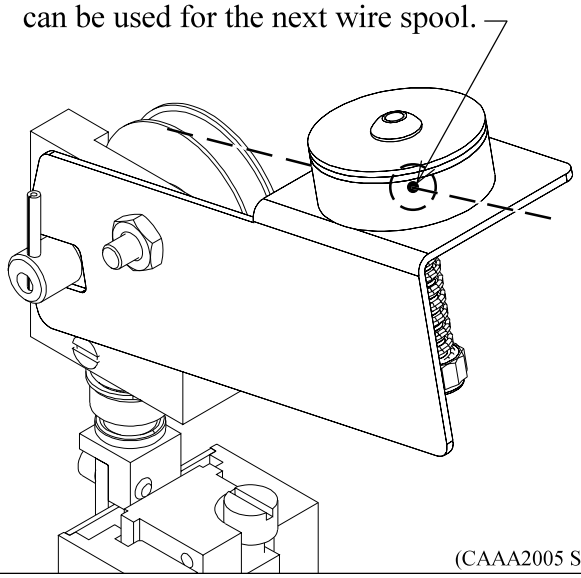
G. Inject lube into cutter operating slide.

H. Wipe driver clean, and apply a light coating of lube.

After prolonged use (or storage) accumulations of wire dust, dirt, or other contaminants can mix with the stitcher lubricant. This will reduce the lubricant's effectiveness. The following procedure is recommended every 1,000,000 cycles.

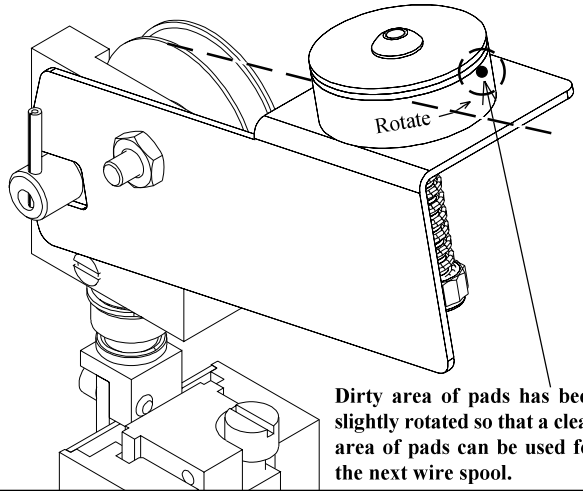
1. Disassemble the head and clean all parts.
2. Lightly lube all sliding surfaces using **ISP** lubricant #CA9640.
3. Double check lube points A through H.

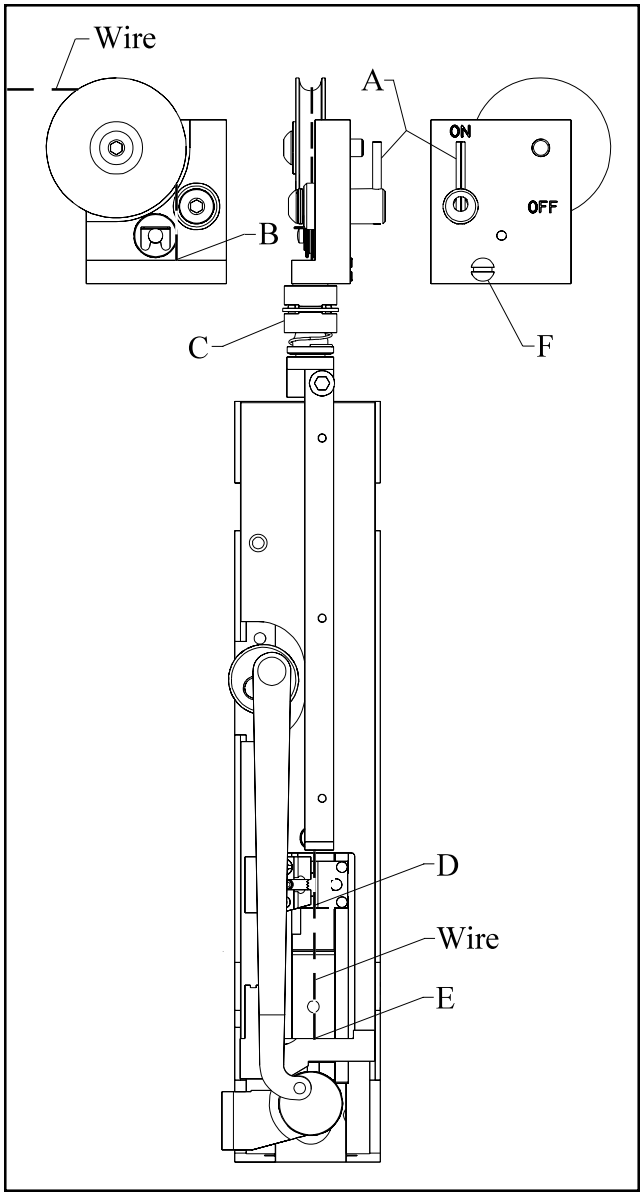
1. After every wire spool, rotate the dirty area of the pads slightly so that a clean area can be used for the next wire spool.



(CAAA2005 Scene 27)

2. Dampen both pads (about 30 to 40 drops) using an SAE 20W oil.





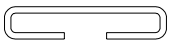
IMPORTANT! In order for the stitchers to operate properly, the felt wire wipes **MUST** be rotated and dampened with SAE 20W oil before each new spool of wire (50,000 to 70,000 stitches). Replace felt pads when they become so dirty that they cannot be rotated to a clean spot.

THREADING

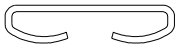
1. Rotate the wire threading lever (A) clockwise to the "OFF" position.
2. Feed the wire over the top roller, between the straightening rollers, and into the hole in the bracket as indicated (B).
3. Push downward on check pawl collar (C) to continue to feed the wire. The collar can be released when the wire gets past the check pawl.
4. Continue to feed the wire, and watch for it to come out past the gripper (D).
5. Feed a little more wire, and guide it into the hole in the top of the cutter (E). Allow the wire to enter this hole about 1/8".
6. Turn wire threading lever (A) counter clockwise to the "ON" position.
7. If necessary, tighten set screw (F) to keep the top roller alligned with the spool of wire.
8. Install wire between thin and thick round felt pads.

The head is now ready to operate. Please note that two cycles of the newly threaded head will be required before you get a proper stitch.

TROUBLE SHOOTING



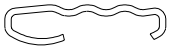
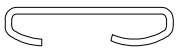
Activated Clinch

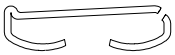


Solid Clinch

HERE'S HOW A PERFECT STITCH LOOKS.

One or more mechanical problems can cause malformed stitches. Use the following chart to resolve any problems. Be sure to check each possible cause.

TROUBLE	POSSIBLE CAUSE & REMEDY
3. One or both legs are buckled.  NOTE: Since buckled legs are often concealed in the work and may appear the same as a short leg, always remove two or more stitches to see which condition is occuring.  4. Crown is wrinkled.	1. Clincher is improperly aligned with head. Adjust clincher or head sideways. On a Stitch'n Fold, loosen the mounting knob behind the head, tilt the head slightly to one side, and tighten. 2. Clincher is worn. Replace clincher. 3. Insufficient compression. Adjust clincher upward or set head actuating bar lower. 4. Unequal leg length. Balance stitch legs per instructions on page 9. 5. Wire is wrong size. Use only approved stitching wire: ISP part number 415-0225. 6. Bender bar is worn. Replace bender bar, item 52 on page 11. (Or replace bender bar assembly, item 51 on page 11.
5. Stitch crown is not flat. 	1. Insufficient compression. Adjust clincher upward or set head actuating bar lower.
6. Leg length varies. 	1. Unequal leg length. Balance stitch legs per instructions on page 9. 2. Grip is worn or dirty. Clean or replace grip, item 61 on page 11. 3. Grip spring is weak or broken. Replace grip spring, item 56 on page 11. 4. Grip release slide is worn. Replace grip release slide, item 23 on page 10. 5. Driver bar is worn. Replace driver bar, item 53 on page 11. 6. Check pawl is worn or dirty. Clean check pawl assembly, item 5 on page 12. Replace worn check pins, item 9 on page 12, or replace entire check pawl assembly. 7. Excessive tension on wire straightener. Turn roll pin, item 6 on page 13 toward the off mark.
7. One or both legs turn out. 	1. Clincher is improperly aligned with head. Adjust clincher or head sideways. On a Stitch Fold, loosen the mounting knob behind the head, tilt the head slightly to one side, and tighten. 2. Wire cutters are dull. Replace wire cutters, item 22 on page 10.

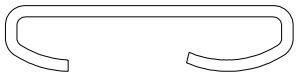
TROUBLE	POSSIBLE CAUSE & REMEDY
8. Corner of crown is distorted or fractured. 	1. Driver bar end is broken. Replace driver bar, item 53 on page 11. 2. Bender bar is worn. Replace bender bar, item 52 on page 11. (Or replace bender bar assembly, item 51 on page 11. 3. Wire is wrong size or poor quality. Use only approved stitching wire: ISP part number 415-0225. 4. Clincher is improperly aligned with head. Adjust clincher or head sideways. On a Stitch Fold, loosen the mounting knob behind the head, tilt the head slightly to one side, and tighten. 5. Clincher is worn. Replace clincher. 6. Excessive compression. Adjust clincher downward or set head actuating bar higher.
9. Stitches come out in pieces. 	1. Improperly aligned rotator. Loosen screw, item 29 on page 10, and slide rotator holder, item 28, in or out until rotator is properly aligned with bender bar, item 52. The wire grooves in the bender bar must be directly above a straight piece of wire being held in the rotator. 2. Rotator operating spring is weak. Replace rotator operating operating spring, item 27 on page 10. 3. Wire is jammed in bender bar grooves. Remove pieces of wire stuck in the bender bar grooves or replace bender bar, item 52 on page 11. 4. Wire is wrong size or poor quality. Use only approved stitching wire: ISP part number 415-0225.
10. Straight pieces of wire fall from the head.	1. Rotator is dirty. Carefully remove, clean, and lubricate rotator. See lubrication instruction C and picture on page 4. 2. Rotator is broken or worn. Replace rotator, item 30 on page 10. 3. Improperly aligned rotator. Loosen screw, item 29 on page 10, and slide rotator holder, item 28, in or out until rotator is properly aligned with bender bar, item 45. The wire grooves in the bender bar must be directly above a straight piece of wire being held in the rotator.
11. One or both legs are bent towards the front or rear.  Top View	1. Stitcher head is not aligned front to back with clincher. Remove stitcher head from parent machine and adjust the two bonnet aligning screws, item 12 on page 10. Adjust the screws by an increment of less than a full turn. Install head and check results. Repeat process if necessary.
12. Wire buckles above the grip, item 55 on page 11 and below the feed tube, item 3 on page 12.	1. Driver bar is worn. Replace driver bar, item 53 on page 11. 2. Latch assembly is worn. Replace latch assembly, item 54 on pg. 11. 3. Friction plug is worn. Replace friction plug, item 55 on page 11. 4. Friction plug spring is weak or broken. Replace spring, item 56 on page 11.

TROUBLE	POSSIBLE CAUSE & REMEDY
13. Wire buckles below the grip, item 61 on page 11 and above the wire cutters, item 22 on page 10.	1. Improperly aligned rotator. Loosen screw, item 29 on page 10, and slide rotator holder, item 28, in or out until rotator is properly aligned with bender bar, item 52. The wire grooves in the bender bar must be directly above a straight piece of wire being held in the rotator. 2. Wire cutters are dull or broken. Replace wire cutters, item 22 on page 10. 3. Cutter operating slide is worn or broken. Replace cutter operating slide, item 19 on page 10. 4. Wire cutter slot in face plate is worn. Replace face plate, item 2 on page 12 or replace entire face plate assembly, item 1 on page 12. 5. Check pawl is worn or dirty. Clean check pawl assembly, item 5 on page 12. Replace worn check pins, item 9 on page 12, or replace entire check pawl assembly. 6. Burrs exist on funnel in rotator. Polish rotator, item 30 on page 10.

ADJUSTMENTS

TO BALANCE STITCH LEGS:

If the stitch legs are uneven in length as pictured, use the following procedure to balance the leg length.



1. Loosen the leg balance block screw (Index 8, page 10).
2. Turn the adjusting screw (Index 47, page 11) clockwise to shorten the left stitch leg or counter clockwise to lengthen the left leg.
3. Tap leg balance block (Index 48, page 11) down before tightening the screw (Index 8, page 10).

WIRE DRAW ADJUSTMENT:

How to change the wire draw length for the thickness of the work being stitched.

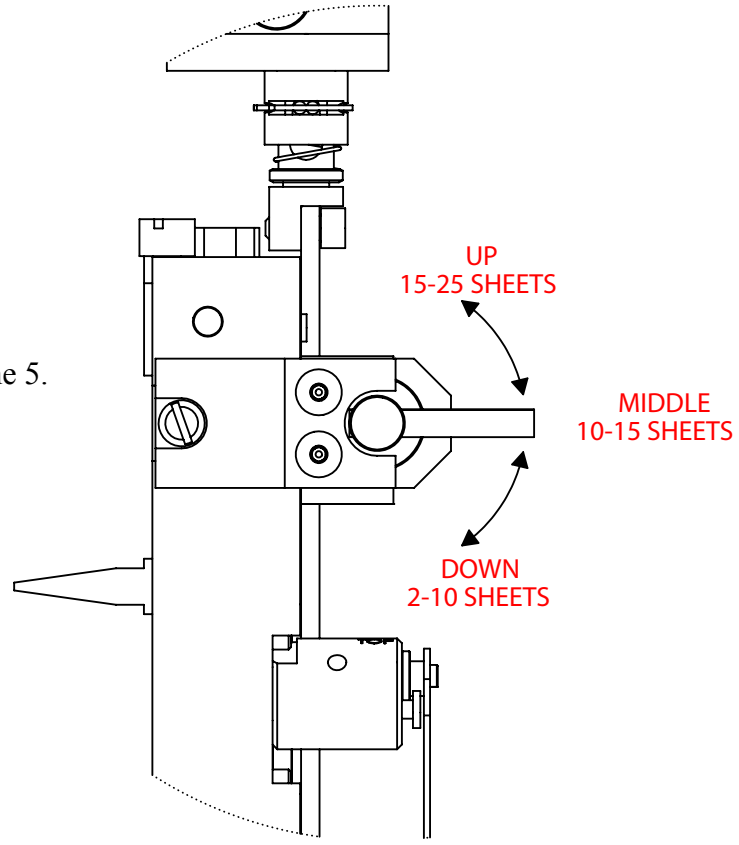
The Stitcher head is equipped with a 3 position eccentric Adjuster Lever Assembly (CAA176) See CAAA2006 Scene 5. This lever changes the length of wire used to stitch the book.

The down position results in the shortest length of wire for stitching books with 2-10 sheets.

The middle position results in a medium length of wire for stitching books with 10 - 15 sheets.

The up position results in the longest length of wire for stitching books with 15-25 sheets.

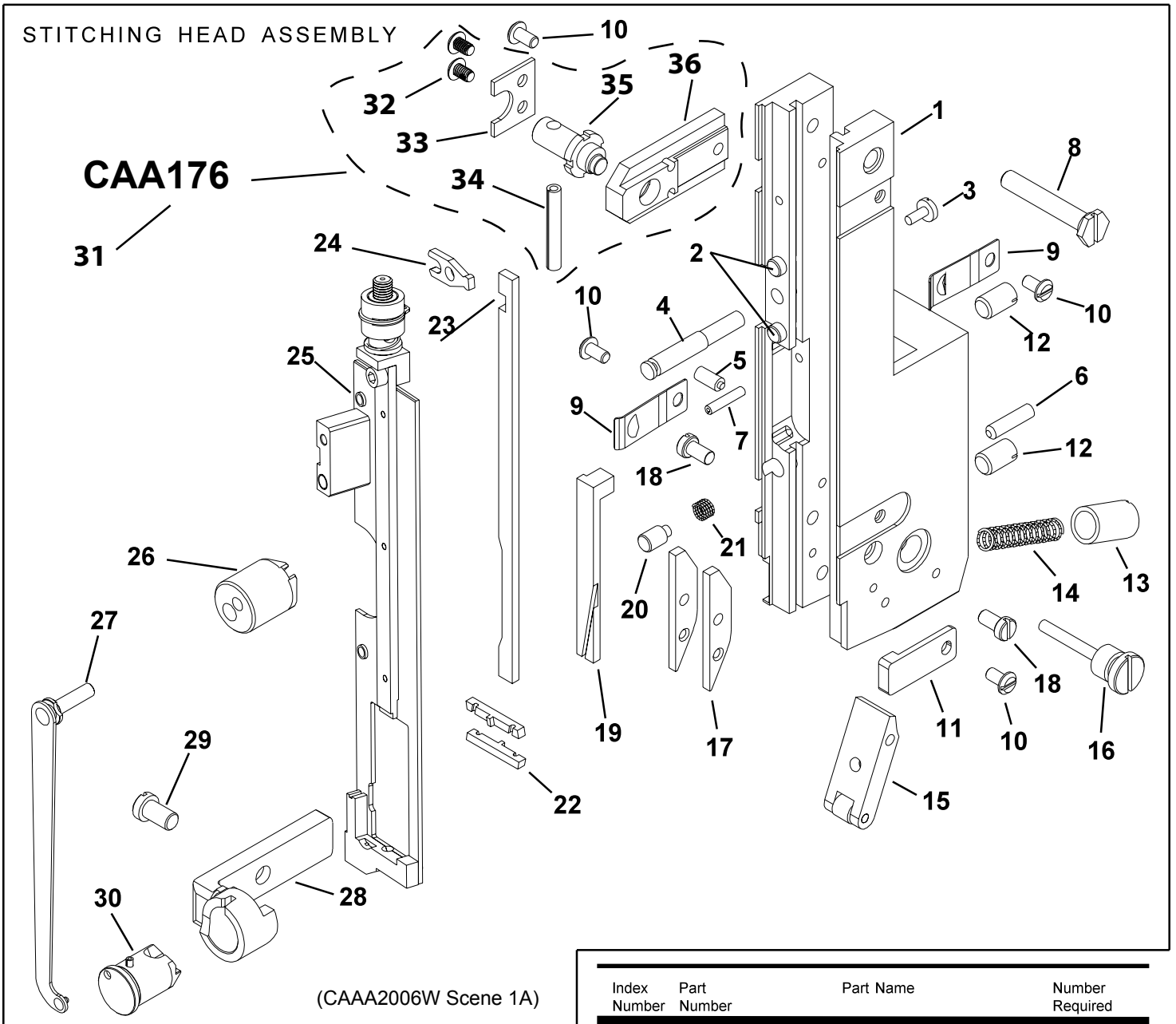
3-4 sample books should be stitched and inspected to see a change in the wire length inside the book.



Scene 2

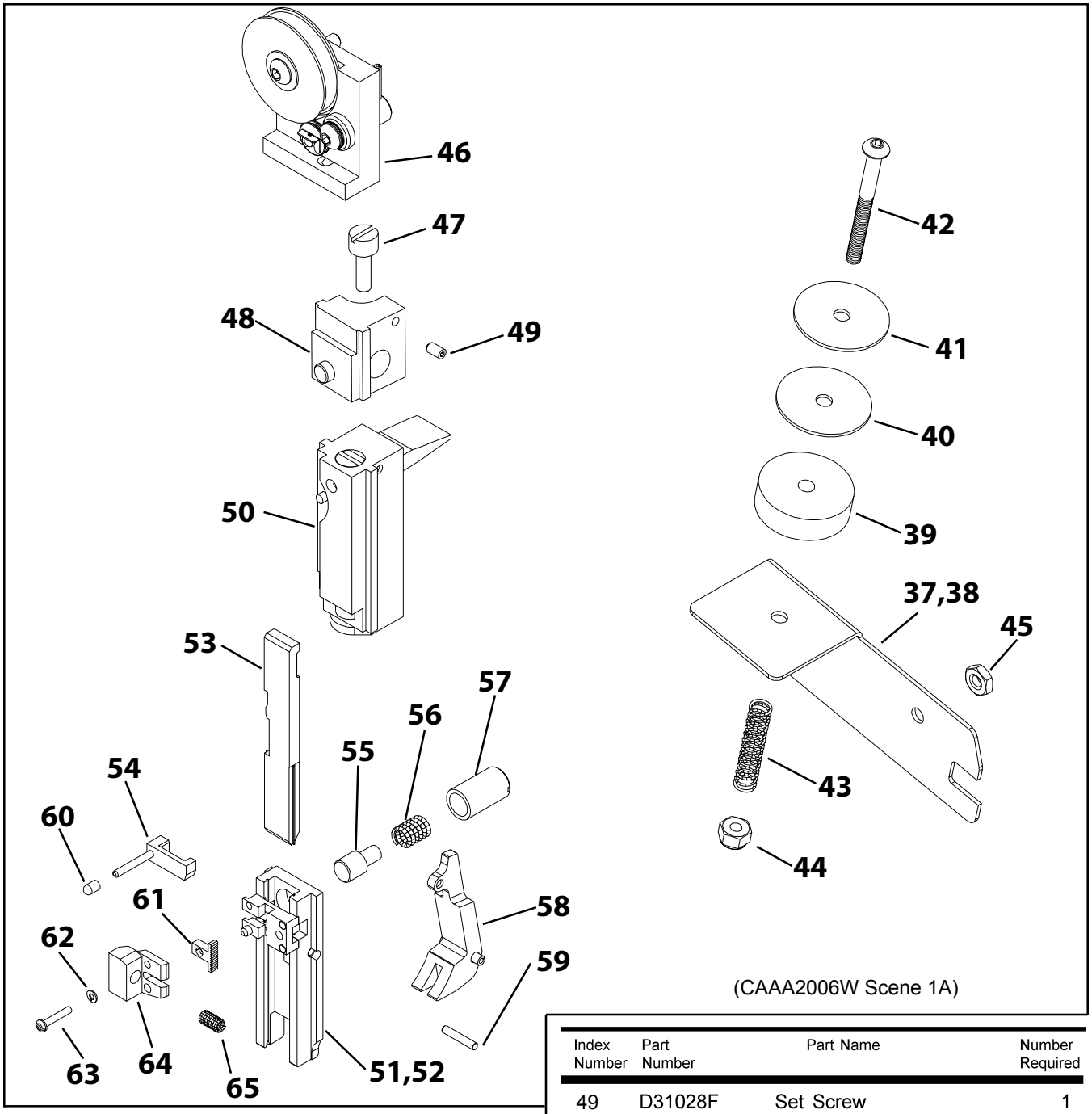
EZ Thread

STITCHING HEAD ASSEMBLY



(CAAA2006W Scene 1A)

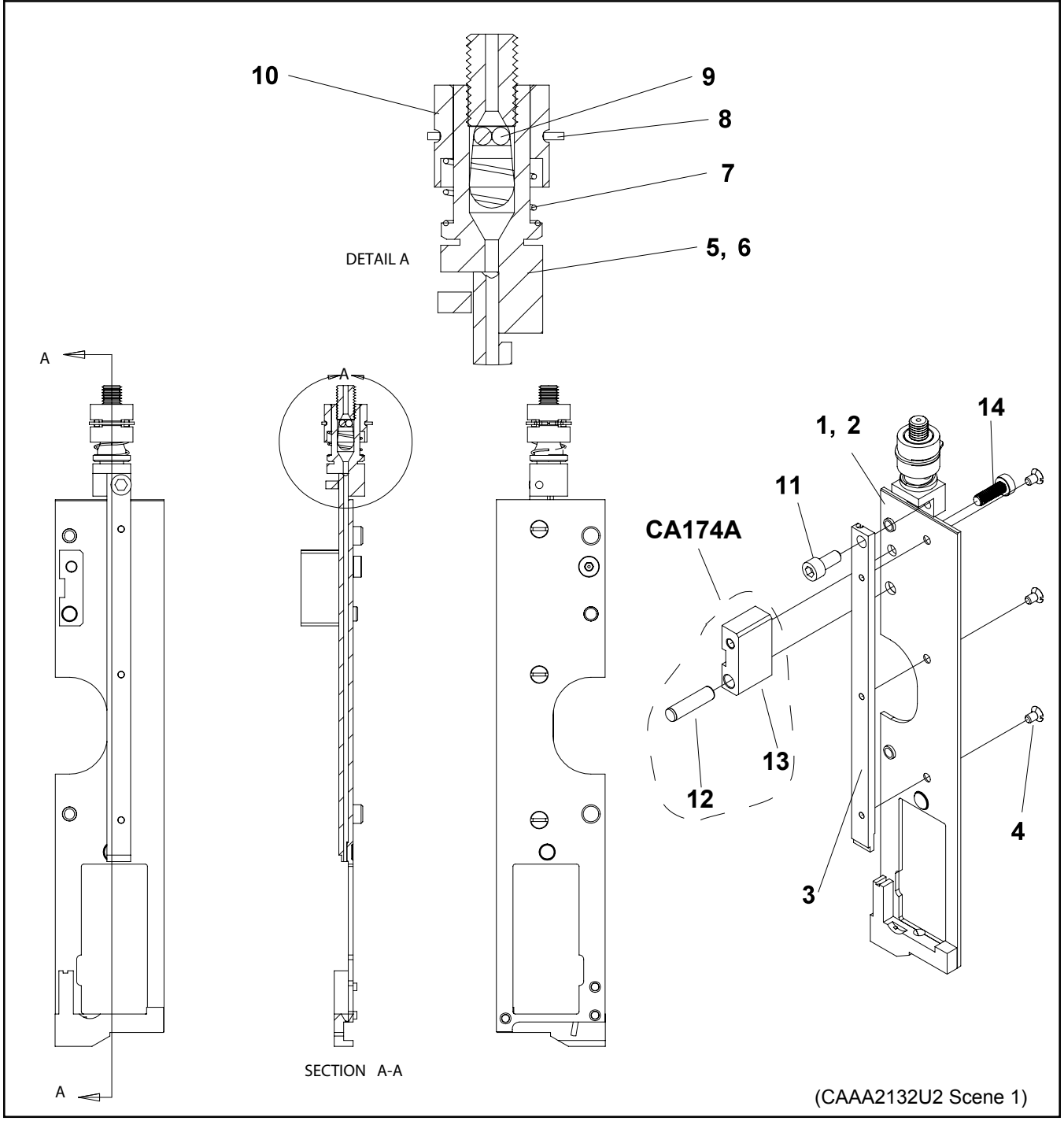
Index Number	Part Number	Part Name	Number Required
1	CA2004G	Bonnet, Easy Thread, Bolt-On (Includes Items #2 thru #6)	1
2	CA9139	Stop Pin	2
3	CA9058	Screw	1
4	CA9127	Cam Stud	1
5	CA157	Screw, 10-32x.375 Set	1
6	CA156	Screw, Supporter Lever Adj.	1
7	D38063F	Roll pin	1
8	CA9075	Leg Balance Block Screw	1
9	CA9056C	Face Plate Clip	2
10	CA2081	Clip Screw	4
11	CA9056A	Face Plate Clip	1
12	CT9109	Bonnet Aligning Screw	2
13	CA9037	Supporter Spring Bushing	1
14	CA9032C	Supporter Spring	1
15	CAA9036	Supporter Spring Lever	1
16	CA9034	Supporter Spring Lever Screw	1
17	CA9030	Supporter Guide Plate	2
18	CA9081	Supporter Guide Plate Screw	2
19	CA9049	Cutter Operating Slide	1
20	CA9050A	Friction Plug	1
21	CA9051A	Friction Plug Spring	1
22	CA9048	Wire Cutter	2
23	CA9022L	Grip Release Slide	1
24	CA9025	Grip Release Slide Adj Lever	1
25	CAAA2132U2	Face Plate Assembly EZ (See page 12 for details.)	1
26	CA9163C	Rotator Operating Cam	1
27	CAA9046D	Rotator Operating Spring	1
28	CA9043L	Rotator Holder	1
29	CA9044A	Rotator Holder Screw	1
30	CAA9038E	Magnetic Rotator	1
31	CAA176	Adjuster Bracket Assembly (includes items #32 thru #36)	1
32	DW1056	Screw, Button Head 8-32 X 1/4	2
33	CA177	Shaft Retainer	1
34	CB835T2	Roll Pin, .187 X 1.250	1
35	CA9648A	Adjustment Shaft EZ	1
36	CA176	Adjuster Bracket	1



(CAAA2006W Scene 1A)

Index Number	Part Number	Part Name	Number Required
37	RBM1894A	Oiler Bracket Assembly (Includes items 32 thru 38)	1
38	RBM1894F	Oiler Bracket	1
39	CA9652	Felt Washer, Thick	1
40	CA9653	Felt Washer, Thin	1
41	CA9651	Washer	1
42	CG26S	Screw, 10-32 x 2.000	1
43	CA9032C	Spring, Compression	1
44	CB860B	Nut, 10-32 Elastic Stop	1
45	CB278	Nut, 10-32 Hex.	1
46	RBM1678A	Wire Guide Assembly (See page 13 for details)	1
47	CA9076	Adjusting Screw	1
48	CAA9074C3	Leg Balanace Block Assy	1
49	D31028F	Set Screw	1
50	CTT2623J	Driving Slide Assy	1
51	CAAA9013S3	Bender Bar Assembly 1/2" (Includes Items #46 thru #59)	1
52	CAA9013S2	Bender Bar	1
53	CA9012M	Driver Bar	1
54	CAA9014J	Latch Assy	1
55	CA9112A	Friction Plug	1
56	CA9113A	Spring	1
57	CA9115	Bushing	1
58	CAA9026	Supporter	1
59	CA9029	Pivot Pin	1
60	CA173	Black Cap	1
61	CA9015D	Grip	1
62	CB371K	Lockwasher	1
63	CA9024A	Screw	1
64	CT413A	Grip Spring Housing	1
65	CA168	Grip Spring	1

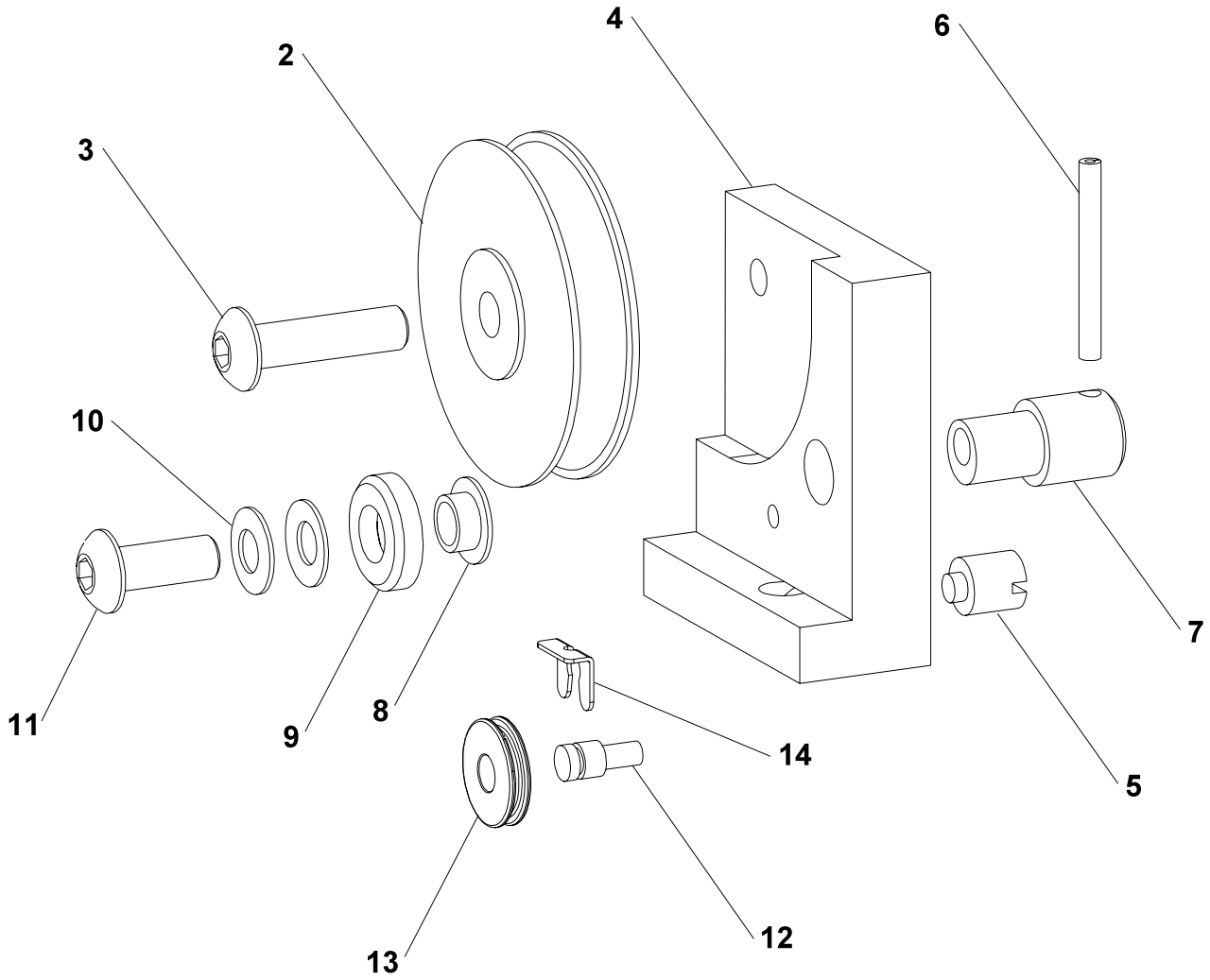
FACE PLATE ASSEMBLY



(CAAA2132U2 Scene 1)

Index Number	Part Number	Part Name	Number Required
1	CAAA2132U2	Face Plate Assembly EZ (Item 1 consist of items 2 through 14)	1
2	CAA2132R2	Face Plate Sub Assembly - EZ	1
3	CA182A	Feed Tube	1
4	CA9643	Flat Head Screw	3
5	CBBB513G	Check Pawl Assembly (Item 5 consists of items 6 through 10.)	1
6	CBB513G	Check Pawl Body Assy	1
7	RBM1481F	Spring	1
8	CB517	Retaining Ring	1
9	CB516	Check Pin	2
10	CB515	Check Sleeve	1
11	D30676F	Cap Screw	1
12	CB284A	Steel Dowel Pin 3/16"	1
13	CA174	Face Plate Adjust Slide Bar EZ	
14	G20176	Screw M4x0.7x12, Low, Nylon	1

WIRE GUIDE ASSEMBLY



(RBM1678A Scene 1)

Index Number	Part Number	Part Name	Number Required
1	RBM1678A	Wire Guide Assy (Includes Items #2 - #14.)	1
2	RBM1677F	Wire Guide Pulley	1
3	CG26B	Button Hd Scr 10-32 x 1	1
4	RBM1647F	Straightener Bracket	1
5	CA172	Soft Tip Set Scr 1/4-20	1
6	D41302F	Roll Pin	1
7	RBM1423F	Straightener Eccentric	1
8	CA9068	Bushing	1
9	CA9065	Roller	1
10	CL44A	Spring Washer	2
11	RBM1424F	Button Head Screw	1
12	CA9123A	Stud	1
13	CA9103C	Roll	1
14	CA9124	Clip	1

EZ Thread

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