

FIGURE 8.1

MAGNAPUNCH

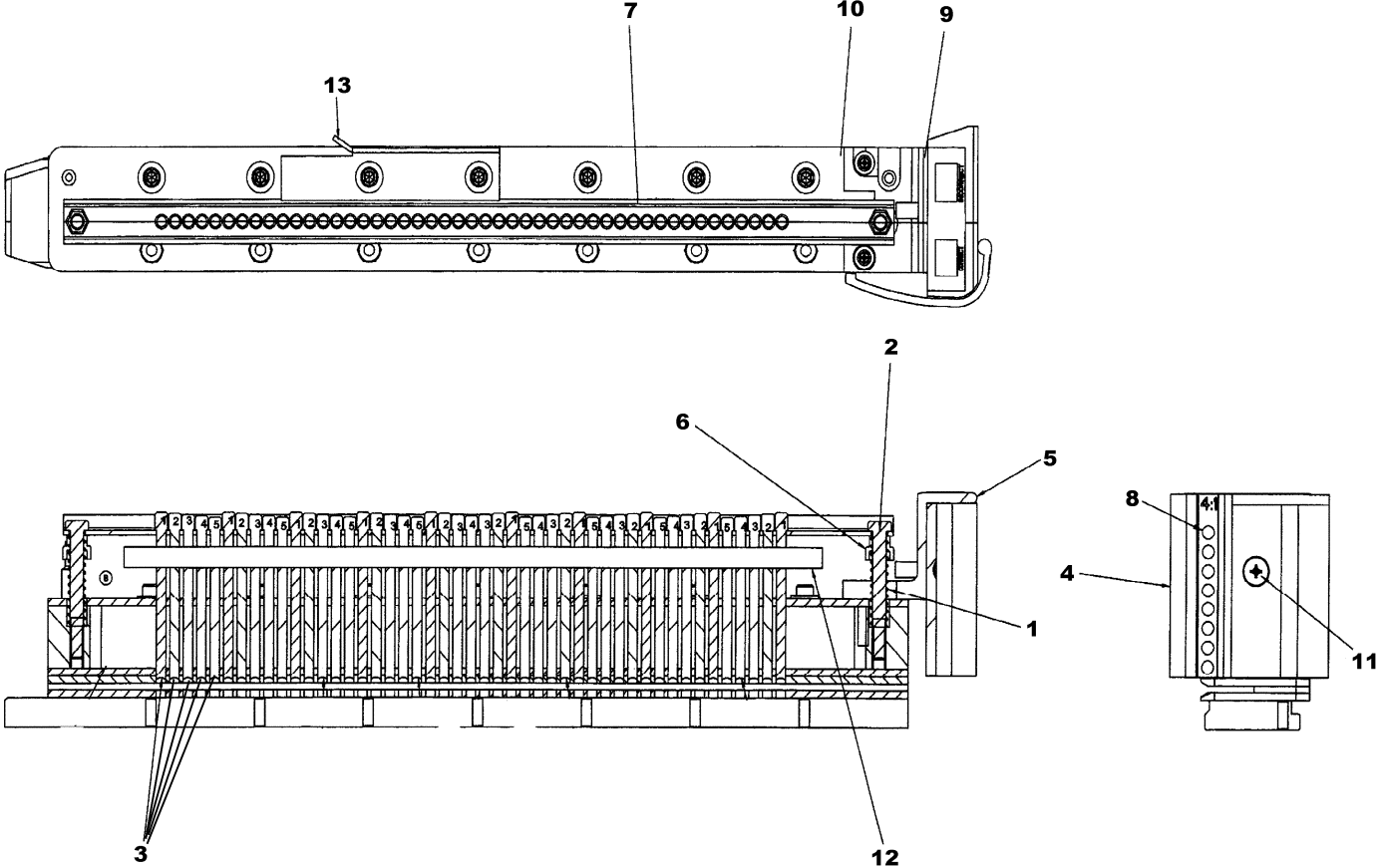
ITEM	PART NO.	DESCRIPTION	QTY
1	1952011	Bushing	4
2	7703210	Base Assembly (Prior to S/N# MG)	1
	7703025	Base Assembly (After S/N# MH)	1
3	6190011	Pneumatic Foot Pedal	1
4	7703245	Bracket, Safety Switch	1
5	7703271	Safety Switch	1
6	7703160	Safety Switch Guard	1
	1902840	Screw, 4-40 x 3/4" Safety Switch	2
7	1902503	Screw, 10-32 x 3/4" Safety Bracket	2
	1927407	Nut, 10-32, Safety Bracket	2
	7703275	Spacer, Safety Bracket	2
8	1926804	Nut, 4-40, Safety Switch	2
9	7703243	Plunger	2
10	1935220	Spring, Plunger Detent	2
11	7703242	Housing, Plunger Detent	2
12	1911103	Screw, 10-32 x 1/2"	2
13	7703276	Screw, Plunger Detent	2
	7703272	Plunger Detent Assembly Complete (Includes Items 9-10-11-13)	2
14	7703247	Bearing Cap	2
15	7703240	Vertical Bracket, Right	1
	7703241	Vertical Bracket, Left	1
	1951971	Screw, 1/4-20 x 5/8" Bracket to Base	4
	1925030	Washer, Bracket to Base	4
16	1905019	Screw	8
17	7703153	Tie Bracket	1
18	1900531	Screw, Stripper	5
19	1927407	Nut, 10-32 for Stripper Screw	5
20	7703258	Pressure Bar	1
21	7703259	Stripper Bar	2
22	7703217	Chip Drawer	1
23	7703268	Bottom Cover Plate	1
24	6009334	Power Switch Label	1
25	1907810	Screw, 8-32 x 3/8"	4
26	1101379	Shield	1
27	1100150	Drawer Guide, LH	1
28	1128183	Spring	4
29	1128182	Shoulder Bolt	4
30	7703237	Bracket, Control Switch	1
31	7703018	Control Switch Assembly	1
32	1132343	Fuse Holder	1
	1103554	Fuse 1 Amp (Not Shown) 115V Machine	1
	1103048	Fuse 1 Amp (Not Shown) 230V Machine	1

ITEM	PART NO	DESCRIPTION	QTY
33	1926801	Nut, 6-32 Control Switch Bracket	2
34	1100228	Rubber Foot	4
35	1100180	Washer	4
36	1901511	Screw, 6-32 x 1/2"	4
37	7703238	Bracket, Underarm Switch	1
38	7703640	Switch, Underarm	1
		Underarm Switch Assembly (Includes item# 37, 38, 39, 40)	1
39	1902840	Screw, 4-40 x 3/4"	2
40	1926804	Nut, 4-40	2
41	1907803	Screw, 6-32 x 3/8"	2
42	1128136	Solenoid, 230VAC	1
	1128128	Solenoid Assembly Complete 230VAC (Includes P/N 1128136 1118831,1118830,1930518)	
	1118832	Solenoid, 115VAC	1
	1118833	Solenoid Assembly Complete 115VAC (Includes P/N 1118832, 1118831,1118830,1930518)	1
	7703373	Solenoid Valve Bracket Kit 115VAC For S/N# KG-LG (See NSB 223R)	1
	7703097	Solenoid Valve Bracket Kit 230VAC For S/N# KG-LG (See NSB 223R)	1
	7703089	Solenoid Bracket Sub-Assembly 115VAC For S/N# LH & LI and After (See NSB 223Q)	1
	7703094	Solenoid Bracket Sub-Assembly 230VAC For S/N# LH & LI and After (See NSB 223Q)	1
43	1118831	Solenoid Link (For S/N# KG-LG)	1
44	1118830	Solenoid Shaft (For S/N# KG-LG)	1
	7703179	Connecting Rod With Head (For SN# LH & LI and After)	1
45	1930518	Retaining Ring (For S/N# KG-LG)	2
	1929802	7/16 Hair Pin Clip (For S/N# LH & LI and After)	1
46	1907803	Screw, 6-32 x 3/8"	4
47	6202046	Switch, Pneumatic For Foot Pedal	1
48	7703260	Plug Bracket	1
49	1103754	Relay 115VAC, Large (See NSB 223AE)	1
	7703281	Relay 115VAC, Small (See NSB 223AE)	1
	1154238	Relay 230VAC, Large (See NSB 223AE)	1
	7703017	Relay 230VAC, Small (See NSB 223AE)	1
50	1902815	Screw, 6-32 x 1/2"	2
51	1902815	Screw, 6-32 x 1/2"	2

NOTE: N.S.B.'S are at the back of Parts List

ITEM	PART NO.	DESCRIPTION	QTY
52	1926801	Nut, 6-32	2
53	1902805	Screw, 10-32 x 3/8"	3
54	7703277	Lock, Pin Retainer	1
55	1911103	Screw	2
56	6009000	Label, Warning Shock	1
57	1118839	Motor, 115VAC	1
	1100190	Motor, 230VAC	1
	7703256	Wire Guard (Not Shown)	1
58	1903204	Screw, 5/6-18 x 1/2"	4
59	1107242	Pulley	1
	1900056	Set Screw, 5/8-18 x 1/4" (Not Shown)	2
60	7704863	O-Ring Belt	1
61	6200001	Power Cord 115VAC	1
	6200002	Power Cord, Europe	1
	6200015	Power Cord, Switzerland	1
	6200016	Power Cord, Australia	1
	6200060	Power Cord, United Kingdom	1
	7703088	Power Cord, Connector Lock (Not Shown)	1
62	7703202	Housing Assembly	1
63	7703289	Electrical guard	1
64	1100030	Expansion Plug	1
65	6195001	Socket, 115VAC & 230VAC Power Cord	1
66	1926801	Nut, 6-32	2

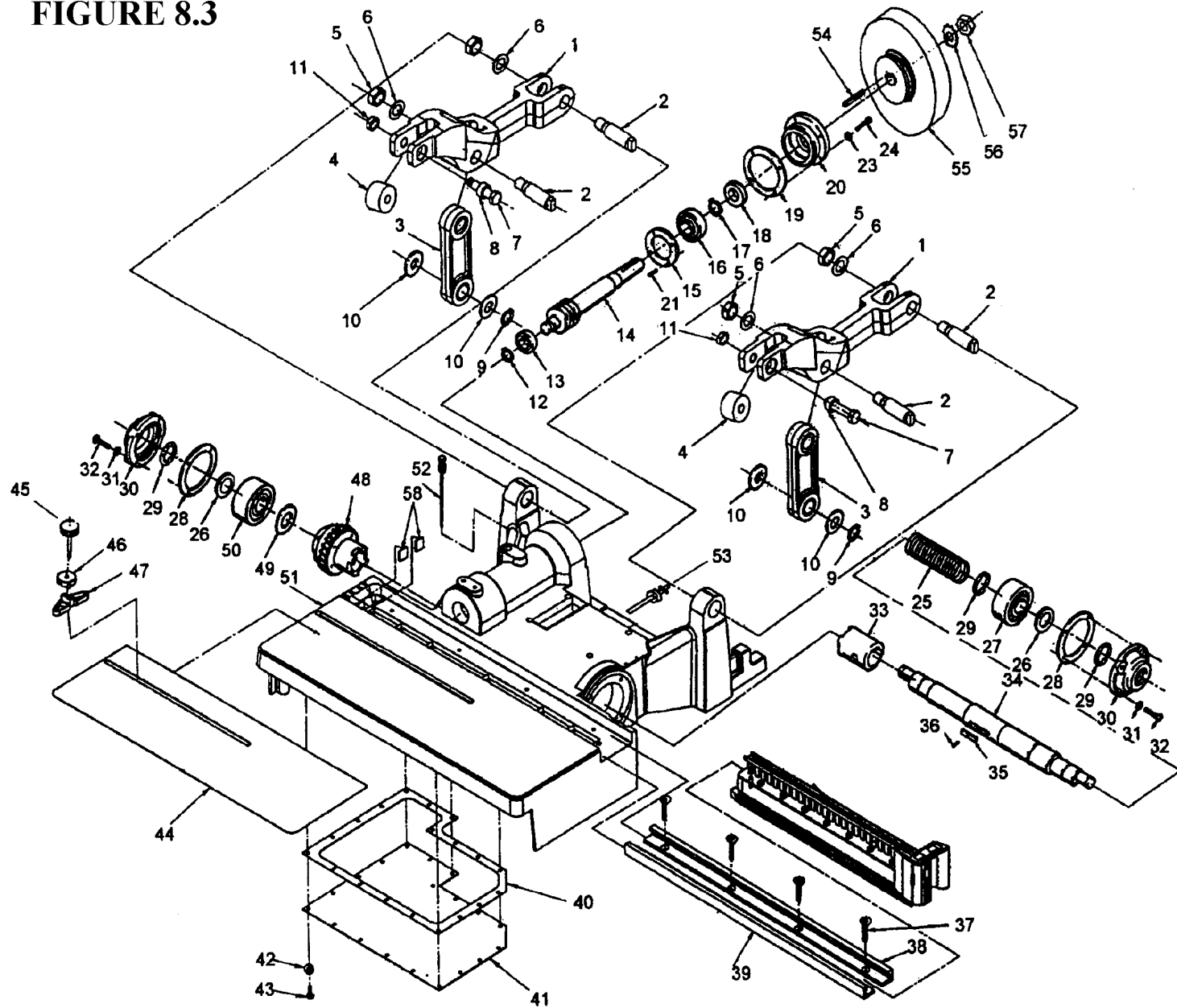
FIGURE 8.2



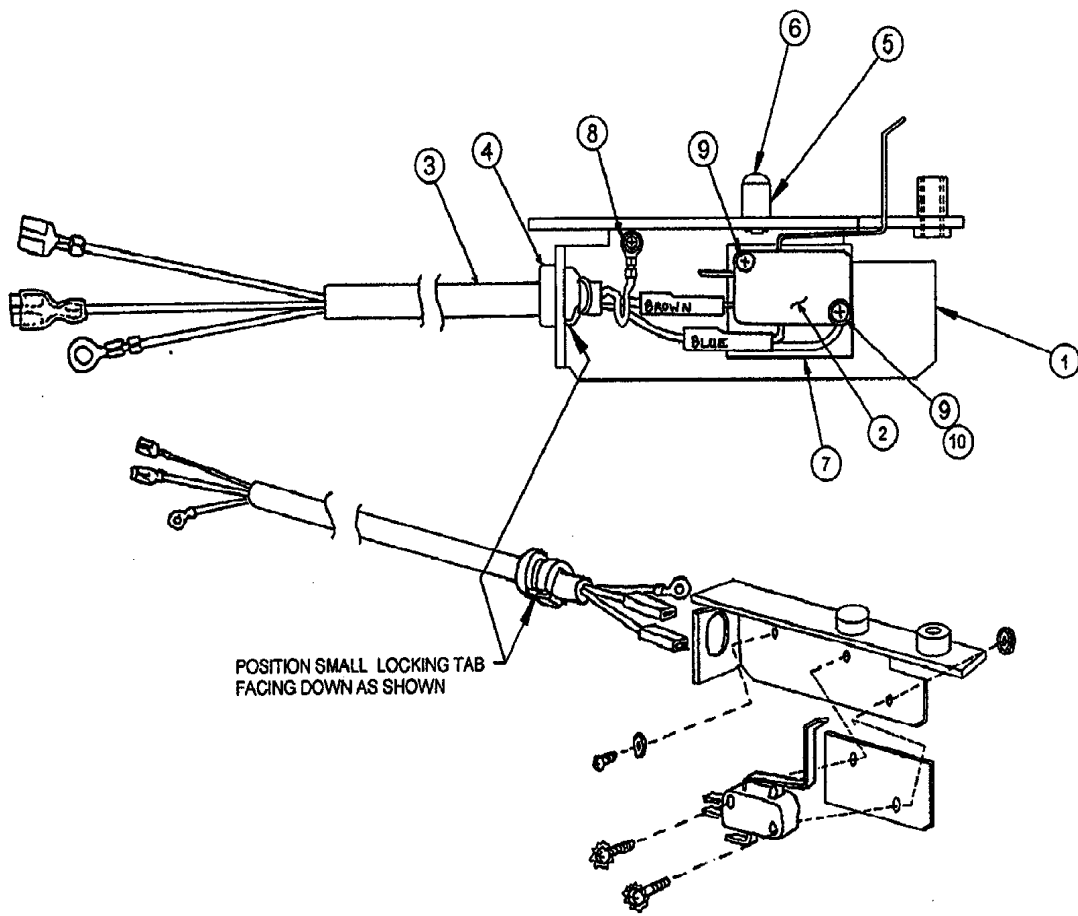
PUNCH PIN LOCATION (FIGURE 8.2)

DESC.	PART NO.	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58		
Adjust. PB	1722827	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25																																			
C4 GBC .2475	1722828	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58		
C4 IND. .250	1722828	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58		
W2 Round	1722829	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58		
W2 Square	1722832	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58		
SureBind	1722831	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25																																			
VeloBind	1722831	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25																																			
W3 Round	1722832	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58		
W3 Square	1722833	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58		
C5 GBC	1722834	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58		
3-5-7 Hole	7707283																																																												
2-4 Hole	7703428																																																												
C4 GBC OVAL	1722835	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58		

FIGURE 8.3



ITEM	PART NO.	DESCRIPTION	QTY
1	7703249	Pressure Arm	2
2	7703252	Wrist Pin	4
3	7703231	Connecting Rod	2
4	7703270	Cam Follower	2
5	1926601	Jam Nut, 1/4-20	4
6	1925808	Washer	4
7	7703253	Bolt, Pressure Arm	2
8	7703254	Spacer, Pressure Arm Bolt	2
9	1930507	Retaining Ring	2
10	1925116	Washer	4
11	1926615	Jam Nut, 3/8-16	2
12	1930502	Retaining Ring	1
13	1100079	Bearing	1
14	1100984	Worm Gear	1
15	1100209	Bearing Clamp	1
16	1100210	Bearing	1
17	1930503	Retaining Ring	1
18	1100081	Oil Seal	1
19	1100082	Gasket, Bearing Retainer	1
20	1100080	Bearing Retainer	1
21	1900532	Screw, 6-32 x 1/4"	4
22		NOT USED	
23	1925207	Washer	4
24	1911107	Screw, 10-32 x 5/8"	4
25	1100066	Clutch Spring	1
26	1101299	Oil Seal	2
27	1100056	Bearing w/o Snap Ring	1
28	1132120	Gasket, Bearing Retainer	2
29	1930506	Retaining Ring	3
30	1132121	Bearing Cap	2
31	1925207	Washer	8
32	1911117	Screw, 10-32 x 7/8"	8
33	1100064	Clutch Jaw	1
34	1100055	Crankshaft	1
35	1100065	Key, Clutch Jaw	1
36	1900056	Screw, 4-40 x 3/8"	1
37	1902647	Screw	8
38	7703233	Slide, Right	1
39	7703234	Slide, Left	1
40	7703215	Gasket, Bottom Cover (Obsolete)	1
41	7703268	Bottom Cover Plate	1
42		NOT USED	



ITEM	PART NO.	DESCRIPTION	QTY
	7701615	Table Switch & Bracket Assembly (Includes Items 1-10)	1
1	7703172	Bracket, Table Switch	1
2	7701613	Table Switch	1
3	7701612	Table Switch, Cable Assembly	1
4	1952409	Strain Relief	1
5	1925305	Plastic Spacer	1
6	1929605	Plastic Rivet	1
7	1122005	Switch Insulator	1
8	1911109	Screw 6-32 x 1/4"	1
9	1911137	Screw 4-40 x 3/4"	2
10	1926804	Nut 4-40 W/Lock Washer	1



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NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION N.S.B. NO: 223Q
 FROM: NATIONAL SERVICE DEPARTMENT Page: 1 of 1
 SUBJECT: **MAGNAPUNCH, AND 111PM-3 SOLENOID,
 BRACKET SUB-ASSEMBLY.** DATE: 08/01/00

When replacing a defective Solenoid, GBC Manufacturing recommends that you replace it with the Solenoid, Bracket Sub-Assembly. Part number **7703089** is for the **115volt Magnapunch**, and **115volt 111pm-3 machines**. Part number **7703094** are for the **230volt Magnapunch machines only**. The Solenoid Mounting Bracket was implemented by manufacturing approximately late August 1999 to early September 1999 (serial numbers **LH**, and **LI00000**). This is to provide a direct alignment between the solenoid plunger, and the clutch pin. Part numbers listed below are the bills of material that are in the Solenoid, Bracket Sub-Assembly. Please update your Service Manual with this information.

ITEM No.	PART No.	DESCRIPTION	QTY.
1	1118832	Solenoid 115volt	1
1	1128136	Solenoid 230volt	1
2	7703061	Bracket, Solenoid	1
3	7703179	Connecting Rod W/Head	1
4	1929802	7/16 Hair Pin Clip	1
5	1902606	SCR 6-32 3/8 Flat Hd.	4



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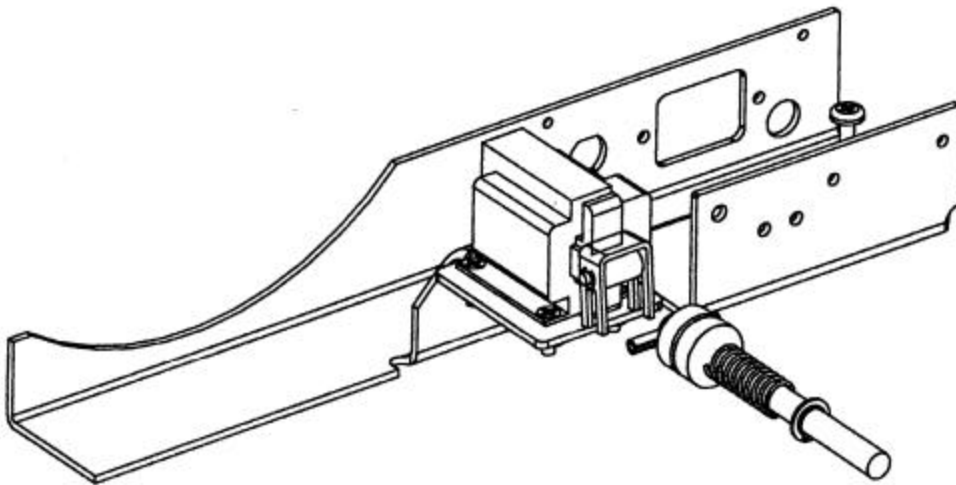
SUBJECT: **MAGNAPUNCH SOLENOID VALVE
BRACKET KIT ASSEMBLY**

N.S.B. NO: 223R

Page: 1 of 3

Date: 08/15/00

Manufacturing has released a Solenoid Valve Bracket Kit Assembly. This effects machines produced between **July 1998, and July 1999** (serial numbers **KG00291** to **LG 000000**). Part number **7703373** is for the **115volt**, and part number **7703097** is for **230volt** machines. Attached is the disassembly and installation procedure. Please update your service manual with this information.



Solenoid Bracket Installation Instructions

The installation of this Solenoid Bracket with a new Solenoid Assembly and a new Clutch Pin Assembly should take approximately **40 minutes**. This affects **Magnapunch** machines produced between **July 1998** and **July 1999** (serial numbers **KG00291** to **LG00000**).

DISASSEMBLY

STEP 1: DISCONNECT THE MACHINE FROM IT'S POWER SOURCE AND RETAIN THE POWER CORD IN YOUR CONTROL FOR YOUR SAFETY AS WELL AS THE SAFETY OF OTHERS.

STEP 2: REMOVE THE UPPER HOUSING.

STEP 3: REMOVE THE MOTOR FROM THE MOTOR BRACKET AND SET IT ASIDE. LEAVE THE DRIVE BELT ON THE FLYWHEEL.

STEP 4: MAKE A SMALL REFERENCE MARK ON THE MOTOR BRACKET TO ASSIST IN PLACEMENT DURING INSTALLATION. REMOVE THE MOTOR BRACKET FROM THE MACHINE AND SET IT ASIDE.

STEP 5: LEAVING THE WIRES CONNECTED TO THE ELECTRICAL COMPONENTS, REMOVE THE RELAY, POWER RECEPTACLE AND PNEUMATIC SWITCH FROM THE OLD SOLENOID BRACKET.

STEP 6: DISCONNECT THE GROUND WIRES FROM THE OLD SOLENOID BRACKET.

STEP 7: DISCONNECT THE WIRES TO THE SOLENOID.

STEP 8: REMOVE THE THREE SCREWS THAT SECURE THE OLD BRACKET INTO THE MACHINE.

STEP 9: REMOVE THE OLD BRACKET AND SOLENOID FROM THE MACHINE AND USE IT TO PROP THE MAGNAPUNCH UP ON A SLIGHT ANGLE. THIS WILL HELP TO PREVENT OIL LEAKS IN THE NEXT STEPS.

STEP 10: REMOVE THE CLUTCH PIN WITH A LARGE PAIR OF VICE GRIPS AND PRYING MOTION AGAINST THE BASE CASTING.

Solenoid Bracket Installation Instructions (Continued)

INSTALLATION

STEP 1: GENTLY TAP THE NEW CLUTCH PIN ASSEMBLY INTO PLACE.

STEP 2: HOLDING THE NEW SOLENOID BRACKET IN POSITION, ATTACH THE RELAY, PNEUMATIC SWITCH, POWER RECEPTACLE, AND THE GROUND WIRES USING THE NEW THREAD CUTTING SCREWS PROVIDED.

TIP: A MAGNAPUNCH DIE SET PIN RETAINER MAGNET CAN HELP HOLD SMALL NUTS IN PLACE.

STEP 3: SLIDE THE SOLENOID PLUNGER INTO THE SOLENOID. **IMPORTANT:** ENSURE THAT THE FOUR TINY TABS AROUND THE SOLENOID OPENING DO NOT INTERFERE WITH THE PLUNGER. ENSURE THAT THE “U” BRACKET IS POINTING DOWNWARD AND TOWARD THE FRONT OF THE MACHINE. IF NOT, REMOVE THE PLUNGER, FLIP THE “U” BRACKET AROUND AND REPEAT THIS STEP. THIS ORIENTATION WILL PROVIDE THE CLUTCH PIN WITH PROPER PLAY IN RELATION TO THE SOLENOID ACTION.

STEP 4: ATTACH THE NEW BRACKET TO THE BASE CASTING USING THE OLD MOUNTING SCREWS. USE LOCTITE ON THESE SCREWS.

STEP 5: INSTALL THE MOTOR BRACKET USING THE REFERENCE MARK (YOU MADE EARLIER) TO HELP ALIGNMENT.

STEP 6: INSTALL THE MOTOR ONTO THE BRACKET.

STEP 7: INSTALL THE MOTOR BELT.

STEP 8: CONNECT THE MAGNAPUNCH TO POWER AND TEST PUNCH 10 TO 15 STACKS OF PAPER TO CHECK FOR PROPER OPERATION.

STEP 9: PERFORM A GENERAL INSPECTION OF THE MAGNAPUNCH TO ENSURE PROPER OPERATION. REFER TO ANY AND ALL NATIONAL SERVICE BULLETINS FOR THE LATEST INFORMATION OF MAGNAPUNCH REPAIR.

P/N 6150007

ITEM	PART NO	DESCRIPTION	QTY
43	1903209	Screw, 10-32 x 1/2"	19
44	7703156	Table Laminate	1
45	7702437	Dome Knob, Edge Guide	1
46	7702444	Locking Collar	1
47	7702433	Edge Guide	1
48	1100244	Worm Gear	1
49	1100182	Stop washer	1
50	1100073	Bearing With Snap Ring	1
51	7703210	Base Assembly (Prior to S/N# MG)	1
	7703025	Base Assembly (After S/N# MH)	1
52	1128158	Dipstick (Obsolete)	1
	1953002	1/4" NPT Pipe Plug	1
53	7703266	Clutch Pin Assembly (For S/N# KG-LG)	1
	7703178	Clutch Pin Assembly (After S/N# LH, Must Order 1929802 With This Assembly)	1
	1929802	Hair Pin Clip (Not Shown)	1
	1952218	Clutch Pin Base Bushing (Not Shown)	1
54	1100178	Key, Flywheel	1
55	7704867	Flywheel	1
56	1118803	Lock Washer, Flywheel	1
57	1103767	Jam Nut 5/8-18 Left Handed Thread	1
58	7703246	Pad, Die Set Stop	2



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NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION

N.S.B. NO: 223AE

FROM: NATIONAL SERVICE DEPARTMENT

Page: 1 of 2

SUBJECT: **MAGNAPUNCH RELAYS**

Date: 12/20/01

This N.S.B. supersedes and obsoletes N.S.B. 223K dated 3/01/99.

GBC Manufacturing has been installing two different size Relays in the MagnaPunch machines. There is a large Relay part number 1103754 for the 115VAC, and part number 1154238 for the 230VAC machines. If you have to replace the large Relay, you must order the large Relay. **You cannot use a small Relay in place of a large Relay on machines with a Serial Number prior to LJ, which is October 1999. Machines with S/N after LJ can accept either of the Relays.**

The small Relay is part number 7703281 for the 115VAC, and part number 7703017 for the 230VAC. If you have the small Relay in your MagnaPunch machine, you can either use the large or the small Relay. **They are interchangeable because of the way it is mounted to the machine.** If you are not sure what Relay you have, or how to make proper wiring connections, refer to the Relay pin configuration and wire connections for the interchangeable Relays below. Please update your Service Manual with this information.

111PM-3 & MAGNAPUNCH RELAY PIN CONFIGURATION AND WIRE CONNECTIONS

P/N 1154238 - RELAY DPDT FROM MAGNACRAFT
 USED ON 111PM-3 AND MAGNAPUNCH 230 VAC

P/N 1103754 - RELAY DPDT FROM POTTER&BRUMFIELD
 USED ON 111PM-3 AND MAGNAPUNCH 115 VAC

P/N 7703017 - RELAY SPDT FROM OMRON
 USED ON 111PM-3 AND MAGNAPUNCH 230 VAC

P/N 7703281 - RELAY SPDT FROM OMRON
 USED ON MAGNAPUNCH 115 VAC

