



System two Parts List

GBC IS AN ACCO BRANDS COMPANY



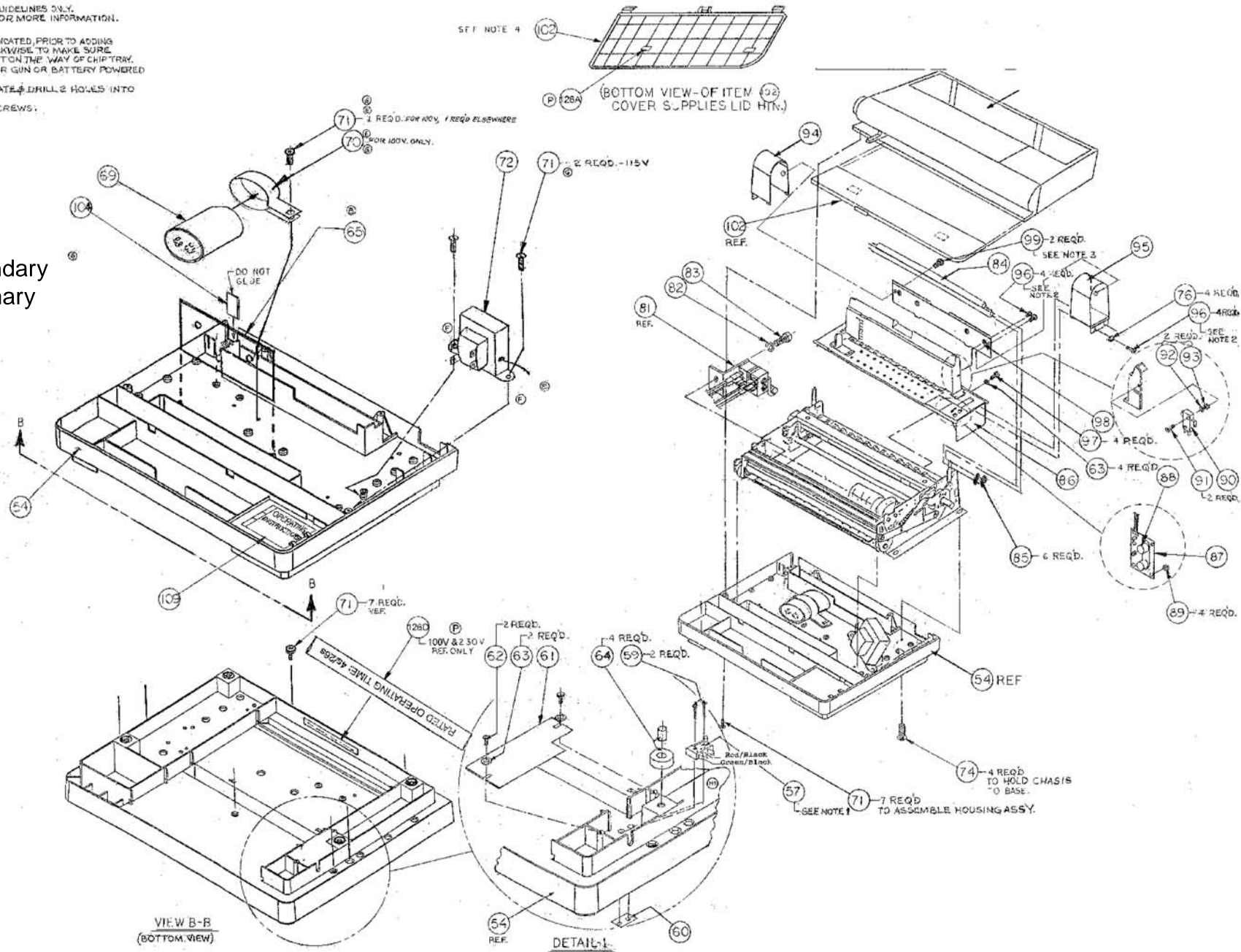
SYSTEM TWO FINAL ASSEMBLY, PART 2

DRAWING IS MADE FOR ASSEMBLY GUIDELINES ONLY.
REVIEW INDIVIDUAL PART DRAWING FOR MORE INFORMATION.

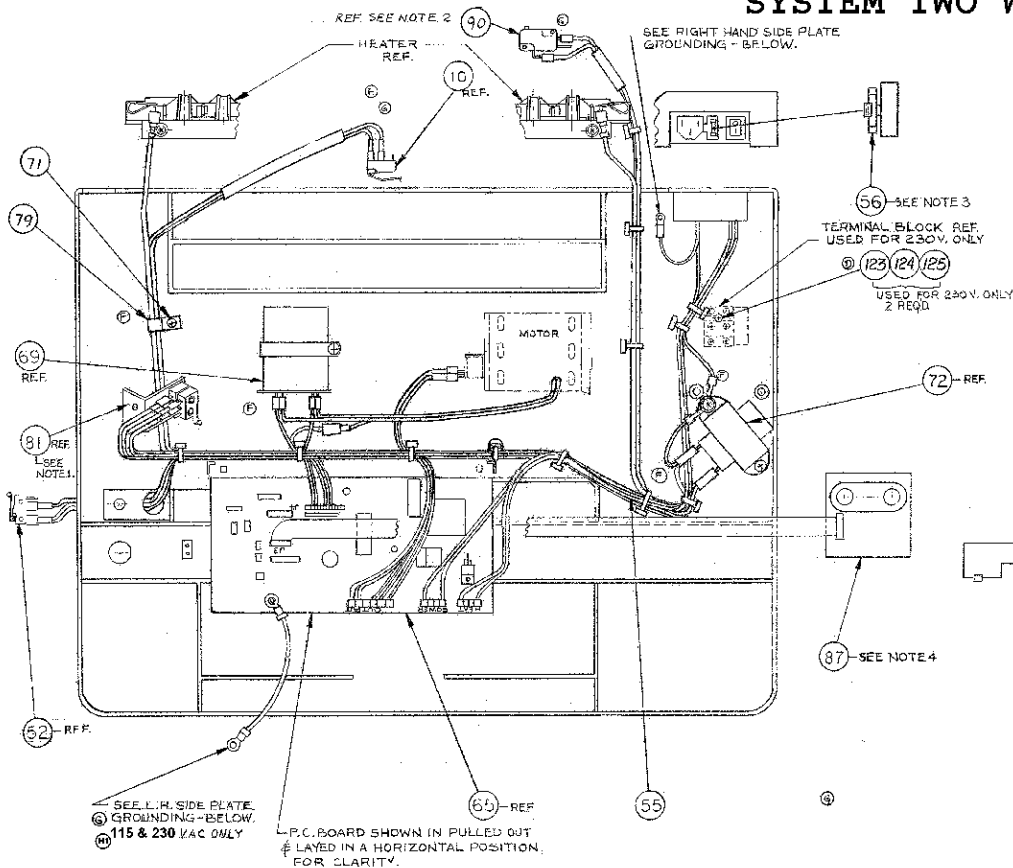
NOTES:

1. ASSEMBLE HARNESS (65) TO SWITCH (61) AS INDICATED, PRIOR TO ADDING COVER LID (61). ROTATE SWITCH COUNTER CLOCKWISE TO MAKE SURE THAT THE ROLLER ON THE SWITCH STICKS OUT ON THE WAY OF CHIP TRAY.
2. DO NOT OVERTIGHTEN! USE LOW TORQUE AIR GUN OR BATTERY POWERED DRILL. SCREWS EASILY STRIP PLASTIC.
3. USING PN (60) LOCATE 2 HOLES AT ENDS OF PLATE & DRILL 2 HOLES INTO (64) AND THEN SCREW IN (62).
4. ASSEMBLE (63) ONTO (61) PRIOR TO ADDING (71) SCREWS.

Note:
Inside Terminals Secondary
Outside Terminals Primary



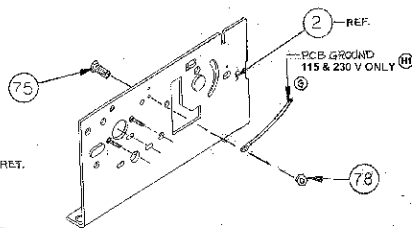
SYSTEM TWO WIRING DIAGRAM



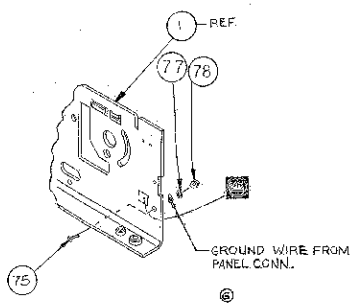
"VIEW LOOKING INTO BASE, SHOWING ALL ELECTRICAL HOOK-UPS."

NOTES:

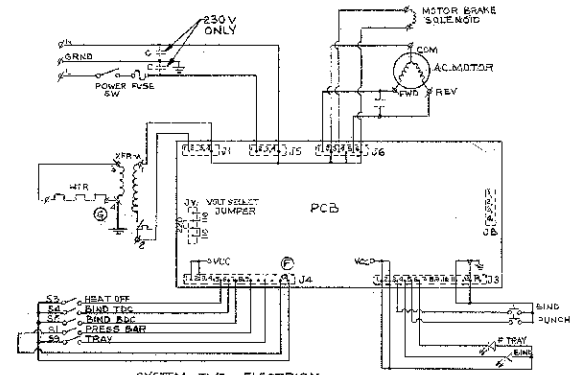
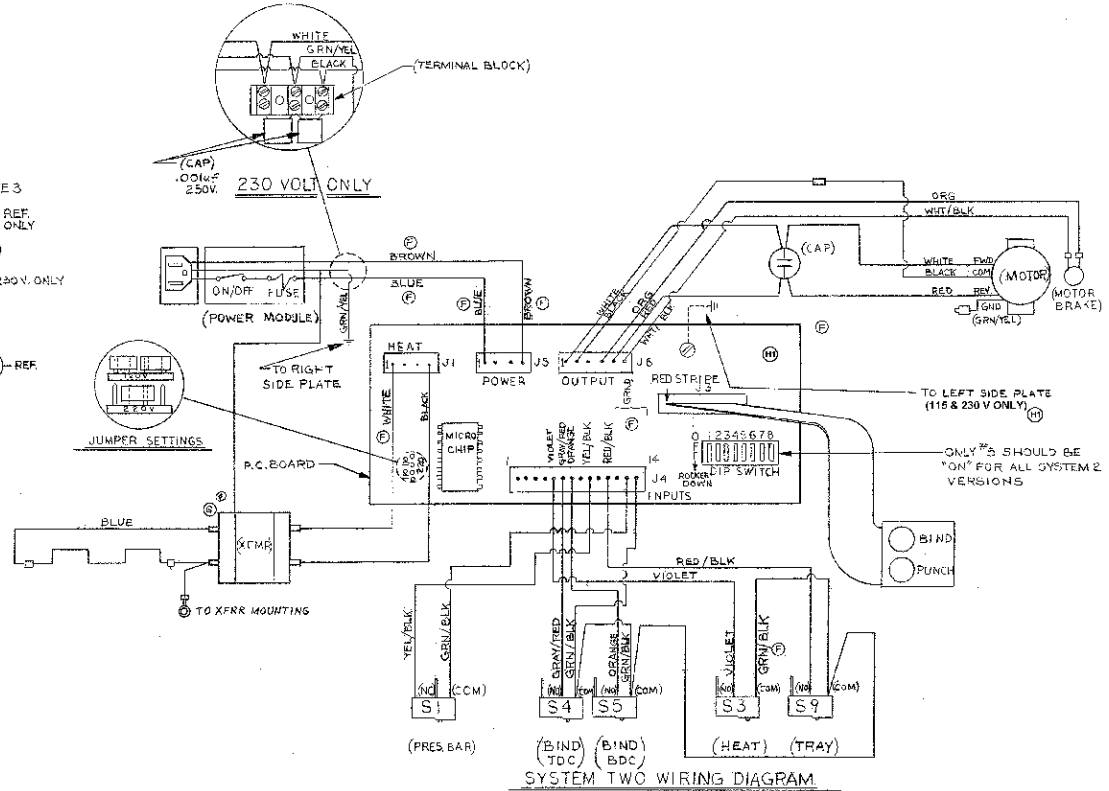
- ORANGE WIRE, ITEM 55, SHOULD BE POSITIONED NEXT TO THE BRACKET, ITEM 81, AS SHOWN.
81 REF.
GREY/RED WIRE
ORANGE WIRE.
- SWITCH, ITEM 90, SHOULD BE INSTALLED AFTER TURRET ASSY., ITEM 84, AND PRESSURE BAR ASSY., ITEM 88, ARE INSTALLED. WIRES FROM HARNESS SHOULD PASS THRU 3/8" HOLE ON TURRET. REMOVE FUSE HOLDER FROM REAR OF POWER MODULE, ITEM 56, TO INSERT FUSE, ITEM 56.
- THE PCB ASSY., ITEM 87, TO BE INSTALLED AFTER CHASSIS IS ASSEMBLED TO BASE, ITEM 54. CABLE ON THE PCB ASSY. SHOULD BE GUIDED THROUGH THE SLOT ON R.H. SIDE PLATE, ITEM 1.



LEFT HAND SIDE PLATE, SHOWING STATIC CONTROL GROUND WIRE CONN. (230V. ONLY)



RIGHT HAND SIDE PLATE, SHOWING GROUND WIRE FROM PANEL CONN.



SYSTEM TWO ELECTRICAL SCHEMATIC

SYSTEM TWO FINAL ASSEMBLY

ITEM NO.	DESCRIPTION	QTY	COMMON	SB-JAPAN	SB-230V	VB-INT'L 220V	VB-DOM 120V	SB-DOM 120V
1	SIDE PLATE SUB ASSY, R.H.S.	1	9783627					
2	SIDE PLATE SUB ASSY, L.H.S.	1	9783628					
3	MOTOR & CAM SUB ASSY	1	SEE DRAWING FOR MOTOR AND CAM SUBASSEMBLY					
4								
5	GREASE, LUBRICATING	A/R	1961503					
6	CRANK PUNCH DRIVE	2	9781082					
7	SPACER .861 X .010	2	1925136					
8	ROLL PIN 3/16x7/8	2	1929233					
9	TIMING SHAFT ASSEMBLY	1	9781060					
10	SWITCH & BRACKET ASSY, S3	1	9783537					
11	SCREW FLT HD PH-2-56X5/8	1	1902634					
12	HEX NUT, 2-56 SELF LOCKING	1	1927401					
13	BRACE	1	9781061					
14	SCREW SOC SET 8-32X1	1	1900021					
15	SCREW HEX SOC FLT HD 6-32X1/4	2	1900633					
16	SPRING EXTENSION 3/4"	1	9779271					
17	PUNCH HOUSING SUB-ASSY, VB	1		9781814	9781814	9781029	9781029	9781814
18	SCREW HEX SCO CAP 1/4-20X1/2	8	1900538					
19	WAHER MEDIUM SPLIT LOCK 1/4	8	1926018					
20	NUT, HEX 1/4X20	6	1926729					
21	LOCKWASHER INTERNAL TOOTH 1/4	2	1925804					
22	SHAFT & DRIVE LINK ASSY, R.H.S	1	SEE DRAWING FOR SHAFT AND DRIVE LINK ASSEMBLY					
23	BEARING	2	9776609					
24	SPACER	1	1925220					
25	LINK ASSY, L.H. PRESSURE BAR	1	9781556					
26	DRIVE LINK ASSY, L.H.S.	1	9783539					
27	RETAINING RING	1	1930544					
28	PLATE DRIVE	2	9778732					
29	SPRING DRIVE	2	9781158					
30	HEATER ASSEMBLY	1		9777072	9777072	9776678	9776678	9777072
31	LINKAGE ASSEMBLY, R.H.S.	1	9783542					
32	LINKAGE ASSEMBLY, L.H.S.	1	9783541					
33	LINK BIND	1	9781060					
34	ACTUATOR	2	9781049					
35	STUD PIVOT	2	9779351					
36	STUD PIVOT	2	9781083					
37	WASHER .50 OD X.26 ID	4	1925206					
38	WASHER, FLAT PLASTIC	1	1925208					
39	WASHER, SHIM .50 OD X .26 ID	6	1925107					
40	RETAINING RING	4	1930510					

SYSTEM TWO FINAL ASSEMBLY

ITEM NO.	DESCRIPTION	QTY	COMMON	SB-JAPAN	SB-230V	VB-INT'L 220V	VB-DOM 120V	SB-DOM 120V
41	WASHER, FLAT, .875X.253X.05 THK	1	1925130					
42	E-RING .185 DIA	1	1930530					
43	WASHER, FLAT .263 ID X .80 OD X .025 THK	1	1925133					
44	ROLLER CUTTER ARM	1	9779084					
45	BEARING	2	9781122					
46	WASHER CRANK LINK	2	1925117					
47	RETAINING RING	1	1930520					
48	SCREW SOC-HD SHLD 10-32X.625	1	1900803					
49	HEX NUT 10-32	1	1926702					
50	SCR 10-32X5/8/1/4 SCH HXOC LH	1	1900809					
51	NUT 10-32 LH THREAD	1	1926731					
52	LOCTITE 242	A/R	1960512					
53								
54	BASE SYSTEM TWO & THREE	1	7704967					
55	WIRE HARNESS MAIN SYSTEM TWO	1		9783679	9783680	9783680	9783679	9783679
56	FUSE 5X20MM	1	1970124					
57	SW SNAP ACTION SPDT W/ROLLER	1	9781142					
58								
59	SCR 2-56 X 1/2PP HD INT STAR WASHER	1	1911135					
60	NUT PLATE SWITCH #2-56	1	9778618					
61	RACEWAY COVER	1	7704968					
62	SCREW PH PAN HD 6X1/2 TYPE A	2	1905106					
63	WASHER FLAT #6	5	1925119					
64	RUBBER FOOT	4	9781363					
65	PCB ASSEMBLY	1		9783596	9783668	9783668	9776634	9776634
66								
66								
67								
68								
69	CAP MOTOR RUN	1		6205044	6205038	6205038	6205039	6205039
70	MOUNTING BRACKET	1		6205041	---	---	---	---
71	SCRW PHIL PAN HD 8-32X3-8		1902804	QTY = 12	QTY = 12	QTY = 12	QTY = 10	QTY = 10
72	TRANSFORMER, HEATER POWER	1		9784041	9784040	9784040	9784039	9784039
73								
74	SCREW PH PAN HD 10-32X3/8 MACH	4	1902805					
75	SCREW PH PAN HD 8-32X1/2		1925809	QTY = 1	QTY = 2	QTY = 2	QTY = 1	QTY = 1
76	LOCKWASHER EXT TOOTH #8	4	1925903					
77								
78	NUT HEX 8-32		1926701	QTY = 1	QTY = 2	QTY = 2	QTY = 1	QTY = 1
79	CABLE CLAMP	1	193103					

SYSTEM TWO FINAL ASSEMBLY

ITEM NO.	DESCRIPTION	QTY	COMMON	SB-JAPAN	SB-230V	VB-INT'L 220V	VB-DOM 120V	SB-DOM 120V
80								
81	DOUBLE SWITCH & BRACKET ASSY	1	9783538					
82	LOCKWASHER #6 SPLIT MEDIUM	1	1926005					
83	SCREW HEX SOC CAP 6-32X1/4	1	1900594					
84	PRESSURE BAR SUB-ASSEMBLY	1	7704962					
85	RETAINING RING	6	1932502					
86	TURRET GUIDE ASSY, SYSTEM TWO	1	7704963					
87	PCB ASSY CRS SYS TWO DK GRAY	1	9781128					
88	SW COND RUBBER SYS TWO DK GRAY	1	7704994					
89	NUT HEX 6-32	4	1926707					
90	SWITCH SNAP ACTION SPDT S1	1	9781592					
91	SCREW PH PAN HD 4-40X3/4	2	1902840					
92	WASHER LOCK #4 EXT TOOTH	2	1925909					
93	NUT HEX 4-40	2	1926711					
94	END CAP LH TURRET SYSTEM TWO	1	7704975					
95	END CAP RH TURRET SYSTEM TWO	1	7704976					
96	SCREW PHIL PAN HD 8-18X3/8	8	1907832					
97	SCR THD CUT PH PAN HD 6-32X3/8	4	1907830					
98	TURRET BACK COVER SYSTEM TWO	1	7704977					
99	SCREW PH PAN HD 4-14X1/4 PLASK1	2	1908602					
100	WASTE TRAY	1	7704978					
101	HOUSING & PUNCH GUIDE ASSY	1		7704965	7704965	7705097	7705097	7704965
102	COVER SUPPLIES LID HINGED	1	7704985					
103								
104	COUNTER COVER SYSTEM TWO & THREE	1	7704986					
105	COVER SUPPLIES LID FIXED	1	7704987					
106	ADHESIVE SICOMET CYANOACRYLATE	A/R	1960508					
107								
108								
109	INFORMATIO CARD ENG SYS TWO	1	7704988					
110								
111	TUV PRODUCT SERVICE GS LABEL	1			1128417	1128417		
112	CAUTION LABEL	1		600900	6009001	6009001	600900	600900
113	CSA NRTL/C LABEL	1					6009413	6009413
114	LABEL CE MARK .875 IN	1		6009178	6009178			
115	LABEL DENTORI SYSTEM TWO/THREE	1		9781697				
116	PATENET LABEL	1	6009400					
117	LABEL CAUTION HOT SURFACE	1		1154236	9781617	9781617	9781618	9781618
118	OVER SIZE BLK EQUIP. TESTING	A/R		1132850	1132850	9741170	9741170	1132850
119	1X11 BLK EQUIP. TESTING	A/R		1132830	1132830	9741010	9741010	1132830

SYSTEM TWO FINAL ASSEMBLY

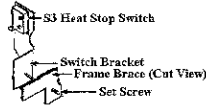
ITEM NO.	DESCRIPTION	QTY	COMMON	SB-JAPAN	SB-230V	VB-INT'L 220V	VB-DOM 120V	SB-DOM 120V
120	PAPER A4 TESTING	70	1128331					
121								
122								
123	SCREW	2			1902868	1902868		
124	WASHER	2			1902805	1925805		
125	NUT	2			1926714	1926714		
126	LABEL KIT	1	7705135					
126A	PAD SPACER	2	9781498					
126B	EDGE GUIDE MARK, LINE	1	7705127					
126C	EDGE GUIDE LABEL	1		7705135	7705135	7705098	7705098	7704989
126D	DECAL, OPERATING TIME	1		7705135	7705135	7705135	7705135	
126E	LABEL, ECC COMPLIANCE	1					6009106	6009106
126F	LABEL, CANADIAN, CLASS A '96	1					6009247	6009247
126G	FUSE LABEL	1	1963914					

CALIBRATIONS AND ADJUSTMENTS

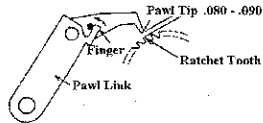
Settings With Housing & Punch guide assy, item #101 off Unit

PC board Dip Switch setting
ONLY #5 SHOULD BE "ON" FOR ALL MODELS

8-32 Soc set screw settings, item #14
 Note: S3 switch assy, item #10 must pivot freely with attached spring, item #16
 Position 8-32 Soc set screw as follows:
 120V/100V - approximately 1/2" of the screw protruding out of the Brace, item #13
 240V - approximately 1/4" of the screw protruding out of the Brace



Pawl Tip settings, (sheet 2, ref. Right Hand Side Plate, item #1)
 Pawl should have a clearance of .080" to .090" from 7 Tooth Ratchet, when Punch Assy is at fully raised position. Use TN G-2383 to adjust or use the thickness of the binding strip as a gauge.



PAWL TIP ADJUSTMENT

Pawl Guide settings, (sheet 2, ref. Right Hand Shaft & Drive Link assy, item #22)
 slightly bend entire Pawl Guide away from Pawl with a screw driver if required to prevent Pawl from catching on Pawl Guide

Heater Assy, item #30
 9777072 - Surebind
 Using a small C-clamp with a teflon tip, gently tighten 1/4 turn the first 2 and last 2 positions of the heater Blade. This prevents the blade from cutting into the binding strips.

Testing
 UNIT SHOULD HAVE SUCCESSFULLY PASSED THE FOLLOWING TESTS:
GROUNDING/CONTINUITY TEST
DIELECTRIC TEST

Calibration
BEFORE MAKING ANY TYPE OF CALIBRATION TO UNIT
ALWAYS UNPLUG UNIT TO AVOID POSSIBLE
SEVERE ELECTRICAL SHOCK

Punch Operation

- Place the Turret, item #86, in an upright position, so that it rests on the side plates.
- Move the Pressure bar, item #84, so that it is seated on the turret.
(This will slow the punch cycle to start)
- PLUG IN UNIT**, Turn machine "ON", and the "READY" indicator should be lit.
- Press the "PUNCH" button
 The motor should make one complete rotation and STOP when the Eccentric Drive (see page 2) moves as far away from the Punch Assy, item #17.
 If the motor does not rotate, check that the Double switch & Bracket assy item #81, are not being activated by the Cams. Loosen the screws on the Double Switch and Bracket assy. if necessary so that the switches pivot freely. Adjust the Switches until both the Cams actuates the Switches when rotating.
 This may require the unit be turned "OFF" when the Eccentric drive is fully extended forward. Adjust the Cams and tighten set screws
- Punch 3 sets of 22 sheets of paper
- The Jam-Stopper feature will sense a high paper load.

Bind Operation

- Same as step 1 above
- Add screws, items #83 & #87 to attach Turret assy, DO NOT TIGHTEN
- Place a binding strip (with holes) and place it over the locating PIN in the strip recess on the Turret. Make sure the strip is properly positioned with the Pin. Textured side down.
- PLUG IN UNIT**, Turn machine "ON", and the "READY" indicator should be lit.
- Move Pressure bar forward (Allows the Binding cycle to start) but DO NOT place on binding strip. Holding the Pressure bar approx. 2" from strip. Press the "BIND" button. When the Heater blade, item #30, moves forward so that the blade is underneath the binding strip quickly turn unit "OFF".
- Carefully move Turret so that the binding strip is centered with the Heater blade (Usually moved to the left).
- Apply an even amount of pressure along the top of the Turret assy so that screws are tightened to the Brace, item #10.
- Add the second binding strip (with the dots) and place the Pressure bar on top of the strip
- Turn machine "ON" and press the "BIND" Button. (Pressure bar should be firmly pressed

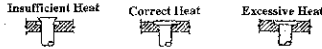
against the strips - check Pawl settings) The "READY" indicator should flash during the bind cycle and you will hear beeping. Both will go out upon completion.
IF THE BINDING CYCLE IS NOT COMPLETED, THE TRAY-FULL AND READY INDICATORS WILL FLASH ALTERNATELY.

Turn machine "OFF" and "ON", or, press the "BIN0" or "PUNCH" button. Rebind the document. If the binding cycle is incomplete again, adjust the S3 switch, item #10. Turn the 8-32 Soc set screw, item #14, for the following results:

Clockwise - shorter heat cycle (COOLER)
 Counter Clockwise - Longer heat cycle (HOTTER)

Note: Rotate set screw 1/4 turn at a time and test

10 Raise the pressure bar and remove the strip set. Rivet protrusion .023" Max; Bind should be set for .010" to .018".



11 (Repeat step 10) two times with 22 to 30 sheets of paper.
 12 Tray Full Indicator Light illuminates after 50 binds, remove and empty waste tray with the power on to reset lamp.

After successfully completing the above adjustments, assemble the Housing & Punch Guide assy, item #101, to unit. Repeat the Binding Operation above 2 times.
 Note: Cycle the punch halfway and turn unit "OFF" in order to install Housing.

Fixed Cover Supplies Lid

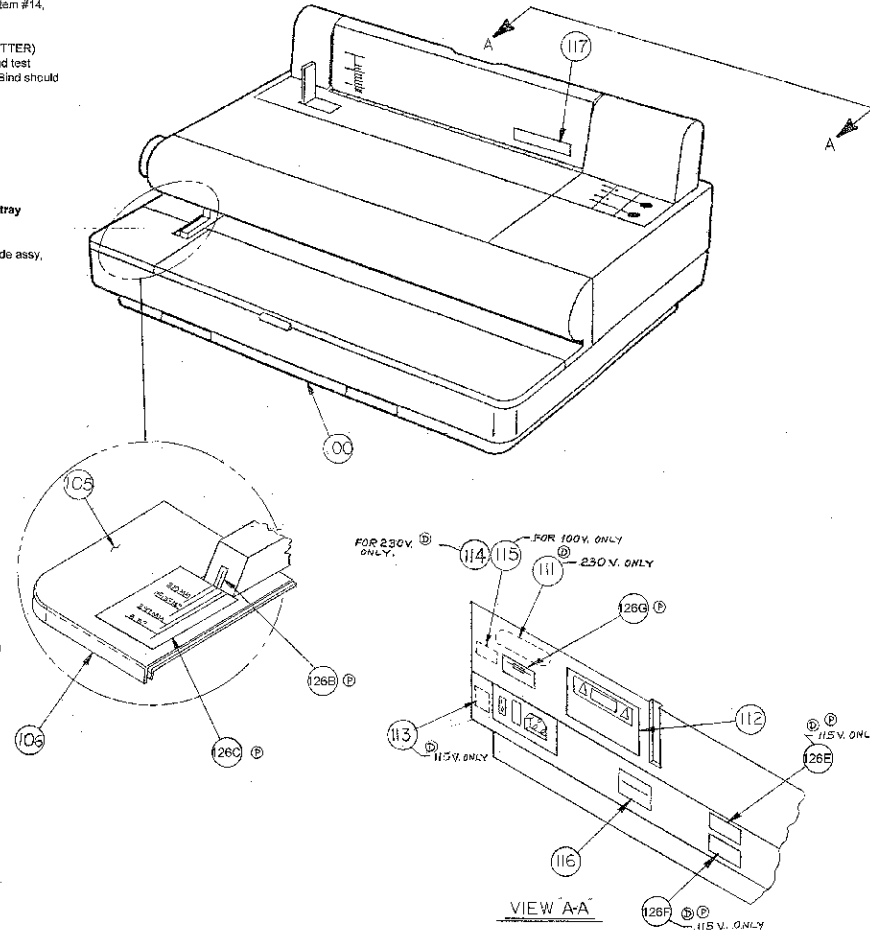
Add Decal Punch, item #108, to Cover Supplies lid, item #105. Apply Adhesive Sicromet, item #106, to Cover Supplies lid and to front left Base Housing, item # 54. Make sure Cover aligns with all edges before applying holding clamp.

Punch Edge Guide Adjustment

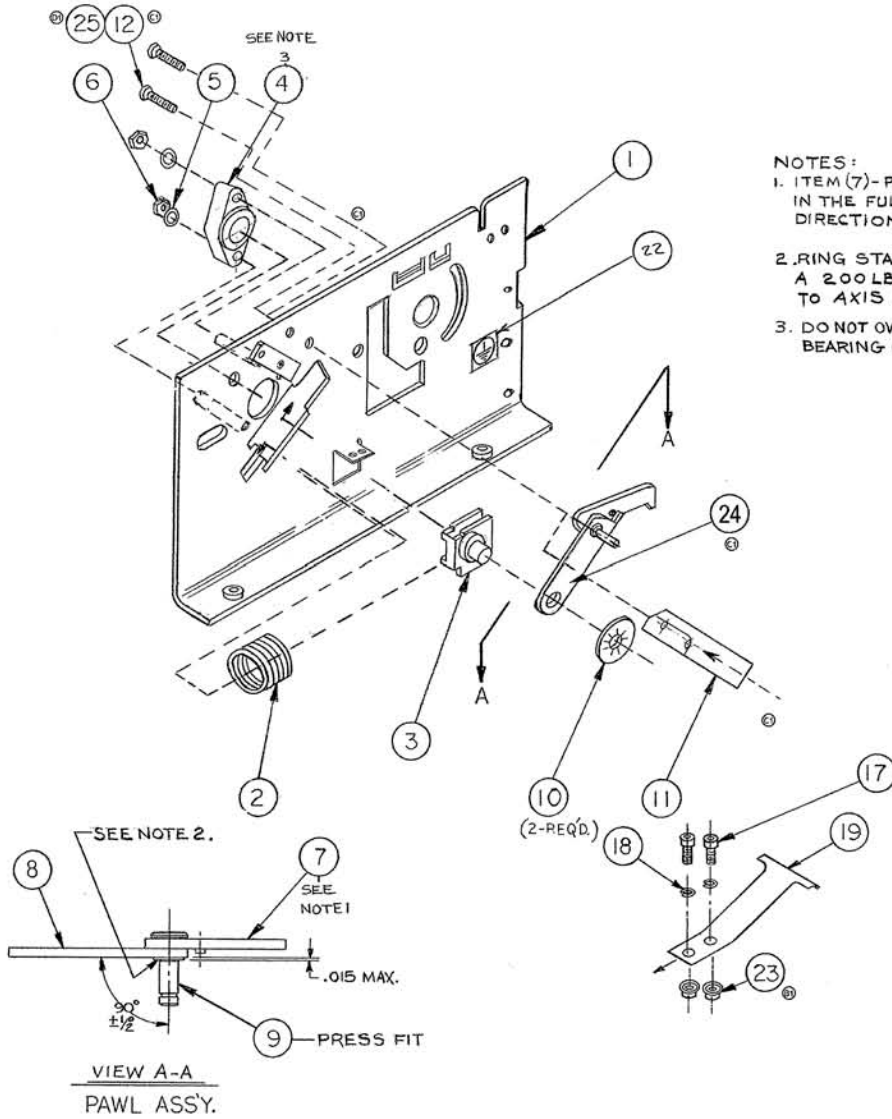
With Housing & Punch guide assy, item #101 On Unit
 Use the appropriate tool to set the Punch Edge Guide
 Note: Turn Unit "OFF" when Punch pins are down to adjust paper guide.
 Velobind: TN G-2381
 Surebind: TN G-2382

Apply Decal Edge Guide, item #107, to Punch: Edge Guide (See drawing). Decal must align with appropriate settings on Decal Punch, item #108
 Velobind - 11"
 Surebind - A4

Velobind ONLY
 Adjust the punch edge guide to the correct paper length. Check the punch alignment by punching a sheet of paper and folding it in half along the punched edge. (See below) Match the holes up; if the corners of the paper match with no overlap, the alignment is correct. If not, readjust the guide and repeat the process until the edges are square.



RIGHT HAND SIDE PLATE SUB-ASSEMBLY

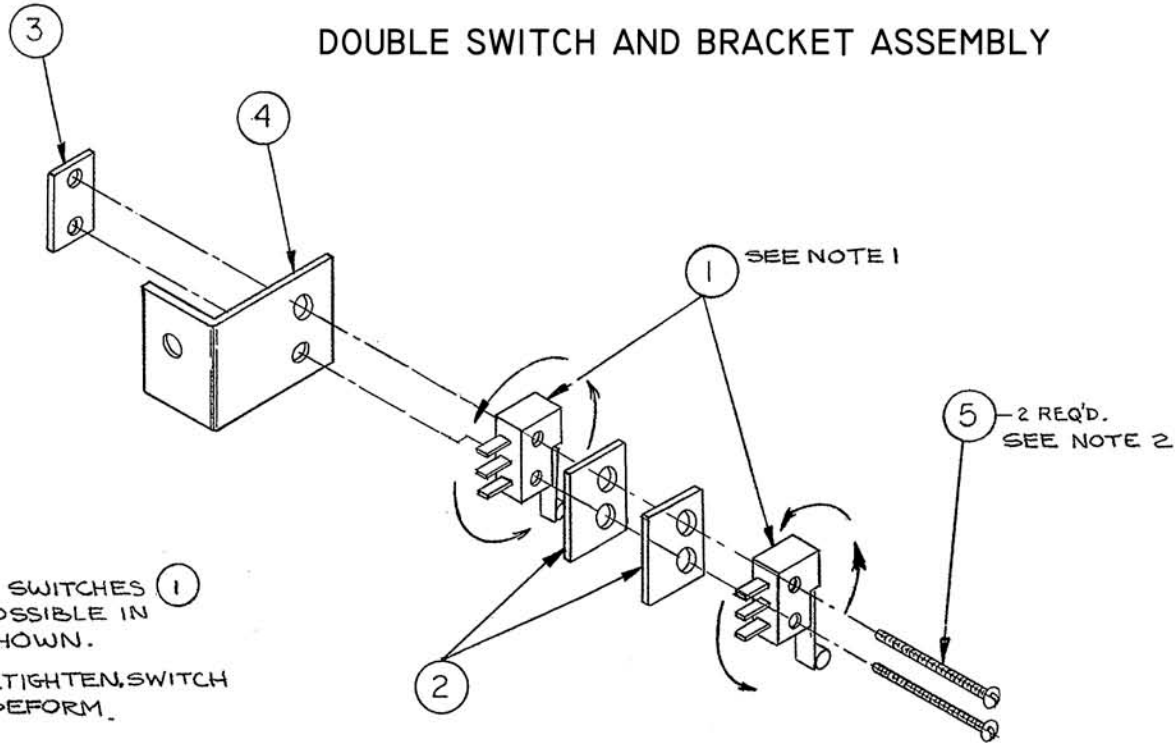


NOTES:

1. ITEM (7)-PAWL, MUST ROTATE FREELY IN THE FULL SWING RANGE IN BOTH DIRECTIONS BY ITS OWN WEIGHT.
2. RING STAKED PIN MUST WITHSTAND A 200LB. FORCE APPLIED PARALL TO AXIS OF PIN.
3. DO NOT OVER TIGHTEN LOCK NUT (6) BEARING (4) WILL DEFORM.

NO.	DESCRIPTION	QTY.	PART NO.
1	SIDE PLATE SYS-2, RH	1	9784060
2	COMPRESSION SPRING 2.5"	1	9776603
3	PILLOW BLOCK	1	9776665
4	BEARING - 230/101	1	9776608
5	WASHER, FLAT #8	2	1925008
6	LOCK NUT, 8-32	2	1927406
7	PAWL	1	9781872
8	PAWL LINK	1	9781868
9	DRIVE PIN	1	9781871
10	SPEED NUT, .312 DIA	2	1931301
11	BRACE, SYSTEM-2	1	7704990
12	SCREW 8-32X3/8 SLOT HEX HEAD	2	1907321
13			
14			
15			
16			
17	SCREW, SOC HEAD 4-40X3/8	2	1900501
18	LOCKWASHER, SPLIT #4	2	1926007
19	SUPPORT SPRING	1	9781163
20			
21			
22	GROUND LABEL	1	1128416
23	NUT & WASHER 4-40 (KEPS)	2	1926804
24	GREASE WITH TEFLON	0.01	1962532
25	LOCTITE 242	0.01	1960524

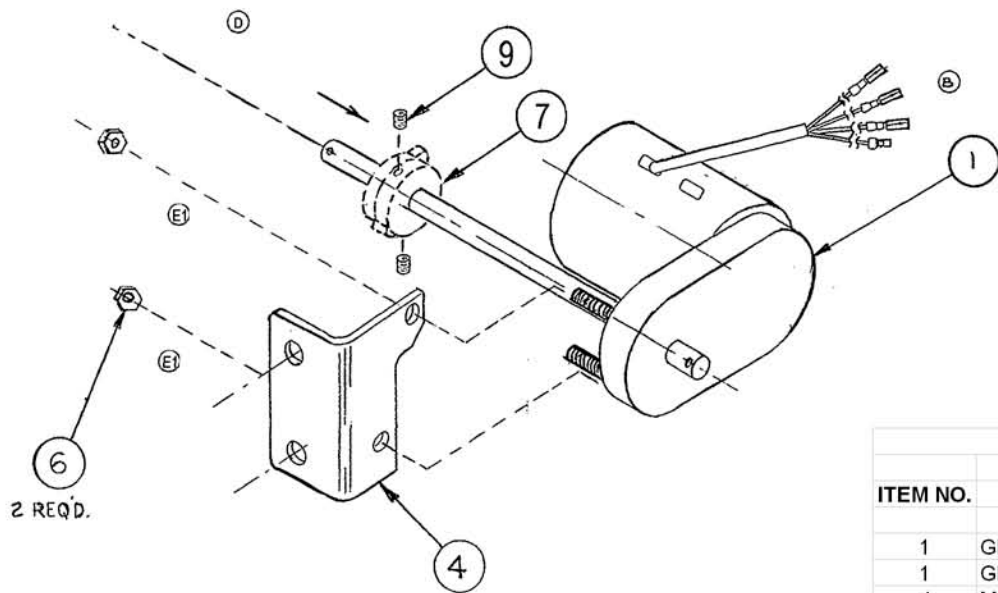
DOUBLE SWITCH AND BRACKET ASSEMBLY



- NOTES:
1. ROTATE BOTH SWITCHES (1) AS FAR AS POSSIBLE IN DIRECTION SHOWN.
 2. DO NOT OVERTIGHTEN, SWITCH BODY WILL DEFORM.

DOUBLE SWITCH AND BRACKET ASSEMBLY			
ITEM NO.	DESCRIPTION	QTY	PART NO.
1	SWITCH, SNAP W/ROLLER	2	9781142
2	SWITCH INSULATOR	2	9783651
3	NUT PLATE, SWITCH #2X56	1	9778618
4	SWITCH BRACKET TDC/BDC	1	9781136
5	SCREW 2-56x3/4 INT STAR WASHER	2	1911134

MOTOR AND CAM ACTUATOR ASSEMBLY



NOTES:

1. SLIDE CAM ASSEMBLY ONTO SHAFT OF MOTOR AS SHOWN
DO NOT TIGHTEN SET SCREW

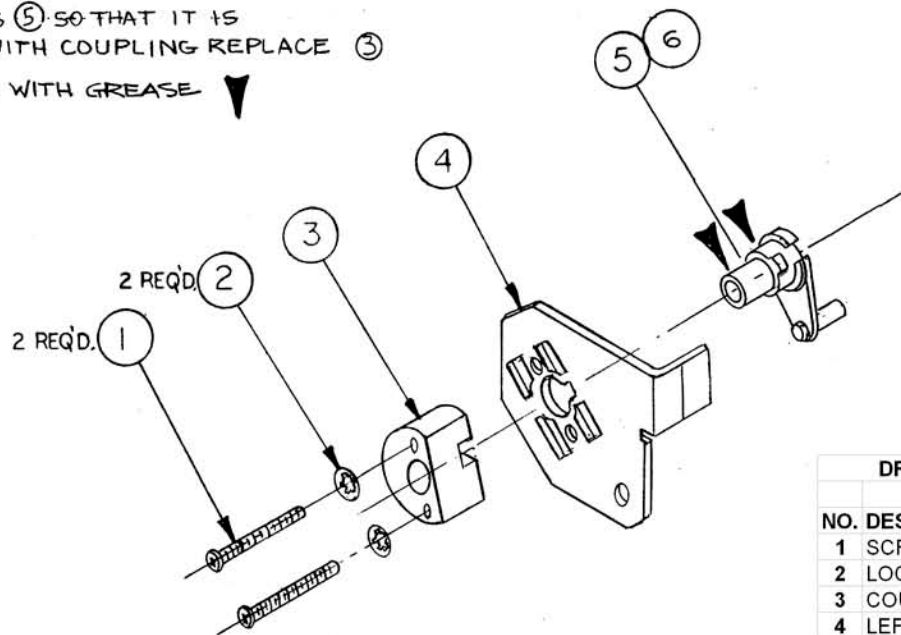
MOTOR & CAM ACTUATOR ASSEMBLY

ITEM NO.	DESCRIPTION	QTY	PART NUMBER
1	GEAR MOTOR PUNCH (110/115 V)	1	9781077
1	GEAR MOTOR PUNCH (220V)	1	9781351
4	MOTOR MOUNT	1	9781078
6	KEPS NUT 10-32	2	1926803
7	CAM SWITCH ACTUATOR ASSEMBLY	1	7705099
9	SCREW HEX SOC SET 6-32X1/4	2	1900020

LEFT HAND DRIVE LINK ASSEMBLY

NOTES

1. TURN HUB (5) SO THAT IT IS LOCKED WITH COUPLING REPLACE (3)
2. LUBRICATE WITH GREASE ▼

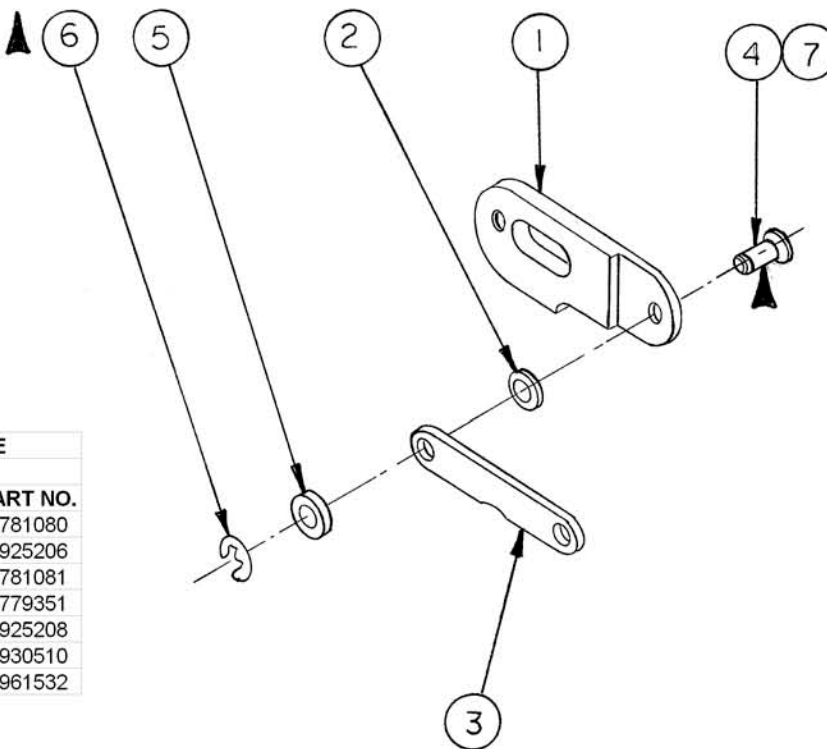


DRIVE LINK ASSEMBLY, LEFT HAND SIDE			
NO.	DESCRIPTION	QTY	PART NO.
1	SCREW, PH PAN HD 10-32X1	2	1902822
2	LOCKWASHER, INT. TOOTH #10	2	1925803
3	COUPLING REPLACE	1	9781062
4	LEFT DRIVE LINK	1	9778450
5	HUB	1	9778198
6	LUBRICATING GREASE	A/R	1961532

LEFT HAND SIDE LINKAGE ASSEMBLY

NOTE :

1-LUBRICATE
WITH GREASE ▲

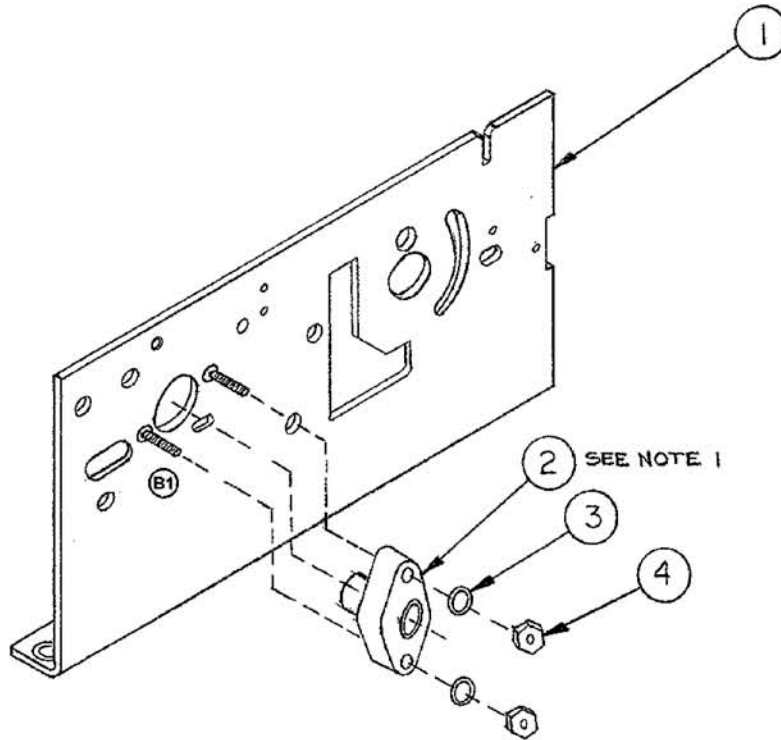


LINKAGE ASSEMBLY, LEFT HAND SIDE			
ITEM NO.	DESCRIPTION	QTY.	PART NO.
1	LINK. LEFT HAND	1	9781080
2	WASHER, .50 OD x .261 ID	1	1925206
3	LINK PUNCH	1	9781081
4	STUD PIVOT	1	9779351
5	WASHER, FLAT PLASTIC	1	1925208
6	RETAINING RING	1	1930510
7	LUBRICATING GREASE	A/R	1961532

LEFT HAND SIDE PLATE SUB-ASSEMBLY

NOTE

1. DO NOT OVERTIGHTEN LOCKNUT (4),
BEARING (2) WILL DEFORM.

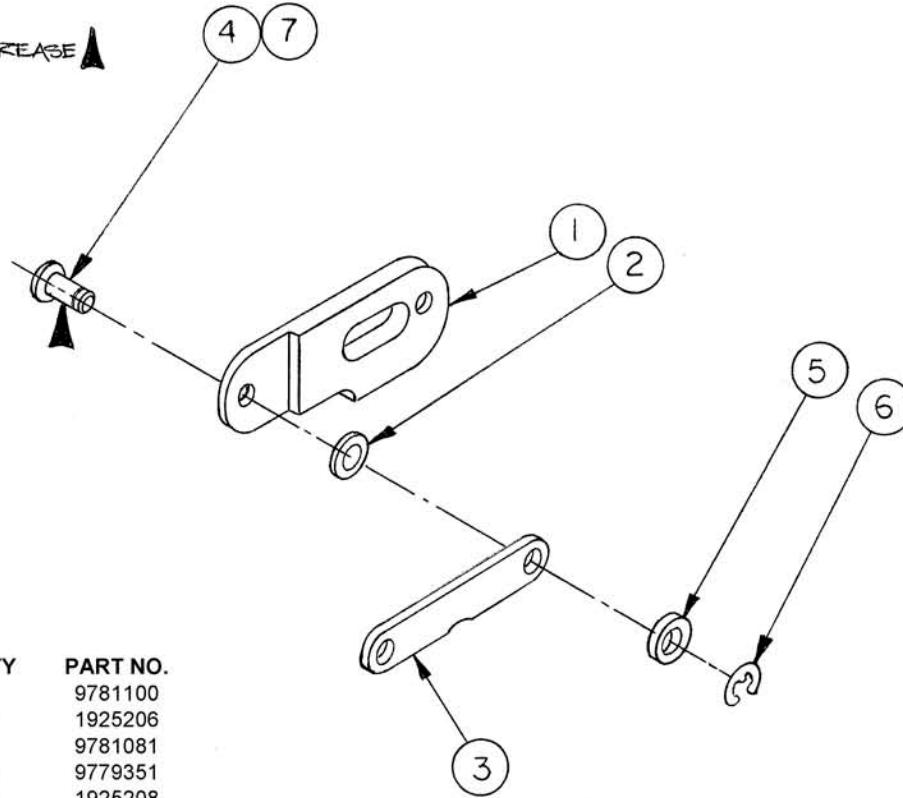


ITEM NO	DESCRIPTION	QTY	PART NO.
1	SIDE PLATE, SYS 2, LH	1	9784061
2	BEARING 230/101	1	9776608
3	WASHER, FLAT #8	2	1925008
4	LOCK NUT, 8-32	2	1927406

RIGHT HAND LINKAGE ASSEMBLY

NOTE :

1- LUBRICATE WITH GREASE ▲



ITEM NO.	DESCRIPTION	QTY	PART NO.
1	LINK, RIGHT HAND	1	9781100
2	WASHER, .50 x .261 ID	1	1925206
3	LINK PUNCH	1	9781081
4	STUD PIVOT	1	9779351
5	WASHER, FLAT PLASTIC	1	1925208
6	RETAINING RING	1	1930510
7	LUBRICATING GREASE	A/R	1961532

RIGHT HAND SHAFT AND DRIVE LINK ASSEMBLY

NOTE:

1- USE TOOL & ARBOR PRESS TO STAKE PIN.

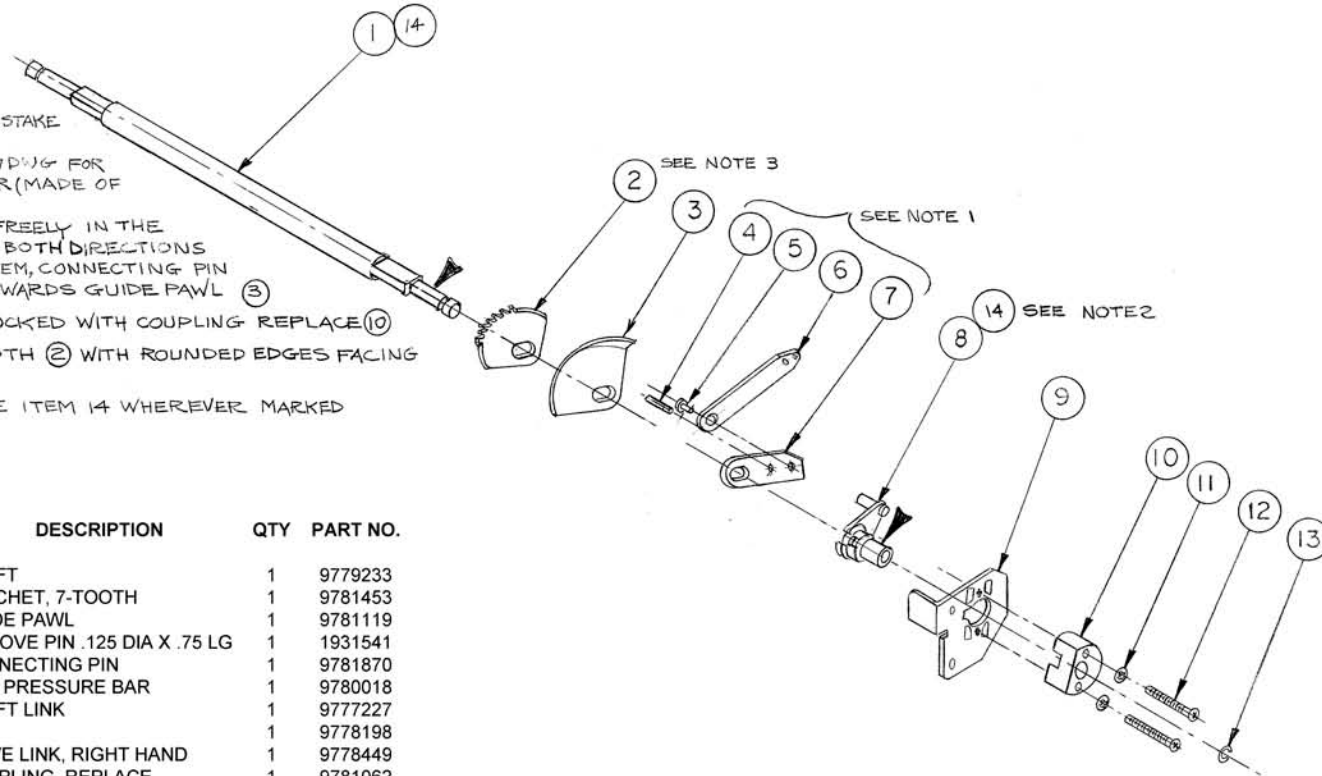
REFER TO P/N 9781557D¹⁰ FOR LINK ASSY, R.H. PR. BAR (MADE OF ITEM 4, 5, 6, & 7)
 ITEM 6 MUST ROTATE FREELY IN THE FULL SWING RANGE IN BOTH DIRECTIONS BY ITS OWN WEIGHT. ITEM, CONNECTING PIN HEAD, ⑤ SHOULD FACE TOWARDS GUIDE PAWL ③

2- TURN HUB ⑧ SO THAT IT IS LOCKED WITH COUPLING REPLACE ⑩

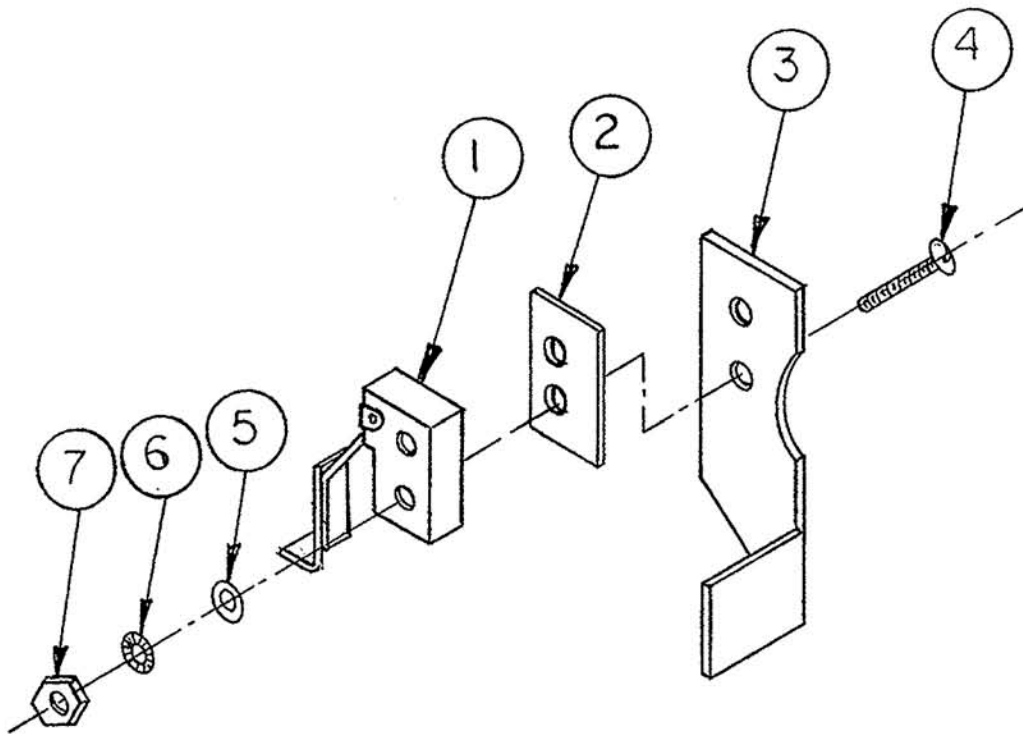
3- POSITION RATCHET 7 TOOTH ② WITH ROUNDED EDGES FACING GUIDE PAWL ③

4- ▲ LUBRICATE WITH GREASE ITEM 14 WHEREVER MARKED

ITEM NO.	DESCRIPTION	QTY	PART NO.
1	SHAFT	1	9779233
2	RATCHET, 7-TOOTH	1	9781453
3	GUIDE PAWL	1	9781119
4	GROOVE PIN .125 DIA X .75 LG	1	1931541
5	CONNECTING PIN	1	9781870
6	LINK PRESSURE BAR	1	9780018
7	SHAFT LINK	1	9777227
8	HUB	1	9778198
9	DRIVE LINK, RIGHT HAND	1	9778449
10	COUPLING, REPLACE	1	9781062
11	LOCK WASHER, INT TOOTH #10	2	1925803
12	SCREW, PH PAN HD 10-32x1"	2	1902822
13	RETAINING RING	1	1935044
14	LUBRICATING GREASE	A/R	1961532



SWITCH AND BRACKET ASSEMBLY



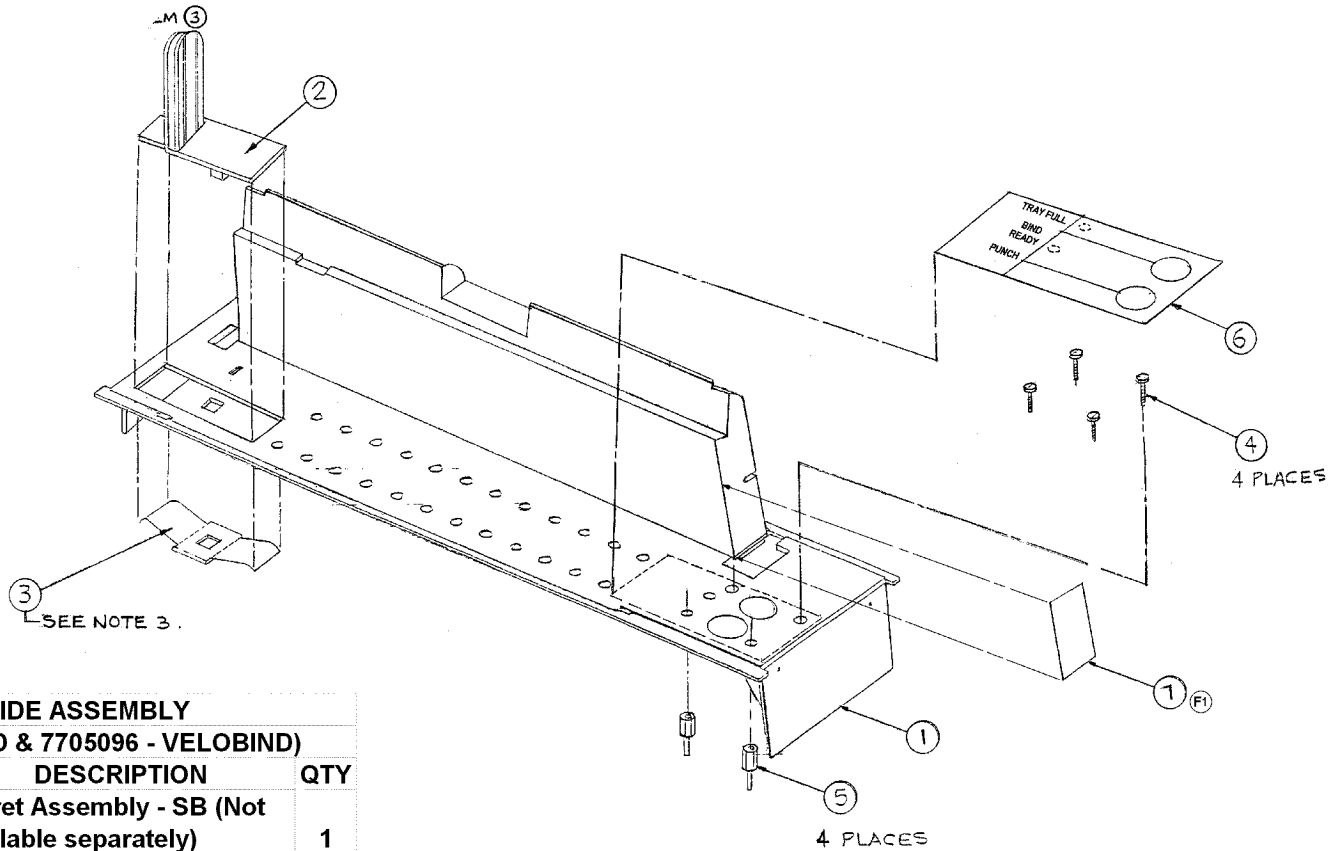
DO NOT OVER TIGHTEN SCREW ④
SWITCH BODY WILL DEFORM

SWITCH & BRACKET ASSEMBLY, S3			
ITEM NO.	DESCRIPTION	QTY	PART NO.
1	SWITCH, SNAP ACTION SPDT S3	1	9781085
2	SWITCH INSULATOR	1	9783651
3	SWITCH BRACKET	1	9781138
4	SCREW, 2-56X3/4 PPH INT STAR WASHER	1	1911134
5	WASHER, FLAT #2	1	1925120
6	WASHER, INT LOCK #2	1	1925805
7	HEX NUT 2-56	1	1926714

TURRET GUIDE ASSEMBLY

NOTE:

1. THE DRAWING IS FOR ASSEMBLY GUIDELINE ONLY. PLEASE REVIEW INDIVIDUAL PARTS DRAWING FOR DETAILS.
2. ASSEMBLE ITEM ⑤ SPACER USING ITEM ④ SCREWS BEFORE ADDING ITEM ⑥ LABEL OVER THE SCREWS.
3. INSERT SPRING PAPER GUIDE, ITEM ③ APPROXIMATELY 1/16" DEEP ON SQUARE STUD BENEATH GUIDE PAPER EDGE, ITEM ②.
- ④ 4. ITEM 6 IS PART OF THE LABEL KITS FOR THE SYSTEM 2 VELOBIND & SUREBIND MACHINES PART NUMBERS 7705134 & 7705135

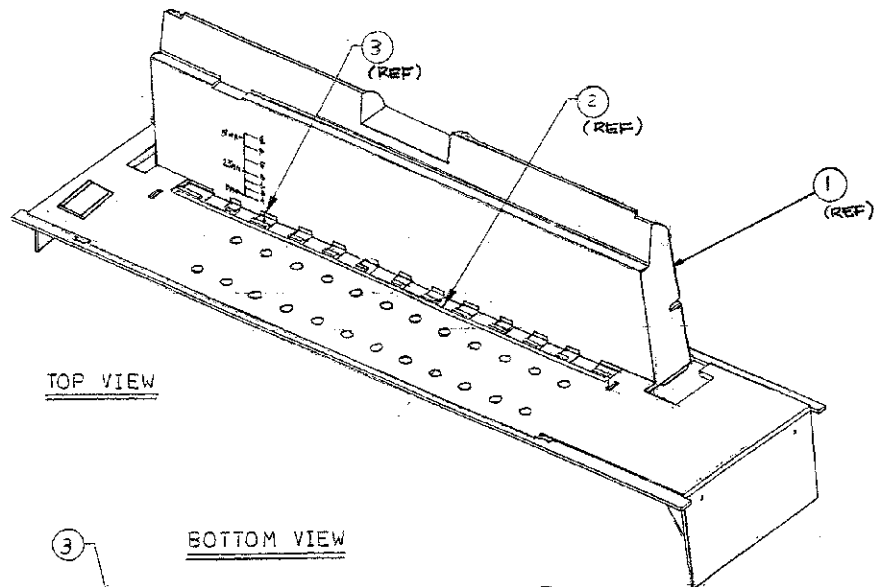


TURRET GUIDE ASSEMBLY (7704963 - SUREBIND & 7705096 - VELOBIND)			
ITEM NO.	PART NO.	DESCRIPTION	QTY
1	7704964	Turret Assembly - SB (Not available separately)	1
	7705095	Turret Assembly - VB (Not available separately)	1
2	7704972	Guide Paper Edge Bind	1
3	9776954	Spring Paper Guide	1
4	1902606	Screw Phillips Flt Hd 6/32 X 3/8	4
5	1951007	Spacer Control Panel PCB	4
6	7704973	Label Control Panel	1
7	7704919	Turret Switch Plate	1

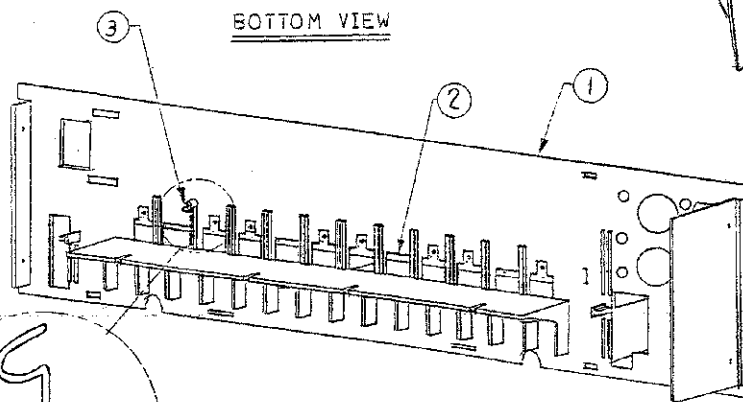
TURRET ASSEMBLY

1-THE DRAWING IS FOR ASSEMBLY
GUIDELINE ONLY. PLEASE REVIEW
INDIVIDUAL PARTS DRAWING FOR
DETAILS.

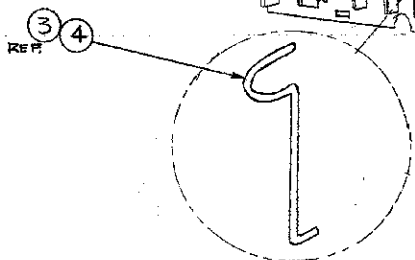
2-ADD SICOMET GLUE, ITEM 4., TO PIN, ITEM 3,
AS SHOWN.



TOP VIEW



BOTTOM VIEW

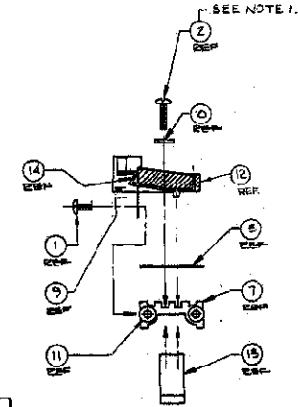
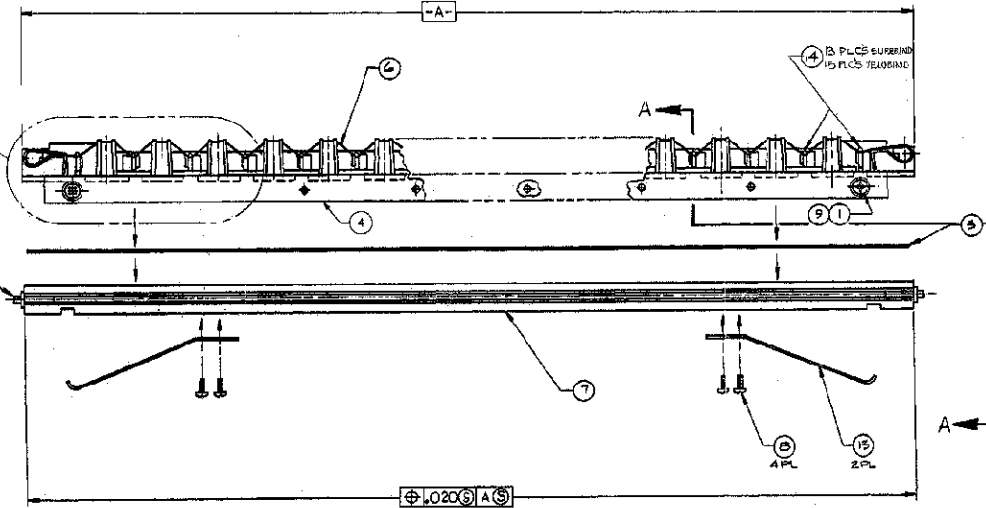
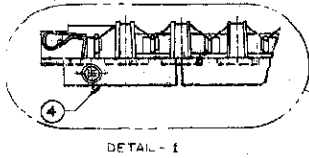
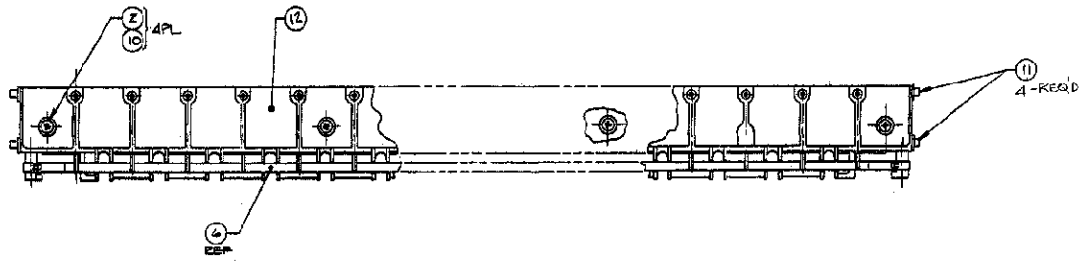


TURRET ASSEMBLY

(7704963 - SUREBIND & 7705096 - VELOBIND)

ITEM NO.	PART NO.	DESCRIPTION	QTY
1	7704974	Turret Silkscreened - SB (Not available separately)	1
	7704917	Turret Silkscreened - VB (Not available separately)	1
2	9777400	Strip, Cover SB	1
	9779358	Strip, Cover VB	1
3	9778682	Locating Pin	1
4	1960506	Adhesive Sicomet Cynoacrylate	AR

NOTE:
 1. BEFORE TIGHTENING SCREW ITEM 2, MAKE SURE THAT BLADE SUPPORT ITEM 11 IS CENTERED IN RELATION TO THE SUPPORT BAR, ITEM 7.
 2. USE TRAVEL ARRESTOR QTY (1) OR (2) DEPENDING UPON THE TOLERANCE STACKUP, SUREBIND ONLY

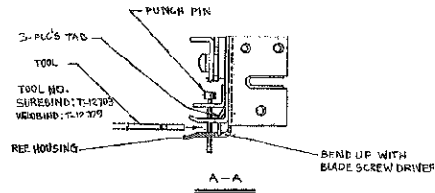
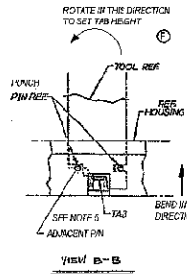
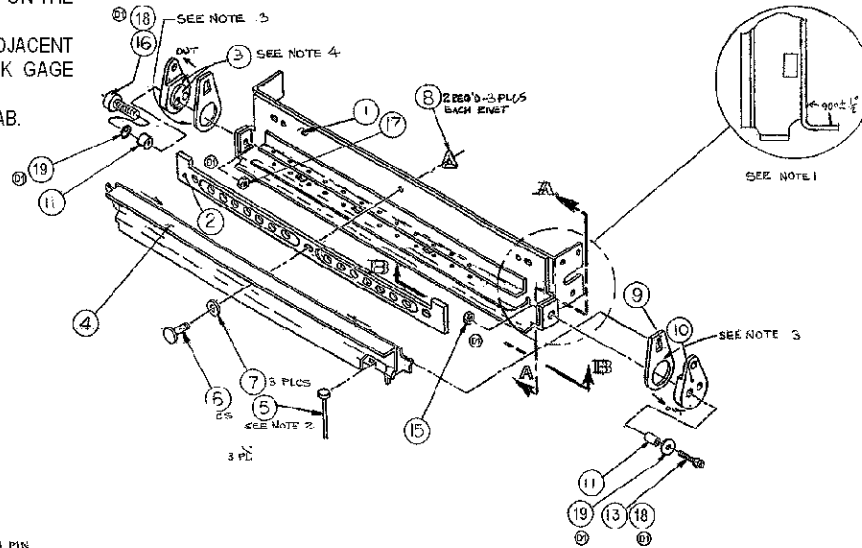


HEATER ASSEMBLY				
(9777072 - SUREBIND & 9776678 - VELOBIND)				
ITEM NO.	PART NO.	DESCRIPTION	QTY SB	QTY VB
1	1907831	SCR THD CUT PH PAN HD 6-32 X 1/4	6	4
2	1907834	SCR PH PAN HD SELF TAP 4-24X1/2	4	4
3	9781572	INSULATOR HEATER ASSEMBLY SB	1	
	9778291	INSULATOR HEATER ASSEMBLY VB		1
4	9781153	TRAVEL ARRESTOR SB	2	
	9776951	TRAVEL ARRESTOR VB		1
5	NOT USED			
6	9781639	BLADE STRIP ASSY BLK TEFLON SB	1	
	9781638	BLADE STRIP ASSY BLK TEFLON VB		1
7	9776664	BAR SUPPORT ALUM MACHINED	1	1
8	1907833	SCR PH PAN HD THD CUT 4-40x1/4	4	4
9	1925119	WASHER FLAT #6	6	4
10	1925012	WASHER FLAT .125ID	4	4
11	9779352	STUD HEATER	4	4
12	9777029	SUPPORT BLADE SB	1	
	9779293	SUPPORT BLADE VB		1
14	9781163	SPRING SUPPORT	2	2
15	9779268	SPRING TENSIONER	13	15

NOTES:

PUNCH ASSEMBLY

1. BEND SHOULD BE PERPENDICULAR AT BOTH ENDS.
2. VISUALLY INSPECT PINS ITEM 5 FOR FOLLOWING:
 - RADIUS CENTERED
 - RADIUS TIP SHARP
3. ROUNDED EDGE OF ITEM 9 TO FACE OUT (2 PLACES).
4. LUBRICATE SURFACE INDICATED WITH GREASE ITEM 3 (8 PLACES EACH END).
5. BEND TAB SHOWN IN FIGURE A-A AND B-B IN THE DIRECTION SHOWN. THIS SETS THE BACKGAGE TABS TO MINIMUM SETTING USING A FLAT BLADED SCREWDRIVER. INSTALL THE PROPER TOOL VELOBIND OR SUREBIND TOOL IN DIE SET THROAT AS SHOWN IN FIGURE A-A AND B-B SO THAT THE SLOT IN THE TOOL IS LOCATED ON THE PUNCH PIN NEAR ONE OF THE BACK GAGE TABS. ROTATE THE TOOL UNTIL IT CONTACTS THE ADJACENT PIN. THIS WILL SET THE HEIGHT OF THE BACK GAGE TABS. REPEAT THIS PROCESS FOR EACH BACK GAGE TAB.



PUNCH ASSEMBLY (9781814 - SUREBIND & 9781029 - VELOBIND)			
ITEM NO.	PART NO.	DESCRIPTION	QTY
1	9781814	PUNCH ASSEMBLY COMPLETE SB - INCLUDES HOUSING (9777425) AND ITEMS 2, 4, 5, 6, 7, AND 8	1
2	9779250	SPACER	1
3	1921532	GREASE LUBRICATING	AR
4	9781390	ACTUATOR PUNCH SB	1
	9776365	ACTUATOR PUNCH VB	1
5	9778684	PUNCH PINS	12SB
6	9779063	RETAINING PINS	3
7	1925218	SPACER	3
8	1929105	1/4" SPEED NUT	3
9	9778446	PUNCH LINK	2
10	9781095	DRIVE ECCENTRIC	2
11	9779257	SPACER	2
12	USED	NOT USED	
13	1900591	1/4-28 x 1-1/8 RIGHT THREAD SCREW	1
14	USED	NOT USED	
15	1926710	1/4-28 HEX NUT RIGHT THREAD	1
16	1900527	1/4-28 x 1-1/8 LEFT THREAD SCREW	1
17	1926724	1/4-28 HEX NUT LEFT THREAD	1
18	1960512	LOCTITE 242	AR
19	1925183	WASHER	2