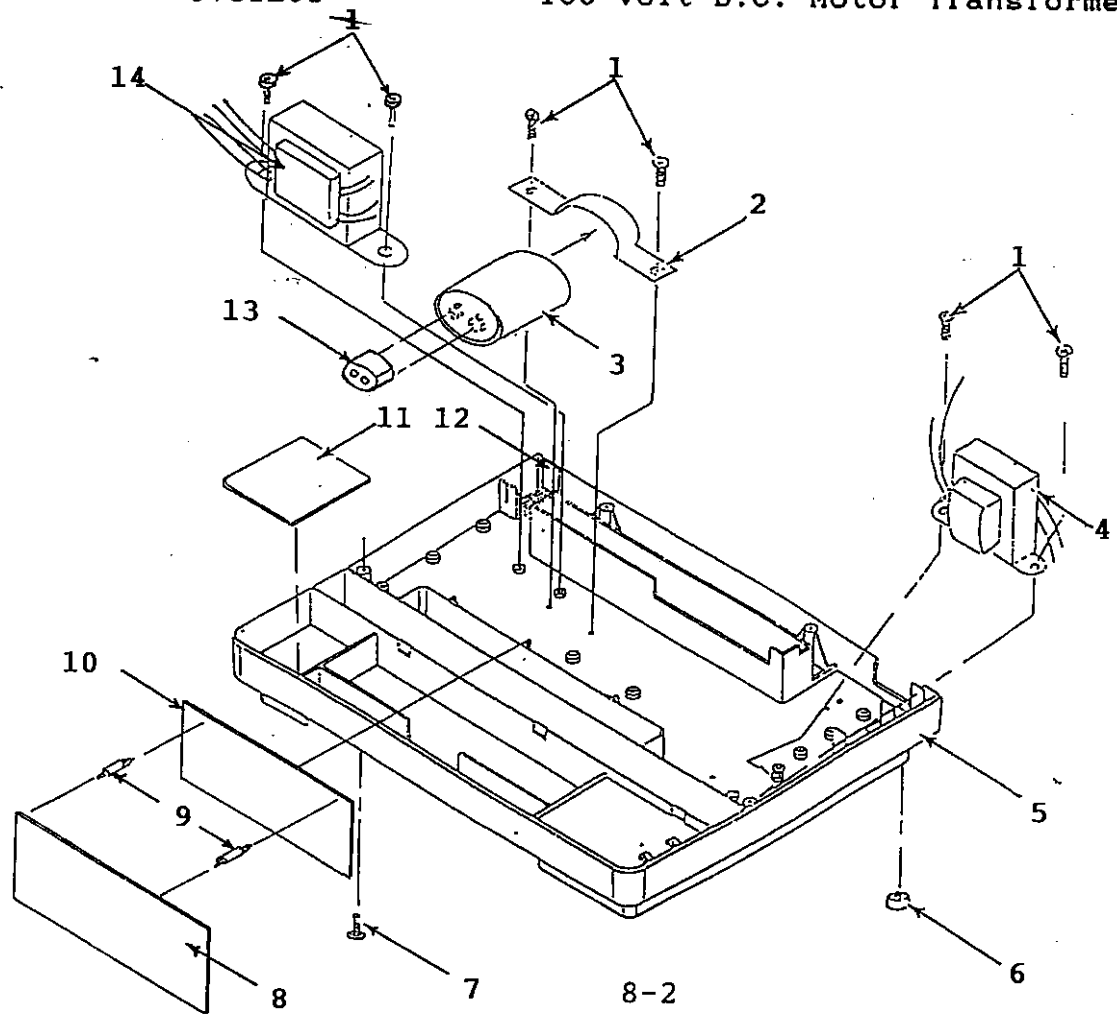


*Punch guide
Label SB-978160X
Label VB-9781623
Punch Guide*

8.0 PARTS LIST

Figure 8-1

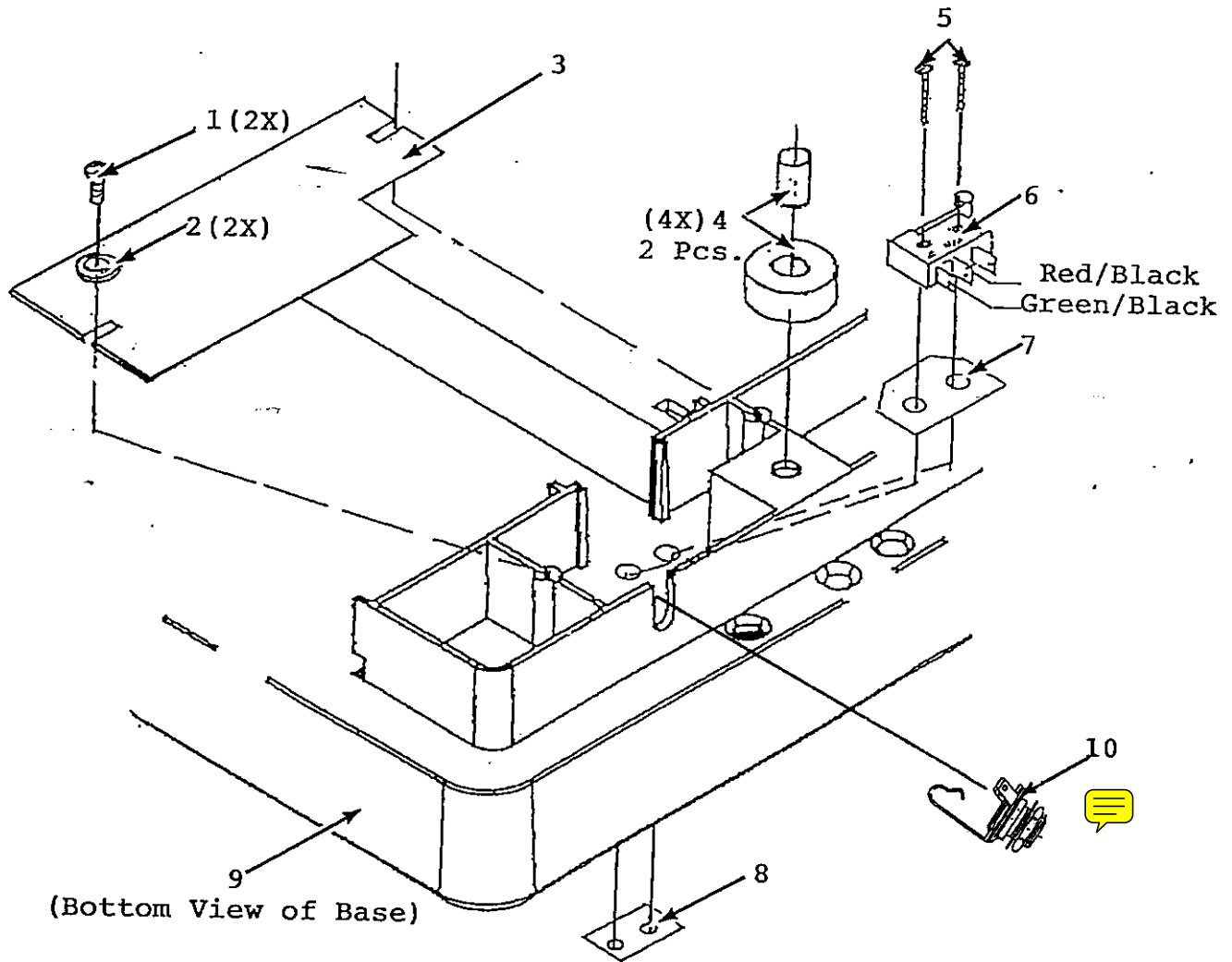
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9779174	8/32 X 3/8 Phillips Screw	6
2	9781197	Capacitor Mounting Bracket	1
3	9781195	7.5 uf, 370 VAC Motor Run Capacitor	1
	9781196	10 uf, 440 VAC Motor Run Capacitor	1
	9776779	30 uf, 370 Volt Motor Run Capacitor	1
4	9781202	100 VAC Heater Power Transformer	1
	9781203	115 VAC Heater Power Transformer	1
	9781205	230 VAC Heater Power Transformer	1
5	9781214	Base	1
6	9781363	Rubber Foot	4
7	9779174	8/32 X 3/8 Phillips Pan Head Screw	7
8	9781357	P.C.B. Lead Protector	1
9	9781360	P.C.B. Spacer	2
10	9781207	P.C. Board Assembly	1
11	9781229	Supplies Lid Cover, Fixed	1
12	9781251	Counter Cover	1
13	9776745	Capacitor Boot	1
14	9781210	D.C. Motor Transformer	1
	9781201	100 Volt D.C. Motor Transformer	1



8.0 PARTS LIST

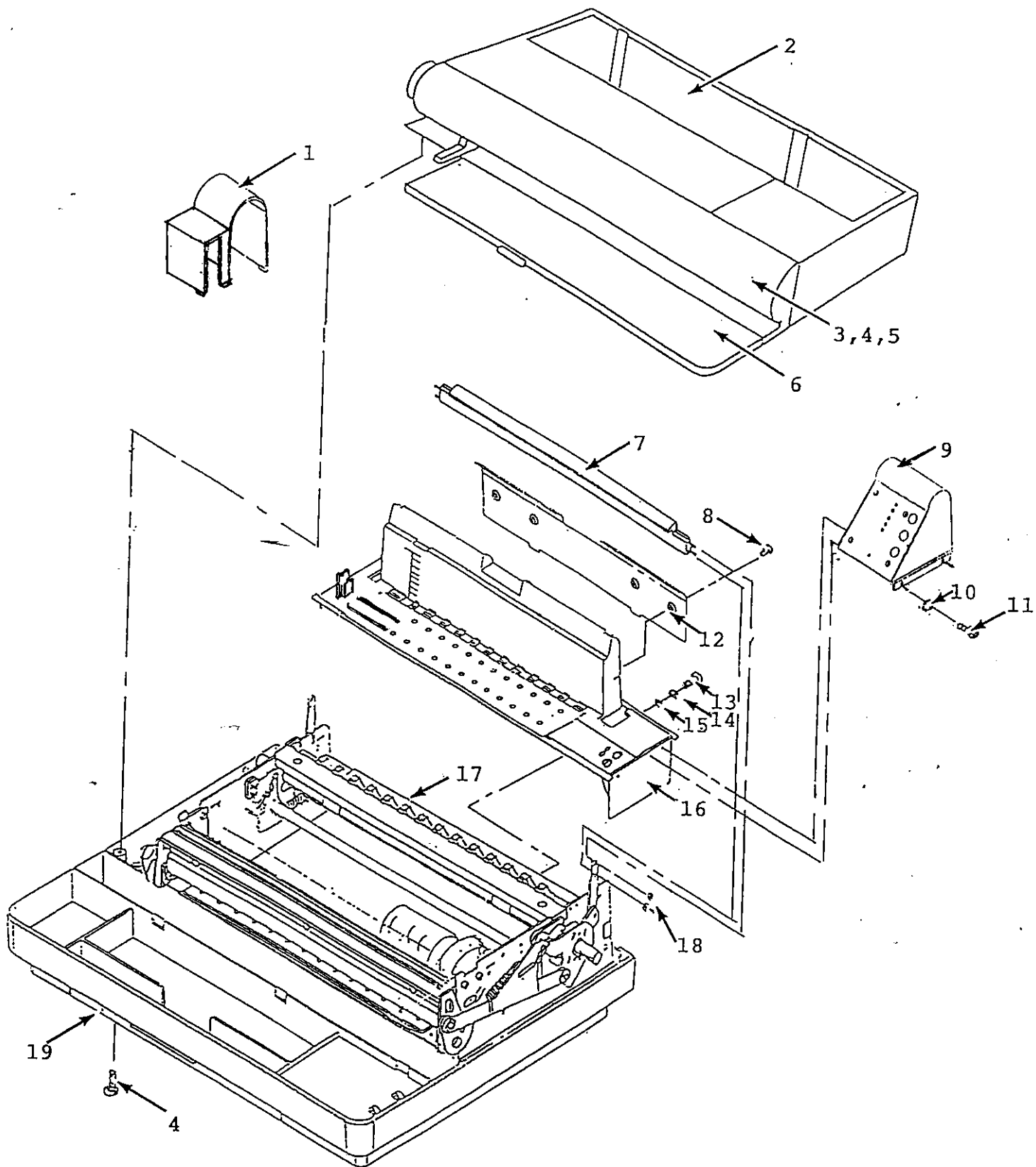
Figure 8-2

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9779219	6/32 X 3/8 Phillips Pan Head Screw	2
2	9779897	#6 Flat Washer	2
3	9781250	Raceway Cover	1
4	9781363	Rubber Foot (2 Pieces)	4
5	9779162	2/56 X 5/8 Round Head Phillips Screw	2
6	9781142	Snap Action Switch with Roller	1
7	9778287	Switch Insulator	1
8	9778618	#2/56 Nut Plate	1
9	9781214	Base (Bottom View)	1
10	9781234	Phone Jack Connector	1



8.0 PARTS LIST

Figure 8-3



8.0 PARTS LIST

FIGURE 8-3

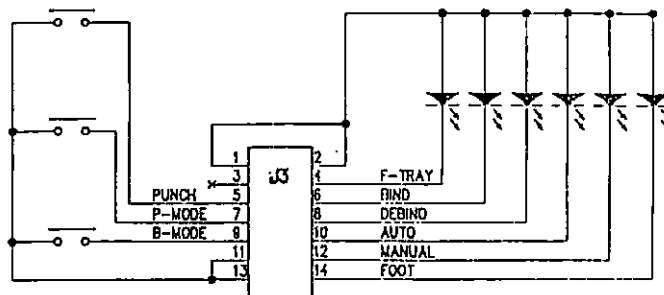
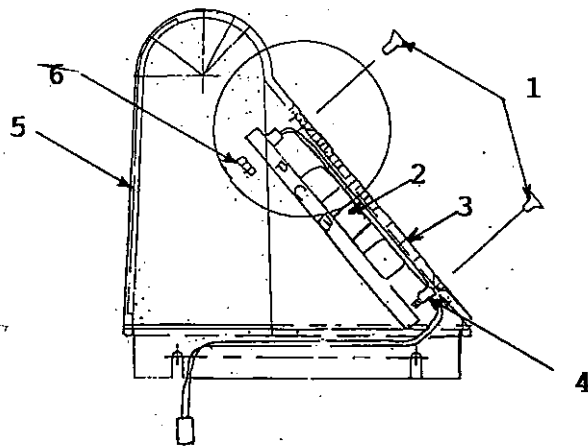
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9781 233	LEFT TURRET END CAP	1
2	9781222	TOP COVER	1
3	9781212	BULLNOSE	1
4	9779174	8/32 X 3/8 PHILLIPS PAN HEAD SCREW	11
5	9779914	#8 FLAT WASHER	4
6	9781213	SUPPLIES COVER LID	1
7	9781538	PRESSURE BAR ASSEMBLY	1
	9781104	VELOBIND PRESSURE BAR LOGO	1
	9781352	GESTETNER PRESSURE BAR LOGO	1
	9781353	NASHUATEC PRESSURE BAR LOGO	1
	9781355	GUSA PRESSURE BAR LOGO	1
	9781667	GBC SUREBIND PRESSURE BAR LOGO	1
8	9779214	#8/18 X 1/2 PHILLIPS PN HD SCREW	4
9	9781219	RIGHT TURRET END CAP	1
10	9779926	#8 EXTERNAL TOOTH LOCKWASHER	4
11	9779214	8/18 X 1/2 SELF-TAP SCREW	4
12	9781249	TURRET BACK COVER	1
13	9779219	6/32 X 3/8 THREAD CUTTING SCREW	4
14	9779897	#6 FLAT WASHER	4
15	9779925	#6 EXTERNAL TOOTH LOCKWASHER	4
16	9781424	TURRET ASSEMBLY - SYSTEM THREE	1
	9781423	TURRET ASSEMBLY - GEST/NASH S/B	1
	9781221	BIND EDGE GUIDE	1
17	9781061	BRACE	1
18	9776950	RETAINING RING	6
19	9781215	WASTE TRAY	1

9779218 Screws, Turret Covers
 (to secure end caps) ~~4~~

8.0 PARTS LIST

Figure 8-4

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9781568	6/32 X 3/8 Ph Flat Head Screw - 100°	4
2	9781129	P.C.B. Assembly w/Flat Cable	1
	9781400	Green Conductive Rubber Switch	1
	9781417	Dark Grey Conductive Rubber Switch	1
3	9781362	Control Panel Label	1
	9781381	Control Panel Label - Gest/Nash	1
4	9781364	Control Panel P.C.B. Spacer	4
5	9781219	Right End Cap	1
6	9778588	6/32 Hex Nut	4

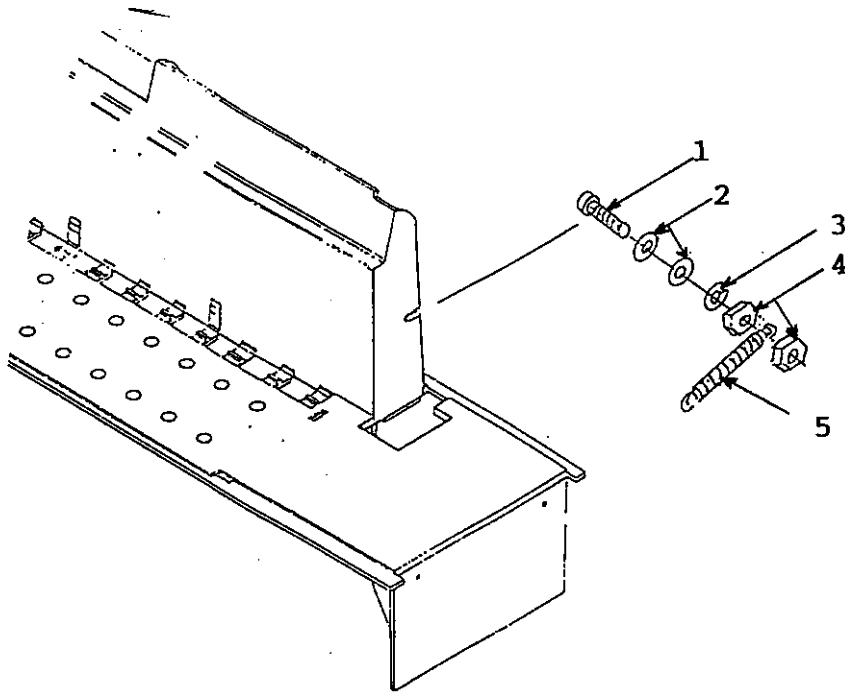


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8.0 PARTS LIST

Figure 8-5

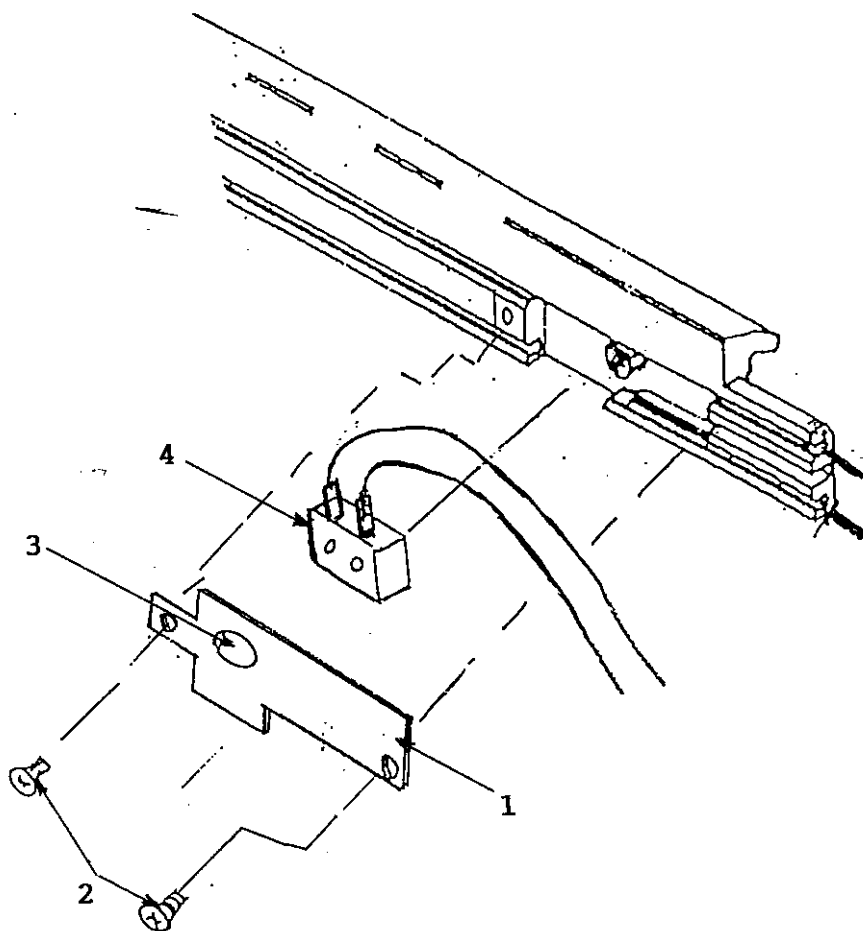
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9779132	8/32 X 3/4 Socket Head Screw	2
2	9779898	#8 Flat Washer	4
3	9779911	#8 Split Lock Washer	2
4	9778589	8/32 Hex Nut	4
5	9781135	Pressure Bar Return Spring	2



8.0 PARTS LIST

Figure 8-6

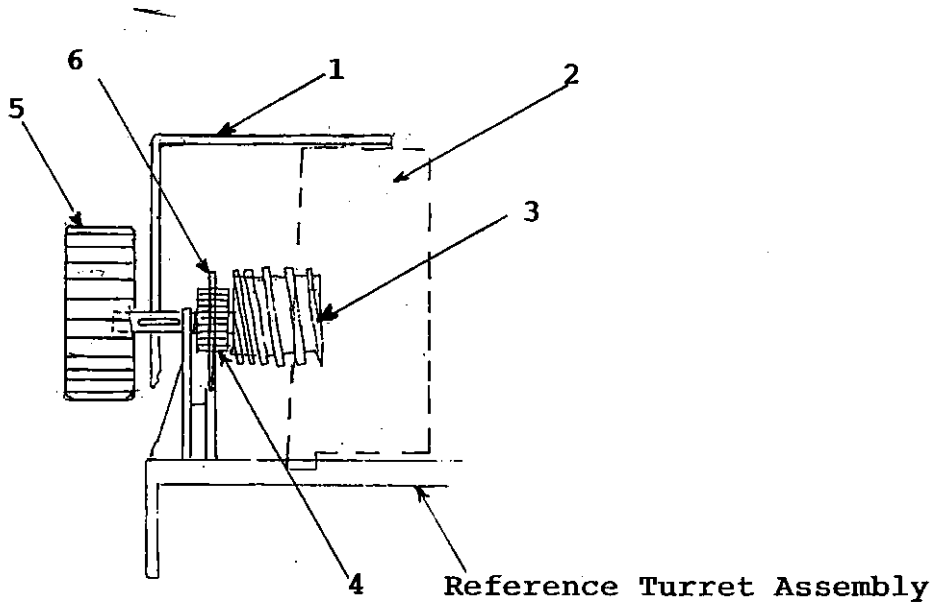
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9781492	Switch Cover Plate	1
2	9779223	2/56 X 3/16 Phillips Flat Hd Screw	2
3	9778772	Spacer Pad	2
4	9780089	Pressure Bar Switch Assembly	1



8.0 PARTS LIST

Figure 8-7

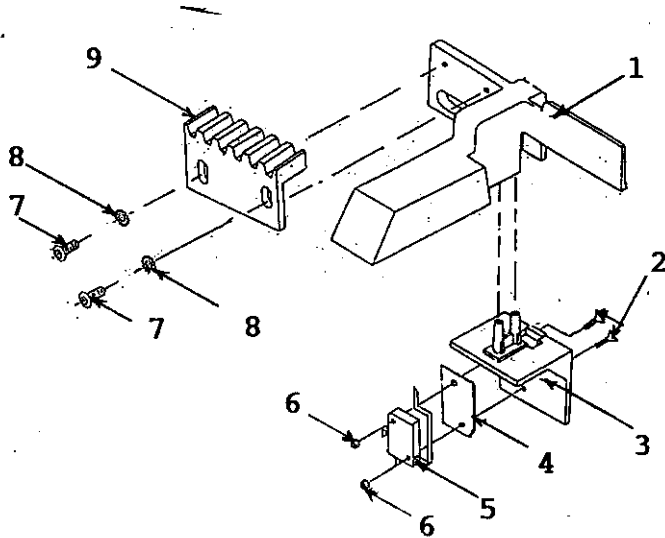
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9781233	Left End Cap (Reference)	1
2	9781221	Bind Edge Guide	1
3	9781227	Bind Edge Guide Screw	1
4	9781217	Knob Cap	1
5	9781220	Guide Knob	1
6	9781252	Edge Guide Wire Clip	1



8.0 PARTS LIST

Figure 8-8

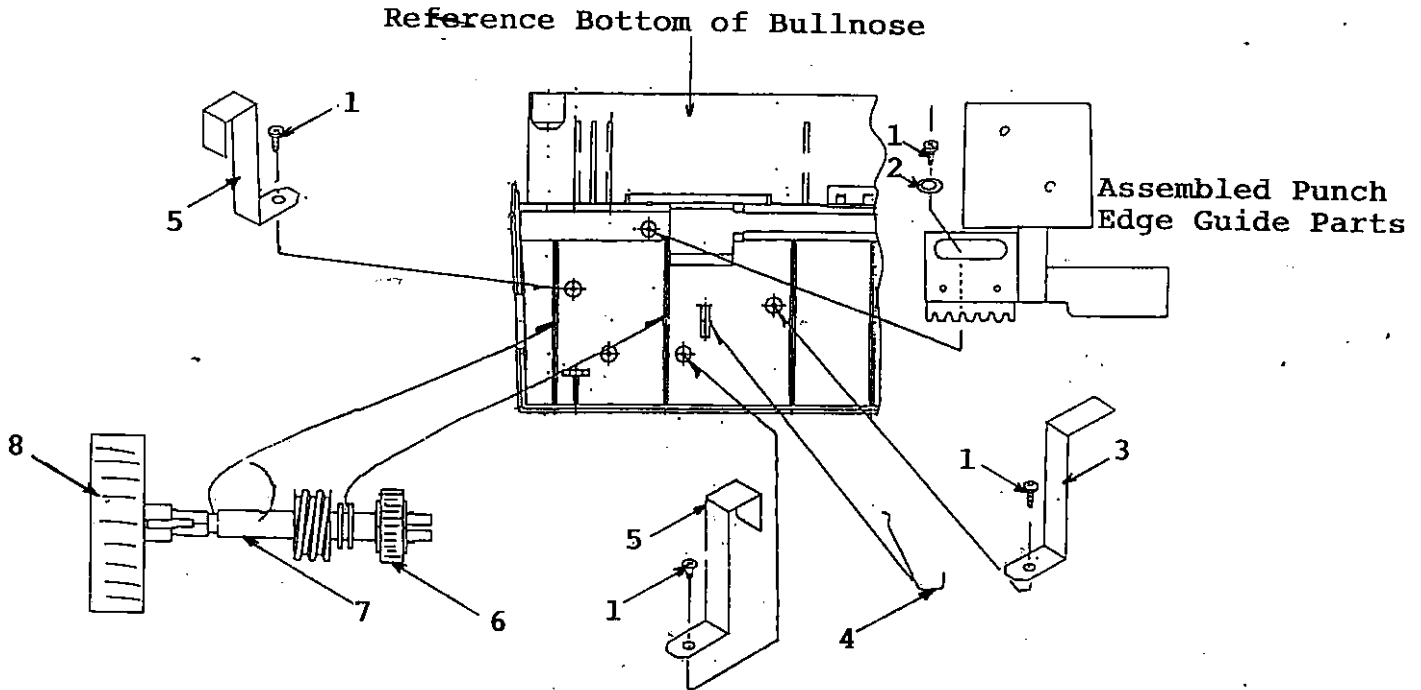
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9781211	Punch Edge Guide Support	1
2	9779185	4/40 X 5/8 Phillips Flat Hd. Screw	2
3	9781246	Punch Edge Guide	1
	9781605	Punch Edge Guide (SureBind)	1
	9781469	Punch Decal	1
	9781604	Punch Decal (SureBind)	1
4	9778285	Insulator	1
5	9781149	Auto Punch Switch	1
6	9778587	4/40 Hex Nut	2
7	9781172	4/40 X 1/4 Phillips Pan Hd. Screw	2
8	9779925	#6 Exterior Lock Washer	2
9	9781245	Edge Guide Rack	1



8.0 PARTS LIST

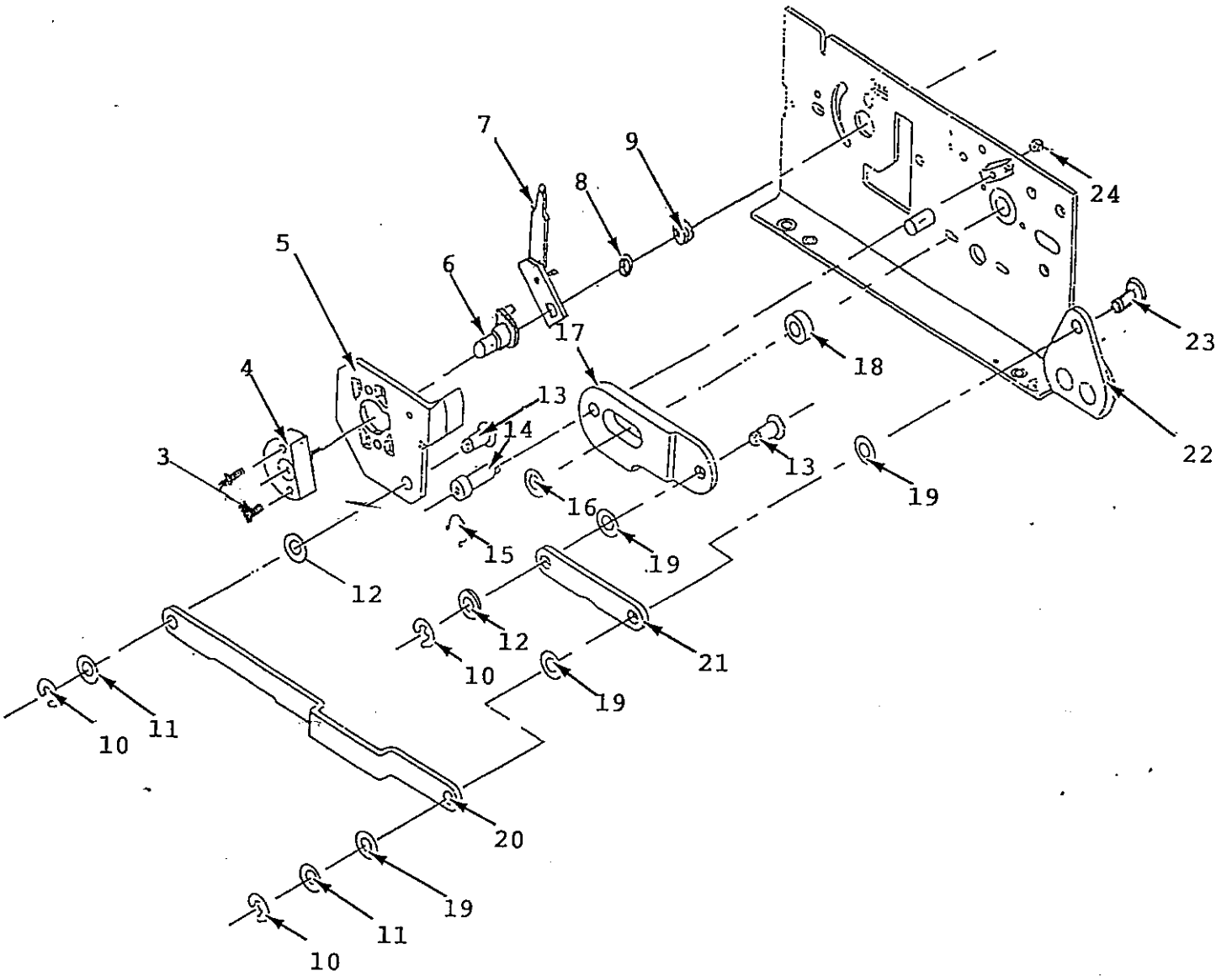
Figure 8-9

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9781455	4/14/ X 1/4 Plask 1 Screw	4
2	9779897	#6 Flat Washer	1
3	9781254	Punch Edge Guide Clamp	1
4	9781252	Punch Edge Guide Wire Clip	1
5	9781253	Punch Edge Guide Screw Clip	2
6	9781217	Gear Cap Knob	1
7	9781228	Punch Edge Guide Screw	1
8	9781220	Guide Knob	1



8.0 PARTS LIST

Figure 8-10



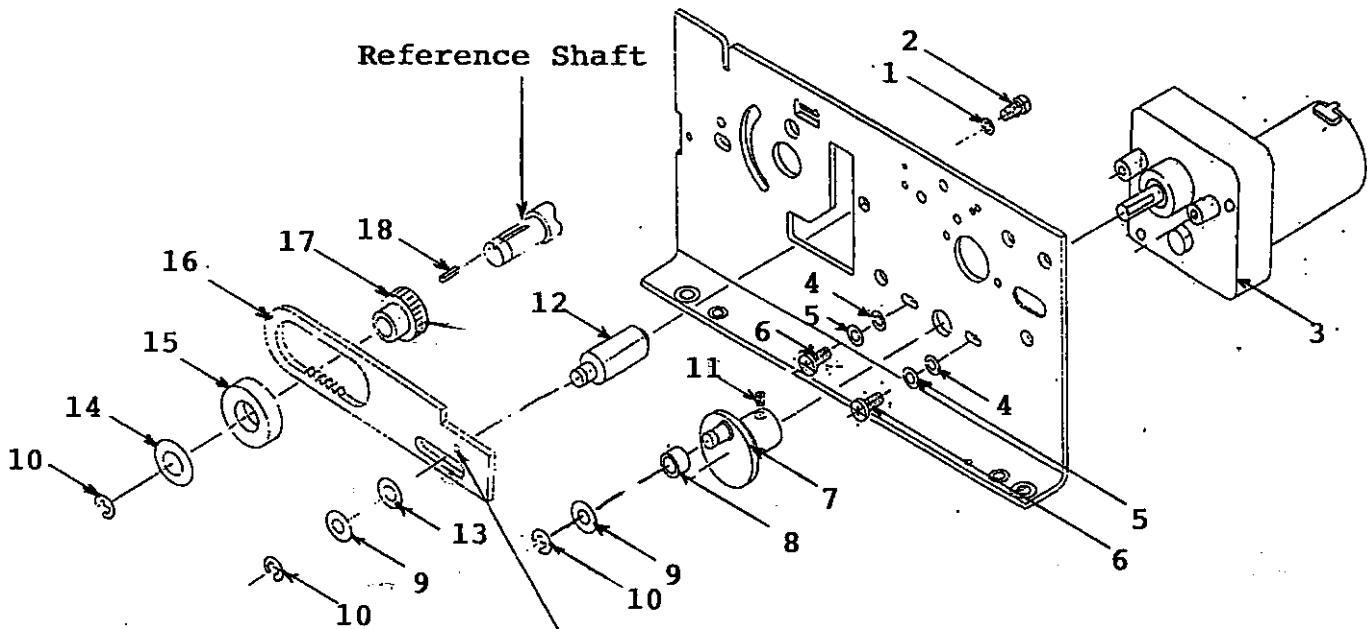
8.0 PARTS LIST

Figure 8-10

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	Not Used		
2	Not Used		
3	9779146	10/32 X 1/2 Flat Head Cap Screw	2
4	9781090	Inner Spacer	1
5	9778450	Left Drive Link	1
6	9778198	Hub	1
7	9781540	Left Pressure Bar Link Assembly	1
8	9779251	Spacer	1
9	9776609	Bearing	1
10	9779069	Retaining Ring	3
11	9779936	Shim Washer	2
12	9779932	Plastic Washer	2
13	9779351	Pivot Stud	2
14	9777608	10/32 X 5/8 Socket Hd Shoulder Screw	1
15	9781134	Retaining Ring	1
16	9781123	Crank Link Washer	1
17	9781080	Left Hand Link	1
18	9781122	Bearing	1
19	9778766	Teflon Washer	4
20	9781050	Bind Link	1
21	9781081	Punch Link	1
22	9781095	Drive Eccentric	1
23	9781083	Pivot Stud	1
24	9778584	10/32 Hex Nut	1

8.0 PARTS LIST

Figure 8-11



Timing Mark - set at 1:00 p.m.
with Pressure Bar up in home position.

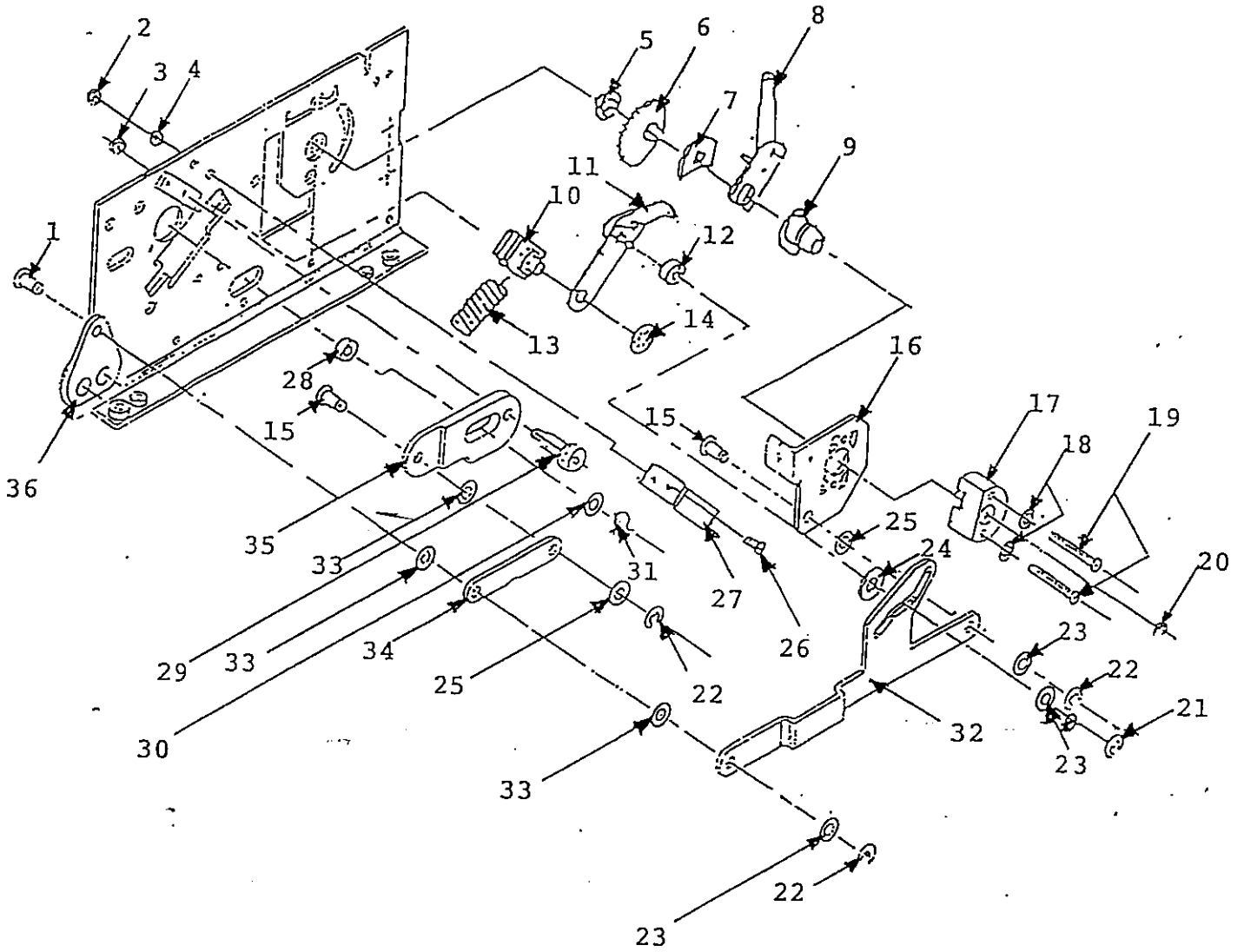
8.0 PARTS LIST

Figure 8-11

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9779912	#10 Split Lock Washer	1
2	9779109	10/32 X 1/2 Socket Head Screw	1
3	9781137	D.C. Pressure Bar Return Motor	1
4	9779898	#8 Flat Washer	2
5	9779911	#8 Split Lock Washer	2
6	9779222	8/32 X 1/2 Phillips Pan Head Screw	2
7	9781087	Crank Return	1
8	9781098	Crank Return Bearing	1
9	9779936	Shim Washer	2
10	9779069	Retaining Ring	3
11	9779191	10/32 X 1/8 Socket Set Screw	1
12	9781094	Pressure Bar Return Rivet	1
13	9778766	Teflon Washer	1
14	9781099	Gear Holder Washer	1
15	9781086	Outer Spacer	1
16	9781088	Rack Return	1
17	9781097	Gear Return	1
18	9781089	Key Stock	1

8.0 PARTS LIST

Figure 8-12



8.0 PARTS LIST

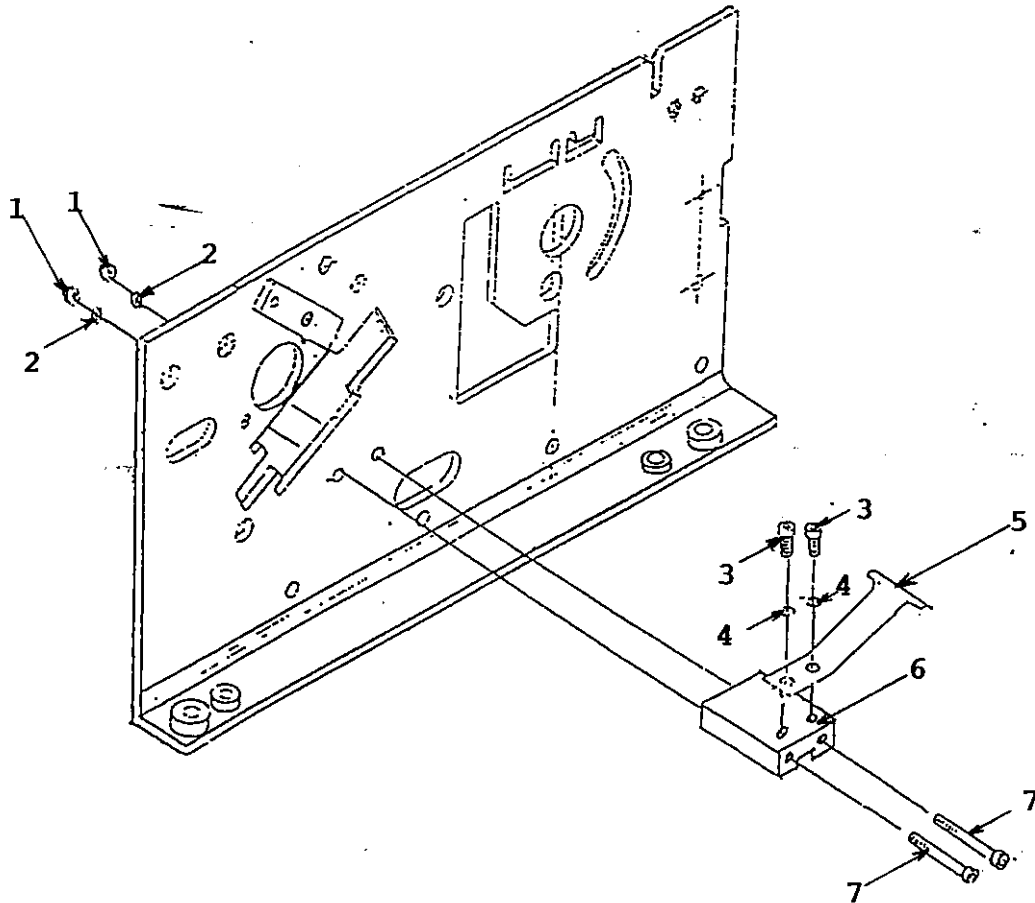
Figure 8-12

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9781083	Pivot Stud	1
2	9778589	8/32 Hex Nut	1
3	9778584	10/32 Hex Nut	1
4	9779926	#8 External Lock Washer	1
5	9776609	Bearing	1
6	9779086	10 Tooth Ratchet	1
7	9781119	Pawl Guide	1
8	9781539	Right Pressure Bar Link Assembly	1
9	9778198	Hub	1
10	9776665	Pillow Block	1
11	9779984	Pawl Assembly	1
12	9779084	Roller	1
13	9779270	Compression Spring	1
14	9778606	5/16 Speed Nut	1
15	9779351	Pivot Stud	2
16	9778449	Right Hand Drive Link	1
17	9781062	Coupling Replace	1
18	9779923	#10 Internal Lock Washer	1
19	9781132	10/32 X 1 Phillips Pan Head Screw	2
20	9779076	Crescent Ring	1
21	9779068	Retaining Ring	1
22	9779069	Retaining Ring	3
23	9779936	Shim Washer	4
24	9781156	.263 ID, .800 OD Flat Washer	1
25	9779932	Plastic Washer	2
26	9779173	6/32 X 1/2 Phillips Pan Hd Screw	1
27	9776667	Link Brace	1
28	9781122	Bearing	1
29	9777608	10/32 X 5/8 Socket Hd Shoulder Screw	1
30	9781123	Crank Link Washer	1
31	9781134	Retaining Ring	1
32	9781049	Actuator	1
33	9778766	Teflon Washer	3
34	9781081	Punch Link	1
35	9781100	Right Hand Link	1
36	9781095	Drive Eccentric	1

8.0 PARTS LIST

Figure 8-13

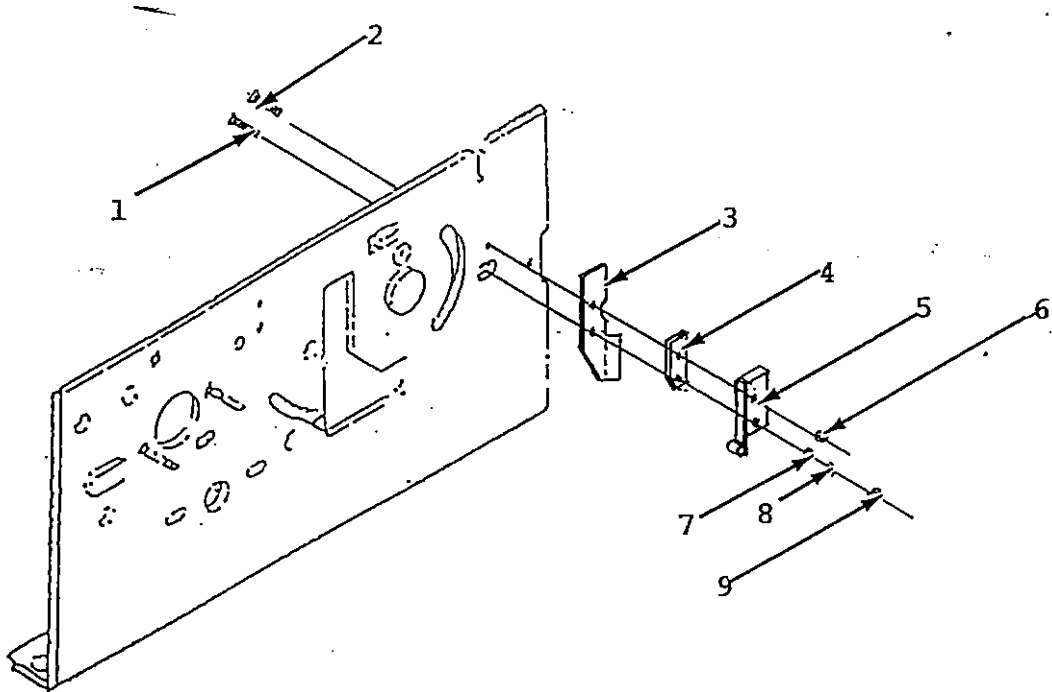
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9778588	6/32 Hex Nut	2
2	9779910	#6 Split Lock Washer	2
3	9779118	4/40 X 3/8 Socket Head Screw	2
4	9779909	#4 Split Lock Washer	2
5	9781163	Support Spring	1
6	9781120	Spring Holder	1
7	9781133	6/32 X 1-1/4 Socket Hd Cap Screw	2



8.0 PARTS LIST

Figure 8-14

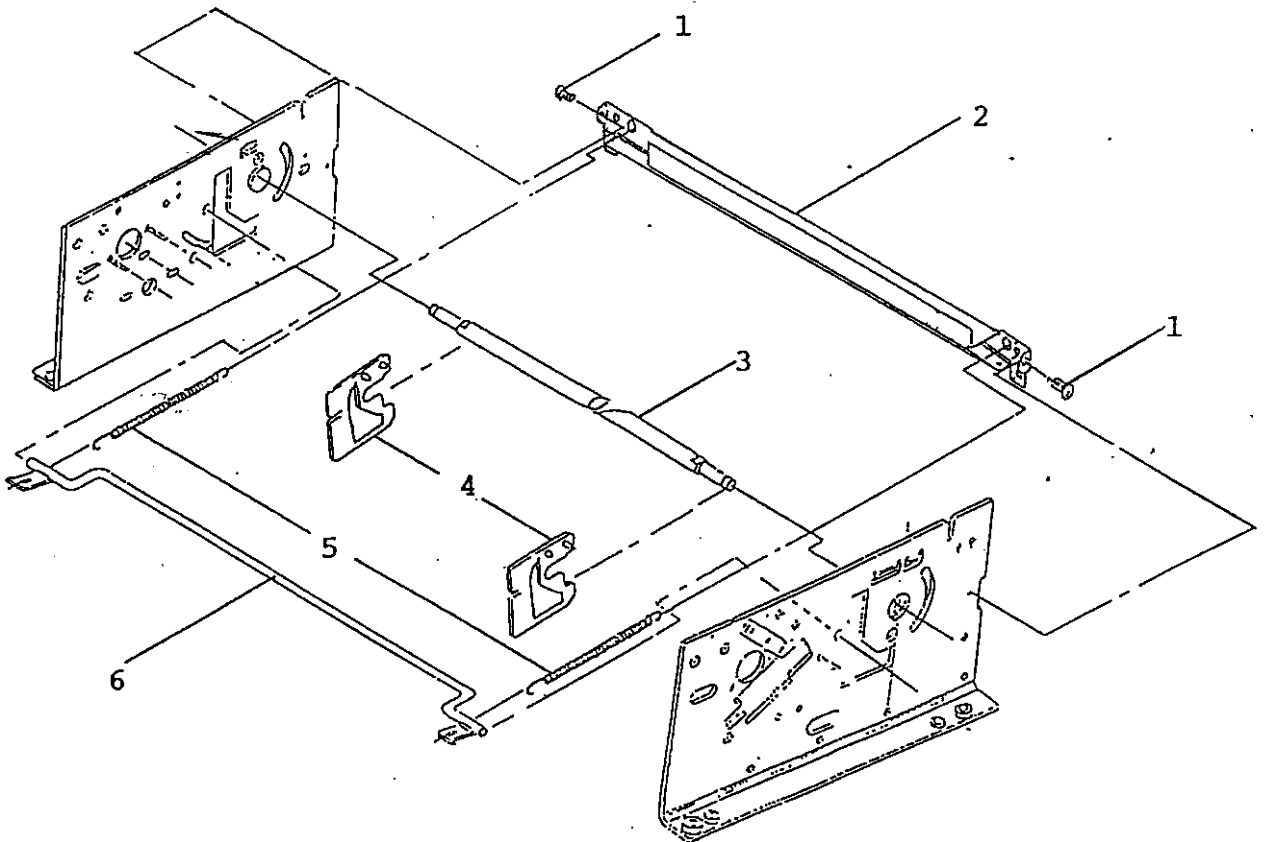
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9779162	2/56 X 5/8 Round Head Screw	1
2	9779181	2/56 X 5/8 Flat Head Screw	1
3	9781138	S3 Switch Bracket	1
4	9778292	Insulator	1
5	9781085	S3 Snap Action Switch	1
6	9778594	2/56 Self-Lock Nut	1
7	9779917	#2 Flat Washer	1
8	9779920	#2 Internal Lock Washer	1
9	9778586	2/56 Hex Nut	1



8.0 PARTS LIST

Figure 8-15

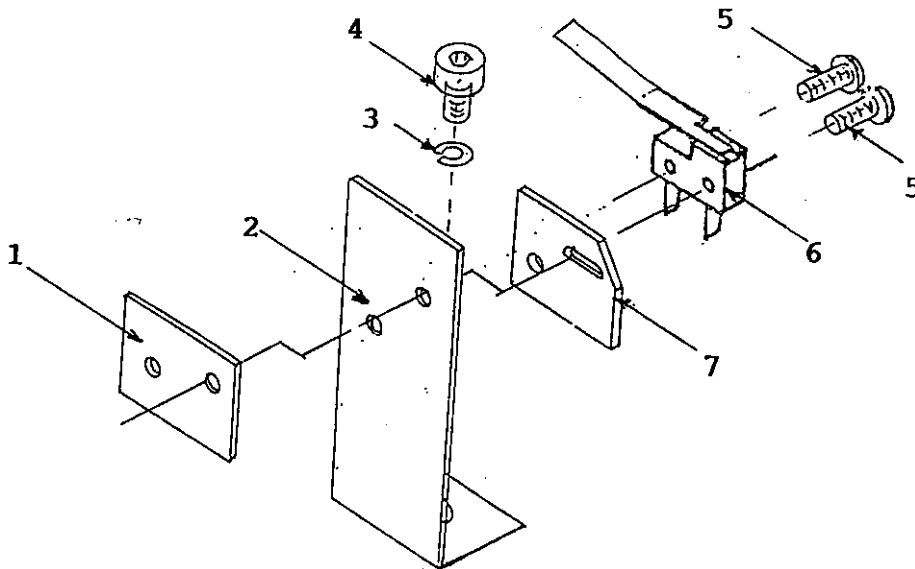
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9781552 9781552	6/32 X 1/4 Hex Socket Flat Hd Screw	2
2	9781061	Brace	1
3	9779233	Shaft	1
4	9778732	Drive Plate 9781059	2
5	9781158	Drive Spring	2
6	9781060	Timing Shaft Assembly	1



8.0 PARTS LIST

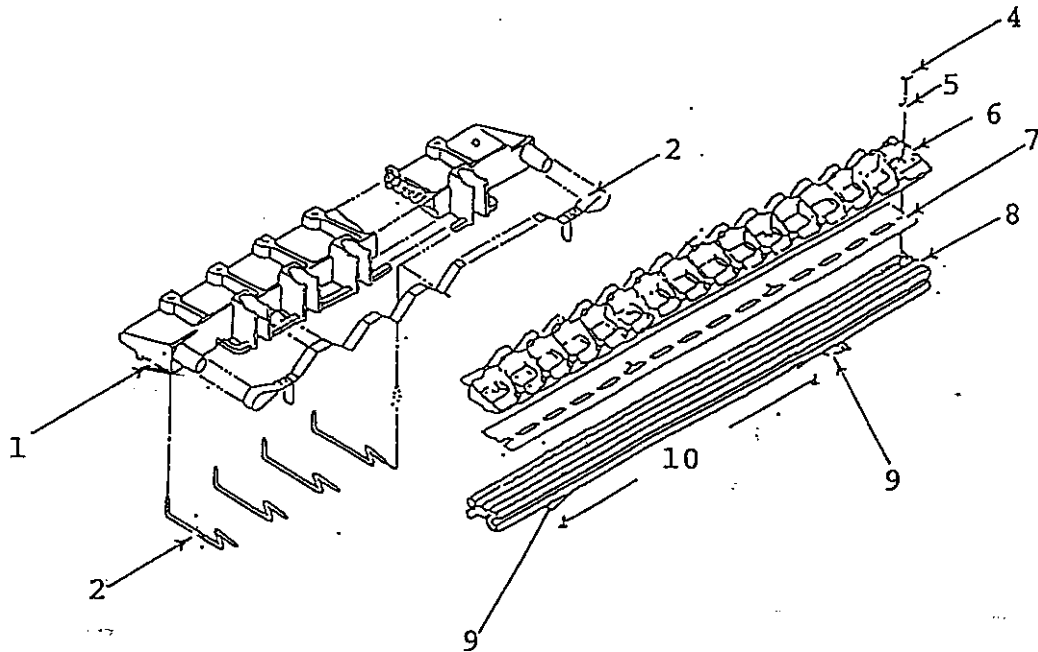
Figure 8-16

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9778618	2/56 Nut Plate	1
2	9781139	Pressure Bar Return Bracket	1
3	9779911	#8 Split Lock Washer	1
4	9779127	8/32 X 1/4 Socket Head Screw	1
5	9779162	2/56 x 5/8 Round Head Screw	2
6	9781131	S8 Switch	1
7	9778292	Insulator	1

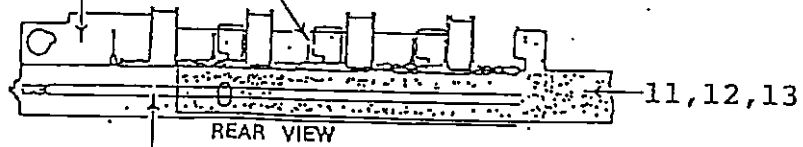


8.0 PARTS LIST

Figure 8-17



Heater Support Spring



Arrester Screws inserted into groove in Support Bar

8.0 PARTS LIST

Figure 8-17

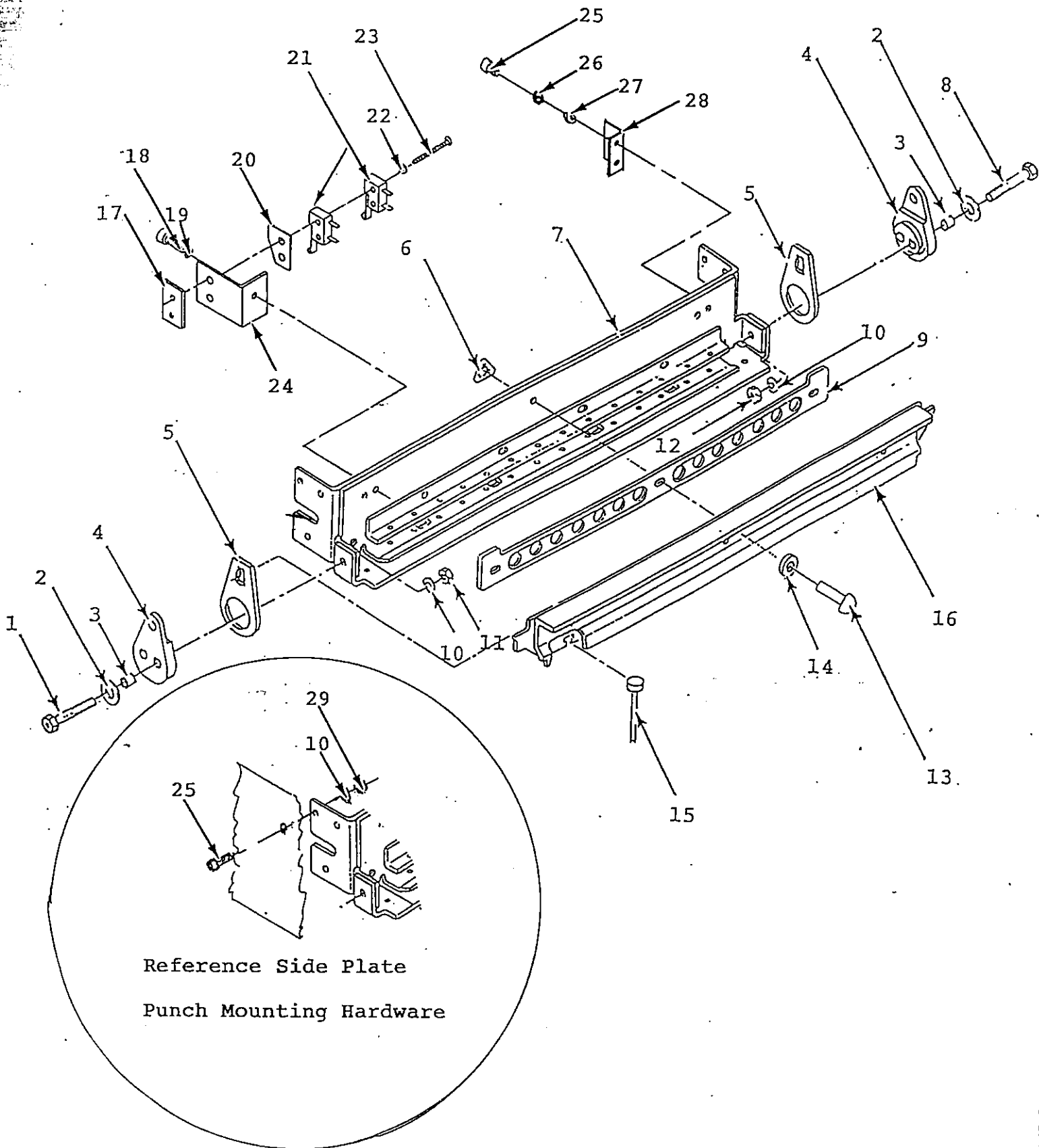
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9779293	Blade Support	1
	9777029	Blade Support - SureBind	1
2	9779268	Tensioner Springs	15
3	9781638	Strip Blade Assembly	1
	9781639	Strip Blade Assembly - SureBind	1
4	9779213	4/24 X 1/2 Self-Tapping Screw	4
5	9779896	#4 Flat Washer	4
6*	9776336	Heater Retrofit Kit	1
7	9778291	Insulator	1
	9781572	Insulator - SureBind	1
8	9776664	Support Bar	1
9	9781163	Support Spring	2
10	9781172	4/40 X 1/4 Thread Cutting Screw	4
11	9776951	13 Inch Travel Arrestor	1
	9776952	2 Inch Travel Arrestor	1
	9781152	Travel Arrestor - SureBind	1
	9781153	Travel Arrestor - SureBind	1
12	9779218	6/32 X 1/4 Self Tapping Screw	2
13	9779897	#6 Flat Washer	2

*Note: Heater Retrofit Kits (P/N 9776336 & 9781041 for SureBind) come assembled with items 1, 2, and 3, and is ready to install.

9777022
SB heater
assy

8.0 PARTS LIST

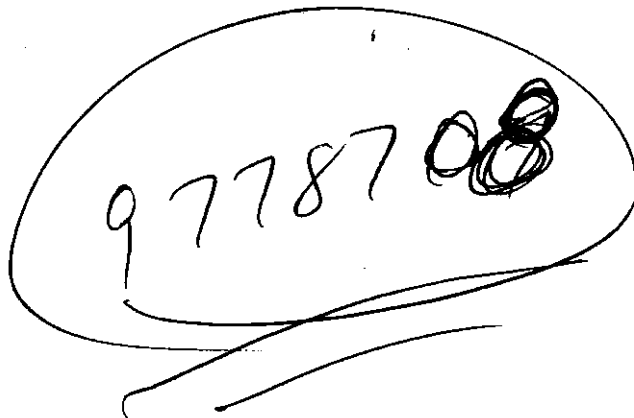
Figure 8-18



8.0 PARTS LIST

Figure 8-18

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9776507	1/4-28 x 1-1/8 Left Thread Screw	1
2	9779915	1/4 Flat Washer	2
3	9779257	Spacer	2
4	9781095	Drive Eccentric	2
5	9778446	Punch Link	2
6	9779078	Retaining Clip	6
7	9778194	Punch Housing	1
	9777425	Punch Housing - SureBind	1
8	9779116	1/4-28 X 1-1/8 Right Thread Screw	1
9	9779250	Punch Spacer	1
10	9779913	1/4-28 Lock Washer	8
11	9776507	1/4-28 Left Thread Nut	1
12	9778585	1/4-28 Right Thread Nut	1
13	9779063	Punch Retaining Pin	3
14	9779933	Spacer	3
15	9778684	Punch Pin	14
16	9776365	Punch Actuator	1
	9781390	Punch Actuator - SureBind	1
17	9778618	Switch Nut Plate	1
18	9779122	6/32 X 1/4 Hex Socket Screw	1
19	9779910	#6 Split Lock Washer	1
20	9778287	Switch Insulator	1
21	9781142	Switch (S5-left/S4-right)	2
22	9779920	#2 Internal Tooth Lock Washer	2
23	9779163	2/56 X 3/4 Round Head Screw	2
24	9781136	Switch Bracket	1
25	9779140	1/4-20 X 1/2 Hex Socket Screw	8
26	9779913	1/4 Split Lock Washer	2
27	9781553	1/4 Internal Tooth Lock Washer	2
28	9781078	Motor Mount	1
29	9778591	1/4-20 Hex Nut	6



 97787008

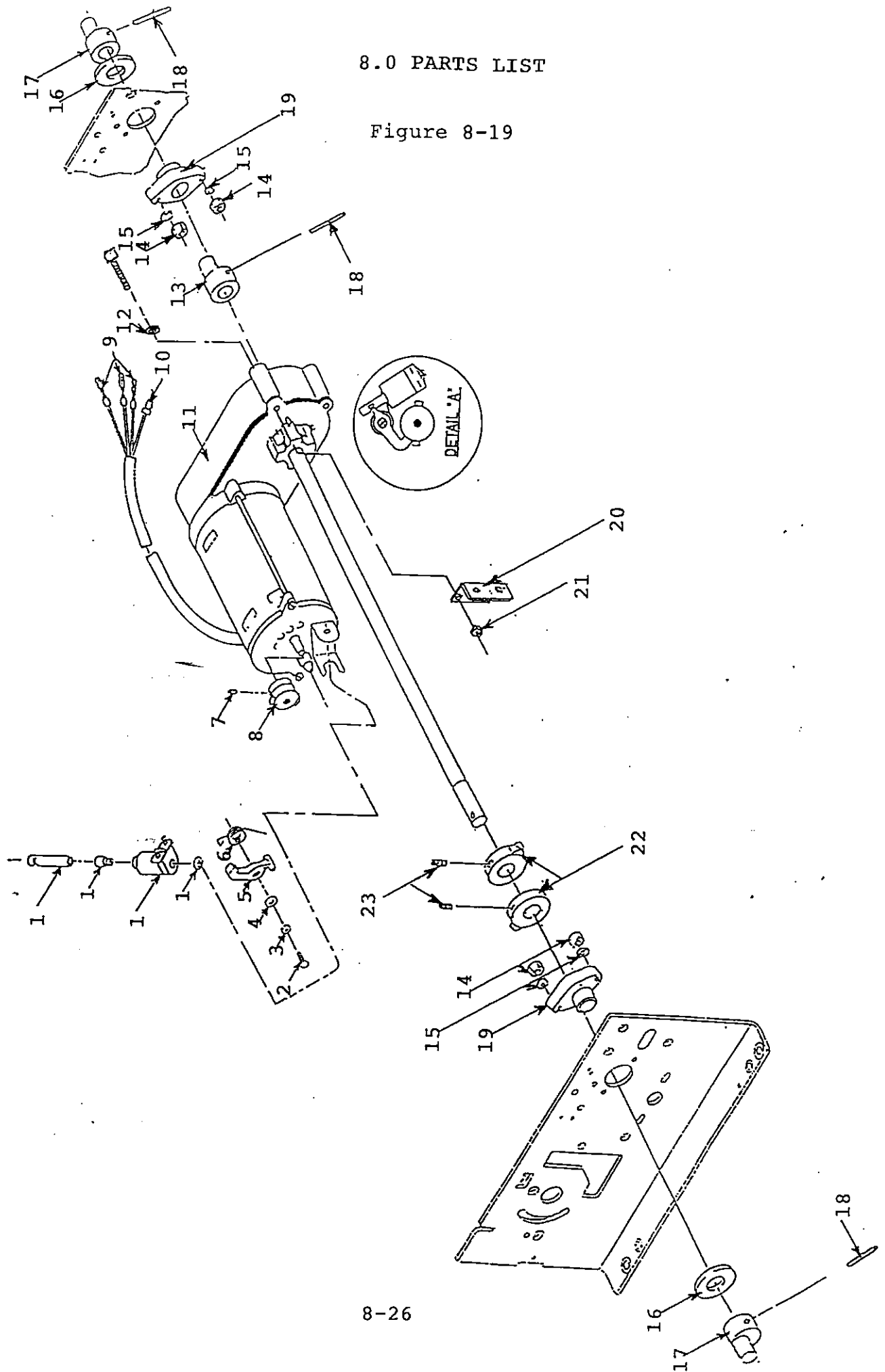
REPLACING PUNCH MOTOR CAMS

1. REMOVE E-RING FROM LINK TO PUNCH ECCENTRIC AND MOVE LINK OUT OF WAY.
2. LOOSEN LINK OFF ECCENTRIC.
3. REMOVE SHOULDER SCREW TO LOCK NUT.
4. CLEAN OFF SHOULDER SCREW THREADS AND RELOCTITE (WIRE BRUSH WORKS REAL GOOD).
5. PUT WASHER (9781563) BACK ON SHOULDER SCREW.
6. REMOVE RETAINING RING AND FLAT WASHER FROM CRANK SHAFT.
7. REMOVE CRANKSHAFT.
8. CHECK TRAVEL BUSHING.
9. KNOCK OUT PUNCH ~~CRANK~~ ROLL PIN (3/16" PUNCH).
10. BEHIND CRANK IS SHIM WASHER.
11. LOOSEN CAM SET SCREWS WITH 1/16" ALLEN WRENCH AND MOVE CAMS OVER OUT OF WAY.
12. REMOVE TDC BRACKET SCREW AND MOVE OUT OF WAY.
13. REMOVE NUTS FROM PLASTIC BEARING.
14. REMOVE ROLL PIN FROM RIGHT SIDE OF CRANK NEAREST MOTOR.
15. REMOVE MOTOR MOUNT SCREWS.
16. PULL MOTOR LOOSE AND UP - LEAVE PCB IN.
17. INSTALL 4 NEW CAMS AND MOVE 2 EXTRAS TO RIGHT OUT OF WAY.
18. GLUE NUB ON CAM AND ALONG CAM AND PUSH TOGETHER MOVING TO BE SURE LOCTITE DOESN'T STICK TO SHAFT.
19. SLIDE CAMS UP AND DON'T SET. PLACE MOTOR BACK INTO POSITION.
20. TAKE PUNCH AND PUSH THROUGH HOLE IN CRANK AND MOTOR SHAFT TO ALIGN, AND REINSTALL ROLL PIN.
21. REINSTALL MOTOR MOUNT BOLTS (HAS STAR AND LOCKWASHER) REAL TIGHT.
22. REINSTALL PLASTIC BEARING LEFT HAND SIDE, AND LEAVE LOOSE.
23. ALIGN CRANK AND SHIM WASHER WITH RIGHT HAND SIDE AND REINSTALL ROLL PIN. PRESS ROLL PIN BELOW EDGE OF CRANK.
24. REINSTALL DRIVE LINKAGE ON CRANK AND REINSTALL SHOULDER SCREW.

25. REINSTALL BUSHING, AND REINSTALL LOCK NUTS AND FLAT WASHERS ON BEARING.
26. REINSTALL WASHER AND RETAINING RING ON DRIVE LINKAGE.
27. REINSTALL OTHER LINKAGE.
28. REINSTALL TDC BRACKET (PUNCH ALL THE WAY UP AND DRIVE LINKS UP).
29. SLIDE CAMS OVER - MAKE SURE TDC SWITCH IS ACTUATED WITH RIGHT HAND CAM.
30. PLUG IN MACHINE AND CYCLE PUNCH TO CHECK SETTINGS OF CAMS. RESET CAMS AS NECESSARY (GO BY DRIVE LINKS BEING ALL THE WAY TO TOP OF SIDE PLATE SLOTS).

8.0 PARTS LIST

Figure 8-19



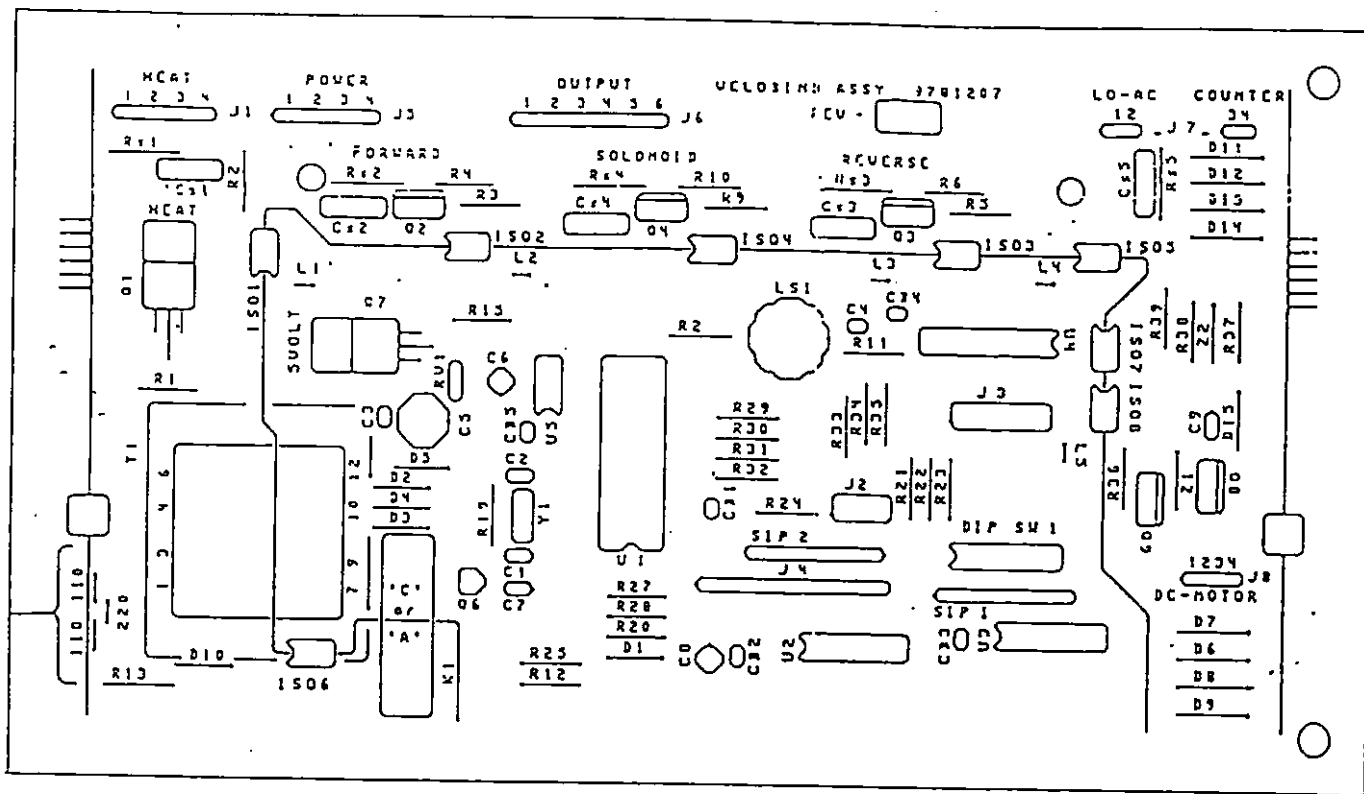
8.0 PARTS LIST

Figure 8-19

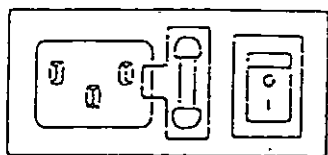
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	9776316	115 VAC Solenoid Kit	1
	9776317	230 VAC Solenoid Kit	1
2	9776313	6/32 X 1/4 Screw	1
3	9776312	#6 Lock Washer	1
4	9776311	#6 Flat Washer	1
5	9776310	Lever Arm	1
6	9776309	Spring	1
7	9776314	Hub Set Screw	1
8	9776308	Brake Hub	1
9	9779383	Bullet Terminal Lug	3
10	9776789	Cap Splice Connector	1
11	9781077	115 Volt Punch Motor	1
	9781351	240 Volt Punch Motor	1
12	9779918	#10 Flat Washer	2
13	9781079	Punch Motor Coupling	1
14	9778596	8/32 Lock Nut	4
15	9779898	#8 Flat Washer	4
16	9781247	.861 X .010 Spacer	2
17	9781082	Punch Drive Crank	2
18	9781450	3/16 X 7/8 Roll Pin	3
19	9776608	Bearing	2
20	9781078	Motor Mount (Reference)	1
21	9778592	10/32 Lock Nut	2
22	9776851	Punch Cam <i>9781677</i>	2
23	9779192	6/32 X 1/8 Socket Set Screw	2

8.0 PARTS LIST

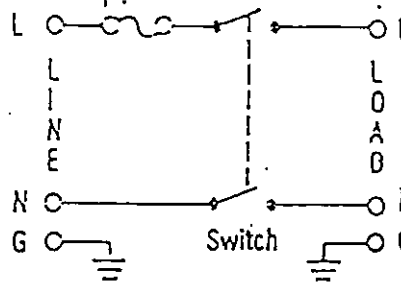
Figure 8-20



- P/N 9781207 - P.C. Board Assembly - 1 Per
- P/N 9781200 - P.C. Board Assembly - 1 Per - 100 Volt
- P/N 9781185 - 5 X 20 mm. Fuse - 1 Per

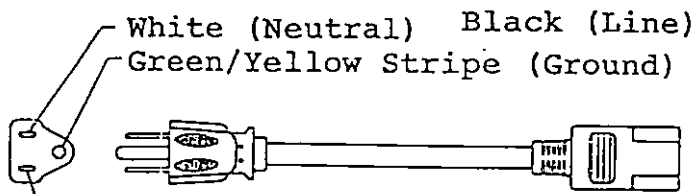


P/N 9781130 - Power Inlet Connector
(1 Per)

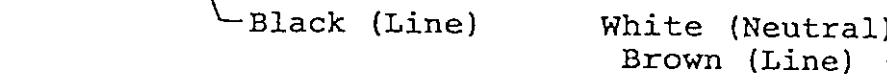


*9781357 - Protector
1 per
9781360 - Spacers
Insulation
2 per*

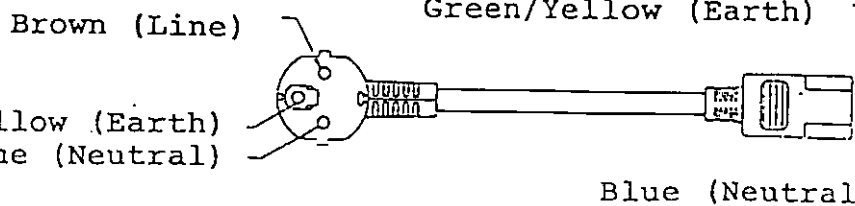
100 Volt Power Cord - P/N 9781564



P/N 9781344
115 VAC Cordset
(1 Per)



P/N 9781345
Power Cord
Continental Euro
(1 Per)



Green/Yellow (Earth)
Blue (Neutral)

9.0 RECOMMENDED SPARE PARTS LIST

Note: This is a list of high usage parts only. Less frequently used and incidental parts should be determined and stocked at your discretion.

PART NUMBER	DESCRIPTION	QUANTITY
9776336	Heater Retrofit Kit	2
9781041	Heater Retrofit Kit - SureBind	2
9781638	Strip Blade Assembly	10
9781639	Strip Blade Assembly - SureBind	10
9778732	Drive Plate	2
9779984	Pawl Assembly	2
9781085	S-3 Snap Action Switch	2
9781122	Bearing	4
9781142	S-4/S-5 Snap Action Switch	2
9781131	S-8 Snap Action Switch	4
9781149	Punch Edge Guide Switch (S6)	2
9780089	Pressure Bar Switch Assembly	5

10.0 ADDITIONAL INFORMATION

This section contains information released after the manual was published. All information pertinent to these units should be inserted in this section whether it is published in an N.S.B. or a Circuit Breaker.

10.0 ADDITIONAL INFORMATION

10.1 COUNTER KITS

COUNTER KITS ARE AVAILABLE FOR INSTALLATION IN CUSTOMER MACHINES. THE PART NUMBER FOR THE COUNTER KITS IS 9781687, AND THEY COME WITH INSTRUCTIONS - P/N 9781426.

10.0 ADDITIONAL INFORMATION

10.2 PROBLEMS AND SOLUTIONS

ERRATIC BIND/UNEVEN HEAT - TRANSFORMER WIRES COULD HAVE LOOSE CONNECTIONS - ONLY 6 VOLTS COMING OUT OF SECONDARY - MAY NOT BE GETTING PROPER VOLTAGE.

TRAY LIGHT STAYS ON - CHECK SWITCH.

BROKEN SHAFTS WHERE KNOBS ATTACH - SHAFTS BEING MADE STRONGER.

INTERMITTENT BIND PROBLEMS - S-3 SWITCH STICKING - SWITCH BRACKET HAS BEEN MODIFIED TO PREVENT STICKING - S-3 BENT.

PLASTIC STICKING TO BLADES - BLACK BLADES SHOULD PREVENT THIS PROBLEM.

PRESSURE BAR NOT RETURNING - ADD STAR WASHERS TO PRESSURE BAR MOTOR MOUNTING SCREWS - IF MOTOR TOO FAR FORWARD, WILL NOT RETURN ALL THE WAY - TOO FAR BACK, WILL STICK UP. CHECK FOR 15-18 VAC OUT OF BLACK TRANSFORMER TO PCB - J8 - TO PRESSURE BAR RETURN MOTOR - CHECK CRIMPS - BLACK BRACE IN REAR COULD BE BENT TOO MUCH - SET SCREW ON CRANK RETURN BACKS OUT - GEAR RETURN WEARS OUT - RACEWAY COVER NOT LONG ENOUGH (STATIC) - INSTALL PLASTIC RACEWAY COVER.

BAD CRIMPS CAN CAUSE PRESSURE BAR TO GO UP AND DOWN OR NOT RETURN - CHECK BOTH DOUBLE GREEN AND BLACKS TO PRESSURE BAR RETURN SWITCH.

PUNCH ONCE IN MANUAL AND LOCK-UP UNIT - CAUSED BY STATIC - ALL GROUND KITS SHOULD BE INSTALLED BY NOW ON ALL MACHINES - CHECK CONNECTIONS ON PHONE JACK - U2 ON PCB PROBABLY BLOWN. RACEWAY COVER NOT LONG ENOUGH - STATIC ENTERING MACHINE - INSTALL PLASTIC RACEWAY COVER.

PINS LEFT HANGING ON STRIP AFTER BIND CYCLE - GENERALLY CAUSED BY COMBINATION OF BLADE AND TURRET - CHANGING BLADE MIGHT HELP OR MAY HAVE TO RETURN TO SPARKS.

P.C. BOARD SHORTED - CAUSED BY Q8 HITTING Q9 - PUT R.T.V. ON METAL OF Q8 TO PREVENT CONTACTING Q9.

ALL LIGHTS COME ON - CANNOT CHANGE MODES - CAUSED BY STATIC - P.C. BOARD BEING GROUNDED ALSO.

LIGHTS FLASH BETWEEN BIND AND DEBIND - CAUSED BY TRANSFORMER WIRE ARCING TO S3 SIMULATING S3 ACTUATING. MISSED LOCATING PIN ALSO - MACHINE TOO HOT - S3 NOT ACTUATING.

DEBIND NO MORE THAN 2-3 PER MINUTE - MORE CAN BURN TRANSFORMER.

10.0 ADDITIONAL INFORMATION

10.2 PROBLEMS AND SOLUTIONS

WHEN YOU MUST REINSTALL THE TURRET, PLACE THE TURRET FLAT ON THE CHASSIS, AND TIGHTEN DOWN THE SCREWS. DO NOT PUSH DOWN ON THE TURRET ASSEMBLY WHEN TIGHTENING.

IN FOOT PEDAL MODE, IF A CUSTOMER MISSES THE LOCATING PIN WHEN BINDING, THE BIND/DEBIND LIGHTS WILL FLASH BACK AND FORTH, AND THE FOOT PEDAL/PUNCH LIGHTS WILL BE LIT AT THE SAME TIME. TO CLEAR, PRESS THE PUNCH SELECT BUTTON TWICE, OR TURN THE MACHINE OFF AND BACK ON.

PUNCH MOTOR HUMS WHEN ACTIVATED - CHECK WIRE CONNECTIONS ON THE MOTOR START CAPACITOR.

CONTINUOUS BIND - SWITCHES LOOSEN UP.

LIPS ON RIVETS - CENTERING TURRET ON BLADE WILL SOMETIMES PREVENT.

THE FOLLOWING LEDS WILL HELP DETERMINE IF THE PROBLEM IS PCB OR EXTERIOR COMPONENT RELATED - IF ON DURING SEQUENCE OF OPERATION, CHECK EXTERIOR COMPONENTS:

L-1 - HEAT LIGHT - WHEN DRIVE PLATE CONTACTS S3, L-1 SHOULD GO OUT. PROBLEM WITH TRANSFORMER IF NOT.

L-2 - PUNCH LED - PROBLEM WITH PUNCHING - LOOK AT PUNCH MOTOR.

L-3 - MOTOR REVERSE LED - LIGHTS IN JAM SITUATION - PUNCH MOTOR REVERSES.

L-4 - BIND/POWER ON LED - LIGHTS WHEN PRESSURE BAR SWITCH ACTIVATED.

L-5 - PRESSURE BAR RETURN MOTOR LED - NOT ON - MOTOR BAD.