

Saddle Stitcher Problem Solving Tips-n-Hints

Problem	What to look for...	What should you do...
Stitcher does not run	<ul style="list-style-type: none"> a. RESET indicator off. b. RESET indicator on. 	<ul style="list-style-type: none"> a. Make sure that I/O selector is switched to I (on) and that the key operated switch is ON. If these conditions exist, make sure motor starter is reset; press overload button to be sure. If stitcher is still OFF, check input power from machine's (I/O) isolator switch. If you have power at this point, make sure circuit breakers are not tripped. b. Release EMERGENCY STOP then press RESET control, indicator should turn off.
Stitcher heads driven each cycle	<ul style="list-style-type: none"> a. Clutch switched OFF. b. LS7 not actuated or is defective. c. Photo detector defective. d. Head clutch defective, or misadjusted. e. Defective solenoid in head clutch assembly. 	<ul style="list-style-type: none"> a. Switch clutch ON/OFF selector to ON. b. Make sure LS7 is being actuated, if actuated, check for ON/OFF switch action in each cycle. Also, verify that wiring from LS7 to head clutch is good. c. Make sure reflective tape is located on stitcher saddle. With LS7 closed and CLUTCH ON, wave hand to break beam from photo detector to stitcher saddle. Solenoid in head clutch should be turning on & off. d. Verify operation of head clutch. e. Verify solenoid is operating as indicated in step c.
Stitcher heads drive remains off, CLUTCH ON	<ul style="list-style-type: none"> a. Repeat checks/condition checks given in previous problem. 	<ul style="list-style-type: none"> a. Repeat actions described in b.,c.,d., and e., of previous problem.
Stitcher heads are down too far	<ul style="list-style-type: none"> a. Brake drag too low. b. Phase reversal at input to drive motor running backwards. 	<ul style="list-style-type: none"> a. Check brake drag without booklets. Cycle clutch, if it stops momentarily at normal height and then goes down further adjust brake shoe drag. b. Problem should only occur after wiring changes in three-phase input line to stitcher. Reverse any two, three phase leads to drive motor.
Booklet does not head properly	<ul style="list-style-type: none"> a. Signatures not even. b. Centering back stop (s) incorrectly set. c. Obstruction in path of booklet. 	<ul style="list-style-type: none"> a. Jog signatures in booklet to head before feeding. b. Adjust backstops. c. Check that movement path for booklets along saddle ridge are clear of obstruction. Also, make sure backstops move freely, center on saddle ridge as needed.
Booklet (s) not advanced on saddle, stitches out of position	<ul style="list-style-type: none"> a. Slide and/or centering backstops incorrectly set for size of booklet. b. Shear pin sheared. c. When Stagger Stitching, stagger adjustment incorrect. 	<ul style="list-style-type: none"> a. Adjust feed finger slide and centering backstops. b. Replace shear bolt securing power and actuating arms. c. See Stagger Stitch Setup Sheet for adjustments.
Staples not located on center of crown	<ul style="list-style-type: none"> a. Pamphlet hold-downs incorrectly adjusted. b. Centering guides and/or centering supports incorrectly adjusted. c. Brushes incorrectly adjusted. 	<ul style="list-style-type: none"> a. Readjust pamphlet hold-downs. b. Readjust centering guides and/or centering supports. c. Readjust brushes.
Unable to make a tight stitch	<ul style="list-style-type: none"> a. Head drive casting set too high for booklet thickness. b. Clincher points not driven up high enough. c. Head casting drive stroke too short. 	<ul style="list-style-type: none"> a. Readjust head drive casting for booklet thickness. b. Adjust clincher points. c. Only consider this adjustment after replacing reducer and/or head clutch. Adjust head pull rod.

Stapes not formed correctly	<ul style="list-style-type: none"> a. Clincher height incorrect. b. Clincher pints worn or broken. c. Wire jammed in clinchers. 	<ul style="list-style-type: none"> a. Adjust clincher pints. b. Replace points. c. Remove wire; examine clincher points for signs of damage. Replace if damaged.
Stitcher heads do not feed wire	<ul style="list-style-type: none"> a. Grippers in head not closing during upstroke. b. Defective head assembly. 	<ul style="list-style-type: none"> a. Face plate too high. b. Service as indicated in manufacturer's manual. After replacing head adjust for book thickness.
Booklets fly hitting heads and/or ejector rolls	<ul style="list-style-type: none"> a. Centering supports and/or centering guides incorrectly adjusted. b. Spring tension too great on centering backstop. 	<ul style="list-style-type: none"> a. Readjust guides and/or supports. b. Readjust spring tension on centering backstop.
Booklet delivery poor, skewed and/or uneven	<ul style="list-style-type: none"> a. Delivery stop not set for booklet length. b. Tucker fingers lift height too low. c. Ejector rolls misadjusted. d. Booklets hitting ejector rolls. e. Deflector roll arm assembly misadjusted. 	<ul style="list-style-type: none"> a. Readjust delivery stop. b. Readjust lift height c. Readjust ejector rolls d. Readjust centering guides and/or centering supports e. Readjust roll arm & deflector wheels.
Booklets not transported on delivery table	<ul style="list-style-type: none"> a. Tape drive not engaged. b. Loose tapes. c. Defective drive train. 	<ul style="list-style-type: none"> a. Push tape drive control-knob in until drive engages. b. Move extension of delivery table out to tighten tapes, keep both delivery rollers parallel to each other. c. Check delivery train.
Stitcher coasts before stopping or stops too early or late in cycle	<ul style="list-style-type: none"> a. Integral brake at drive motor is defective or worn. b. Early or late stop, stop cam for LS3 misadjusted. 	<ul style="list-style-type: none"> a. Readjust brake as indicated. Replace brake if lining is worn. b. Readjust cam that actuates LS3.