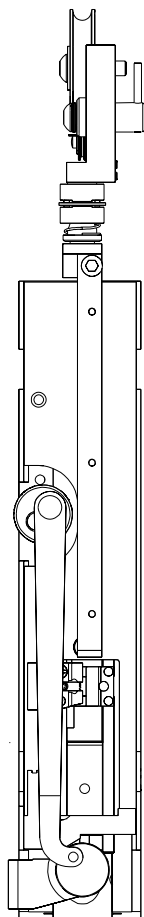


**ISP** Stitching & Bindery Products

OWNERS  
MANUAL

# *EZ Thread*

Model: CAAA2004W



Exclusive Patented  
Magnetic Technology

# EZ Thread

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## SAFETY

### SAFETY PRECAUTIONS AND PROCEDURES

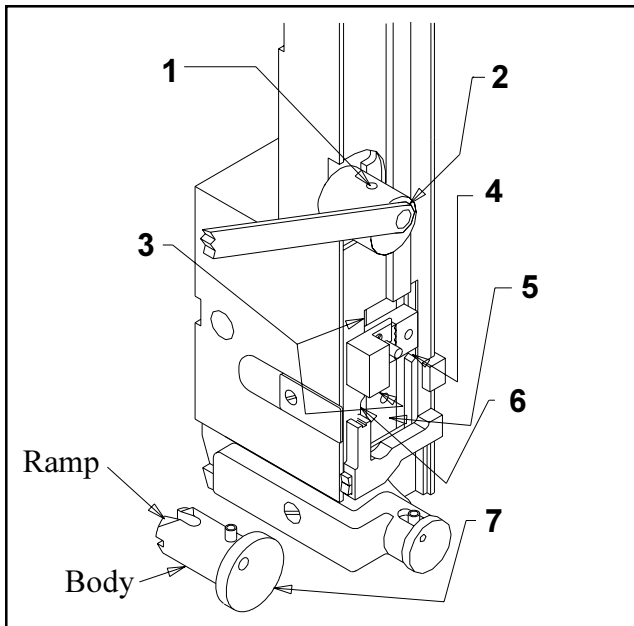
1. *Make sure electrical power is turned off before performing any adjustment or maintenance.*
2. *Keep hands, hair, tools, and clothing clear of stitching area.*
3. *Become familiar with the moving components of your machine. Keep fingers away from areas that could pinch or cut.*
4. *A well maintained 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!**

### CAUTION

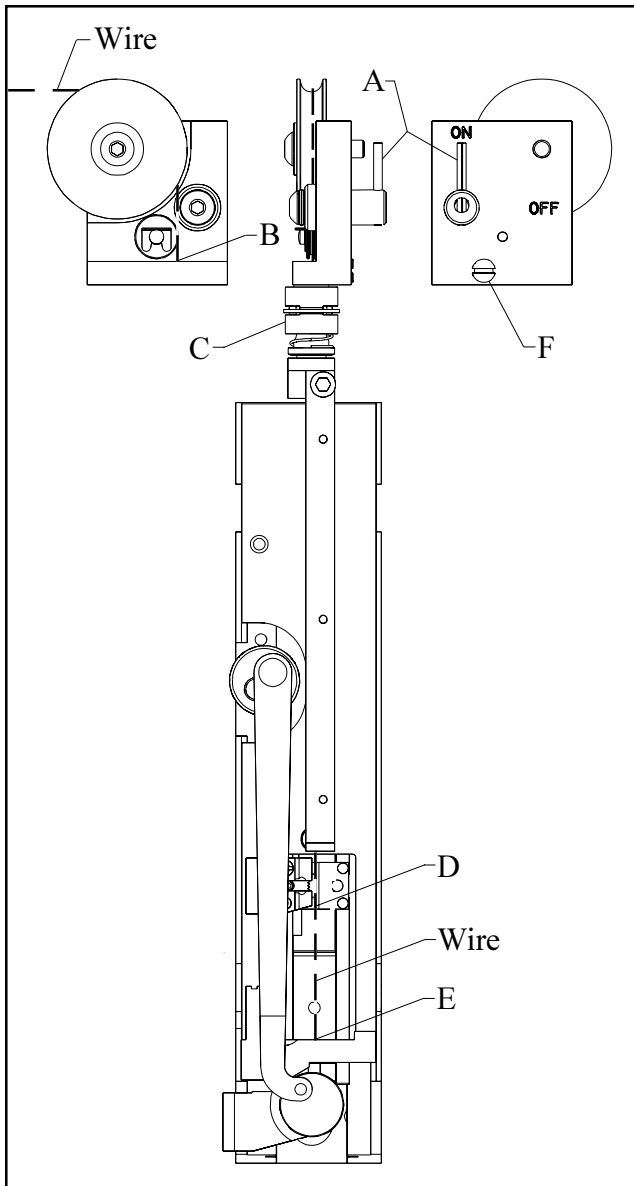
Be sure your stitcher or collator has adequate guards to keep fingers out of the *EZ Thread's* point of operation.



## LUBRICATION

Important! The stitching head must be lubricated before each spool of wire (50,000 to 70,000 stitches). Use ISP lubricant #CA9640.

1. Inject lube into hole, or remove and lube shaft.
2. Remove rotator spring and lube shaft.
3. Inject a small amount of lube on cam surface of driver bar above and below grip housing.
4. Wipe area clean, and inject a small amount of lube on grip release cam.
5. Wipe driver clean, and apply a layer of lube.
6. Inject lube into cutter operating slide.
7. Very important! Remove rotator and clean inside of rotator holder. Carefully clean the rotator and apply lube to its body and ramp.



## 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 aligned with the spool of wire.


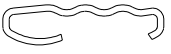
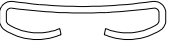


The head is now ready to operate. Please note that two cycles of the newly threaded head will be required before you get a proper stitch.

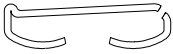



## TROUBLE SHOOTING



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
<p>3. One or both legs are buckled.</p>  <p>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 occurring.</p>  <p>4. Crown is wrinkled.</p>	<ol style="list-style-type: none"> <li>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.</li> <li>2. Clincher is worn. Replace clincher.</li> <li>3. Insufficient compression. Adjust clincher upward or set head actuating bar lower.</li> <li>4. Unequal leg length. Balance stitch legs per instructions on page 7.</li> <li>5. Wire is wrong size. Use only approved stitching wire: ISP part number 415-0225.</li> <li>6. Bender bar is worn. Replace bender bar, item 6 on page 9. (Or replace bender bar assembly, item 5 on page 9.)</li> </ol>
<p>5. Stitch crown is not flat.</p> 	<ol style="list-style-type: none"> <li>1. Insufficient compression. Adjust clincher upward or set head actuating bar lower.</li> </ol>
<p>6. Leg length varies.</p> 	<ol style="list-style-type: none"> <li>1. Unequal leg length. Balance stitch legs per instructions on page 7.</li> <li>2. Grip is worn or dirty. Clean or replace grip, item 16 on page 9.</li> <li>3. Grip spring is weak or broken. Replace grip spring, item 20 on page 9.</li> <li>4. Grip release slide is worn. Replace grip release slide, item 39 on page 9.</li> <li>5. Driver bar is worn. Replace driver bar, item 7 on page 9.</li> <li>6. Check pawl is worn or dirty. Clean check pawl assembly, item 5 on page 10. Replace worn check pins, item 9 on page 10, or replace entire check pawl assembly.</li> <li>7. Excessive tension on wire straightener. Turn roll pin, item 6 on page 11 toward the off mark.</li> </ol>
<p>7. One or both legs turn out.</p> 	<ol style="list-style-type: none"> <li>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.</li> <li>2. Wire cutters are dull. Replace wire cutters, item 38 on page 9.</li> </ol>

TROUBLE	POSSIBLE CAUSE & REMEDY
<p>8. Corner of crown is distorted or fractured.</p> 	<ol style="list-style-type: none"> <li>1. Driver end is broken. Replace driver end, item 8 on page 9.</li> <li>2. Bender bar is worn. Replace bender bar, item 6 on page 9. (Or replace bender bar assembly, item 5 on page 9.)</li> <li>3. Wire is wrong size or poor quality. Use only approved stitching wire: ISP part number 415-0225.</li> <li>4. 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.</li> <li>5. Clincher is worn. Replace clincher.</li> <li>6. Excessive compression. Adjust clincher downward or set head actuating bar higher.</li> </ol>
<p>9. Stitches come out in pieces.</p> 	<ol style="list-style-type: none"> <li>1. Improperly aligned rotator. Loosen screw, item 45 on page 8, and slide rotator holder, item 44, in or out until rotator is properly aligned with bender bar, item 5. The wire grooves in the bender bar must be directly above a straight piece of wire being held in the rotator.</li> <li>2. Rotator operating spring is weak. Replace rotator operating spring, item 43 on page 9.</li> <li>3. Wire is jammed in bender bar grooves. Remove pieces of wire stuck in the bender bar grooves or replace bender bar, item 5 on page 9.</li> <li>4. Wire is wrong size or poor quality. Use only approved stitching wire: ISP part number 415-0225.</li> </ol>
<p>10. Straight pieces of wire fall from the head.</p> 	<ol style="list-style-type: none"> <li>1. Rotator is dirty. Carefully remove, clean, and lubricate rotator. See lubrication instruction 7 and picture on page 3.</li> <li>2. Rotator is broken or worn. Replace rotator, item 46 on page 9.</li> <li>3. Improperly aligned rotator. Loosen screw, item 45 on page 8, and slide rotator holder, item 44, in or out until rotator is properly aligned with bender bar, item 5. The wire grooves in the bender bar must be directly above a straight piece of wire being held in the rotator.</li> </ol>
<p>11. One or both legs are bent towards the front or rear.</p>  <p>Top View</p>	<ol style="list-style-type: none"> <li>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 28 on page 8. Adjust the screws by an increment of less than a full turn. Install head and check results. Repeat process if necessary.</li> </ol>
<p>12. Wire buckles above the grip, item 16 on page 8 and below the feed tube, item 3 on page 10.</p>	<ol style="list-style-type: none"> <li>1. Driver bar is worn. Replace driver bar, item 7 on page 9.</li> <li>2. Latch assembly is worn. Replace latch assembly, item 9 on page 9.</li> <li>3. Friction plug is worn. Replace friction plug, item 10 on page 9.</li> <li>4. Friction plug spring is weak or broken. Replace spring, item 11 on page 9.</li> </ol>

# EZ Thread

TROUBLE	POSSIBLE CAUSE & REMEDY
13. Wire buckles below the grip, item 16 on page 8 and above the wire cutters, item 38 on page 8.	<ol style="list-style-type: none"><li>1. Improperly aligned rotator. Loosen screw, item 45 on page 8, and slide rotator holder, item 44, in or out until rotator is properly aligned with bender bar, item 5. The wire grooves in the bender bar must be directly above a straight piece of wire being held in the rotator.</li><li>2. Wire cutters are dull or broken. Replace wire cutters, item 38 on page 9.</li><li>3. Cutter operating slide is worn or broken. Replace cutter operating slide, item 35 on page 9.</li><li>4. Wire cutter slot in face plate is worn. Replace face plate, item 2 on page 10 or replace entire face plate assembly, item 1 on page 10.</li><li>5. Check pawl is worn or dirty. Clean check pawl assembly, item 5 on page 10. Replace worn check pins, item 9 on page 10, or replace entire check pawl assembly.</li><li>6. Burrs exist on funnel in rotator. Polish rotator, item 46 on page 8.</li></ol>

## ADJUSTMENTS

### TO BALANCE STITCH LEGS:

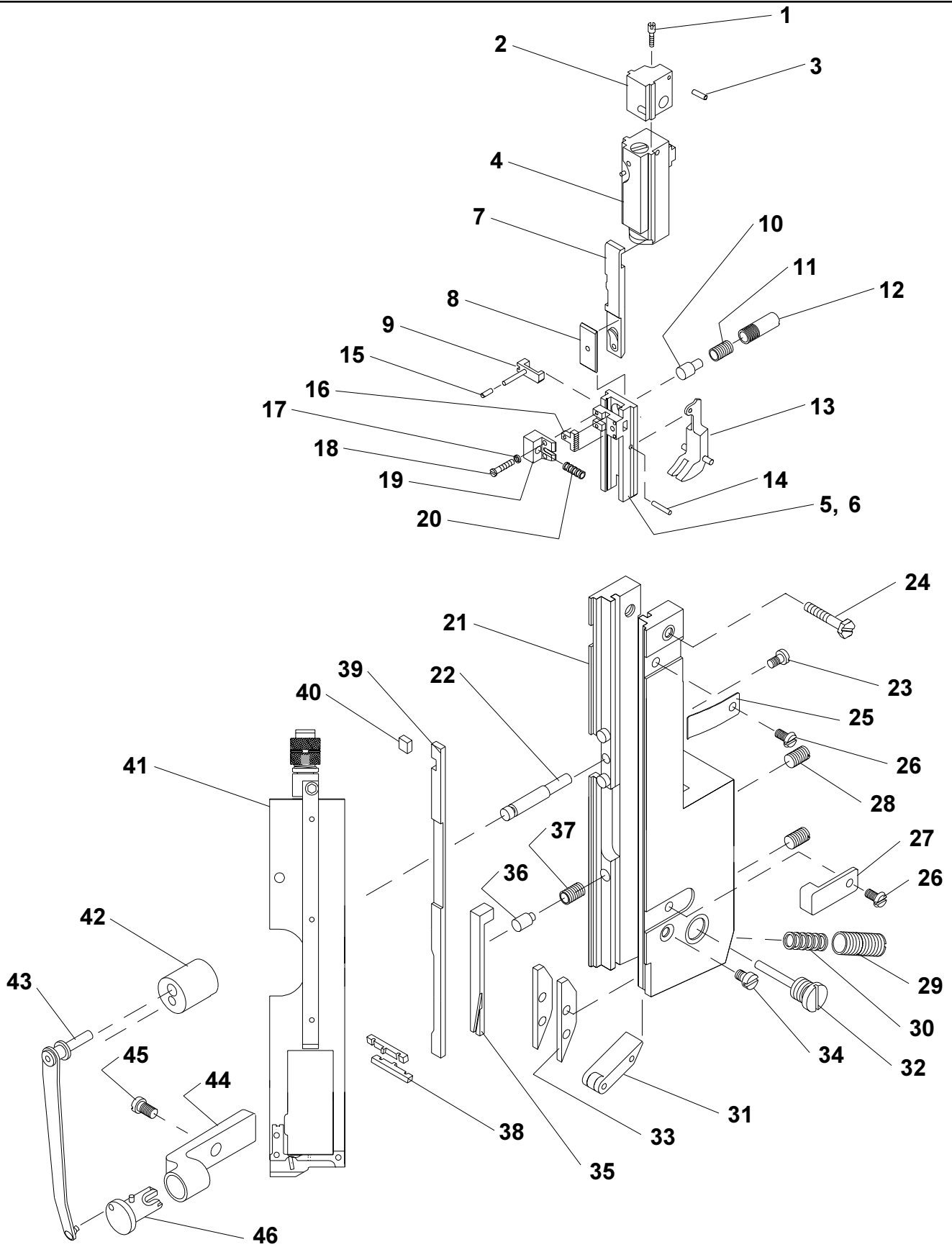
If the stitch legs are uneven in length as pictured, use the following procedure to balance the leg length.



1. Loosen the leg balance block screw (Index 24, page 8).
2. Turn the adjusting screw (Index 1, page 8) clockwise to shorten the left stitch leg or counter clockwise to lengthen the left leg.
3. Tap leg balance block (Index 2, page 8) down before tightening the screw (Index 24, page 8).

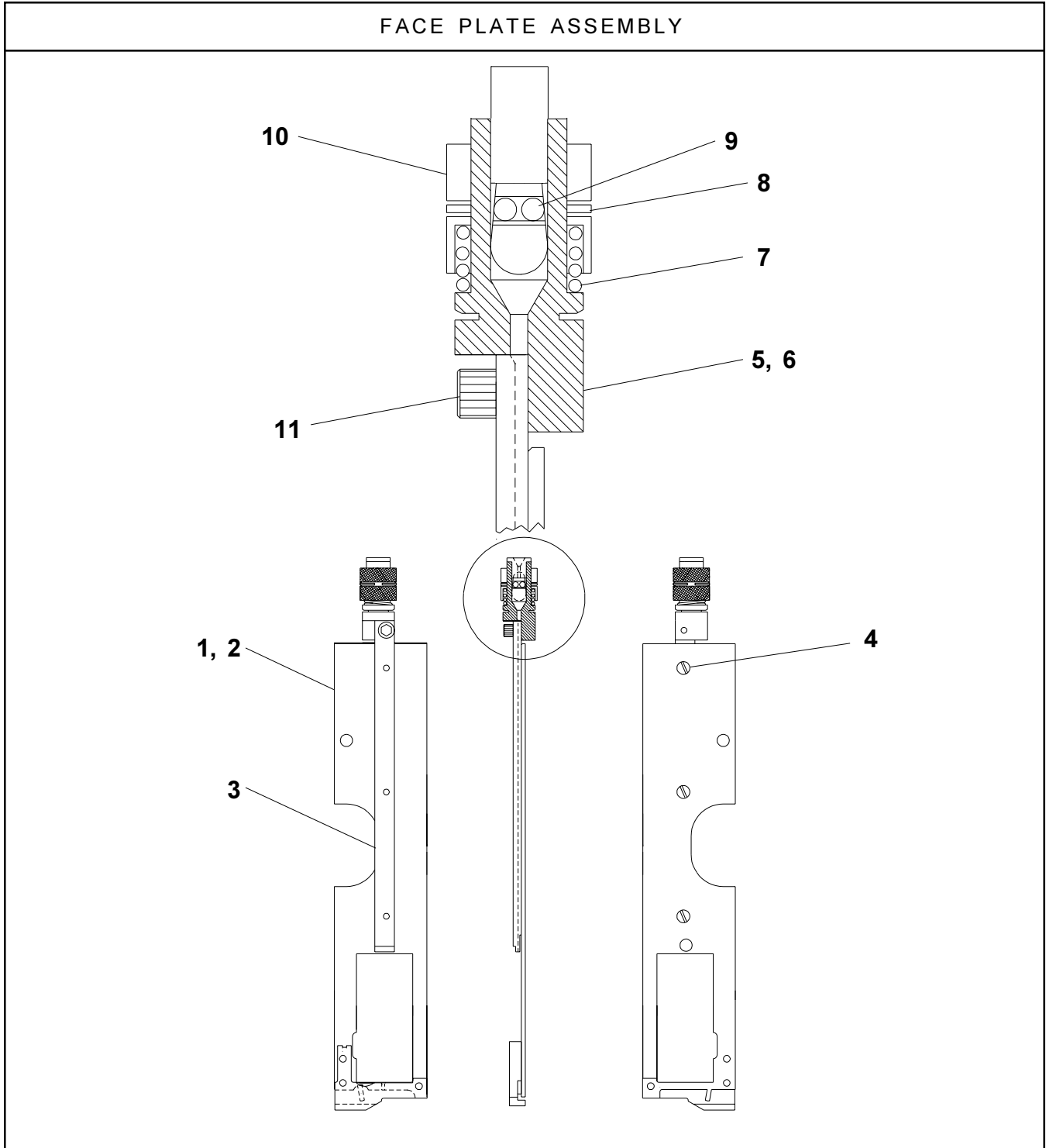
# EZ Thread

## STITCHING HEAD ASSEMBLY



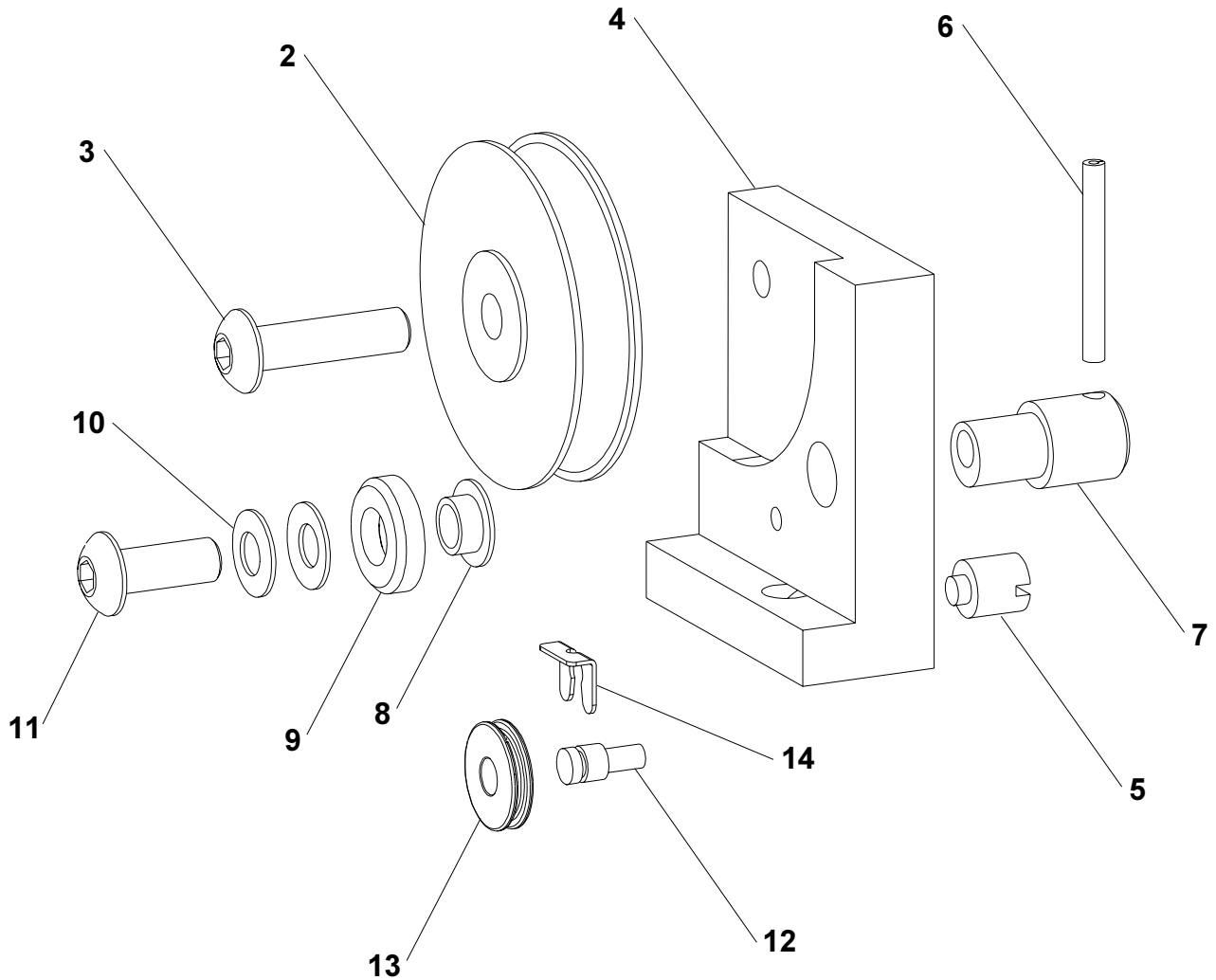
Index Number	Part Number	Part Name	Number Required
1	CA9076	Adjusting Screw	1
2	CA9074C2	Leg Balance Block	1
3	D31028F	Set Screw	1
4	CTT2623	Driving Slide Assy	1
5	CAA9013T2	Bender Bar Assy (Includes Items #6 - #20)	1
6	CAA9013S2	Bender Bar	1
7	CAA9012A	Driver Bar	1
8	CA9009	Driver End	1
9	CAA9014E	Latch Assy	1
10	CA9112A	Friction Plug	1
11	CA9113A	Spring	1
12	CCA9115	Bushing	1
13	CA9026	Supporter	1
14	CA9029	Pivot Pin	1
15	CA173	Black Cap	1
16	CA9015D	Grip	1
17	CB371K	Lockwasher	1
18	CA9024A	Screw	1
19	CT413A	Grip Spring Housing	1
20	CA168	Grip Spring	1
21	CAA2004G	Bonnet Assy (Includes Items #22 & #23)	1
22	CA9127	Cam Stud	1
23	CA9058	Screw	1
24	CA9075	Leg Balance Block Screw	1
25	CA9056C	Face Plate Clip	3
26	CA2081	Clip Screw	4
27	CA9056A	Face Plate Clip	1
28	CT9109	Bonnet Aligning Screw	2
29	CA9037	Supporter Spring Bushing	1
30	CA9032	Supporter Spring	1
31	CAA9036	Supporter Spring Lever	1
32	CA9034	Supporter Spring Lever Screw	1
33	CA9030	Supporter Guide Plate	2
34	CA9081	Supporter Guide Plate Screw	2
35	CA9049	Cutter Operating Slide	1
36	CA9050A	Friction Plug	1
37	CA9051A	Friction Plug Spring	1
38	CA9048	Wire Cutter	2
39	CA9022G	Grip Release Slide	1
40	CA9025A	Key	1
41	CAA2132U	Face Plate Assy (See next page for details.)	1
42	CA9163C	Rotator Operating Cam	1
43	CAA9046A	Rotator Operating Spring	1
44	CA9043A	Rotator Holder	1
45	CA9044A	Rotator Holder Screw	1
46	CAA9038M	Magnetic Rotator	1

# EZ Thread



Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	CAAA2132U	Face Plate Assembly (Item 1 consists of items 2 through 11.)	1	6	CBB513G	Check Pawl Body Assy	1
2	CAA2132R	Face Plate	1	7	RBM1481F	Spring	1
3	CA182A	Feed Tube	1	8	CB517	Retaining Ring	1
4	CA9643	Flat Head Screw	3	9	CB516	Check Pin	2
5	CBBB513G	Check Pawl Assembly (Item 5 consists of items 6 through 10.)	1	10	CB515	Check Sleeve	1
				11	D30676F	Cap Screw	1

WIRE GUIDE ASSEMBLY



1

Index Number	Part Number	Part Name	Number Required	Index Number	Part Number	Part Name	Number Required
1	RBM1678A	Wire Guide Assy (Includes Items #2 - #14.)	1	8	CA9068	Bushing	1
2	RBM1677F	Wire Guide Pulley	1	9	CA9065	Roller	1
3	CG26C	Button Hd Scr 10-32 x 3/4	1	10	CL44A	Spring Washer	2
4	RBM1647F	Straightener Bracket	1	11	RBM1424F	Button Head Screw	1
5	CA172	Soft Tip Set Scr 1/4-20	1	12	CA9123A	Stud	1
6	D41302F	Roll Pin	1	13	CA9103C	Roll	1
7	RBM1423F	Straightener Eccentric	1	14	CA9124	Clip	1

*EZ Thread*

**ISP** Stitching & Bindery Products

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