




















AUTOMATIC BOX STITCHING MACHINES

STITCHING FAULTS (REASONS & CORRECTIONS)

FAULTS		REASONS
	PERFECT STITCH	
	ONE LEG TOO SHORT	UNCORRECT WIRE FEED, UNDUE BRAKE ON WIRE SPOOL WRONG SETTING OF WIRE FEED
	ONE LEG TOO LONG	TOO MUCH WIRE FEED, WRONG ADJUSTMENT OF FEED LEVER
	CRUMLED STAPLE CROWN	WIRE OF NO PENETRATING FORCE, CHANGE FOR STRONGER WIRE
	ONE LEG BREAKS AT BENDING ANGLE	WIRE TOO BRITTLE OR HARD, EDGE OF DRIVER TOO SHARP
	STAPLE CROWN NOT FLUSH, LEGS CRUMPLED	ARM TOO-LOW OR WIRE TOO SOFT OR TOO THIN
	BOTH LEGS SHORT	ADJUST THE LENGTH OF WIRE BY RESETTING WITH THE HELP OF FEED ADJUSTING SCREW
	BOTH LEGS SQUEEZED BACK	REPLACE LOOP BAR OR FORMES
	ONE LEG SQUEEZED UPWARD	DAMAGE TO DRIVER (CORNER BROKEN)
	CROWN OF STAPLE BOWED, STAPLE NOT CLINCHED CORRECTLY	WRONG SETTING OF STITCHING THICKNESS SET THE ARM
	STAPLE LEGS NOT FULLY CLOSED	SET THE PUSH BAR
	ONE LEG NOT CLINCHED	CLINCHERS, BACK PLATE PUSH BAR DAMAGED
	CLINCHING PRESSED THROUGH BOARD	PUSH BAR TOO HIGH
	BURR ON WIRE ENDS	BLUNT CUTTERS OR CUTTERS NOT SLIDING WITH CUTTING TUBE
	BOWED STAPLE CROWN, NO FLUSH CLINCHING	WIRE TOO HARD, REPLACE WIRE
	SIDE DEFLECTED SHANK	DAMAGE BACK PLATE OR BACK PLATE OUT OF LINE WITH HEAD
	WIRE BUCKLED BETWEEN CUTTING TUBE AND FEEDER	WRONG SIZE OF WIRE, SHORT FEEDING, BAD CUT OFF, WIRE INTERMINGLED IN COIL, EXCESSIVE WEAR OF WIRE GUIDE, LOOP BAR, WIRE HOLDER