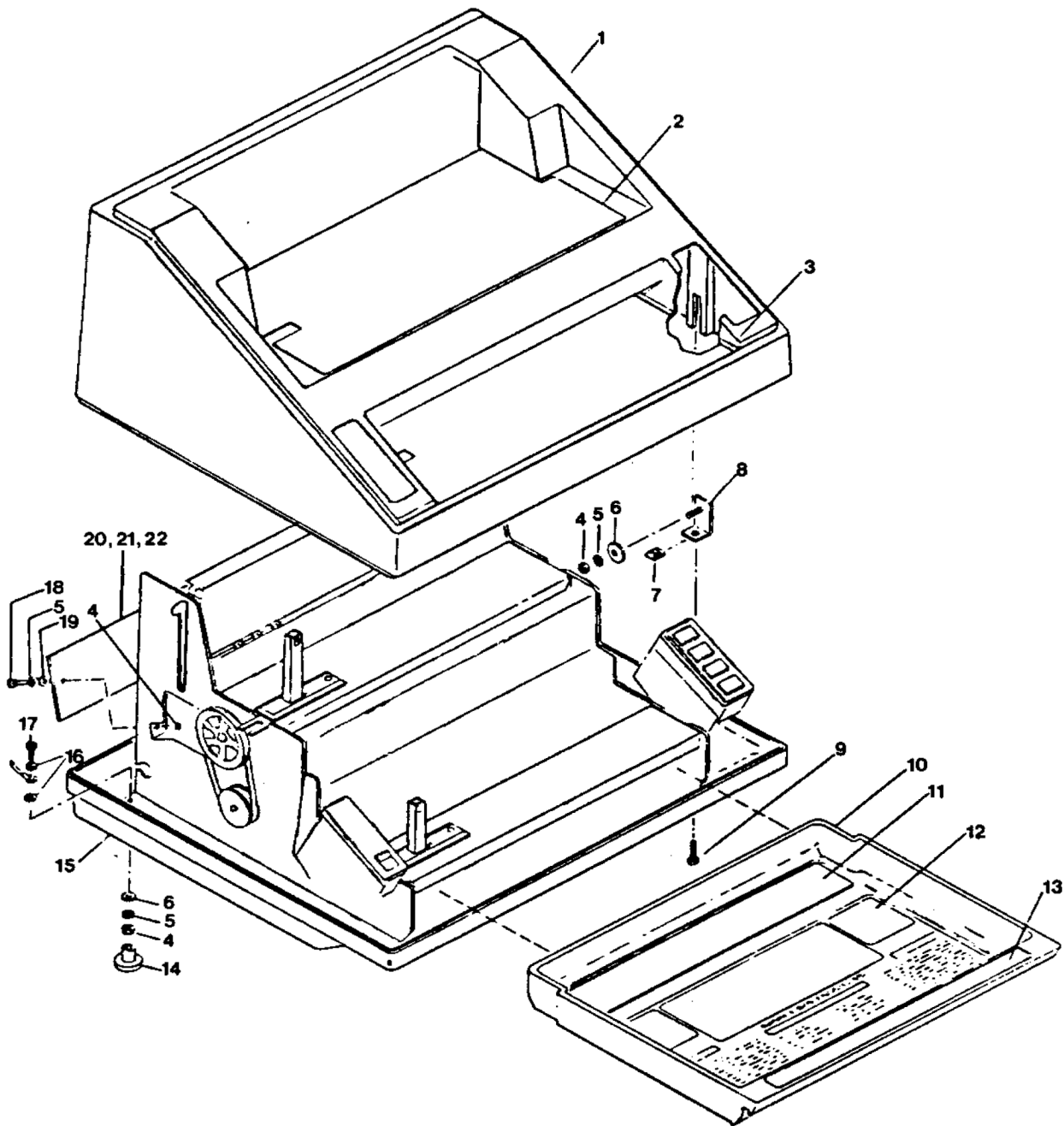


323 PARTS LIST

FIGURE 1 - HOUSING REMOVAL

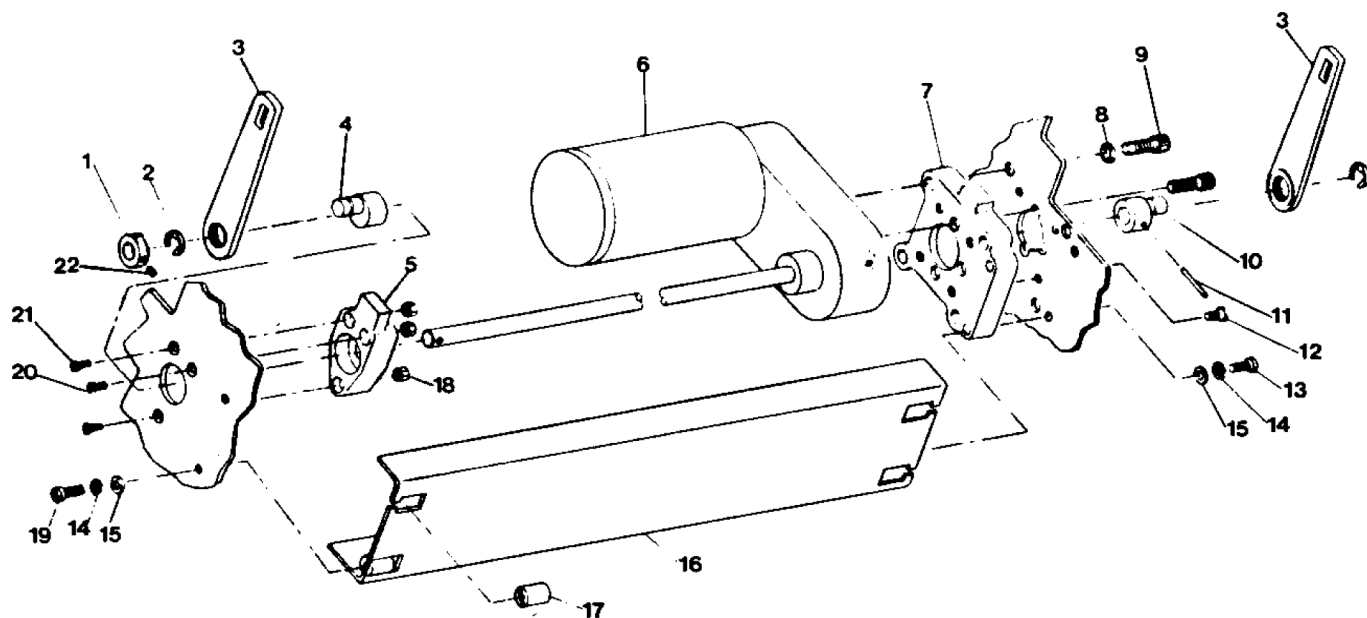


PART NUMBER REFERENCE GUIDE

1--9776963--HOUSING	12--9776901--OP INST. DECAL
2--9778786--BIND PLATEN	13--9776898--SALES REP DECAL
3--9778792--PUNCH PLATEN	14--9778089--RUBBER FOOT
4--9778590--#10 HEX NUT	15--9778221--BASE
5--9779912--#10 LOCKWASHER	16--9779923--STAR WASHER
6--9779912--#10 FLAT WASHER	17--9779179--10/24 X 1-1/8 SCREW
7--9778610--#10 TINNEMAN NUT	18--9779178--10/24 X 1/2 SCREW
8--9776719--HSING MTG BRAC ASSY.	19--9779899--FLAT WASHER
9--9779206--10/16 X 1 SCREW	20--9778696--P.C. BOARD
10--9779438--WASTE TRAY	21--9779247--P.C. BOARD SHIELD
11--9779365--FOAM STRIP	22--9779362--3/16 SUPPORT

9778230--HOUSING ASSEMBLY (INCLUDES ITEMS 1-8)

FIGURE 2 - PUNCH DRIVE ASSEMBLY REMOVAL



PART NUMBER REFERENCE GUIDE

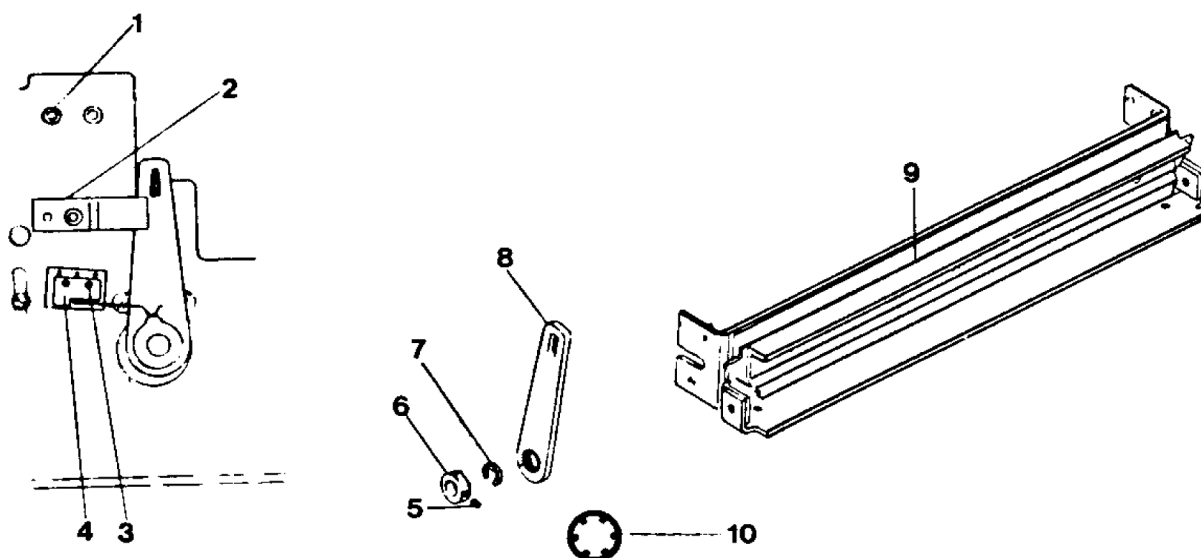
1--9776851--PUNCH CAM	12--9779204--10/24 X 1/2 SCREW
2--9777570--RETAINING RING	13--9779134--8/32 X 1-1/4 SCREW
3--9778461--PUNCH LINK	14--9779911--LOCK WASHER
4--9776842--PUNCH CRANK	15--9779898--FLAT WASHER
5--9776610--PUNCH BEARING	16--9776935--GEARBOX SUPPORT
6--9778567--PUNCH MOTOR ASSEMBLY	17--9776927--SLOTTED NUT
7--9776389--PUNCH MOTOR ADAPTOR	18--9778597--HEX NUT
8--9779929--LOCK WASHER	19--9779132--8/32 X 3/4 SCREW
9--9779205--5/16 X 3/4 SCREW	20--9779187--10/24 X 3/4 SCREW
10--9776842--PUNCH CRANK	21--9779187--10/24 X 3/4 SCREW
11--9778669--ROLL PIN	22--9779192--6/32 X 1/8 SCREW

NOTE: REFERENCE FIGURES 2 (ABOVE) AND FIGURE 3 (NEXT PAGE) FOR REMOVAL.

PUNCH DRIVE ASSEMBLY REMOVAL

1. Disconnect the punch motor connectors, and cut any wire ties necessary to free the punch motor wiring.
2. Remove the two zee brackets (Item 2, Fig. 3), and loosen the Punch Cam Switch (Item 4, Fig. 3) by removing the right screw, and loosening the left screw.
3. Remove the punch cam (Item 1, Fig. 2); remove the E-rings (Item 2, Fig. 2); and remove the punch links (Item 3, Fig. 2).
4. Remove the three allen screws (Item 12, Fig. 2) from the punch motor adaptor.
5. Remove the three phillips screws (Items 20, 21, Fig. 2) by holding the Punch Shaft Bearing (Item 5, Fig. 2), and move the bearing to the right.
6. The punch drive assembly can now be removed by moving the assembly to the left, and lifting it out of the unit.
7. Reassemble in reverse order.

FIGURE 3- PUNCH ASSEMBLY REMOVAL



PART NUMBER REFERENCE GUIDE

1--9779141--1/4-20 X 1 SCREW	5--9779192--SET SCREW
1--9779913--LOCK WASHER	6--9776851--PUNCH CAM
1--9778591--HEX NUT	7--9779072--E-RING
2--9776726--ZEE BRACKET	8--9778461--PUNCH LINK
3--9779168--2/56 X 9/16 SCREW	9--9778709--PUNCH ASSEMBLY
4--9779311--SWITCH	10--9777570--RETAINING RING

PUNCH ASSEMBLY REMOVAL

1. Loosen (do not remove) the bind support by removing the four phillips screws. This will provide easier access for the punch assembly removal.
2. Remove the two zee brackets (Item 2, Fig. 3) on both sides of the unit - 3/16 allen.
3. Loosen the Punch Cam Switch (Item 4, Fig. 3) by removing the right screw (Item 3, Fig. 3), and loosening the left screw.
4. Remove the punch cam (Item 6, Fig. 3) by loosening the 1/16 allen screw (Item 5, Fig. 3).
5. Remove the E-ring (Item 7, Fig. 3) from both eccentric cams.
6. Remove the punch links (Item 8, Fig. 13). Be careful not to damage the punch cam switch (Item 4, Fig. 3).*
7. Remove the remaining two 3/16 allen screws (Item 1, Fig. 3) with hardware, from both sides of the punch assembly.
8. The punch assembly (Item 9, Fig. 3) may now be removed.
9. Reassemble in reverse order, and re-time the punch and bind cam switches.

*NOTE: IF YOUR MACHINE HAS COMPUTER/STANDARD SELECTOR, REMOVE THE HEX NUT AND CLAMP UNDER THE PUNCH HOUSING, AND REMOVE THE CABLE FROM THE LEVER BEFORE STEP 7.

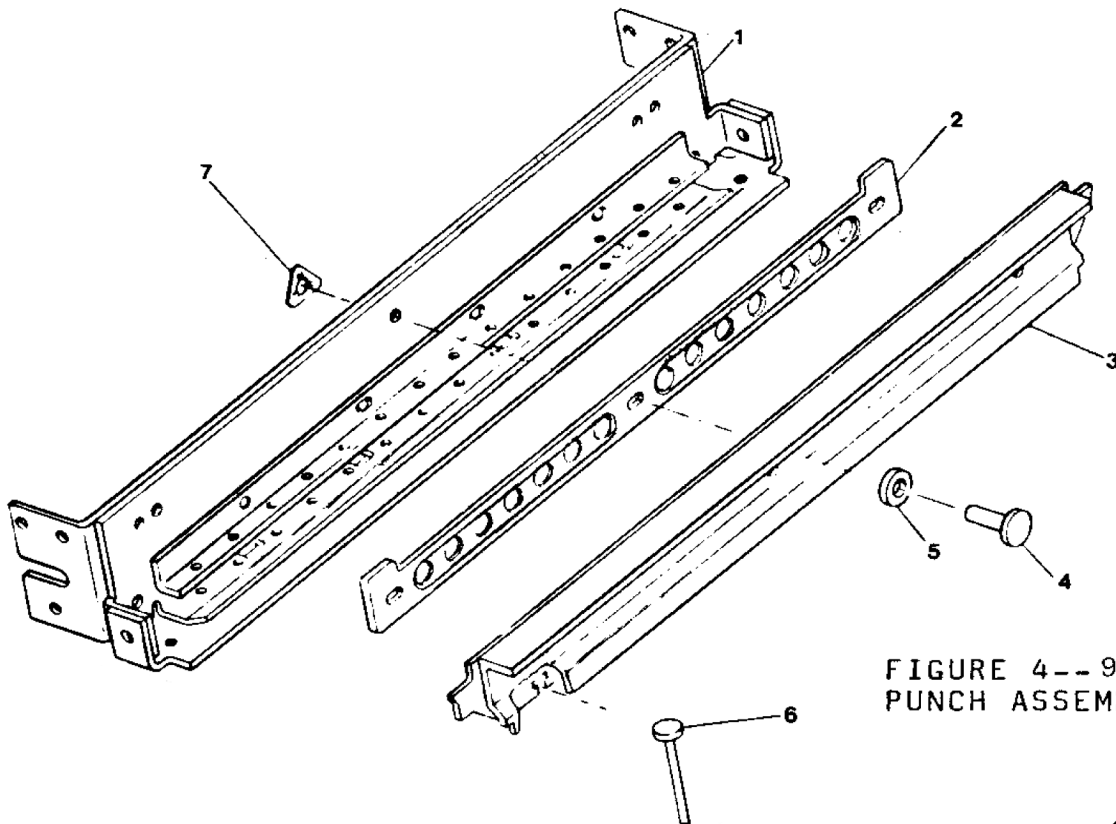


FIGURE 4-- 9778709
PUNCH ASSEMBLY (AFTER S/N 6254)

FIGURE 5--PUNCH ASSEMBLY
9778713 -OBSOLETE (PRIOR S/N 6254)
ORDER COMPONENTS BELOW

PART NUMBER REFERENCE GUIDE

- 1--9778194--PUNCH HOUSING
- 2--9779250--PUNCH SPACER
- 3--9776364--PUNCH ACTUATOR
- 4--9779063--RETAINING PIN
- 5--9779933--WASHER
- 6--9778684--PUNCH PIN
- 7--9779078--RETAINING CLIP

(#'S BELOW PRIOR TO S/N 6254)

- 8--9779069--E-RING
- 9--9779936--WASHER
- 10--9778233--PUNCH HOUSING
- 11--NOT AVAILABLE
- 12--9779371--PUNCH SLIDE
- 13--9779254--NYLON SPACER
- 14--9778466--PUNCH LEVER
- 15--9779279--SLIDE SPRING
- 16--9779897--FLAT WASHER
- 17--9778595--6/32 LOCKNUT
- 18--9776857--CLAMP
- 19--9779186--SCREW
- 20--9776621--BUSHING

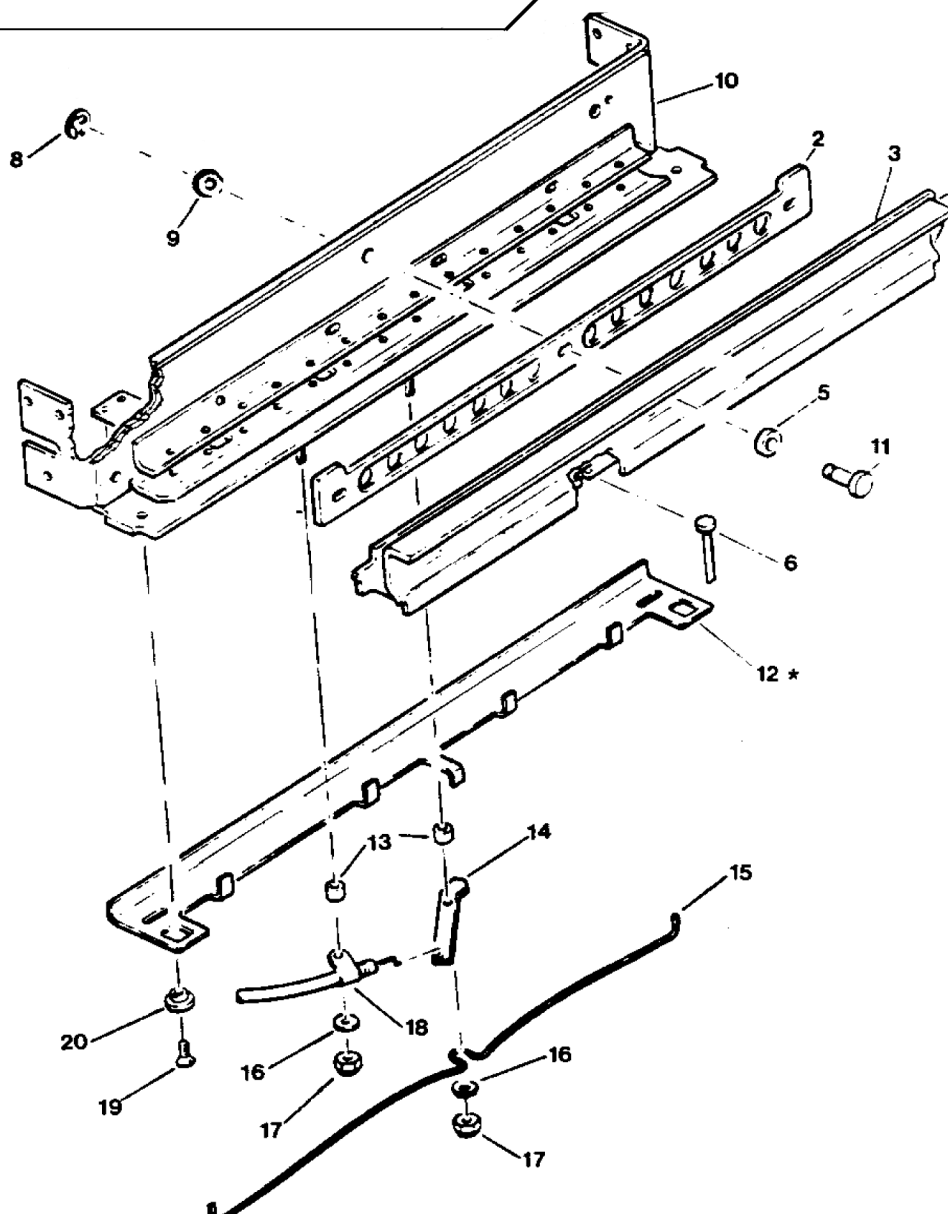
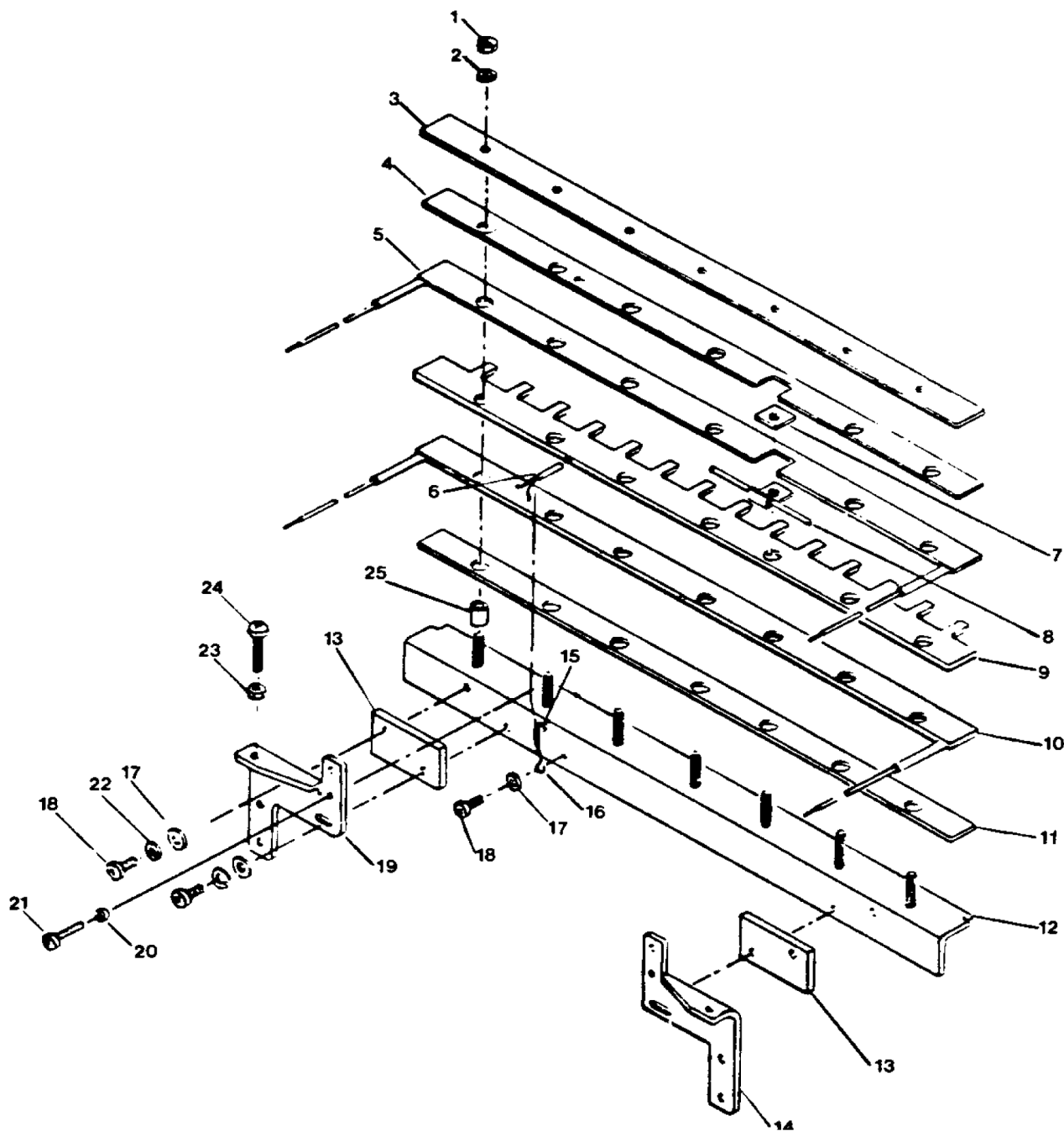


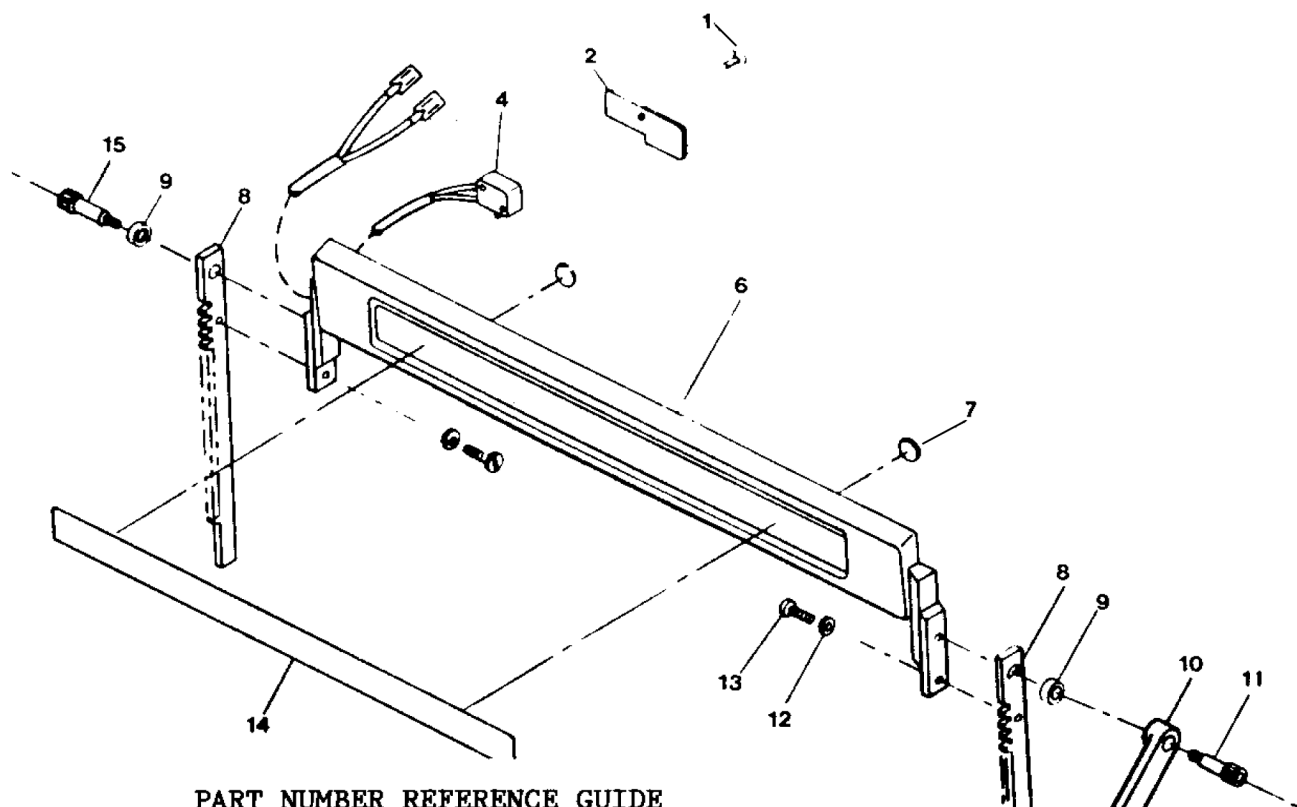
FIGURE 7 - KNIFE ASSEMBLY



PART NUMBER REFERENCE GUIDE

1--9778588--6/32 HEX NUT	14--9776704--LH HTR BRACKET
2--9779910--LOCK WASHER	15--9779410--TEFLON SLEEVE
3--9778754--KNIFE HTR PLATE	16--9779089--RETAINER
4--9778289--INSULATOR	17--9779898--FLAT WASHER
5--9778217--UPPER HEATER	18--9779175--3/32 X 1/2 SCREW
6--9779450--THERMISTOR	19--9776703--RH HTR BRACKET
7--9778289--INSULATOR	20--9778587--4/40 HEX NUT
8--9779394--CUTOFF THERMOSTAT	21--9779170--4/40 X 3/4 SCREW
9--9776713--BLADE	22--9779911--LOCK WASHER
10--9778226--LOWER HEATER	23--9778589--8/32 HEX NUT
11--9778289--INSULATOR	24--9779177--8/32 X 1 SCREW
12--9776705--HEATER SUPPORT	25--9778296--INSULATOR SLEEVE
13--9778294--INSULATOR BRACKET	N/A- 9778313 --KNIFE ASSEMBLY

FIGURE 8 - 9780037 - PRESSEURE BAR ASSY.



PART NUMBER REFERENCE GUIDE

1-- 9779223 --2/56 X 3/16 SCREW

2--9776734--SWITCH COVER

3--NOT USED

4-- 9780193* SWITCH KIT

5--NOT USED

6-- 9780043 PRESSURE BAR

7--9778772--FELT PAD

8--9779044--RACK

*INCLUDES 1, 2 & 4

4 -- 9780089 -- Pressure bar switch

9--9776620--BUSHING

10-9778460--RETURN LINK

11-9779155--SHOULDER SCREW

12-9779912--LOCK WASHER

13-9779178--10/24 X 1/2 SCREW

14-9778626--PRESSURE BAR LOGO

15-9779154--SHOULDER SCREW

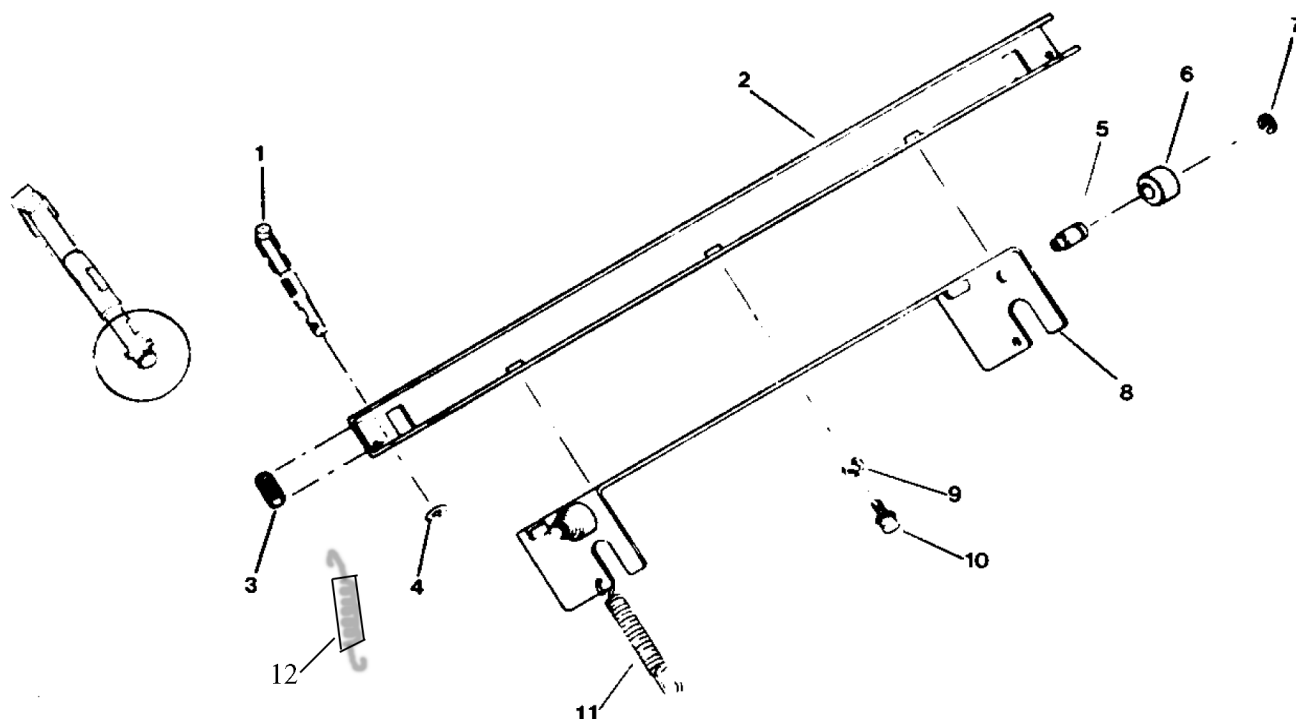
PRESSURE BAR AND RACKS REMOVAL

REFERENCE FIGURE 8 FOR PARTS DIAGRAM

1. Remove power cord from rear of machine, and place pressure bar in home position.
2. Remove housing (P. 25).
3. Disconnect the two connectors from the pressure bar harness (Item 5) to the main harness.
4. Remove the two 1/8" screws (Items 11 & 15) from each side of the pressure bar. Remove the pressure bar by pulling straight up, being careful not to break the pressure bar harness wires.
5. The racks (Item 8) may be replaced by removing the mounting screws (Item 13).

- 1.NOTE: When replacing the pressure bar and racks, install the first tooth of the racks to the pinion gears simultaneously. Otherwise, the pressure bar will not be parallel with the backstop when in the home position.
- 2.NOTE: If actuator (Item 3) is bent or malformed, it has a tendency to stick. Change or re-form the actuator if this situation occurs.

Figure 9 - Cooling finger / bracket assy.



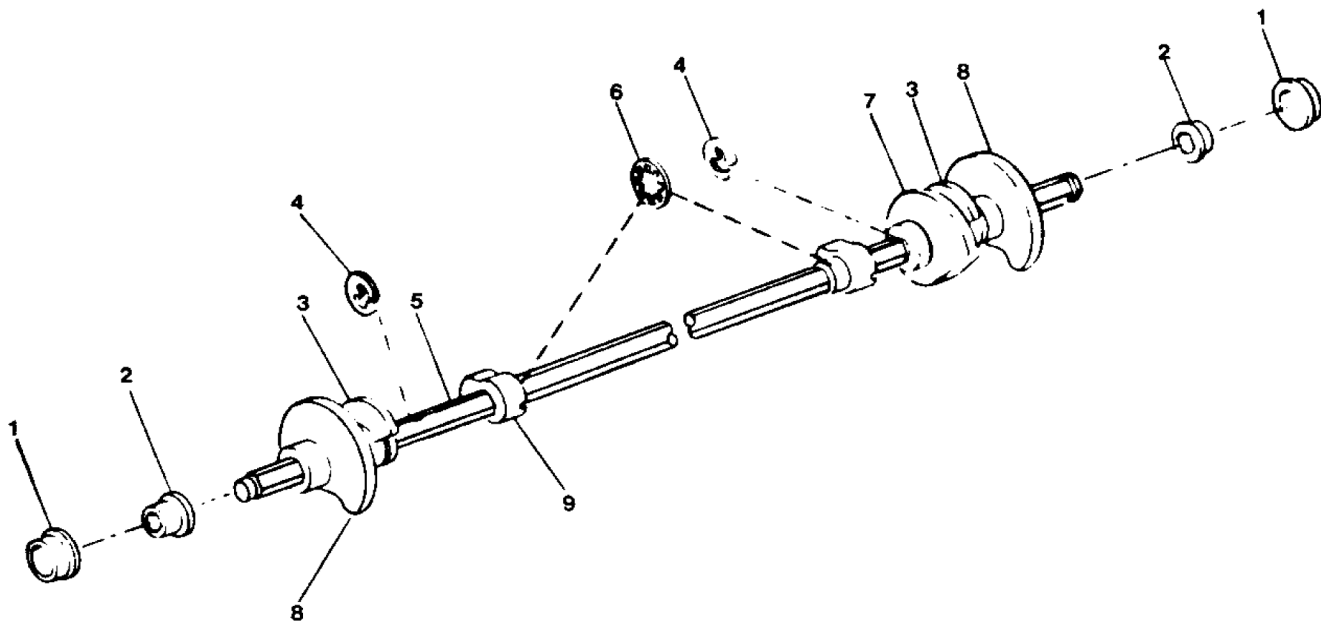
PART NUMBER REFERENCE GUIDE

1--9778687--COOLING FINGER	7--9779077--C-CLIP
2--9776845--CHANNEL	8--9776748--COOLING BRACKET
3--9779272--SPRING	9--9779910--LOCK WASHER
4--9776950--RETAINING RING	10--9779172--6/32 X 3/8 SCREW
5--9779062--RIVET	11--9779278--TENSION SPRING
6--9779084--CAM FOLLOWER	N/A-9776708--COOLING FINGER ASSY.
N/A-9776718--COOLING BRACKET ASSY.	(INCLUDES ITEMS 1-4)
(INCLUDES ITEMS 5-8)	12 - Cooling channel springs

REPLACING THE COOLING FINGERS

1. Disconnect the plug from the rear of the machine, and remove the housing (Page 25).
2. Remove the screws (Item 1, Fig. 11) holding the bind guide assembly (Item 2, Fig. 11) and lift it up to gain access to the cooling finger assembly.
3. Remove the retaining ring (Item 4, Fig. 9).
4. The finger will pop up, and can now be removed by lifting it out behind the backstop.
5. Reinstall by pushing it into the bridge slot, and reinstall the retaining ring. Reassemble in reverse order.
6. Reinstall old configuration without retaining rings, by pushing into bridge slot and twisting (See Detail).

Figure - 10



PART NUMBER REFERENCE GUIDE

N/A-9776843-CAMSHAFT ASSY.

1--9776611--BEARING

2--9779236--JOURNAL

3--9776840--CUTTER CAM

4--9779072--E-RING

5--9779236--CAMSHAFT

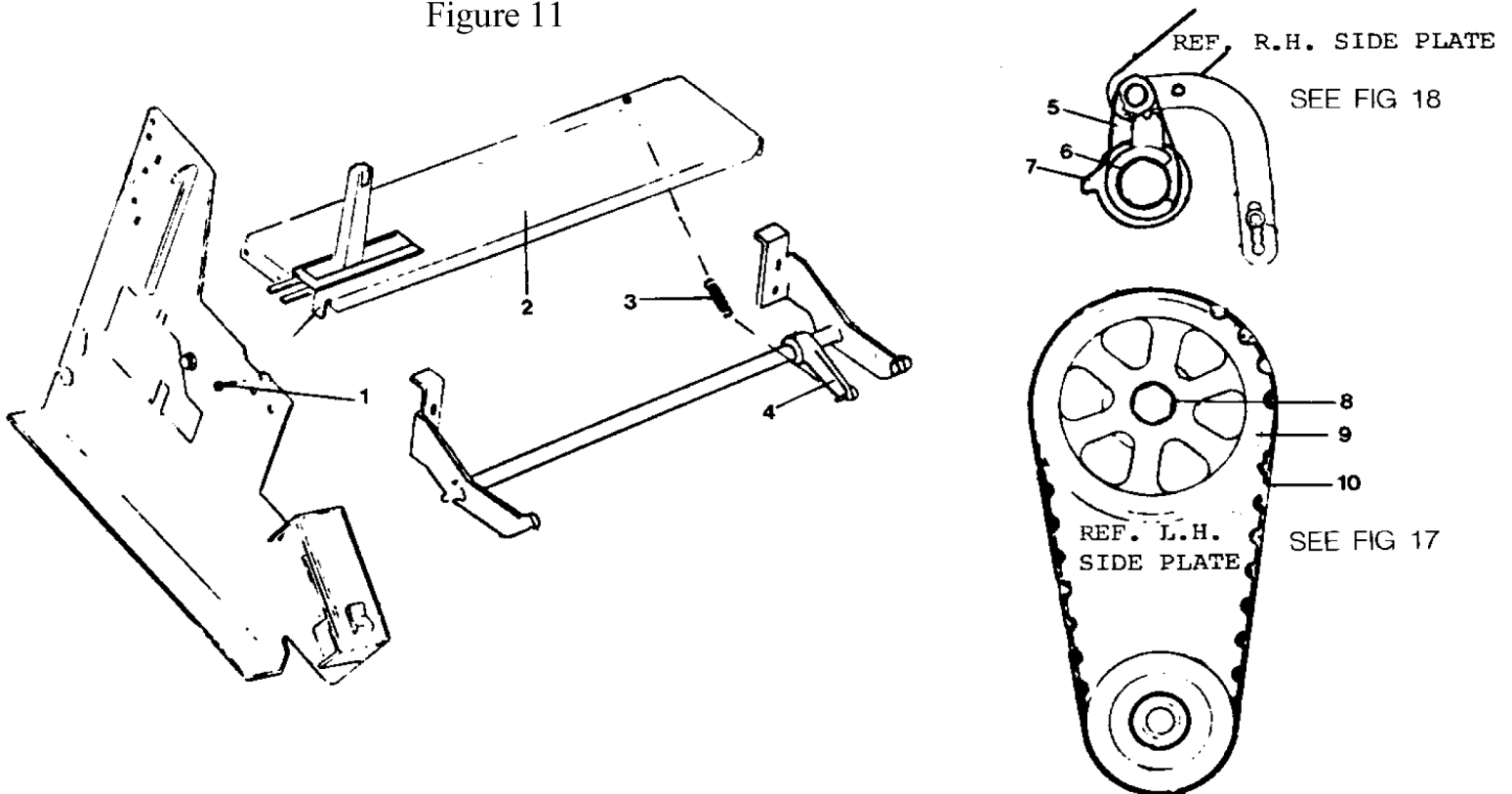
6--9776937--RETAINING CLIP

7--9776841--EXTRUDER CAM

8--9776959--PRESSURE CAM

9--9776928--COOLING CAM

Figure 11



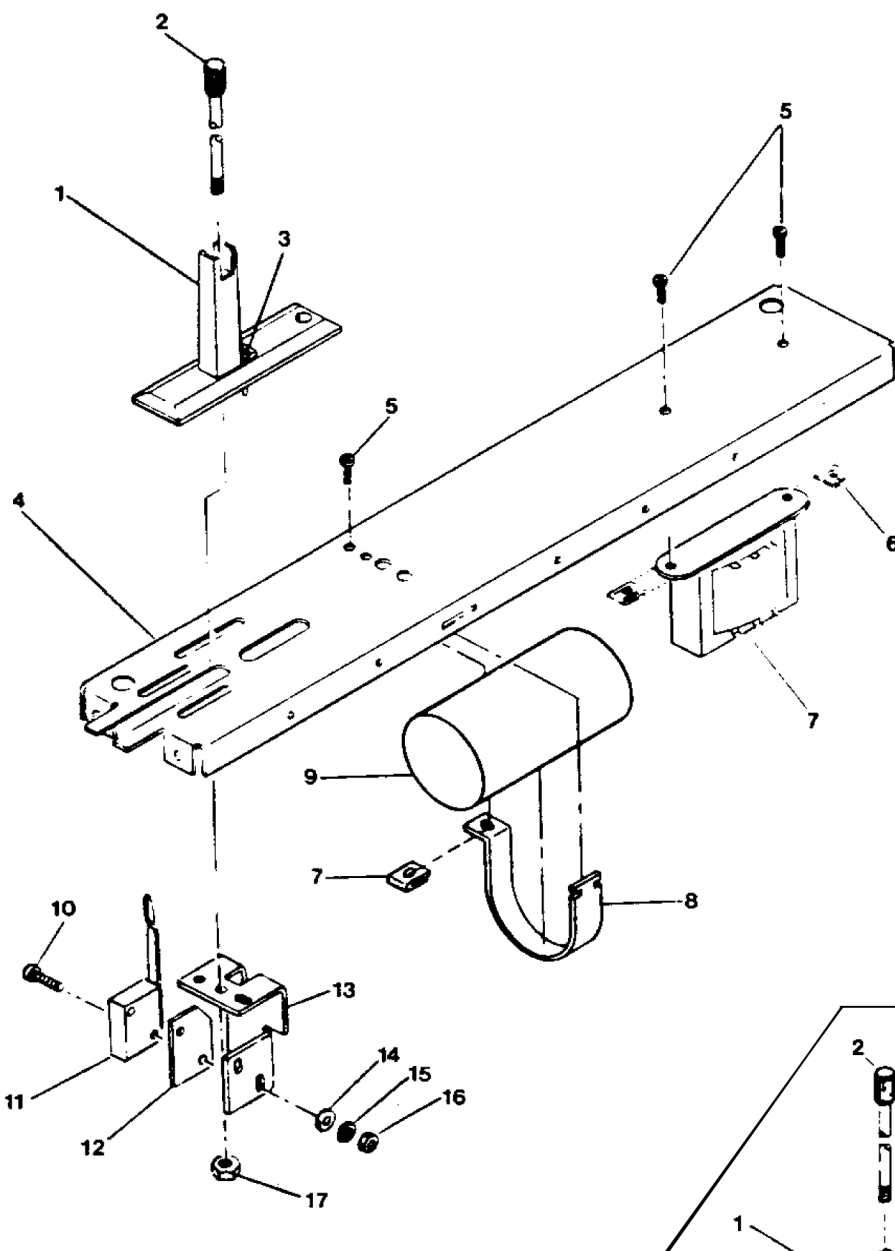


FIGURE 12
PART NUMBER REFERENCE GUIDE

- 1--9778150--PUNCH EDGE GUIDE
- 2--9778318--PUNCH GUIDE KNOB
- 3--9776897--DECAL
- 4--9779299--GUIDE SUPPORT
- 5--9779172--6/32 X 3/8 SCREW
- 6--9778611--6/32 NUT
- 7--9779405--TRANSFORMER
- 8--9776761--BRACKET
- 9--9776778--30MFD CAPACITOR
- 10--9779170--4/40 X 3/4 SCREW
- 11--9779325--SWITCH
- 12--9778285--INSULATOR
- 13--9776724--SW MTG BRACKET
- 14--9779896--FLAT WASHER
- 15--9779909--LOCK WASHER
- 16--9778587--4/40 NUT
- 17--9778592--10/32 LOCK NUT
- N/A-9778143-PUNCH GUIDE ASSY

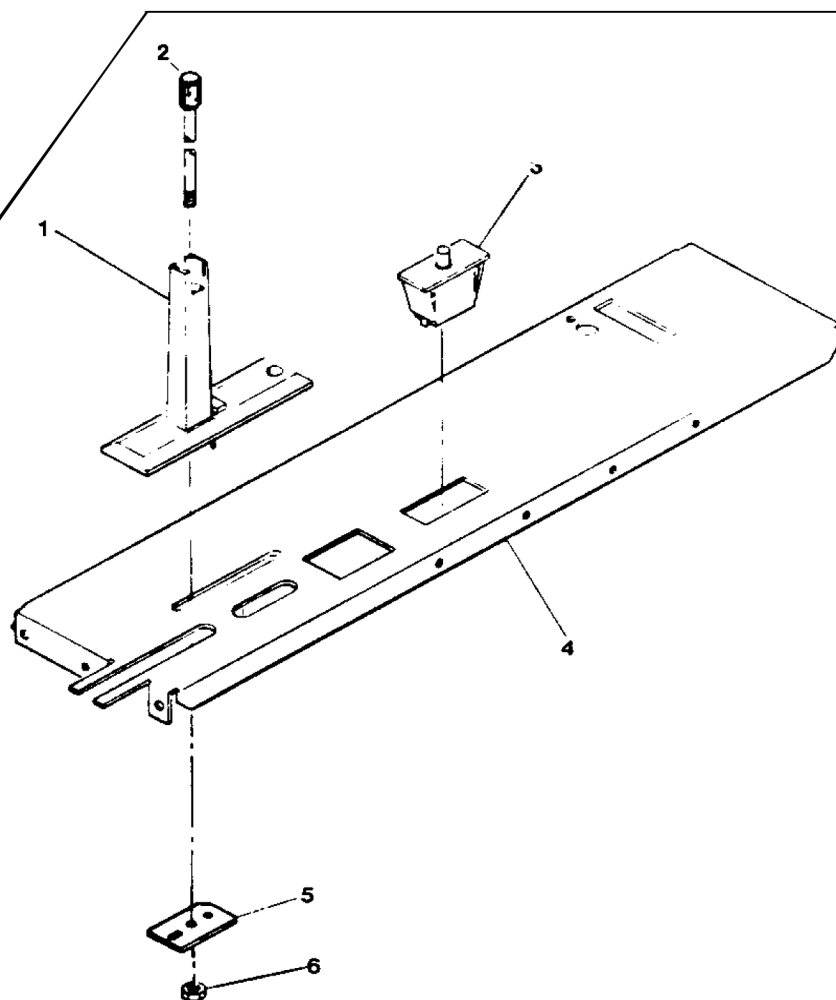


FIGURE 13
PART NUMBER REFERENCE GUIDE

- 1--9778145--BIND EDGE GUIDE
- 2--9778317--KNOB
- 3--9779309--INTERLOCK SWITCH
- 4--9779363--GUIDE SUPPORT
- 5--9778756--RETAINER PLATE
- 6--9778592--10/32 LOCK NUT
- N/A-9778140-BIND GUIDE ASSY

FIGURE -14

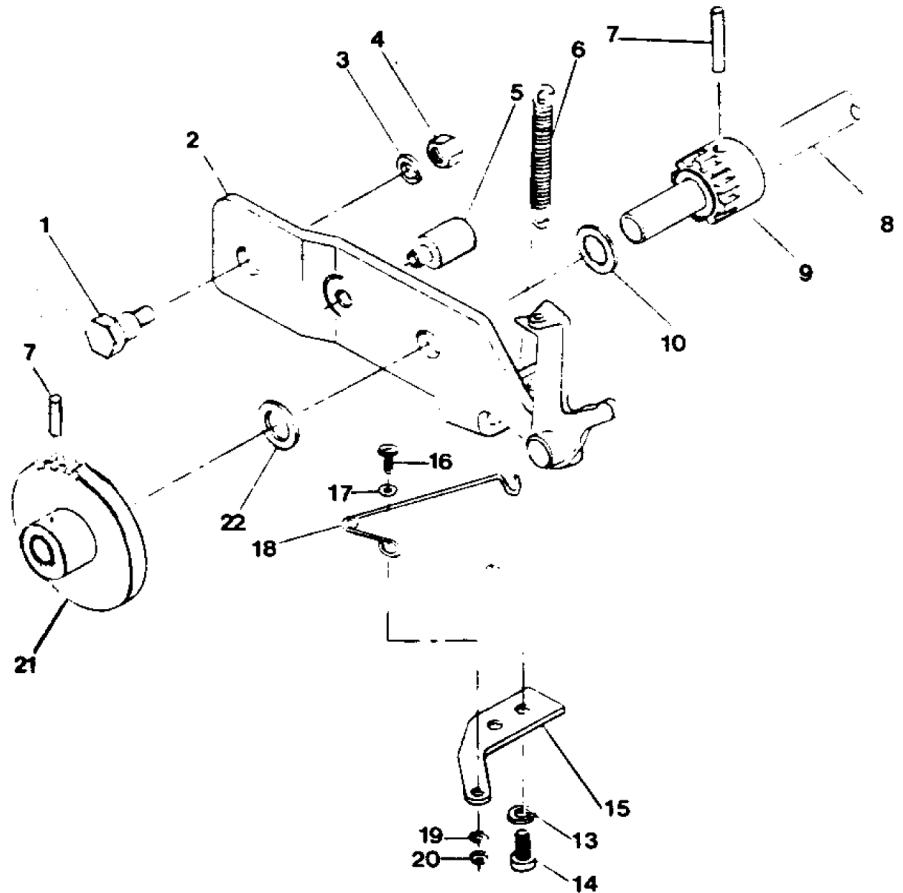
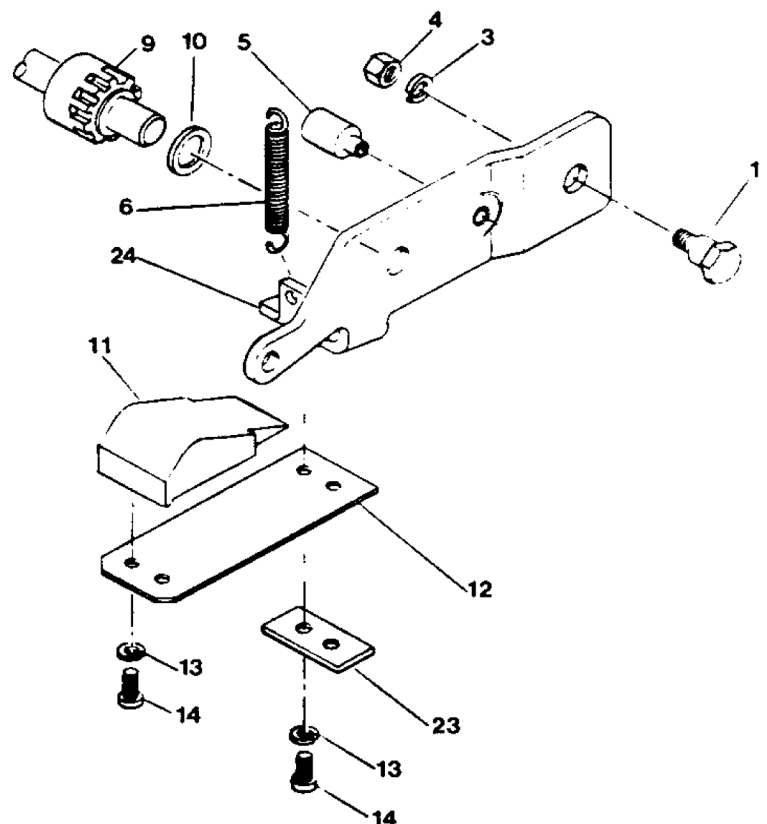


FIGURE 15



PART NUMBER REFERENCE GUIDE

N/A-9778775--LH PIVOT SPRING ASSY.

N/A-9778776--RH PIVOT SPRING ASSY.

N/A-9779241--TIMING SHAFT ASSY.

1--9779337--SHOULDER SCREW

2--N/A--LH PIVOT PLATE

3--9779913--LOCK WASHER

4--9778591--1/4-20 NUT

5--N/A--GUIDE RIVET

6--9779274--SPRING

7--9778665--ROLL PIN

8--9779240--TIMING SHAFT

9--9778765--PINION GEAR

10--9779256--SPACER

11--NOT USED

12--NOT USED

13--9779910--LOCK WASHER

14--9779219--6/32 X 3/8 SCREW

15--9779087--RETAINER PLATE

16--9779118--4/40 X 3/8 SCREW

17--9779896--FLAT WASHER

18--9779280--PAWL SPRING

19--9779909--LOCK WASHER

20--9778587--4/40 NUT

21--9779085--RATCHET

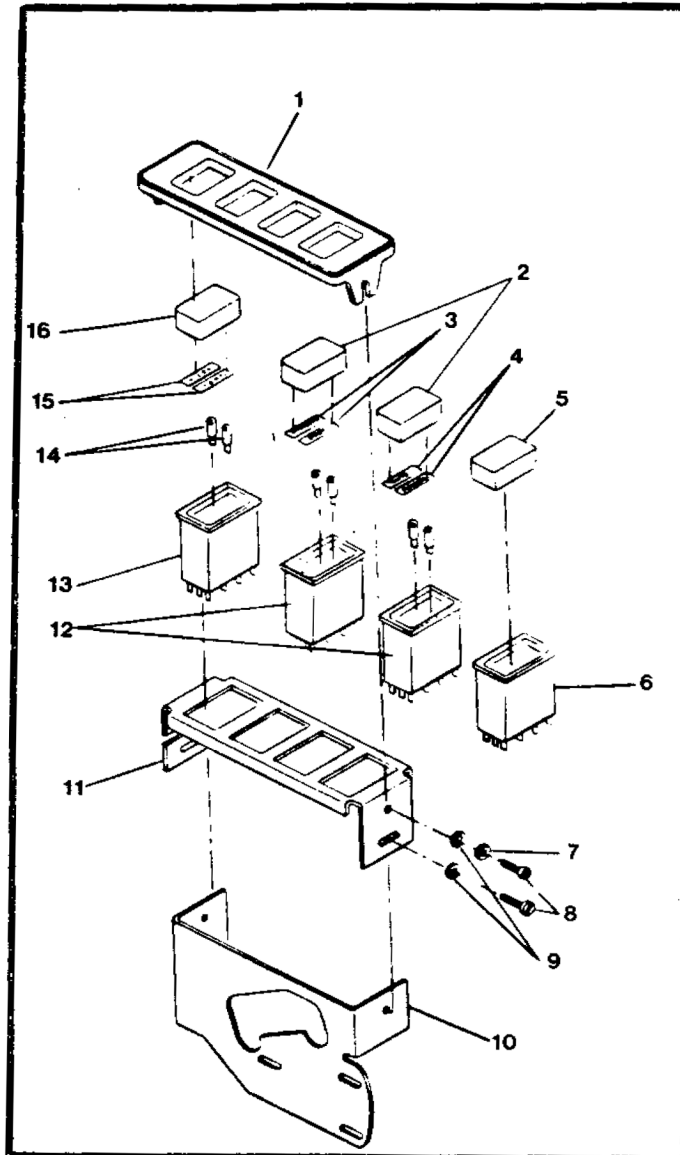
22--9779255--SPACER

23--9779088--RETAINER PLATE

24--N/A--RH PIVOT PLATE

POWER SWITCH PANELS

(SEE PAGE 40 FOR PART
NUMBER REFERENCE GUIDE)



Prior to SN 6254

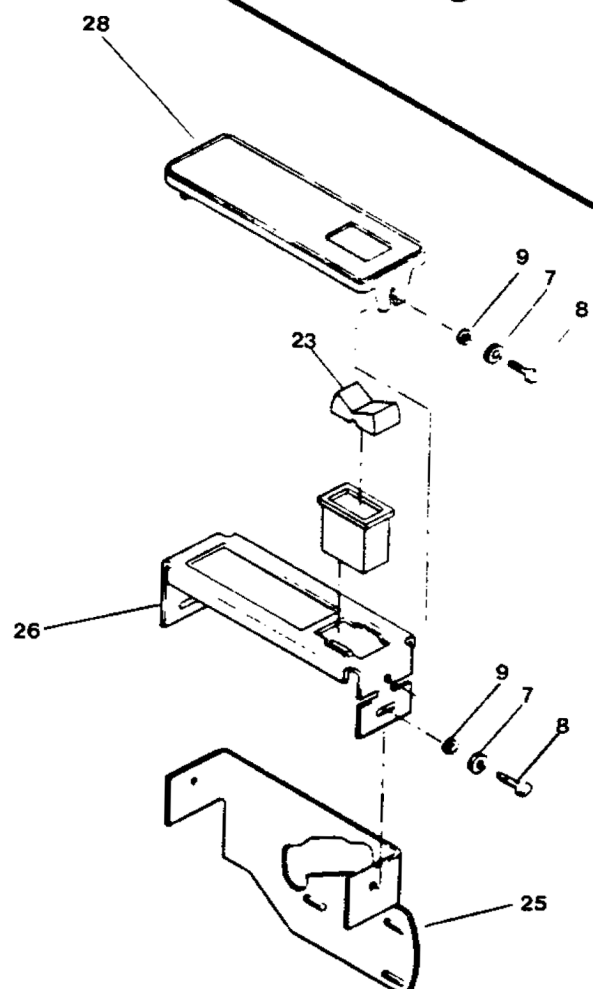
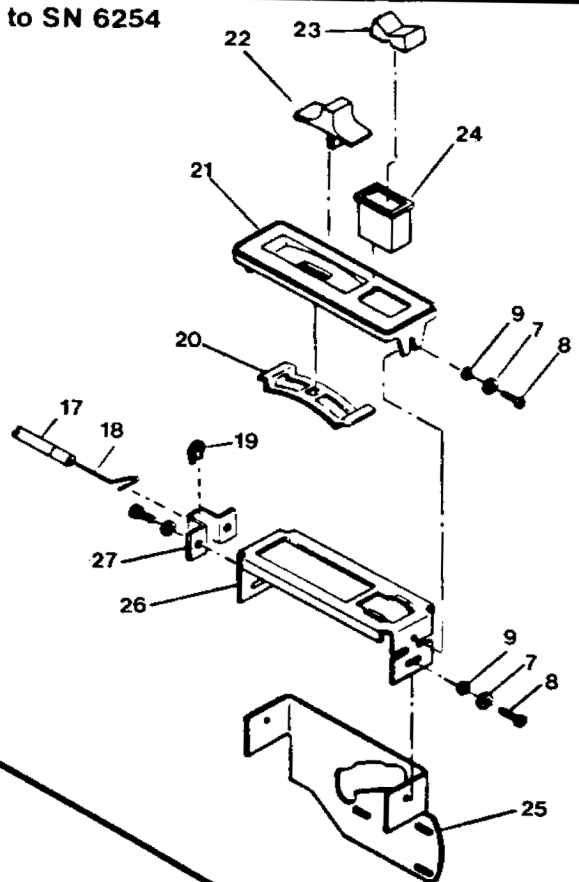
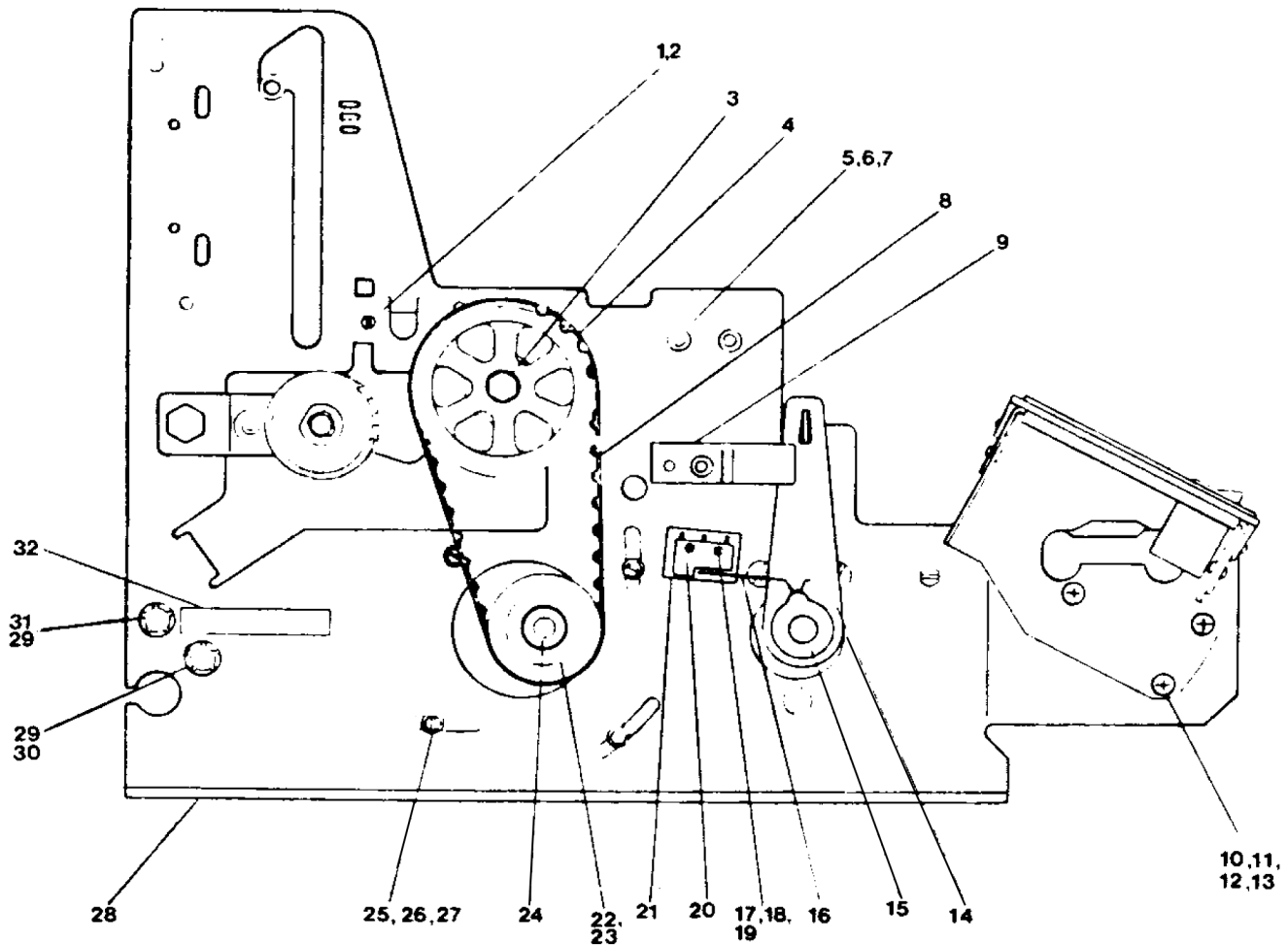


FIGURE 16

PART NUMBER REFERENCE GUIDE
(SEE PAGE 39)

1--9778777--SWITCH CONTROL PANEL
2--9776850--MODE SELECT CAP
3--9778464--FAST/STD LENS
4--9778465--AUTO/MANUAL LENS
5--9776848--MANUAL PUNCH CAP
6--9779322--MANUAL PUNCH SWITCH
7--9779910--LOCK WASHER
8--9779219--6/32 X 3/8 SCREW
9--9779897--FLAT WASHER
10-9776709--ADJUSTABLE SUPPORT
11-9776712--BRACKET
12-9779321--MODE SWITCH
13-9778419--INDICATOR SWITCH
14-9778420--LAMP
15-9778463--READY/WAIT LENS
16-9778462--INDICATOR SWITCH CAP
17-9779275--HOUSING CABLE
18-9776769--PUNCH SELECT CABLE
19-9779074--GRIP RING
20-9779273--COMPUTER DETENT SPRING
21-9778783--POWER SWITCH PANEL
22-9779359--SLIDE SELECTOR
23-9776849--ON/OFF CAP
24-9779320--ON/OFF SWITCH
25-9776710--ADJUSTABLE SUPPORT
26-9776711--SWITCH MTG BRACKET
27-9776858--BRACKET
28-9776940--POWER SWITCH PANEL

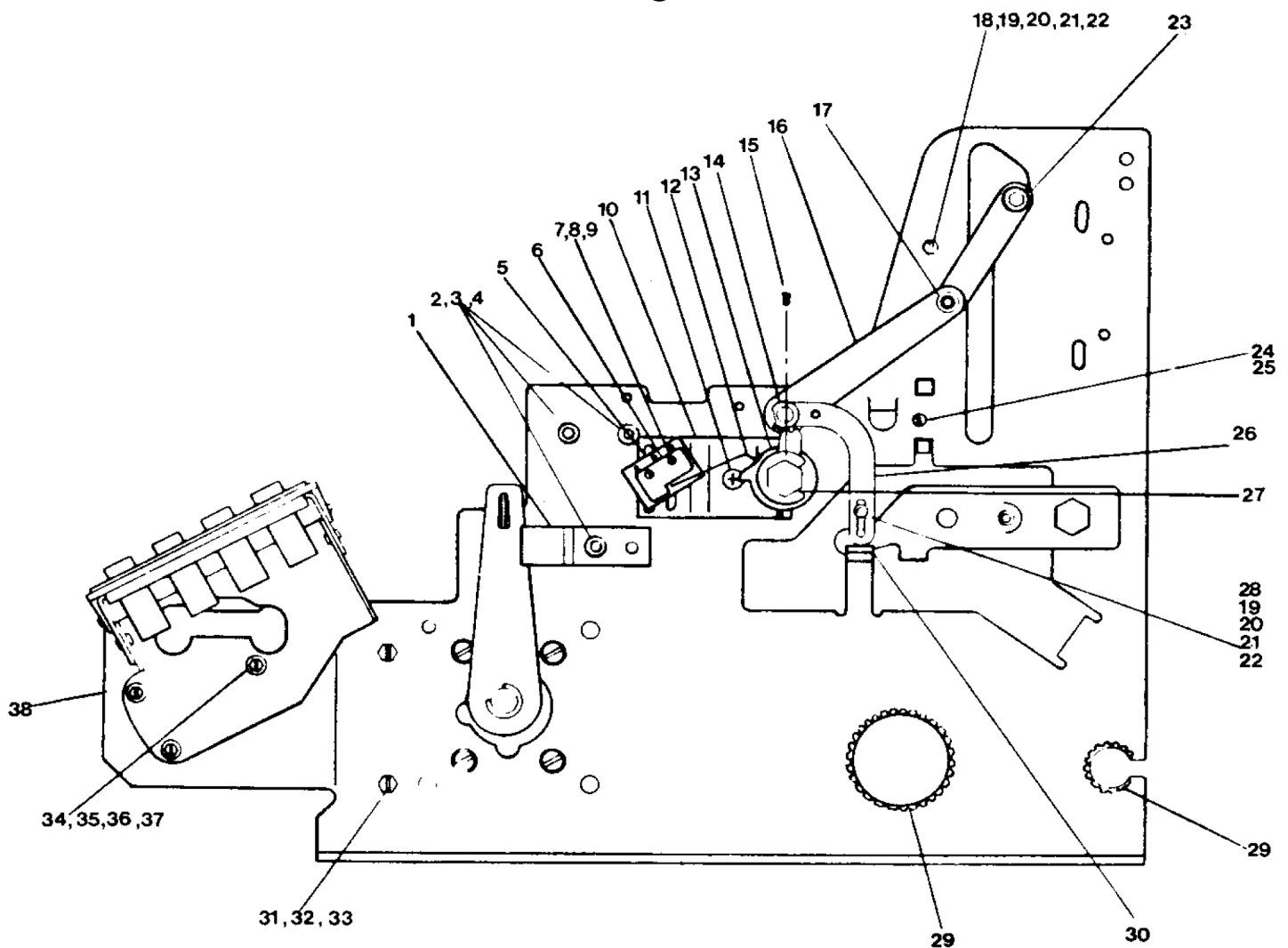
Figure 17



PART NUMBER REFERENCE GUIDE

1--9779222--8/32 X 1/2 SCREW	17--9779168--2/56 X 9/16 SCREW
2--9779911--LOCK WASHER	18--9779920--LOCK WASHER
3--9779072--E-RING	19--9778618--NUT PLATE
4--9778705--PULLEY	20--9779311--SWITCH Punch
5--9779141--1/4-20 X 7/8 SCREW	21--9778287--INSULATOR
6--9779913--LOCK WASHER	22--9778704--MOTOR PULLEY
7--9778591--1/4-20 NUT	23--9778665--ROLL PIN
8--9776613--TIMING BELT	24--9778565--BIND MOTOR
9--9776726--ZEE BRACKET	25--9779131--8/32 X 5/8 SCREW
10--9779173--6/32 X 1/2 SCREW	26--9779898--FLAT WASHER
11--9779910--LOCK WASHER	27--9779911--LOCK WASHER
12--9779897--FLAT WASHER	28--N/A--L.H. SIDE PLATE
13--9778588--6/32 NUT	29--9778084--FUSEHOLDER
14--9778461--PUNCH LINK	30--9778078--1/2 AMP FUSE
15--9776851--PUNCH CAM	31--9778083--10 AMP FUSE
16--9776353--ACTUATOR	32--9776896--FUSE WARNING DECAL

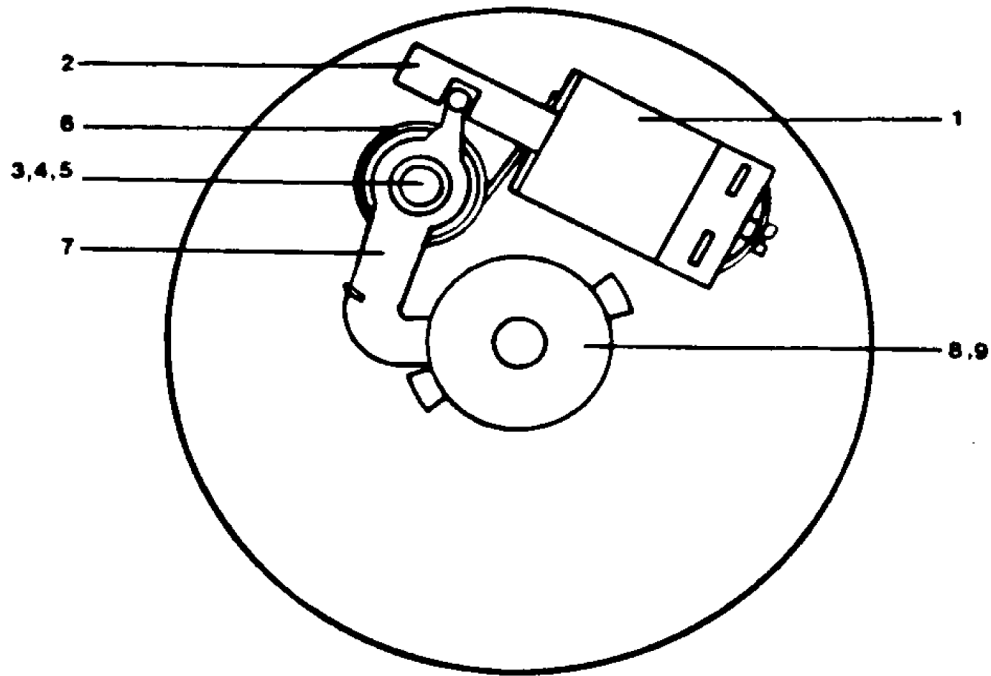
Figure 18



PART NUMBER REFERENCE GUIDE

1--9776958--BRACKET	20--9779896--FLAT WASHER
2--9779141--1/4-20 X 7/8 SCREW	21--9779909--LOCK WASHER
3--9779913--LOCK WASHER	22--9778587--4/40 NUT
4--9778591--1/4-20 NUT	23--9778460--P. BAR RETURN LINK
5--9778287--INSULATOR	24--9779912--LOCK WASHER
6--9779311--SWITCH	25--9779222--8/32 X 1/2 SCREW
7--9779168--4/40 X 9/16 SCREW	26--9776394--DRIVE ARM
8--9779920--LOCK WASHER	27--9778467--CONNECTING LINK
9--9778618--NUT PLATE	28--9779170--4/40 X 3/4 SCREW
10--9776958--BRACKET	29--9778118--GROMSTRIP
11--9779219--6/32 X 3/8 SCREW	30--9778796--RUBBER PAD
12--9776354--ACTUATOR	31--9779175--8/32 X 1/2 SCREW
13--9778116--DRIVE GEAR	32--9779911--LOCK WASHER
14--9779069--E-RING	33--9779911--FLAT WASHER
15--9779194--6/32 X 1/4 SCREW	34--9779173--6/32 X 1/2 SCREW
16--9776380--P. BAR RETURN ARM	35--9779910--LOCK WASHER
17--9778609--SPEED NUT	36--9779897--LOCK WASHER
18--9779169--4/40 X 1/2 SCREW	37--9778588--6/32 NUT
19--9779090--DRIVE ARM ROLLER	38--N/A--R.H. SIDE PLATE

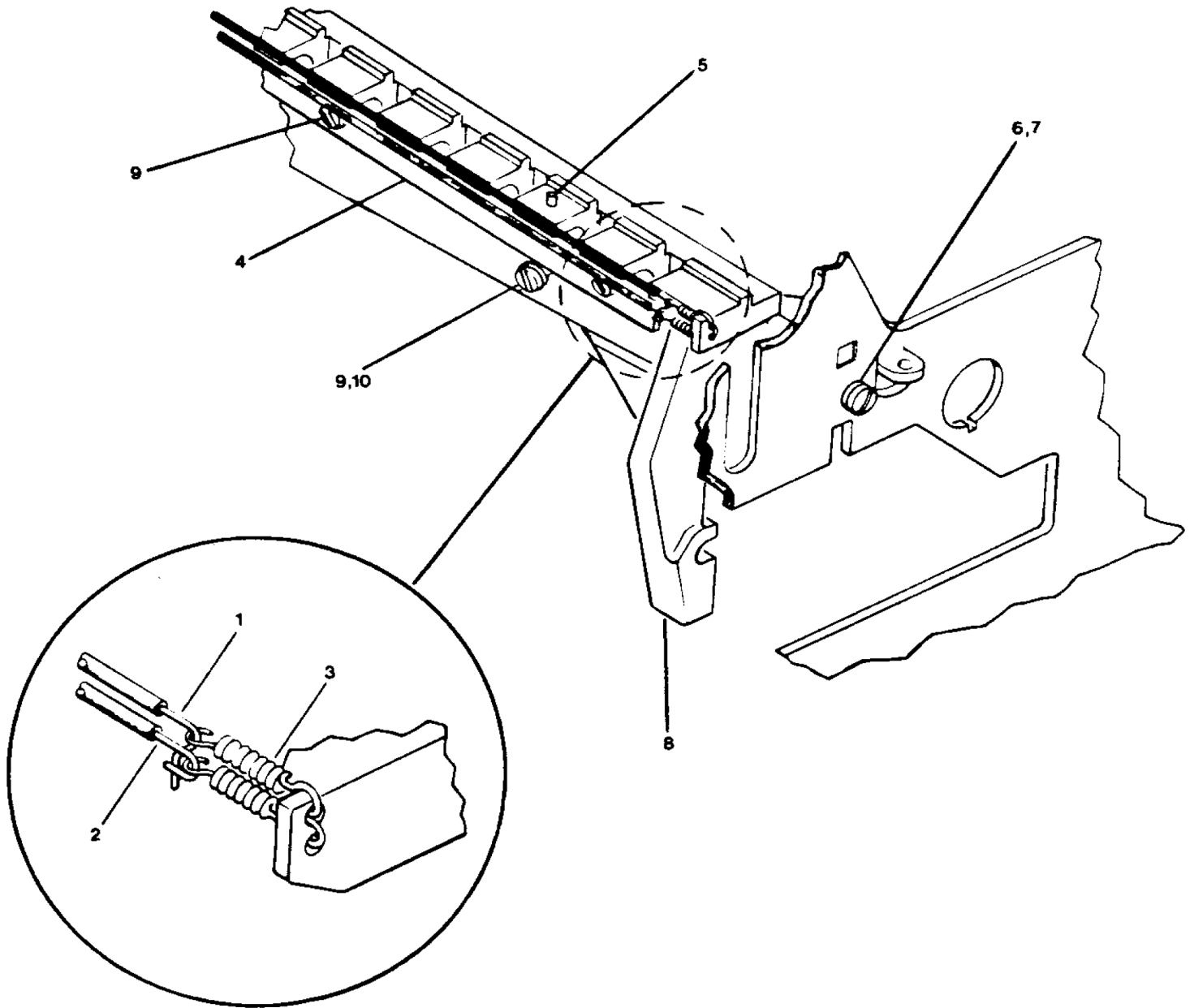
Figure 19



PART NUMBER REFERENCE GUIDE

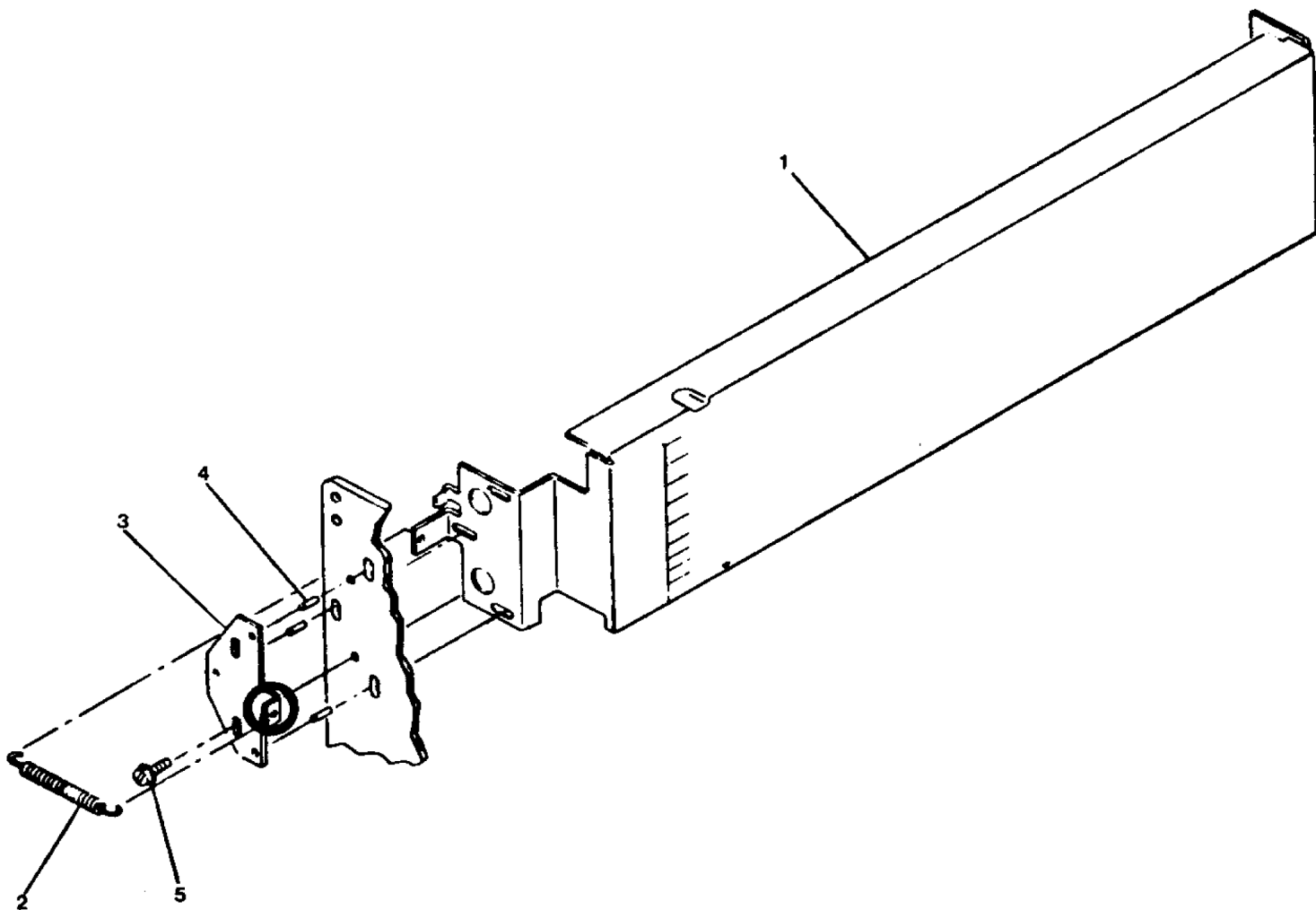
1--9776316--115 SOLENOID KIT
2--9776320--PLUNGER
3--9776313--6/32 X 1/4 SCREW
4--9776312--LOCK WASHER
5--9776311--FLAT WASHER
6--9776309--SPRING
7--9776310--LEVER ARM
8--9776308--HUB
9--9776314--SET SCREW

Figure 20



PART NUMBER REFERENCE GUIDE

- 1--9779958--UPPER WIPER
- 2--9779957--LOWER WIPER
- 3--9779276--EXTENSION SPRING
- 4--9776731--STRIPPER BRACKET
- 5--9778689--LOCATING PIN
- 6--9779178--10/24 X 1/2 SCREW
- 7--9779912--LOCK WASHER
- 8--9776700--BRIDGE
- 9--9779222--8/32 X 3/8 SCREW
- 10--9779898--FLAT WASHER



PART NUMBER REFERENCE GUIDE

1--9776727--BACKSTOP
2--9779261--SPRING
3--9778753--ADJ. PLATE
4--9778671--GROOVE PIN
5--9779219--6/32 X 3/8 SCREW
#'S 1-5 PRIOR TO S/N 7318

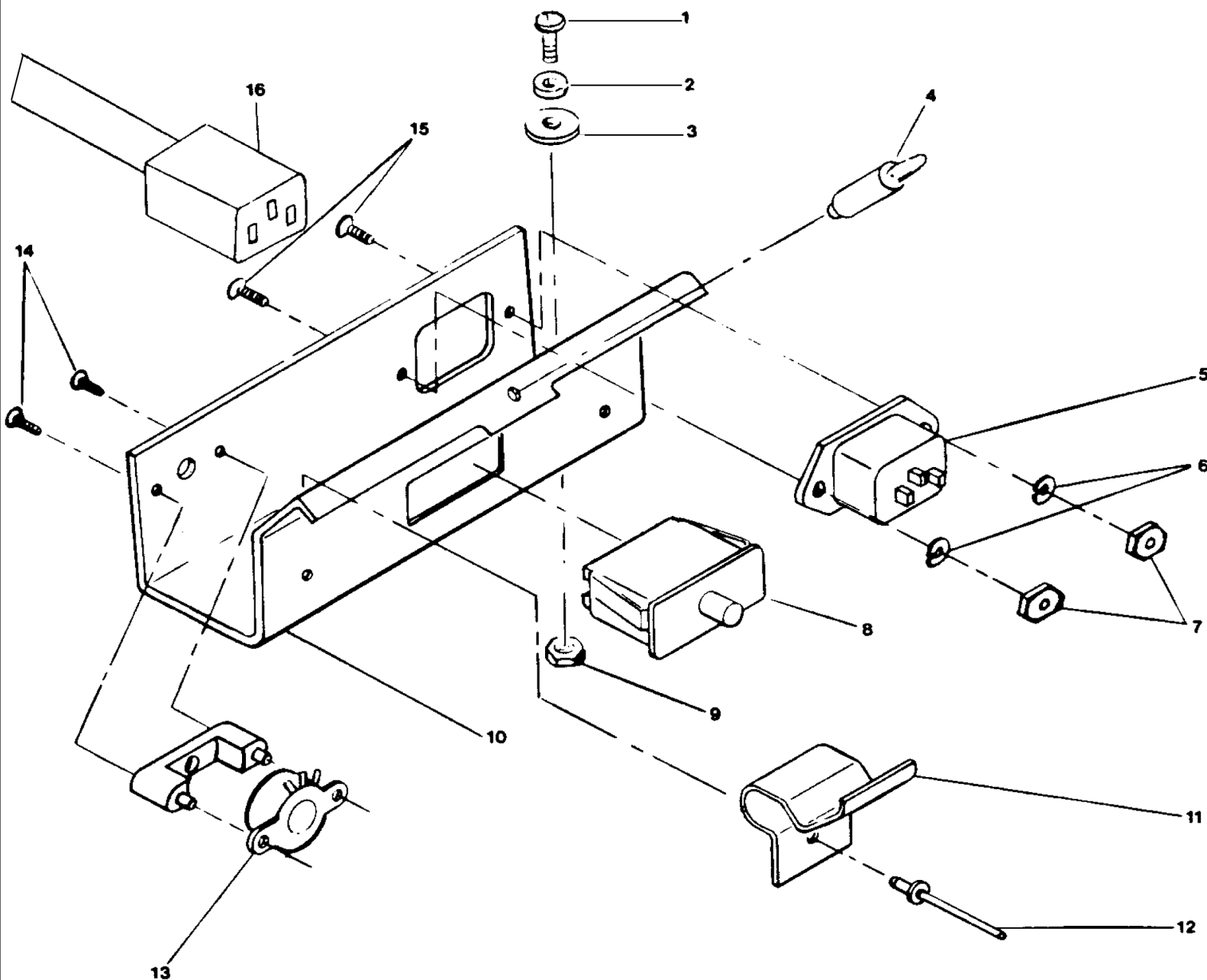
N/A-9776932-BACKSTOP
(AFTER S/N 7318)

NOTE: If a customer does not use computer strips, then the floating backstop should be made stationary. Remove the adjustable plates (Item 3). Using a vise grip, or pliers, break off the spring tabs (note circle) in order to mount the plates on the inside of the backstop ears. (note that you have to turn the plates around in order for the holes to line up).

This diagram shows an exploded view of a mechanical assembly. The main components are labeled with numbers 1 through 14. Part 1 is a long, thin rod or shaft. Part 2 is a bracket or plate with two slots. Part 3 is a circular component, possibly a pulley or a wheel. Part 4 is a small pin or bush. Part 5 is a small rectangular plate. Part 6 is a small circular component. Part 7 is a small circular component. Part 8 is a small circular component. Part 9 is a small circular component. Part 10 is a small circular component. Part 11 is a small circular component. Part 12 is a small rectangular plate. Part 13 is a bracket or plate with two slots. Part 14 is a small pin or bush. The diagram shows how these parts fit together to form a complete assembly.

1--9779235--ECCENTRIC SHAFT
2--9778363--RH CUTTER ARM ASSY.
3--9778766--TEFLON WASHER
4--9779072--E-RING
5--9778666--ROLL PIN
6--9779084--ROLLER
7--9778589--8/32 HEX NUT
8--9779911--LOCK WASHER
9--9779346--SHOULDER SCREW
10--9779260--EXTENSION SPRING
11--9779222--8/32 X 3/8 SCREW
12--9778751--RETAINING PLATE
13--9776384--LH CUTTER ARM ASSY.
14--9776376--EXTRUDER ARM

Figure 23



PART NUMBER REFERENCE GUIDE

1--9779136--10/24 X 5/8 SCREW
 2--9779912--LOCK WASHER
 3--9779899--FLAT WASHER
 4--9779370--PCB SPACER
 5--9779047--RECEPTACLE
 6--9779909--LOCK WASHER
 7--9778587--4/40 NUT
 8--9779327--INTERLOCK SWITCH

9--9778590--10/24 NUT
 10--9776733--INTERLOCK BRACKET
 11--9779277--SPRING LATCH
 12--N/A--RIVET
 13--9776904--POTENTIOMETER
 14--9779209--4/24 X 1/4 SCREW
 15--9779185--4/40 X 5/8 SCREW
 16--9779940--POWER CORD