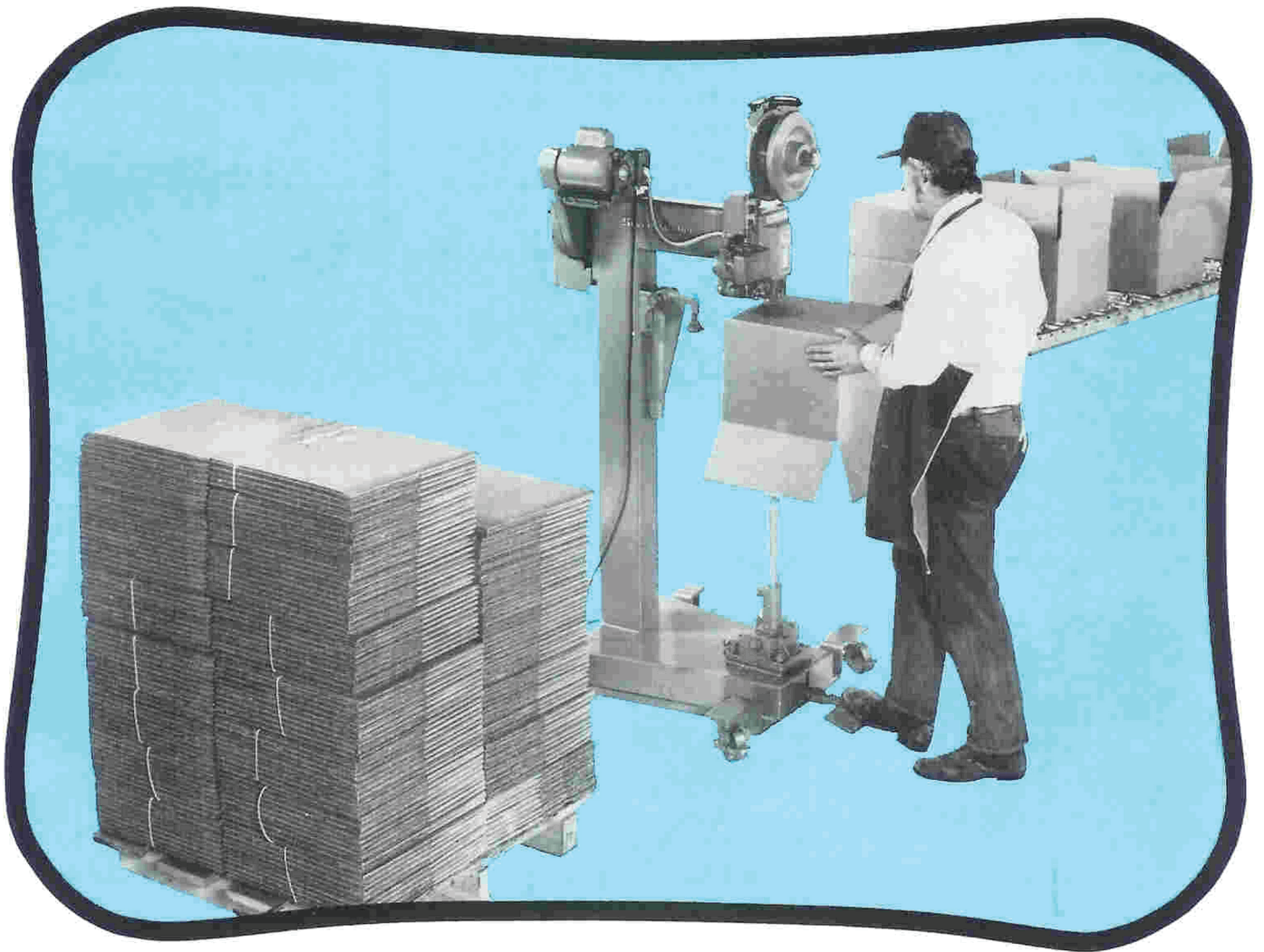


GUIDE TO STITCHING MACHINES FOR BOX SETUP



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SET UP CORRUGATED AND SOLID

Low-Cost
Safe
Fast
Strong

Why pay more than you need to pay for a closure system to assemble corrugated and/or fibreboard containers?

ISP stitching systems, machines, accessories and stitching wire can help you achieve faster box set-up, better results – at less cost than other methods.

Why pay more for pre-formed staples?

ISP stitching machines draw wire from a coil and automatically cut, form, drive and clinch about five staple-like stitches per second. You can feed as much as a mile of continuous wire without reloading.

The most complete line in the industry.

ISP designs and builds a wider range of stitching machines than any other manufacturer. You are assured of getting the machine that will best meet your exact requirements. Also, ISP supplies both stitching machines and stitching wire. This single-source responsibility is your best assurance that the machine you buy will do the job you bought it to do.

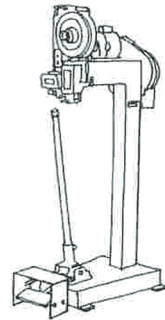
Important safety features.

All Models include as standard the following important features:

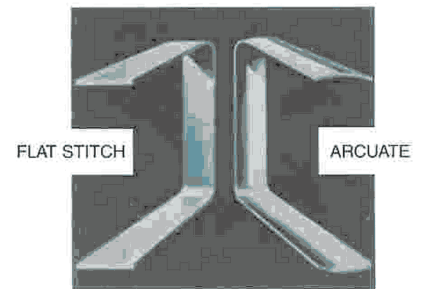
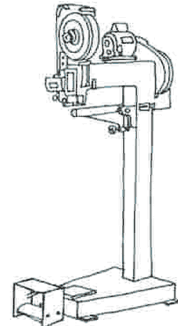
- Completely enclosed head and feed wheels.
- Parts are color-coded to comply with O.S.H.A. requirements.
- An improved finger guard protects the operator from the front and sides of the stitching head.
- Motor starter is on the front of the machine in close proximity to the operator.
- Low voltage protection switch prevents machine from recycling after power failure. Machine must be reset manually.
- Foot pedal guard prevents accidental cycling of machine.

Fast, low-cost assembly of conventional style boxes

ASSEMBLY WITH



ASSEMBLY WITH



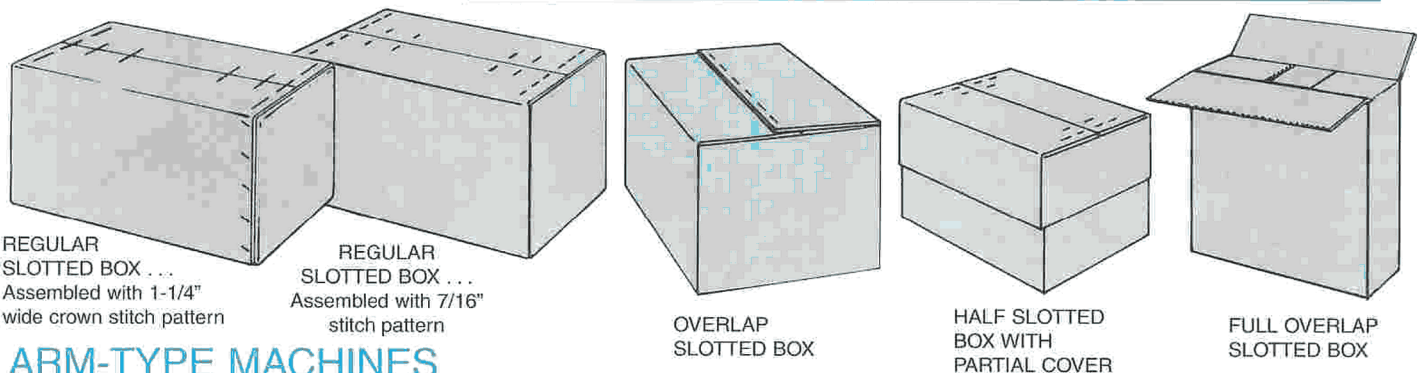
THE MODERN WAY TO FIBREBOARD BOXES FOR SHIPPING

Illustrated on these pages are some of the conventional-style boxes that can be stitched with ISP post or arm machines. For this purpose, stitches of both 7/16" and 1-1/4" crown size are standard, meeting all rail and motor carrier regulations.

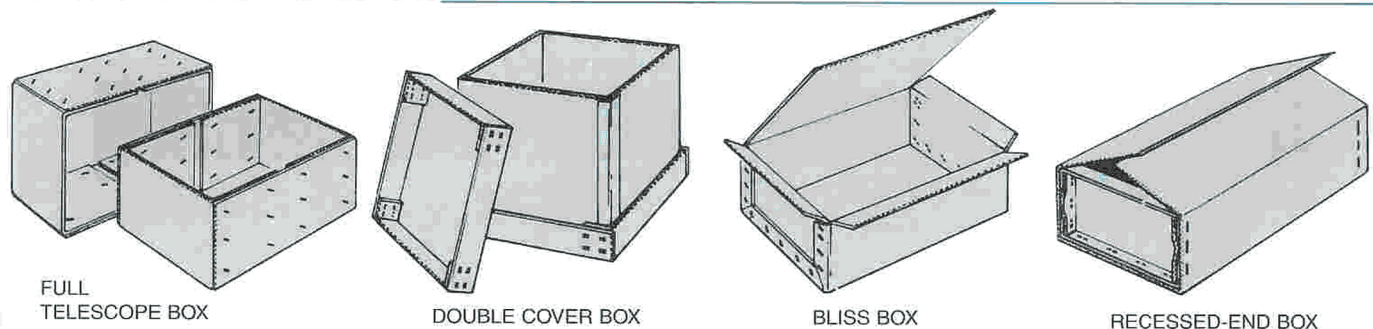
Operators using the newer, faster 1-1/4" Wide Crown machines can assemble up to 450 regular slotted cartons an hour with a single-head stitcher, and as many as 600 an hour with dual-head equipment. This is up to 50% faster than the narrower 7/16" crown size.

Regular slotted boxes are in more general use than any other style box, and are adapted to shipment of most commodities. They can be assembled on the post-type stitchers shown in this brochure. Arm-type stitchers are used for telescope boxes, recessed-end boxes, Bliss boxes and tubes with caps.

POST-TYPE MACHINES



ARM-TYPE MACHINES



Advanced Arcuate Shape

Produces stronger stitches, minimizes machine maintenance.

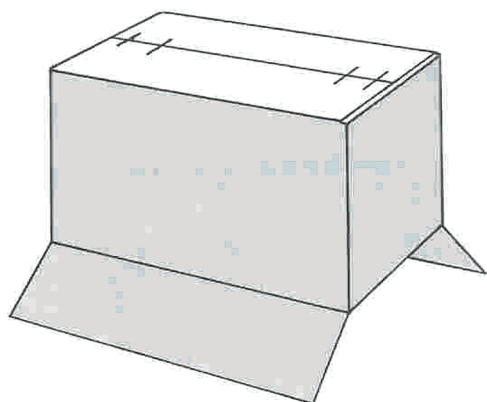
Many shippers and box makers now set up or make their own boxes in less time, at reduced cost, using ISP's Arcuate Stitching method. As flat wire is run through stitchers equipped for Arcuate Stitching, its cross section is flexed into permanent arc-shape for greater strength and penetration. There are important advantages:

- Cuts material costs. Less wire is used. Often it can be of lighter gauge due to its arc-increased-strength.
- Arc-shaped wire greatly increases driving and clinching strength. Greater strength reduces machine wear.
- Looks neater. Exposed surface of the Arcuate Stitch is round and

smooth. Boxes are set-up stronger and more economically and have more customer appeal.

- Adapts to many machines. Nearly all ISP Stitchers - and many other makes - can be converted for Arcuate Stitching with our handy conversion kit. Available at ISP.

TITCH

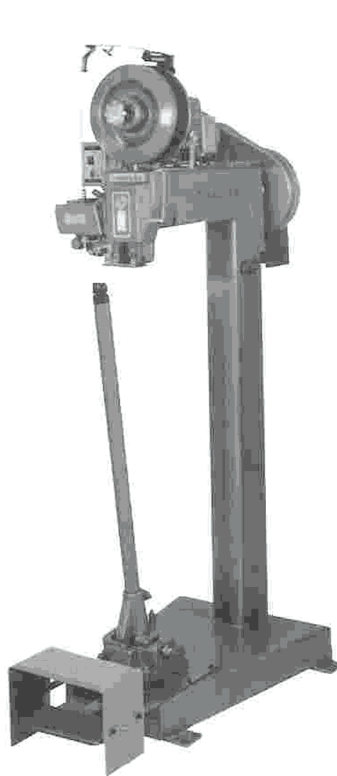


Use a Post-type stitcher for setting up regular slotted boxes, overlap slotted boxes, full overlap boxes or half-slotted boxes with partial covers. Post-type stitchers close bottoms of slotted boxes quickly, securely...to meet all carrier regulations. Select a model to meet your production requirements, using either narrow or wide crown stitching heads.

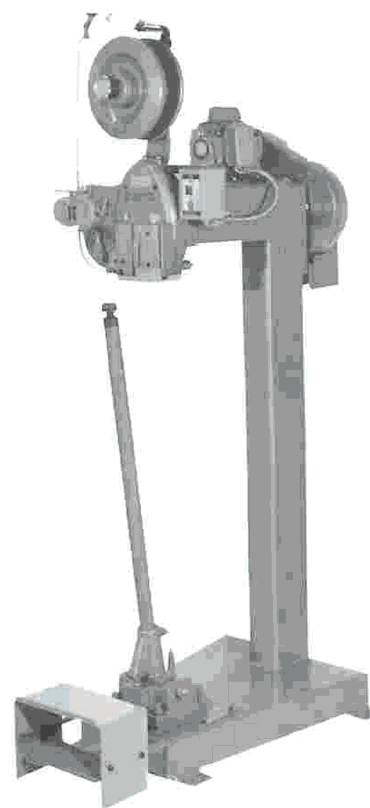
For production up to 3000 boxes per day, choose a regular duty Silverstitcher. These proven units let you set up as many as 350 RSC boxes per hour...all day long.

For greater production and longer runs, a Dual-head Silverstitcher places two stitches simultaneously...lets you set up as many as 600 boxes per hour.

For heavy-duty work, such as stitching three pieces of single wall corrugated, two pieces of double or triple wall, or for assembly of solid fibreboard boxes, select an ISP Heavy-duty stitcher.



**Regular duty
HF16P
Silverstitcher**



**Heavy duty
S5F25P
Stitcher**

SPECIFICATIONS

	MODEL NUMBER	DISTANCE FROM FRONT OF FRAME TO CLINCHER	DISTANCE FROM FRONT OF FRAME TO CLINCHER	MAXIMUM SIZE BOX HANDLED (INCLUDING TOP FLAPS)		APPROXIMATE SHIPPING WEIGHT (POUNDS)
				WIDTH	DEPTH	
REGULAR DUTY SINGLE HEAD	HF16P	16"	41-1/2"	32"	41-1/4"	430
	HF25P HF25A	25"	41-1/2"	50"	41-1/4"	477
REGULAR DUTY DUAL HEADS	HF16DP HF16DA	16"	39-1/2"	24"	39-1/2"	615
	HF25DP HF25DA	25"	41-1/2"	40"	41-1/2"	665
HEAVY DUTY SINGLE HEAD	S5F16P S5F16A	16"	41-1/2"	32"	41-1/4"	480
	S5F25P S5F25A	25"	41-1/2"	50"	41-1/4"	527

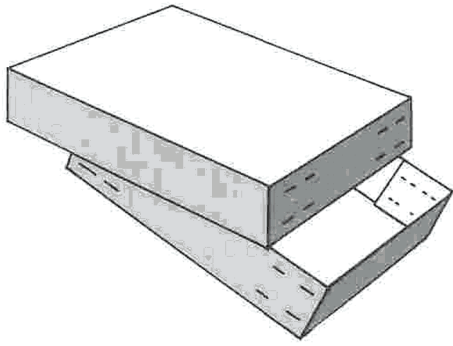
NOTES:
7/16" crown stitch is standard.
1-1/4" crown optional.
All standard sizes of flat stitching wire can be used on these machines.

All post type machines can be furnished with extra height frames.

Standard motor is 1/3 hp, 1725 R.P.M., single phase, 115 volt, 60 Cycle, AC. Special motors available as required.

* Base is approximately 4-1/4" high on HF and S5F

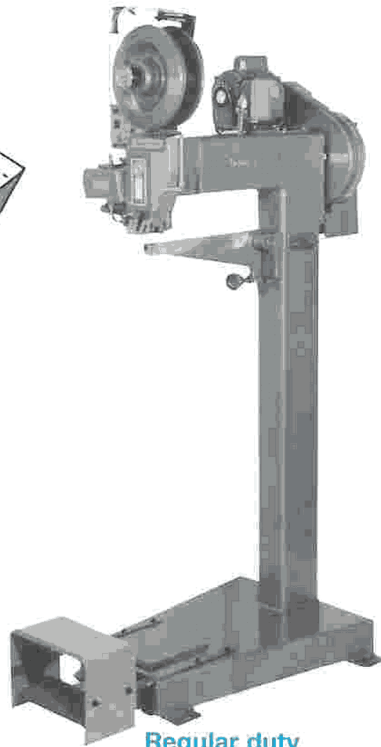
ARM-TYPE STITCHERS



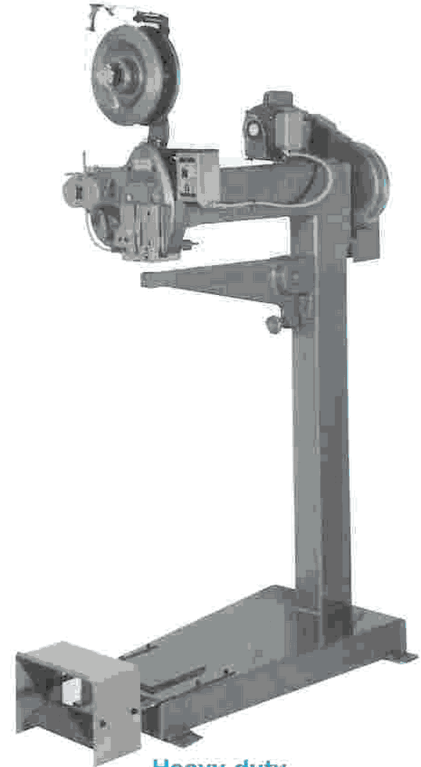
Arm-type stitchers speed stitchers of corrugated trays and baskets; telescope, Bliss and end-closed boxes; also solid fibre drums and boxes.

For longer high-production runs and less downtime, use dual-heads with 25-lb. coil holders.

Optional equipment includes a fatigue-reducing electric trip pedal.



**Regular duty
Single-head
HF16A Silverstitcher**



**Heavy duty
Single-head
S5F25A Silverstitcher**

STITCHERS FOR THE FRUIT & PRODUCE INDUSTRY

Gas engine and electric box stitchers

ISP's Model HD16PG Silverstitchers are designed and built to operate at high speeds under field packing conditions, with minimum requirements for adjustment and maintenance. Powered by a 3 H.P. gasoline engine, the unit speeds assembly of fruit and produce boxes in the field. The Model HD16PGE with 1/2 H.P. electric motor is ideal for shed packing.

These stitchers include all features of the standard HF16P, Plus:

- Redesigned clutch mechanism with alloy steel drive shaft and front and rear sealed ball bearings for longer life.
- New brake with greater braking surface has been located behind head plate for more convenient adjustment and protection from the elements.
- Alloy steel heat-treated feed gears and new design idler gear stud.
- Improved coil holder bracket is made from heavier gauge steel... and with added brace.

**Model HD16PGE
Silverstitcher
for fruit and
produce
packing**



COMBINATION POST & ARM STITCHERS

Highly versatile machines. Stitch telescope boxes, trays, regular slotted bottoms, sides and ends of solid fibre drums. Handy for shippers and box users whose box styles require both post and arm-type stitching capabilities.



**Regular duty
HF16C Silverstitcher**



**Heavy duty
S5F16C Silverstitcher**

SPECIFICATIONS

	MODEL NUMBER	DISTANCE FRONT OF FRAME TO CLINCHER	DISTANCE* FROM TOP OF BASE TO CLINCHER	MAXIMUM SIZE BOX HANDLED (INCLUDING TOP FLAPS)		APPROXIMATE SHIPPING WEIGHT (POUNDS)
REGULAR DUTY SINGLE HEAD	HF16C	16"	41-1/2"	32"	41-1/4"	450
	HF25C	25"	41-1/2"	50"	41-1/4"	499
HEAVY DUTY DUAL HEADS	S5F16C	16"	41-1/2"	32"	41-1/4"	500
	S5F25C	25"	41-1/2"	50"	41-1/4"	549
REGULAR DUTY DUAL HEAD	HF16DC	16"	39-1/2"	24"	39-1/2"	555
	HF25DC	25"	41-1/2"	40"	41-1/2"	685

NOTES: 7/16" crown stitch is standard; 1-1/4" crown optional. All standard sizes of flat stitching wire can be used.

All machines can be furnished with extra-height frames.

Standard motor is 1/3 h.p., 1725 R.P.M., single phase, 115 Volts, 60 Cycle, AC.

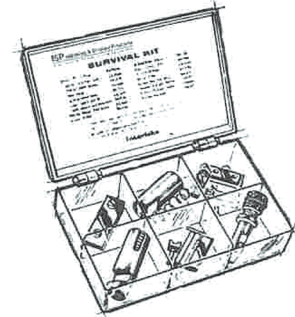
Special motors are available.

* Base is approximately 4-1/4" high on HF and S5F models

ACCESSORIES

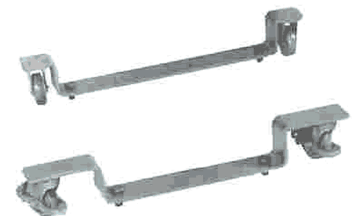
SURVIVAL KIT

Contains the most common wear items for instant repairs on the job.



CASTER DOLLY

Enables you to move stitcher to where it's needed...with ease.



SAFETY KITS

Are available for older industrial stitchers. For additional information, call 1-800-345-6641, or outside the USA 262-632-5115. Please provide model number, serial number and year built.

OPTIONS

- Increased height
- Various crown sizes available
- Various wire sizes available
- Electric trip
- Pedal extensions
- Post locks

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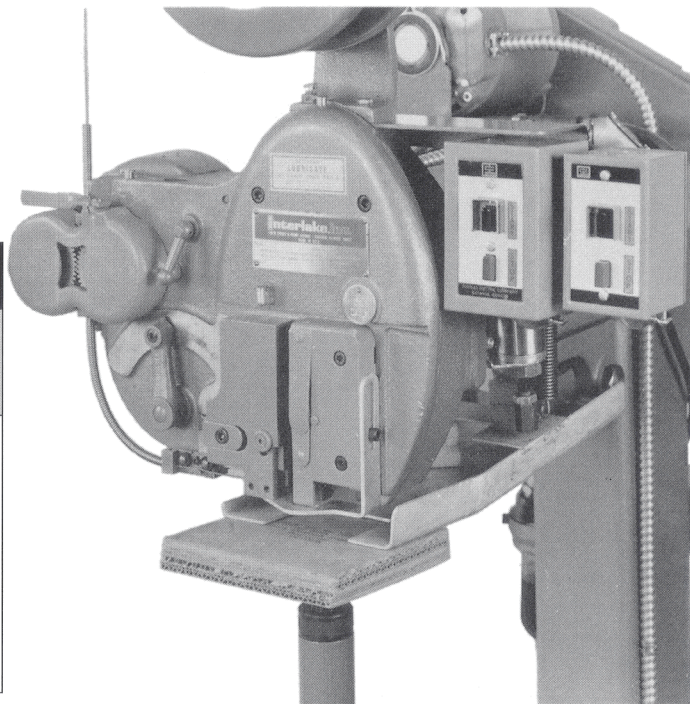
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TRIPLE WALL BOX STITCHER ISP Stitching & Bindery Products

Stitches triple wall corrugated without pre-crushing

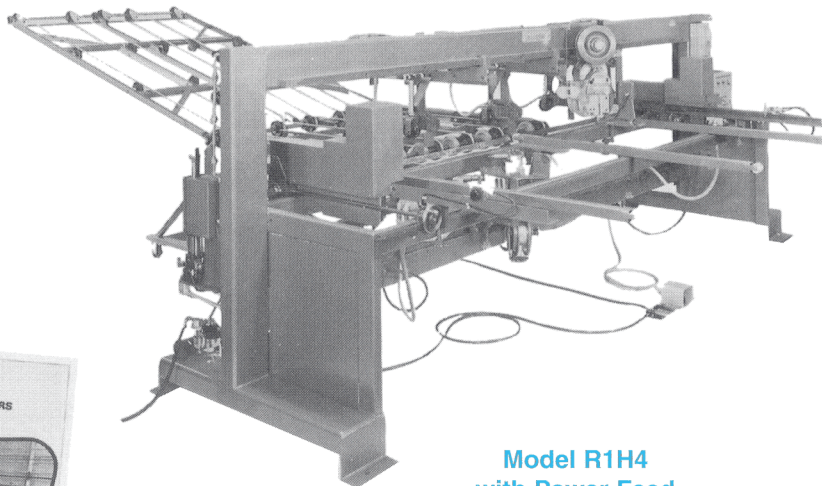
The ISP S5F heavy-duty stitcher completely penetrates and clinches two thicknesses of triple wall corrugated board without the unsightly, weakening effects of pre-crushing. The machine can also drive stitches through two or more thicknesses of single wall corrugated. Unique pneumatic flap hold-down device greatly simplifies the stitching operation.



SPECIFICATIONS				
MODEL NUMBER	DISTANCE FRONT OF FRAME TO CLINCHER	DISTANCE FROM TOP OF BASE TO TO CLINCHER	APPROXIMATE SHIPPING WEIGHT (POUNDS)	
S5F16PJ	16"	41-1/2"	575	NOTES: Standard motor 1/3 hp (1725 R.P.H.), 115V, AC, 60 Cycle, single phase. Air pressure: 60 psi. Stitch crown: 5/8" Wire size: .103" x .028" Wire draw: 1-3/8" min., 3-1/4" max. Leg length: 7/16" min., 1-5/16" max. Base height: 4-1/4"
S5F25PJ	25"	41-1/2"	735	
S5F16AJ	16"	41-1/2"	525	
S5F25AJ	25"	41-1/2"	710	
S5F16CJ	16"	41-1/2"	600	
S5F25CJ	25"	41-1/2"	760	

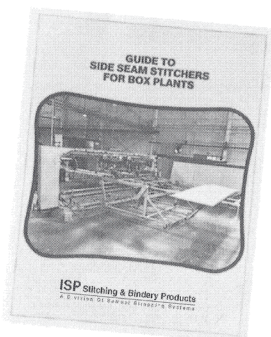
MANUFACTURERS JOINT STITCHER

ISP's Model R1H4 Manufacturers Joint Stitcher, with two proven S5 heavy-duty stitching heads, easily stitches single, double and precrushed triple-wall two-piece boxes in a single pass. Highly versatile, the unit stitches contour boxes with one manufacturers joint longer than the other, and can also stitch one-piece boxes using the upper head only. The R1H4 features automatic power feed and an exit conveyor for greater productivity.



**Model R1H4
with Power Feed**

An 8-page catalog, "GUIDE TO SIDE SEAM STITCHERS FOR BOX PLANTS", describes ISP's entire line of side seam stitchers. Included are hand machines with table, self-contained head for use on a jib boom, and the hand-fed R1H1 manufacturers joint stitcher. For your copy of Form CA-816R, contact the Stitching Dept. at ISP.



1-800-345-6641

Not available through distributors

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CONTROLLED QUALITY FLAT WIRE

Every coil of ISP wire meets standards of top performance. Here are just a few advantages of our careful quality control.

- Precision-made . . . Quality standards applied to the steel stock are exceptionally high to maintain proper, consistent temper of every coil. These high standards result in smoother feeding through the stitcher, more solid stitches in containers.
- Electro-Galvanized . . . A heavy zinc coating is electrically bonded to ISP

stitching wire for rust resistance.

- Proper Penetration . . . High quality carbon steel stitches penetrate smoothly, easily. The steel is made precisely soft enough to bend at stitch points without cracking, yet strong enough to drive readily through the toughest materials. ISP wire stitches hold securely under all climatic conditions, even extreme dampness or dryness. They also hold better than other forms of closures on waxed or lacquered surfaces.

- Copper Coated . . . A softer metal than zinc, this finish reduces flaking and clogging, thereby providing longer run times and increased productivity.

- Level Wound Coils . . . ISP coils are precision wound to eliminate wire tangling and contribute to smooth high-speed feeding of wire for efficient stitching production.

Choose from a wide range of galvanized or copper wire sizes

Width	Thickness	Feet per lb.	**Length of wire used per stitch Number of stitches per pound of wire							
			7/8"	1-1/16"	1-3/16"	1-1/4"	1-5/16"	2-1/4"	2-1/2"	3-1/4"
.103"	.028"	105	1440	1186	1061	1008	960	560	504	388
.103"	.023"	129	1769	1457	1304	1238	1179	688	619	476
.103"	.020"	148	2030	1672	1496	1420	1353	790	710	546
.103"	.017"	175	2400	1976	1768	1680	1600	933	840	646
.103"	.014"	211	2894	2383	2132	2026	1929	1125	1013	779
.074"	.037"	111	1522	1254	1122	1066	1015	592	533	410
*.060"	.024"	222	3045	2507	2243	2131	2030	1184	1065	820
*.060"	.0205"	260	3566	2936	2627	2496	2377	1386	1248	960

* Available in 13 and 25-pound coils only

**Explanatory Legend - Length of wire used per stitch

Wire draw	Machine application	Wire draw	Machine application
7/8"	S5F - 7/16" crown - min. wire draw	2-1/4"	HF - 1-1/4" crown - 3/8" cutter blade
1-1/16"	HF - 7/16" crown - 3/16" cutter blade	2-1/4"	EBS - all models
1-3/16"	HF - 7/16" crown - 1/4" cutter blade	2-1/4"	S5F - 7/16" crown - maximum wire draw
1-1/4"	HF - 7/16" crown - 5/16" cutter blade	3-1/4"	S5F - 1-1/4" crown - maximum wire draw
1-5/16"	S5F - 7/16" crown - mid-point wire draw		

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