



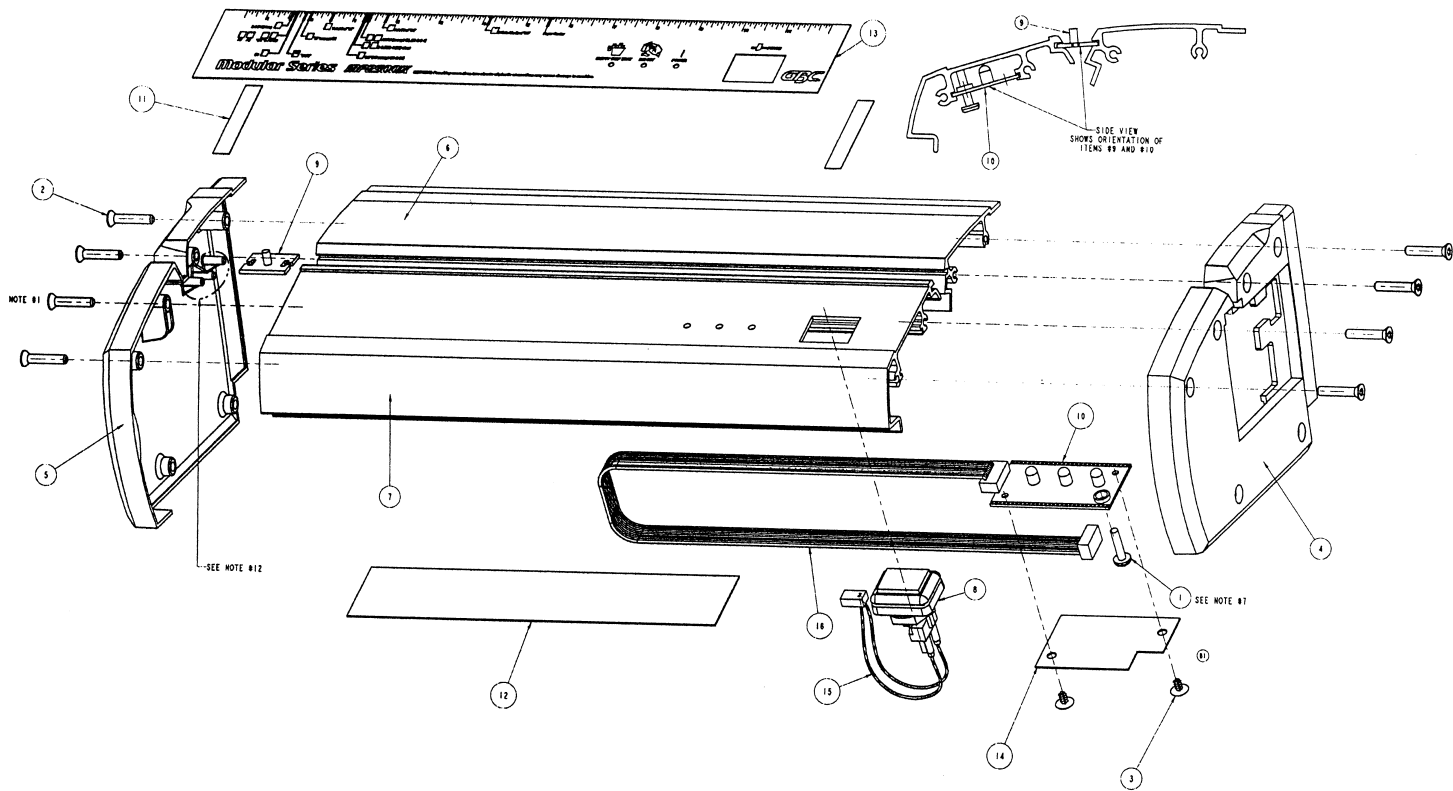
# MP2500IX Parts List



GBC IS AN ACCO BRANDS COMPANY

8.0 PARTS LIST - MP2500iX ELECTRIC PUNCH

Figure 8-1 - MP2500iX Parts, Machine Front Assembly

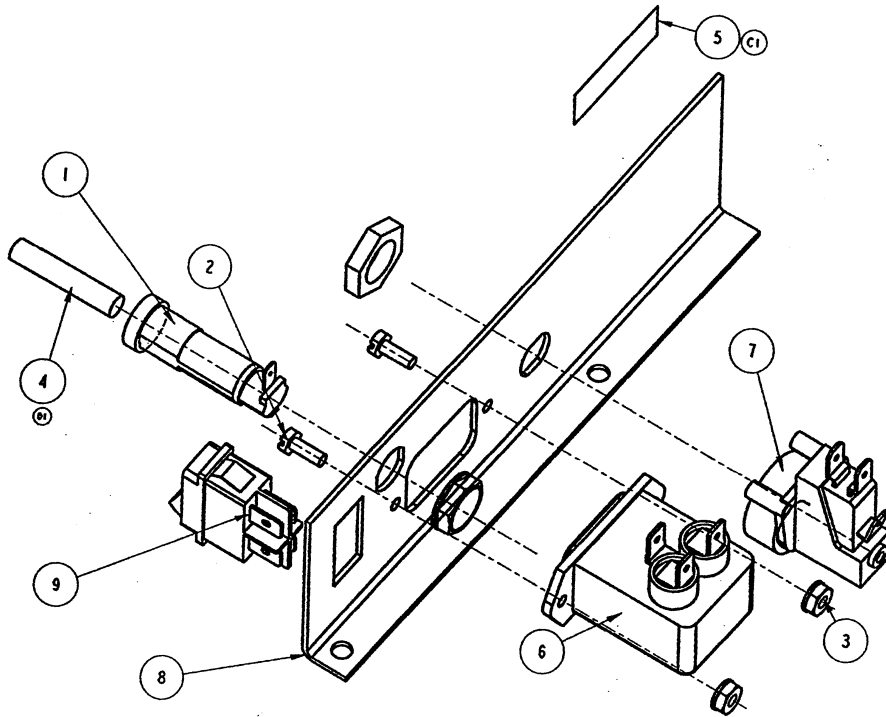


## 8.0 PARTS LIST - 640ID ELECTRIC PUNCH

### 8.1 Parts Listing, Machine Front Assembly

Index	Part Number	Description	Qty
1	1902828	SCREW, 8-32 x .75 PHIL PAN HEAD	1
2	1908801	SCREW, 10-32 x 1.0 F.H. SOCKET SCREW	8
3	1929606	PLASTIC RIVET	2
4	7704306	ENDCAP, RIGHT, POWDER COATED, 640ID	
5	7704307	ENDCAP, LEFT, POWDER COATED, 640ID	1
6	7704706S	DECK, BACK, POWDER COATED, 640ID	1
7	7704708S	DECK, FRONT, POWDER COATED, 640ID	1
8	7704336	SWITCH, START	1
9	7704348	PLATE, EDGE GUIDE ADJUSTMENT	1
10	7704349	PCB, LED, MODULAR PUNCH	1
11	7704364	LABEL, BLACK	2
12	7704369	WIRE RETAINER	1
13	7704709	LABEL, MAIN DECK, 640ID	1
14	7704446	LED BOARD COVER	1
15	7704495	CABLE ASSEMBLY, RUN SWITCH	1
16	7704497	CABLE ASSEMBLY, LED BOARD	1

## 8.0 PARTS LIST - 640ID ELECTRIC PUNCH



### 8.2 Parts Listing, Power Switch Assembly

Index	Part Number	Description	Qty
1	1132343	FUSE HOLDER, 115V	1
1	1155063	FUSE HOLDER, 230V	1
2	1907301	SCREW, 6-32 x .38 SLOT HEX HD	2
3	1926801	NUT, 6-32 KEPS	2
4	1970120	FUSE, 3A, 250V (for use with 115V model)	1
4	1970122	FUSE, 2 A, 250V (for use with 230V model)	1
5	6009402	LABEL, FUSE, 3A, 250V	1
5	1963906	LABEL, FUSE, 2A, 250V	1
6	6195001	SOCKET, POWER LINE, RFI FILTER 115V & 230V	1
7	6202046	SWITCH, PNEUMATIC	1
8	7704354	BRACKET, ELECTRICAL MOUNTING	1
9	7704376	ROCKER SWITCH	1

# 8.0 PARTS LIST - 640ID ELECTRIC PUNCH

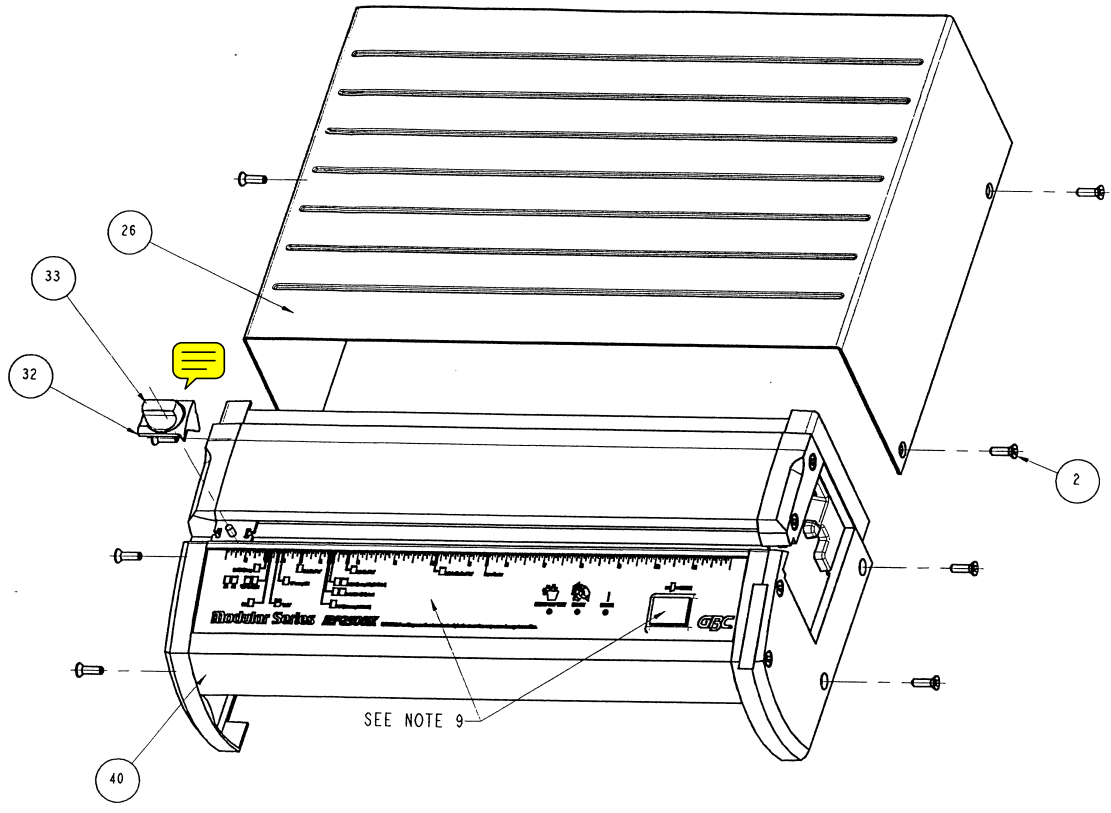


Figure 8-3 - 640ID Parts Page 8-5

8.0 PARTS LIST - MP2500iX ELECTRIC PUNCH

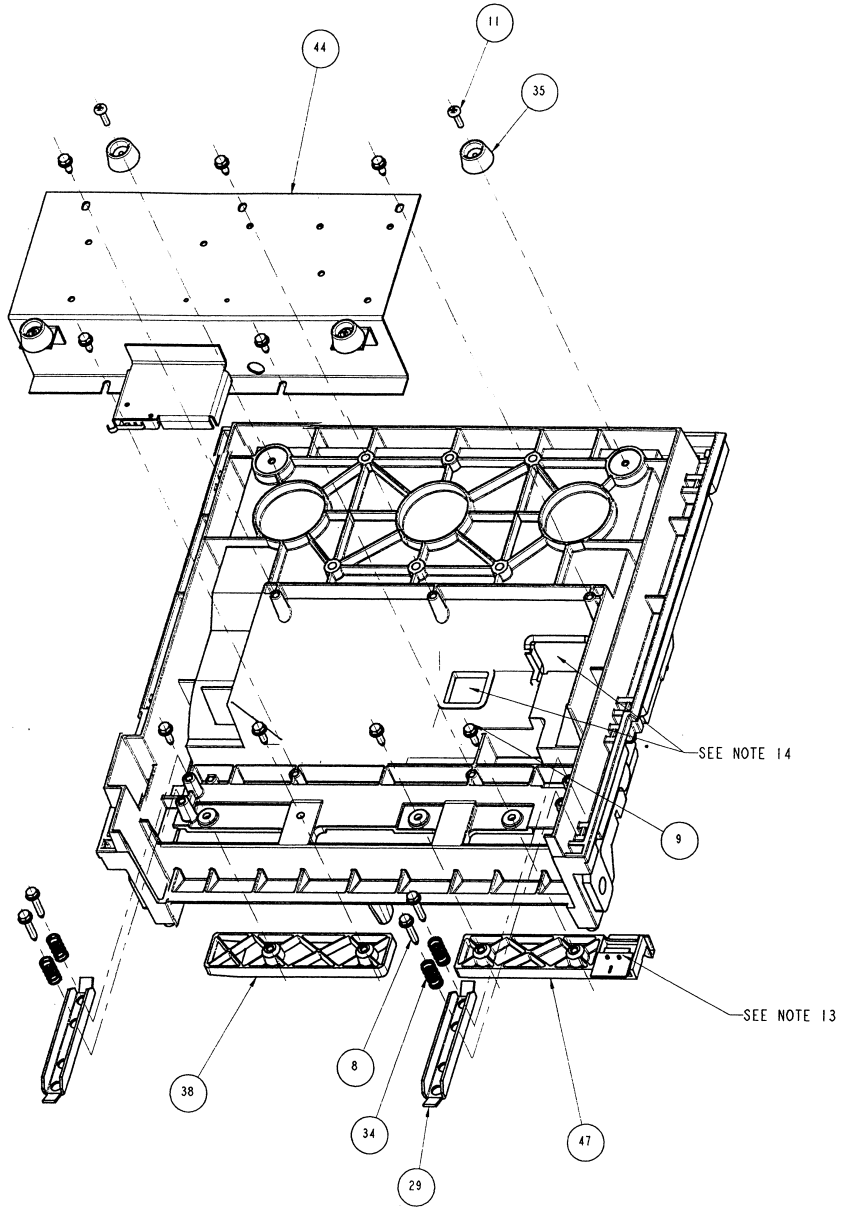


Figure 8-3 - MP2500iX Parts Page 8-6

### 8.0 PARTS LIST - MP2500iX ELECTRIC PUNCH

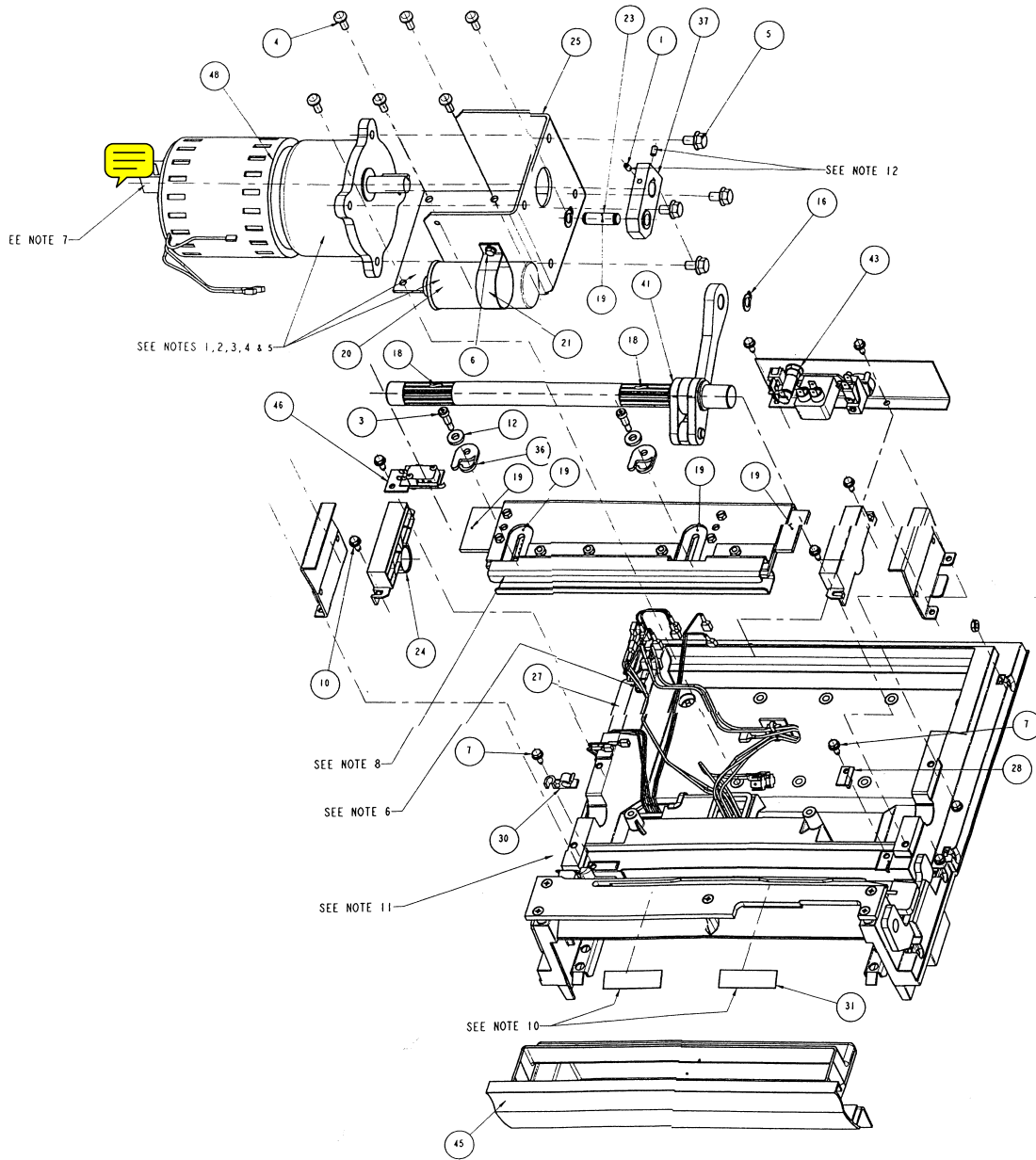


Figure 8-3 - MP2500iX Parts

## 8.0 PARTS LIST - MP2500iX ELECTRICPUNCH

### 8.3 Parts Listing

Index	Part Number	Description	Qty
1	1900001	SET SCREW, CUP, 10-32 x 3/8	2
2	1900613	SCREW, 10-32 x 2.25 S.H.C.	8
3	1900814	P-BAR SHOULDER BOLT 1/4-20 <b>(SEE N.S.B.264B)</b>	2
4	1951987	SCREW, 1/4 - 20 x 5/8 HX CAP W/NYLOCK	6
5	1903204	SCREW, 5/16-18 x .50 FLANGELOCK	4
6	1907101	SCREW, 10-32 x 11/16 SEMS HX WSH HD TAP SCR	5
7	1907105	SCREW, 10-32 x .50 ST HEX HD	3
8	1907210	SCREW, 10-32 x 1.0 ST HEX HD	4
9	1907215	SCREW, 10-32 x .63 ST HEX HD	4
10	1907807	SCREW, 10-32 x .50 ST HEX HD	11
11	1907843	SCREW, 8-32 x .75 PHIL PH	2
12	1953504	STAINLESS STEEL WASHER 1/8" <b>(SEE N.S.B. 264B)</b>	2
13	1926702	NUT, 10-32 KEPS	8
14	1931047	CABLE CLAMP	4
15	1931250	STRIP, EDGE CORD	1
16	1931612	RETAINING RING	2
17	1932123	TIE WRAP	4
18	1961503	GREASE, LUBRIPLATE #130 AA	2
19	1961531	OIL, GENERAL PURPOSE CITCO	5
20	6205030	CAPACITOR 35UF, 115V	1
20	6205035	CAPACITOR 230V	1
21	6205041	BRACKET, CAPACITOR	1
22	7301052	CABLE, GROUND (PART OF WIRE KIT)	1
23	7704375	BOLT, SHOULDER, PIVOT <b>(SEE N.S.B. 264D)</b>	1
	1927501	CASTLE NUT (NOT SHOWN)	1
	1930208	COTTER PIN (NOT SHOWN)	1
	1925185	LARGE SHIM (NOT SHOWN)	2
	1925136	SMALL SHIM (NOT SHOWN)	2
24	7704319	GUIDE	2
25	7704322	MOTOR MTG BRKT	1
26	7704443	HOUSING ASSEMBLY, WITH LABELS – 115V	1
26	7704373	HOUSING ASSEMBLY, WITH LABELS – 230V	1
27	7704329	BASE ASSEMBLY, MACH. & PAINT	1
28	7704331	PAD, ANTI-ROTATION	1
29	7704332	GUIDE, CHIPTRAY	2
30	7704333	DETENT, DIE SET, MOD PUNCH	1
31	7704335	DEFLECTOR, MODULAR PUNCH	2



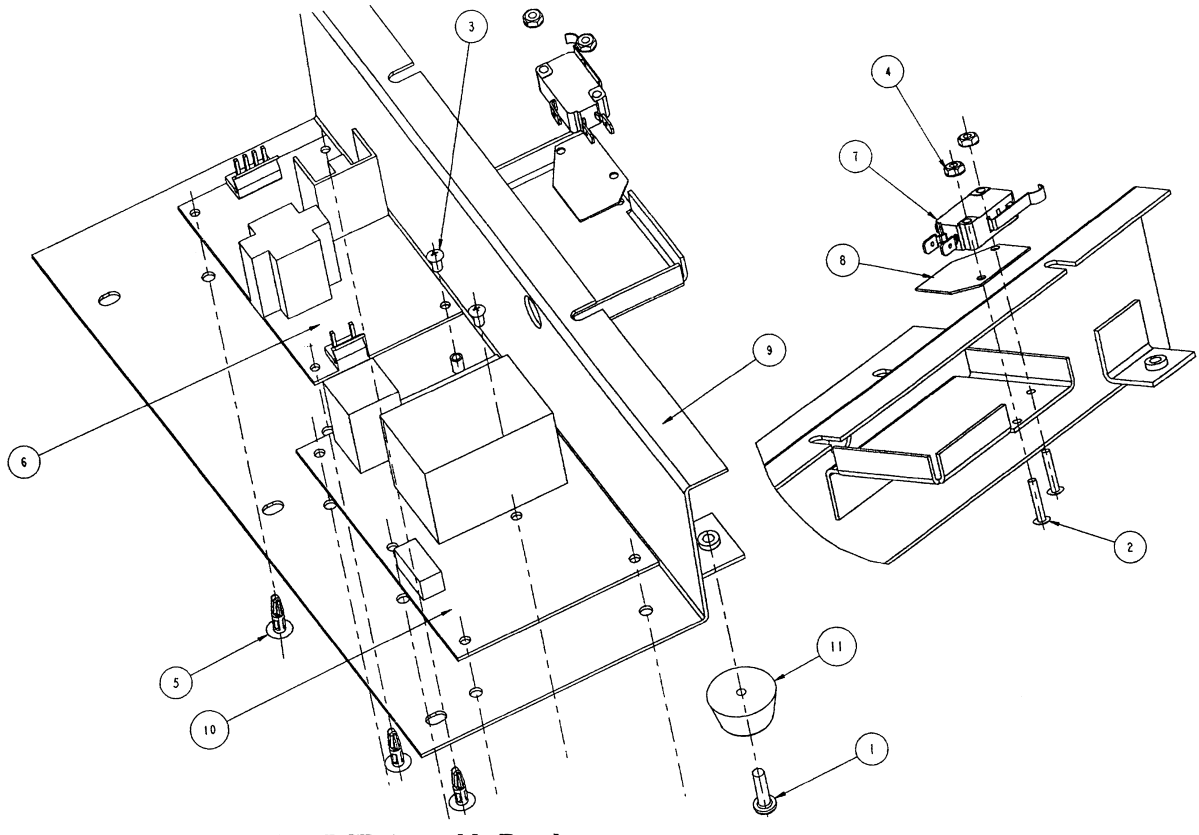
## 8.0 PARTS LIST –MP2500I~~x~~ ELECTRIC PUNCH

### 8.3 Parts Listing

Index	Part Number	Description	Qty
36	7704377	WASHER, PRESSURE BAR, PLASTIC ( <b>SEE NSB 264B</b> )	2
37	7704382	CRANK, 5/8" SHAFT	1
38	7704412	SLIDE, DIE SET, FRONT	1
39	7704414	CHART, FINAL DIESET ASSEMBLY MOD PNC	1
40	7704713S	MACHINE FRONT ASSEMBLY, 640ID	1
41	7704433	LINKAGE ASSEMBLY	1
42	7704434	PRESSURE BAR ASSEMBLY	1
43	7704435	POWER SWITCH ASSEMBLY	1
44	7704436	PCB ASSEMBLY	1
45	7704437	CHIP TRAY ASSEMBLY	1
46	7704438	HOME SWITCH ASSEMBLY	1
47	7704439	SLIDE INTERLOCK SWITCH ASSEMBLY	1
*48	7704442	FASCO GEAR MOTOR W/SOLE BRAKE – 115V	1
48	7704714	FASCO BRAKE KIT ASSEMBLY – 115V	1
48	7704715	FASCO BRAKE HUB ONLY	1
*48	7704397	BODINE GEAR MOTORW/SOLE BRAKE – 115V	1
48	7704416	BODINE BRAKE ASSEMBLY – 115V	1
48	6208065	FASCO GEAR MOTOR W/SOLE BRAKE – 230V	1
48	7704342	FASCO BRAKE KIT ASSEMBLY – 230V	1
48	7704175	BODINE GEAR MOTORW/SOLE BRAKE – 230V	1
48	7704178	BODINE BRAKE ASSEMBLY – 230V	1
49	7704444	"Z" SUPPORT BRACKET ( <b>SEE TSSB 2003</b> )	2
50	7704491	CABLE ASSEMBLY, LINE	2
51	7704492	CABLE ASSEMBLY, LINE	1
52	7704493	CABLE ASSEMBLY, A.C	1
53	7704494	CABLE ASSEMBLY, D.C.	1
54	7704496	CABLE ASSEMBLY, TRAY SWITCH	1
55	7704498	CABLE ASSEMBLY, DIESET/FOOT/HOME	1
56	7704499	BLE ASSEMBLY, INPUT/MOTOR BRAKE	1
57	7704489	WIRE KIT, CABLE ASSEMBLY, ITEM #22, 50-5	1

**\* ITEM #48 SEE TSSB 2003E FOR FASCO & BODINE SERVICE MOTOR KITS**

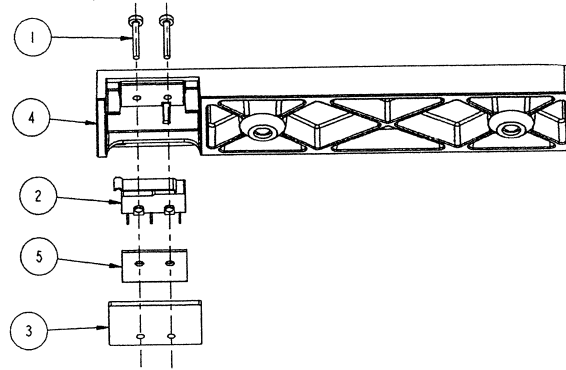
## 8.0 PARTS LIST - 640ID ELECTRIC PUNCH



### 8.4 Parts Listing, PCB Assembly Bracket

Index	Part Number	Description	Qty
1	1902806	SCREW, 8-32 x .63 PHIL PH	2
2	1902834	SCREW, 4-40 x .63 PHIL PH	2
3	1911126	SCREW, 4-40 x .25 PHIL PH, SEMS	2
4	1926804	NUT, 4-40 KEPS	2
5	1951012	P.C.B. SUPPORT	8
6	7301278	POWER SUPPLY	1
7	7301296	SWITCH	1
8	7704334	INSULATOR, CHIPTRAY	1
9	7704353	BRACKET, PCB	1
10	7704355	PC BOARD	1
11	7704368	FOOT, 640ID	4

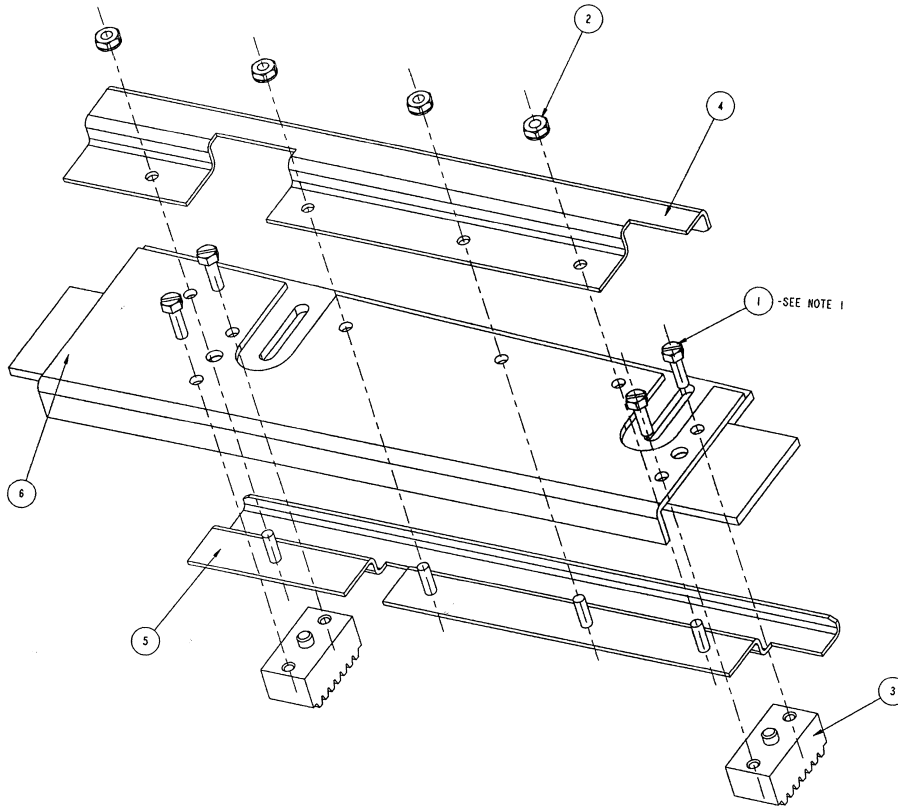
## 8.0 PARTS LIST - 640ID ELECTRIC PUNCH



### 8.5 Parts Listing, Slide Interlock Switch Assembly

Index	Part Number	Description	Qty
1	1902833	SCREW, 2-56 x .5, PHIL PH	2
2	7704326	SNAP SWITCH	1
3	7704328	SWITCH COVER PLATE	1
4	7704357	SLIDE, DIE SET, BACK	1
5	9783651	INSULATOR, SUBMINATURE SWITCH	1

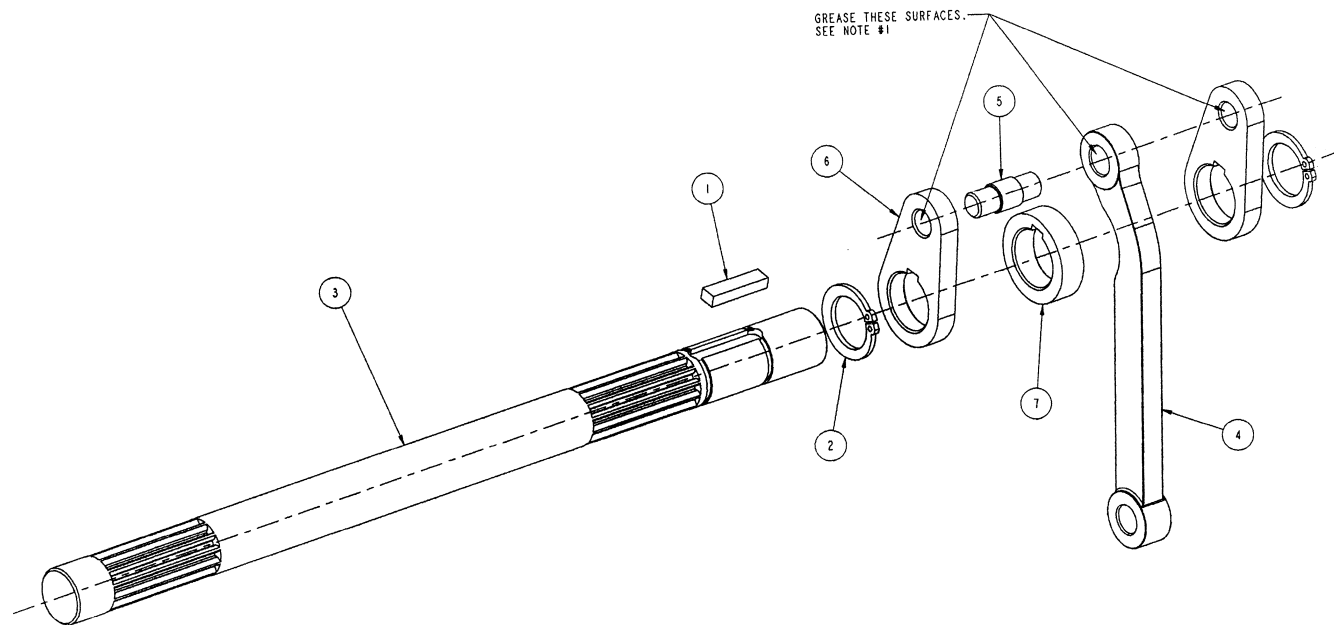
## 8.0 PARTS LIST - 640ID ELECTRIC PUNCH



### 8.6 Parts Listing, Pressure Bar Assembly

Index	Part Number	Description	Qty
1	1907405	SCREW, 10-32 x .63 SLOT HEX HD W/ SEMS	4
2	1926803	NUT, 10-32 KEPS	4
3	7704475	RACK, PRESSURE BAR	2
4	7704343	STRIPPER BRACKET, UPPER	1
5	7704344	STRIPPER BRACKET, LOWER	1
6	7704352	PRESSURE BAR, WELDMENT	1

## 8.0 PARTS LIST - MP2500iX ELECTRIC PUNCH



### NOTES:

1. APPLY PT. NO. 1961503 (LUBRIPLATE #130-AA) TO ITEMS #4 & #6 AS SHOWN.
2. ITEM #4 MUST BE FREE TO ROTATE AFTER ASSEMBLY.

Figure 8-7 - MP2500iX Parts, Linkage Assembly

## 8.0 PARTS LIST - 640ID ELECTRIC PUNCH

### 8.7 Parts Listing, Linkage Assembly

Index	Part Number	Description	Qty
1	1852901	KEY, CONNECTING CRANK	1
2	1931611	RETAINING RING	2
3	7704303	SHAFT, DRIVE	1
4	7704312	CONNECTING LINK	1
5	7704317	PIVOT PIN, SHAFT	1
6	7704350	CONNECTING CRANK	2
7	7704351	SPACER, CONNECTING CRANK	1
8	1961503	LUBRIPLARE #130-AA	.01

## 8.0 PARTS LIST - 640ID ELECTRIC PUNCH

### 8.8 Die Set Parts Listing (Die Set not shown)

Part Number	Description	Qty
7704445	FELT PAD, OILED	1
7704447	MAGNET, FELT PAD RETAINING	1
7704464	PUNCH PIN, PB	21
7704485	PUNCH PIN, C4	47
7704529	PUNCH PIN, W3 SQUARE	34
7704594	PUNCH PIN, W3 ROUND	34
7704511	PUNCH PIN, W2 SQUARE	23
7704581	PUNCH PIN, W2 ROUND	23
7704543	PUNCH PIN, VELOBIND	12
7704543	PUNCH PIN, SUREBIND	10
7704568	PUNCH PIN, LOOSE LEAF, 2-4 / 3-5-7	11

Die Set repair is not recommended other than to clean and lubricate the Punch Pins. Punch pins are listed here as a service item only in the event that some may be lost.

If a Die Set produces poor hole quality over time, it is more likely a result of Die Plate wear. In this case the Die Set should be replaced with a new one.

### 8.8 Complete Die Set Assemblies including shipping carton

Part Number	Description
7704450	DIE SET, PB
7704490	DIE SET, C4 ROUND .2475
7704590	DIE SET, W3 ROUND
7704520	DIE SET, W3 RECTANGULAR
7704470	DIE SET, W2 ROUND
7704500	DIE SET, W2 RECTANGULAR
7704570	DIE SET, LOOSE LEAF 3-5-7/2-4
7704560	DIE SET, SB
7704550	DIE SET, VB

7704440 DIE SET, C4, OVAL .2475

7705200 DIE SET, PROCLICK



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## NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION N.S.B. NO: 257E  
FROM: NATIONAL SERVICE DEPARTMENT Page: 1 of 1  
SUBJECT: **MODULAR SERVICE VIDEOTAPES** Date: 11/13/00

This N.S.B. obsoletes and supersedes N.S.B. 257 dated 07/20/00.

Technical Service Video Tapes are now available for the Desk Top Modular machines, and can be ordered under the following part numbers.

<b>PART NO.</b>	<b>MODEL NO.</b>	<b>FORMAT</b>
6001116	PB2600 Electric Binder	VHS
6001117	MP2000 Electric Punch	VHS
6001118	CC2700 Electric Coil Binder	VHS
6001125	MP2500IX Interchangeable Die Punch	VHS
6001126	TL2900 Twin Loop Wire Binder	VHS
6001127	MP2500IX Interchangeable Die Punch	European Pal Standard
6001128	TL2900 Twin Loop Wire Binder	European Pal Standard
6001119	PB2600 Electric Binder	European Pal Standard
6001120	MP2000 Electric Punch	European Pal Standard
6001121	CC2700 Electric Coil Binder	European Pal Standard

ECO NO. E-10122 & ECO NO. E-10209





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## NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION N.S.B. NO: 264  
FROM: NATIONAL SERVICE DEPARTMENT Page: 1 of 1  
SUBJECT: **MP2500IX LED BOARD WIRES** Date: 01/29/01

During the month of November 2000, Manufacturing found that the red wires that connect the punch button to the LED Board were coming off. The wires became disconnected where they attach to the two-pin connector on the LED Board. When the red wires become disconnected the machine will not run when the punch button is pushed. To eliminate this problem, the red wires will be attached to the LED Board, along with a small amount of hot melt glue. This will prevent the wires from being disconnected. The alpha-serial number for the first MP2500IX Domestic 115volt machine with the wires glued to the LED Board is NA08129. For the International 230volt machine, it is NA01295.

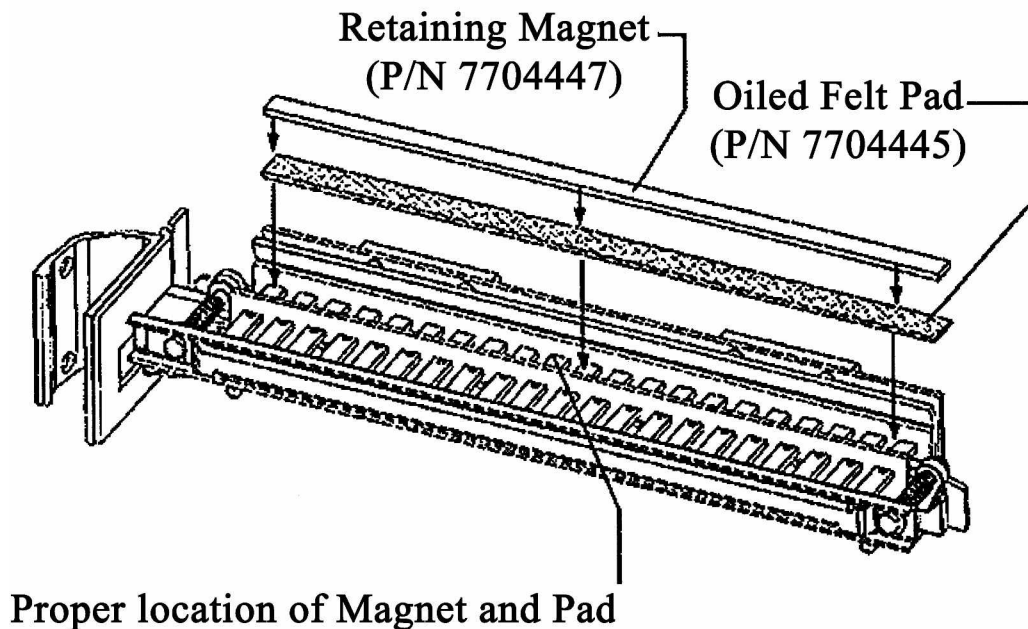


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## NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION N.S.B. NO: 264A  
FROM: NATIONAL SERVICE DEPARTMENT Page: 1 of 1  
SUBJECT: **MP2500IX OILED FELT PAD & MAGNET** Date: 01/29/01

The GBC MP2500IX Die Set is supplied with a Felt Pad containing oil, and a Retaining Magnet. (**Note:** Felt Pad and Retaining Magnet are not included on the 2-4/3-5-7 Die Set). **Do not throw these items away.** The Felt Pad will provide lubrication to the punch pins under normal usage, and will help to keep the punch pins clean. The Magnet is intended to keep the Felt Pad in place during typical handling. If the Pad and Magnet came off of the Die Set during shipping or unpacking, please replace them as indicated in the accompanying diagram. The Die Sets come with two additional punch pins in the event that some of the installed pins become lost. Keep this sheet as a reference in the event that the Pad and Magnet are removed or replaced.





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## NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION N.S.B. NO: 264B  
 FROM: NATIONAL SERVICE DEPARTMENT Page: 1 of 1  
 SUBJECT: **MP2500IX PRESSURE BAR SHOULDER BOLT'S** Date: 11/16/01

GBC Manufacturing has increased the Pressure Bar Shoulder Bolt's size from a 10-24 to a 1/4-20. There are significant part number changes to accommodate for the larger Shoulder Bolts being used. This change was implemented on **11/14/01**, starting with **S/N# NK19168**. Listed below are the part numbers **prior to S/N# NK19168**, as well as the new replacement part numbers from **S/N# NK19168 and after**. Please update your Service Manual with this information.

OLD P/N	NEW P/N	DESCRIPTION	QTY
7704352	<b>7704452</b>	<b>Pressure Bar</b>	<b>1</b>
7704327	<b>7704475</b>	<b>Pressure Bar Rack</b>	<b>2</b>
7704377	<b>7704453</b>	<b>Pressure Bar Washer</b>	<b>2</b>
1900827	<b>*1900814</b>	<b>Pressure Bar Shoulder Bolt (1/4-20x1/2)</b>	<b>2</b>
xxxxxxx	<b>*1960524</b>	<b>Loctite 242</b>	<b>2 Drops</b>
1925183	<b>1953504</b>	<b>Stainless Steel Washer (1/8")</b>	<b>2</b>
1925107	<b>**1953501</b>	<b>Stainless Steel Shim Washer (.010)</b>	<b>4</b>

\* Add 2 drops per Pressure Bar Shoulder Bolt. Loctite 242 added to Pressure Bar Bolts at installation.

\*\* Add as required to maintain a .015" - .025" between Pressure Bar Washer and Pressure Bar. This is checked with a set of Feeler Gauges.



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## NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION

N.S.B.NO: 264C

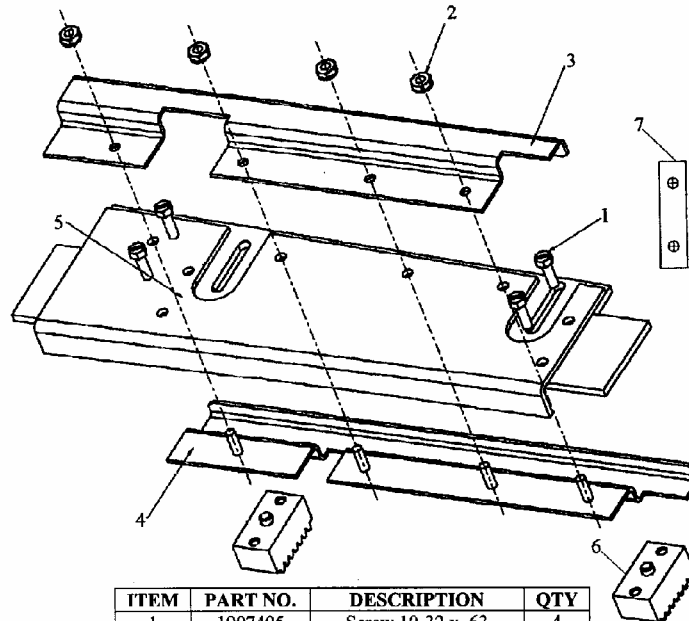
FROM: NATIONAL SERVICE DEPARTMENT

Page: 1 of 1

SUBJECT: **MP2500iX PRESSURE BAR RACK PLATES**

Date: 12/27/01

GBC Manufacturing has installed Pressure Bar Rack Plates to cover the Pressure Bar Rack dowel pins in the MP2500iX. The Rack Plates, part number **7704394**, will prevent the dowel pins in the Pressure Bar racks from walking out of the Pressure Bar Racks. **It is only necessary on units made with Pressure Bar P/N 7704352, prior to S/N# NG02845.** The new Pressure Bar P/N 7704452 does not need the Rack Plates. **The installation is as follows:** Remove 4 screws, item 1, P/N 1907405, and set aside. Add one Pressure Bar Rack Plate to the left side of Pressure Bar, and one Pressure Bar Rack Plate to the right side of Pressure Bar. Re-install the four screws using loctite #242, P/N 1960524.



ITEM	PART NO.	DESCRIPTION	QTY
1	1907405	Screw 10-32 x .63	4
2	1926803	Nut, 10-32	4
3	7704343	Stripper Bracket, Upper	1
4	7704344	Stripper Bracket, Lower	1
5	7704352	Pressure Bar	1
6	7704475	Pressure Bar Rack	2
7	7704394	Pressure Bar Rack Plate	2



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## NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION N.S.B. NO: 264D  
FROM: NATIONAL SERVICE DEPARTMENT Page: 1 of 1  
SUBJECT: **MP2500iX PIVOT PIN CRANK** Date: 01/21/02

There is a part number error in the MP2500iX Service Manual. The Pivot Pin Crank, P/N 7704318 was never implemented in the build of the machine. Listed below are the part numbers, descriptions, and quantities to use. Please update your Service Manual with this information.

<b>PART NO.</b>	<b>DESCRIPTION</b>	<b>QTY</b>
7704375	Pivot, Shoulder Bolt	1
1927501	Castle Nut 3/8-24	1
1930208	Cotter Pin 3/32 x 1"	1
1925185	Heavy Flat Washer	2
1925136	Spacer	2



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## NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION N.S.B. NO: 264E  
FROM: NATIONAL SERVICE DEPARTMENT Page 1 of 1  
SUBJECT: **MP2500iX PUNCH PINS NOT RETRACTING** Date: 8/27/2007

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### **S/N'S AFFECTED: OA TO OC**

Calls on MP2500iX's (S/N's OA to OC) where paper cannot be removed from the Punch Throat because the Punch Pins do not retract could be caused by the Brake on the Motor (7704442) failing. This may be due to the Set Screw that secures the Brake Hub to the Motor Shaft not being secured with Thread Locking Adhesive. Apply a drop of Thread Locking Adhesive (Loctite 242) to the Set Screw and secure the Brake Hub to the Motor Shaft.



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## NATIONAL SERVICE BULLETIN

TO: SEE DISTRIBUTION N.S.B. NO: 264G  
FROM: NATIONAL SERVICE DEPARTMENT Page 1 of 1  
SUBJECT: **MP2500IX DIE SET GUIDE** Date: 8/27/2007

The height of the guide on the bottom of the **MP2500IX** die sets (**P/N 7704410**) has been increased by **.060"**. This change will ensure that the interlock switch inside the machine is always activated when the die set is installed in the machine. The plating of the guide will be changed from black oxide (**black in color**) to a clear zinc plating (**silver in color**). Please update your manual with this information.

ECO # 10590 8-15-02



# TECHNICAL SERVICE & SUPPORT BULLETIN

500 Bond St.  
Lincolnshire, IL. 60069

T.S.S.B. NO.	<b>2003</b>	DATE:	<b>1/05/04</b>
MODEL:	<b>MP2500IX</b>		
SUBJECT:	<b>Addition of Tie Bar to Strengthen Z Brackets</b>	PAGE:	<b>1 of 1</b>

The MP2500ix uses two metal Z shaped brackets to strengthen the plastic pressure bar guides. After extensive use the plastic pressure bar guides may crack and break due to the Z shaped brackets flexing during the punch cycle. Once the pressure bar guides break there is nothing to keep the pressure bar racks from separating from the drive shaft. The following parts are susceptible to damage once the pressure bar guides break or crack and should be inspected: drive shaft, pressure bar racks, black plastic pressure bar guides, pressure bar shoulder bolts, and base casting in the area of the pressure bar shoulder bolts.

To prevent this failure, a kit has been created that makes use of a tie bar, redesigned Z brackets, and Z bracket spacers. The purpose of the tie bar is to connect the left and right Z brackets and therefore eliminate their ability to bend or flex and subsequently prevent the pressure bar guides from breaking. One kit is required to retrofit one machine. This kit should be installed on machines that require new pressure bar guides, and on machines that that require a new drive shaft and or pressure bar racks because of loss of teeth.

## **Tie Bar Kit PN# 7704719**

### **The kits individual parts are listed below.**

- > **7704717 Z bracket with studs 2 Req.**
- > **7704718 Spacer Z Bracket 2 Req.**
- > **7704716 Tie Bar 1 Req.**
- > **1927410 1/4-20 Nylock Nut 4 Req.**



# MP2500IX Tie Bar Kit Installation Procedure

Part Number 7704721 Revision A1

1. Disconnect the plug from the electrical power receptacle. Retain the plug under your control to ensure your safety.
2. Remove the qty. (4) 10-32 socket head cap screws that hold the rear housing in position.
3. Remove the rear housing from the machine.
4. Remove the qty. (4) 10-32 socket head cap screws that hold the front housing in position.
5. Remove the front housing from the machine. Leave the gray ribbon cable attached to both the main P.C. board located inside the machine and attached to the L.E.D board located in the front housing assembly.
6. Remove the qty. (4) Phillips screws that secure the qty. (2) Z Brackets in place.
7. Remove the qty. (2) Z Brackets from the machine.
8. Install the qty. (2) new Z Bracket with studs on the base casting using qty (4) Phillips screws. Installation of the new Z Brackets are shown in Figure 1.
9. Install qty. (1) Z Bracket Spacer on top of each new Z Bracket with studs. Installation of the Z Bracket Spacers is shown in Figure 2.
10. Install the new Tie Bar on top of the Z Bracket Spacers. The cutout in the Tie Bar should be toward the front of the machine. Installation of the new Tie Bar is shown in Figure 3.
11. Install qty. (4)  $\frac{1}{4}$ "-20 Nylock nuts on the studs.

12. Reinstall the front housing on the machine.
13. Reinstall the qty. (4) 10-32 socket head cap screws that hold the front housing in position.
14. Reinstall the rear housing on the machine.
15. Reinstall the qty. (4) 10-32 socket head cap screws that hold the rear housing in position.
16. Connect the power cord to the machine.
17. Turn on/off switch to the on position.
18. Install a die set in the machine and check the operation of the machine.

### MP2500IX Tie Kit Bar Parts

Part Number	Description	Qty.
7704716	Tie Bar MP2500IX	1
7704717	Z Bracket W/ Studs MP2500IX	2
704718	Spacer Z Bracket MP2500IX	2
1927410	Nylock Nut 1/4-20	4

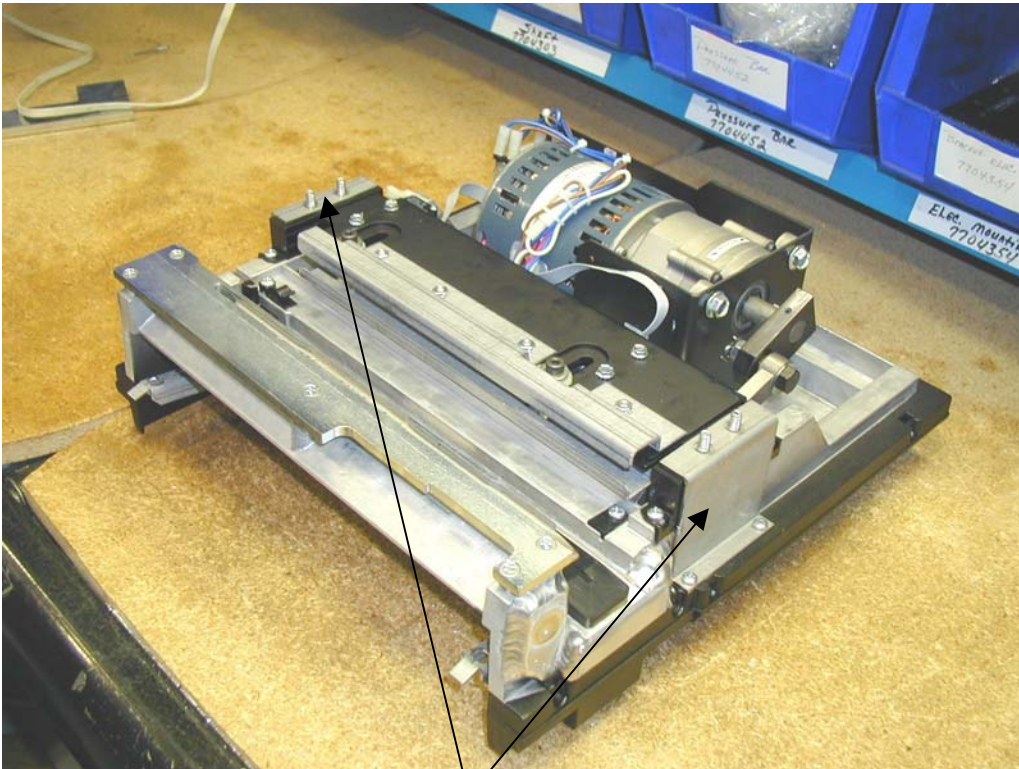


Figure 1 Z Brackets with Studs

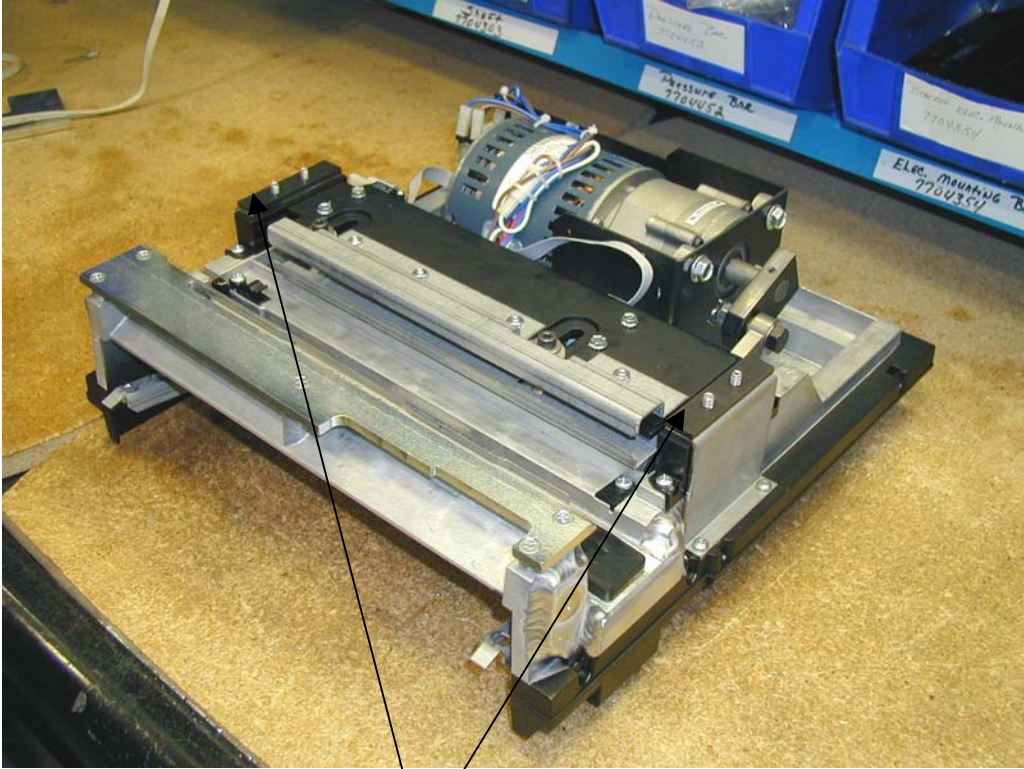


Figure 2 Z Bracket Spacer

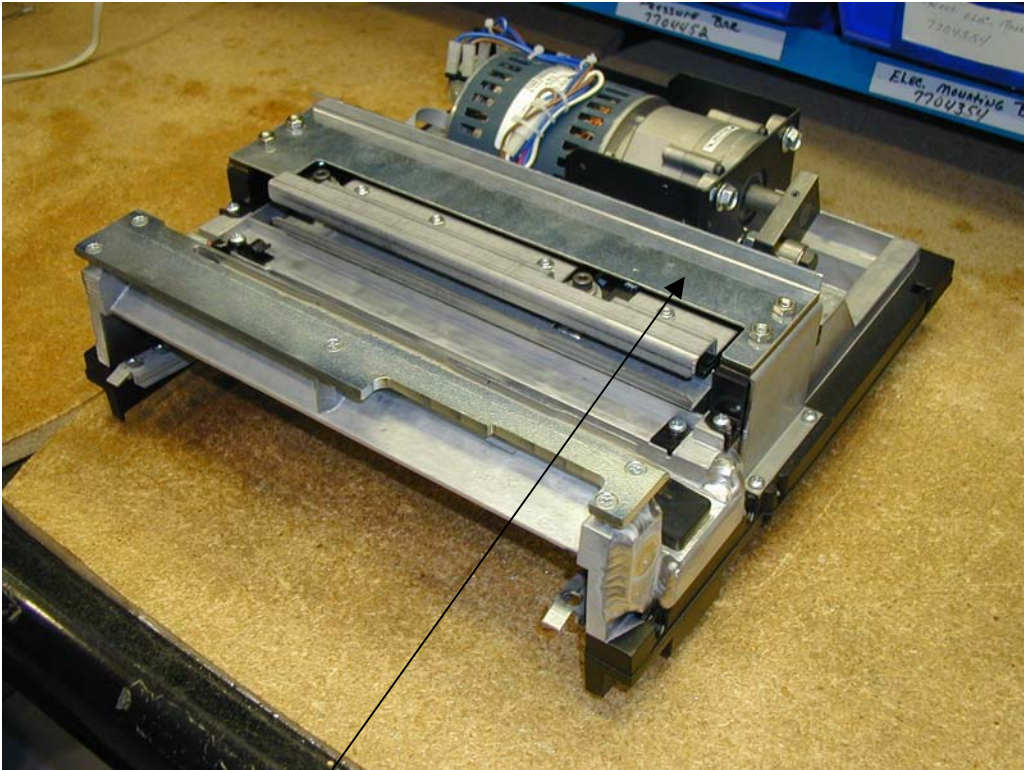


Figure 3 Tie Bar



# TECHNICAL SERVICE & SUPPORT BULLETIN

500 Bond St.  
Lincolnshire, IL. 60069

T.S.S.B. NO.	<b>2003A</b>	DATE:	<b>02/25/04</b>
MODEL:	<b>MP2500ix</b>		
SUBJECT:	<b>Screw Replacing Hot Glue on Start Switch</b>	PAGE:	<b>1 of 1</b>

The start switch on the MP2500ix may fall apart. Most of the MP2500ix that will have this problem will be new machines; this is because the problem generally occurs in shipping. To solve this problem manufacturing will implement the use of a #2 x 1/4 wood screw in place of the hot glue currently used. This should permanently resolve this problem on all machines with this implementation. The switch with the screw installed will be available from service parts.

**Start Switch (With Hole and Screw Added) P/N 7704720**

12/19/03 RGM



# TECHNICAL SERVICE & SUPPORT BULLETIN

500 Bond St.  
Lincolnshire, IL. 60069

T.S.S.B. NO.	<b>2003B</b>	DATE:	5-3-05
MODEL:	<b>MP2500IX</b>		
SUBJECT:	<b>DIE SET PIN RETAINER</b>	PAGE:	1 OF 1

There have been some problems with the pin retainer (**P/N 7704512**) that is used to secure the punch pins in place on the **MP2500IX**. The pin retainer tab makes contact with the black plastic bearing guide when the die set is installed in the machine. When this happens the tab is bent down. This makes it difficult to remove the pin retainer and any punch pins the operator may want to remove. Manufacturing has moved the tab **.200"** toward the handle. The part itself has changed not the part number. Please update your service manual with this information.

ECO#10945  
BY T.J.H

## TECHNICAL SERVICE & SUPPORT BULLETIN

T.S.S.B. NO.	<b>2003C</b>	DATE:	1-9-07
MODEL:	<b>MP2500IX</b>		
SUBJECT:	<b>PRESSURE BAR RECOMMENDED REPLACEMENT PARTS</b>	PAGE:	1

When one of the following parts listed below have failed on the MP2500IX, all the parts listed should be replaced to prevent future service calls or lengthen the time between service calls.

<u>P/N</u>	<u>DESC.</u>	<u>QTY</u>
7704475	Racks	2 right and left side of the machine.
7704303	Drive Shaft	1
7704319	Plastic Bearing Guide	2 right and left side of the machine.
7704312	Connecting Link	1 Replace unless it is black in color-which indicates it is made of steel.

In addition, if the machine does not have the Tie Bar kit installed, it should be installed. The part number for the Tie Bar kit is **7704719**. The Tie Bar Kit was first installed on machines beginning with **Serial Number QF18097**.

## TECHNICAL SERVICE & SUPPORT BULLETIN

T.S.S.B. NO.	<b>2003D</b>	DATE:	2-20-07
MODEL:	<b>MP2500IX</b>		
SUBJECT:	<b>PUNCH CAPACITY LABEL</b>	PAGE:	1 of 1

GBC service is experiencing significantly higher service calls on the **MP2500IX** at the **Office Max and Office Depot locations** then at the non national accounts. In the last year **73%** of all MP2500IX service calls were at Office Max and Office Depot locations. In effort to minimize the amount of service calls it is desired to release a caution label (**P/N7704361**) that shows the recommended punch capacity with the **PB and C4 die sets**. The label will also recommend that the maximum punching capacity on plastic sheets is **Qty of Two**. Please update your service manual with this information.



## TECHNICAL SERVICE & SUPPORT BULLETIN

T.S.S.B. NO.   **2003E** DATE: 8/24/07  
 MODEL:       **MP2500IX**  
 SUBJECT:      **115 VOLT BODINE MOTOR IMPLEMENTATION** PAGE: 1 of 1

GBC Manufacturing is currently using two different brand name motors due to the difficulty of delivery from Fasco Motors. As a result, a new motor was developed with Bodine Electric Company. To use the new 115volt Bodine motor the machine requires a motor mounting bracket, four mounting screws and lock washers, a new 55 microfarad capacitor, capacitor bracket, capacitor mounting screw, and a new louvered rear housing.

If you have a MP2500IX that has a 115volt Fasco motor failure and the Fasco motor P/N# 7704442 is not in stock, order the **Bodine Motor Kit P/N#7704404**. Listed below is the Bodine Motor Kit BOM (Build of Material).

PART NUMBER	DESCRIPTION	QTY
7704397	115 Volt Bodine Motor	1
7704417	Motor Mounting Bracket	1
7704395	55 Microfarad Capacitor	1
7704396	Capacitor Bracket	1
1902836	Capacitor Mounting Screw	1
1900449	Motor Mounting Bracket Screws SHCS 1/4-28x1/2"	4
1926064	Lock Washers	4
7704402	Louvered Rear Housing	1

If you have a MP2500IX that has a 115volt Bodine motor failure and the Bodine motor P/N# 7704397 is not in stock, order the **Fasco Motor Kit P/N# 7704405**. Listed below is the Fasco Motor Kit BOM (Build of Material).

PART NUMBER	DESCRIPTION	QTY
7704442	115 Volt Fasco Motor	1
7704322	Motor Mounting Bracket	1
6205030	35 Microfarad Capacitor	1
6205041	Capacitor Bracket	1
1908500	Capacitor Mounting Screws PPH 10-32X3/8"	1
1903204	Motor Mounting Bracket Screws 5/16X.45 Flange Lock	4

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## TECHNICAL SERVICE & SUPPORT BULLETIN

T.S.S.B. NO.	<b>2003F</b>	DATE:	10/1/07
MODEL:	<b>MP2500IX</b>		
SUBJECT:	<b>230 VOLT BODINE MOTOR IMPLEMENTATION</b>	PAGE:	1 of 1

GBC Manufacturing is currently using two different brand name motors due to the difficulty of delivery from Fasco Motors. As a result, a new motor was developed with Bodine Electric Company. To use the new 230 volt Bodine motor the machine requires a motor mounting bracket, four mounting screws and lock washers, and new louvered rear housing.

You have a MP2500IX that has a 230 volt Fasco motor failure and the Fasco motor P/N# 6208065 is not in stock, order the **Bodine Motor Kit P/N#7704176**. Listed below is the Bodine Motor Kit BOM (Build of Material).

PART NUMBER	DESCRIPTION	QTY
7704175	115 Volt Bodine Motor	1
7704417	Motor Mounting Bracket	1
1900449	Motor Mounting Bracket Screws SHCS 1/4"-28 X 1/2"	4
1926064	Lock Washers	4
7704402	Louvered Rear Housing	1

You have a MP2500IX that has a 230 volt Bodine motor failure and the Bodine motor P/N# 7704397 is not in stock, order the **Fasco Motor Kit P/N# 7704175**. Listed below is the Fasco Motor Kit BOM (Build of Material).

PART NUMBER	DESCRIPTION	QTY
6208065	Volt Fasco Motor 230 Volt	1
7704322	Motor Mounting Bracket	1
1903204	Motor Mounting Bracket 5/16" x.45 Lock	4

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