

# PNEUMATIC COIL CARTON STAPLER MODEL:

## MANUAL

### **WARNING**

BEFORE OPERATING THIS STAPLER. ALL OPERATORS SHOULD STUDY THIS MANUAL, TO UNDERSTAND AND FOLLOW THE SAFETY WARNINGS AND INSTRUCTIONS. KEEP THESE INSTRUCTIONS WITH THE STAPLER FOR FUTURE REFERENCE. IF YOU HAVE ANY QUESTION, CONTACT YOUR DISTRIBUTOR.



# TABLE OF CONTENTS

	<b>PAGE</b>
<b>TOOL SPECIFICATIONS.....</b>	<b>3</b>
<b>SAFETY INSTRUCTIONS.....</b>	<b>4</b>
<b>LUBRICATION AND MAINTENANCE .....</b>	<b>5</b>
<b>AIR SUPPLY AND CONNECTIONS .....</b>	<b>5</b>
<b>LOADING THE TOOL .....</b>	<b>6</b>
<b>CHECK STAPLE LEG LENGTH .....</b>	<b>7</b>
<b>CLINCH ADJUSTMENT .....</b>	<b>8</b>
<b>DEPTH ADJUSTMENT .....</b>	<b>8</b>
<b>OPERATING THE TOOL .....</b>	<b>9</b>
<b>CLEANING THE TOOL .....</b>	<b>10</b>
<b>CLEARING A JAM FROM THE TOOL .....</b>	<b>11</b>
<b>TROUBLESHOOTING .....</b>	<b>12</b>
<b>TEETH REPLACEMENT .....</b>	<b>13</b>
<b>DRIVER REPLACEMENT .....</b>	<b>14</b>
<b>VALVE'S AND TUBE'S O-RINGS REPLACEMENT .....</b>	<b>15</b>
<b>PISTON REPLACEMENT .....</b>	<b>16</b>
<b>PARTS LIST .....</b>	<b>17</b>
<b>EXPLODED VIEW OF TOOL .....</b>	<b>18</b>

# TOOL SPECIFICATIONS

DIMENSIONS (LENGTH \* HEIGHT \* WIDTH) .....233MM \* 230MM \* 115MM  
(91 3/4" \* 91 5/8" \* 45 1/4")

WEIGHT (WITHOUT FASTENERS) ..... 2.37KG (5.22lb)

AIR INLET ..... .1/4" NPT

**COMPRESSED AIR :**

MAXIMUM PERMISSIBLE OPERATING PRESSURE.....8KG/CM<sup>2</sup> (110 PSI)

RECOMMENDID OPERATING PRESSURE .....5-7 KG/ CM<sup>2</sup> (70 – 100 PSI)

AIR CONSUMPTION .....0.067 M<sup>3</sup>/MIN (2.4 C.F.M) WITH 60 STAPLES  
PER MINUTE @5.66KG/ CM<sup>2</sup> (80 PSI)

STAPLES SPECIFICATION ..... I SERIES --WIRE DIMENSION 1.90 x 0.9 mm 2.30 x 0.9 mm  
 S SERIES  
 T SERIES

STAPLES CAPACITY .....1000 PCS

THE NOISE LEVELS : (AT THE WORKPLACE, ALWAYS WEAR HEARING PROTECTION EQUIPMENT.)

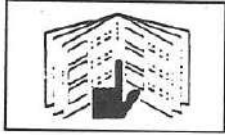
A - EIGHTED SINGLE-EVENT SOUND PPRESSURE LEVEL AT OPERATOR'S POSITION: L pA, 1s = 89 dBA

A - WEIGHTED SINGLE-EVENT SOUND POWER LEVEL ..... L WA, 1s = 93 dBA

A - WEIGHTED SINGLE-EVENT SURFACE SOUND PRESSURE LEVEL ..... L Pa, 1s, 1m = 80 dBA

# SAFETY INSTRUCTIONS

## DANGER



1. READ THIS MANUAL AND UNDERSTAND ALL SAFETY INSTRUCTIONS BEFORE OPERATION THE TOOL. IF YOU HAVE ANY QUESTIONS, PLEASE CONTACT OUR AUTHORIZED REPRESENTATIVES.



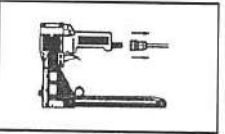
2. NEVER ALLOW TO USE TYPE OF FLAMMABLE GASES OXYGEN AS A POWER SOURCE FOR THE TOOL. USE FILTERED, LUBRICATED, REGULATED COMPRESSED AIR ONLY.



3. NEVER USE GASOLINE OR OTHER FLAMMABLE LIQUIDS TO CLEAN THE TOOL. VAPORS IN THE TOOL WILL IGNITE BY A SPARK AND CAUSE THE TOOL TO EXPLODE.



4. DO NOT EXCEED MAXIMUM PERMISSIBLE OPERATING PRESSURE OF THE TOOL (8 KG/Cm<sup>2</sup>)



5. DISCONNECT THE TOOL FROM AIR SUPPLY BEFORE CLEANING JAMS, SERVICING, ADJUSTING, AND DURING NON-OPERATION.

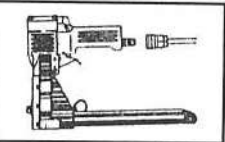
## WARNING



6. DO NOT PULL THE TRIGGER WHEN CARRYING OR HOLDING THE TOOL. NEVER CARRY THE TOOL BY THE HOSE OR PULL THE HOSE TO MOVE THE TOOL.



7. AT THE WORKPLACE, ALWAYS WEAR THE PROTECTIVE EQUIPMENT SUCH AS SAFETY GLASSES, HEARING PROTECTION AND HEAD PROTECTION.



8. DO NOT USE A CHECK VALVE OR ANY OTHER FITTING WHICH ALLOWS AIR TO REMAIN IN THE TOOL.



9. DO NOT PLACE YOUR HAND OR ANY PART OF YOUR BODY IN THE STAPLE CLINCHING AREA OR ADJUSTMENT WINDOW OF THE TOOL WHEN CONNECTING OR DISCONNECTING AIR SUPPLY.



10. NEVER POINT ANY OPERATIONAL DRIVING TOOL AT YOURSELF OR AT ANY OTHER PERSON.

# LUBRICATION AND MAINTENANCE

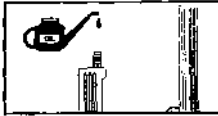
## NOTE



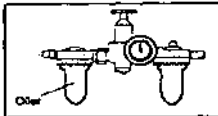
YOUR TOOL REQUIRES LUBRICATION BEFORE YOU USE IT FOR THE FIRST TIME.



DISCONNECT THE AIR SUPPLY FROM THE TOOL BEFORE LUBRICATING.



TURN THE TOOL SO THE INLET IS FACING UP AND PUT ONE DROP OF HIGH SPEED SPINDLE OIL, UNOCAL RX22, OR 3-IN-1 OIL INTO AIR INLET. NEVER USE DETERGENT OIL ADDITIVES. OPERATE THE TOOL BRIEFLY AFTER ADDING OIL.

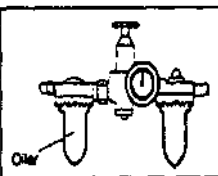
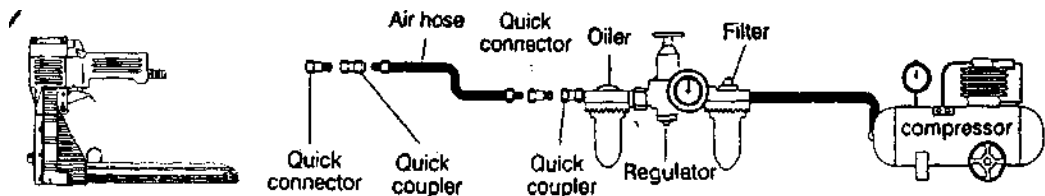


WIPE OFF EXCESSIVE OIL AT THE EXHAUST, EXCESSIVE OIL WILL DAMAGE ORINGS OF TOOL. IF IN-LINE OILER IS USED. MANUAL LUBRICATION THROUGH THE AIR INLET IS NOT REQUIRED ON A DAILY BASIS.

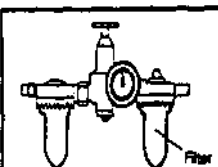
# AIR SUPPLY AND CONNECTIONS

## NOTE

THE FOLLOWING ILLUSTRATION SHOWS THE CORRECT MODE OF CONNECTION TO THE AIR SUPPLY SYSTEM WHICH WILL INCREASE THE EFFICIENCY AND USEFUL LIFE OF THE TOOL.

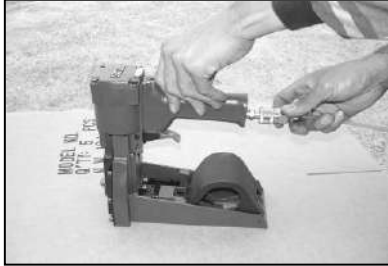


MANY AIR TOOL USERS FIND IT CONVENIENT TO USE OILER TO HELP PROVIDE OIL CIRCULATION THROUGH TOOL AND INCREASE THE EFFICIENCY AND USEFUL LIFE OF THE TOOL. CHECK OIL LEVEL IN THE OILER DAILY.

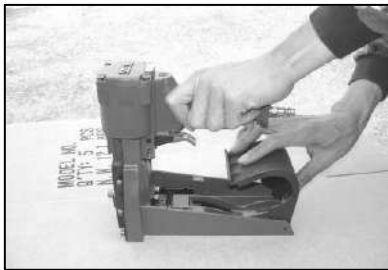


MANY AIR TOOL USER FIND IT CONVENIENT TO USE A FILTER TO REMOVE LIQUID IMPURITIES WHICH CAN RUST OR WEAR INTERNAL PARTS OF THE TOOL. A FILTER ALSO INCEREASE THE EFFICIENCY AND USEFUL OF THE TOOL. THE FILTER MUST BE CHECKED ON A DAIL BASIS AND IF NECESSARY DRAINED.

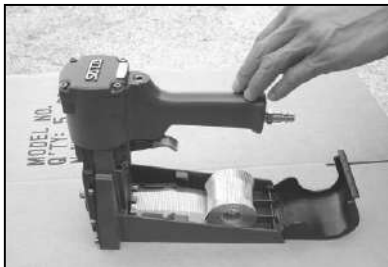
# LOADING THE TOOL



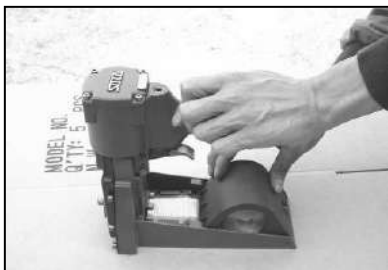
DISCONNECT THE AIR SUPPLY



SLIGHTLY SQUEEZE COVER (044) BACK THEN PULL TO OPEN COVER(044)



PLACE COIL STAPLES IN MAGAZINE. FEED FRONT END OF COIL STAPLES INTO RIGHT COIL GUIDE (037), LEFT COIL GUIDE (038), AND TOP GUIDE (035). PUSH FORWARD UNTIL STOPPING IN DRIVER GUIDE UNIT (027).



SWING COVER CLOSED AND SLIGHTLY SQUEEZE TO ENGAGE MAGAZINE BOSSES.  
NOTE : CHECK POSITION ENGAGEMENT.

# CHECK STAPLE LENGTH



**NOTE : DISCONNECT THE AIR SUPPLY**

LOOSEN SET SCRCW (526) WITH 3MM HEXAGON WRENCH KEY.



TURN ADJUSTING ROD (018)180°WITH A SCREW DRIVER TO THE DESIRED ADJUSTMENT.

STAPE LENGTHS	15MM (5/8")	18MM (3/4")
ROD POSITION		

IF WANT TO SHOOT LONG LEG STAPLES. LET "L" ON ADJUSTING ROD (018) UP. IF WANT TO SHOOT SHORT LEG STAPLES, LET "S" ON ADJUSTING ROD (018) UP.



IF WANT TO SHOOT LONG LEG STAPLES. LOOSEN ROUND HEAD SCREW (542) WITH SCREW DRIVER. MOVE RIGHT COIL GUIDE (017) AND LEFT COIL GUIDE (038) OUT. THEN SET ROUND SCREW (542).

IF WANT TO SHOOT SHORT LEG STAPLES. LOOSEN ROUND HEAD SCREW (542) WITH SCREW DRIVER. MOVE RIGHT COIL GUIDE (017) AND LEFT COIL GUIDE (038) IN. THEN SET ROUND HEAD SCREW (542).

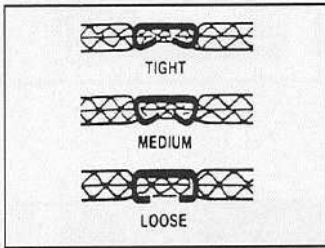
# CLINCH ADJUSTMENT



**NOTE : DISCONNECT THE AIR SUPPLY**

USE ROD(DIA 3 MM) OR 2.5G MM HEXAGON WRENCH KEY. TURN COLLAR (006) THROUGH WINDOW CLOCKWISE TO TIGHTEN CLINCH AND COUNTER-CLOCKWIDE TO LOOSEN CHINCH.

NOTE : REMOVE ADJUSTING TOOL AFTER ADJUSTMENT IS MADE.

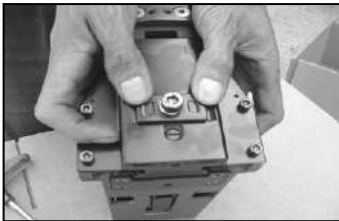


# DEPTH ADJUSTMENT



**NOTE : DISCONNECT THE AIR SUPPLY**

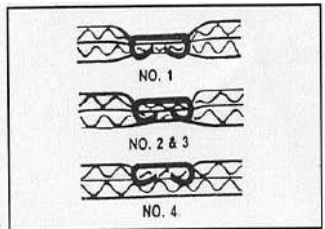
LOOSEN FRONT SCREW (527) WITH 6 MM HEXAGON WRENCH KEY.



PUSH THE BODY (007) UP AND ADJUST TO DESIRED DEPTH.



WHEN TOP EDGE OF ADJUSTMENT PLATE (019) IS AT ITS HIGHEST SETTING (NO.4), THE TEETH (021,022) ARE AT THEIR SHALLOWEST PENETRATION. IF SET AT LOWEST SETTING (NO.1) THE TEETH (021,022) ARE AT THEIR DEEPEST PENETRATION.





# OPERATING THE TOOL

## WARNING

PROTECT YOUR EYES AND EARS. WEAR SAFETY GLASSES WITH SIDE SHIELDS. WEAR HEARING PROTECTION. EMPLOYERS AND USERS ARE RESPONSIBLE FOR ENSURING THE USER OR ANYONE NEAR THE TOOL WEAR THIS SAFETY PROTECTION.

## WARNING

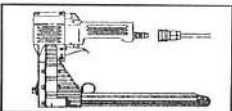
TO PREVENT ACCIDENTAL INJURIES : NEVER, PLACE A HAND OR ANY OTHER PART OF BODY IN STAPLE CLINCHING AREA OR ADJUSTMENT WINDOW. NEVER POINT TOOL TOWARD ANYONE ELSE. NEVER ENGAGE IN HORSEPLAY. ALWAYS HANDLE THE TOOL WITH CARE. NEVER PULL TRIGGER UNLESS TOOL IS IN PLACE OF CARTON.

## NOTE

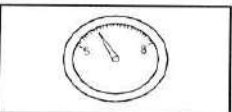
CHECK AND REPLACE ANY DAMAGED OR WORN COMPONENTS ON THE TOOL. THE SAFETY WARNING LABELS ON THE TOOL MUST ALSO BE REPLACED IF THEY ARE NOT LEGIBLE.



ADD A FEW DROPS OF UNOCAL R \* 22 OR 3-IN -1 OIL INTO THE AIR INLET.



INSTALL A QUICK CONNECT FITTING TO THE TOOL



REGULATE THE AIR PRESSURE TO OBTAIN 6 KG/Cm<sup>2</sup> AT THE TOOL



INSERT STAPLES INTO YOUR TOOL FOLLOWING THE INSTRUCTIONS OF LOADING THE TOOL.



RECONNECT THE AIR HOSE TO THE TOOL



GRASP HANDLE WITH ONE HAND. POSITION ON BOX IN LINE WITH THE DESIRED STAPLE LOCATION. THERE IS A SMALL PROJECTION ON EITHER SIDE OF THE MAGAZINE SEAT (039) AS AN AID IN LOCATING THE POSITION OF THE STAPLE.

PRESS TRIGGER (011) MOVE MACHINE TO NEXT STAPLE LOCATION WITH OR WITHOUT RELEASING TRIGGER.

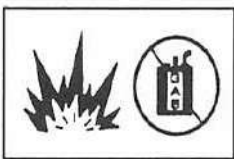


STRONGEST CLOSURE REQUIRES END STAPLES CLOSE TO END OF BOX. CHECK PACKING REQUIREMENTS.

CHECK STAPLE CLINCHING IN SAMPLES OF BOX BOARD BEING USED. ADJUSTMENTS FOR DEPTH OF PENETRATION & TIGHTNESS OF CLINCH ARE EASY & INSTANTANEOUS, FULL ADVANTAGE SHOULD BE TAKEN OF THEM.

## CLEANING THE TOOL

**DANGER**



NEVER USE GASOLINE OR OTHER FLAMMABLE LIQUIDS TO CLEAN THE TOOL. VAPORS IN THE TOOL WILL IGNITE BY A SPARK AND CAUSE THE TOOL TO EXPLODE AND RESULT IN DEATH OR SERIOUS PERSONAL INJURY.

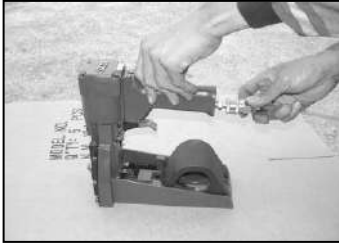


1. DISCONNECT THE AIR SUPPLY FROM THE TOOL.

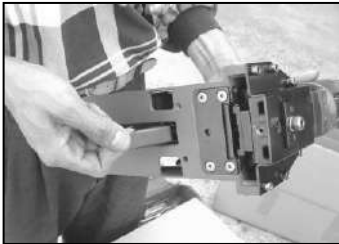


2. REMOVE TAR BUILDUP WITH KEROSENE #2 FUEL OIL OR DIESEL FUEL. DO NOT ALLOW SOLVENT TO GET INTO THE CYLINDER OR DAMAGE MAY OCCUR. DRY OFF THE TOOL COMPLETELY BEFORE USE.

# CLEARING A JAM FROM THE TOOL



DISCONNECT THE AIR SUPPLY.



PRESS DOWN LEVER (043).



INSERT LONG NOSE PLIERS OR SCREW DRIVER TO CLEAR JAM.

PULL BACK LEVER (043).

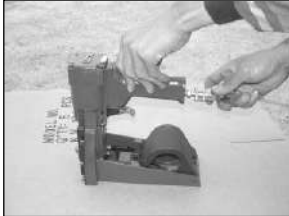
# TROUBLESHOOTING

## WARNING

**STOP USING THE TOOL IMMEDIATELY IF ANY OF THE FOLLOWING PROBLEMS OCCUR. SERIOUS PERSONAL INJURY COULD OCCUR. ANY REPAIRS OR REPLACEMENTS MUST BE DONE BY A QUALIFIED PERSON OR AN AUTHORIZED SERVICE CENTER ONLY.**

PROBLEM	CAUSE	REMEDY
AIR LEAKAGE FROM TRIGGER.	O-RINGS ON VALVE (016) OR ON TUBE (017) ARE DAMAGED.	O-RINGS MUST BE REPLACED.
AIR LEAKAGE FROM EXHAUST PORT.	O-RINGS ON VALVE (016) OR ON TUBE (017) ARE DAMAGED.	O-RINGS MUST BE REPLACED.
	PISTON'S O-RING (507) IS DAMAGED.	O-RING MUST BE REPLACED.
AIR LEAKAGE FROM CYLINDER.	PISTON ROD PORT O-RING IS DAMAGED.	REPLACE THE O-RING.
SLOW AND SHORT TRAVEL CYCLING	CHECK FOR LOOSE END SCREW (517) AND WEAR OF PARTS (014, 009)	POSITION ECCENTRIC PIN (013) AS SHOWN AND TIGHTEN SCREW (517) RECHECK, FOR MAXIMUM EFFICIENCY, SLIGHT ADJUSTMENT OF PIN AT THE POSITION SHOWN MUST BE MADE UPWARD DIRECTION IF SHORT TRAVEL OCCURS AND DOWNWARD DIRECTION IF SLOW CYCLING OCCURS.
EXCESSIVE JAMS:	SLOW AND SHORT TRAVEL CYCLING.	CHECK AS NOTED IN SLOW AND SHORT TRAVEL CYCLING SECTION.
	TEETH SCREWS LOOSE.	TIGHTEN SCREWS
	STAPLE SIZE IS WRONG.	USE THE PROPER SIZE STAPLE
	INSUFFICIENT LUBRICATION.	CLEANING AND LUBRICATION SUITABLY.
UNEVEN CLINCH	WRONG STAPLE SIZE.	CHECK FOR PROPER LEG LENGTH & ADJUSTMENT CLINCHER.
UNCLINCHED STAPLE	TEETH (021,022) LOOSE	TIGHTEN TEETH (021,022)
	TEETH (021,022) ARE	REPLACE TEETH (021,022)
	SLOW AND SHORT TRAVEL CYCLING.	CHECK AS NOTED IN SLOW AND SHORT TRAVEL CYCLING SECTION.

# TEETH REPLACEMENT



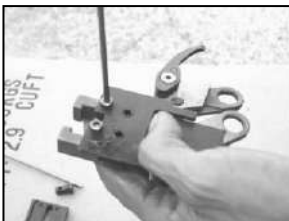
NOTE : DISCONNECT THE AIR SUPPLY.



LOOSEN SCREWS (530) WITH 4 MM HEXAGON WRENCH KEY.



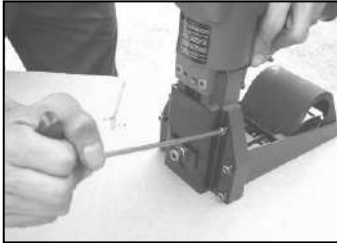
REMOVE THE MAGAZINE (039) ASSEMBLY.



LOOSEN SCREWS (532) WITH 3 MM HEXAGON WRENCH KEY.  
CHANGE TEETH ONE AT A TIME TO PREVENT REVERS TEETH.

# DRIVER REPLACEMENT

NOTE : DISCONNECT THE AIR SUPPLY.



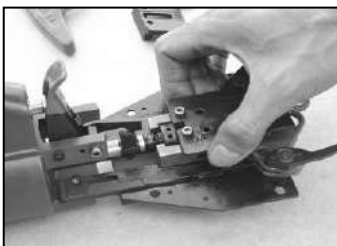
LOOSEN SCREWS (530) WITH 4 MM HEXAGON WRENCH KEY.



REMOVE THE MAGAZINE (039) ASSEMBLY.



LOOSEN SET SCREW (526) WITH 3 MM HEXAGON WRENCH KEY TO UNLOCK ADJUSTING ROD (018)



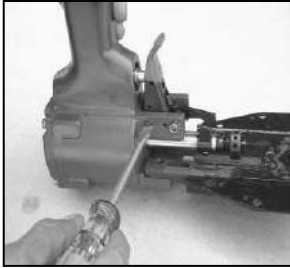
SLIDE LINKAGE MECHANISM AND ADJUSTING ROD (018) SIMULTANEOUSLY FROM COLLAR (006)



LOOSEN SCREWS (535) WITH 3 MM HEXAGON WRENCH KEY.  
TAKE OFF THE SPRING PIN (537) WITH HAMMER AND 6 MM STRAIGHT ROD.

# VALVE'S AND TUBE'S O-RINGS REPLACEMENT

**NOTE : DISCONNECT THE AIR SUPPLY**



LOOSEN SCREWS (513) WITH FLAT SCREW DRIVER.



REMOVE SPRING (012) WITH LONG NOSE PLIERS.



REMOVE C-Ring (545) WITH C-Ring Pliers.



REMOVE VALVE (017) AND TUBE (016) WITH A LONG NOSE PLIERS.

# PISTON REPLACEMENT



**NOTE : DISCONNECT THE AIR SUPPLY.**

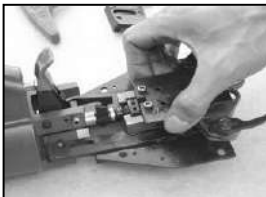
REMOVE SCREWS (530) WITH 4 MM HEXAGON WRENCH KEY.



REMOVE THE MAGAZINE (039) ASSEMBLY.



LOOSEN SET SCREW (526) WITH 3 MM HEXAGON WRENCH KEY TO UNLOCK ADJUSTING ROD (018).



SLIDE LINKAGE MECHANISM AND ADJUSTING ROD (018) SIMULTANEOUSLY FROM COLLAR (006).



LOOSEN COLLAR (006) WITH 3 MM STRAIGHT ROD.  
REMOVE SPRING (005).



LOOSEN SCREW (510) WITH 3 MM HEXAGON WRENCH KEY.  
REMOVE BLOCK (004) THROUGH WINDOW.



LOOSEN SCREWS (501) WITH 3 MM HEXAGON WRENCH KEY.  
REMOVE CAP (001).



REMOVE PISTON ASSEMBLY.  
LOOSEN NUT (504) WITH 10 MM SPANNER.

REMOVE PISTON (002) AND EXCHANGE A NEW ONE.