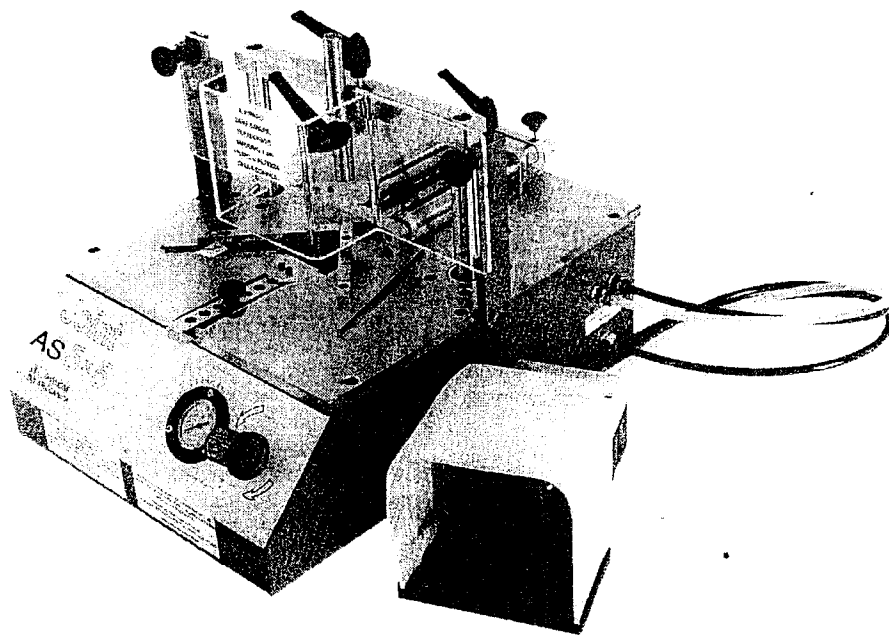
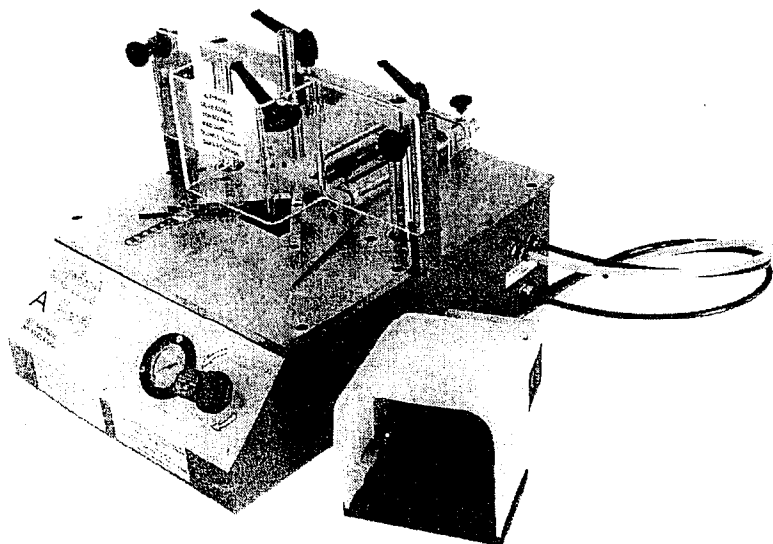


# JOINT

## 5x5 A e 5x5 AS

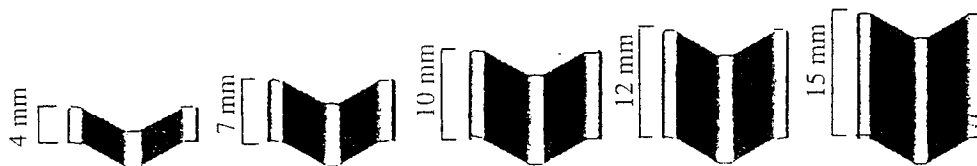
### Use - Maintenance - Spare Parts



## UNISCE·E RISOLVE

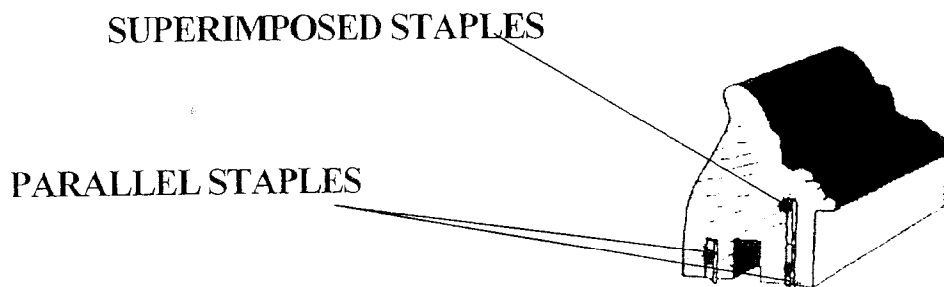


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All PILM INTERNATIONAL machines type "5x5" & "JUMBO" use only staples patented by PILM. The special shape of PILM staples allows to joint the angle putting in traction the two pieces, in order to reach a very good quality in the joint.

PILM special staples having double sharpening edge have been created purposely for particular woods, such as strong woods as oak, walnut etc. or when it is necessary to superimpose several staples for a better result. The use of PILM double edge staples is recommended with at least two parallel staples in order to obtain a good fastening of the moulding.



### NORMAL STAPLES

<u>Dimension</u>	<u>Pieces per box</u>	<u>Weight in Kg.</u>
4 mm.	6000 pcs.	0,800
7 mm.	4000 pcs.	0,980
10 mm.	3000 pcs.	1,000
12 mm.	3000 pcs.	1,250
15 mm.	2000 pcs.	1,000

### DOUBLE SHARPENING STAPLES

<u>Dimension</u>	<u>Pieces per box</u>	<u>Weight in Kg.</u>
7 mm.	4000 pcs.	0,980
10 mm.	3000 pcs.	1,000
12 mm.	3000 pcs.	1,250
15 mm.	2000 pcs.	1,000

PILM INTERNATIONAL can also supply universal staples which can be used for competitors' machines and special staples for particular types of machines.

# JOINT 5X5 A & 5X5 AS

## INDEX

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9. LOADING AND CHANGING OF THE STAPLES
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12. ADJUSTMENT OF THE WORKING PRESSURE
13. FRAME'S JUNCTION: ADJUSTMENT OF THE SQUARE
14. FRAME'S JUNCTION WITH SEVERAL PARALLEL STAPLES
15. INTRODUCTION OF MORE SUPERIMPOSED STAPLES
16. CHECK AND ADJUSTMENT OF THE JOINT
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20. WHAT YOU HAVE TO DO IF..... PROBLEMS AND SOLUTIONS
21. THE STAPLES

**BEWARE : THIS MANUAL OR A COPY OF IT MUST ALWAYS BE AT OPERATOR'S DISPOSAL FOR CONSULTATION; THE MANUAL MUST BE KEPT TOGETHER WITH THE MACHINE IN CASE IT SHOULD BE LENT OR SOLD.**

## **1. GENERAL SUGGESTIONS**

- Keep the packing in case the machine should be sent back for repair or maintenance.
- Use compressed air and a wet cloth to clean the machine. Do not use alcohol or solvents especially on plastic parts, *plexiglass* protection and manometer panel.
- Do not feed the machine before reading the instructions carefully.
- Protection parts & systems must be always in function; it is forbidden to misplace or to remove them.

## **2. GUARANTEE**

The machine's and constructor's identification label is placed on the back part of the machine's shell.

Do check the machine on delivery in order to verify possible transport damages. Each claim must be addressed to PILM in written within 3 days from receipt of the goods.

The guarantee is valid 12 months starting from the date of purchase. Substitutions or repairs in guarantee time will not extend in any case the guarantee terms.

The guarantee consists in the substitution or repair of parts having defects already at the origin phase. In any case transport fees, custom duties and VAT are at buyer's charge.

Direct and indirect compensations for damages are excluded.

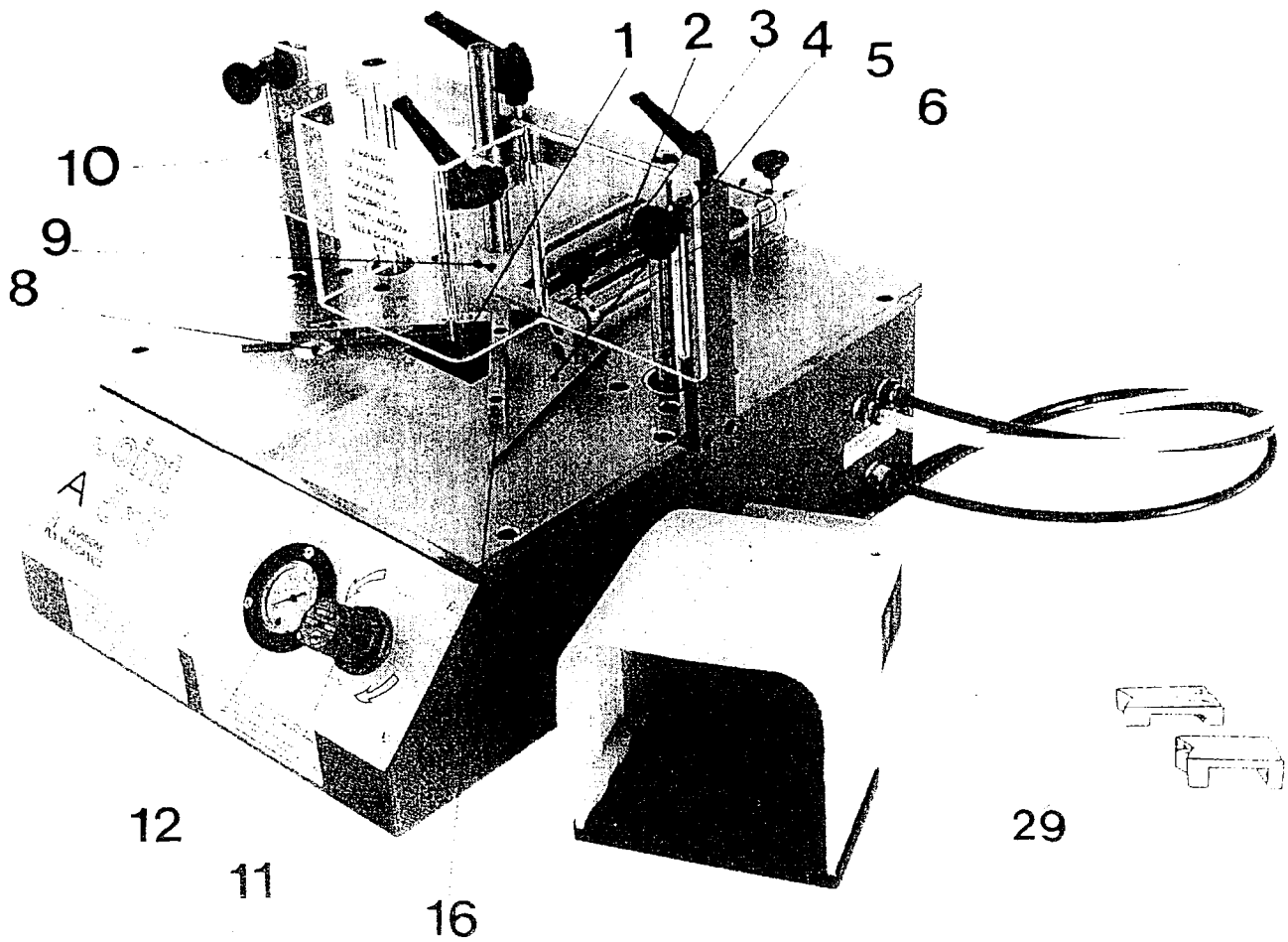
The guarantee is not valid in the following cases :

- instructions in the present manual are not respected
- modifications are made without previous approval of the constructor
- repairs are made by unauthorized personnel
- the machine is not used properly
- original parts have been replaced with those of a different brand
- staples of other manufacturers have been used

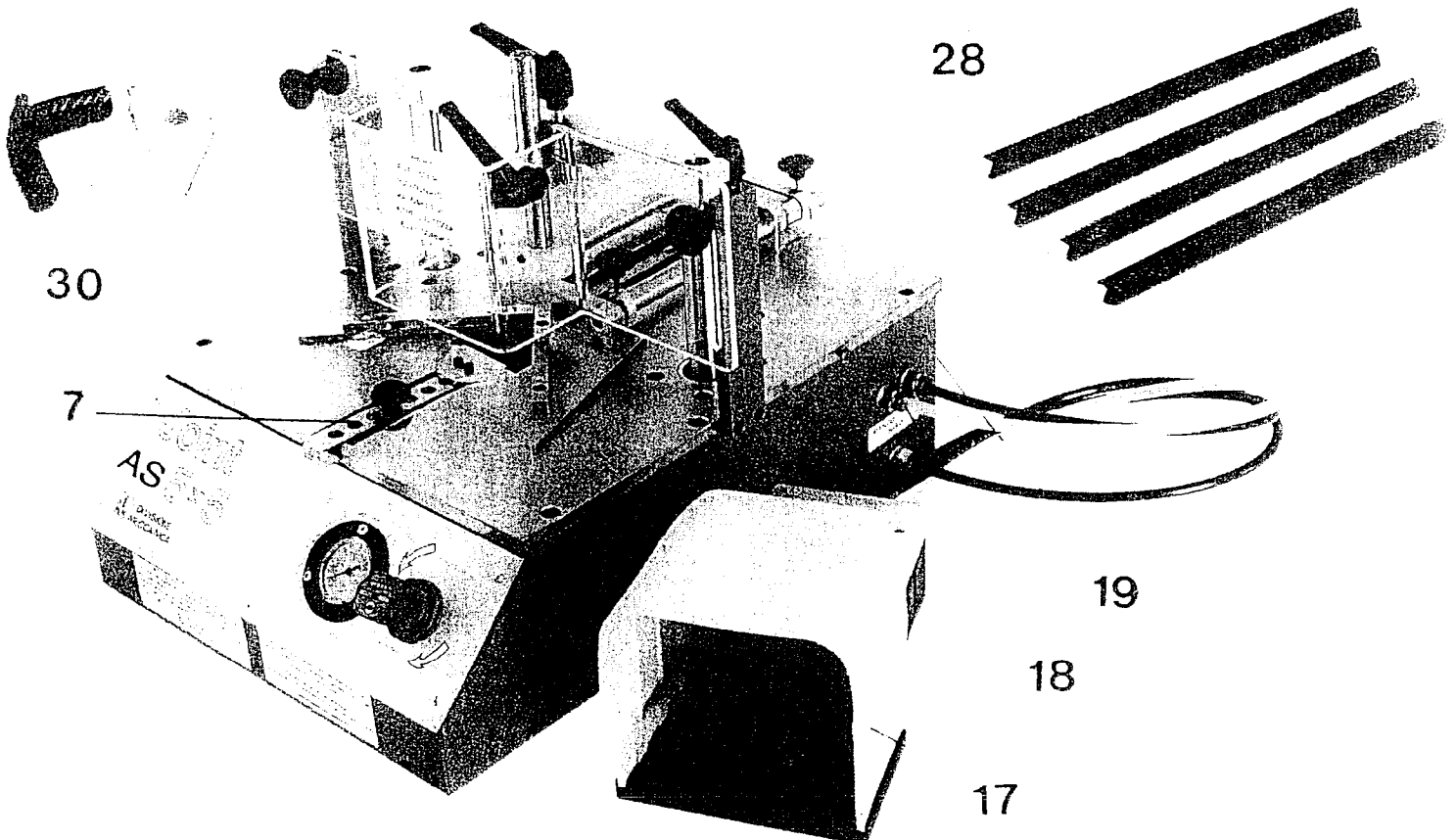
## **3. SAFETY RULES**

The machine is not dangerous if used properly, as described in the instructions. In any case do please pay attention to the following points:

- Keep fingers away from the vertical blocking working area
- During maintenance activity disconnect the pneumatic feeding from the machine
- During setting of the machine, do keep the foot far from the pedal
- The machine has been created and built to joint mouldings using PILM's staples: each other use is strongly not suggested. PILM declines any responsibility
- PILM will have no responsibility for possible damages coming from arbitrary modification made on the machine



# JOINT 5x5 AS



## VERY IMPORTANT

THE MACHINE IS EQUIPPED WITH A TRANSPARENT PROTECTION MADE OF PLEXIGLASS IN ORDER TO AVOID FINGERS OR HANDS GETTING CLOSE TO THE WORKING AREA. SUCH PROTECTION MUST ALWAYS STAY IN ITS POSITION, PLACED MAX. 1 cm. OVER THE MOULDING YOU HAVE TO JOINT.

IF THE PROTECTION IS NOT CLOSED ACCURATELY OR IF IT HAS BEEN REMOVED, THE MACHINE STOPS ITS ACTIVITY AND DOES NOT PROCEED WITH THE WORKING CYCLE.

## 4 PREMISE

This operator manual is integral part of the machine, it gives all information concerning its functioning and maintenance. Before proceeding with any operation, it must be read carefully.

The JOINT 5x5 is a good quality machine, it is fast and requires very simple maintenance. Following these instructions you will use the machine in the best way and it will always be efficient. In any case, our technical staff is always at your disposal for any request or question should you have.

## 5 TECHNICAL FEATURES

DIMENSIONS	dept 45 cm., width 35 cm., total height 32 cm., workingtop's height 15 cm.
WEIGHT	28 kg.
FEEDING	lubricated and filtered pressed air ( the lubrication filter should stay no more than 5 m. from the machine, otherwise the underpinner should be equipped with its own lubricator)
MAX. PRESSURE	12 atm.
WORKING PRESSURE	min. 2,5 atm. / max. 7,5 atm.
TEMPERATURE	from -15° to +70°
USE	moulding angle junction having a min. h. of 5 mm. and a max. one of 110 mm., a min. width of 5 mm. and a max. one of 130 mm., using PILM's staples having an height of 4-7-10-12mm.
WORKING SPEED	60 cycles per minute
MATERIALS	supports and mechanical parts are made of steel treated for a long oxidation resistance. Workingtops, fences, rods, etc. are treated on the surface (chromated) for a long wearproof. Driving plates and hammer are made of tempered steel. Side and central cylinders are made to grant their efficiency for a very long time. The washers are made of antioil nitrilic rubber able to resist to substances normally present in the pneumatic circuits

## 6 ACCESSORIES

- nr. 4 thickness compensators for staples
- nr. 1 flat angular pad
- nr. 1 round angular pad
- nr. 1 set with 5 wrenches for maintenance
- nr. 1 magnet for the loader cleaning
- nr. 2 staples' pushers: 1 for an h. of 4 and 7 mm., 1 for an h. of 10,12 and 15 mm.

1. NAILING HEAD WITH DRIVING PLATES AND HAMMER
2. LOADER WITH INTERCHANGEABLE THICKNESS COMPENSATORS IN ORDER TO USE ALL STAPLES' SIZES (7-10-12 mm. standard supplied, 4-12 mm. only on request)
3. STAPLEPUSHER TROLLEY WITH RETRACTABLE TIE-ROD
4. 90° FENCE
5. FENCE ROD
6. ADJUSTING SMALL WHEELS R1 AND R2 IN ORDER TO FIRE 2 OR MORE PARALLEL STAPLES
7. FRONTAL CLAMP UNIT (ONLY FOR THE JOINT 5X5AS)
8. METRIC SCALE
9. UPPER CLAMP UNIT, ADJUSTABLE IN HEIGHT, HAVING INTERCHANGEABLE PAD
10. TRANSPARENT PROTECTION, ADJUSTABLE IN HEIGHT
11. PRESSURE REGULATOR WITH WORKING AREA SELECTION FROM 2,5 TO 7,5 atm.
12. MANOMETER FOR INDICATION OF THE MOULDING'S CLAMPING PRESSURE
16. FENCE'S RISERS AND FOR ANGLE REGULATION
17. PEDAL
18. CONNECTION PIPES OF THE PEDAL TO THE MACHINE
19. EXTERNAL COMPRESSED AIR FEEDING LINE ENTRY
28. INTERCHANGEABLE THICKNESS COMPENSATORS
29. STAPLES-PUSHER UNITS
30. INTERCHANGEABLE PADS

## 8. START-UP

The Joint 5x5A and AS are supplied already assembled and ready to work with the staples. The start-up of the machine exclusively needs the connection to the feeding line and the connection of the pedal's pipes to the junctions, accordingly to the colors on the machine. **BEFORE CONNECTING THE MACHINE TO THE FEEDING LINE, REMOVE THE UPPER CLAMP UNIT (and the frontal clamp on the Joint 5X5AS.)**

By stepping on the pedal the staple will be inserted. BEWARE! The pedal is a dual foot control operated pedal, therefore its first stroke's part controls the upper clamp unit and, only on the Joint 5x5AS, the frontal clamp unit as well, then there is a short idle stroke, and after that the final stroke controls the nailing head unit.

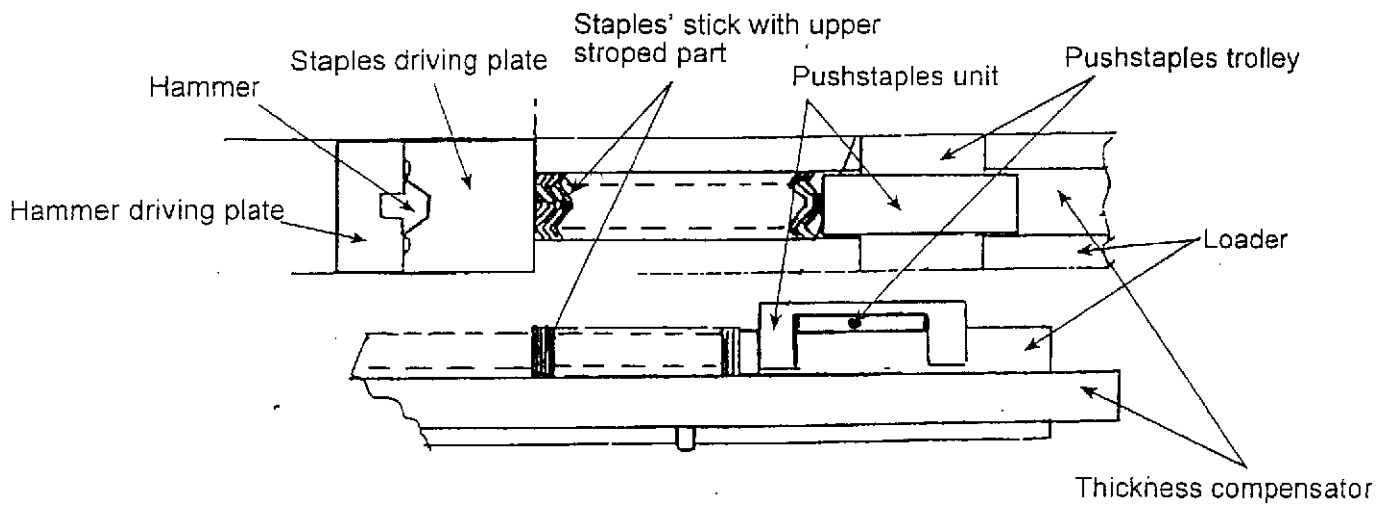
When the machine is new or if it has been out of service for a certain period, it is suggested to use it without joining any moulding, by firing out 4 or 5 staples without shooting them into the wood.

## 9. HOW TO LOAD AND REPLACE THE STAPLES (SEE DWG. A)

For the first loading of the staples proceed according to the following instructions: verify that the loader is empty, place the thickness compensator in the loader bottom, if it is necessary do insert the magnetic feeler supplied with the machine (each thickness compensator shows the dimension of the staples to be used with - the 15 mm. staples do not need any thickness compensator), check that the thickness's pivot is well inserted in the hole situated on the loader's bottom. Draw back the staplepusher trolley and insert the staples having the sharpened part - the one with glue - positioned upward and the two points ahead according to the drawing. Considering the height of the staples, insert in the trolley the proper staplepusher unit and then release it again.

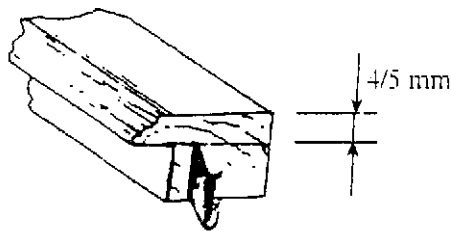
To put more staples in the loader just draw back the staplepusher trolley acting on the fitting tie-rod, introduce the new stick and release the trolley again.

In order to change size of the staples, just draw back the trolley and take off the staplepusher unit. Remove from the loader either all staples or the thickness compensator, make sure that the driving channel of the loader is perfectly clean (inserting a magnetic feeler) and then introduce the new thickness compensator and proceed with the loader as already described.

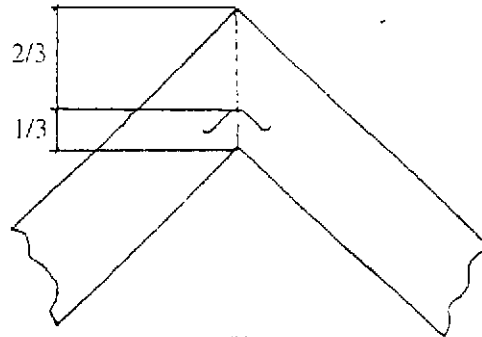


## 9 STAPLES LOADER

DIS. A

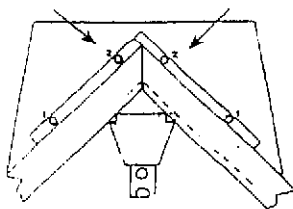


DIS. 1



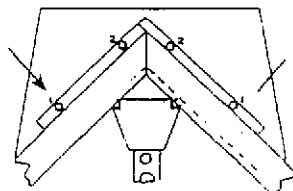
DIS. 2

## 15 JUNCTION WITH ONE STAPLE



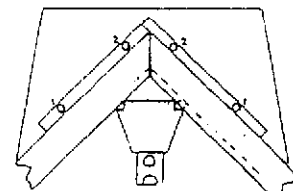
EXTERNAL OPEN ANGLE

Loosen the screws 2 and close the angle.



INTERNAL OPEN ANGLE

Loosen the screws 1 and close the angle.



UPWARD OPEN ANGLE

Loosen the screws 1 and 2 and place the rods aligned to the fence wall, till the closing of the angle.

## 18 CHECK AND ADJUSTMENT OF THE JOINT



## 10. ADJUSTMENT AND USE OF THE UPPER CLAMP UNIT

The presser of the machine is adjustable in height and its end part, the one touching the moulding, is interchangeable. The interchangeable pads are three and can be used according to your needs. The use of the round one is suggested for shaped mouldings and surfaces not even, the one made of nylon d. 40 is for flat or round surfaces, the flat angular is instead suitable for wide shaped mouldings and in particular for tender wood in order to avoid deformations in the contact points. Felts, rubbers or particular shapes can be used according to your needs.

The clamp can be regulated both in height and crosswise: it is suggested to place it in height at 15/20 mm. from the moulding and crosswise in axis with the axis of the coming out staple. In order to insert more parallel staples, the correct procedure is to place the presser in the middle of the area where the staples have to be inserted. To avoid the sliding of the clamp, the presser's rod has grooves where the rubber bands of the vice must be inserted; to be sure it is done properly, once the clamp has been positioned at the wished height, verify that it is moving freely and then lock it with the lever.

**BEWARE:REMEMBER TO REPLACE THE PROTECTION AT THE END OF THE CLAMP'S ADJUSTMENT OPERATION, 10/15 mm. OVER THE MOULDING TO BE JOINTED.**

## 11. ADJUSTMENT AND USE OF THE FRONTAL CLAMP (ONLY FOR THE JOINT 5X5 AS)

The Joint is equipped with a system for the frontal clamp of the moulding that works at the same pressure of the upper clamp unit and its value is given by the manometer. The frontal clamp, which starts moving always immediately before the upper clamp unit, allows the moulding to absorb the thickness of the staples, achieving a much better closing in the back part of the angle. The use of the frontal clamp unit is very important while working with small sectioned mouldings that require just one staple. Frontal clamp unit must be positioned 10/15 mm. from the moulding. In order to change its position, unthread the bored rod from the fix pivot and introduce it in another hole.

## 12. ADJUSTMENT OF THE WORKING PRESSURE

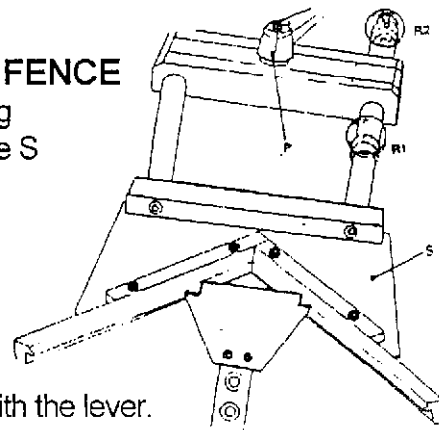
The machine is equipped both with a working pressure regulator and a manometer. The machine works normally between 2.5 atm and 7 atm, in particular 2.5/4 atm. is used for tender woods, 4 / 5.5 atm. for medium woods and 6 / 7 atm. for strong woods. In order to adjust the pressure, draw the knob of the regulator and turn it clockwise to increase it and in the opposite direction to decrease it. The manometer will show the variations. Once the desired pressure has been found, press the regulator's knob to block it and to avoid any changes.

**BEWARE : DO NOT REGULATE THE PRESSURE IF THE MACHINE IS NOT FEEDED.**

## 13. MOULDING'S JUNCTION. ADJUSTMENT OF THE FENCE

After having chosen the suitable staple for the height of the moulding according to the general indications of drawing N. 1, place the fence S so that the staple can be inserted as per drawing 2 : therefore loosen the lever P, move the fence to the desired position and block the lever P.

Place the frontal clamp at 5 / 10 mm. from the moulding (only for the JOINT 5X5 AS). According to the shape of the moulding, position the selected pad of the upper clamp unit at 15 mm. from the moulding and block it with the lever. Place the two pieces to be jointed against the fence till they touch at the very top, then step on the pedal completely and release it only after the the hammer has gone upward. Your angle is done!

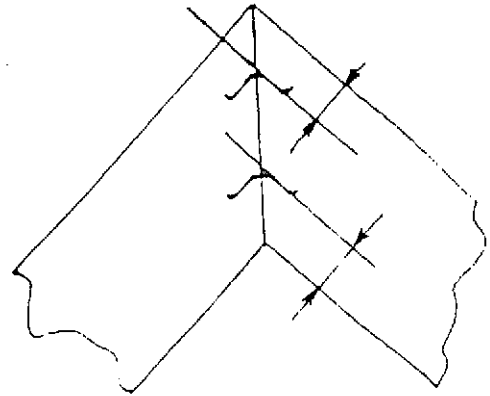


## 14. MOULDING'S JUNCTION WITH MORE PARALLEL STAPLES

When working with mouldings thicker than 1.5 cm. it is necessary to insert more parallel staples (dwg. 3) to reach a good junction.

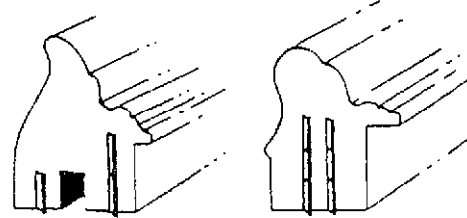
The machine allows to use 2 or more parallel staples.

Remove the frontal clamp (in the JOINT 5X5 AS) in order to introduce 2 parallel staples, release the lever P (see dwg. Point 15), position the fence in order to fire the internal staple, block the register R1 against the fence's support G, then position the fence in order to fire the external staple, therefore block the register R2 against the fence's support G. Moving the fence manually backward and forward alternatively and repeating each time the machine's working cycle, the two positions for inserting the staples are obtained. Other staples can be inserted in the intermediate positions.



## 15. INSERTING MORE SUPERIMPOSED STAPLES

When working with mouldings thicker than 20 mm. it is useful to fire two or more superimposed staples, in order to reach the best angletight. To achieve this, follow the instructions as per the operations with just one staple and keeping everything blocked with the first pedal's stroke, repeat the second pedal's stroke as many times as the number of staples you want to superimpose.



## 16. CHECKING AND REGISTRATION OF THE JUNCTION

This registration is valid only for the JOINT 5X5 AS, which is equipped with the frontal presser that has to be adjusted respect to the fence, as per point 11; do not assemble the upper presser! Step on the pedal and observe the angle obtained by the 2 wooden pieces, follow the directions as per dwg. 5, according to the different cases.

The only way to open and close the angle in the JOINT 5X5A is by operating on the holes and the screws positioned on the thickness of the fence's risers.

**BEWARE !**

1) The fence's angle is 90°. Should there be any defects or negative results - although having adjusted each angle perfectly -, the reason must be searched on the wooden pieces' cut or on the twisted rods.

2) When working with the staple on strong or medium/strong wooden mouldings thicker than 8/10 mm., the edge will always show a slight opening towards the end due to the staple's thickness which is not absorbed by the wood. The inconvenience can be solved by using properly the frontal clamp and when possible a shorter staple.

## 17. THE PNEUMATIC CIRCUIT

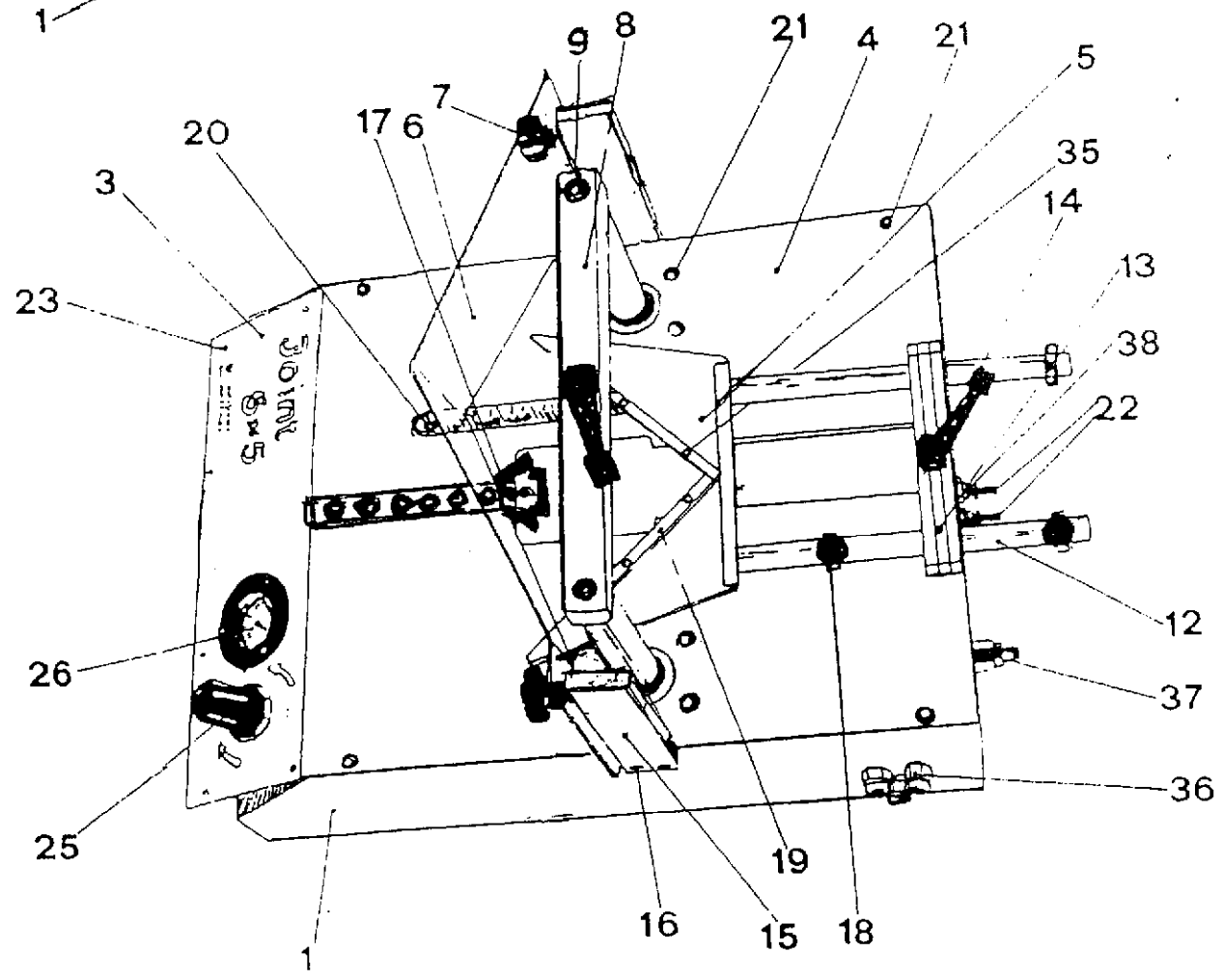
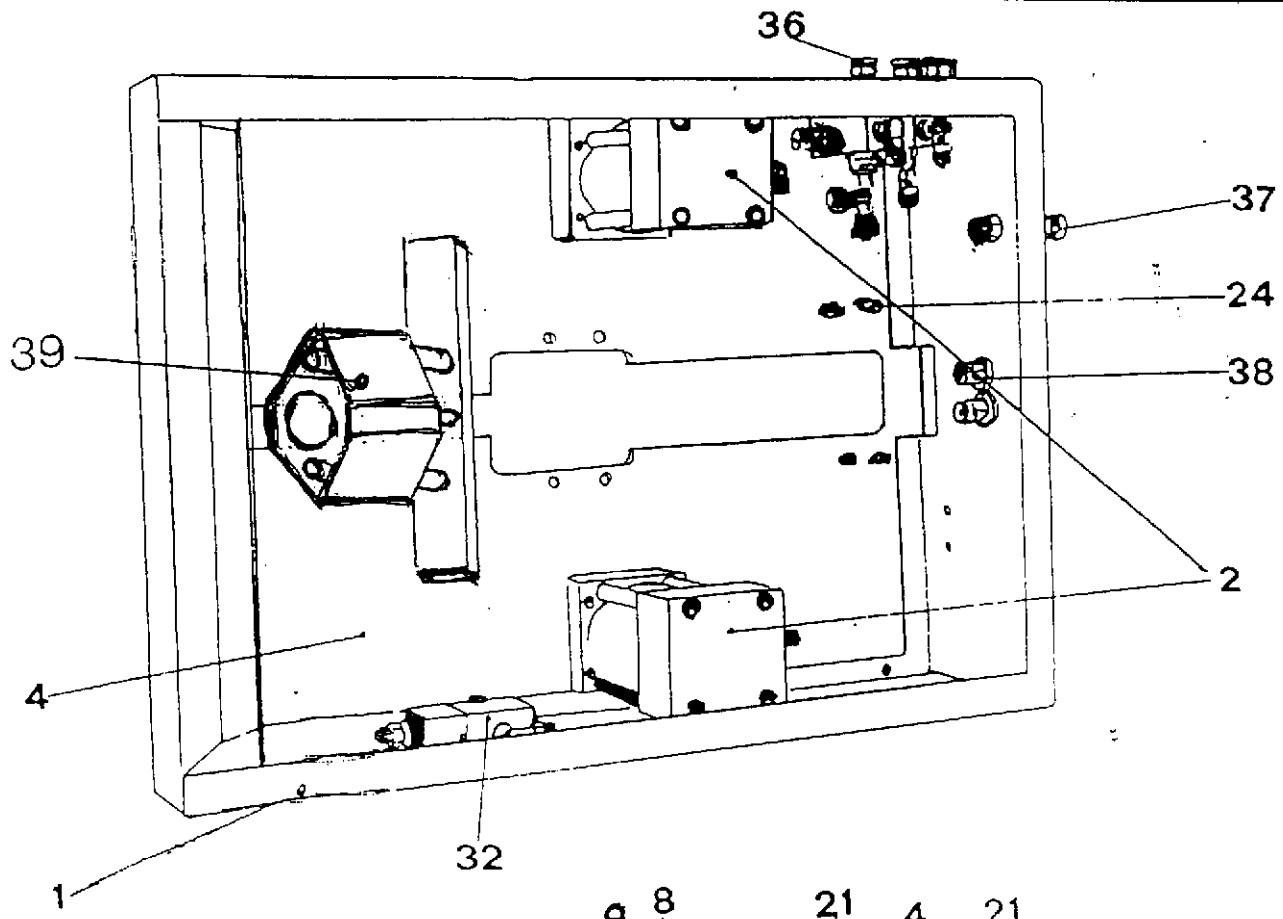
The JOINT 5X5 is equipped with reliable pneumatic components that normally do not need any maintenance. However the working area and the quality of compressed air of the feeding line are indispensable for the life of the parts.

Clean, dry and oil vaporized air guarantees a long life. Before the air goes through the machine, it is recommended to install a filter and lubrication device (our device is in the optionals' list); use hydraulic oil, which is not aggressive for the rubber nitrilic washers, with viscosity between 5÷8 E at 20 °C.

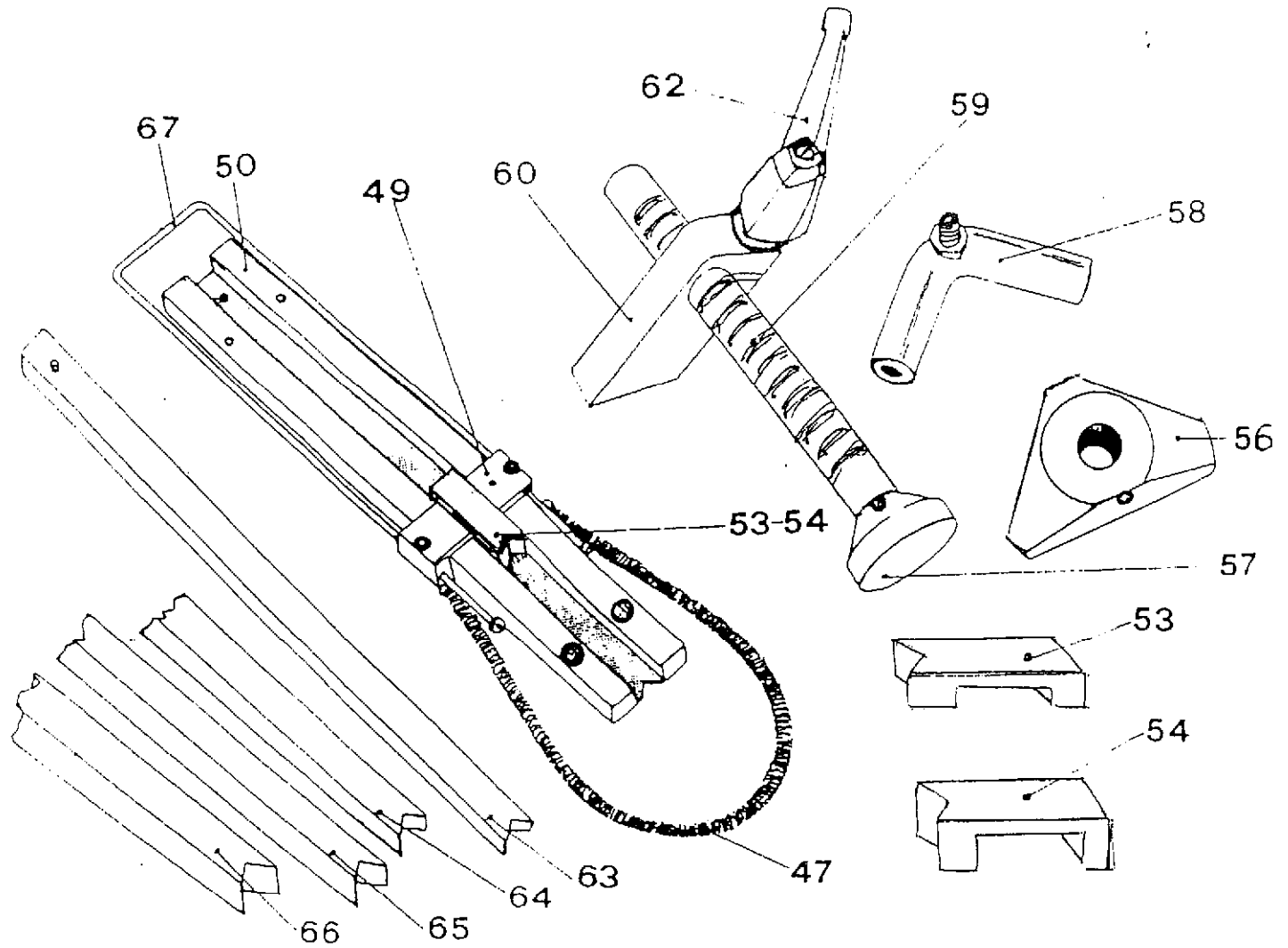
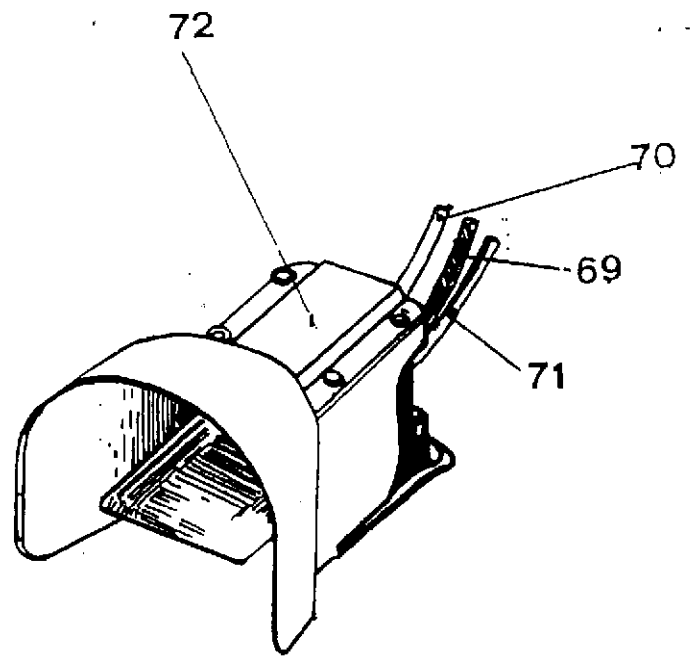
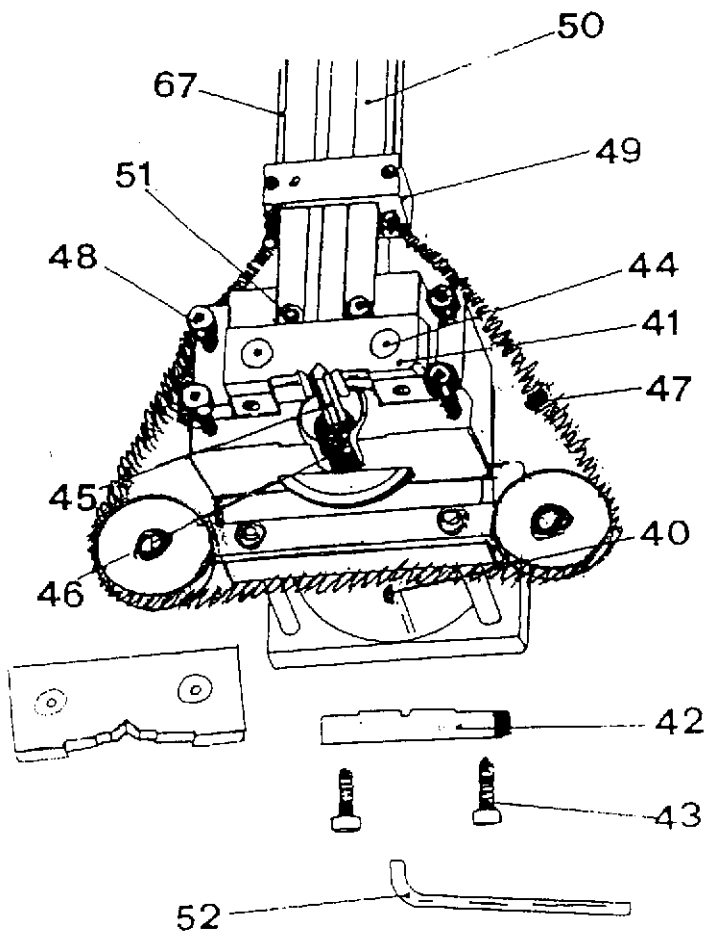
Should there be need of maintenance on any connection (to replace some components or something else), do pay attention to reassemble it using some *teflon* tape; make sure to leave loose the first connection's thread in order to avoid that any tape's fragment goes inside the pneumatic components.

Every 4-5 days it is opportune to clean the pedal with compressed air. It is recommended to do it more frequently if the working area is very dusty.

Every 20-30 days repeat the same procedure inside the machine, especially on the valves' muffler filters.









## 19. OPTIONALS

### **REDUCTIONS FOR HEXAGON (120 °) AND OCTAGON (135°)**

To position the fence from 90° to 120° or 135° proceed by loosening the blocking screws of the fence's supports and instead of these fix the the reduction's fence at 120° or 135°. Execute the joining as described for the 90° angle.

### **LUBRICATION FILTER DEVICE F.L.**

(Only if your F.L. is farther than 5 m. from the machine)

The equipments using compressed air need clean and conveniently lubricated air. The filter lubricator F.L. complies to these two important requirements. The filter F blocks all impurities due to the compressor's suction, such as dust, rust particles of the line of compressed air and umidity, allowing only clean and dry compressed air for a longer life of cylinders and valves. The lubricator L gives the correct oil quantity to the compressed air allowing a continuous lubrication of the machine's parts.

For the maintenance of the filter F check every 10-15 days the condensation's discharge through the screw device placed at the bottom of the container.

If the working area is very dusty, every 30-60 days clean the filter by blowing air after having loosened the container (without having pressure in line).

Check the oil level of the lubricator through the little windows on the container and add more oil each time should it be necessary. The adding must be done by loosening the container without pressure in line.

**BEWARE! THE ABOVEMENTIONED OPERATIONS MUST ALWAYS BE DONE AFTER HAVING DISCONNECTED THE COMPRESSED AIR!**

The adjustment of the oil can be done by acting on the screw placed at the top of the lubricator: the correct adjustment is performed when one drop of oil is formed (and therefore drops) every 30-40 times the pedal has been stepped on (complete working cycles).

**BEWARE! USE ONLY HYDRAULIC OIL – NOT AGGRESSIVE - FOR THE NITRILIC RUBBER WASHERS.**

The suggested oil should have a viscosity of 6-8°E at 20°C. This type of oil is available at any reliable dealer of pneumatic components or directly at PILM.

### **THICKNESS COMPENSATORS FOR STAPLES H4 AND 12 MM.**

They complete the set of thickness compensators in order to work with all the staples' heights.

### **GLUEING DEVICE**

All PILM machines can be equipped with a glueing device through two connections placed at the back where two pipes must be jointed according to the different colours. The unit has a little piston with a glueholder pivot to be screwed on at the extremity for small sections. In case bigger sections have to be glued, a net-like device is available. By connecting the glueing device, make sure that the first step is the immersion in the glue container when stepping on the pedal, and secondly when the pedal is released the little piston (or net-like device) goes back to its initial position. When working with glue, be careful to clean thoroughly the area where the staples are inserted every time glue drops, in order to avoid lumps which could damage the closure of the moulding's angle or could clog the nailing head area.

It is also recommended to clean the glueing devices and the components which could get dirty after being used, and to close hermetically the glue container with the proper lid.

### **TILTING FLOOR STAND**

The JOINT 5X5 is a bench top machine. However it can be assembled on a tilting floor stand and with an amplified working table. It allows to work easily and more precisely big and medium mouldings, by tilting the stand at 80°. Each stand is supplied with detailed directions for assembly and use.



## **EXTENSION WINGS**

If the machine is placed on a table, in order to widen the working area for medium mouldings, the extension wings can be added. The extension wings are fixed on both right and left side of the machine into the proper threaded holes.

## **FENCE'S RISERS**

They are 7 mm. high bars which can be superimposed allowing to lift the moulding's leaning surface. They can also be helpful to adjust the angle by leaving a little play between hole and fixing screws.

## **PNEUMATIC FENCE CLAMP**

It is applicable on all 5x5 machines, especially on the JOINT 5X5 AS and the JOINT 5X5 SUPER instead of the blocking fence bar with lever. Each time the pedal is stepped on, the pneumatic fence clamp intervenes. In the 5X5 AS and 5X5 Super the pneumatic fence clamp allows to insert two parallel staples at a maximum distance of 15 mm. by using also the frontal presser for a better quality of the joining. The first step is to establish the two positions in which the staples will be inserted, then place the blocking fence bar at the minimum distance for the first position so that the remaining stroke can block the moulding also in the second position.

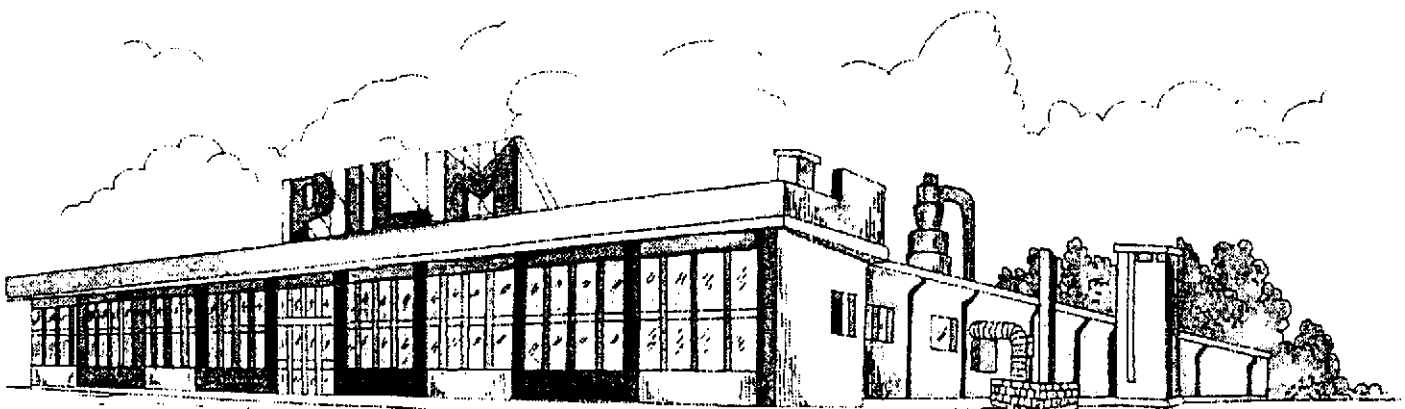
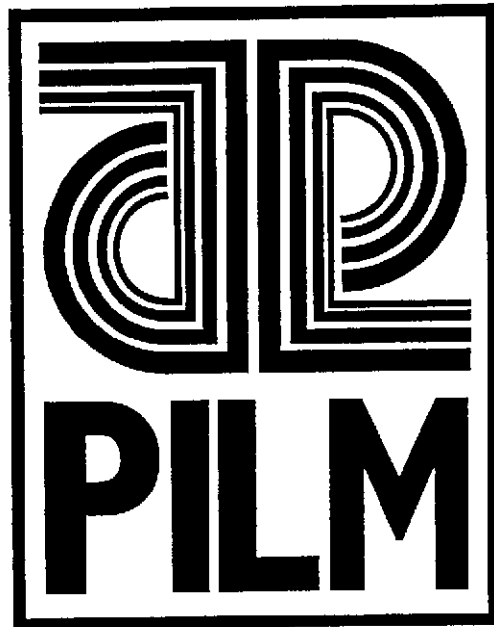
## **20. WHAT TO DO IF..... INCONVENIENCES AND SOLUTIONS**

- 1) ONCE THE MACHINE HAS BEEN CONNECTED TO THE COMPRESSED AIR, A CONTINUOUS AIR BLOW IS HEARD.
  - a) Search the leakage in the machine's circuit, if it is due to a loosened pipe, tighten it with the proper wrench.
  - b) If the leakage disappears by stepping on the pedal, check the connection of the pedal to the machine; if it is done correctly, the defect can be due to a pipe not perfectly inserted in its seat, therefore introduce it properly.
  - c) The leakage is found on the pressure regulator device which indicates a pressure over 8 atm.; lower the pressure by acting on the regulator device.
  - d) Peculiar air leakages :
    - If there is a leakage on the head control valve, both when the machine is in production or not, the valve itself can be out of order or there could be an air loss on the nailing head cylinder.
    - If in the same conditions as above, there is an air leakage on the pressers-cylinders' control valve, the reason can be the damaged valve or there could be an air loss of the presser's control cylinders. In both cases contact PILM customer care service.
- 2) AFTER CONNECTING THE MACHINE TO THE PNEUMATIC FEEDING LINE, THE MANOMETER DOES NOT DISPLAY THE PRESSURE
  - a) Verify that the pressure regulator is not in position 0
  - b) Verify if there is pressure in the feeding line
- 3) THE MACHINE IS CONNECTED TO THE FEEDING LINE, BUT DOES NOT WORK
  - a) If the manometer does not display the pressure; verify as per point 2
  - b) The speed regulator is on 0, increase it
  - c) The plexiglass shield is not placed correctly
- 4) ONCE THE PRESSURE HAS BEEN ADJUSTED, THE HAMMER DOES NOT COME OUT
  - a) The working pressure is too low; min. is 2.5 atm.
  - b) If the pressure is correct, proceed according to the following point no. 6
  - c) If the hammer has been replaced, it could hit under the plate; repeat the operation by checking that the hammer is in plane and that the head is not damaged.

- 5) ACTING ON THE PRESSURE REGULATOR, THE MANOMETER STAYS STILL
- The regulator is out of order, replace it
  - The manometer is out of order, replace it
  - If there is continuous and heavy blow, it means that a pipe is broken or disconnected: look for the breakdown and fix it.
- 6) THE HAMMER DOES NOT COME OUT
- The staples' stick is placed opposite to its way out.
  - One staple positioned itself crosswise in the magazine near the hammer's area : block the push-staples carriage, pull out the staples, insert the magnetic feeler and pull out the staple : if it doesn't come out because it is clogged, take off the frontal hammer-driving plate by unscrewing the two screws with the proper wrench, then remove the staple. Reassemble the plate, making sure to block it perfectly on the same level with the staples-driving plate. Insert the staples and release the staples-pusher.
- 7) THE STAPLE DOES NOT COME OUT
- The staples are missing
  - The pedal has been released too quickly, therefore the hammer did not start working : try again by doing it slowly.
  - Clogging up of the hammer's coming out area : proceed according to the point 7b.
  - The staples' pusher unit does not push the stick: make sure that it is clear otherwise check the spring or possible obstructions.
  - The thickness compensator is wrong or not correctly placed (it must be positioned under the staples and with the pivot into the hole located on the bottom of the loader).
  - The staples' stick has been positioned backwards.
  - The hammer's edge is worn out and it can not pick up the staple.
  - The stick is made of crooked staples.
- 8) THE STAPLE DOES NOT ENTER THE WOOD COMPLETELY
- The working pressure is too low, increase it.
  - The hammer does not come out completely: make sure there isn't any obstruction between hammer-holder pivot and hammer-driving plate; should there be, remove it with the magnet, if it is metallic, otherwise use a screwdriver or compressed air.
  - The presser does not block the frame: adjust the presser's height considering the 10-20 mm. frame
  - The hammer point is wore and the staple slides: replace the hammer
- 9) THE MOULDING DOES NOT GET CLAMPED
- The presser is too far from the moulding: position it 10-20 mm. from the moulding
- 10) THE FENCE GETS JAMMED WHILE IT IS IN FUNCTION
- The adjusting small wheels R1 & R2 are blocked: unblock them
  - There could be an obstruction under the fence : remove the fence and clean the area.
- 11) ONCE THE STAPLE HAS BEEN FIRED, THE MOULDING GOT LIFTED UP, THE ANGLE REMAINED OPENED AND THE STAPLE DID NOT ENTER COMPLETELY
- The presser has not been properly positioned : place it 10-20 mm. from the moulding
  - The working pressure is too low.

- 12) THE STAPLES-PUSHER DOES NOT PUSH THE STICK
- a) It is blocked at the end of its run.
  - b) The spring got unhooked: hook it.
  - c) The spring got extended and lost its flexibility : replace it.
  - d) It interferes with some piece inside the machine: turn it upside down and check.
- 13) STEPPING ON THE PEDAL COMPLETELY THE MOULDING DOES NOT GET CLAMPED, ONLY THE STAPLE GOES UP.
- a) Verify the flexible lever inside the pedal: if it is broken, replace it.

**HOWEVER, SHOULD YOU ENCOUNTER ANY PROBLEM WHICH YOU CAN NOT SOLVE OR UNDERSTAND BY YOURSELF, DO CALL OUR CUSTOMER CARE SERVICE BY DIALING 0039/0434/85031-85212.**



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