



Pneumatic Flexco® XP™ Staple Fastener Installation System

Ordering Number: XPPST Item Code:



Safety, Operation, and Maintenance Manual



WARNING

Improper use of this tool can result in serious bodily injury! This manual contains important information about product function and safety. Please read and understand this manual BEFORE operating the tool. Please keep this manual available for other users and owners before they use the tool. This manual should be stored in a safe place.

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Limited Warranty

Flexco warrants to the original purchaser that this product is free from defects in material and workmanship, and agrees to repair or replace, at Flexco’s option, any defective product within 1 year from the date of purchase. This warranty is not transferable. It only covers damage resulting from defects in material or workmanship, and it does not cover conditions or malfunctions resulting from normal wear, neglect, abuse, accident or repairs attempted or made by other than our regional repair center or authorized warranty service center.

To obtain warranty service, return the product at your expense together with proof of purchase to Flexco or a Flexco authorized distributor.

Introduction

Role of Applicator

The Pneumatic Staple Applicator is designed to be used with Flexco® XP™ Staple Fasteners.

Precision Built

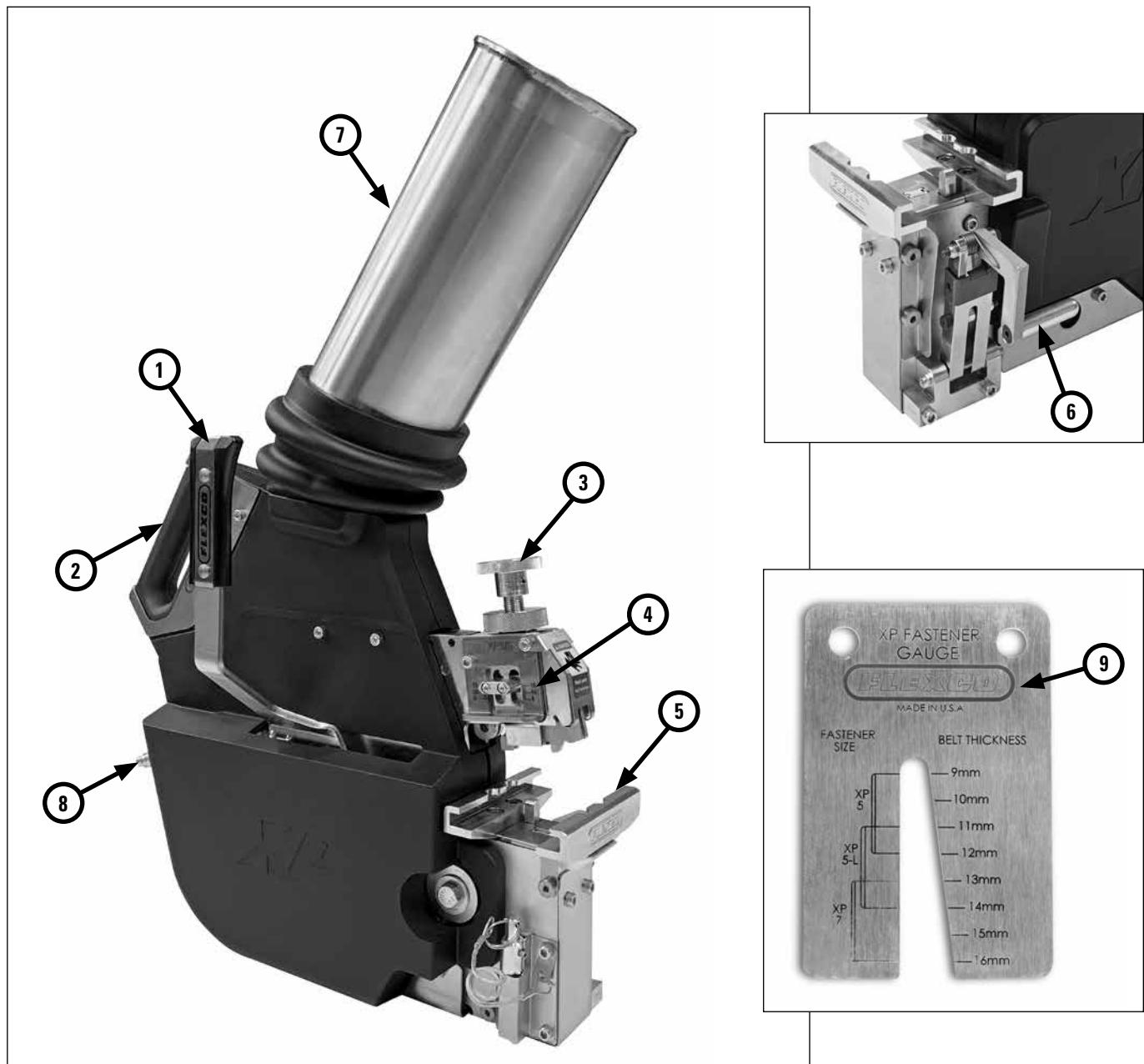
Flexco tools are precision-built tools designed for precise, high volume installation. These tools will deliver efficient, dependable service when used correctly and with care. As with any fine power tool, for best performance, the manufacturer's instructions must be followed. Please study this manual before operating the tool and understand the safety warnings and cautions. The instructions on installation, operation, and maintenance should be read carefully, and the manual kept for reference.

Flexco® XP™ Pneumatic Staple Applicator Specifications

Overall weight	28 kg (62 lbs)
Overall dimensions	762 mm x 508 mm (30" x 20")
Tool Air Fitting	Tool uses a 3/8" industrial shape designation male coupling. The airflow diameter should be .275" (7 mm) or larger. The fitting must be capable of discharging tool air pressure when disconnected from the air supply.
Operating Pressure	65 to 101 p.s.i. (4.5-7.0 bar) Select the operating pressure within this range for best fastener performance. DO NOT EXCEED THIS RECOMMENDED OPERATING PRESSURE.
Air Consumption	Tool requires 7 SCFM (where the pressure is at 14.7 psia and the temperature is at 72 degrees F (22.2 C)) or 198 L/m of free air to operate at the rate of 20 fasteners per minute, at 80 p.s.i. (5.6 kg/cm ²).
Coupling	ISO 6150/B 8mm profile, 3/8" industrial shape designation quick release coupling
Hose length (included with tool purchase)	7.6 meters (25 feet)

System Components

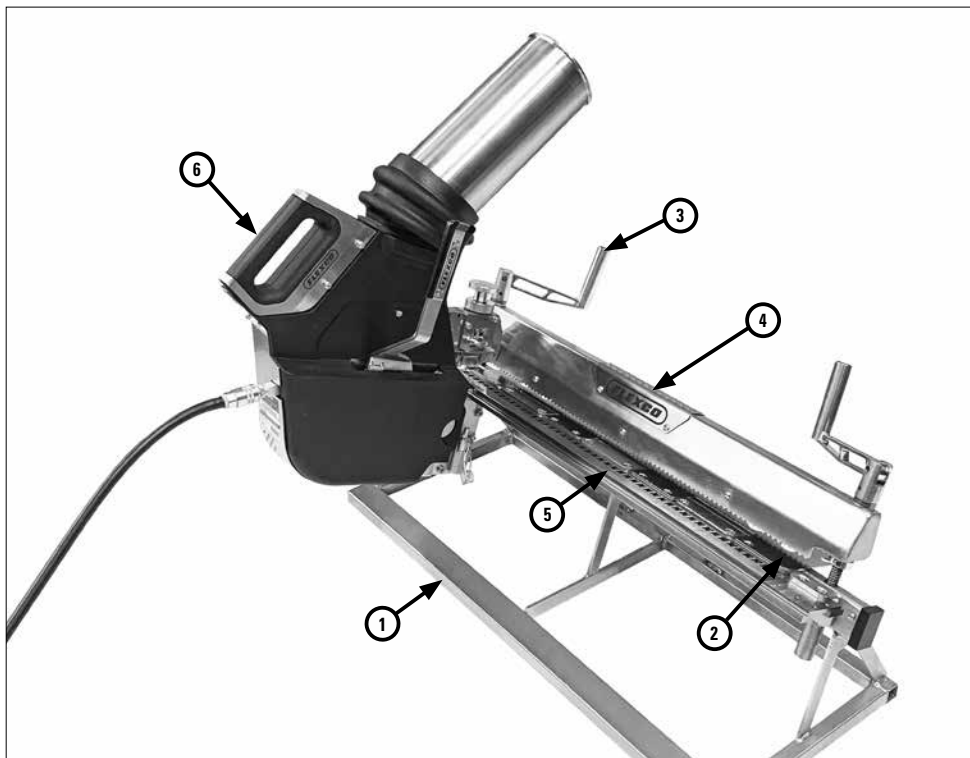
Flexco® XP™ Pneumatic Staple Applicator	
1. Advance/actuation handle	6. Advance mechanism lever
2. Carrying handle	7. Pneumatic cylinder
3. Fastener compression adjustment knob and lock	8. Air inlet: 3/8" Male quick release coupling
4. Integrated belt thickness gauge	9. Standalone belt thickness gauge
5. Mounting bracket	



System Components

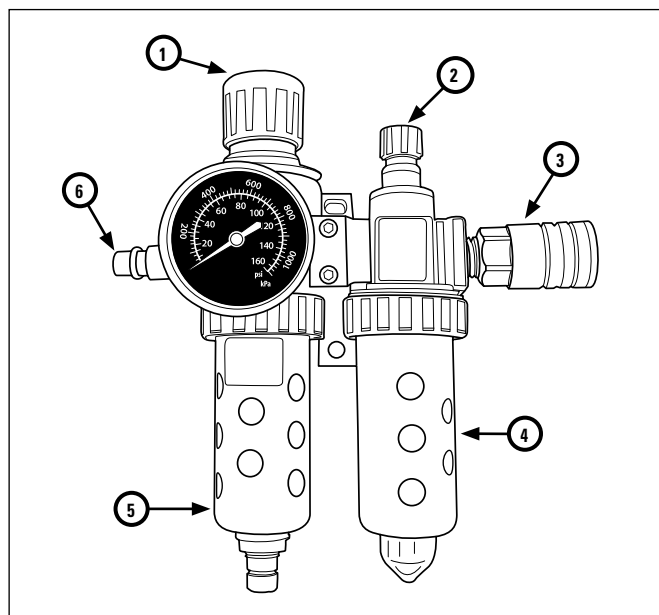
Flexco® XP™ Staple Tool Frame

1. Frame	4. Clamp bar
2. Belt guide plate	5. Bed
3. Clamp bar handle	6. Pneumatic staple applicator



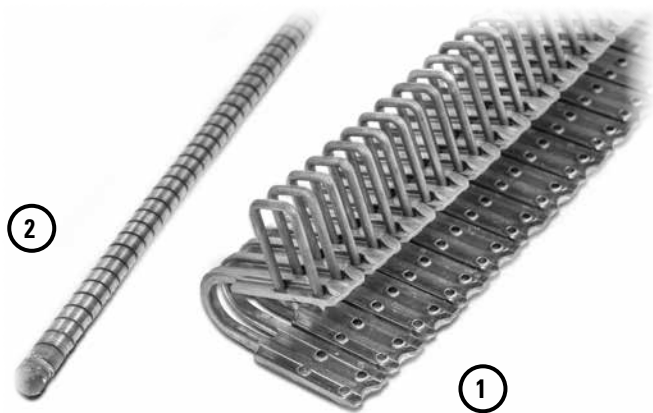
Regulator kit

1. Air pressure cap
2. Oil flow cap
3. Air outlet ISO 6150/B 8 mm profile, 3/8" industrial shape designation, female coupling
4. Oiler
5. Filter
6. Air inlet ISO 6150/B 8 mm profile, 3/8" industrial shape designation, male coupling

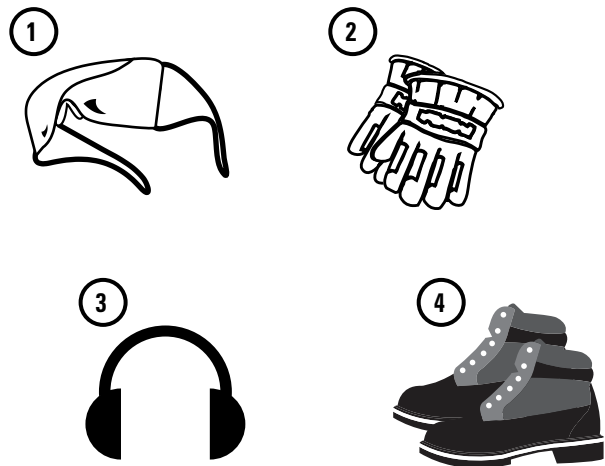


System Components

Flexco® XP™ Staple Fasteners
1. Fastener Strips
2. Hinge Pin



Protective Equipment
1. Safety Glasses
2. Gloves
3. Hearing Protection
4. Safety Shoes



General Safety Rules – Save These Instructions

Signal words

“DANGER” indicates an imminently hazardous situation which, if not avoided, **will** result in death or serious injury. The signal word is limited to the most extreme situations.

“WARNING” indicates a potentially hazardous situation which, if not avoided, **could** result in death or serious injury.

“CAUTION” indicates a potentially hazardous situation which, if not avoided, **may** result in minor or moderate injury. It may also be used to alert against unsafe practices.

International Safety Symbol



This international safety symbol is used to identify and call attention to specific safety matters.

Safety Information

To Avoid Severe Personal Injury or Property Damage, read carefully and understand the following Safety Precautions.

1. WORK AREA SAFETY

DANGER

Never repair conveyors before applying OSHA Lock-Out/Tag-Out protocols, see 29 CFR 1910.147(a)(1)(i).

Do not allow bystander, visitor, or children in work area during tool operation.

WARNING

Store tools outside the reach of children and untrained persons. Tools are dangerous in the hands of unskilled users.

CAUTION

Keep work area clean and well lit. Clutter and dark areas invite accidents.

2. PERSONAL PROTECTIVE EQUIPMENT

WARNING

EYE PROTECTION which conforms to ANSI specifications and provides protection against flying particles both from the FRONT and SIDE should ALWAYS be worn by the operator and others in the work area. Eye protection is required to guard against flying debris, which could cause severe eye injury.

The employer and/or user must ensure that proper eye protection is worn. Eye protection equipment must conform to the requirements of the American National Standards Institute, ANSI Z87.1 and provide both frontal and side protection. NOTE: Non-side shielded spectacles and face shields alone do not provide adequate protection.

CAUTION

HEARING PROTECTION will be required in some environments. For example, the working area may include exposure to noise level which can lead to hearing damage. The employer and user must ensure that any necessary hearing protection is provided and used by the operator and others in the work area.

CAUTION

HEAD PROTECTION – Some environments will require the use of head protection equipment. When required, the employer and user must ensure that head protection conforming to ANSI Z89.1 is issued.

FOOT PROTECTION – Safety footwear should always be worn. Operators must be protected against falling tools and slippery conditions.

HAND PROTECTION – Safety gloves should always be worn against hot surfaces and other sharp objects.

General Safety Rules

3. PERSONAL SAFETY

WARNING

Do not use in explosive environments as this may result in serious personal injury.

Always handle the tool with care: 1.) Never engage in horseplay; 2.) Never pull the advance/actuation handle unless the applicator is loaded onto the bed/frame base; 3.) Keep others a safe distance from the tool while tool is in operation as accidental actuation may occur, possibly causing injury; 4.) Never place a hand or any part of body in the downward path of the head applicator or air cylinder.

Do not operate the equipment if you are:

1.) Taking medication, feeling drowsy, feeling unwell or feeling tired; 2.) Under the influence of drugs or alcohol; 3.) Experiencing pain in hands, feet, lower back, or other parts of your body hurt or are injured. Failure to observe this precaution can result serious injury or even death.

Never alter or remove safety devices.

Always disconnect air supply: 1.) Before making adjustments; 2.) When servicing the tool; 3.) When clearing a jam; 4.) When tool is not in use; 5.) When moving to a different work area, as accidental actuation may occur, possibly causing injury.

When lending someone the equipment, make sure the safety instructions have been thoroughly read and fully understood by the person who is going to use the equipment.

Do not overreach. Keep proper footing and balance at all times to enable better control of the tool in unexpected situations.

When using the machine to perform work-related activities, you may experience discomfort in the hands, arms, shoulders, neck, or other parts of the body: 1) Adopt a comfortable posture while maintaining secure footing and avoid awkward off-balanced postures; 2) Changing posture during extended tasks may help avoid discomfort and fatigue; 3) In case of persistent or recurring symptoms, consult a qualified health professional.

4. PNEUMATIC SAFETY

DANGER

This tool is only designed to be used to install Flexco® XP™ staple fasteners. DO NOT operate this tool when: 1.) Part of the tool or whole tool has been drenched in water or seawater; 2.) The operating pressure exceeds the pressure range prescribed.

Do not operate tool unless it is loaded onto the bed/frame base.

AIR SUPPLY SOURCE: Use only clean regulated compressed air as a power source for this tool. **NEVER USE OXYGEN, COMBUSTIBLE GASES, OR BOTTLED GASES, AS A POWER SOURCE FOR THIS TOOL AS TOOL MAY EXPLODE.**

FITTINGS: A male plug is installed on the tool which is free flowing and which will release air pressure from the tool when disconnected from the supply source.

HOSES: Air hoses should have a minimum of 150 p.s.i. (10.6 kg/cm²) working pressure rating or 150 percent of the maximum pressure that could be produced in the air system. The supply hose should contain a fitting that will provide “quick disconnecting” from the male plug on the tool.

REGULATOR: A pressure regulator with an operating pressure of 0 – 125 p.s.i. (0 – 8.79 kg/cm²) is required to control the operating pressure for safe operation of this tool. Do not connect this tool to air pressure which can potentially exceed 200 p.s.i. (14 kg/cm²) as tool may fracture or burst, possibly causing injury.

General Safety Rules

WARNING

Use the Flexco pneumatic tool only for the purpose for which it was designed.

At the beginning of each shift, conduct a TOOL OPERATION CHECK: 1) Remove all fasteners from tool before performing tool operation check; 2.) Do not use if there is damage to the tool.

Do not store tool in a cold weather environment to prevent frost or ice formation on the tool's operating valves and mechanisms that could cause tool failure.

At the end of operation, secure the tool to prevent unauthorized use. Never assume you will find the equipment in the same condition in which you left it.

Never leave a tool unattended with the hoses attached.

CAUTION

Always carry the tool by a handle.

Do not alter or modify this tool from the original design or function without approval from FLEXCO.

Always be aware that misuse and improper handling of this tool can cause injury to yourself and others.

NOTE: Some commercial air line drying liquids are harmful to "O"-rings and seals – do not use these low temperature air dryers without checking compatibility.

5. OPERATIONAL SAFETY

WARNING

Do not use supply sources which can potentially exceed 200 p.s.i.g. as tool may burst, possibly causing injury.

6. MAINTENANCE SAFETY

DANGER

Always disconnect air supply when servicing the tool or before making adjustments.

CAUTION

Do not operate this tool if it does not contain legible WARNING LABELS.

REPLACEMENT PARTS: FLEXCO replacement parts are recommended. Do not use modified parts or parts which will not give equivalent performance to the original equipment.

Operational Instructions

Set-Up Information

Operating Pressure:

65 to 101 p.s.i./4.5-7.0 bar

Select the operating pressure within this range for best fastener performance. **DO NOT EXCEED THIS RECOMMENDED OPERATING PRESSURE.**

Air Supply-Pressure and Volume:

Air volume is as important as air pressure. The air volume supplied to the tool may be inadequate because of undersize fittings and hoses, or from the effects of dirt and water in the system. Restricted air flow will prevent the tool from receiving an adequate volume of air, even though the pressure reading is high. The results will be slow operation, mis-drives or reduced driving power. Before evaluating tool problems for these symptoms, trace the air supply from the tool to the supply source for restrictive connectors, swivel fittings, low points containing water and anything else that would prevent full volume flow of air to the tool.

Air Consumption:

Tool requires 7 SCFM (where the pressure is at 14.7 psia and the temperature is at 72 degrees F (22.2 C)) or 198 L/m of free air to operate at the rate of 20 fasteners per minute, at 80 p.s.i. (5.6 kg/cm²).

Filter:

Dirt and water in the air supply are major causes of wear in pneumatic tools. A filter will help to get the best performance and minimum wear from the tool. The filter must have adequate flow capacity for the specific installation. The filter has to be kept clean to be effective in providing clean compressed air to the tool. Consult the manufacturer's instructions on proper maintenance of your filter. A dirty and clogged filter will cause a pressure drop which will reduce the tool's performance.

Lubrication:

Frequent, but not excessive, lubrication is required for best performance. Use Air Tool Lubricant, Mobil Velocite #10, or equivalent. Do not use detergent oil or additives as these lubricants will cause accelerated wear to the seals in the tool, resulting in poor tool performance and frequent tool maintenance. Only a few drops of oil at a time is necessary. Too much oil in the tool will cause "seal swell" and the tool may not function properly. **To maintain tool performance, always use air regular/filter and keep the tool lubricated.**

Cold Weather Operation:

For cold weather operation, near and below freezing, the moisture in the air line may freeze and prevent tool operation. We recommend the use of winter formula air tool lubricant or permanent antifreeze (ethylene glycol) as a cold weather lubricant.

CAUTION: Do not store tools in a cold weather environment to prevent frost or ice formation on the tools operating valves and mechanisms that could cause tool failure. NOTE: Some commercial air line drying liquids are harmful to "O"-rings and seals – do not use these low temperature air dryers without checking compatibility.

Hoses:

Air hoses should have a minimum of 150 p.s.i. (10.6 kg/cm²) working pressure rating or 150 percent of the maximum pressure that could be produced in the air system. The supply hose should contain a fitting that will provide "quick disconnecting" from the male plug on the tool.

Supply Source:

Use only clean regulated compressed air as a power source for this tool. **NEVER USE OXYGEN, COMBUSTIBLE GASES, OR BOTTLED GASES, AS A POWER SOURCE FOR THIS TOOL AS TOOL MAY EXPLODE.**

Pneumatic Integrity:

Do not use a tool that leaks air or does not function properly. Notify your nearest FLEXCO representative if your tool continues to experience functional problems.

Operational Instructions *(continued)*

Guidelines

1. When connecting and disconnecting couplings, make sure dirt, dust, and other foreign substances do not enter or attach to coupling and hoses.



2. Do not trip over the hoses.



3. Make sure there are no jobsite obstacles.



4. Be cautious not to injure your back while lifting the tool.

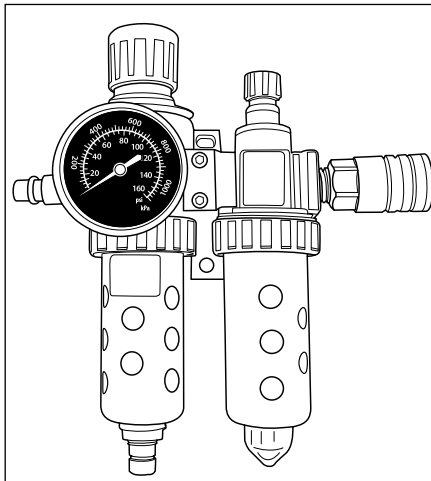
5. Replace with new hoses when they are worn or leaking.

Tool Inspection

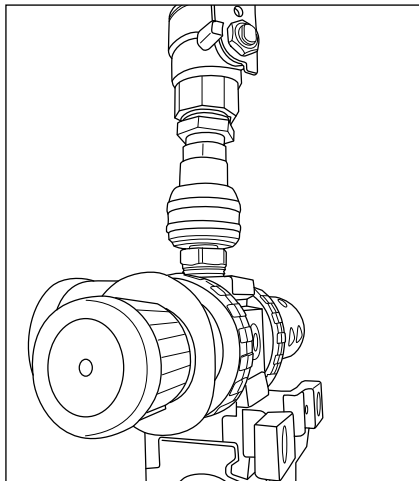
Examine the tool before applying fasteners.

- Clean any dirt build-up from the bed rails.
- Check the pneumatic applicator to make sure the mounting brackets are free from dirt build-up.
- Check for any nicks in the bed that may interfere with the movement of the head. Should any nicks be found, they should be filed off before using the tool.
- Ensure applicator moves freely on bed. If not spray SLP5 GLIDE silicone lubricant on bed rails and mounting brackets for smoother operation.
- Inspect swipe arms, pusher tip and front/rear locator prongs for damage, chips or cracking. Replace damaged parts by authorized distributor.

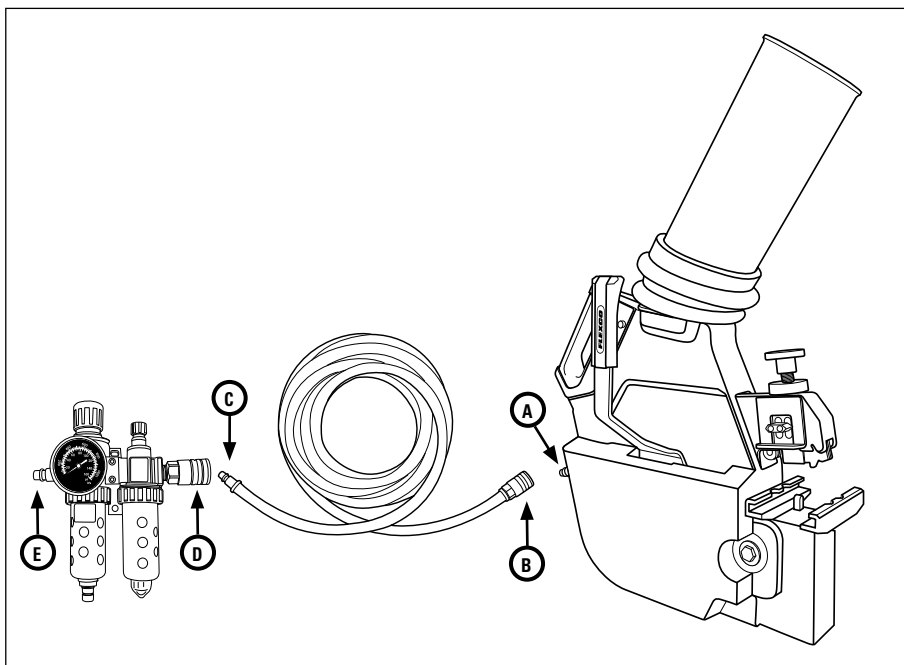
Set-up Procedure



1. Mount Air Control Assembly in upright position. **The air control assembly kit must remain level during tool operation.** Fill oiler with Parker F442 oil or equivalent.

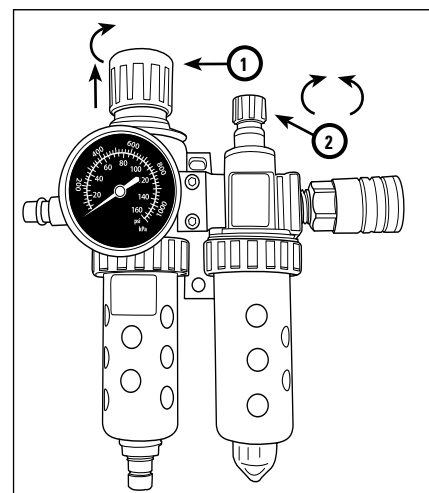


2. Connect your air compressor to the Parker No. H2E3/8" Male Nipple on the regulator kit. Use compressed air directly from an air compressor. **WARNING: Do not use any bottled gasses, including oxygen, to operate this tool. An explosion can occur.**



3. Continue connecting your pneumatic fittings as shown.

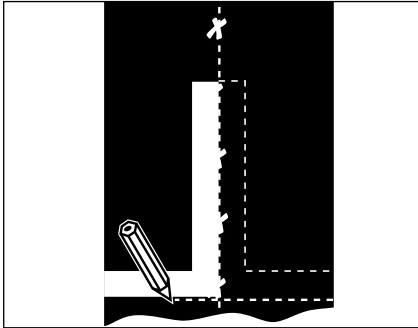
- Connect A to B
- Connect C to D
- Connect E to air supply



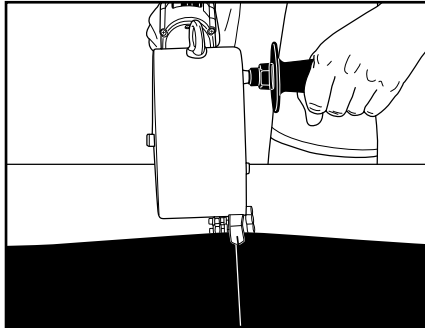
4. To adjust air pressure pull cap “1” up and turn clockwise. After desired air pressure is set, snap cap down into locked position. For optimal results operate the applicator at 85-90 p.s.i. (approximately 6 bar). Do not exceed 101 p.s.i. (7 bar).

To adjust oil flow turn cap “2” clockwise, until tight, then turn cap counterclockwise 1 turn for proper adjustment.

Belt Preparation



1. Square belt using centerline method.



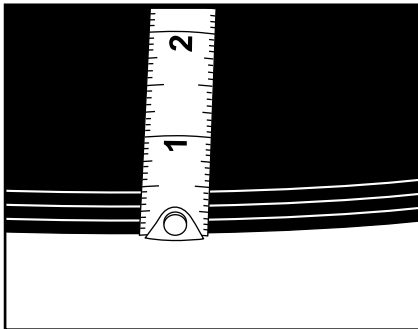
2. Cut belt at least 4" (100 mm) behind old splice using Flexco belt cutting tool.



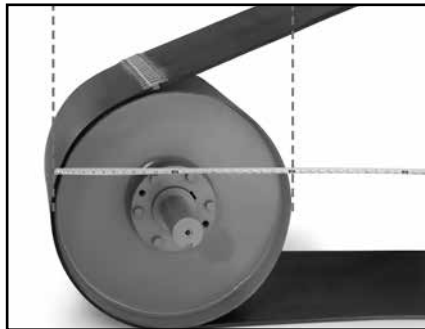
3. Skive belt when covers permit.

Installation Instructions

1. Select the Proper Fastener and Hinge Pin



a. Measure the belt thickness after skive from cut edge using belt gauge or tape measure.



b. Determine the diameter of the smallest pulley in the system which the belt will wrap at least 90° (including the belt take up and storage unit) and the mechanical fastener rating of the belt.

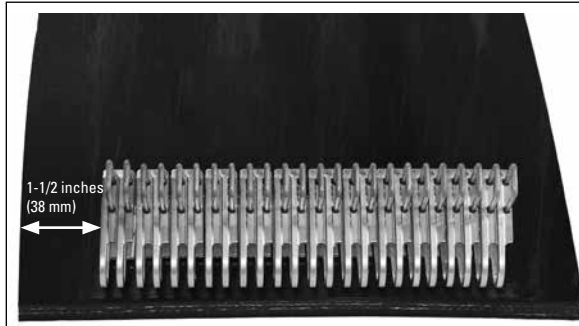
Flexco® XP Staple Belt Fastener Selection Chart

A			B		C		D	
Fastener Size	Belt Strength	Tension Rating	Belt Thickness Range After Skive		Recommended Min. Pulley Diameter		Max. Hinge Pin Diameter	
	kN/m	P.I.W.	mm	in	mm	in	mm	in
XP5	2000	1150	9-12	11/32 - 15/32	350	14	8.1	5/16
XP5-L	2000	1150	11-14	7/16 - 9/16	350	14	8.1	5/16
XP7	3500	2000	13-15	1/2 - 19/32	500	20	10.3	13/32
XP8	3500	2000	15-18	19/32-23/32	500	20	11.0	7/16
XP8-L	3500	2000	17-20	21/32-25/32	500	20	11.0	7/16

c. Refer to the table above to select the proper size fastener.

Installation Instructions *(continued)*

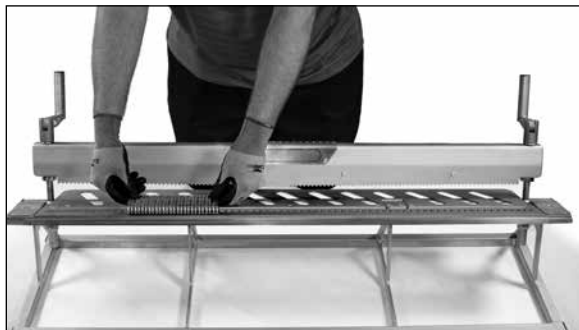
2. Load the Fasteners



a. Determine the exact number of fasteners needed for the belt by laying strips of fasteners across the belt end. Center fasteners so that approximately 1-1/2 inches (38 mm) of belt extends beyond the fasteners on each edge.



b. If a shorter fastener strip is needed, hold strip in one hand and carefully twist the strip with the other hand. Prior to placing in tool bed, trim any welded wire that remains at the end of the shortened strip so wire is flush with end fastener.

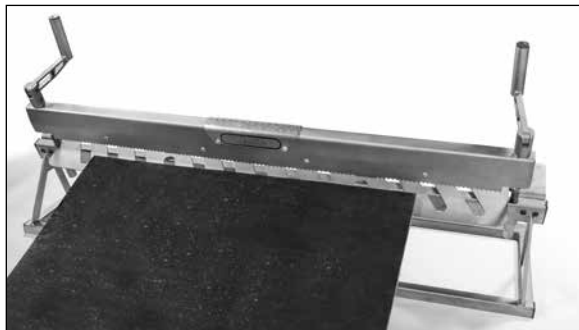


c. Center fastener strips within the bed.

- Insert the fasteners, with the open end of the fasteners toward the clamp bar. The heads (crowns) of the staple will fit into the slots in the bed.
- Use rocking motion to guide staple pairs (two staples per fastener plate) into each individual bed opening.
- Make sure there are no empty slots between fastener strips.

3. Load the Belt

BEST PRACTICE: Run crown side of staples on the carry side of the belt for optimal belt cleaner interface. Place carry side of belt facing down in frame for installation.



a. Place belt on belt guide plate and slide the belt end under the clamp bar and into the fastener.



b. Push the belt end into the fasteners until it is tight against the belt stops which are built into the fasteners. If belt end rises above the belt stop push the belt back so it is properly aligned.

Installation Instructions *(continued)*

3. Load the Belt *(Continued)*



c. Center the belt so that approximately 1-1/2 inches (38 mm) of belt extends beyond the fasteners on each edge.

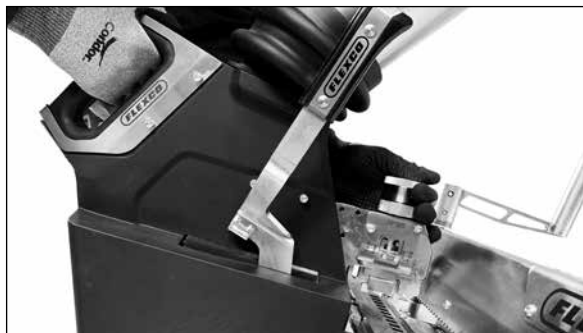


d. Secure the belt in this position by evenly tensioning the clamp bar handle on both ends of the clamp bar until the belt is securely clamped.

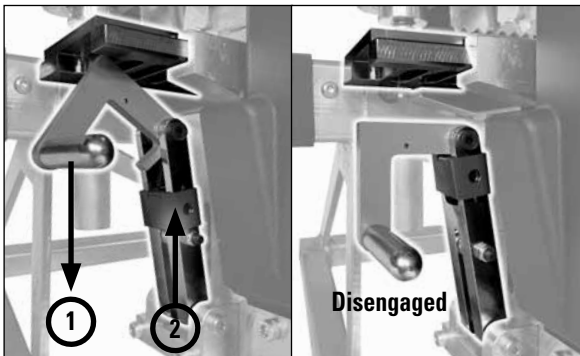
4. Load the Applicator



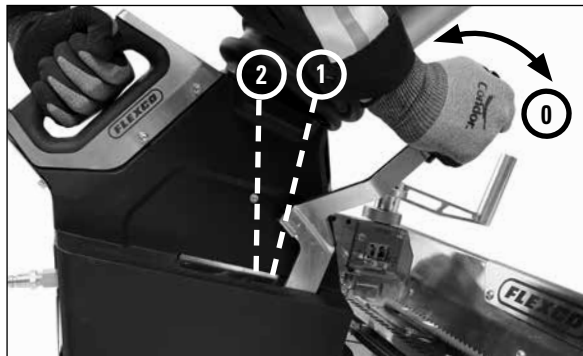
a. Attach the applicator to the bed by sliding the mounting brackets located on the applicator onto the left end of the bed rail. **Ensure the advance/actuation handle is in the forward position "0".**



b. Push the applicator firmly to the right until the tool is solidly on the bed.



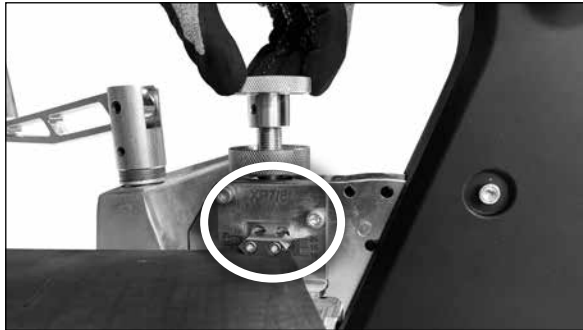
c. The applicator can be moved to the right either by continuing to push it across the bed or by using the handle to rapidly advance the head along the tool bed. The applicator can be moved to the left by disengaging the advance mechanism lever and pushing the head to the left.



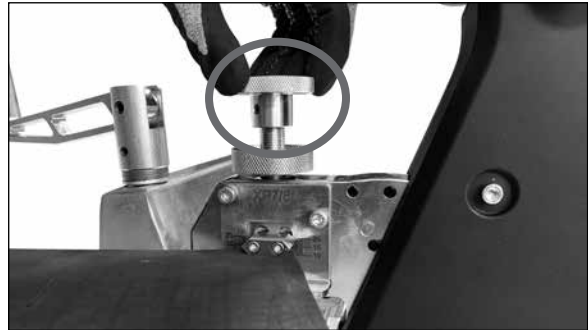
d. To use the rapid advance feature move the advance/actuation handle from start position "0" to position "1" and repeat to quickly advance the tool. Position the applicator over the first two fasteners in the fastener strip.

Installation Instructions *(continued)*

5. Set the Belt Thickness Gauge



a. Insert sample belt end into the belt thickness gauge located on the sides of the head. The side used is determined by the fastener size that will be applied. For an XP7 fastener use the left side belt gauge marked “XP7/XP8”. For an XP5 or XP5-L fastener use the right side belt gauge marked “XP3/XP5”.



b. Adjust the fastener compression knob until the belt just slides in the gauge opening. Turn clockwise to tighten. Turn counter-clockwise to loosen.

NOTE: If the belt doesn't fit into the gauge, the gauge is probably set from a previous use.

- Loosen the locking knob and open the gauge by turning the compression knob counter-clockwise several turns.
- Lock gauge in place by tightening the locking knob and remove belt from gauge. This setting is approximate.



c. Use the stand alone belt thickness gauge as an alternative when a belt sample is not available. Correlate the belt thickness reference number marked on the gauge and adjust fastener compression knob accordingly.

BEST PRACTICE: Use XPLT XP-LOK™ Tensioner and XPLW-120 XP-LOK™ Belt Wire to prevent belt wave and ripple on rubber plied belting.

BEST PRACTICE: Always perform a test sample to verify proper belt thickness setting before completing final installation. A final adjustment may be necessary after the first few fasteners have been installed.

Installation Instructions *(continued)*

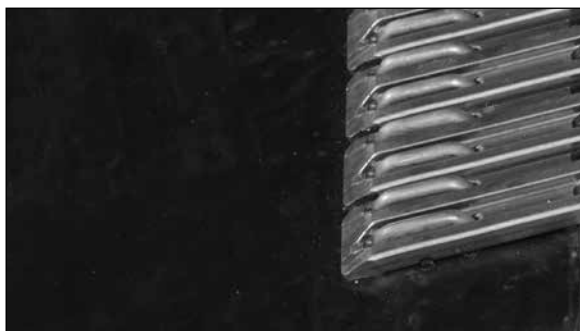
6. Fastener Installation



a. Move the advance/actuation handle from position "0" to end of travel (position "2"). This action will result in the following sequence of events: advance applicator to the next fastener, compress top plate, drive staples, fold and swipe staple legs. Hold handle in position "2" until feedback in handle is felt.

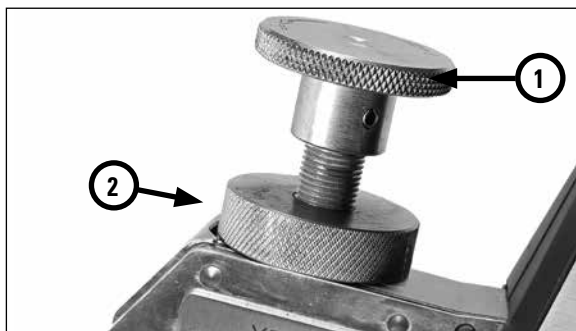


b. Push the advance/actuation handle forward (position "0"). This action completes the drive cycle. Completed cycle time is about two seconds.

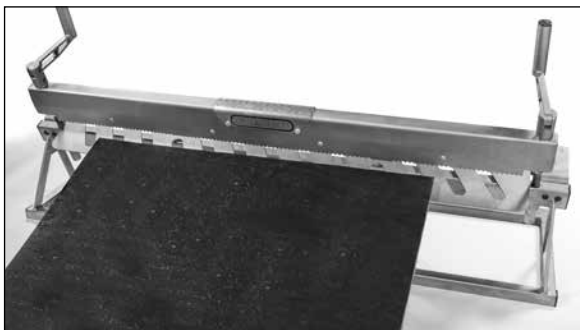


c. Examine the first fasteners to ensure that the staple legs are properly set. The leading edge of the fastener must be set tight on the belt to reduce the fastener's exposure to cleaner blades, skirt rubbers, and return idlers.

NOTE: To prevent belt ripple, do not over compress fasteners on the belt.



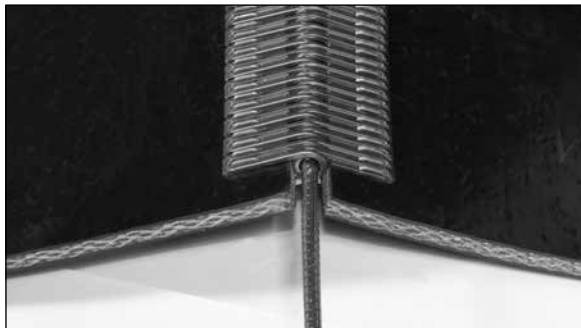
d. Because belt thicknesses may vary across the width of the belt, it is important to examine the fasteners as they are applied. If the top plate of the fasteners is not tight on the belt, adjust the compression by turning the adjustment knob (1) 1/4 turn to the right (clockwise), check and repeat as necessary. If the applied fasteners appear to create a "ripple" in the belt, the fasteners are over compressed. Adjust the compression by turning the adjustment knob (1) 1/4 turn to the left (counter-clockwise), check and repeat as necessary. Hold the compression position by tightening the adjustment knob's locking knob. (2).



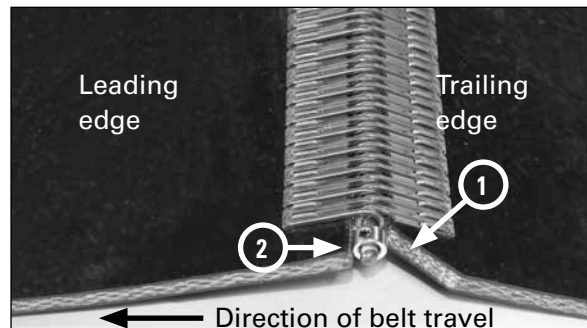
e. Loosen clamp bar, remove belt, and repeat the fastener installation procedure on the opposite belt end.

Installation Instructions *(continued)*

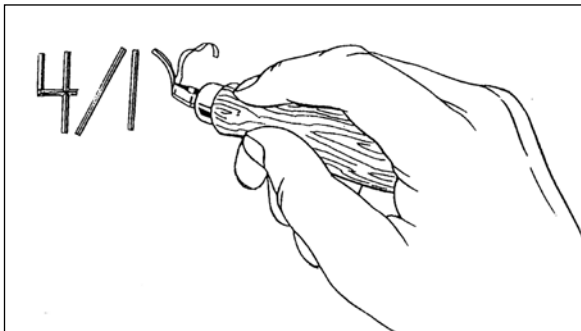
7. Complete the Splice



a. Insert the hinge pin. For ease of hinge pin insertion, overlap both belt ends. Tent both ends and start to join loops from one side. Insert hinge pin and continue to join the rest of loops.



b. Notch the trailing belt edge (1) and attach Flexco Hinge Pin Retaining Collars (2) to maintain proper hinge pin position.



c. Mark the splice date on the belt using the Flexco Belt Identification Tool or other comparable method and record it in your belt maintenance record.

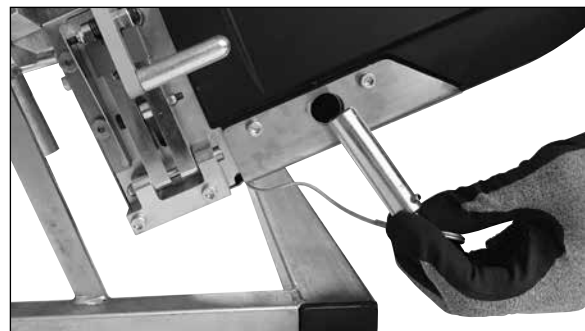
8. Tool Transport

NOTE: When transporting the tool over any distance, it is recommended that the applicator be removed and carried separately. If you need to move the tool a short distance or reposition it, it can be carried. Take care to keep the tool level and use two people to move it as the weight may not be evenly distributed.

Two-step feature (Optional)



a. Insert the stop pin. Move handle as directed in Step 7 to drive the staples through the plates without swiping them.



b. Remove stop pin and store. Repeat movement as directed in Step 6 to complete fastener installation.

Maintenance Instructions *(continued)*

Replacement Parts:

FLEXCO replacement parts are recommended. Do not use modified parts or parts which will not give equivalent performance to the original equipment.

Assembly Procedure For Seals:

When repairing a tool, make sure the internal parts are clean and lubricated. Coat each “O”-ring with “O”-LUBE before assembling. Use a small amount of oil on all moving surfaces and pivots.

Air Supply-Pressure And Volume:

Air volume is as important as air pressure. The air volume supplied to the tool may be inadequate because of undersize fittings and hoses, or from the effects of dirt and water in the system. Restricted air flow will prevent the tool from receiving an adequate volume of air, even though the pressure reading is high. The results will be slow operation, mis-drives or reduced driving power. Before evaluating tool problems for these symptoms, trace the air supply from the tool to the supply source for restrictive connectors, swivel fittings, low points containing water and anything else that would prevent full volume flow of air to the tool.

Tool Air Fitting:

Tool uses a 3/8" industrial shape designation male coupling. The inside diameter should be .275" (7 mm) or larger. The fitting must be capable of discharging tool air pressure when disconnected from the air supply.

Operating Pressure:

65 to 101 p.s.i./4.5-7.0 bar

DO NOT EXCEED THIS RECOMMENDED OPERATING PRESSURE. Do not exceed recommended maximum operating pressure as tool wear will be greatly increased. The air supply must be capable of maintaining the operating pressure at the tool. Pressure drops in the air supply can reduce the tool's driving power.

Filter:

Dirt and water in the air supply are major causes of wear in pneumatic tools. A filter will help to get the best performance and minimum wear from the tool. The filter must have adequate flow capacity for the specific installation. The filter has to be kept clean to be effective in providing clean compressed air to the tool. Consult the manufacturer's instructions on proper maintenance of your filter. A dirty and clogged filter will cause a pressure drop which will reduce the tool's performance.

Lubrication:

Frequent, but not excessive, lubrication is required for best performance. Use Air Tool Lubricant, Mobil Velocite #10, or equivalent. Do not use detergent oil or additives as these lubricants will cause accelerated wear to the seals in the tool, resulting in poor tool performance and frequent tool maintenance. Only a few drops of oil at a time is necessary. Too much oil in the tool will cause “seal swell” and tool not function properly. **To maintain tool performance, always use air regular/filter and keep the tool lubricated.**

Tool Specifications:

All screws and nuts are metric.

Alteration:

Do not alter or modify this tool from the original design or function without approval from FLEXCO.

Disconnect Air Supply:

Always disconnect air supply when servicing the tool or before making adjustments.

Troubleshooting

Problem	Cause	Correction
Pull advance/actuation handle but applicator does not advance	<ol style="list-style-type: none"> 1. Advance mechanism lever was in disengage position 2. Advance/setting handle was not pulled down to position "1" to complete advance cycle 3. Advance/setting handle was not fully pushed forward (position "0") to engage advance mechanism 4. Bed rails are dirty 5. Advance mechanism lever spring was not in position or damaged (Rare) 	<ol style="list-style-type: none"> 1. Engage advance mechanism lever 2. Pull handle down to position "1" 3. Push handle forward all the way to complete cycle 4. Clean surfaces and spray SLP5 GLIDE silicone lubricant on bed rails and mounting brackets 5. Adjust or replace spring
Functioning but weak or low speed	<ol style="list-style-type: none"> 1. Air supply restriction 2. Tool dry, lack of lubrication 	<ol style="list-style-type: none"> 1. Check air supply equipment 2. Use Air Tool Lubricant
Pull advance/actuation handle down but applicator does not actuate	<ol style="list-style-type: none"> 1. Compressed air source unit is not turned ON 2. Hose is not connected 3. Couplings are not connected properly 4. Compressed air source relief valve pressure is set too low 	<ol style="list-style-type: none"> 1. Turn ON compressed air source unit 2. Connect hose 3. Check if couplings have been connected properly 4. Adjust pressure to recommended level
Staple legs are pushed up but staples are only partially bent over	<ol style="list-style-type: none"> 1. Operator did not wait for handle feedback at end of the pull (position "2") before returning handle to start position "0" 	<ol style="list-style-type: none"> 1. Pull advance/actuation handle down to position "2" and wait for handle feedback prior to releasing
Tool stops during return stroke	<ol style="list-style-type: none"> 1. Fastener compression was incorrectly set (over-compress) 	<ol style="list-style-type: none"> 1. Adjust fastener compression by turning the adjustment knob ¼ turn to left (counter-clockwise) and repeat as necessary
Staple legs are pushed up but staples are not completely set	<ol style="list-style-type: none"> 1. Fastener compression was incorrectly set (under-compress) 	<ol style="list-style-type: none"> 1. Adjust fastener compression by turning the adjustment knob ¼ turn to right (clockwise) and repeat as necessary
Belt has too much ripple or wave	<ol style="list-style-type: none"> 1. Fastener compression was incorrectly set (over-compress) 2. Using rubber plied belting 	<ol style="list-style-type: none"> 1. Adjust fastener compression by turning the adjustment knob ¼ turn to left (counter-clockwise) and repeat as necessary 2. Use XPLT XP-LOK™ Tensioner and XPLW-120 XP-LOK™ Belt Wire to prevent belt wave and ripple
Staple legs are pushed up but staples are not bent over	<ol style="list-style-type: none"> 1. Damaged swipe arms 2. Damaged swipe linkages 	<ol style="list-style-type: none"> 1. Replace swipe arms by authorized distributor 2. Replace swipe linkages by authorized distributor
Cannot load applicator onto frame	<ol style="list-style-type: none"> 1. Pilot punch is in up position 2. Mounting brackets are not aligned properly 	<ol style="list-style-type: none"> 1. Push advance/actuation handle to position "0" prior to loading onto frame 2. Inspect and verify mounting bracket are properly installed
Tool leaks air	<ol style="list-style-type: none"> 1. O-ring or Gasket is cut or cracked 2. Hose is cut or cracked 3. Loose internal hose connections 	<ol style="list-style-type: none"> 1. Replace O-ring 2. Replace hose 3. Secure internal hose connections