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<b>OPERATING INSTRUCTIONS</b>	Translation of original manual
<b>BRUKSANVISNING</b>	Original bruksanvisning
<b>BETRIEBSANLEITUNG</b>	Übersetzung der Originalbetriebsanleitung
<b>MODE D'EMPLOI</b>	Traduction du mode d'emploi original

## F53

From series no 1500504

Från serienummer 1500504

Ab Serie-Nr. 1500504

A partir du no de série 1500504

Manual industrial stapler

Manuell planhäftare

Manuelle heftmaschine

Agrafeuse manuelle



Before using the industrial stapler, read the operating instructions carefully.

Läs igenom bruksanvisningen noga innan du använder maskinen.

Vor dem Gebrauch der flacheffter Betriebsanleitung aufmerksam lesen.

Avant l'utilisation de l'appareil, consultez soigneusement le mode d'emploi.



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## 1

## TECHNICAL DATA

Weight	42 kg (92,6 lbs)
Dimensions	Length 920 mm (36.2") Width 750 mm (29.5") Height 1350 mm (53.1")
Magazine capacity	312 staples
Staple leg length	09–12 mm (3/8"–1/2")
Throat depth	400 mm (15.7")
Free anvil height	860 mm (33,9")

## FASTENERS

Staple JK53-09 (3/8")	Art.No 400130
Staple JK53-12 (1/2")	Art.No 400132

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## DECLARATION OF CONFORMITY



We take sole responsibility for declaring that the industrial stapler F53, to which this declaration refers, is in full compliance with the current requirements of the guidelines laid down by the council on 17th May 2006 (2006/42/EG) "Machine Guidelines".

Complies with norms: ISO 12100:2010

SE-544 50 HJO, 30.01.2015

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# 2

## GENERAL INFORMATION



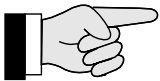
### CAUTION!

Used where there is danger to life and health.



### WARNING!

Used for danger which can cause material damage.



### NOTE!

Used for general information and information which if not followed can cause faults in the operating sequence.

These operating instructions are intended to simplify familiarisation with the industrial stapler and the possibilities of application for the intended purpose. The operating instructions contain important information concerning the safe, proper and efficient use of the Industrial stapler. Observation of the information will help to avoid danger, reduce repairs and stoppages and increase the reliability and service life of the Industrial stapler.

The operating instructions must always be available at the place of operation of the Industrial stapler. They must be read and observed by all persons concerned with work on the industrial stapler. This work specifically includes operation, refilling of operating material, fault elimination and maintenance.

In addition to the operating instructions and the regulations for accident prevention effective in the country of use and place of application, the recognised technical regulations for safety and proper working must also be observed.

### 2.1 INFORMATION ON ENVIRONMENTAL PROTECTION

This industrial stapler is manufactured without any physical or chemical substances which could be dangerous to health. For disposal of all the parts, the governmental instructions must be observed.

# 3

## SAFETY INSTRUCTIONS



### Inform yourself!

Read the operating instructions carefully.



### Warning: Danger of crushing!

Do not put your fingers underneath the protector. Do not remove protection covers.



**Original JOSEF KIHMBERG staples must be used exclusively.**



**Original JOSEF KIHMBERG spare parts must be used exclusively!**

Not using original spare parts will void the warranty and the liability.

### Use for the intended purpose

The Industrial stapler is intended for stapling corrugated cardboard.

This Industrial stapler was designed and manufactured for safe handling during the stapling operation.

### Possible misuse

The Industrial stapler is designed to be used only with corrugated cardboard.

### Servicing

The following maintenance work must be carried out at regular intervals, varying with working conditions and workload:

- clean the Industrial stapler regularly.
- check the condition of the Industrial stapler at regular intervals for defects or worn parts. Never use a Industrial stapler that has defective or worn parts (for service work refer also to chapters 7.1 and 7.2).

## 4

## DESCRIPTION

## 4.1 DESIGN



Fig. 1

- 1 Stapling head
- 2 Anvil
- 3 Pedal
- 4 Pusher

## 4.2 FUNCTION



Fig. 2

1. The stapling head (Fig. 2/1) is activated by the pedal (Fig. 2/2).
2. When you press the pedal the stapling head (Fig.2/2) presses against the manually positioned carton.
3. The stapling head automatically pushes a staple through the carton and the staple clinches against the anvil.
4. When you release the pedal the stapling head is returned and the Industrial stapler is ready for next stapling.



**Warning:** before stapling, ensure that no part of your body is underneath the stapling head.

# 5

## INITIAL OPERATION

### 5.1 INSTALLATION

The Industrial stapler is delivered with the rear foot disassembled. Assemble as following:

1. Remove the Industrial stapler and the rear foot from the carton.
2. Assemble the rear foot (Fig. 3/1) and support (3/2) according to Fig. 3. Tighten the screws.
3. Place the Industrial stapler on level, firm and cleanworking ground.

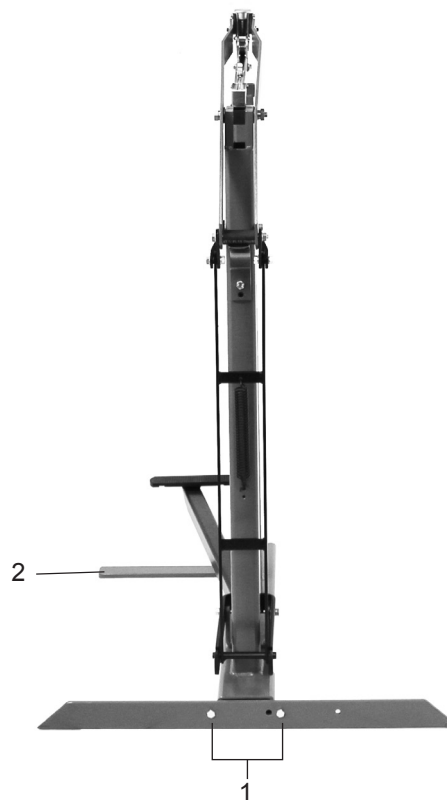


Fig. 3

## 6

## OPERATING INSTUCTIONS

## 6.1 LOADING THE INDUSTRIAL STAPLER

- Always use Josef Kihlberg original staples JK53-09 or JK53-12. The correct type of staple is marked on the left side of the magazine.
- Pull the pusher back and lift up the pusher and the breech.



Fig. 4



Fig. 5

- Insert staple strips from the rear.
- Do not overload the magazine. The pusher can be damaged.



Fig. 6

- Release the pusher.



Do not release the pusher directly from the rear when the magazine is empty, carefully guide it forward.

## 6.2 OPERATING THE INDUSTRIAL STAPLER

- Load the stapling head with staples, (refer to chapter 6.1). Ensure to use the right length of the staple (refer to chapter 6.3).
- Place the carton on the anvil holder.



**Warning:** before stapling, ensure that no part of your body is underneath the stapling head



Fig. 7

- Press the pedal.
- The stapling head compressed the carton and automatically clinches the staple against the anvil.



Fig. 8



Fig. 9

- When you release the pedal the stapling head will return.
- Move the carton to the next staple position and press the pedal again. Repeat until the correct amount of staples have been used.

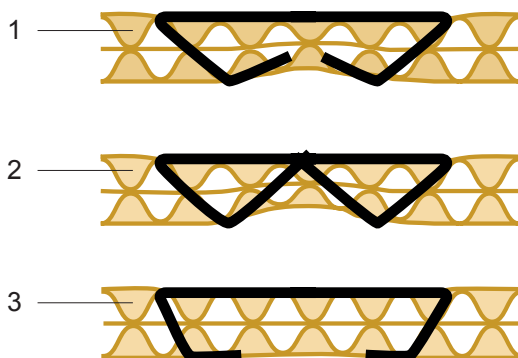


Fig. 10

### 6.3 CONTROL THE CLINCH

- 1 Good clinch.
- 2 Leg length of the staple too long.
- 3 Leg length of staple too short.



**Always use Josef Kihlberg original staples: JK53-09 or JK53-12.**

# 7

## PREVENTIVE AND CORRECTIVE MAINTENANCE

### 7.1 LUBRICATION

The linkage bearings are greased at delivery. At regular intervals (monthly) lubricate them with oil. Also lubricate the moving parts in the stapling head with a few drops of oil.

### 7.2 CLEANING THE INDUSTRIAL STAPLER

This Industrial stapler does not require special servicing. It only needs regular cleaning with a non-aggressive (non-corrosive) cleaning agent. Do not remove any parts for cleaning purposes!

- Check if all screws and nuts are securely tightened.

### 7.3 REMOVING JAMMED STAPLES

- Loosen the screw (Fig. 11/1). Squeeze the stapler head and remove the staple trip block(11/3).
- Driving down the lower part of stapling head until the defective staple exposed.
- Remove the defective staple.
- Replace the driver (16/5) if it is worn.
- Assemble in reverse order.

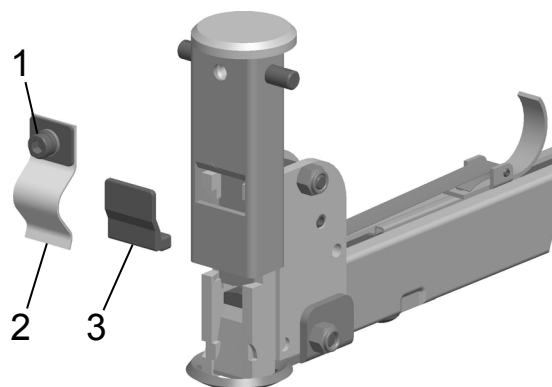


Fig. 11

#### 7.4 ADJUSTMENT OF STAPLING HEAD BEARING

Upon delivery, the stapling head bearing is tight but easily movable. After being in use for a while, the bearing will have become worn and must be readjusted as follows:

- Loosen nut (Fig. 12/1) and screw (Fig. 12/2).
- Tighten screw (Fig. 12/2) to obtain just enough play.
- Lock with nut (Fig. 12/1).

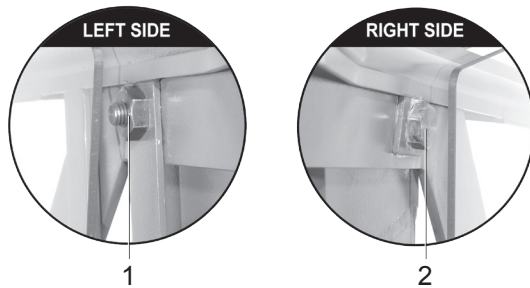


Fig. 12

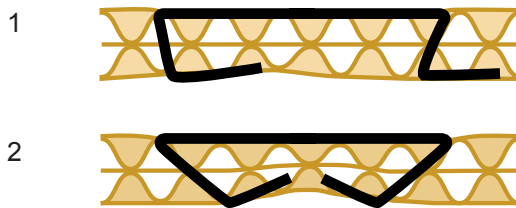


Fig. 13

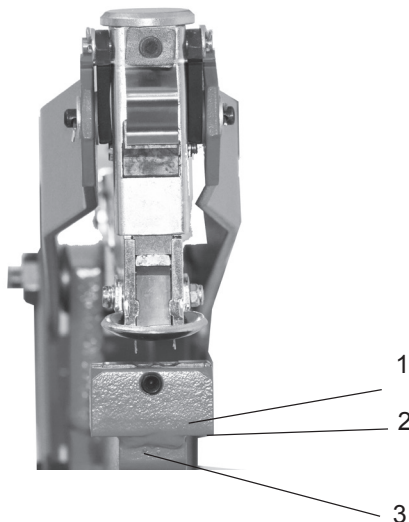


Fig. 14

#### 7.5 ADJUST STAPLE CLINCH

Each Industrial stapler is tested carefully before delivery. Following rough treatment during transport a screw may become loosened and the anvil may therefore have to be adjusted. Incorrect stapling may occur (Fig. 13/1).

- Press down a staple (Fig. 14/1) by hand until the staple legs are visible or insert a single staple into the canal.
- Move the staple head down towards the anvil (Fig. 14/2) and check that the staple legs hit the anvil symmetrically.
- If necessary, loosen the screw (Fig. 14/3) and centre the anvil to the staple. Remember to tighten the screw after adjustment.
- Make a test stapling in a piece of cardboard. If the anvil is correctly adjusted, the clinch should be as shown in (Fig. 13/2).

## 7.6 REPLACE STAPLING HEAD

1. Loosen the links (15/1) and screws (15/2).
2. In order to loosen the rear screw (15/2) the stapling head must be lifted 90°.
3. Mount a new head and adjust as per (7/4).
4. Tighten the screws (15/2) and reassemble the links.
5. Adjust the stapling head to the anvil as described in chapter 7.5.



Fig. 15

## 7.7 REPLACE DRIVER BLADE / RETURN SPRINGS

1. Remove the stapling head according to chapter 7.6.
2. Remove any staples from the staple track and pusher to the front position.
3. Loosen the screw (Fig. 16/1). Squeeze the stapler head and remove the staple trip block (16/3).
4. Driving down the lower part of stapling head until the driver blade (16/5) are uncovered.
5. Replace the driver and the return spring (16/6). We recommend change driver blade and return spring at the same time.
6. Assemble in reverse order. Please note that the bevel at the driver blade must be turned to the rear.
7. Assemble the stapling head to the machine as described in chapter 7.6.
8. Adjust the stapling head as described in chapter 7.5.

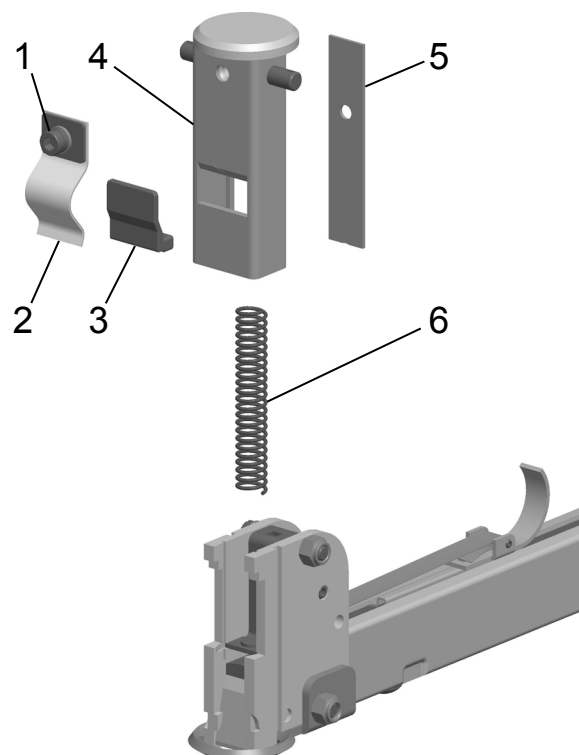


Fig. 16

## 7.8 REPLACE FEED SPRING OR PUSHER

1. Remove the stapling head according to chapter 7.6.
2. Remove the roll pin (Fig. 17/1) with a punch with size 4,9 mm.
3. Remove the circlips (18/1) and disassemble the breech complete (18/2).
4. Remove the pusher (18/4), feed spring (18/3) and rollers.
5. Replace defective feeders or spring.
6. Assemble in reverse order.
7. Assemble the stapling head to the machine as described in chapter 7.6.
8. Adjust the stapling head as described in chapter 7.5.

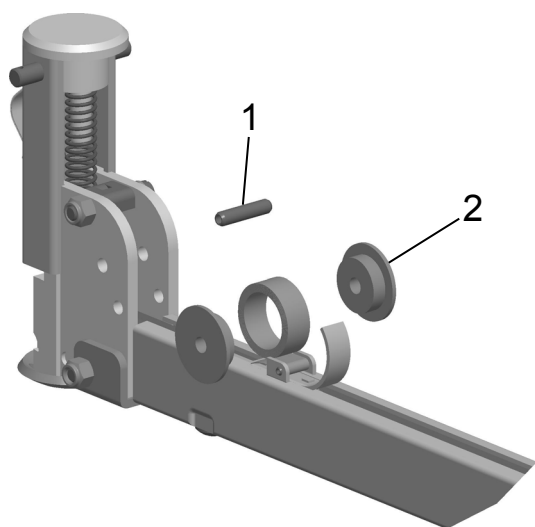


Fig. 17

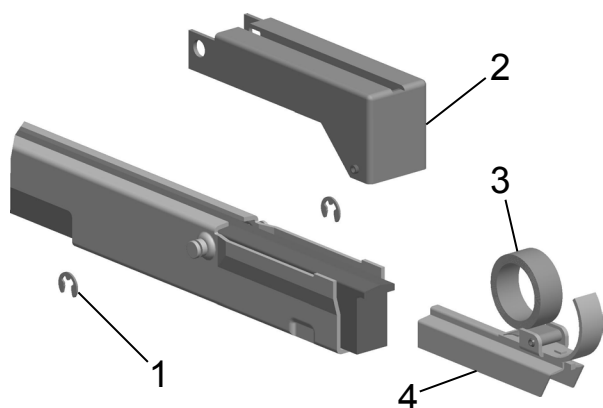


Fig. 18

# 8

## TROUBLE SHOOTING

FAULT	ELIMINATION
<b>Staples are not fed properly</b>	<ul style="list-style-type: none"> <li>– Check if the right type of staples is used. <b>Always use Josef Kihlberg original staples.</b></li> <li>– Check if the feeder spring is not defective. If necessary replace.</li> <li>– Check if the staple pusher is not defective. If necessary replace.</li> <li>– Clean the staple track.</li> <li>– Check return spring in the stapling head. If necessary replace.</li> </ul>
<b>Staples are deformed when inserted</b>	<ul style="list-style-type: none"> <li>– Check if stapling head bearing has no play (refer to chapter 7.4).</li> <li>– Check if anvil is properly centered. (refer to chapter 7.5). Check if driver is not damaged. If necessary replace.</li> <li>– Check if the staple channel is clean.</li> </ul>
<b>Removing a staple which has got stuck</b>	<ul style="list-style-type: none"> <li>– Refer to chapter 7.3.</li> </ul>