

- 1) Cap
- 2) Body
- 3) Collar
- 4) Adjustment Plate
- 5) Adjusting Rod
- 6) Magazine Seat
- 7) Cover
- 8) Trigger

Model	Size of tool (mm)	Weight (kg)	Staples 32 mm crown size	
☐ MERO 18 P			for single and light double corrugated cardboard	for double corrugated cardboard
	233 x 230 x 115	2,37	R 1/58 = 15 mm	R 1/34 = 18 mm
			Leg length: 15 mm, 18 mm, Capacity: 1000 staples	
☐ MERO 22 P			for double corrugated cardboard	for double and light triple corrugated cardboard
	233 x 230 x 115	2,37	R 1/34 = 18 mm	R 1/78 = 22 mm
			Leg length: 18 mm, 22 mm Capacity: 1000 staples	

## 1 Usage

Pneumatic stapling tool for fastening the flaps of filled cartons of single, double or light triple corrugated cardboard boxes.

## 2 Important note

It is the customer's responsibility to have all operators and service personnel read and understand this manual. This stapling tool may only be used by specially advised persons (s. Annex).

Prior to first use, please lubricate all movable parts, then insert staples (s. Chapter 3.3). The air supply should be connected with a quick release coupling. It is operated by a motive agent (compressed air). This stapling device is made solely for normal operation in industrial spheres or similar areas (use as directed). The tool should be fitted with a maintenance unit with pressure regulator, air cleaner and oil spray units to ensure smooth trouble free operating and long life.

### 2.1 Environmental conditions

The tool should be used with indoor conditions (room temperature, etc.). Usage within explosive atmosphere is only permitted with the manufacturer's prior approval.

### 2.2 Emission

The noise level is max. 93 dB(A) (L WA, Is). Heterogeneous gases will not be emitted by the stapling device.

### 2.3 Technical Data

Connection:	1/4''
Operation pressure:	5 - 7 bars; max. 8 bars
Air consumption:	1,1 NL/stapling

### 2.4 Safety instructions

**CAUTION: Keep your hands away from base of the machine at all times! Danger of injury!**

- Never exceed the recommended maximum pressure for the stapling tool.
- Do not attempt to use a defective stapling tool.
- Never load the stapling tool until you are ready to use it.
- Never attempt to fasten into very hard or brittle material such as concrete, steel or tile etc..
- Use only clean, dry regulated COMPRESSED AIR. Never use oxygen, carbon dioxide or other bottled gases.
- Always disconnect the tool from the air supply and empty magazine before: work breaks - changing parts - servicing stapling tool.



## 3 Operating Instructions

### 3.1 Functional description

The stapling tool should be fitted with maintenance unit. The maintenance unit should be adjusted to one drop lubrication, e.g. Unocal RX 22, per 40-50 machine cycles.

The stapler **MERO 18 P** can be used with the following coiled staples: R 1/58, R 1/34.

The stapler **MERO 22 P** can be used with the following coiled staples: R 1/34, R 1/78.

**3.2 Handling**

Insert staples into the magazine (7) (s. Chap. 3.3). Adjust the stapling tool as required (s. Chap. 3.4 - 3.6). Place the stapler **MERO 18 P** or **MERO 22 P** on top of the carton to be sealed in a way that the flap joint is directly in the centre of the stapling tool (s. arrow in the front of stapler). Then activate trigger (8) to release stapling. The anvils will extend, clinch the staples and return automatically into the tool. Release trigger (8). Then move the tool to the next stapling position.

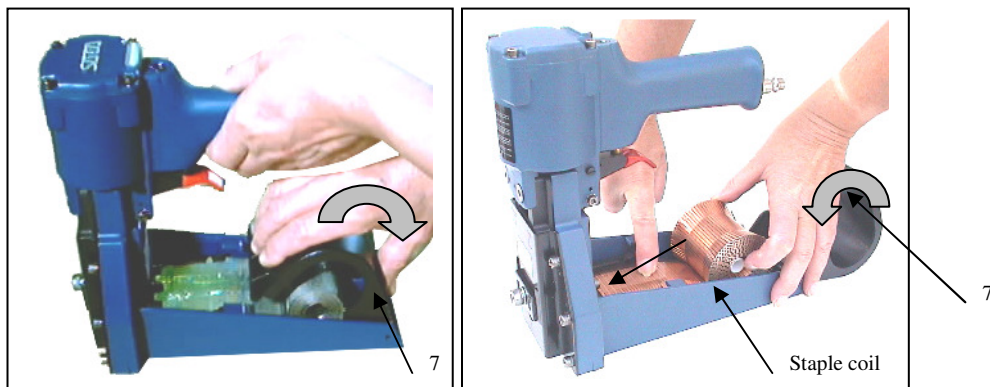
For an optimal fastening result apply staples approx. 1cm to the rim of the carton.

**Caution:** The stapler should only be moved with the anvils completely returned into the tool to avoid damage to the retractable anvils!

**3.3 To load staples**

Before inserting staples disconnect air supply!

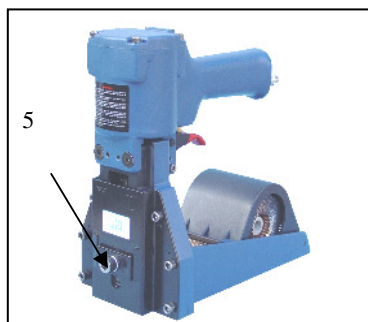
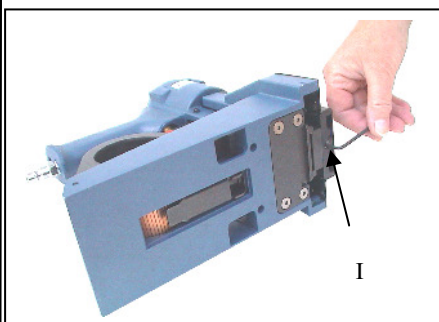
The cover (7) has to be squeezed slightly and folded backward. Insert the coil as shown into the magazine seat and push the staples into the stapling tool until stop. Then fold the cover (7) forward until the cover is locked.



**3.4 Adjusting leg length of staples**

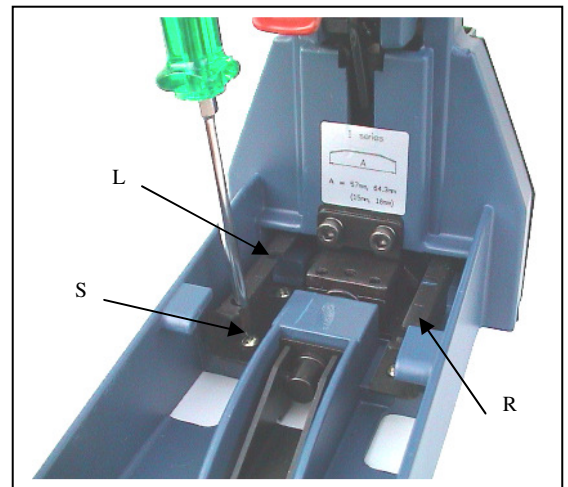
Before adjusting disconnect air supply!

Loosen screw with hexagonal recessed hole (I) with 3 mm hexagon spanner, turn the adjusting rod (5) 180° with a screw driver to the required position. For long leg length turn adjusting rod (5), so that L is in upright position, for short leg length turn adjusting rod (5), so that S is in upright position. Fasten the screw again with hexagonal recessed hole (I).



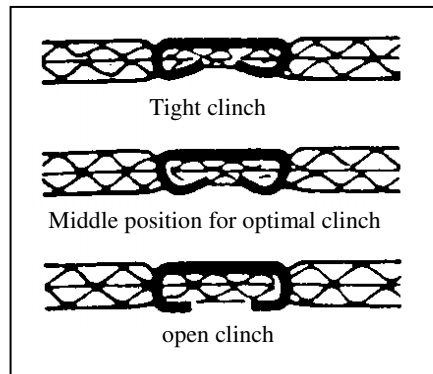
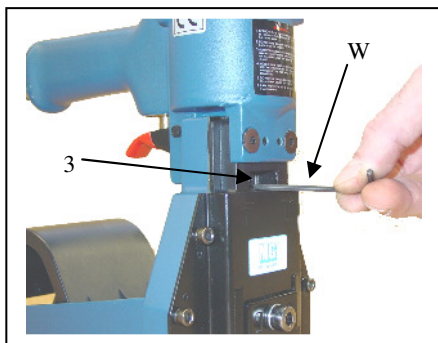
<b>MERO 18 P</b>	15 mm	18 mm
Leg length	R 1/58	R 1/34
<b>MERO 22 P</b>	18 mm	22 mm
Leg length	R 1/34	R 1/78
adjusting rod - position	S — T	L — S

Loosen screws (S) in magazine seat (6) and move right (R) and left (L) stapling plate outward for long leg length (18) and inward for short leg length (15). Fasten screws (S) again.



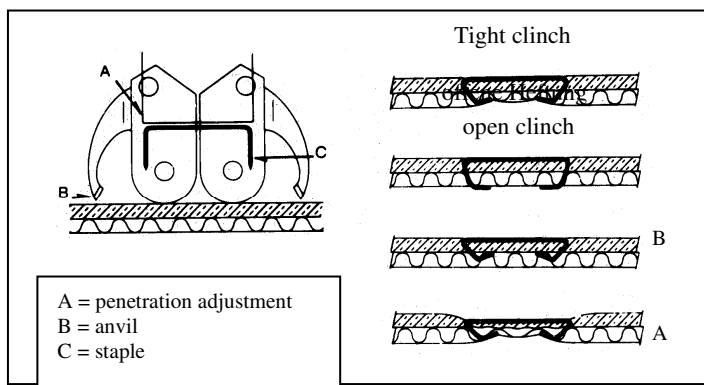
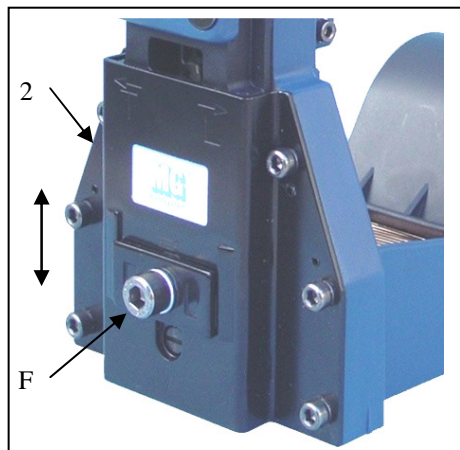
### 3.5 Staple clinch control (closed or open clinch)

Should adjustment of the staple clinch be necessary, it should be carried out as follows: turn collar (3) with a matching tool (W), e.g. 2,5 mm rod, turn the collar (3) counter clockwise for a looser clinch, turn the collar (3) clockwise for a tight clinch. For thick carton quality a looser clinch may be recommendable as the staple can penetrate deeper into the carton.



### 3.6 Adjustment of penetration

For adjusting the penetration of the anvils loosen front screw (F) by means of a 6 mm hexagon spanner (I). Move body up or down into the required position. Fasten front screw (F) again. If the body (2) is in the upper position, the stapling penetration (A) is maximal. If the body (2) is in the lower position, penetration (B) is minimal.



### 3.7 Malfunction check list

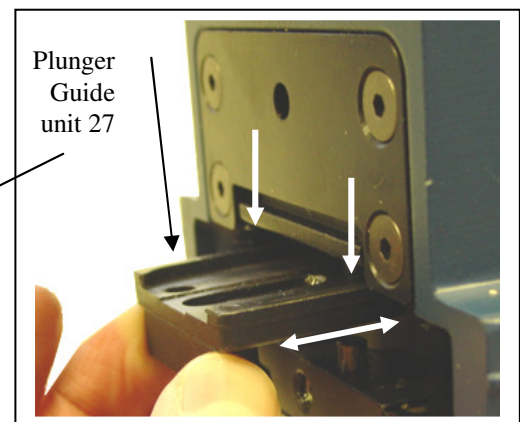
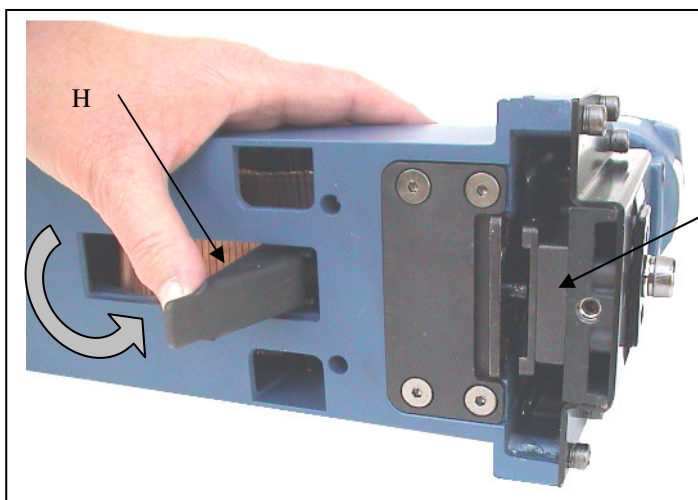
For regulations, disassembly or repairs, always disconnect tool from air installation.

Malfunction	Cause	How to clear
Air leakage of trigger/Cylinder/exhaust port	O-ring/s is/are defect	Remove O-rings Send stapler to manufacturer
Slow and short travel cycling	Trigger defect or loose	Fasten screws, exchange trigger
Jammed staples	Trigger defect or loose	Fasten screws, exchange trigger Send stapler to manufacturer
	Screws at anvils loose	Fasten screws
	Wrong staple size adjusted	Adjust correct staple size
	Insufficient lubrication	Lubricate moving parts
Uneven clinch	Wrong staple size adjusted	Adjust stapling accord. to chapter 3.4 – 3.6.
Unclinched staple	Anvils defective or loose	Fasten screws at anvils or exchange anvils. Send stapler to manufacturer.
	Trigger defective or loose	Fasten screws at trigger or exchange trigger. Send stapler to manufacturer.

### 3.8 De-jamming

Should a staple jam inside the tool, do not trigger any more. This can damage the anvils. Disconnect air supply. Turn lever (H) as shown. Remove the jammed staples with an according tool, e.g. a spanner.

In case of severe jamming the driver guidance unit 27 can also be removed to gain more space for clearing the jamming (may be removed quite easily as it is only fixed on 2 bolts). Then turn lever (H) in the original position. Connect air supply. The machine is now ready for stapling again.



### 3.9 Unauthorized application and operation

Use stapler only for the defined materials and operations. Use only original staples.

If the stapling tool is not used as directed, the manufacturer is not liable for any damage

resulting from this undue use. Any risk of damage is borne solely by the user.

Use as directed also means observing the operating, servicing and maintenance conditions laid down by the manufacturer of the tool.

The stapler may only be used, maintained and repaired by persons who are familiar with it and have been advised of the dangers.

The relevant accident prevention regulations as well as other generally recognized industrial safety and medical regulations must be observed.

Unauthorized modifications to this stapler or the use of spare parts or staples which are not original parts from the manufacturer exclude any liability of the manufacturer for any resultant damage.

### **3.10 General Instructions**

When not in use disconnect air supply and remove all staples.

<p><b>Important - General Instructions</b></p> <p>It is the customer's responsibility to have all operators and service personnel read and understand this manual. MG<sup>®</sup> tools are ruggedly built for long, dependable operation. Details about safety as well as all necessary information for the tool's proper care and general maintenance are contained in this book.</p> <p><b>Safety rules</b></p> <p>NEVER exceed the recommended maximum pressure for the tool (normally 6 bars). DO NOT attempt to use a defective stapler.</p>	<ul style="list-style-type: none"><li>• NEVER load the stapler until you are ready to use it</li><li>• DO NOT reload when you release a stapling operation</li><li>• Only operate the tool when in contact with the carton surface.</li><li>• At all times keep hands clear of base of machine whilst activating trigger.</li><li>• Do not attempt to staple on to hard surface.</li><li>• NEVER USE oxygen, combustible gases or high pressure compressed gas tanks as air supply for the tool</li><li>• Always disconnect air supply and empty magazine before: work breaks, changing parts, servicing tools or clearing a jammed staple, storing tool at the end of the day</li><li>• ALWAYS utilise couplers on the compressor side of the air supply system (couplers when disconnected automatically shut off the flow of air)</li></ul>
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## **4 Maintenance and Personal Safety Instructions (training, education)**

Operation and usage of the stapler is only allowed to specially advised and trained persons.

For maintenance: Always disconnect the tool from the air supply.

For repair use only original spare parts from the manufacturer (s. spare parts list).

The following actions/inspections have to be regularly accomplished by specially advised and trained persons:

- Clean stapler regularly
- Oil all movable parts weekly (no oil containing graphite!).
- Check the pneumatic operating unit. Refill oil and remove water if necessary.
- The pneumatic operating unit should be adjusted to one oil drop per 40-50 machine cycles.

Remark: Advised and trained persons are those who have the education and the experience to use stapling tools. They have also knowledge of governmental safety and accident prevention instructions and technical guidelines as DIN, etc. They can also judge function and operating reliability of staplers.

## **5 Shut down instructions**

If the stapler will not be used disconnect air supply and remove all staples.

## 6. Annex: Spare Part List

### *Pneumatic Carton Top Closing Stapler MERO 18 P and MERO 22 P*

MERO 18 P Order No.	MERO 22 P Order No.	Code Nr	Beschreibung	Description	Stck pcs.
675 / 001	676 / 001	A02800101	Deckel	Cap	1
675 / 002	676 / 002	A02800201	Kolben	Piston	1
675 / 003	676 / 003	A02800301	Kolbenstange	Piston rod	1
675 / 004	676 / 004	A00100401	Zwischenstück	Block	1
675 / 005	676 / 005	A00100501	Feder	Spring	1
675 / 006	676 / 006	A00100601	Manschette	Collar	1
675 / 007	676 / 007	A02800401 P	Zylindergehäuse	Cylinder body	1
675 / 008	676 / 008	A00100803	Nippel	Air plug EU	1
675 / 009	676 / 009	A00100902	Zwischenstück	Block	1
675 / 010	676 / 010	A00101001	Feder	Spring	1
675 / 011	676 / 011	A00101101	Auslösehebel	Trigger	1
675 / 012	676 / 012	A00101201	Feder	spring	1
675 / 013	676 / 013	A00101301	Verbindungsbolzen	Rod	1
675 / 014	676 / 014	A00101402	Kontrollhebel	Trigger's control	1
675 / 015	676 / 015	A00101501	Feder	Spring	1
675 / 016	676 / 016	A00101601	Ventil	Valve	1
675 / 017	676 / 017	A00101702	Ventilrohr	Tube	1
675 / 018	676 / 018	A00101801	Einstellbolzen	Adjusting rod	1
675 / 019	676 / 019	A00101901	Einstellplättchen	Adjusting plate	1
675 / 020	676 / 020	A00102001	Vorderplatte	Front plate	1
675 / 021	676 / 021	A01900501/A01200502	Greifer rechts	Right anvil	1
675 / 022	676 / 022	A01900601/A01200602	Greifer links	Left anvil	1
675 / 023	676 / 023	A00102301	Greiferhalter	Anvil seat	2
675 / 024	676 / 024	A00102401	Greifergelenk	Anvil joint	2
675 / 025	676 / 025	A00102501	Treiberblock	Plunger block	1
675 / 026	676 / 026	A01201701	Treiber	Plunger	1
675 / 027	676 / 027	A02300101	Treiberführung	Plunger guide unit	1
675 / 028	676 / 028	A02300301	Abbiegeplatte	Former plate	1
675 / 029	676 / 029	A02300401	Formblock	Former block	1
675 / 030	676 / 030	A03600202	Vorschub	Feeder	1
675 / 031	676 / 031	A02201101	Feder	Spring	2
675 / 032	676 / 032	A02200501	Vorschubblock	Feeder block	1
675 / 033	676 / 033	A02201201	Feder	Spring	1
675 / 034	676 / 034	A02200901	Platte	Plate	1
675 / 035	676 / 035	A02201702	Federhalter	Spring retainer	1
675 / 036	676 / 036	A02201802	Blattfeder	Leaf spring	1
675 / 037	676 / 037	A02300602/A03700601	rechte Klammernführung	Right staple coil guide	1
675 / 038	676 / 038	A02300702/A03700701	linke Klammernführung	Left staple coil guide	1
675 / 039	676 / 039	A02200101	Magazin	Magazine	1
675 / 040	676 / 040	A02201301	Befestigungsschaft	Shaft	1
675 / 041	676 / 041	A02201901	Unterlegscheibe	Washer	1
675 / 042	676 / 042	A02200801	Bolzen	Shaft	1
675 / 043	676 / 043	A02201001	Arretierhebel	Locking lever	1
675 / 044	676 / 044	A02201401	Abdeckung	Cover	1
675 / 045	676 / 045	A00105001	Platte	Plate	2
675 / 046	676 / 046	A02300901	Unterlegplatte	washer	1
675 / 501	676 / 501	BAC0604142	Sechskantschr. M4 x 0,7-14	Hexagon soc.HD bolt	4
675 / 503	676 / 503	BAB017537	O-Ring 1,78 x 53,7	O-ring	1

MERO 18 P Order No.	MERO 22 P Order No.	Code Nr	Beschreibung	Description	Stck pcs.
675 / 504	676 / 504	BAD02061	Sechskantmutter M6 x 1	Hexagon nut	1
675 / 505	676 / 505	BAT03061	Scheibe 1/4" x 5/8" x 1T	Washer	1
675 / 506	676 / 506	BAB017076	O-Ring DM 1,78 x DM 7,65	O-ring	1
675 / 507	676 / 507	BAB057476	O-Ring 5,7 x 47,6	O-ring	1
675 / 508	676 / 508	A00104101	Unterlegscheibe 8 x 23 x 1,6	Washer	1
675 / 509	676 / 509	BAE01042	Federscheibe M4	Spring washer	1
675 / 510	676 / 510	BAC0404082	Sechskantschr. M4 x 0,7 -8	Hexagon soc.HD bolt	1
675 / 511	676 / 511	BAA025014	Federstift DM 2,5 - 14	Spring pin	1
675 / 512	676 / 512	BAC0312122	Sechskantschr. M12 x1,75-12	Hexagon soc.HD bolt	1
675 / 513	676 / 513	A00104401	Auslösehebelschr M4 x0,7- 7	Trigger screw	2
675 / 514	676 / 514	BAE01042	Unterlegscheibe M4	Spring washer	2
675 / 515	676 / 515	BAA030020	Federstift pin DM 3-20	Spring	1
675 / 516	676 / 516	BAE02042	äuß GreiferbeilagscheibeM4	Outside anvil washer	1
675 / 517	676 / 517	BAC0404102	Sechskantschr. M4 x 0,7-10	Hexagon soc.HD bolt	1
675 / 518	676 / 518	BAA030010	Federstift DM 3-10	Spring pin	1
675 / 519	676 / 519	BAB017124	O-ring 1,78 - 12,42	O-ring	1
675 / 520	676 / 520	BAB017076	O-Ring 1,78-7,65	O-ring	2
675 / 521	676 / 521	BAB016145	O-Ring 1, 6 - 14,5	O-ring	1
675 / 522	676 / 522	BAB016150	O-Ring 1, 6 - 15	O-ring	1
675 / 523	676 / 523	BAB016155	O-Ring 1 ,6 - 15,5	O-ring	1
675 / 524	676 / 524	BAB016160	O-Ring 1 ,6 - 16	O-ring	1
675 / 525	676 / 525	A00104701	Stange 4,9 - 17,5	Rod	2
675 / 526	676 / 526	BAC0306142	Sechskantschr. M 6 x 1-14	Hex.soc.HDless.bolt	1
675 / 527	676 / 527	BAC0408162	Sechskantschr. M8 x1,25-16	Hex.soc.HD bolt	1
675 / 528	676 / 528	BAB01082	Unterlegscheibe M8	Spring washer	1
675 / 529	676 / 529	BAA030010	Federstift 3 -10	Spring pin	4
675 / 530	676 / 530	BAC0605142	6.schr. M5 x 0,8-14	Hex.soc.HD bolt	6
675 / 532	676 / 532	BAC0205122	6.-Senkschraube M5 x 0,8-12	Hex.soc.flat.screw	2
675 / 533	676 / 533	A00104501	Stift 3,98 - 13	Pin	4
675 / 534	676 / 534	A00104602	Stift 6,05 - 8	Pin	2
675 / 535	676 / 535	BAC0604142	Sechskantschr. M4 x 0,7 - 14	Hex.soc.HD bolt	2
675 / 537	676 / 537	BAA060016	Federstift 6 - 16	Spring pin	2
675 / 538	676 / 538	BAA040022	Federstift 4 - 22	Spring pin	3
675 / 540	676 / 540	BAC0605102	Sechskantschr. M 5 x 0,8 -10	Hex.soc.HD bolt	2
675 / 541	676 / 541	BAC0205082	6-Senkschraube M 5x0,8-8	Hex.soc.flat.hd.srew	4
675 / 542	676 / 542	BAC0703061	Rundschraube M 3 x 0,5 - 6	Round HD screw	4
675 / 543	676 / 543	BAF10252	E-Ring 2,5	E-ring	2
675 / 544	676 / 544	BAA040020	Federstift 4 - 20	Spring pin	1
675 / 545	676 / 545	BAF22002	C-Ring	C-ring	1
675 / 546	676 / 546	BAF10252	E-Ring 2,5	E-ring	1
675 / 547	676 / 547	BAG06202	Dichtring M6 x 1,0-2D	Heli coil	1
675 / 548	676 / 548	A00104901	Plastik-Stift	Plastic pin	1
675 / 549	676 / 549	BAE03102	Unterlegscheibe 8	Wave washer	1
675 / 550	676 / 550	C0011201	Aufhänger	Suspension hook	1
675 / 551	676 / 551	PA60031000	Schalldämpfer	Silencer	1



