

STANLEY BOSTITCH

Model D16-2AD BOXLOK STAPLER

STAPLE SIZES: SW7437 7/16 SW7437 5/8 SW7437 3/4
SW9040 5/8 SW9040 3/4 SW9040 7/8

▲ WARNING:

OPERATORS MUST WEAR SAFETY GLASSES OR GOGGLES WHEN OPERATING THE TOOL.
OPERATING PRESSURE MUST NOT EXCEED 80 PSIG (5.7 kg/cm²).

WHEN AIR SUPPLY IS CONNECTED KEEP HANDS AND BODY AWAY FROM STAPLE DISCHARGE AREA AT ALL TIMES. DO NOT FIRE THE TOOL WITHOUT STAPLING INTO MATERIAL.

DO NOT CONNECT FEMALE QUICK COUPLER DIRECTLY TO TOOL. ATTACH MALE FREE FLOW NIPPLE TO TOOL AND FEMALE QUICK COUPLER TO AIR HOSE. IF CONNECTED IMPROPERLY AND DISCONNECTED FROM AIR SUPPLY TOOL WILL REMAIN CHARGED WITH AIR, WILL NOT FREELY EXHAUST AND WILL FIRE A STAPLE IF TRIGGER MECHANISM IS ACTUATED.

ALWAYS DISCONNECT THE AIR SUPPLY BEFORE MAKING ADJUSTMENTS OR SERVICING THE TOOL.

DO NOT USE OXYGEN OR COMBUSTIBLE GASES AS A POWER SOURCE FOR THIS TOOL.

FAILURE TO OBSERVE ANY OF THESE WARNINGS MAY RESULT IN INJURY.

THESE INSTRUCTIONS ARE INTENDED TO PROVIDE SAFE, TROUBLE-FREE SERVICE FROM YOUR STAPLER. READ THEM CAREFULLY.

WHEN THE AIR SUPPLY IS CONNECTED KEEP YOUR HANDS AND BODY AWAY FROM THE STAPLE DISCHARGE AREA. ALWAYS DISCONNECT THE AIR SUPPLY BEFORE MAKING ADJUSTMENTS OR SERVICING THE TOOL. Reasonable care will prevent damage to vital working parts and increase the life of the tool. Do not abuse this tool.

AIR SUPPLY AND CONNECTION

Clean, dry air as provided by the proper filter-regulator-lubricator is mandatory for satisfactory operation of the tool. For proper functioning and lubrication, install this trio unit within 15 feet (4.8 meters) of the tool. Check periodically for cleanliness and oil usage. Use only Mobil Velocite #10 or equivalent oil. **DO NOT** use a detergent oil.

The air supply must be adequate and at a pressure of 40 to 60 pounds per square inch (2.8 to 4.2 kg/cm²). Check supply lines for cleanliness when making connections.

All hoses, pipes and pipe fittings must have a 3/8" (9.5 mm) minimum inside diameter. Hose fittings must have a 9/32" (7.1 mm) minimum inside diameter.

DO NOT CONNECT FEMALE QUICK COUPLER DIRECTLY TO TOOL. ATTACH MALE FREE FLOW NIPPLE TO TOOL AND FEMALE QUICK COUPLER TO AIR HOSE. IF CONNECTED IMPROPERLY AND DISCONNECTED FROM AIR SUPPLY, TOOL WILL REMAIN CHARGED WITH AIR, WILL NOT FREELY EXHAUST AND WILL FIRE A STAPLE IF TRIGGER MECHANISM IS ACTUATED.

Air requirements will vary with operating speed and the type of material to be fastened. Do not use more air pressure than required for the job. Air pressure in excess of the amount required to provide adequate fastening wastes compressed air and may result in damage to equipment.

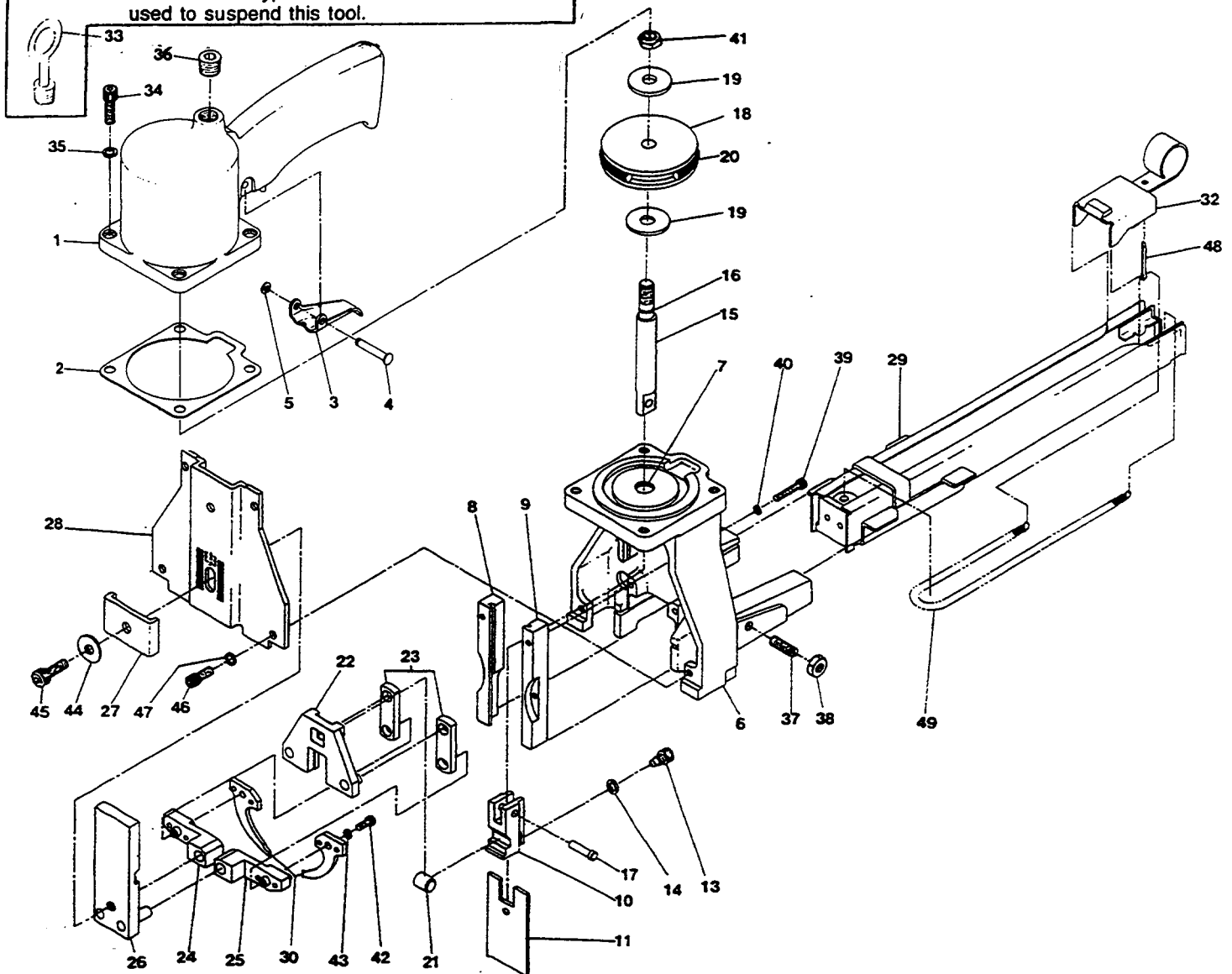
After all air connections are made, check for leaks.

CHOICE OF STAPLE SIZE

When letter "A" on D16112 clamp is in upper left hand corner refer to below listed chart as a guide for establishing proper staple leg length and approximate clincher depth setting. **NOTE:** When D16112 clamp is rotated 180° and letter "B" appears in the upper left hand corner the range of clincher depth settings is lowered 1/32" (.79 mm).

1. Apply LOCTITE 242 to screw thread before assembling hanger to tool.

2. Use a swivel type hook on the counterbalance used to suspend this tool.



ITEM

NO.	PART NO.	DESCRIPTION
1.	D16101A	Cylinder Ass'y
2.	D16243	Cylinder Gasket
3.	T20111	Trigger
4.	T20018	Trigger Pivot Pin
5.	T20049	Trigger Pin Retaining Ring
6.	D16163A	Frame
7.	85014	"O" Ring
8.	D16168	Driver Guide L.H.
9.	D16167	Driver Guide R.H.
10.	D16179	Driver Block
13.	UA4006.2	Driver Retaining Screw
14.	D16327	Retaining Screw Spacer
15.	D16180	Piston Rod
17.	D16185	Driver Block Pin
18.	D14227B	Piston
19.	D16146	Piston Washer

ITEM

NO.	PART NO.	DESCRIPTION
20.	85016	"O" Ring
21.	D16183	Escapement Roller
22.	D16184A	Clincher Link Plate
23.	D14130	Clincher Link
24.	D14132A	Clincher Lever L.H.
25.	D14133A	Clincher Lever R.H.
26.	D16111A	Clincher Adj. Plate
27.	D16112	Clincher Adj. Clamp
28.	D16114	Front Plate
32.	D16149A	Pusher Assembly
34.	UA4814.1	1/4-20 x 7/8 Soc. Hd. Cap Screw
35.	LW14.2	1/4 Lock Washer
36.	UA9607	1/4 Pipe Plug
37.	UA4816.12	1/4-20 x 1" Cone Pt. Set Screw
38.	HN1420.2	1/4-20 Hex Jam Nut
39.	UA2810	#8-32 x 5/8" Soc. Hd. Cap. Screw

NO.	PART NO.	DESCRIPTION	NO.	PART NO.	DESCRIPTION
40.	LW8	#8 Lock Washer	45.	UA5812.3	5/16-18 x 3/4" Soc. Hd. Cap. Screw
41.	HN3824.4	3/8-24 Elastic Stop Nut	46.	UA3808.8	#10-24 x 1/2" Soc. Hd. Cap. Screw
42.	UA2808.1	#8-32 x 1/2" Soc. Hd. Cap. Screw	47.	LW10	#10 Lock Washer
43.	LW8	#8 Lock Washer	48.	UB2912.3	3/32 x 3/4" Cotter Pin
44.	PW516.4	Washer	49.	D14164	Pusher Spring

VARIABLE PARTS

ITEM NO.	DESCRIPTION	STANDARD PARTS	OPTIONAL PARTS
11.	Driver	D16170 (long)	D16178 (short)
30.	Clincher	D16124 (deep)	D16124B (deep pointed) D14135 (shallow)
33.	C' Balance Hanger		D16106A
29.	Magazine Assembly	D16169A [5/8" (15.9mm) 3/4" (19.1mm) and 7/8" (22.2mm) staples]	D16164A [7/16" (11.1mm) 5/8" (15.9mm) and 3/4" (19.1mm) staples]

D14135 CLINCHERS

Approx. Clincher Adjusting
Clamp Setting.

	6	5	4	3	2	1
(2) A Board-Blind				5/8 (15.9mm) Leg		
(2) A Board-Through					3/4 (19.1mm) Leg	
(2) B Board-Blind		7/16 (11.1mm) Leg				
(2) B Board-Through			5/8 (15.9mm) Leg			
(2) C Board-Blind			7/16 (11.1mm) Leg			
(2) C Board-Through			5/8 (15.9mm) Leg			

To obtain maximum efficiency from the staple closure, it is important that the staple be clinched properly. Proper clinching for any thickness board may be obtained by adjusting the clincher setting with staples of proper leg length.

Use the proper length staples for the thickness of work to be stapled, otherwise unnecessary pressure is exerted and staple crowns and legs will be distorted, or the clinch will be too loose.



Staple driven completely through two thicknesses of corrugated board and clinched on underside.



Staple clinched "blind," when desired, in two thicknesses of corrugated board.

D16124 DEEP CLINCHERS

Approx. Clincher Adjusting
Clamp Setting

	6	5	4	3	2	1
(2) A Board-Through					3/4 (19.1mm) Leg	
(2) AB Board-Blind					3/4 (19.1mm) Leg	
(2) AB Board-Through						7/8 (22.2mm) Leg

D14135 clinchers are for shallow penetration as in single wall board and will clinch inside board without damage to contents. D16124 clinchers are for deep penetration as in double wall board.

CAUTION: WHEN USING DEEP PENETRATION CLINCHERS, IT MAY BE NECESSARY TO USE A FILLER TO PREVENT DAMAGE TO MERCHANDISE. D16124 CLINCHERS MAY ALSO BE USED FOR STAPLING THROUGH SINGLE WALL BOARD PROVIDED A FILLER IS USED TO PREVENT DAMAGE TO CONTENTS OR CLINCHERS.

CLINCHER ADJUSTMENT:

Clincher adjustment for depth of penetration is obtained by loosening the clincher adjusting clamp screw on front of machine and moving it up or down. When in its highest position, the clinchers are set for the shallowest staple penetration. Lowering the clinchers increases the penetration. After establishing the setting, tighten adjustment screw.

NOTE:

The D16-2AD is equipped with a driver to counter-sink the crown of the staple below the surface of the box. The shorter driver, available on order, will allow the crown of the staple to rest on the top of the box.

TO LOAD:

Pull Pusher to back of magazine and turn over rear as far as it will go.

Place 2 sticks of SW7437 or SW9040 staples in channel.

Swing pusher into place against staples. Do not let it slip and strike staples. This may deform some staples, and cause poor feeding.

▲ WARNING: SHUT OFF AIR SUPPLY BEFORE MAKING ADJUSTMENT, REMOVING CLOGGED STAPLES, OR SERVICING.

TO OPERATE:

To operate machine, grasp handle. Position machine on box placing directly over the seam between flaps and in line with desired staple location. Squeeze trigger and release completely before moving machine. Move machine to each staple position and repeat. Strongest closure requires end staples close to end of box, approximately 1" (25.4mm). Be sure staples penetrate inner flaps. Check staple clinching in sample of box board, such as that being used. Adjustment for depth of penetration is easy and full advantage should be taken. Clincher adjusting clamp settings as listed in chart are offered only as a guide and may have to be slightly modified.

MAINTENANCE:

Specify the part number when ordering replacement parts. Do not order by description. Do not wrench, twist or force parts during servicing, as damage may result.

Check screws periodically for tightness. Observe caution against stripping threads when tightening. When the tool is disassembled, clean thoroughly. Lubricate all moving parts after cleaning. Apply "Cal-lub" to O-rings. Examine all parts for wear during servicing so that replacement parts can be ordered in advance of trouble.

LUBRICATION:

Use Mobil Oil Velocite #10 or equivalent. Do not use detergent oil. Tools which are in constant operation should be lubricated daily with a reasonable amount of oil. Lubricate regularly instead of excessively.

FILTER-REGULATOR-LUBRICATOR:

See manufacturer's instructions for maintenance of this unit. It should be thoroughly cleaned periodically for best results. Dirt in air lines will damage precision cylinders and clog valves in any pneumatic equipment.

▲ WARNING: DISCONNECT THE AIR SUPPLY BEFORE SERVICING TOOL.

CLINCHER REPLACEMENT:

1. Loosen the clincher adjusting clamp screw.
2. Slide the clincher adjusting clamp to the highest position. Retighten clamp screw. The clincher screws will be aligned with and visible through the 2 round holes in the back of the machine frame. Insert a socket screw wrench to loosen and remove screw holding clincher.
3. Grasp the clinchers by hand or with pliers and lift off the anchor dowels.
4. To assemble new clincher and screw, clean parts thoroughly. Degrease threads with Loctite Safety Solvent #75559; apply Loctite Grade 222 to screw threads and assemble. Refer to Loctite's instructions. Tighten screw firmly.
5. Readjust the clincher adjusting clamp to the desired setting and tighten.

DRIVER REPLACEMENT:

1. Remove the magazine.
2. Remove the driver retaining screw **Item 13**. Driver may now be removed from the housing.

MAGAZINE REPLACEMENT:

1. Remove staples from magazine.
2. Loosen the two magazine binding screws and nuts.
3. Pull magazine out of engagement with the frame.
4. Insert new magazine making sure the front edge contacts the rear of driver guides. Centralize magazine in driver guides with binding screws. Tighten the magazine binding screw and nut so that magazine is securely held.

CAUTION: DO NOT TIGHTEN THE MAGAZINE BINDING SCREW EXCESSIVELY AS TOO MUCH PRESSURE WILL DAMAGE THE MAGAZINE.

DRIVER BLOCK PIN REPLACEMENT

1. Remove piston rod and driver block assembly from machine.
2. Remove as much flare on end of driver block pin as possible.
3. Use a rod smaller than pin diameter as a punch and drive pin free.
4. To reassemble, insert new driver block pin thru driver block and piston rod. Support driver block pin on head and flare opposite end. Only a slight flare of approx. .020 greater than pin diameter is required to retain pin and provide proper linear movement of pin in assembly.

STANLEY BOSTITCH
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