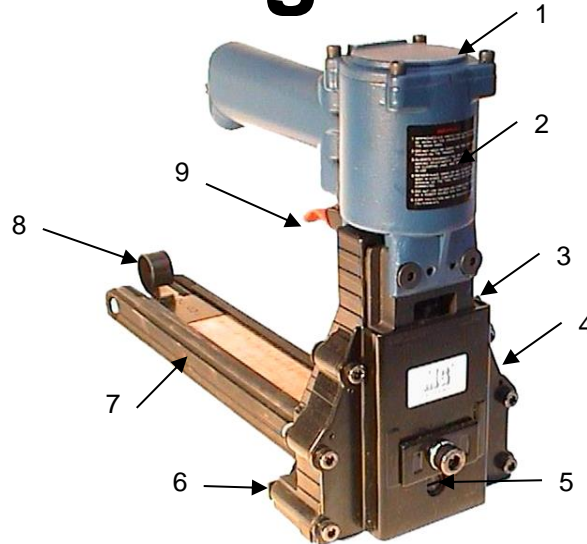


Operating Instructions



- 1) Cover
- 2) Housing
- 3) Adjustment ring
- 4) Adjustment plate
- 5) Adjusting screw
- 6) Magazine housing
- 7) Magazine
- 8) Transport puck
- 9) Triggering lever

**Pneumatic cover sealing stapler
MEPA 18 P and MEPA 22 P**

IMPORTANT

Before the first commissioning read this manual thoroughly and completely and keep it in a safe place. Observe and follow the safety instructions and only use the stapling device if you are sure that you have completely understood all the instructions. Failure to comply can lead to injuries!

If you have any questions, contact the manufacturer

MEZGER Heftsysteme
Saganer Straße 24
90475 Nuremberg
Germany
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Model

Type/description:

See device label

Preface

For a safe operation of the stapling device it is necessary to acquire the knowledge conveyed by these **ORIGINAL OPERATING INSTRUCTIONS**. The information is presented in brief and clear form. The chapters are sorted by numbers.

Copyright

The copyright of this operation manual remains with **MEZGER Heftsysteme GmbH**

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1 Conformity

This stapling device was built in conformity with the following EU guidelines:
Machinery directive 2006/42/ EG

2 Safety information

Safety instructions and important explanations, are labelled with the following pictograms. The symbols used in the operating instructions have the following meaning:

Symbol	Signal word	Meaning
	Warning notice	Warning of possible injuries to persons or possible damage to property Warning of possible defects or destruction of the machine
	Prohibition	Indicates general prohibitions!
	Warning notice	Risk of fingers being crushed!
	Prohibition	Protect from moisture!

Read all these instructions before using the stapling device and keep the safety instructions in a safe place. Safety on the well.

The operating personnel must be trained in the handling of the stapling device and they must have fully read and understood the operating instruction.

To avoid injury or damage, the operator must additionally observe the company's internal safety guidelines!

In addition, we would like to refer to further national rules and safety provisions which are not contained in this manual.



Keep persons who are not instructed, especially children, away from your work area!

If damage to the device is determined by the operator during production, the stapling device may no longer be used and must be repaired by a professional!

The required personal protective equipment must be provided by the operator.

Only original parts may be used as spare parts!

3 Warranty and liability

Our “General Terms of Sale and Delivery” shall generally apply. These terms were made available to the operator by the time of contract award at the latest.

Any warranty and liability claims in the case of personal and material damage shall be excluded, if such damage occurred as a result of:

- Improper use of the machine stapling device.
- Non-compliance with the specification provided in the operating instructions as regards transport, storage, assembly, commissioning, operation, maintenance and setup of the stapling device.
- Operation of the stapling device with defective safety equipment or improperly installed or non-functional safety and protection facilities.
- Improper monitoring of device parts which are subject to wear and improperly executed repair work.
- Manipulation of the stapling device in any way.

4 Intended use

The stapling device is **only** to be used as intended. It may only be used, operated and maintained according to the information contained in this operating manual.

Only use the materials and staples defined for the respective stapling device, otherwise malfunctions and damage to the stapler may occur. The stapling device may only be used as specifically described in this operating manual. Any other application is only permitted after a prior written approval from the manufacturer.

Any other usage is not regarded as intended use and can lead to damage to persons or property. The operator of the machine is solely liable for damages deriving from any non-intended use.

The operator must ensure that the stapling device is only operated as intended and that all types of hazards to life and health for the user or third parties are avoided. In addition, a compliance with the accident prevention regulations and other safety regulations and laws must be observed.



If the stapling device is abused for purposes other than the specified usage scenarios, this can lead to accidents

5 Ambient conditions/Emission

The stapling device should be operated at room temperature, protected against environmental influences.

Use within an explosive atmosphere is permitted only with prior consent and written permission of the manufacturer.

The noise emission is less than 93 dB(A).

Non-atmospheric gases are not released during the stapling process.

6 Operating personnel

Only trained and knowledgeable staff is permitted to operate the stapling device.

Note: Competent, is someone who based on his training and experience has sufficient knowledge in the field of stapling devices and is familiar with the relevant government industrial safety regulations, accident prevention regulations and the generally accepted rules of technology (e.g. DIN standards, VDE regulations) to the extent that he can assess the secure state of machines and in particular the state of stapling devices.

7 Transport and initial commissioning

Before the stapling device is put into operation, please read all instructions in this manual. This stapling device may only be put into operation by **trained** personnel.

The stapling device is delivered completely assembled and can be transported as a whole. Transportation equipment can also be used for transporting the machine.

To make the stapling device ready for operation after delivery, the following tasks must be carried out:

- Check the equipment for completeness
- Load the stapling device with staples
- Connect the compressed air

The air pressure is 4 - 6 bar overpressure.

It is necessary to install a filter regulator upstream which consists of a filter and a pressure regulator.

As a connecting hose, a hose with an internal diameter of 6 mm is required.



Oxygen or combustible gases may not be used as a propulsion source for pressure driven machines.

It is recommended to only supply the stapling device with oil, filter and pressure regulator through a maintenance unit.

8 Fundamental notes on the work technique and handling

Before the operator starts to use the machine he must acquire information about the application scenario and check if the stapling device is suitable for it.
Carefully observe all safety instructions!



Check to make sure that the stapling device is not damaged and that it can be operated in a safe way.

The operating safety of the stapling device must be checked before starting the work and constantly rechecked!

Safety devices may not be bypassed or rendered ineffective!

Keep your work area in order.

Disorder in the work area can cause accidents.

- Use only ORIGINAL staples that are made specifically for this quality equipment. Third-party staples can cause considerable damage and malfunctions.
- Never perform a stapling without material to be stapled. Do not remove the stapling device until the stapling process has been completed.
- Do not staple on a hard underlay.
- Should a staple failure arise, correct it immediately and do not trigger any further staple cycles.
- Shut down the stapling device after use.
- If possible, the stapling device should be suspended over the packaging center.

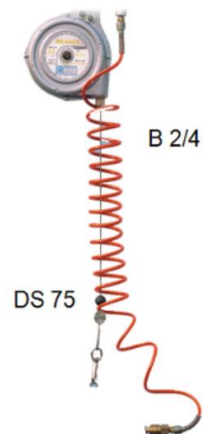
Available accessories:

B 2/4 Balancer (weight equalization) with a swivelling load hook

DS DS 75 spiral compressed air hose with an extended length of 7.5 m

W/EINH Maintenance unit

consisting of a pressure regulator, water separator and an oil vaporizer



9 Decommissioning

If the stapling device is not used for a prolonged period of time, disconnect the air supply and extract the staples.

10 Maintenance and care



CAUTION! Before performing any maintenance work, the compressed air supply must be disconnected.



Any kind of alteration to the stapling device (e.g. drill holes) shall only be permitted with a prior consent and written permission of the manufacturer. the manipulations on the safety device(s) are forbidden!

In order to maintain the operational readiness and function of the stapling device, it must be regularly checked and cleaned by the operator or by qualified personnel.

Check area	Activity / check	D	W	M	Y	Area
Stapling area and environment	cleaning		●			Complete stapling device
The stapling device	check / clean		●			Stapling area
Stapling device	Clean and lubricate lightly		●			
Loading area	check / clean		●			
Pneumatic hoses, leak tightness, damages	check		●			Pneumatics
Screw connections for tightness	check			●		
Filter regulator	Cleaning/ draining				●	

T = daily / **W** = weekly / **M** = monthly (6M = every 6 months) / **J** = yearly

The stapling device does not require a great deal of care, but should be cleaned and maintained on a regular basis. Soiling should be removed directly by the operator after the machining processes.

Adequate care will help to permanently keep the stapling device in a functionally correct state. The stapling device should be cleaned thoroughly at least once a week.

- No aggressive cleaning agents or solvents (could damage seals), or even sandpaper may be used for cleaning.
- The cleaning with compressed air should also be avoided, since this could transport dirt particles into the seals and damage them.
- Do not use linting cleaning wool for cleaning work.

The following work processes/inspections should be performed by knowledgeable personnel on a regular basis:

- Regular oiling of the movable parts (no graphite oil!) - on a weekly basis
- Check the filter controller for condensation. If necessary remove the condensation water.

Only ORIGINAL spare parts may be used. (see "spare parts list")

Failure to comply will void any guarantee claim and exclude any liability!

All technical equipment, especially the safety equipment, must be inspected by qualified personnel after repairs.

In order to maintain the operational readiness and function of the stapling device, it must be regularly checked and cleaned by the operator or by qualified personnel.

11 Application area/designated use

The stapling device may only be used for the following purposes:
to seal filled folding cartons made of single, double and light triple corrugated cardboard.

Do not staple into hard (e.g. metal plates, nails, etc.) and brittle materials.
This can damage the stapling device.

12 General/Function

The cover sealing staplers are available in two basic versions:

MEPA 18 P and MEPA 22 P

The cover sealing stapler **MEPA 18** processes B 5/8 and B 3/4, (15 and 18 mm) staples.

The cover sealing stapler **MEPA 22** processes B 3/4 and B 7/8, (18 and 22 mm) staples.

Adjust the stapling device according to the requirements.

The **MEPA** cover sealing stapler is placed onto the carton to be sealed, so that the slit of the carton is positioned centered below the stapling device (see arrow on the front of the stapling device). Afterwards the stapling is triggered. To do this, the triggering lever (9) is pressed. The bending grippers extend, set the staple and automatically return to the base position. Release the triggering lever (9) again. The stapling device can be moved to the next stapling position.

The optimum stability of the seal can be achieved if staples are additionally applied as close as possible (approx. 1 cm) from the edge of the folding carton.



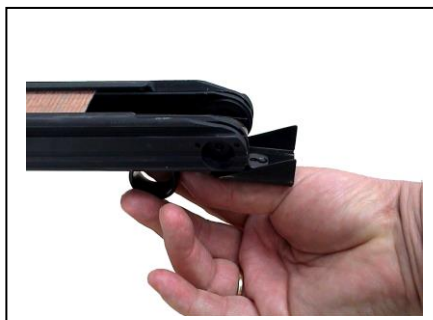
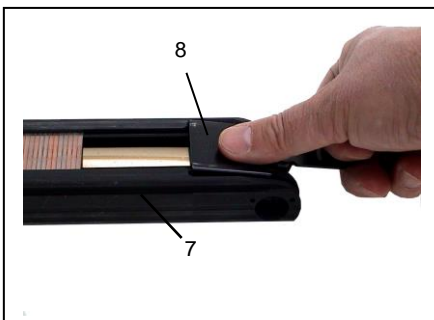
**Only move the stapling device after the bending grippers have been fully retracted!
Otherwise damages could occur.**

13 Reloading

CAUTION:

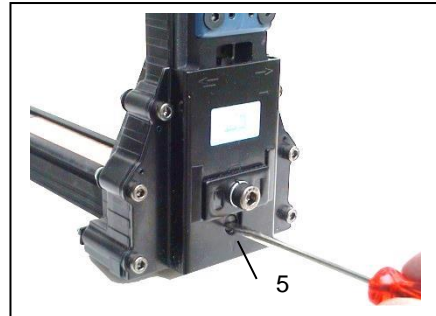
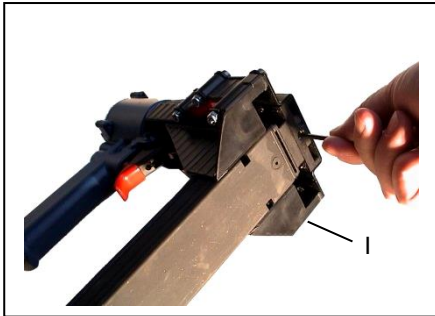
The stapling device must be disconnected from the compressed air supply before reloading.

The transport puck (8) is pulled back in the magazine (7) and swiveled downwards until it snaps in. After inserting the staple strips, press down the transport puck (8) and **do not** bring it into a tensioned position rapidly.



14 Adjusting the leg length of the staple

The stapling device must be disconnected from the compressed air supply before the adjustment. Loosen the hexagonal screw (I) with a 3 mm Allen wrench, turn the adjusting screw (5) 180° with a screwdriver into the required adjustment position. For long leg lengths turn the adjusting screw (5) so that L faces upwards. For a short leg lengths turn the adjusting screw (5) so that S faces upwards. Tighten the hexagonal screw (I) again.



MEPA 18 P

Leg-length	15 mm (B5/8)	18 mm (B 3/4)
Adjusting screw position	S — T	L — S

MEPA 22 P

Leg-length	18mm (B3/4)	22mm (B7/8)
Adjusting screw position	S — T	L — S

15 Setting for open and closed stapling

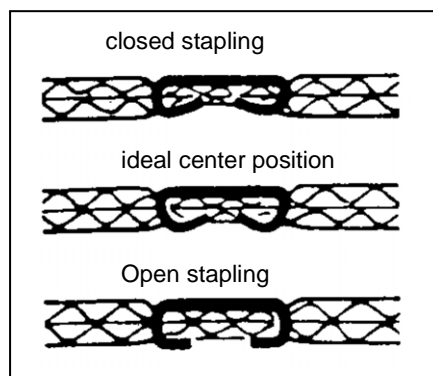
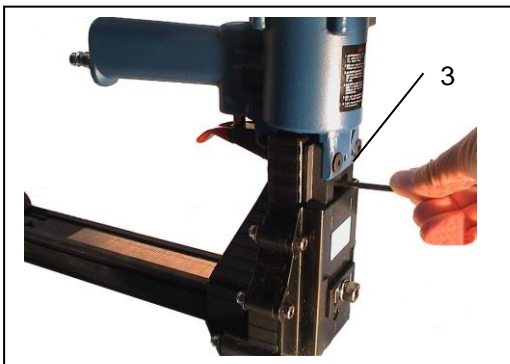
To adjust the stapling strength, turn the adjusting ring (3) with an appropriate tool (enclosed), e.g. a 2.5 mm Allen key, in the desired direction

Adjustment T = Thin = Turn adjustment ring to the left

(staple closed is suitable for thinner cardboard boxes)

Setting L = Large = Turn setting ring to the right

(staple open is suitable for thicker cardboard boxes)

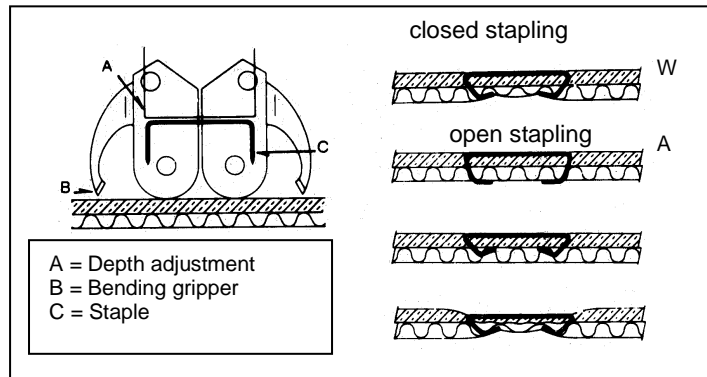
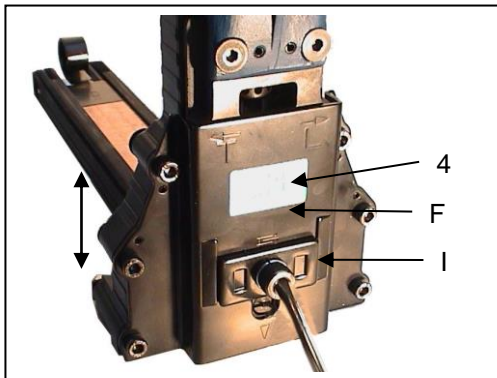


16 Setting the Stapling depth

To adjust the penetration depth of the bending grippers (stapling depth), loosen the front screw (F) with a 6 mm hexagonal wrench (W). Pull/press the complete magazine housing (5) towards the cylinder housing (2) upwards or downwards into the desired position. Subsequently tighten the front screws (F) again.

If the magazine housing (5) is pushed completely upwards, the penetration depth (A) will be the greatest.

If the magazine housing (5) is pushed completely downwards, the penetration depth (A) will be the lowest.



17 Error detection



During any kind of defect, the stapling device is to be shut down and separated from the pressurized air supply until the flawless operation is ensured again. Please do not try to dismantle or repair the stapling device.



In the event of a malfunction, which is more extensive than just some jammed staples, please contact us. The stapling device will be examined by our specialists and the malfunction will be remedied.

Remove **all** staples in the stapler and clean the stapling device.

- Remove visible staples in the staple outlet opening with a suitable tool. Do not overload or damage the device thereby! In difficult cases, open the magazine and pull out the staples upwards. Make sure that the clamp outlet opening is not damaged.
- Replace damaged or worn stapling devices.
- Connect the compressed air again
- Make sure that the air pressure is set correctly

17.1 No stapling occurred or the staple wasn't *fully bent*, or it *remains* in the stapling device.

Fault	Cause	Remedy
No pressure indication	Shut-off valve closed.	Open the shut-off valve.
	Pressure not set.	Set the pressure with the pusher adjustment knob.
	Pressure gauge defective.	Replace pressure gauge.
Low flow rate (operating pressure collapses during air consumption)	Filter cartridge is dirty.	Replace the filter cartridge.
	Constriction between main valve and maintenance unit	Check the lines.
Pressure rises above set operating pressure	Valve disc at the sealing seat defective.	Contact the manufacturer
Audible blow-off at the control knob	Valve seat defective.	Contact the manufacturer
Audible blow-off at the drain plug	Drain plug leaking.	Tighten or replace.
Feed movement not guaranteed.	Air pressure too low.	With stapling 4 - 6 bar overpressure. Check hoses and valves, and ensure a sufficient air supply.
Air cleanliness inadequate	Compressed air	Connect a maintenance unit upstream consisting of a pressure regulator and water separator.
Staple is jammed in the stapling head and is not preformed.	Compressed air	Air pressure too low. Stapling device operated too quickly.
Triggering lever/cylinder blows off	O-ring(s) is/are damaged	Replace O-rings Send in the stapling device
Slow and too short stapling time	Triggering lever loose/defective	Tighten the screw or replace the triggering lever
Jammed staple	Triggering lever loose/defective	Tighten the screw or replace the triggering lever Send in the stapling device
	Screw loose on the bending gripper	Tighten screw firmly
	Staple size is set incorrectly	Insert the correct staple size
	Insufficient lubrication	Lubricating the moving parts
Asymmetrical stapling	Wrong staple size	Setting the stapling according to the operating manual (see chapters 3.4 - 3.6).
Staple does not bend over	Bending grippers are loose or damaged	Tighten the bending gripper at the screws, or replace if necessary. Send in the stapling device
	Triggering lever loose/defective	Tighten the screw or replace the triggering lever Send in the stapling device

17.2 Removing jammed staples

If a staple becomes jammed despite built-in safety devices, the stapling device may not be released under any circumstances, as this can lead to breakage of the bending grippers. Disconnect the stapling device from the compressed air supply.

Pull the transport puck (8) backwards. Remove the jammed staples with an appropriate tool, for example, with pliers. Unlock the transport puck (8) again.

18 Technical data/versions

Connection: 1/4''
Working pressure: 5 - 7 bar; max. 8 bar
Air consumption: 0.7 NL/stapling

For pneumatic plier staplers, we can supply accessories such as balancers, spiral hoses, maintenance units, swivel arms, compressors, etc. (see INFO: pneumatic accessories).

Available version	Dimensions (mm)	Weight (kg)	matching staple 35 mm back width		
			for single corrugated cardboard	for double corrugated cardboard	for light triple corrugated cardboard
<input type="checkbox"/> MEPA 18 P	340 x 220 x 115	1.98	B 5/8 = 15 mm	B 3/4 = 18 mm	
<input type="checkbox"/> MEPA 22 P	340 x 220 x 115	2.16		B 3/4 = 18 mm B 7/8 = 22 mm	B 7/8 = 22 mm
			Leg lengths:	15 mm, 18 mm, 22 mm	
			Load capacity:	100 staples	

19 Notice of residual risks



Do not reach into the stapling device or the staple outlet opening when the stapler is in working order! DANGER OF injury!



Compressed air connections must be checked regularly



When working on pressurized air connections and hoses the stapling device must be depressurized.



Never point the stapling device at yourself or other persons



**Protect the stapling device from moisture!
Do not operate the machine in a humid environment!
Only operate the machine within buildings!**

