

paslode[®]

OPERATION, PARTS
& SAFETY MANUAL

MAGNUM CORRUGATED FASTENER TOOL MODEL MA-C20



**Drives 1/4", 3/8", 1/2" & 5/8"
corrugated fasteners.**

**IMPORTANT!
DO NOT DESTROY**

**It is the customer's responsibility to
have all operators and service personnel
read and understand this manual.**

**PATENT NOTICE
REVISED NOVEMBER 1981**

The Paslode Methods, Tools, Equipment and Fasteners are covered by one or more of the following United States Patents in addition to foreign patents and other United States and foreign patents applied for:

3,194,324	3,323,183	3,629,931	3,841,473
3,207,405	3,329,068	3,638,532	3,851,371
3,212,632	3,342,659	3,653,117	3,851,759
3,229,589	3,353,737	3,653,299	3,878,663
3,253,760	3,357,761	3,673,922	3,908,884
3,261,527	3,401,072	3,717,891	3,966,042
3,269,274	3,410,620	3,720,960	3,980,179
3,272,267	3,468,590	3,722,670	4,073,423
3,272,417	3,477,629	3,774,293	4,153,959
3,276,576	3,496,835	3,774,833	4,186,862
3,278,102	3,552,274	3,815,475	4,188,858
3,285,489	3,576,286	3,822,819	4,227,591
3,315,436	3,628,714	3,840,165	4,252,261

*REGISTERED U. S. PATENT OFFICE

paslode[®]
The Driving Force in Power Fastening

400516-2

OPERATOR SAFETY INSTRUCTIONS

While Paslode has designed, produced and inspected all its tools with safety in mind, there are certain basic safety precautions that must always be followed by the operator. These include:

1. NEVER operate or work in the vicinity of a tool in use without hearing protection and eye protection devices, including side shields.
2. NEVER assume the tool is empty. Check the magazine.
3. NEVER engage in horseplay with the tool; it is not a toy.
4. NEVER point the tool at anyone or yourself, even if you think it is empty or disconnected.
5. NEVER operate the tool unless it is in contact with the work-piece.
6. NEVER tamper with, disable, or remove the work contacting element.
7. NEVER leave the work area for any extended period of time WITHOUT DISCONNECTING the tool from the air line.
8. NEVER attempt to clear a jam without disconnecting the tool from the air line and removing the remaining fasteners from the tool.
9. NEVER allow the air pressure to exceed the maximum marked on the tool. Check the air pressure gauge at least twice daily. Do not operate with bottled air or gases.
10. NEVER operate a dirty tool or one with worn parts. Clean and inspect the tool at least daily and lubricate if required. Replace worn parts promptly.
11. In case of tool malfunction:
 - (a) Disconnect from air line immediately and remove all fasteners from magazine.
 - (b) Turn the tool over immediately to the person responsible for repair, or attach a tag to the air inlet indicating the tool should not be used.
 - (c) NEVER re-connect to the air line until the tool is thoroughly repaired and inspected.
12. NEVER carry the tool with the trigger depressed.
13. NEVER clamp the trigger in a locked operating position.
14. NEVER load the tool with either the trigger or work contacting element depressed.
15. NEVER use parts or fasteners other than those specifically designed and recommended by Paslode for use in the tool and the work to be done.
16. NEVER attempt to modify the tool in any way.
17. For detailed information on the tool installation, maintenance and loading instructions, refer to the last page of this manual.
18. Treat the tool with respect and it will perform safely and reliably for you.

TOOLS DO NOT CAUSE ACCIDENTS — PEOPLE DO!

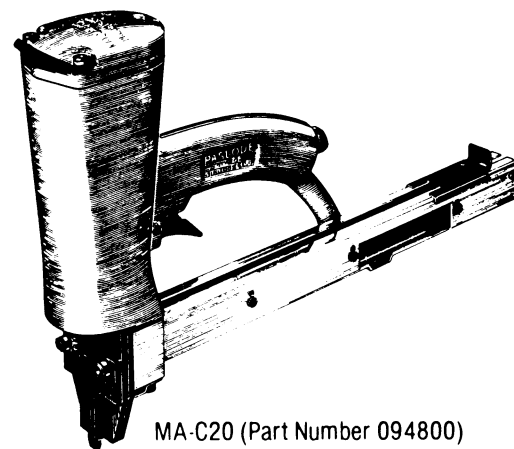
*Safety Instructions in Spanish are available
from your sales representative.*

*Su vendedor le puede proporcionar los
instructivos de seguridad en español.*



MAGNUM CORRUGATED FASTENER TOOL

MODEL MA-C20



MA-C20 (Part Number 094800)

PASLODE TOOL WARRANTY AND LIMITATIONS

Paslode warrants that newly purchased Paslode fastening tools will be free from defects in material and workmanship for a period of ninety (90) days after the date of its delivery to the original users place of business. Paslode's sole liability hereunder will be to replace any part (except normal wearing parts) which proves to be defective within such period. Paslode reserves the right to replace any tool proven to contain a defect with a rebuilt tool of the same model if in Paslode's judgement such replacement is appropriate to efficiently cure the defect. Any rebuilt tool provided owner in accordance with this warranty will carry a warranty for the balance of the period of warranty applicable to the tool it replaces.

This warranty is void as to any tool which has been subjected to misuse, abuse, accidental or intentional damage, used with fasteners of improper specifications, size or quality, improperly maintained, repaired with other than genuine Paslode replacement parts, damaged in transit or handling or which in Paslode's opinion has been altered or repaired in a way that affects or detracts from the performance of the tool.

PASLODE MAKES NO WARRANTY, EXPRESS OR IMPLIED, RELATING TO MERCHANTABILITY, FITNESS OR OTHERWISE EXCEPT AS STATED ABOVE and Paslode's liability as assumed above is in lieu of all others arising out of or in connection with the use and performance of the tool. PASLODE SHALL IN NO EVENT BE LIABLE FOR ANY INDIRECT OR CONSEQUENTIAL DAMAGES INCLUDING, BUT NOT LIMITED TO DAMAGES WHICH MAY ARISE FROM LOSS OF ANTICIPATED PROFITS OR PRODUCTION, SPOILAGE OF MATERIALS, INCREASED COST OF OPERATION OR OTHERWISE.

PARTS LIST

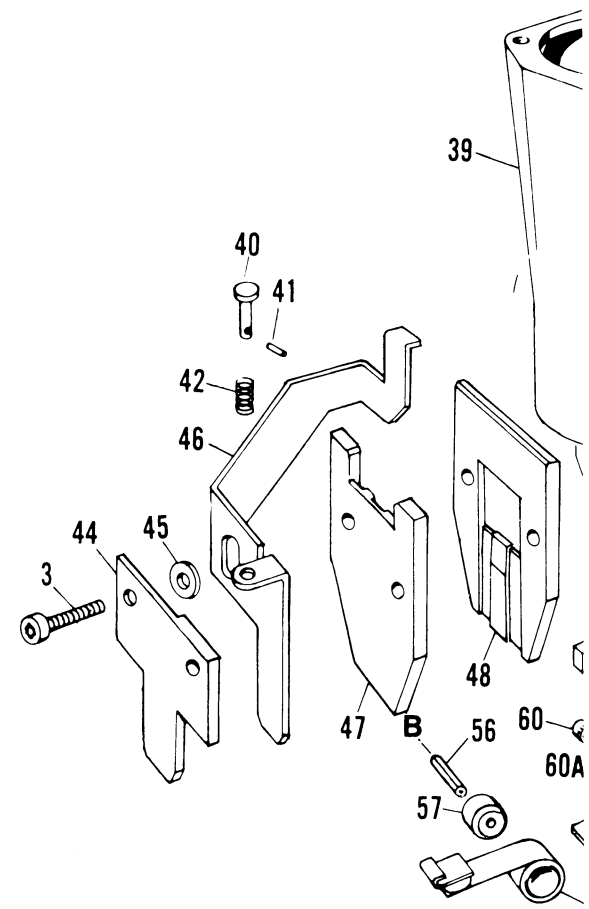
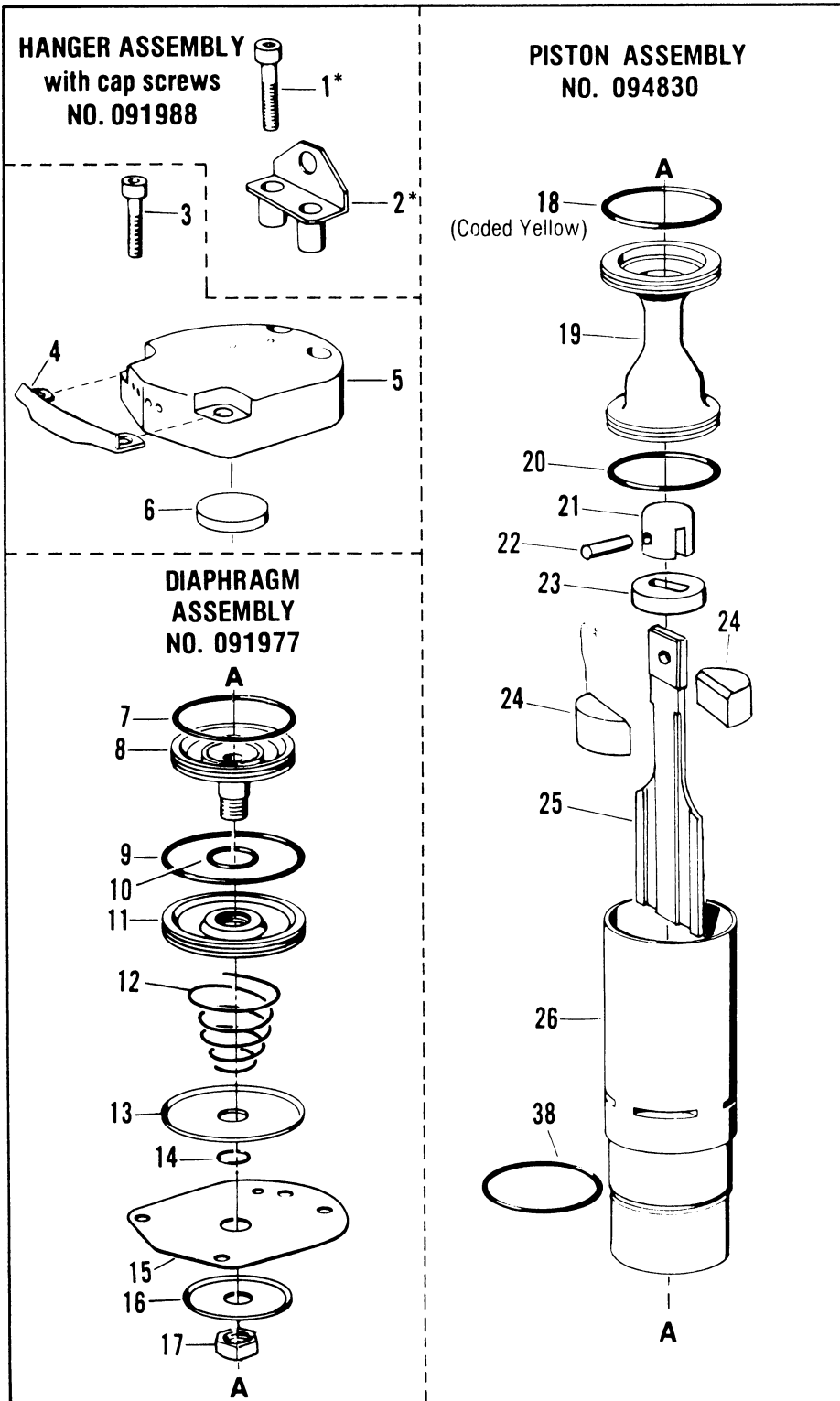
When ordering parts, please show tool model, part number and name.
Standard hardware items listed are available at any local hardware supply.

*Optional parts.

Recommended spare parts are in **bold face type**

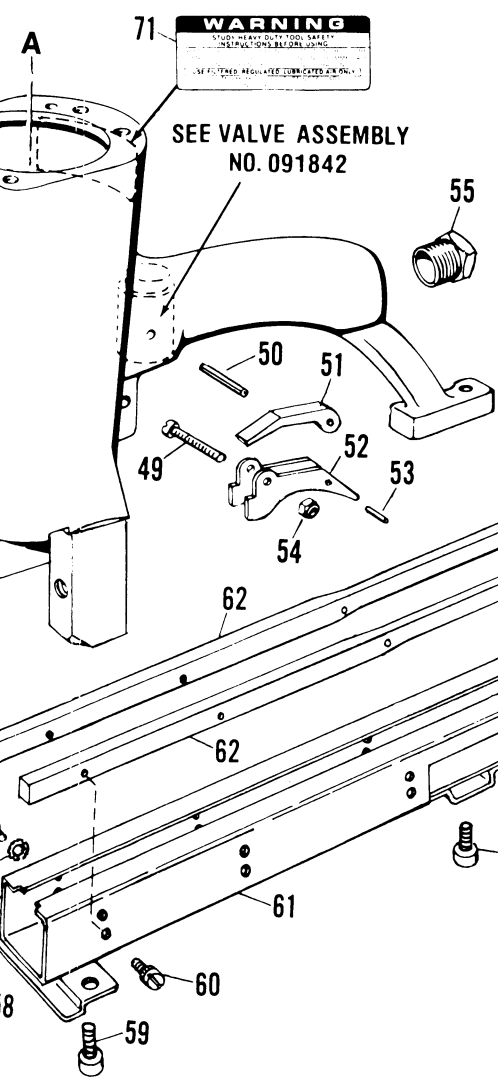
Normal wearing parts are underlined

KEY NO.	PART NAME	QTY.	PART NO.
1*	Soc. Hd. Cap Screw 1/4-20 x 1 1/2	2	091362
2*	Hanger Assembly	1	091566
3	Soc. Hd. Cap Screw 1/4-20 x 1"	6	091592
4	Deflector	1	091912
5	Cap	1	091502
6	Bumper, Cap	1	091503
7	"O" Ring	1	091540
8	Piston, Cap	1	091504
9	"O" Ring	1	091542
10	"O" Ring	1	092709
11	Seal, Cap	1	091505
12	Spring, Diaphragm	1	090495
13	Plate, Diaphragm	1	091506
14	"O" Ring	1	091623
15	Diaphragm	1	094736
16	Washer, Diaphragm	1	091508
17	Flexloc Thin Nut 3/8-24	1	091544
18	<u>"O" Ring (Coded Yellow)</u>	1	091538
19	Piston	1	094822
20	<u>"O" Ring</u>	1	091986
21	Insert, Piston	1	094823
22	Grooved Pin	1	092778
23	Insert	1	094824
24	Bumper	2	091779



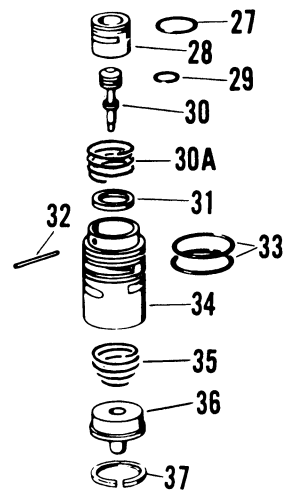
KEY NO.	PART NAME	QTY.	PART NO.
25	Driver Blade	1	094802
26	Sleeve	1	091509
27	"O" Ring	1	091624
28	Insert, Valve	1	091519
29	"O" Ring	1	095419
30	Pin, Valve	1	091518
30A	Spring, Seat Retainer	1	096110
31	Seat, Valve	1	091520
32	Roll Pin, 1/16 x 5/8	1	095420
33	"O" Ring	2	091541
34	Body, Valve	1	091517
35	Spring, Valve Button	1	091523
36	Button, Valve	1	091816
37	Spirolox Retaining Ring	1	091555
38	"O" Ring	1	091208
39	Cylinder	1	094801
40	Pin, Safety	1	091573
41	Roll Pin 3/32 x 1/2	1	091551
42	Spring	1	091574
44	Guide	1	094803
45	Washer	1	091572
46	Work Contacting Element	1	094804
47	Front Guide	1	094805
48	Back Plate	1	094806

KEY NO.	PART NAME	QTY.	PART NO.
49	Pin Trigger	1	091821
50	Roll Pin 5/32 x 1-1/8	1	091550
51	Lever, Trigger	1	091817
52	Trigger	1	091818
53	Roll Pin 3/32 x 5/8	1	091880
54	Flexloc Thin Nut 8—32	1	091363
55	Reducing Pipe Bushing	1	091622
56	Roll Pin 3/16 x 5/8	1	008919
57	Drum	1	091534
58	Negator Assembly	1	094807
59	Soc. Hd. Cap Screw 1/4-20 x 1/2	4	009098
60	Soc. Hd. Cap Screw 8-32 x 1/4	8	014546
60A	Internal Tooth Lockwasher	8	006562
61	Magazine Assembly	1	094810
62	Height Adjustment Rail	2	094819
63	Latch	1	094820
64	Roll Pin 3/32 x 3/8	1	004998
65	Spring	1	007741
66	Flexloc Thin Nut 10-32	1	091732
67	Follower Assembly	1	094813
68	Spacer, Magazine	1	094821
69	Soc. Hd. Cap Screw 10-32 x 1 1/2	1	013566
70	Washer 3/16 x 7/16 x 3/64	1	023089
71	Warning Label	1	096120



! WARNING
All parts must be periodically inspected and replaced if worn or broken. Failure to do this can affect the tool's operation and present a safety hazard.

VALVE ASSEMBLY NO. 091842



TROUBLE SHOOTING CHART

SYMPTOM	POSSIBLE CAUSE	REMEDY
1. PISTON-BLADE ASSEMBLY STAYS DOWN WHEN HOOKED TO AIR	1a Blade (Key # 25) out of proper alignment in relation to guide (Key # 47) (binding)	1a Realign guide
	1b Burred or bent driver blade (Key # 25)	1b Replace piston assembly (# 094830)
	1c Diaphragm assembly (# 091977) stuck in "up" position check "O" ring binding (Key # 7, 9 & 10)	1c Replace blade
	1d Piston (Key # 19) "O" rings (Key # 18 & 20) reversed	1c Determine which "O" ring is binding and replace (grease assembly)
2. FASTENER MISFIRE (SKIPS)	2a Feed mechanism dragging — follower (Key # 67) — negator (Key # 58)	1d Reverse "O" rings' position. Larger "O" ring coded yellow belongs on top.
	2b Negator (Key # 58) weak	2a Locate bind — correct
	2c Piston assembly (# 094830) does not return fast enough	2b Replace negator
3. PISTON WILL NOT CYCLE FAST ENOUGH	3a Blade (Key # 25) out of proper alignment in relation to guide (Key # 47) (binding)	2c Piston "O" rings (Key # 18 & 20) dry, replace or grease
	3b Piston "O" rings (Key # 18 & 20) dry and worn	3a Realign guide (Key # 57)
4. AIR LEAKING REAR OF VALVE PORT WHEN HOOKED UP	4a Valve seat (Key # 31) not sealing	3b Replace piston assembly (# 094830)
	4b "O" ring (Key # 33) cut	3b Replace piston "O" rings (Grease)
5. ERRATIC DRIVE CHARACTERISTICS	5a Diaphragm assembly (# 091977) nut (Key # 17) loose	4a Replace valve assembly
	5b Work contacting element (Key #46) bent	4a Replace seat
6. AIR HOOKUP — TRIGGERED — NO ACTION AT ALL	6a Upper valve "O" ring (Key # 33) cut or broken	4b Replace "O" ring
	7a Driver blade (Key # 25) rounded off and slipping off staple crown	5a Tighten nut
7. FASTENER WILL NOT DRIVE DOWN TIGHT	7b Too low air pressure	5b Replace work contacting element
	8a Sleeve "O" ring (Key # 38) cut or broken	6a Replace "O" ring
8. AIR LEAKING BOTTOM CASTING HOLES	8b Worn or broken lower piston "O" ring	7a Replace blade
	9a "O" ring (Key # 9) cut or broken	7b Increase to adequate air pressure
9. AIR LEAKING TOP CAP ASSEMBLY 1/16" VENT HOLE (OFF CENTER)	9b "O" ring (Key # 14) cut or broken	8a Replace "O" ring
	10a Guide (Key # 47) loose	8b Replace "O" ring
10. STAPLES JAMMING IN NOSE OF TOOL	10b Check blade tip (Key # 25)	9a Remove and replace
	11a Worn bumper (Key # 24)	9b Remove and replace
11. BLADE DRIVING TOO DEEPLY	11b Excessive air pressure in light wood	10a Tighten hold down screws (Key # 43)
	12a Missing diaphragm spring (Key # 12)	10b Replace blade
12. TOOL FIRES WHEN HOOKED UP TO AIR		11a Replace bumper
		11b Reduce air pressure
		12a Install spring (# 090495)

INSTALLATION



CAUTION

THE MAGNUM CORRUGATED FASTENER TOOL HAS BEEN DESIGNED FOR A MAXIMUM SAFE OPERATING PRESSURE OF 120 P.S.I.

Always use the minimum air pressure necessary to do the job properly.

A filter, pressure regulator and lubricator unit with gauge should be installed as close as possible to the tool. Every tool must be equipped with a male quick disconnect nipple installed at the air inlet of the tool. The nipple should be a pneumatic type which discharges the air from the tool when it is disconnected. Air lines should be a minimum of 5/16" in diameter and should be kept as short as possible. Air lines ahead of the regulator should be a minimum of 3/4".

In general, no special installation is required. If the operator is working at a bench or table, it is usually easiest to feed the air line from underneath the bench. A small tray can be fastened under the bench top to hold the tool when not in use. This same tray can also hold the staple supply.

If this tool malfunctions upon installation, do not attempt to disassemble and make repairs. Please call your Paslode representative immediately at 800-323-1303 (toll-free).

MAINTENANCE

The Magnum Corrugated Fastener Tool has been designed with ease of maintenance in mind. A few simple maintenance details will assure trouble-free operation and long tool life. Any person repairing the tool must study the Operator Safety Instructions, all maintenance instructions, and be familiar with the general parts arrangement (depicted elsewhere in this manual), prior to beginning repairs.

1. Keep lubricator filled with Paslode Pneumatic Tool Lubricating Oil (Part # 096291). Make certain that lubricator is operating in accordance with the manufacturer's recommendations.
2. Keep magazine rail and follower clean. General practice is to blow it clean daily.
3. If for any reason it is necessary to remove any moving parts, it should be lubricated with Lubriplate "Aero" grease Part # 093593 or equivalent.
4. Tool repair, if needed, should only be made with Paslode authorized parts.

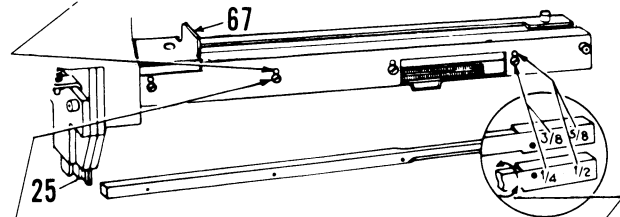
FASTENER HEIGHT ADJUSTMENT RAIL INSTRUCTIONS

NOTE: This tool is assembled at the factory with the adjustment rails positioned for 3/8" fastener use. To adjust for any other size fastener, or to adjust after parts replacement, follow the following procedure.

1. Disconnect air supply.
2. Position blade (Key # 25) down.
3. Place follower (Key # 67) in forward position.

4. Insert height adjustment rails at rear of magazine, position and secure per following instructions.
 - a. 1/4" FASTENERS — Position both rails in the lower set of magazine holes with the 1/4 designation on both rails facing the fastener window opening side of the magazine.
 - b. 3/8" FASTENERS — Position both rails in the lower set of magazine holes with the 3/8 designation on both rails facing the fastener window opening side of the magazine.
 - c. 1/2" FASTENERS — Position both rails in the upper set of magazine holes with the 1/2 designation on both rails facing the fastener window opening side of the magazine.
 - d. 5/8" FASTENERS — Position both rails in the upper set of magazine holes with the 5/8 designation on both rails facing the fastener window opening side of the magazine.

UPPER HOLES — Secure height adjustment rails (Key # 62) for 1/2" and 5/8" fasteners.



LOWER HOLES — Secure height adjustment rails (Key # 62) for 1/4" and 3/8" fasteners.

Rotate rails 180 deg. for 1/4" and 1/2" fasteners.

LOADING MAGAZINE

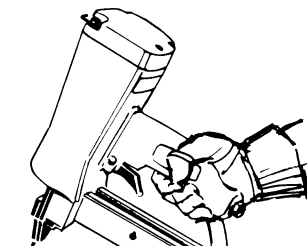
One of the finest features of the Corrugated Fastener Tool is the ease with which it may be loaded.

1. Use all fasteners in tool prior to re-loading.
2. Retract follower and insert three (3) strips of fasteners. Protrusions in fasteners must be inserted first. Yellow mark on strip must be up, ground edge down.
3. Engage follower.



CAUTION

To prevent accidental discharge of the tool, never load it with either the trigger or work contacting element depressed.



Yellow mark must be up, ground edge down.

Follower in latch position

SAFETY

All tool operators and their immediate foremen must become familiar with the Operator Safety Instructions for Paslode Heavy Duty Staplers and Nailers prior to operating the tool. These instructions are contained elsewhere in this manual.



A SIGNODE* COMPANY
TWO MARRIOTT DRIVE, LINCOLNSHIRE, ILLINOIS 60015