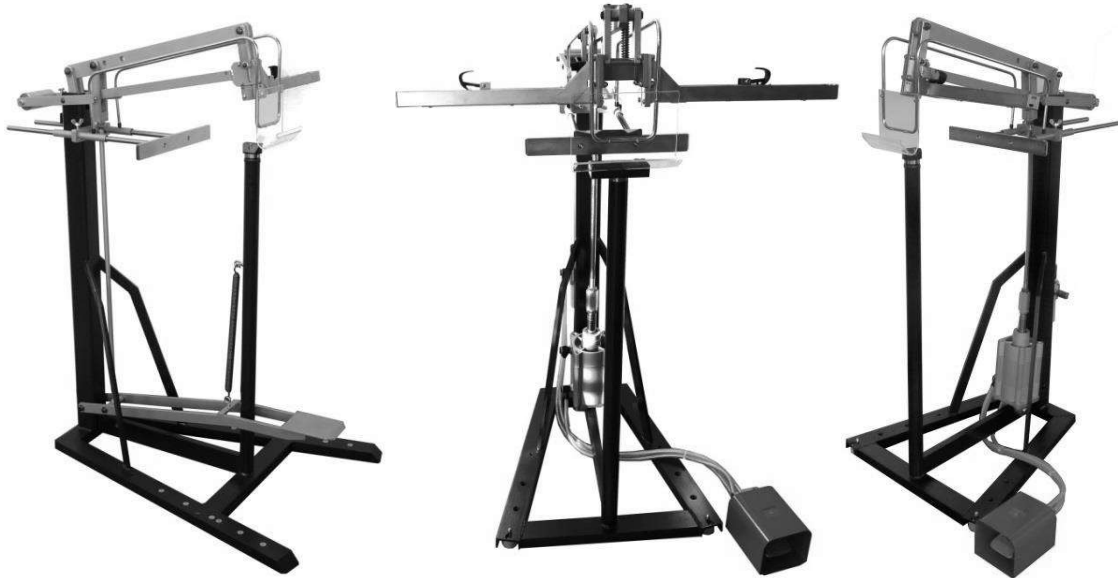


Operating instructions



Bottom stapling machine PERFECTA
Foot | Double head | Pneumatic
for closing the bottom of empty folding boxes

IMPORTANT

Before using the device for the first time, please read these instructions thoroughly and completely and keep them in a safe place.

Observe and follow the safety instructions and only use the stapler after you are sure you understand all instructions.

Failure to follow these instructions may result in injury!

If you have any questions, please contact the manufacturer,

MEZGER Heftsysteme.
Saganer Straße 24
90475 Nuremberg
Germany
+49 (0)911 984 94 0

Model

Type/Designation: **See device label**



Bottom stapling machine PERFECTA
L 323, L323 D + PEL 323, PEL 323 D
Foot | Pneumatic | Double head

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Foreword

Safe operation of the stapling device requires the knowledge provided in this **ORIGINAL OPERATING INSTRUCTIONS**. The information is presented in a concise, clear format. The chapters are arranged numerically.

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1 conformity

This stapler was built in accordance with the following European directives:

Machinery Directive 2006/42/EC

2 Safety instructions

Safety instructions and important explanations are marked with the following pictograms. The symbols used in this manual and on the stapling device have the following meaning:

symbol	Signal word	Meaning
	Warning	Warning of possible injury to persons or possible property damage Warning of possible defects or destruction of the device
	ban	Point out general prohibitions!
	Warning	Danger of crushing fingers!
	ban	Protect from moisture!

Read all of these instructions before using the stapler and keep the safety instructions in a safe place.

The operating personnel must be adequately trained in the handling of the stapling device and must have read and understood the operating instructions in full.

To avoid injuries or damage, the operator must also observe the company's internal safety regulations! In addition, we would like to refer to the further national regulations and accident prevention regulations, which are not affected by these operating instructions.



Keep untrained persons, especially children, away from your work area!

If the operator discovers damage to the stapler during production, the stapler must no longer be used and must be repaired by a specialist!

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

Only original parts may be used as spare parts!

3 Intended use

The stapler may **only** be used for its intended purpose. It must be used, operated, and maintained in accordance with the instructions in this manual.

Only use the materials and staples specified for the respective stapler, as failure to do so may result in malfunctions and damage to the stapler. The stapler may only be used for the intended purpose specified in this manual. Other applications are permitted only with the prior consent and written approval of the manufacturer.

Any other use is improper and may result in personal injury or property damage. The operator alone is liable for any resulting damage.

The operator must ensure that the stapler is operated only as intended and that all types of danger to the life and health of the user or third parties are avoided. Furthermore, compliance with accident prevention regulations and other safety rules and laws must be ensured.



If the stapler is misused for a purpose other than the specified applications, this can lead to accidents

4 Warranty and liability

In principle, our "General Terms and Conditions of Sale and Delivery" apply. These are available to the operator at the latest upon conclusion of the contract.

Warranty and liability claims for personal injury and property damage are excluded if they are due to one or more of the following causes:

- Improper use of the machine.
- Failure to observe the instructions in the operating manual regarding transport, storage, assembly, commissioning, operation, maintenance and setup of the system.
- Operating the machine with defective safety devices or with improperly installed or non-functional safety and protective devices.
- Inadequate monitoring of machine parts subject to wear and improperly performed repairs.
- Manipulation of the machine in any way.

5 Environmental conditions/emissions

The stapler should be operated at room temperature, protected from environmental influences. Use in potentially explosive atmospheres is only permitted with the prior consent and written approval of the manufacturer.

The noise emission is less than 70 dB(A).

Atmosphere foreign gases are not released during stapling

6 Operating personnel

Only trained, qualified personnel are permitted to operate the device.

Note : A person is considered to be competent if, due to their training and experience, they have sufficient knowledge in the field of staplers and are familiar with the relevant state occupational health and safety regulations, accident prevention regulations, guidelines and generally accepted rules of technology (e.g. DIN standards, VDE regulations) to such an extent that they can assess the safe condition of machines, in particular staplers.

7 Transport and initial commissioning

Before operating the stapler, please read all instructions in this manual. This stapler may only be operated by **trained personnel**.

The stapler is delivered fully assembled and can be transported as a complete unit. Transport equipment, for example, can also be used for transportation.

To make the stapler ready for use after delivery, the following tasks must be carried out:

- Check equipment for completeness
- Load stapler with staples
- Connect compressed air

The air pressure is 4 - 6 bar overpressure.

It is necessary to install a filter regulator consisting of a filter, water separator and pressure reducer.

A hose with a clear diameter of 6 mm is required as the connecting hose.



Oxygen or flammable gases must not be used as an energy source for compressed air-powered devices.

8 Basics of working technique and handling

Before using the stapler, the operator must inform himself about the specific application and check whether the stapler is suitable for it.

Please follow all safety instructions carefully!



Make sure that the stapler is undamaged and can be operated safely!

The safe operational condition of the stapler must be checked before starting work and on an ongoing basis!

Safety devices must not be bypassed or rendered ineffective!

Keep your work area tidy.

Clutter in the work area can lead to accidents.

- Use only genuine staples, which are specifically manufactured for these high-quality machines. Using staples from other manufacturers can cause malfunctions and significant damage.
- Never staple without a stapled item. Do not remove the stapler until the stapling process is complete.
- Do not staple to a hard surface.
- If a stapling malfunction occurs, correct it immediately and do not trigger further stapling
- Turn off the stapler after use

9 Decommissioning

If the stapler is not used for a long period of time, the compressed air supply must be disconnected and the staples removed.

10 Maintenance and care



ATTENTION! The compressed air supply must be disconnected before any maintenance.



Any type of modification to the stapler (e.g. drilling holes) is only permitted with the prior consent and written approval of the manufacturer!
Manipulation of the safety device(s) is prohibited!

Dangers from pneumatic energy



Caution

Only personnel with special knowledge and experience in pneumatics may work on pneumatic equipment.
Depressurize any system sections and hose connections that are to be opened before starting repair work .
 pneumatic hose lines at appropriate intervals (5 years), even if no safety-relevant defects are apparent.
 Check pneumatic lines for chafing/damage.
 If necessary, replace damaged hoses and hose connections and eliminate the possibility of chafing.

Operator or qualified personnel must check and clean them regularly.

Test area	Activity / Examination	T	W	M	J	Area
Machine area and environment	clean		•			Entire machine
All protective measures in place/closed	check	•				Safety devices
Stitching unit	clean / check		•			Staple area
Stitching unit moving parts	maintenance				J	
Insertion area	clean / check		•			Pneumatics
Pneumatic hoses, leaks, damage	check		•			
Filter regulator, condensate	check			•		
Screw connections for tight fit	check			•		
sintered filter (if dirty)	change				•	Lubrication
Stitching unit moving parts (driver, spring guide)	Clean and lightly oil		•			
Other moving parts	Clean and lightly oil		•			

D = daily / W = weekly / M = monthly (6M = every 6 months) / Y = annually

The stapler is easy to maintain, but should be cleaned and serviced regularly. Any dirt should be removed directly by the operator after each use.

Proper care will help keep your stapler in top working order over time. The stapler should be thoroughly cleaned at least once a week.

- No aggressive cleaning agents or solvents (which will damage seals) or even sandpaper may be used for cleaning.

- Cleaning with compressed air should also be avoided, as this will cause dirt particles to enter the sealing areas and damage them.
- Do not use fluffy cleaning wool for cleaning.

The following work/inspections should be carried out regularly by qualified personnel:

- Regularly oil the moving parts (no graphite oil!) (weekly)
- Check the filter regulator for condensation. If necessary, remove the condensation.

Only genuine spare parts may be used. (See "Spare Parts List")
Failure to comply will result in the exclusion of any warranty claim or liability!

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

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

11 Description

11.1 Area of application/purpose

The stapler may only be used for the following purposes:
 for stapling solid, single and double corrugated cardboard

Do not staple into hard (e.g. metal plates, nails, etc.) or brittle materials.
 This may damage the stapler.

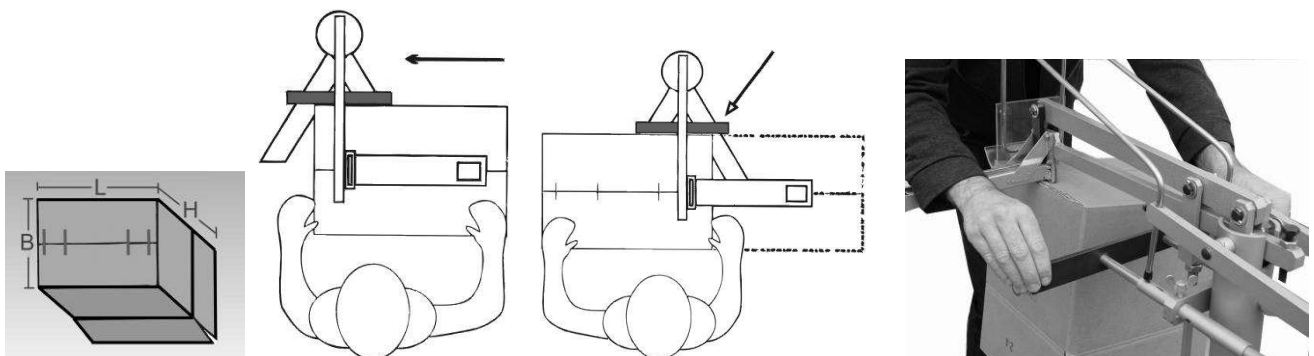


11.2 function

The PERFECTA stapler is designed for bottom stapling empty folding boxes. The side-mounted stapling units with a large staple magazine and an adjustable carton guide stop enable precise stapling over the box slot.

Even very long boxes can be stapled effortlessly, as they don't need to be turned over or the operator's position changed. This allows for extremely ergonomic work.

Kartonführungsanschlag



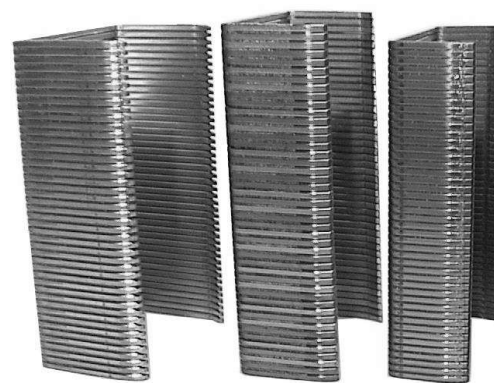
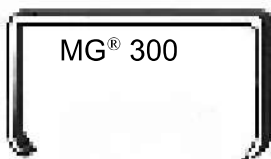
11.3 Staples and type of stapling

The following staples are used for the different cardboard qualities:

Unit 300

Variety	Wire width	Leg length	suitable for cardboard
MG [®] 315	1.5 mm	15 mm	Single-wall corrugated cardboard
MG [®] 320	1.5 mm	20 mm	Double corrugated cardboard
MG [®] 323 NK	1.5 mm	23 mm	strong double corrugated cardboard

Use only ORIGINAL MG[®] 300 staples!
Foreign staples can cause significant disruption and cause damage.
Guarantee or warranty claims can will then not be recognized.



11.4 Inserting the staples

1. Pull back the transport shoe and hook it in .
2. Insert staple strips (up to 4 pieces).
3. Unhook the transport shoe and return it to the pressure position

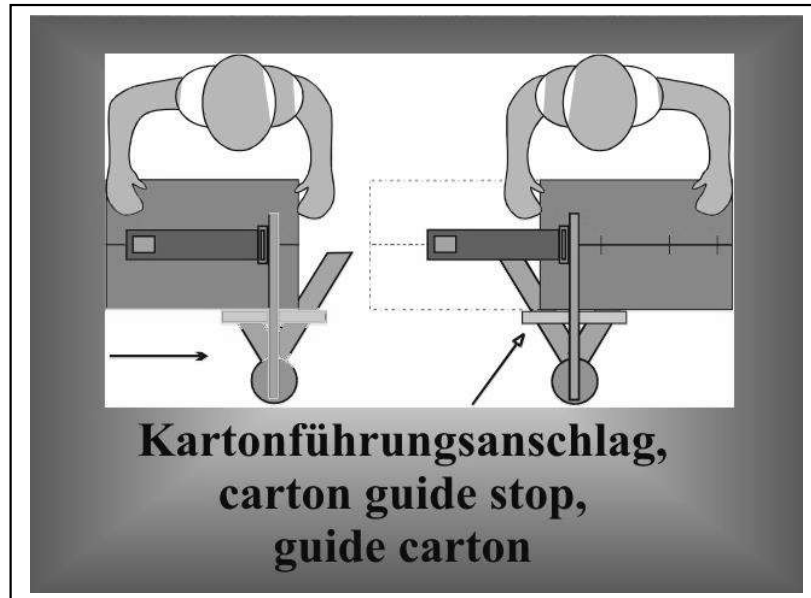


Hold the transport shoe firmly so that it does not shoot forward.



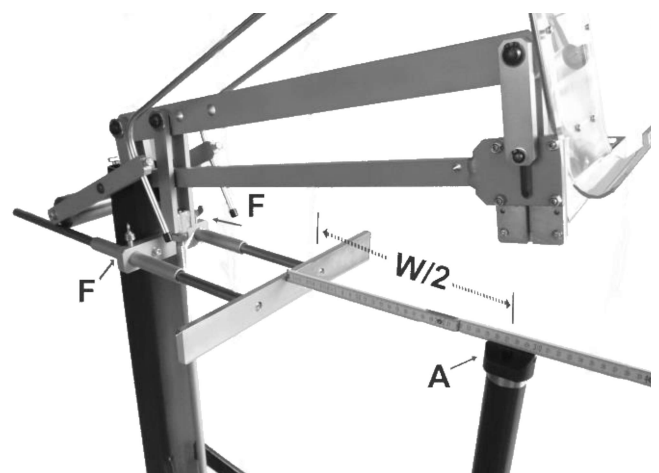
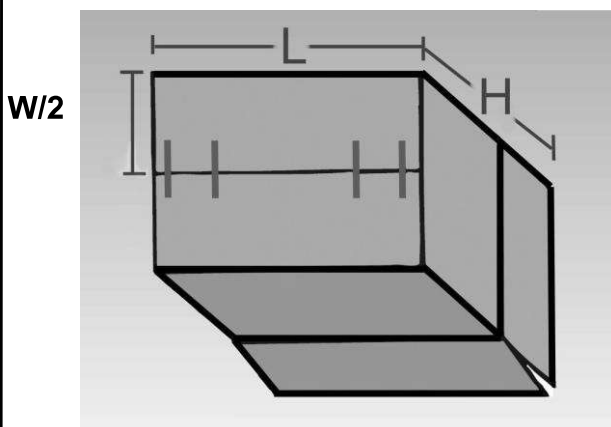
11.5 Carton guide stop

The carton guide stop can be adjusted to the carton.
To do this, loosen the two wing screws. Insert the cardboard.
Push the cardboard stop against the cardboard and tighten the wing screws again.



11.6 Slipping over the folding box and stapling

The carton stop is set to half the width ($W/2$ = to the center of the carton/center of anvil **A**) of the carton. To do this, open the two wing screws (**F**), **slide the stop into position**, and retighten the wing screws (**F**).



When stapling, make sure that the inner cross flap is also included.

When moving the folding box, lift it slightly and push it against the carton guide stop. The adjusted carton guide stop eliminates any need for aiming when stapling additional folding boxes of the same width.

The first stitching is best done about 1 cm from the edge of the cardboard.

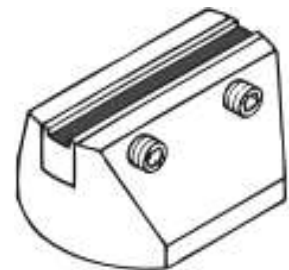
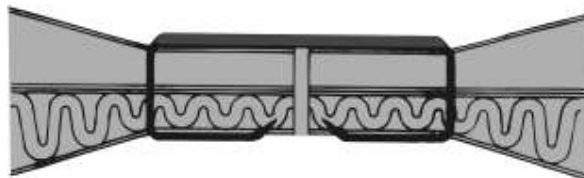
It saves a lot of energy if the foot pedal only rises enough after each stapling to allow the folding box to be moved comfortably. The spring pressure is designed so that when the thigh muscles are relaxed, the foot pedal rises automatically.

For recurring folding box sizes of the same size, we recommend that you use the carton stop to be marked accordingly (e.g. color marking or notching).

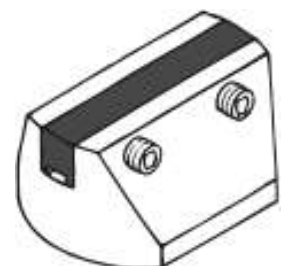
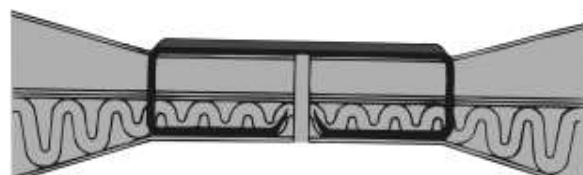
11.7 Exchange anvils

When the stapler is delivered, the stapling anvil is configured for "through-stapling." Optionally, the stapling anvil can be reversed for "blind stapling." Simply loosen the two screws on the stapling anvil and turn it over.

Through-stapling - The stapling anvil has a groove that allows the staple to bend outside the cardboard. The staple legs fit tightly, with the tips recessed into the cardboard.



Blind stitching (only with interchangeable anvil) – Staple anvil smooth surface - the staple bends within the bottom layer of cardboard, i.e. it is sunk into the cardboard.



11.8 Connecting the machine

The filter regulator is factory-set to an air pressure of approximately 6 bar overpressure.

The **required operating pressure is 4-6 bar overpressure** , depending on the board hardness and thickness . It only needs to be set high enough so that the upper arm automatically returns to its original position after stapling.

11.9 Operating the machine

Place the pre-folded cardboard over the stapling column so that either the right or left side of the cardboard rests against the stapling column. Make sure the inner flap of the cardboard is positioned over the stapling anvil.

On the PEL 323, the foot valve is activated and a stapling operation is performed. After releasing the foot valve, the stapling arm automatically returns to its original position, provided the operating pressure (4 - 6 bar) is not too low.

The machine is factory-set to staple all standard cardboard, regardless of thickness, with optimal stapling pressure at an air pressure of 4-6 bar. However, for extremely hard and thick cardboard, it is possible to use a higher stapling pressure by adjusting the lower switching ring. This adjustment may only be performed by the manufacturer!

11.10 Adjusting the foot pedal



For foot pedal only:

If the distance between the stapling anvil and the stapling unit proves to be too small for the folding box to be pulled over, this distance can be changed by turning the stop screw attached to the rear end of the forearm.

NOT PERMITTED FOR PNEUMATIC STAPLER !

Please send these in if necessary.

11.11 Compressed air connection

A filter regulator consisting of a filter, water separator, and pressure reducer must be installed upstream (see filter regulator operating instructions).

A hose with a clear diameter of 6 mm is required for the connection hose. A self-closing hose coupling is included as standard on the maintenance unit. For long hose lines, we recommend using a hose with a clear diameter of 9 mm. The hose nozzle must, of course, be replaced in this case.

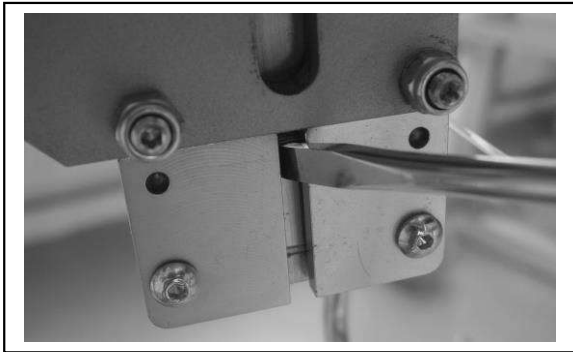


ATTENTION! When the compressed air is switched on, the stapling head moves to the home position

11.12 Removing jammed staples

If there is a fault or clamps are jammed, proceed as follows:

- For pneumatic staplers, remove the supply air.
- Remove **all** clamps from the device and clean any debris and dirt. Reconnect the air supply.



If a staple becomes jammed in the exit channel of the stapling unit, you can use a tool to push it out downwards through the slot. If that doesn't work, simply unscrew a front panel and remove the staple. Then reinsert the staple and screw it tight.



If the upper arm won't separate from the forearm because a staple has jammed in the stapling unit, do not push the stapling unit and thus the forearm downward. This will lead to deformation and ultimately breakage of the head plate. Instead, clamp a piece of wood (e.g., a hammer handle) between the upper and forearm and force them apart.

11.13 Safety devices on the machine

Makrolon protection, to cover the stapling area.

Any kind of manipulation of the machines is prohibited .



Before operating the machine independently, operating personnel must be instructed in its operation by qualified personnel. Operator safety must be given priority. The instructor may only hand over the machine to persons who have understood all safety instructions.

11.14 Technical data/ variants

Technical data	L 323	L 323 D	PEL 323	PEL 323 D
Type of machine	Single-head	Doppelkopf	Single-head	Doppelkopf
drive	Foot control	Foot control	Pneumatic	Pneumatic
Distance between stitching units mm	---	90 (70, 50*)	---	90 (70, 50*)
Operating pressure:	---	---	4 - 6 bar	4 - 6 bar
Air consumption/stapling	---	---	3.7 - 4.3 NL	4.3 NL
Staple series / Capacity	MG ®300	MG ®300	MG ®300	MG ®300
Staples/Aggregate	180	180 (360)	180	180 (360)
largest box height including 1 flap mm*	800	800	950	950
Box width mm, approx.	800	800	750	750
Machine dimensions				
Width mm, approx.	700	850	700	850
Depth mm, approx.	1000	1000	1000	1000
Height mm, approx.	1400	1400	1400	1400
Weight kg, approx.	66	71	57	62
Noise emissions	< 70 dB(A)			
Gas emissions	Non-atmospheric gases are not released when stapling with compressed air.			

*Each stapler can be custom-made with a higher column
 Subject to technical changes.

12 Error detection



In the event of any malfunction, shut down the stapler and disconnect it from the compressed air supply until proper operation is restored. Please do not attempt to disassemble or repair the stapler.



In the event of a problem that goes beyond jammed staples, please contact us. Our specialists will carefully examine the stapler and resolve the issue.

Remove **all** staples from the stapler and clean the stapler.

- Remove any visible staples in the staple exit opening using a suitable tool. Do not overload or damage the device! In difficult cases, open the magazine and pull the staples out upwards. Ensure that the staple exit opening is not damaged.
- Replace damaged or worn stapler.
- Reconnect compressed air
- Make sure the air pressure is set correctly

Disturbance	Caused	remedy
No pressure display	Shut-off valve closed.	Open the shut-off valve.
	Pressure not set.	Adjust pressure using pressure adjustment knob.
	Pressure gauge defective.	Replace pressure gauge.
Low flow (when air is consumed, the operating pressure collapses)	Filter cartridge is dirty.	Replace filter cartridge.
	Narrowing between main tap and filter regulator	Check the cables.
Pressure rises above set operating pressure	Valve disc at the sealing seat defective.	Contact manufacturer
Audible blowing at the adjustment knob	Valve seat defective.	Contact manufacturer
Audible blowing at the drain plug	Drain plug leaking.	Tighten or replace.
Delivery movement not guaranteed.	Air pressure too low.	When stapling, 4 - 6 bar overpressure. Check hoses and valves for sufficient air supply.
Air purity inadequate	compressed air	a filter regulator , consisting of a pressure reducer and a water separator.
Staple is jammed in the stapling head and is not pre-formed.	compressed air	Air pressure too low. Stapler operated too quickly.

13 Reference to residual risks



When the stapler is in operation, do not reach into the stapling area or the staple exit opening! Danger OF INJURY !



**Protect the stapler from moisture!
 Do not operate in wet or humid environments! Operate only indoors!**



- Always check the device for defective, incorrectly connected or worn parts before use.
- Compressed air connections must be checked regularly.
- When working on the compressed air connections and hoses, the stapler must be depressurized.
- When working on the device, wear protective equipment:
 + cut-resistant gloves that provide a suitable feel and safe operation of the trigger and all adjustment devices
 + appropriate safety goggles
- Never point the stapler at yourself or other people
- Keep your fingers away from the trigger when not using this device and when moving from one working position to another.
- Keep all body parts such as hands, legs, etc. away from the staple exit opening and ensure that the driving object cannot penetrate any part of the body.

- **When using the tool, be aware that the driving object may ricochet and cause injury.**
- **Hold the tool firmly and prepare for the driving process.**
- **Be careful when handling driving tools, especially when loading and unloading, as the driving tools have sharp points that could cause injury.**
- **Do not lean too far forward. Use only in a safe work area. Always maintain a firm footing and balance.**
- **Keep third parties away (if you're working in an area where people are likely to pass through). Clearly mark your work area.**
- **Wear cut-resistant gloves that provide a suitable feel and safe operation of the trigger and all adjustment devices, and appropriate safety goggles.**
- **During operation, ensure that the driving tools always penetrate the material correctly and are not deflected or misplaced towards the user and/or third parties.**
- **During operation, fragments may be ejected from the workpiece or from the fastening or magazine system.**
- **The risk to others must be assessed by the user.**
- **Be careful with devices that do not contact the workpiece, as they may accidentally trigger and injure the user and/or third parties.**
- **Make sure that the device is always securely seated on the workpiece and cannot slip away**
- **Take a firm stance and always keep your balance.**
- **Slips, trips, and falls are the main causes of workplace accidents. Attention must be paid to slippery surfaces caused by the use of the equipment, as well as tripping hazards caused by the air hose.**
- **Extra caution should be exercised in unfamiliar surroundings. There may be hidden hazards, such as electrical wires or other utility lines.**
- **This device is not intended for use in potentially explosive atmospheres and is not insulated against contact with electrical energy.**
- **It must be ensured that there are no electrical cables, gas pipes, etc. that could cause a hazard if they are damaged by the device**
- **Compressed air can cause serious injuries.**
- **Always close the air supply and disconnect the device from the air supply when not in use.**
- **Always disconnect the tool from the compressed air supply before changing accessories, making adjustments and/or repairs, and when moving from one work area to another.**
- **Whipping hoses can cause serious injury. Always check for damaged or loose hoses or connections.**
- **Never carry an air-powered device by its hose.**
- **Never pull an air-powered device by its hose.**
- **Do not exceed the maximum operating pressure when using compressed air-powered devices.**
- **Compressed air-powered devices should only be operated with compressed air at the lowest possible pressure for the work process in order to reduce noise and vibration and to minimize wear.**



Bottom stapling machine PERFECTA
L 323, L323 D + PEL 323, PEL 323 D
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- Hold the device with a light and secure grip, as the risk of vibration is greater when the gripping force is higher.

14 Technical documents/service

Repairs by:
MEZGER Heftsysteme GmbH
or
authorized specialist companies

Damage resulting in particular from natural wear and tear, overloading, improper handling or damage caused by the user or other use contrary to the operating instructions are excluded from the warranty. Keep the operating instructions, safety instructions, spare parts list and receipt in a safe place.

MEZGER Heftsysteme GmbH

Staples, staplers and stapling machines

Saganer Straße 24, 90475 Nuremberg
Phone: 0049 (0)911 / 984 94 0 Email:
info@mezger.eu

14.1 Spare parts list

see separate spare parts list