

*STRONG
TIGHT
CORNERS*



MitreNailerTM

A Division of Active Sales Co Inc.

Operating Instructions



Model:

Double Shooter

Thank you for purchasing a MitreNailer® Corner Joining machine. With the proper care and operation outlined in this manual, it will provide years of trouble free operation.

The **Double Shooter** is shipped with the following:

ACCESSORIES:

- 1 round hold down post
- Hold down pads
 - 1 triangle with black pad (for hard woods)
 - 1 small chevron with black pad (for hard woods)
 - 1 Triangle with orange pad (for soft woods)
- Magnet for removing Fasteners
- Allen Wrenches
 - 1 each 7/64"
 - 1 each 1/4"
 - 1 each 9/16"
 - 1 each 5/32"
 - 1 each 3/16"

SPECIFICATIONS:

<u>Molding</u>	<u>Min.</u>	<u>Max.</u>
Width	1/2"	3 1/2"
Height	3/8"	3 1/2"
Frame Dimensions:		
W/ frontal clamps	4" x 5"	unlimited
W/O frontal clamps	3" x 5"	unlimited
# of fastener positions	1	2 (4 w/Multi Shooter option)
# fasteners per position	1	1
Spacing between shots	1/16"	3 1/4"
Operating Pressure	70 # psi	100 # psi

<u>DIMENSIONS (max.)</u>	<u>Bench Model</u>	<u>Floor Model</u>
Depth	20"	38"
Width	12"	18 1/2"
Height	38"	68"
Weight	120 lbs.	170 lbs.

OPTIONS:

- Inserts for 6 sided and 8 sided frames.
- Multi Shooter - allows fastener placement in up to 4 different positions.
- Custom Rabet clamps for unique molding profiles.

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<u>Molding</u>	<u>Min.</u>	<u>Max.</u>
Width	1/2"	4 1/4"
Height	3/8"	3 1/2"
Frame Dimensions:		
W/ frontal clamps	4" x 5"	unlimited
W/O frontal clamps	3" x 5"	unlimited
# of fastener positions	1	2 (4 w/Multi Shooter option)
# fasteners per position	1	1 (3 w/electronic control opt)
Spacing between shots	1/16"	4 3/4"
Operating Pressure	70 # psi	100 # psi

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OPTIONS:

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- Multi Shooter - allows fastener placement in up to 4 different positions.
- Custom Rabet clamps for unique molding profiles.
- Electronic Controller allows stacking up to 3 fasteners in first and last position

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Active Sales Company, Inc.(Active) warrants that newly purchased MitreNailer® machines will be free from defects in material and workmanship for a period of six (6) months after the date of its delivery to the original user's place of business. Active's sole liability hereunder will be to replace any part (except normal wearing parts) which proves to be defective within such period. Active reserves the right at its sole discretion to replace or repair any tool proven to contain a defect with a rebuilt tool of the same model if in Active's judgment such replacement is appropriate to efficiently cure the defect. Any rebuilt tool provided to the 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 MiterNailer replacement parts, damaged in transit or handling or which in Active's opinion has been altered or repaired in a way that affects or detracts from the performance of the tool.

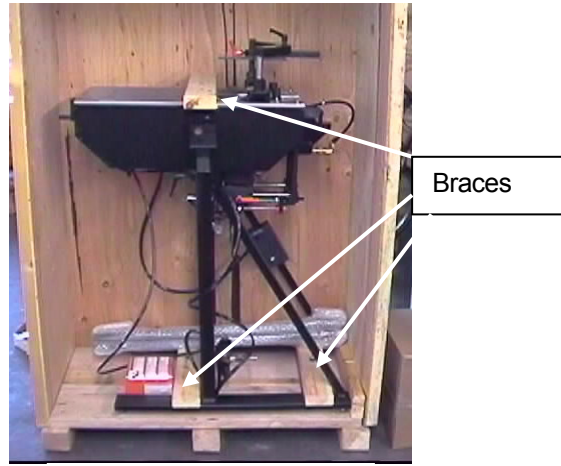
ACTIVE MAKES NO WARRANTY, EXPRESS OR IMPLIED, RELATING TO MERCHANTABILITY, FITNESS OR OTHERWISE EXCEPT AS STATED ABOVE and Active's liability as assumed above is in lieu of all others arising out of or in connection with the use and performance of the tool. ACTIVE SHALL IN NO EVENT BE LIABLE FOR ANY 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.

1. **Always** wear eye protection as well as hearing protection when operating this equipment.
2. **Never** remove factory installed shields.
3. **Always** use a grounded electrical plug for machines and accessories requiring electricity.
4. **Always** use clean, dry air. Do not use bottled air or gases.
5. **Always** disconnect air supply and electricity before attempting repairs, maintenance or attaching accessories.
6. **Never** assume the tool is empty of fasteners. Check the magazine before performing maintenance or testing the machine.
7. **Never** operate the machine without material to be joined in place. **Hands and fingers can be severely injured.**
8. **Never** leave machine unattended for an extended period of time without disconnecting air supply to tool.
9. **Never** allow air pressure to exceed 120 psi. Use the least amount of pressure required to fully drive the fastener. Excess pressure causes premature wear.
10. **Never** operate a dirty tool or machine or one that has worn parts. Clean and inspect daily. Replace worn parts promptly.
11. **Never** remove factory-installed foot pedal guard.
12. **Always** use parts and fasteners specifically designed and recommended by MitreNailer.
13. **Always use common sense and alertness when operating the machine.**
14. **Be** sure that all operators are familiar with the operation of this machine before attempting to operate the machine without supervision.

Unpacking & Initial Setup

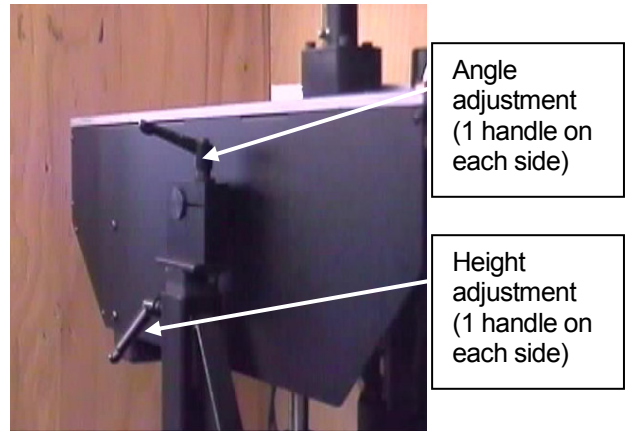
WARNING: Read all safety instructions thoroughly before attempting to operate this machine.

1. Open crate, remove all bolts & braces securing machine to crate

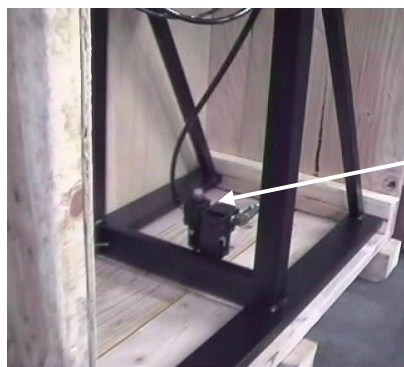


(Stand model Shown)

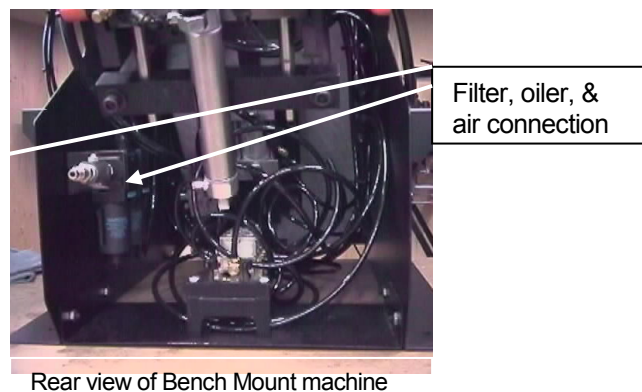
2. Remove the machine from the crate. If your machine is a benchtop model, set it on a work table. If your machine is a stand model, adjust the height and angle of machine to operator's comfort by loosening the adjustment handles, adjusting the machine, and re-tightening the adjustment handles. Note: The stand is equipped with gas struts to make height adjustment easier. Set the foot pedal on the floor near the front of the machine.



3. Check the oil level through the view window (you may need a flashlight). Oil should be at least

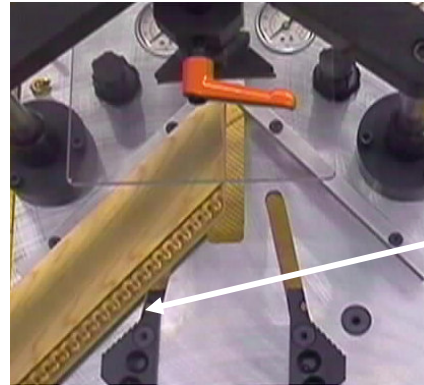


1/3 up the bowl. See maintenance section for instructions on adding oil. Set the proper oil flow rate by closing the flow adjustment knob on top of the oiler completely and then opening it 1/4 turn. Plug in air hose to air connection. Line pressure should be between 90 & 110 lbs. psi.



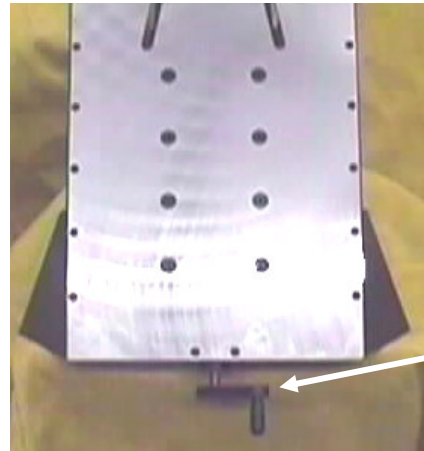
Jaws Adjustment

1. Slide one (1) piece of molding into place along left fence until it touches the right side fence.



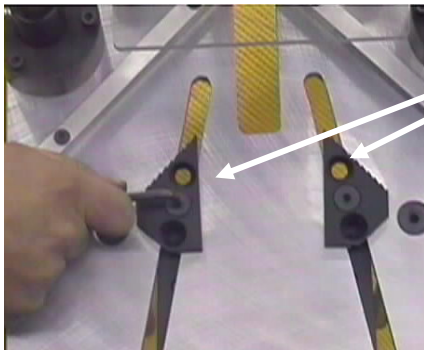
1/2"
between
jaws and
rabet.

2. Rotate the Jaw Crank Handle until the jaws are approximately 1/2" away from the inside of the rabet.



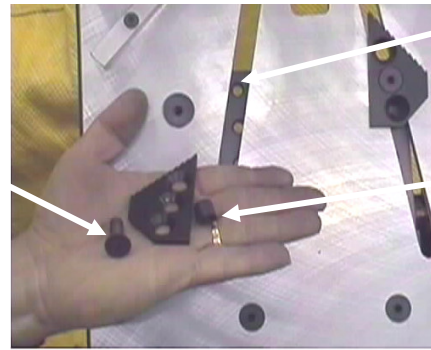
Jaw
Crank
Handle

3. If the molding is too narrow or wide for the current jaw setting, the jaws can be moved to a different hole in either the Jaw Extension Arm, or Jaw itself. Simply remove the Mounting Screw and re-mount in a different hole. (Be careful not to lose the Spacer).



Jaws

Mounting
Screw



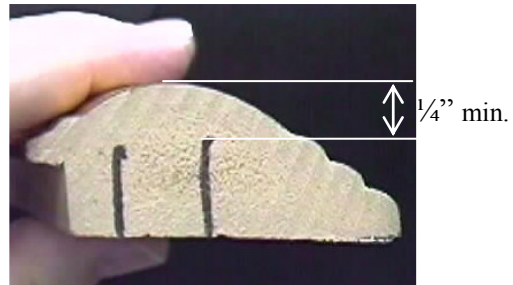
Jaw
Extension
Arm

Spacer

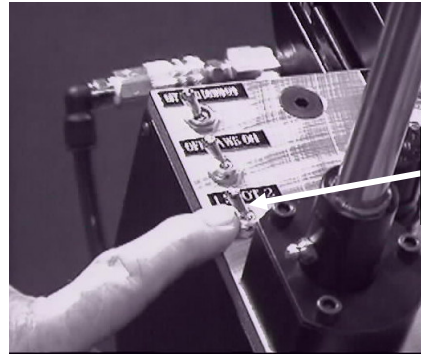
Shot Selection and Spacing

1. Determine Fastener size.

Tip: The fastener should not reach closer than ¼” of the top of the molding. (See “Changing Fastener Size” section for instructions on how to change fastener sizes.)

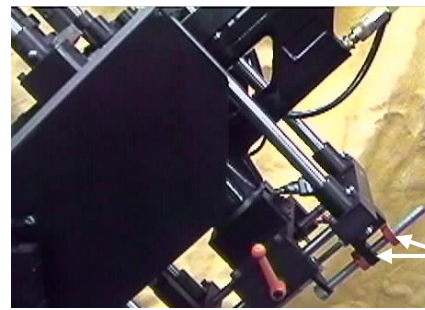


2. Select number of shot positions (1 or 2) using the Shot Selection Switch.



Shot Selection Switch

3. Loosen the set screws on the two (2) orange Tool Stop Collars until they spin freely.

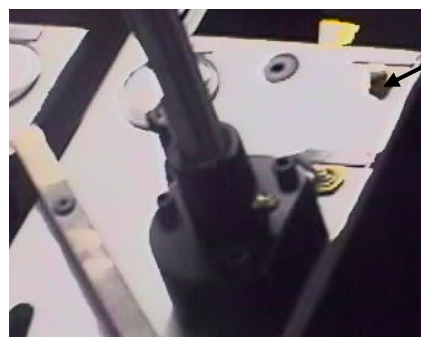


Tool Stop Collars

4. Slide one (1) piece of molding along the left fence until it stops against the right fence.



5. Using the Spacing Button to preview the stop positions, turn the orange Stop Collars (step 3) until desired fastener positions are set. **Caution:** Keep fingers clear of the nose of the tool and the Stop collars – Pinching Hazard.



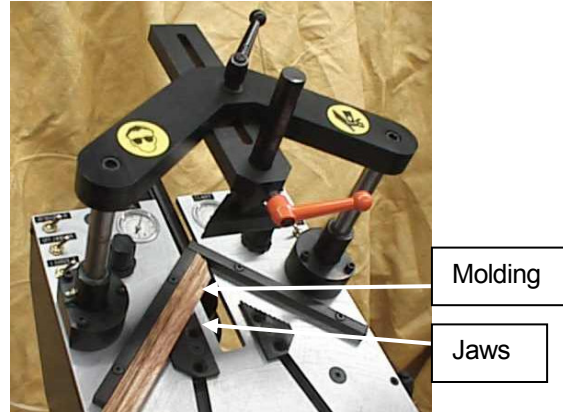
Spacing Button

6. Tighten the set screws on the Tool Stop Collars (see step 3).

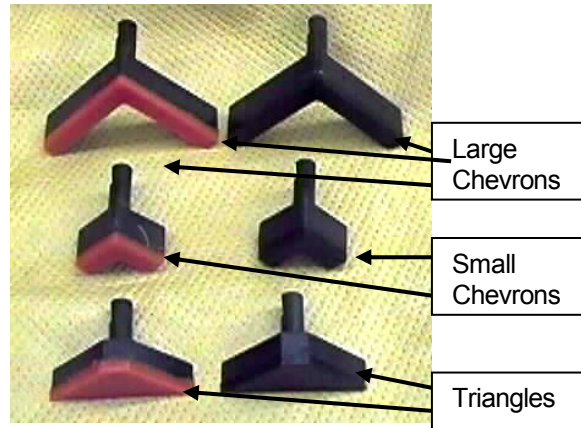
Holddown Adjustment

The holddown should be adjusted to allow enough pressure to prevent the molding from rising up when fasteners are driven, **but not so much as to open the bottom of the joint.**

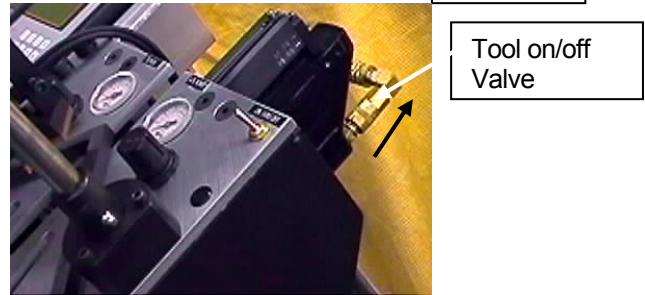
1. Slide left Molding along left fence until it touches right hand fence, Adjust jaws with Crank Handle until they lightly hold the molding in place. (See page 4.1 for instructions on adjusting the jaws.)



2. Select Holddown Pad type. Triangle for flat profiles, chevron(s) for highly contoured profiles. Orange Holddown Pads for soft woods, black for Hard woods. Mount selected Holddown on to Holddown Post using allen screw on the side of the Holddown Post. (see step 4).



3. Turn the tool's air supply OFF by sliding the Tool on/off Valve away from tool.

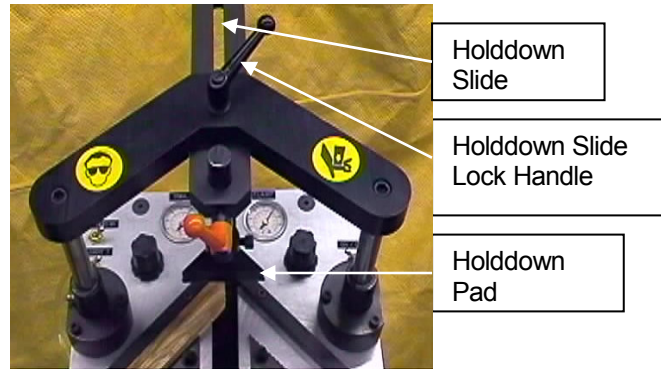


4. Be sure the Holddown switch is in the "on" position. The Jaws switch should be in the "off" position. The Shot selection switch should be set on "1".

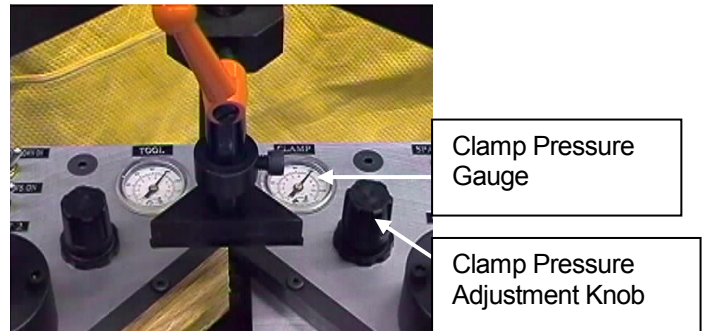


Holddown Adjustment (cont'd.)

5. Loosen Holddown Slide Lock Handle and move Holddown Slide until Holddown Pad is directly over area of molding where fasteners will be driven. If fasteners are spaced wider than the width of the Holddown Pad, center the Holddown Pad between fastener positions or use optional second Holddown Bar. (See Options page item A10).

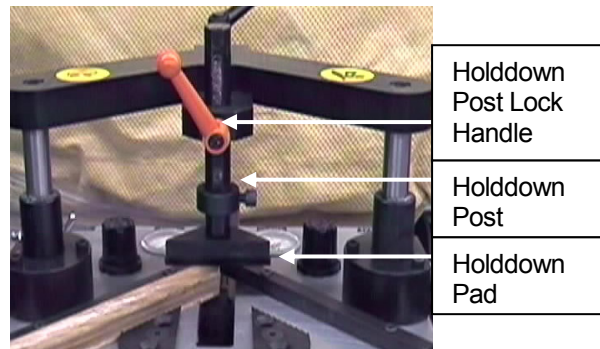


6. Loosen the Clamp Pressure Adjustment knob until Clamp Pressure Gauge shows 10 to 20 lbs. (note: Pull up on knob to unlock before loosening).



7. Loosen the Holddown Post Lock Handle and slide the Holddown Post all the way up.

8. Press and hold the foot pedal. This will cause the Holddown assembly to come down on the molding. With the Holddown in the fully down position, slide the Holddown Post until the Holddown Pad rests on the molding. Tighten the Holddown Post Lock Handle. Release the foot pedal.



9. Return Clamp pressure to normal (80 – 90 lbs psi) by tightening the Clamp Pressure adjustment knob. (See step 6). **NOTE:** Adjusting the Holddown with low pressure assures the corner will be held in place, but not distorted when the operating pressure is restored to normal.

10. Restore air supply to the tool by sliding the Tool on/off Valve toward the tool. (See step 3)

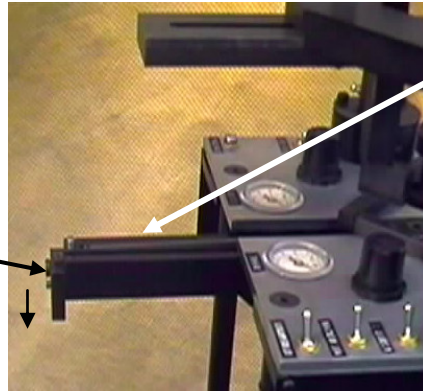
11. Set the Jaws Switch to the “on” position. Set the Shot Selection Switch to the desired number of positions. (See step 4).

12. Loosen Jaws using hand crank and remove molding. (See step 1).

Loading Fasteners

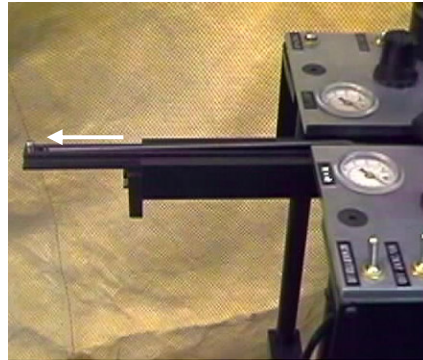
1. Release spring loaded Magazine Cover Latch by sliding it down, or away from the magazine cover.

Magazine
Cover Latch



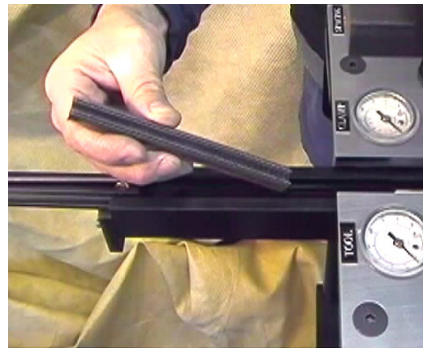
Magazine
Cover

2. Slide the Magazine Cover fully open.

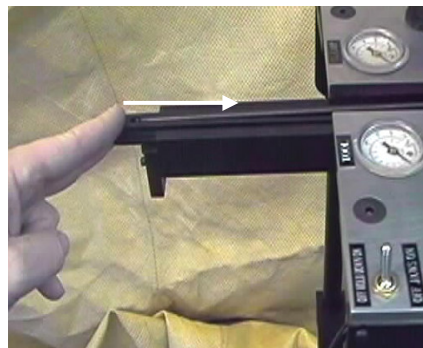


3. Load Fasteners . (See Fastener Orientation section on page 5.4 for proper fastener orientation.)

IMPORTANT! Be sure to load the fastener size for which the tool is setup (ie: 1/4", 3/8", 1/2", or 5/8"). Loading the wrong size fastener will cause the tool to jam.



4. Slide the Magazine Cover closed until it latches.



Changing Fastener Size

NOTE: These instructions apply to MitreNailer® Micro-corrugated, L-Nail, & “V”-fastener tools. Other tools change sizes in a similar, but not identical fashion

1. Open magazine cover and remove any fasteners from magazine. (Use magnet supplied with machine).

2. Loosen the 2 Latch Plate screws using a 7/64” Allen wrench.

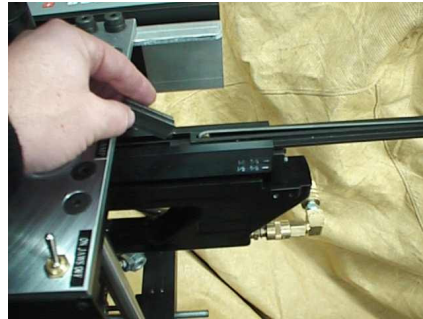
3. Remove Latch Plate by sliding loosened Plate up until Keyholes in plate align with screw heads.

Keyholes

4. Slide Fastener Support Bar out from Magazine.

5. Orient the Fastener Support Bar so the size you will be using is facing up and towards the front of the tool.

6. Slide the Fastener Support Bar into the Magazine Rail slot corresponding to the new size.



Latch Plate
Screws (2)

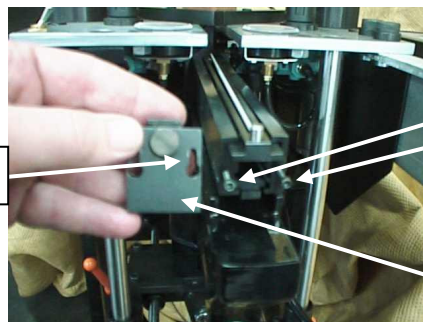
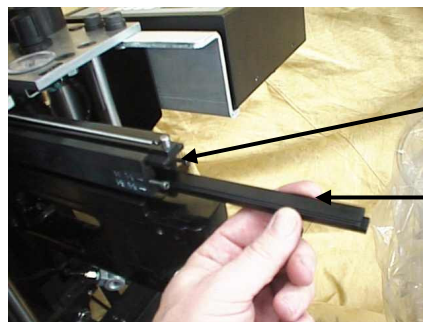


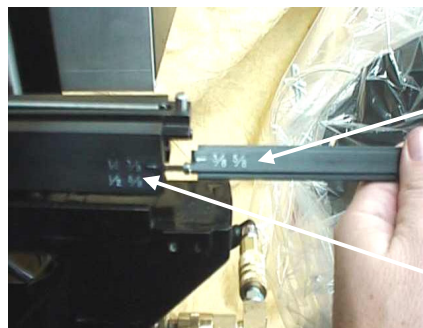
Plate screws

Latch Plate
(removed)



Magazine

Fastener
Support Bar



Fastener
Support Bar
Size Indicator

Magazine Rail
Slot indicator

Changing Fastener Size (cont'd.)

7. Slide the Latch Plate in place and tighten both screws by reversing the procedure in Step 3.
8. Load the new size Fasteners in the magazine of the tool. (See “Loading Fasteners” section on page 5.1 for a more detailed explanation.)

Changing Fastener Types

Because of the variety of materials being used to make molding, no single fastener can meet every need. That's why all MitreNailer machines can drive several different types of fasteners.

“V” Fasteners – For soft woods plastics, and very delicate moldings. Driven with a “press” type tool. Available in 7, 10, 12, & 15 mm heights, All heights available in hardwood or regular.



L-Nails – “V” shaped fastener made from stronger material for soft or hard woods and thin moldings. Driven with a “velocity” tool. Powerful enough to drive into the hardest of woods. Available in 5/16”, 7/16”, & 9/16” heights. Specify hardwood or regular.



Micro Corrugated – For strong, tight corners in harder woods and MDF. Angled “flutes” actually draw miscut molding together and create a corner with exceptional strength. Available in 1/4”, 3/8”, 1/2”, & 5/8” heights. Specify hardwood or regular



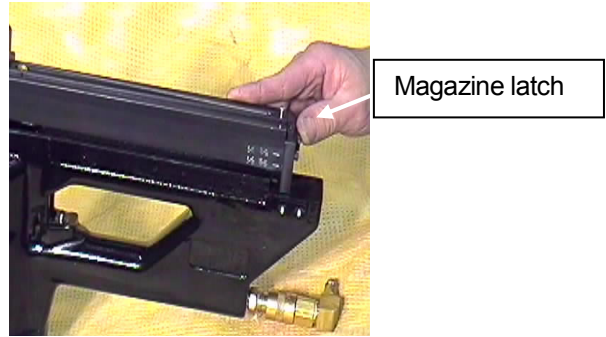
Mini-Corrugated – For Mirrors and other heavy, large frames and extra wide molding where joint strength is of paramount importance. Available in 1/4”, 3/8”, & 1/2” heights.



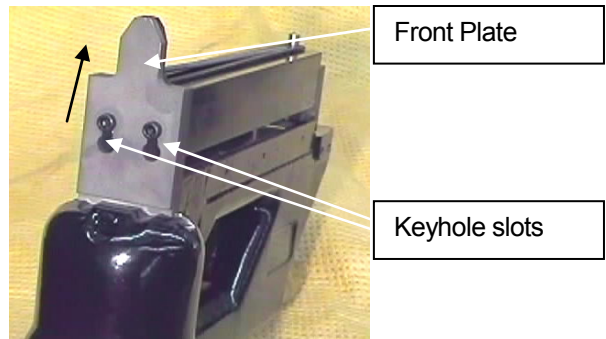
Clearing a Jammed Fastener

NOTE: These instructions apply to MitreNailer® Mico-Corrugated, L-Nail, & V-fastener tools. Other tools are unjammed in a similar, but not identical fashion.

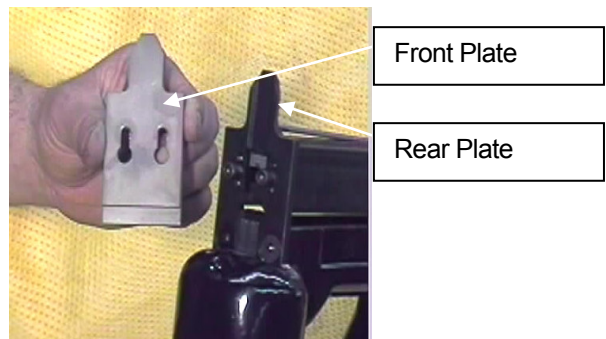
1. Disconnect Air Supply from machine.
2. Remove tool from machine. (See “Changing Fastener Types” section on page 5.6 for step by step instructions).
3. Unlatch magazine and remove fasteners. Clear any misfed fasteners from the magazine.



4. Loosen tool Front Plate screws. Then slide the front plate up until the oversized Keyhole Slots line up with the screw heads.
NOTE: A screwdriver may be needed to free the front plate after loosening the screws due to pressure caused by a jammed fastener.



5. Remove the Front Plate by pulling it out over the screw heads. Clear any jammed fasteners found in the front or rear plate. Inspect the driver blade for damage. Replace as required.



6. Replace the Front Plate, by reversing the procedure followed in steps 3 & 4.
7. Replace the tool on the machine and re-connect all air hoses to the tool.
8. Re-connect the main air supply to the machine.

Maintenance

DAILY:

Check Lubricant Level

Lubricant level can be viewed through the bowl. To add oil: Disconnect air, Loosen bowl 1/4 turn & pull downward to remove, fill oil to just below top of window. Oil can be added through the fill port while the machine is still pressurized.

Important!! Use only 10 wt. non detergent oil. Use of any other lubricant will damage rubber seals and cause machine to malfunction.

Drain Air Filter

Open valve at bottom of filter until all water drains, close valve when water is completely drained. This can be done with the machine pressurized.

Check Air Leaks

Check for air leaks on hoses, cylinders, and valves and replace accordingly.

Visual Inspection

Check for loose or missing screws, bolts, and pins and tighten or replace as required.

Clean Machine

Wipe down or blow off entire machine paying particular attention to the valve assembly, the driving tool, and all moving components.

WEEKLY:

Lubrication

With an oil dampened rag, lightly coat the bearing rods on the holddown and carriage as well as all cylinder rods.

NOTE: Use a 10 wt. Non detergent oil. Use of other oils or lubricants can damage the machine.

Electrical Connections

Visually inspect any electrical wires for fraying or excessive wear. Replace as required.

MONTHLY:

Filter Element

Inspect the filter element and wipe out the bowl with a clean cloth. Replace the filter element if dirty or causing a drop in pressure of 10 lbs. or more.

Grease all “zirc” fittings on the Holddown and the tool carriage bearings. In extreme conditions, this may have to be done more often.

IMPORTANT! Before greasing Holddown bearings, disconnect air from machine and push the holddown assembly to the bottom of its stroke. Failure to do this will cause excessive buildup of grease and adversely affect operation of the Holddown system.

Pneumatic Valves

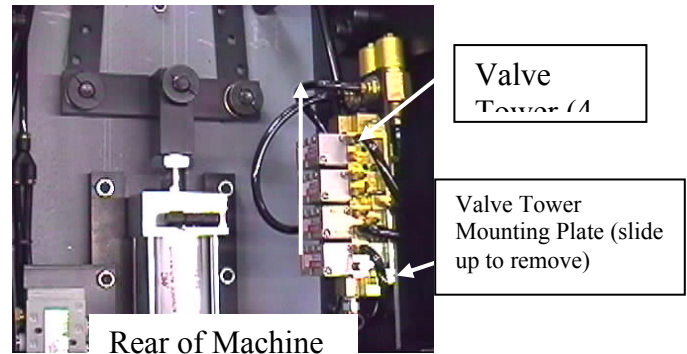
Clean and lubricate pneumatic valves as indicated. See instructions on page 6.2 and 6.3.

Cleaning and Lubricating Pneumatic Valves – Double Shooter

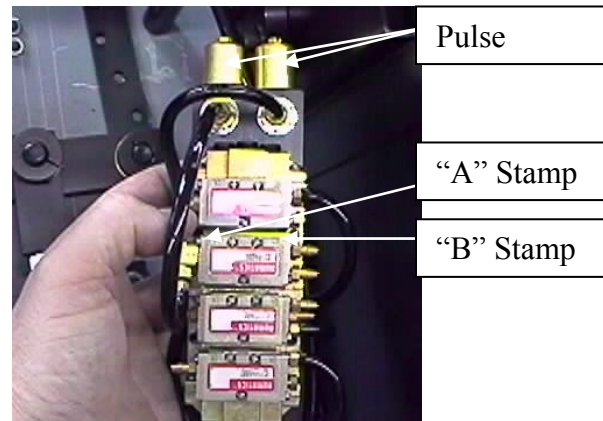
NOTE: This procedure should be done every 2 to 3 months on a machine in heavy production or when the machine begins to function sluggishly. A “dirty” air supply (excessive water or particulate matter in the air lines) will increase the required cleaning frequency.

Disconnect Air Supply to Machine before cleaning Valves.

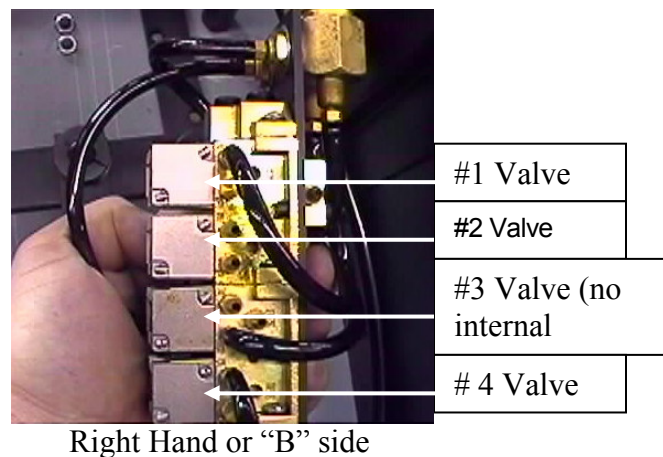
1. Loosen the 2 screws at the bottom of the plate securing the Valve Tower Mounting Plate with a 3/16” allen wrench. Slide the valve tower up to remove it from the bracket.



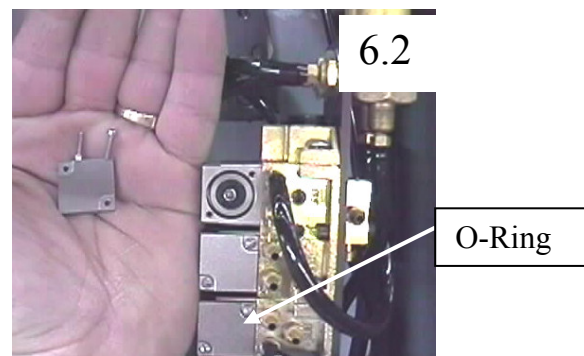
2. Orient the Valve tower as shown with the 2 Pulse Valves facing up.
Note: Some air hoses have been removed for clarity.



3. Rotate the Valve Tower so you are working on the Right Hand (or “B”) side of the valves.



3. Remove the 2 cover screws and the Valve Cover from the “B” side of Valve #1. **Caution: Valve #1, #2, and #4 have a spring behind the Valve**

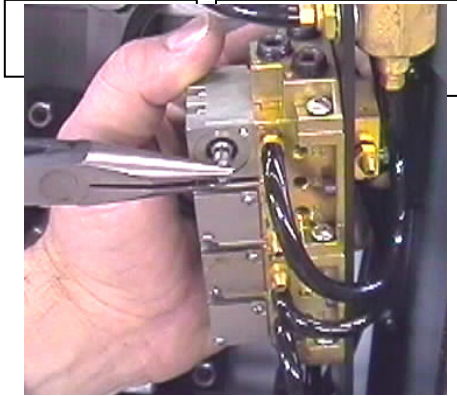


Cover. Be careful not to lose this spring when removing the valve cover.

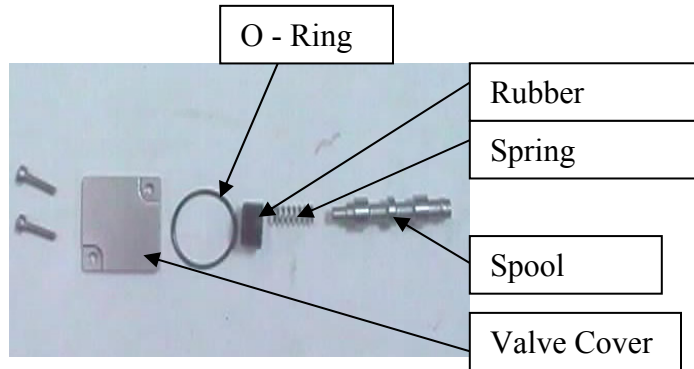
Next, gently remove the Spring, the O-Ring, and the Rubber Bumper from the Valve. Wipe them clean and coat with a light film of 10 wt. non-detergent oil. These parts can usually be re-used if handled with care. Repair kits are available if these parts are damaged. Specify the valve number when ordering PP-4000 for valves with springs (#1, #2, & #4); PP-4000 for valve without spring (#3).

Rubber
Bumper

4. With a pair of needle nose pliers gently remove the Valve Spool from the Valve. Wipe the Valve Spool with a clean cloth. If mineral deposits have built up on the spool, they can be removed with a fine grit polishing compound. Coat the Valve Spool with light film of 10 wt. non-detergent oil. Carefully re-insert the Spool into the Valve and spin it to distribute the oil inside the valve. Check to be sure the Spool moves freely inside the Valve.
- NOTE: The thinner end of the Spool faces out or towards the "B" side of the valve.



5. Place the cleaned & oiled Rubber Bumper, O-Ring and Spring back in the Valve. Replace the Valve Cover and secure in place with the 2 screws. Repeat steps 3 & 4 until all 4 Valve have been cleaned and lubricated.



Trouble Shooting Guide

SYMPTOM	POSSIBLE CAUSE	REMEDY
Tool Not Cycling	<ul style="list-style-type: none"> • Tool on / off valve in off position. • Air not connected to tool or machine • Machine on/off switch in “off” position. • Fastener is jammed in nose of tool. • Broken Piston / Blade assembly. • Tool firing valve O-Rings worn or pinched. • Pulse valve malfunctioning (see valve assembly drawing.) 	<ul style="list-style-type: none"> • Slide on/off valve to “on” position (see “Unpacking & Initial Setup” section). • Connect air to tool or machine. • Turn switch to “on” position (see “Unpacking & Initial Setup” instructions). • Unjam tool (see “Clearing a jam” section). • Remove tool and replace broken assembly. • Remove tool and replace O-Rings. • Replace valve.
Driving Tool Misfires (skips)	<ul style="list-style-type: none"> • Air pressure to tool too low • Tool needs lubrication • Pulse valve malfunctioning (see valve assembly drawing.) • O-Rings on tool cylinder, piston, or main valve worn or pinched • Incorrect Fastener Type loaded in tool • Quick exhaust missing, malfunctioning, or too far from tool (See “Tool Assembly” drawing.) 	<ul style="list-style-type: none"> • Insure tool air pressure above 70 lbs psi. (see “Unpacking and Initial Setup” section) • Remove, clean & oil tool. Make sure oiler has oil and is adjusted properly (see “Maintenance” & “Unpacking & Initial Setup” sections) • Replace valve • Remove tool and Replace O-Rings. • Load correct fastener type (see “Changing Fastener Types” section) • Replace or install in proper position
Driving Tool Jams Excessively	<ul style="list-style-type: none"> • Fastener height adjustment wrong • Fasteners loaded incorrectly • Incorrect Fastener Type loaded in tool • Worn Front Plate, Rear Plate, 	<ul style="list-style-type: none"> • Adjust to correct height (see “Changing Fastener Size” section) • Load fasteners correctly (see “Fastener Orientation” section) • Load correct fastener type (see “Changing Fastener Types” section) • Replace worn part(s)

	or Driver Blade on tool • Driver Blade in backwards	• Reverse driver blade
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Fastener not driving all the way	<ul style="list-style-type: none"> • Air Pressure too low to tool • Air Pressure too low to Holddown • Tool needs lubrication • Driver Blade too short or worn • Tool too far away from molding • Pulse valve malfunctioning (see valve assembly drawing.) • Quick exhaust missing or malfunctioning (See “Tool Assembly” drawing.) • Number 4 valve dirty. This will only affect the second position. 	<ul style="list-style-type: none"> • Increase air pressure to tool. (see “Unpacking & Initial Setup” section) • Increase Holddown pressure. It should be 5 – 10 lbs higher than tool pressure. (See “Unpacking & Initial Setup” section) • Remove, clean & oil tool. Make sure oiler has oil and is adjusted properly (see “Maintenance” & “Unpacking & Initial Setup” sections) • Replace driver blade • Move tool Closer (see “Unpacking & Initial Setup” section) • Replace valve • Replace • Clean & lubricate valve spool. (See “Maintenance” section).
Fastener driving too deep	<ul style="list-style-type: none"> • Air Pressure too high to tool • Worn bumper or missing driver guide in tool • Driver blade too long • Tool too close to molding 	<ul style="list-style-type: none"> • Decrease air pressure to tool. (see “Unpacking & Initial Setup” section) • Remove tool & replace worn / missing parts • Replace with shorter blade • Move tool further away. (see “Unpacking & Initial Setup” section)
Fasteners damaged during driving	<ul style="list-style-type: none"> • Fastener height adjustment wrong • Fastener loaded upside down or backwards • Wrong fastener or fastener type • Worn Front or Rear Plate on tool • Worn or damaged driver blade • Nose of tool too far below molding 	<ul style="list-style-type: none"> • Adjust to correct height (see “Changing Fastener Size” section) • Be sure fastener is loaded correctly. (see “Fastener Orientation” section). • Try using a hardwood fastener or a different fastener type. (see “Changing Fastener Type” section) • Inspect and replace as required • Inspect and replace • Adjust tool depth setting. (See “Unpacking & initial Setup” section)

Piston / Blade assembly does not return	<ul style="list-style-type: none"> • Tool is jammed • Tool cycle valve air supply not connected • Air Pressure to tool too low • Quick exhaust missing or malfunctioning (See “Tool Assembly” drawing.) 	<ul style="list-style-type: none"> • Unjam tool (see “clearing a Jam” section) • Connect air supply. (See “Changing Fastener Types” section) • Increase tool pressure. Minimum 70 lbs psi required. (See “Unpacking & Initial Setup” section) • Replace.
Machine won’t unclamp	<ul style="list-style-type: none"> • Malfunctioning foot pedal • Malfunctioning Foot Switch Pilot Valve (See “Foot Control Assembly” drawing) 	<ul style="list-style-type: none"> • Replace • Replace
Tool won’t shift between 2 positions	<ul style="list-style-type: none"> • Shot selection switch set to 1 • Tool stop collars set too close together • Bearing rods need lubrication • Nose of tool too close to molding causing nose to “drag” against molding when clamped • Number 3 valve dirty (See “Valve Assembly” drawing.) 	<ul style="list-style-type: none"> • Set it to 2 (see “Unpacking & Initial Setup” section) • Move collars apart (See “Unpacking & Initial Setup” section) • Lubricate tool carriage bearing rods. (See “Maintenance” section) • Move tool further away. (see “Unpacking & Initial Setup” section) • Clean & lubricate valve spool. (See “Maintenance” section)
Air leaking from Foot Switch Pilot Valve	<ul style="list-style-type: none"> • Loose hoses • Jaw cylinder excessively worn • Holddown cylinders worn out • Foot Switch Pilot Valve worn out 	<ul style="list-style-type: none"> • Check that all hoses are completely plugged into fittings. • Replace • Replace • Replace