



OWNER'S MANUAL

FLETCHER 5500 CORNERPRO™



The Fletcher-Terry Company

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INTRODUCTION

The Fletcher 5500 CornerPro™ is a versatile foot-pedal-operated manual underpinner. It is shipped with the foot pedal mounted in the front of the base, but it can be easily altered to permit operation from the back. Unpack machine and examine contents. Report any shipping damage to the carrier.

- The 5500 CornerPro™ includes the following:

- Front Clamp

- Upper Clamp with:

- Flat Right Angle Pad

- Round Right Angle Pad

- Two Nail Pushers:

- One for 3/16" and 1/4" (4mm and 7mm) Nails

- One for 3/8", 1/2" and 5/8" (10mm,12mm and 15mm) Nails

- Two Thickness Compensators:

- One for 1/4" (7mm) Nails

- One for 3/8" (10mm) Nails

- Tool Box Containing:

- Metric Hex Wrench Set (5)

- Magnet

- Owner's Manual

- Instructional Video

- Optional Accessories:

- 40mm Round Pad with felt for Upper Clamp (04-340)

- Thickness Compensator for 3/16" (4mm) Nails (04-344) Note: Required if you wish to use 3/16" (4mm) Nails.

- Thickness Compensator for 1/2" (12mm) Nails (04-347) Note: Required if you wish to use 1/2" (12mm) Nails.

- Hexagonal Fence and Octagonal Fence (04-353)

- Fence Risers (04-342)

- Extension Wings (04-341)

- Specifications:

- Width 15" (390mm)

- Depth 21-5/8" (550mm)

- Overall Height 45-1/4" (1150mm)

- Working Height 37-7/16" (950mm)

- Weight 97 pounds (44 kg)

- Moulding Capacity:

- Height*: 1/4" to 2-3/4" (5mm to 70mm)

- Width: 1/4" to 3-9/16" (5mm to 90.5mm)

* Use 3/16" (4mm) Nails only for 1/4" moulding height.

PRODUCT WARRANTY

The Fletcher-Terry Company warrants the Fletcher 5500 CornerPro™ to be free from defects in parts and workmanship for (2) two years* from the date of purchase, *with the exception of those parts and accessories listed below.* The Fletcher-Terry Company warrants that it will repair or replace any such defective machine or replace parts, providing the machine has been under normal use and service and the defective part or machine is returned to The Fletcher-Terry Company at the purchaser's expense. The Fletcher-Terry Company must authorize the return in writing. Proof of purchase must be submitted to validate warranty coverage.

The warranty is in lieu of all other agreements and warranties expressed or implied. THE FLETCHER-TERRY COMPANY DOES HEREBY EXPRESSLY DISCLAIM ANY WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. The Fletcher-Terry Company does not authorize any employee or representative to assume for it any other liability than that set forth in this Product Warranty. The Fletcher-Terry Company shall not be liable for any damages or losses, whether incidental or consequential, or direct or indirect, arising out of the use or abuse of this machine; in any event, THE PURCHASER'S SOLE AND EXCLUSIVE REMEDY UNDER THIS OR ANY OTHER WARRANTY IS LIMITED TO RETURN OF THE PURCHASE PRICE PAID FOR THIS MACHINE.

**Parts and accessories not included in the (2) two year warranty:*

| Description | Description |
|------------------------------|-------------------------------------|
| Thickness Compensator - 4mm | All Locking Levers |
| Thickness Compensator - 7mm | Hexigon Fence |
| Thickness Compensator - 10mm | Octagon Fence |
| Thickness Compensator - 12mm | Extension Wings |
| Nail Pusher - 4-7mm | Flat Right Angle Pad |
| Nail Pusher - 10-15mm | Round Right Angle Pad |
| Complete Tool Box | 40mm Round Pad with Felt Magnet Rod |

*Hammer is warranted for (1) one year.

Damage resulting from the use of joining nails other than CornerPro nails or unauthorized modifications to the machine will void the warranty.

SAFETY

- Follow the operating instructions in this manual.
- Keep your fingers away from clamping areas both front and upper.
- Wear safety glasses during operation, maintenance assembly and disassembly activities.
- Do not rest your foot on the foot pedal until you are ready to drive a nail.

SET UP

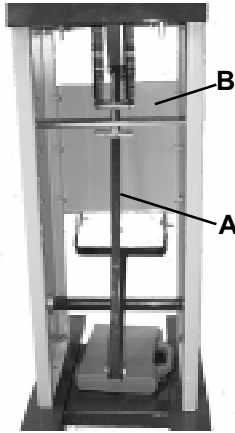


Figure 1

Unpack the machine and examine all components for shipping damage which should be reported to the carrier for claims.

As shipped, the foot pedal will be facing the front, but can be reversed if you prefer to operate the machine from the rear.

1. Remove the front **Panel (B)** and set it aside. (Figure 1)
2. Disconnect the **Tie-rod (A)** at both ends (**C**) and (**D**). (Figures 1a and 1b)
3. Rotate the **Pedal** to operate from the rear.
4. Re-connect the **Tie-rod** at the upper end (**C**). (Figure 1a)
5. Re-connect the **Tie-rod** at the lower end (**D**) using the **Upper Hole**. (Figure 1b)
6. Assemble the **Panel (B)** on the rear side of the machine using the screws from step 1. (Figure 1)

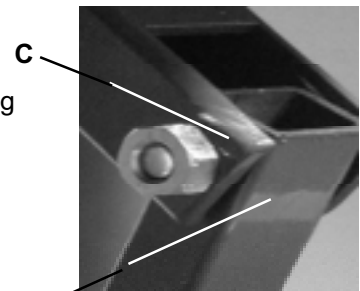


Figure 1a

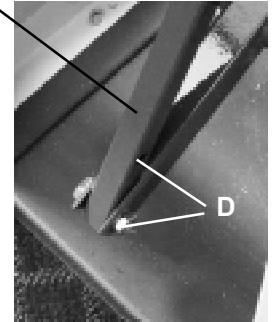


Figure 1b

HOW TO SELECT NAILS

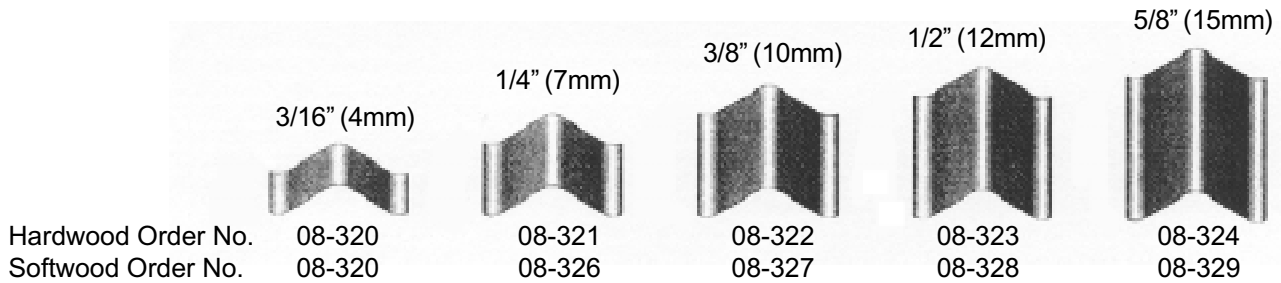


Figure 2

The patented joining nails are designed to apply forces which hold the frame pieces firmly together creating a tight joint. There are 5 different lengths as shown in Figure 2. Each size is available for either hardwood or softwood

with the order number shown for each. Select the nail length which comes no closer to the top of the

frame than 3/16" to 1/4". See Figure 3. For maximum strength, place two or more nails (**E**) and (**D**) in

parallel as shown.

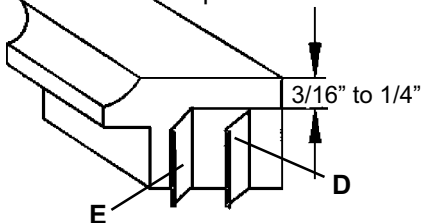


Figure 3

Note: Use only the nails shown above provided by Fletcher-Terry or the machine may be damaged and the warranty voided.

HOW TO JOIN FRAMES

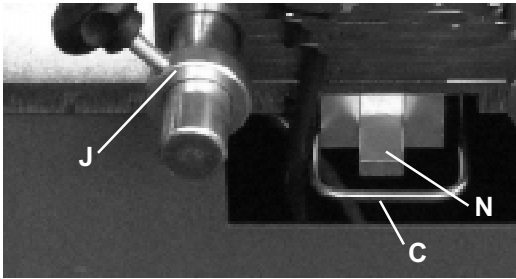


Figure 5

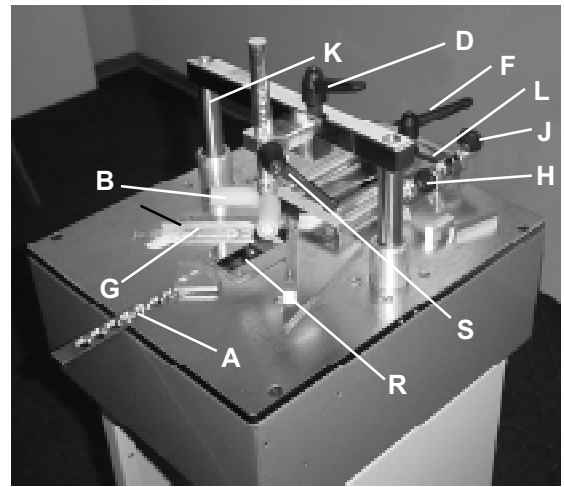


Figure 6

Loading Nails

Figures 5 (from the rear) and 6 illustrate the operating components of the 5500.

1. Verify that the nail path is empty and the **Pusher (O or P)** and **Thickness Compensator (M or N)**, Figure 7, have been removed. Use the **magnet** on the rod from the tool box to clear the nail path of any loose **Nails**.
2. There are two **Thickness Compensators**, one labeled 7mm (**M**) for the 1/4" nails, and the other is labeled for the 10mm (**N**) 3/8", Nails. Select the 10mm **Thickness Compensator (N)** and slide it into the nail path from the rear of the machine with its pin pointing downward and toward the rear of the machine. After pushing it as far as it goes, press down on the back end of the **Thickness Compensator** and the pin will lock it in place. (Figure 5)

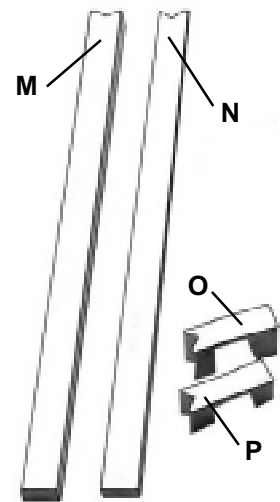


Figure 7

3. Pull the spring loaded **Follower (C)** (Figure 5) to the rear and insert a stack of 3/8" (10mm) **Nails** in the nail path with the glue side up and the bend toward the rear. Set the large **Pusher (O)** for 3/8", 1/2" and 5/8" (10mm, 12mm and 15mm) **nails** over the **Nail Block (T)**, (Figure 7a), with the "V" notch against the **Nails** and release the **Follower (C)**. The smaller **Pusher (P)** is used for 3/16" (4mm) and 1/4" (7mm) **Nails**.

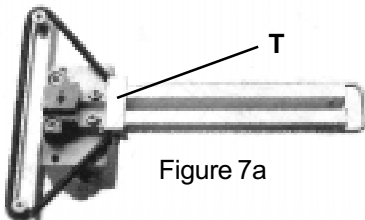


Figure 7a

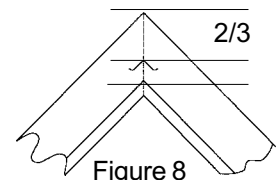


Figure 8

Driving Nails

The **Flat Upper Clamp Pad** is used for flat or rounded frames, while the **Rounded Upper Clamp Pad (B)** is used for moulding that has a concave contoured surface. Do not mount either on the **Upper Clamp Shaft (K)** until the following steps are completed. Refer to Figure 6 for the following steps, unless otherwise noted.

1. Remove the **Front Clamp (A)**. Place one leg of the moulding you are going to join against the left **Fence (G)** and hold its end against the right **Fence**. You will be able to see the slot in the **hammer block (R)** where the **Nail** will be inserted.
2. Slide the fence assembly to the position for the first **Nail**, Figure 8, near the frame rabet. Lock the **Collar (H)** against the front of the **Slide Block (L)**. This **Nail** should be inserted about 1/3 of the frame width from the rabet as shown in the drawing.

3. Slide the **Fence Assembly** toward the front to the position for the second **Nail** which should not be any closer than 3/16" from the frame corner to avoid splitting the wood. Lock the **Collar (J)** against the back of the **Slide Block (L)**.
4. Install the **Round Right Angle Pad (B)**, Figure 10, to the bottom of the **Upper Clamp Shaft (K)**.
5. Place the two frame pieces against the fences and push the **Fence Assembly (G)** to the rear against the **Collar (H)**.
6. Place the **Front Clamp (A)** in its slot and position it about 1/4" to 3/8" from the frame.

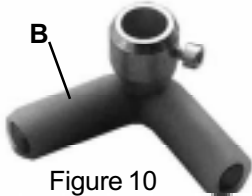


Figure 10

7. Loosen **Locking Lever (D)** and slide the **Upper Clamp** assembly to the front or back so the **Rounded Upper Clamp Pad** is centered over the concave contoured top of the frame shown in Figure 9. Then tighten the **Locking Lever (D)**.

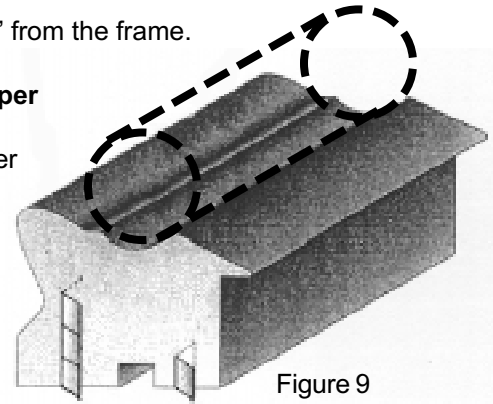


Figure 9

8. Loosen **Locking Lever (S)** and raise or lower the **Upper Clamp Shaft (K)** so the **Round Upper Clamp Pad (B)** is 3/8" to 5/8" above the frame. Tighten the **Locking Lever (S)** which must enter one of the holes in the **Upper Clamp Shaft (S)** to prevent slippage. After tightening, be sure the **Locking Lever (S)** handle is not pointing downward because it may hit the table when the **Upper Clamp** descends. You can pull the handle free and rotate it.
9. If you choose to use glue, apply a small amount in the center of the end of one frame leg, but avoid excessive amounts because it will squeeze out of the joint and create subsequent problems such as mis-alignment, damage to the top of mouldings and restrict the operation of the **Hammer**. Push the mouldings together and visually insure the ends of the frame legs are even and the tops are flush.
10. Depress the **Foot Pedal** to its stop and release it. Do not exert excess pressure after it stops because that may damage the top of the frame.
11. Slide the **Fence Assembly (G)** toward the front against the **Collar (J)** and tighten the **Locking Lever (F)**. This prevents pushing the assembly to the rear under the force of the **Front Clamp (A)**. Locking the slide on the first **Nail** insertion was not necessary because the **Fence Assembly (G)** was held by **Collar (H)**. If necessary, move the **Front Clamp (A)** to the next hole to maintain the 1/4" to 3/8" clearance between the **Front Clamp (A)** and the rabbet of the frame. It may also be necessary to re-position the **Upper Clamp** to align the **Round Upper Clamp Pad (B)** to the shape of the moulding.
12. Depress the **Foot Pedal** again and insert the second **Nail**.
13. If the frame is wide, you may insert a third (or more) nails by positioning the **Fence Assembly (G)** between the first and second nails. Use the **Locking Lever (F)**.
14. In the event of a tall frame profile, you can insert more than one nail in the same position, or "stack" the nails one on top of the other as shown in Figure 9. Ease up on the **Foot Pedal** slightly after inserting the first **Nail** so the moulding remains clamped; then depress the **Foot Pedal** again.
15. If it is necessary to change **Nails** to a different size, pull the **Follower** to the rear, remove the **Pusher, nails, and compensator**. Use the **Magnet** to clear any **Nails** that may be in the nail path. Then reload a **Compensator, Nails, and Pusher** as described in the section on **Loading Nails**.

Note: The last 1/4 of the strip of Nails will not feed into the Hammer Block. This makes it easier to add Nails or change Nail size.

MAINTENANCE

Usage and the environment will dictate the suggested frequency of the following maintenance activity:

- Item 1 Daily
- Item 2 As required
- Item 3 Weekly
- Item 4 Monthly
- Item 5 Monthly

Modify these frequencies as conditions warrant. This machine will provide years of quality performance if well cared for.

1. The most important maintenance requirement is cleanliness. Use a brush or clean cloth to wipe the table surface, Shafts and Pads.
2. If glue accumulates on the table surface or **Hammer Block**, wipe it off before it dries, otherwise, it will have to be scraped off or removed with the solvent recommended by the glue manufacturer. Be sure glue does not dry on the **Upper Clamp Pads** because it will damage the top of a frame.

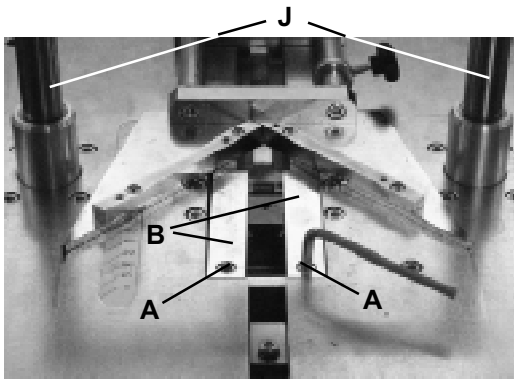


Figure 11

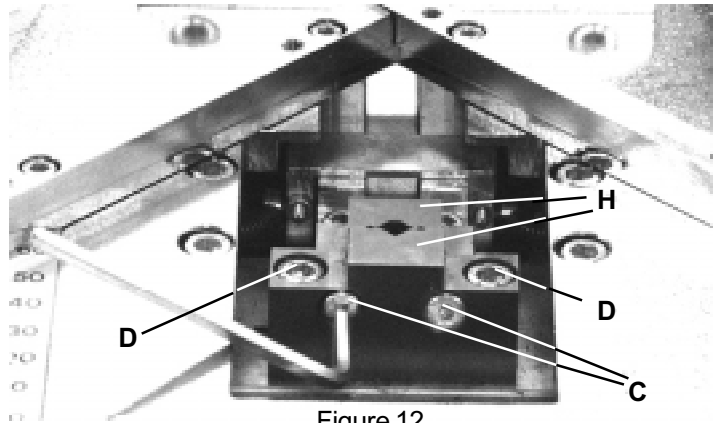


Figure 12

3. Use light oil on a cloth to wipe the **Vertical Shafts (J)** which operate the **Upper Clamp**.
4. Apply light grease sparingly to the pivot points of the **Foot Pedal** mechanisms.
5. Disassemble the **Hammer Block** after removing **Pusher, Nails and Compensator**.
 - a. Remove two screws (**A**) and set the **Cover Plates (B)** aside. (Figure 11)
 - b. Remove two screws (**C**). **DO NOT LOOSEN SCREWS (D)**. (Figure 12)
 - c. Figure 13 is viewed from the rear. Remove the rear half of the **Hammer Block (E)** and wipe the hammer paths (**F**) clean.
 - d. Depress the **Foot Pedal** to expose the **Hammer (G)** and wipe it clean.
6. Assemble the **Hammer Block** components in the reverse order of steps (a.) through (d.)

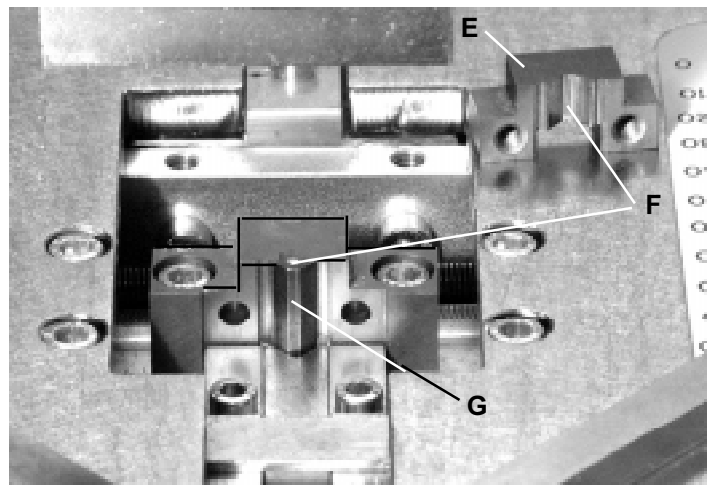


Figure 13

Caution: Be sure the tops of the two halves of the **Hammer Block (H)** in Figure 12 are perfectly flush before tightening **Screws (C)**.

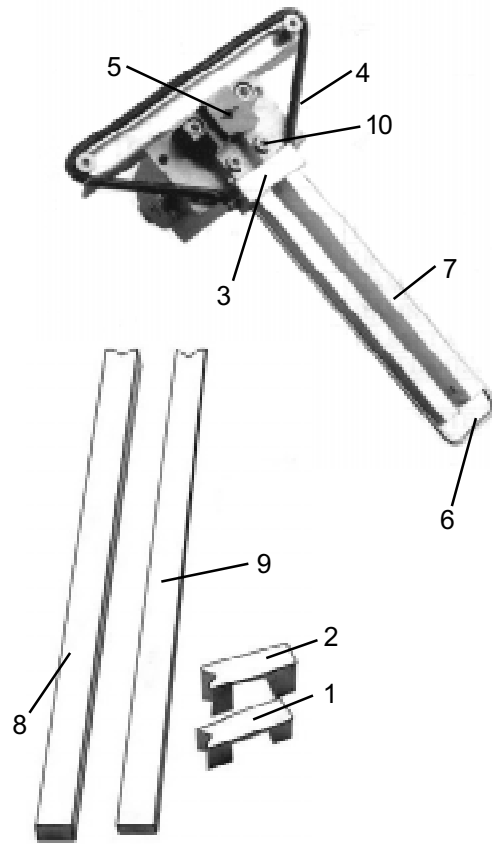
TROUBLESHOOTING

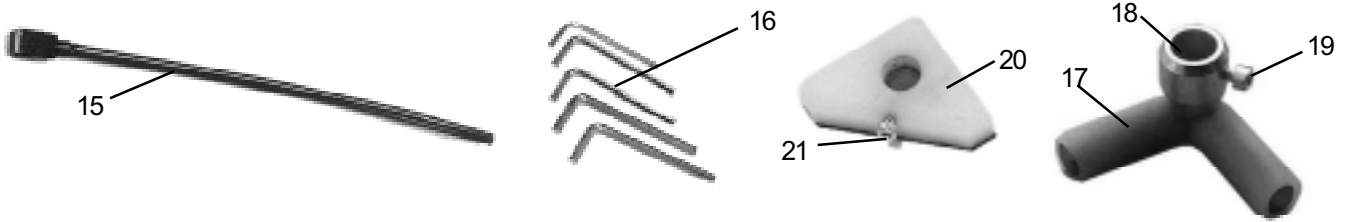
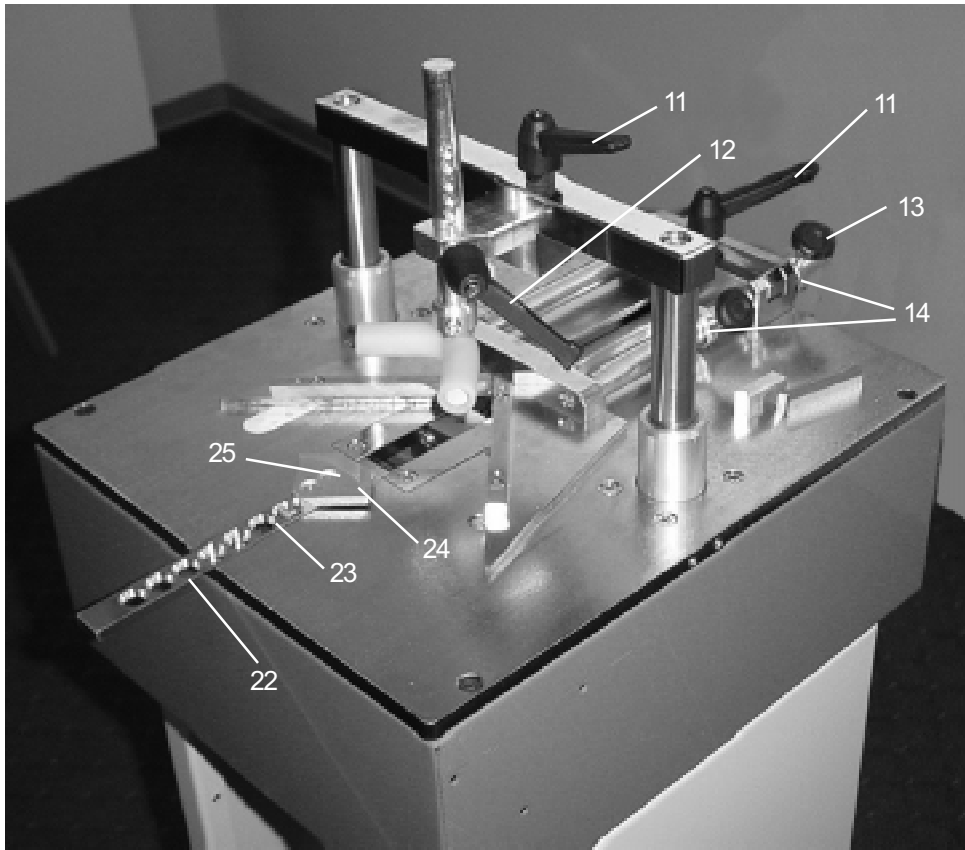
| PROBLEM | POSSIBLE CAUSE | CORRECTION |
|--|--|--|
| Nail is not driven | No nails in the nail path | Load nails |
| | Nails placed backwards in the nail path | Remove and reload strip of nails |
| | Using the wrong compensator | Use the proper compensator |
| | A jammed nail obstructs nail feeding | Remove nails and the jam |
| | Follower spring not pushing strip of Nails into position | Replace follower spring Remove obstruction in nail path Verify Follower Spring is attached |
| | Wrong compensator or not installed correctly | Replace compensator or insert it properly |
| | The last 1/4 of the strip of nails will not feed | Add more nails |
| | Edge of hammer is worn or damaged | Contact Customer Service (see below) |
| Nail only partially driven in moulding | Upper clamp set too high above the frame | Position upper clamp 3/8" to 5/8" above moulding |
| | Edge of hammer is worn or damaged | Contact Customer Service (see below) |
| | Upper clamp pad out of position | Re-position the upper clamp |

FOR ASSISTANCE, CONTACT THE FLETCHER-TERRY COMPANY CUSTOMER SERVICE DEPARTMENT AT 800.843.3826 (U.S./CANADA) OR 860.677.7331, customerservice@fletcher-terry.com.

SPARE PARTS

| Ref. No. | Part No. | Description | Quantity |
|----------|----------|-------------------------|----------|
| 1 | 16-043 | Pusher (7mm) | 1 |
| 2 | 16-044 | Pusher (10mm/12mm/15mm) | 1 |
| 3 | 16-023 | Nail Block | 1 |
| 4 | 16-022 | Follower Spring | 1 |
| 5 | 16-020 | Hammer | 1 |
| 6 | 16-027 | Follower | 1 |
| 7 | 16-024 | Nail Path Guide | 1 |
| 8 | 16-041 | 7mm Compensator | 1 |
| 9 | 16-042 | 10mm Compensator | 1 |
| 10 | 16-025 | Nail Path Guide Screw | 2 |





| Ref. No. | Part No. | Description | Quantity |
|----------|----------|----------------------------|----------|
| 11 | 16-011 | Locking Lever | 2 |
| 12 | 16-029 | Locking Lever | 1 |
| 13 | 16-004 | Locking Knob | 2 |
| 14 | 16-003 | Stop Collar | 2 |
| 15 | 16-013 | Magnet | 1 |
| 16 | 16-074 | Hex Wrench Set (5) | 1 |
| 17 | 16-037 | Round Angular Pad | 1 |
| 18 | 16-038 | Round Angular Pad Bushing | 1 |
| 19 | 16-036 | Round Angular Pad Screw | 1 |
| 20 | 16-039 | Flat Right Angle Pad | 1 |
| 21 | 16-040 | Flat Angular Pad Screw | 1 |
| 22 | 16-070 | Front Clamp Bar | 1 |
| 23 | 16-010 | Front Clamp OperatingScrew | 1 |
| 24 | 16-072 | Front Clamp Head | 1 |
| 25 | 16-071 | Front Clamp Head Screw | 2 |