



OWNER'S MANUAL

FLETCHER 5600 CORNERPRO™



The Fletcher-Terry Company
65 Spring Lane • Farmington, CT 06032-3311
Tel 860.677.7331 • 800.843.3826 • Fax 860.676.8858 • www.fletcher-terry.com
customerservice@fletcher-terry.com

Form 020504
Ver.4.3.4

TABLE OF CONTENTS

- INTRODUCTION 3
 - Components 3
 - Optional Accessories 3
 - Specifications / Capacity 3
- PRODUCT WARRANTY 4
- SAFETY 4
- SET UP 5
- HOW TO SELECT NAILS 5
- HOW TO LOAD NAILS 6
- HOW TO JOIN FRAMES 6, 7
- MAINTENANCE 8
- TROUBLESHOOTING 9
- SPARE PARTS 10, 11

INTRODUCTION

The Fletcher 5600 CornerPro™ is a pneumatically powered underpinner which is designed to be operated on a bench or installed on an optional tilting **Stand**. A Plexiglas® shield is provided to safeguard against pinching your fingers with the pneumatic clamping of the moulding and insertion of nails. It is interlocked with the underpinning operation to prevent the use of the machine unless the guard is in place. Respect the importance of this safety feature for your protection.

- The 5600 CornerPro™ includes the following:

- Front Clamp (adjustable)

- 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:

- Tilting Stand (04-324)

- 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)

- Work Table (04-343)

- Specifications:

- Width 13-3/4" (350mm)

- Depth 17-3/4" (450mm)

- Total Height 12-5/8" (320mm)

- Working Height 6" (150mm)

- Weight 61-3/4 pounds (28kg)

- Maximum Pressure 115 PSI (8 BAR)

- Working Pressure 36 to 110 PSI (2.5 to 7.5 BAR)

- Recommended Pressure 85 to 90 PSI (5.8 to 6.2 BAR)

- Moulding Capacity:

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

- Width 1/4" to 3-15/16" (5mm to 100mm)

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

PRODUCT WARRANTY

The Fletcher-Terry Company warrants the Fletcher 5600 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 company 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:*

<u>Description</u>	<u>Description</u>
Complete Foot Pedal	Thickness Compensator - 4mm
Plexiglas® Guard	Thickness Compensator - 7mm
All Locking Levers	Thickness Compensator - 10mm
All Adjusting Knobs	Thickness Compensator - 12mm
Complete Tool Box	Nail Pusher - 4-7mm
Hex Wrenches	Nail Pusher - 10-15mm
Magnet Rod	Fence Risers
Round Right Angle Pad	Extension Wings
Flat Right Angle Pad	40mm Round Felt Pad

*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



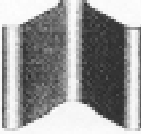
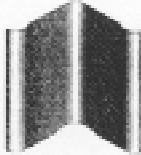
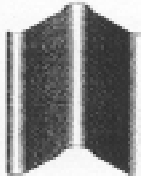
- Follow the operating instructions in this manual.
- Keep your fingers away from clamping areas both front and upper.
- Wear safety glasses during operation, maintenance assembly and disassembly activities.
- Do not rest your foot on the foot pedal until you are ready to drive a nail.
- Do not operate this machine without the Plexiglas® Guard in place.
- Disconnect air source during maintenance.

SET UP

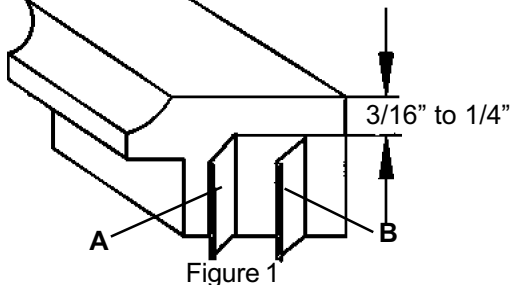
Unpack the machine and examine all components for shipping damage which should be reported to the carrier for claims.

1. Set the machine on a work table of comfortable height and place the **Foot Pedal** on the floor.
2. Remove the **Plexiglas® Guard** for the following three steps.
3. Remove the **Front Clamp** and the **Upper Clamp**. You will reinstall after loading **Nails**.
4. Three color-coded air hoses, already attached to the **Foot Pedal**, should be connected to the matching color-coded receivers on the **machine**. The connection is made by firmly pushing the hose into the receiver. When properly done, the hose will slide into the receiver about 3/8".
5. Attach the compressed air source to the machine with the appropriate "quick disconnect" fitting. The source should be filtered and not exceed 8 BAR or 115 PSI.
6. **REINSTALL THE PLEXIGLAS® GUARD.**
7. The **Foot Pedal** is a 2 step device and should now be practiced. You will notice a felt pad under the pedal. Push the pedal down to the pad and the **Front Clamp** and the **Upper Clamp** mechanisms will operate. Push further into the felt pad and the **Hammer** will move upward. The purpose of the two step **Pedal** is to permit the stacking of one (or more) nails on top of one another. The **Pedal** is slightly released after the first **Nail**, but both **Clamps** remain operated while you push the **Pedal** down again for the next **Nail**. The felt pad is helpful during the learning process. When you get the feel for how far to relax the **Pedal** without deactivating the **Clamps**, you can remove the felt pad.

HOW TO SELECT NAILS

	3/16" (4mm)	1/4" (7mm)	3/8" (10mm)	1/2" (12mm)	5/8" (15mm)
					
Hardwood Order No.	08-320	08-321	08-322	08-323	08-324
Softwood Order No.	08-320	08-326	08-327	08-328	08-329

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 above. 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 1. For maximum strength, place two or more nails **(A)** and **(B)** in parallel as shown.

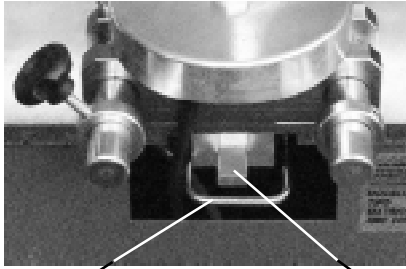


Note: Use only the nails shown above provided by Fletcher-Terry or the machine may be damaged and the warranty voided.

HOW TO LOAD NAILS

1. There are two **Compensators**, one labeled 7mm (**A**) for the 1/4" **Nails**, and the other is labeled 10mm (**B**) for the 3/8" **Nails**. See Figure 2. Select the 10mm **Compensator (B)** and slide it into the nail path from the rear of the machine with its pin toward the rear and pointing downward. After pushing it in as far as it goes, press down on the rear end of the **Compensator (E)** in Figure 3, and the pin will lock it in place.

2. Pull the spring loaded **Follower (F)**, (Figure 3), to the rear and insert a stack of 10mm (3/8") **Nails** in the nail path with the glue side up and the bend toward the rear. Set the large **Pusher (C)**, (Figure 2), for 3/8" **Nails**, over the **Nail Block (U)**, (**Figure 4**), with the notch toward the front, against the **Nails**. Release the **Follower (F)**. The smaller **Pusher (D)** is used for 3/16" (4mm) and 1/4" (7mm) **Nails**.



F Figure 3 E

3. Operate the **Foot Pedal** and observe the **Nail** rising out of the **Hammer Block**. Repeat this 4 or 5 times with a new machine or one that has not been used recently.

4. This completes **Set Up**. You may now reinstall the **Front and Upper Clamps** and prepare to join frames.

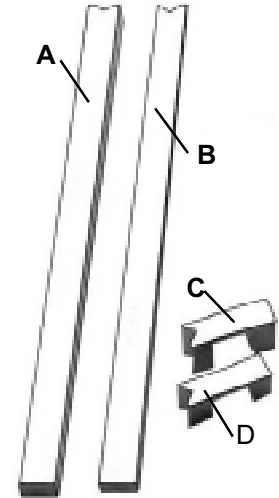


Figure 2

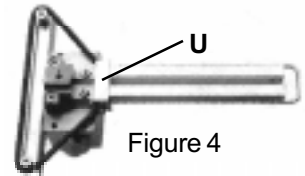


Figure 4

HOW TO JOIN FRAMES

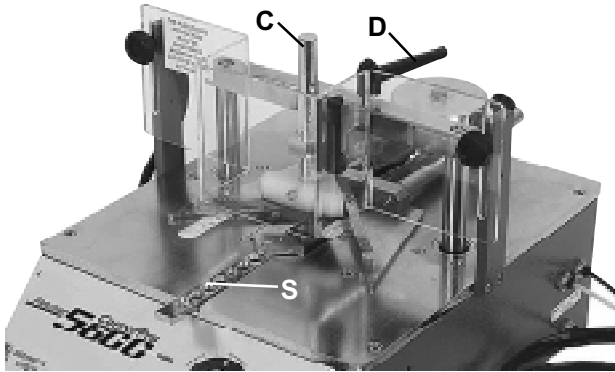


Figure 5

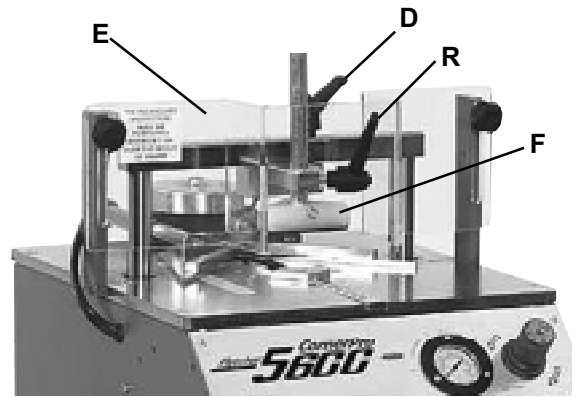


Figure 6

1. Keep the **Plexiglas® Guard (E)** in place.

2. The first step is to position the shaft of the **Upper Clamp (C)** so the **Clamp Pad (F)** is centered over the moulding corner. Loosen the **Locking Lever (D)** and slide the **Clamp** assembly forward or back to center the **Clamp Pad (F)** over the joint. Tighten the **Locking Lever (D)**. The two included **Upper Clamp Pads** are shown at the left. Figure 7 is the **Flat Right Angle Pad** used for flat or convex rounded top mouldings, while Figure 8 is the **Round Right Angle Pad** used for concave curved mouldings.



Figure 7



Figure 8

Loosen **Locking Lever (R)** and position the **Upper Clamp Shaft (C)** so the pad is 5/8" to 3/4" above the frame and the **Locking Lever (R)** is seated in one of the holes in the **Upper Clamp Shaft**. After tightening, be sure the **Locking Lever (R)** is not pointing downward because it may hit the table when the **Upper Clamp** descends. You can pull the handle free and rotate it. Remove the **Front Clamp (S)** until step 5.

3. The front panel of the CornerPro 5600 is shown in Figure 9. The **Pressure Gauge (H)** indicates the air pressure set by the **Pressure Regulator (J)**. The **Pressure Gauge (H)** is marked with the range suggested for softwood from about 37 to 70 PSI and hardwood to 100 PSI.

4. Place the left piece of moulding against the left fence and push the end against the right fence. Slide the **Fence** to align the slot in the **Hammer Block** for the first **Nail** about 1/3 the frame width from the rabbet corner as shown in Figure 11. Loosen the **Locking Knob (K)** in Figure 10; slide **Collar (L)** against the front of the **Slide Block (P)** and tighten **Locking Knob (K)**. Now slide the fence toward the front so the second **Nail** will be inserted no closer than 3/16" from the corner of the moulding to prevent splitting the wood. Loosen the **Locking Knob (M)**; slide the **Collar (N)** against the back of the **Slide Block (P)** and tighten the **Locking Knob (M)**.



H J Figure 9

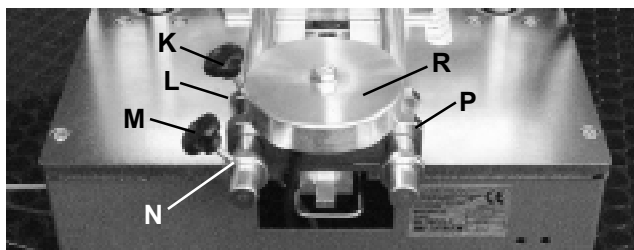


Figure 10

5. Move the **Fence Slide** to the rear to the position for the first **Nail**. Position the **Front Clamp (S)**, in Figure 5, about 3/8" to 5/8" from the rabbet of the moulding. Depress the **Foot Pedal** and a **Nail** will be inserted. If you use glue, apply a small amount to the center of the end of one leg of the moulding to avoid smearing it on the **Upper Clamp Pad** and the **Hammer Block**.

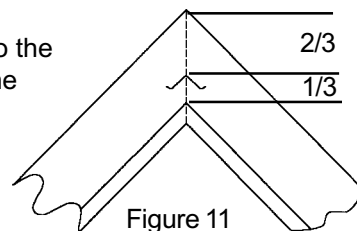


Figure 11

6. Slide the **Fence Slide** to the front; re-position the **Front Clamp** and depress the **Foot Pedal** to insert the second **Nail**.

7. If you want a third **Nail** inserted, slide the **Fence** to an intermediate position, re-set the **Front Clamp** and drive another **Nail**. The **Slide Clamp (R)** is activated when the pedal is depressed, so the **Fence** is locked in place during **Nail** insertion.

8. If the moulding is high you may wish to stack more than one **Nail** in the same position as shown, (**T**) in Figure 12. After the first **Nail** is inserted release the **Foot Pedal** slightly and the **Clamps** will remain in place. Then, depress the **Foot Pedal** further and a second **Nail** will be inserted, which will drive the first **Nail** deeper. This can be repeated for a third **Nail**.

9. If you use the **Round Right Angle Pad** for a contoured moulding, it may be necessary to re-position the **Upper Clamp** for each **Nail** insertion as described in step 2 above so the pad makes contact as shown in Figure 12.

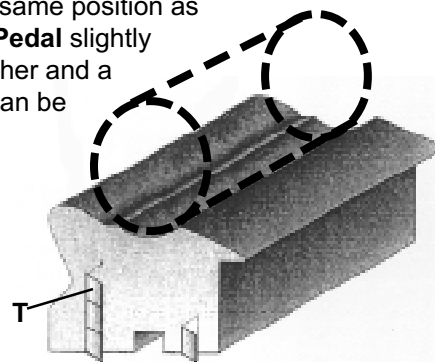


Figure 12

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

Caution: Disconnect air source and wear safety glasses during maintenance.

- Item 1 Daily
- Item 2 As required
- Item 3 Weekly
- Item 4 Monthly
- Item 6..... Weekly
- Item 7..... Weekly

Modify these frequencies as environment and usage dictate. 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 (H)**, Figure 13, 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.
3. Use light oil on a cloth to wipe the **Vertical Shafts (J)**, Figure 14, which operate the **Upper Clamp**.

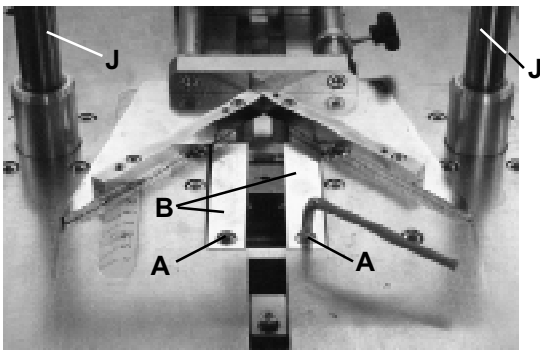


Figure 14

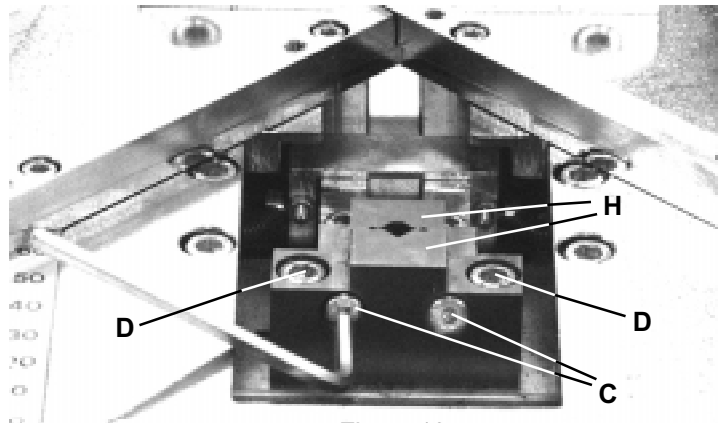


Figure 13

4. Disassemble the **Hammer Block** and clean as follows:
 - a. Remove **Pusher, Nails, and Compensator**.
 - b. Remove two screws (**A**) and set the **Cover Plates (B)** aside. (Figure 14)
 - c. Remove two screws (**C**). **DO NOT LOOSEN SCREWS (D)**. (Figure 13)
 - d. Figure 15 is viewed from the rear. Remove the rear half of the **Hammer Block (E)** and wipe the hammer path (**F**) clean.
 - e. Depress the **Foot Pedal** to expose the **Hammer (G)** and wipe it clean.
5. Re-assemble the Hammer Block components in the reverse order of steps a. through e.

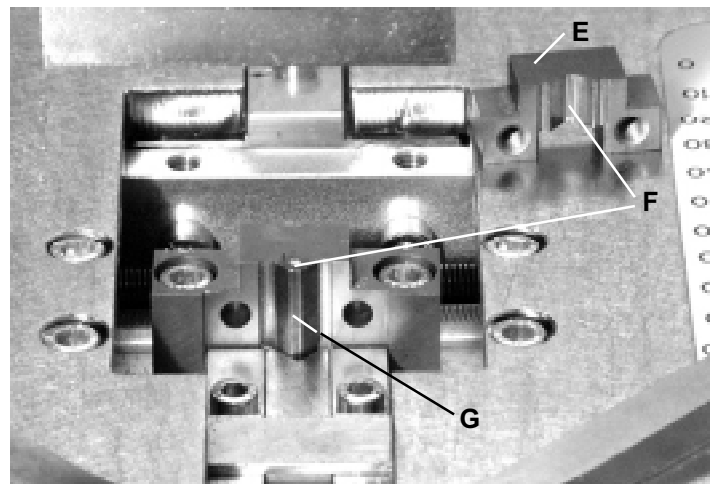


Figure 15

Caution: Be sure the tops of the two halves of the **Hammer Block (H)** in Figure 13, are perfectly flush before tightening screws (**C**).

6. Check the lubricant and drain the filter at the air compressor. The lubricator should produce one drop for every 30 - 40 foot pedal cycles.
7. Use a can of compressed air to clean all porous silencers on pneumatic valves as well as various components of the machine.

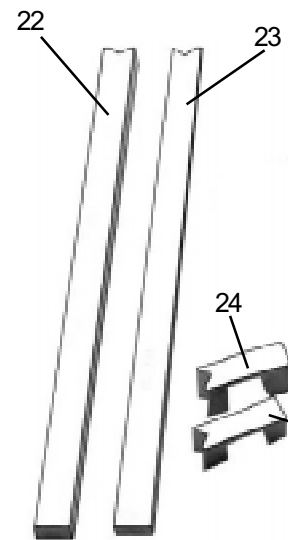
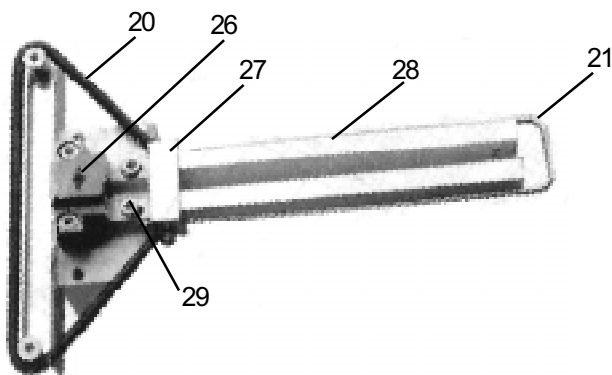
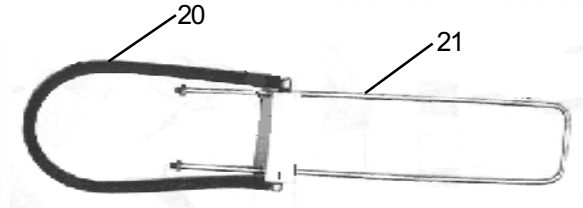
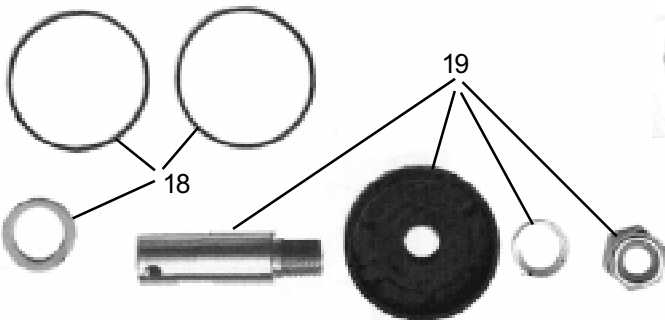
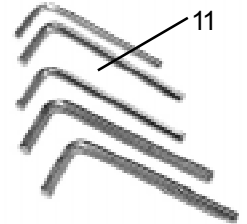
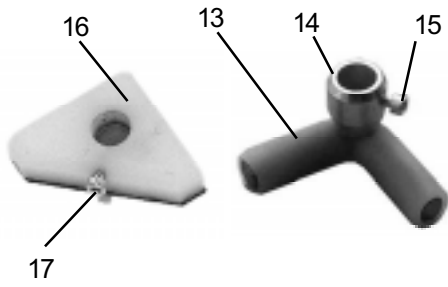
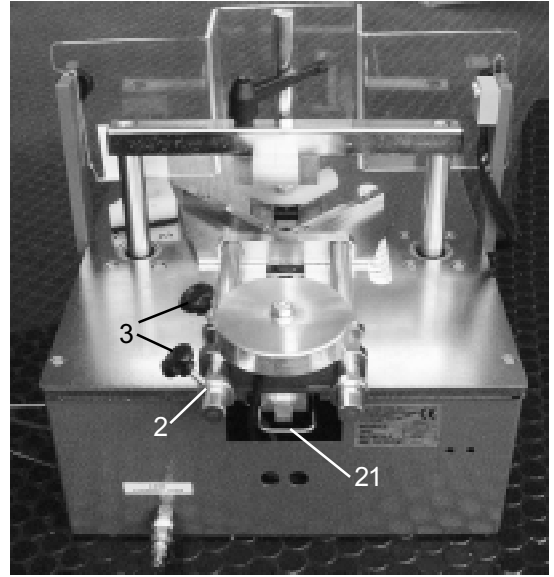
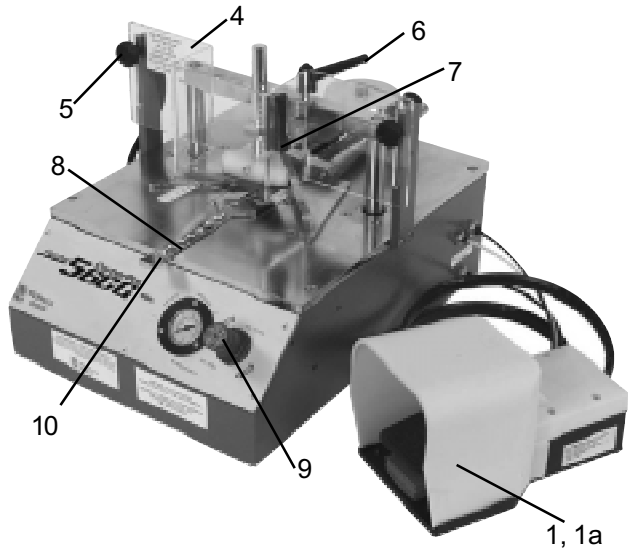
Caution: Wear Safety glasses while cleaning with compressed air.

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	CORRECTION
Sound of leaking air	Leaking at the air source nipple	Remove the air hose and reattach it.
	Leak at one of the hose connections to a valve	Feel for air leak, cut off 1/2" of hose and insert it again
	Pressure regulator set at more than 115 PSI (8 BAR)	Set the regulator at less than 115 PSI (8 BAR)
	Leakage in a valve or a cylinder	Contact Customer Service (see below)
Leak disappears when foot pedal is depressed	Hose connections between foot pedal and machine leaking	Reattach hoses at the foot pedal and the machine
Nail is not driven	Regulator set too low	Set regulator above 37 PSI (2.5 BAR)
	Nails jammed at hammer block	Remove nails and clean nail path
	Nails placed backwards in nail path	Remove and reload strip of nails
	Foot pedal operated too fast	Try again more slowly
	Spring follower not pushing strip of nails into position	Remove obstruction in nail path Replace broken follower spring Verify follower spring is attached
	Wrong compensator or not installed correctly	Replace compensator or insert it properly
	Edge of hammer is worn or damaged	Contact Customer Service (see below)
	The last 1/4 of the strip of nails will not feed	Add more nails
	No nails in the nail path	Load nails
Nail only partially driven into moulding	Air pressure set too low	Set regulator above 37 PSI (2.5 BAR)
	Upper clamp pad out of position	Re-position the upper clamp
	Upper clamp set too high above the frame	Position upper clamp 5/8" to 3/4" above moulding
	Edge of hammer is worn or damaged	Contact Customer Service (see below)
Foot pedal does not activate cycle	Foot pedal return spring broken	Contact Customer Service (see below)
	Air line not connected	Check line connection
	Valve is clogged or air line is blocked	Remove air line, clear obstruction, reattach
	Valve faulty	Contact Customer Service (see below)
	Air pressure set too low	Set regulator above 2.5 BAR (37 PSI)
	Automatic/Manual switch set to manual	Set switch to automatic

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



SPARE PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Quantity</u>
1	16-001	Foot Pedal Assembly	1
1a	16-002	Foot Pedal Valve	1
2	16-003	Stop Collar	2
3	16-004	Locking Knob	2
4	16-007	Plastic Guard	1
5	16-006	Plastic Guard Knob	2
6	16-011	Upper Clamp Slide Locking Lever	1
7	16-029	Upper Clamp Shaft Locking Lever	1
8	16-010	Front Clamp Operating Screw	1
9	16-009	Regulator Knob	1
10	16-070	Front Clamp Bar	1
11	16-074	Hex Wrench Set (5)	1
12	16-013	Magnet	1
13	16-037	Round Angular Pad	1
14	16-038	Round Angular Pad Bushing	1
15	16-036	Round Angular Pad Screw	1
16	16-039	Flat Angular Pad	1
17	16-040	Flat Angular Pad Screw	1
18	16-034	Gasket Set for Hammer Cylinder	1
19	16-035	Piston Assembly for Hammer Cylinder	1
20	16-022	Follower Spring	1
21	16-027	Follower	1
22	16-041	7mm Compensator	1
23	16-042	10mm Compensator	1
24	16-044	Pusher (10mm/12mm/15mm)	1
25	16-043	Pusher (7mm)	1
26	16-020	Hammer	1
27	16-023	Nail Block	1
28	16-024	Nail Path Guide	1
29	16-025	Nail Path Guide Screw	2