

SERVICE & INSTRUCTION MANUAL

MODEL NO. _____

VN-A

SERIAL NO. _____

PISTORIUS
MACHINE CO., INC.

PHONE: 516-582-6000
FAX NO. 516-582-6278
TELEX-971-383 PISTORIUS

1785 EXPRESS DRIVE NORTH • HAUPPAUGE, NEW YORK, U.S.A. 11788



1785 EXPRESS DRIVE NORTH (RT. 495) • HAUPPAUGE, NEW YORK 11787

WARRANTY

Seller guarantees all machines and parts of its own manufacture against defects in material and workmanship for a period of six months from date of shipment under normal use and service by buyer. No other warranties are to be implied with respect thereto. The liability of Seller under its warranty is limited to adjustment, in accordance with the Warranty Adjustment Terms set forth below, for products which are found to be defective by Seller in the form in which they were originally shipped. In no event will Seller be liable for collateral, consequential or other damages of any kind or nature.

WARRANTY ADJUSTMENT TERMS

- (a) Adjustments will be limited to claims which are presented promptly after the product is found to be defective, and within the aforesaid warranty period.
- (b) All products claimed to be defective will be subject to inspection and test by Seller. Normally, Seller will request return of products for inspection and test, however, Seller reserves the right to make inspection and test on Buyer's premises. Returns are to be made only as and if authorized in writing by Seller.
- (c) Buyer will pay all packing, inspection, labor, and transportation costs involved. Credit for the transportation costs only will be issued by Seller provided adjustment subsequently is allowed.
- (d) No adjustment will be allowed for products which have been subjected to abuse, improper installation or application, alteration, accident or negligence in use, storage, transportation or handling; nor for products on which original identification markings have been removed, defaced or altered.
- (e) Final determination as to whether any adjustment is allowable, and as to the extent thereof, rests with the Seller. Full adjustment if allowed, normally will be replacement in kind on an exchange basis. Pro rata adjustment if allowed normally will be made by the issuance of credit. In all cases, however, Seller reserves the right to make adjustment by repair, replacement or credit.
- (f) Replacements for products found subject to adjustment, whether new or repaired, will be shipped FOB city of destination with transportation charges prepaid by Seller.

INSTALLATION

Buyer shall install machinery purchased from Seller at Buyer's cost and expense, unless otherwise expressly stipulated, in writing. At the request of Buyer, Seller will recommend competent engineers to supervise the installation, and to instruct the Buyer in the proper operation, of the machinery and equipment. During such period of supervision and instruction, such personnel shall be deemed to be employees of the Buyer who shall pay the wages, remuneration, board and traveling expenses of such personnel shall not make Seller liable, directly or indirectly, in any manner whatsoever, for any damages resulting from any act of commission or omission or any misfeasance or malfeasance, on the part of any said personnel.

CANCELLATIONS OR RETURNS

Buyer shall not cancel any order nor return any equipment without first procuring the written consent of Seller. In any event, in case of refusal or inability of Buyer to accept a delivery, the Buyer shall nevertheless be liable for freight, express, storage, handling, restocking and any other expense resulting. In no event are orders for machines or parts built to customer specifications subject to cancellation and Buyer shall be liable for work done and materials used.

SAFETY RULES

READ BEFORE OPERATING OR MAINTAINING MACHINE

1. Make sure the area is hazard free of contaminated air, chips, debris, grease, oil, anything slippery, obstructions, etc.
2. Do not operate until properly instructed in the safe use of the machine.
3. Do not operate without all guards, shields, covers, etc. securely in place.
4. Make sure the machine is electrically grounded.
5. Remove or confine all loose clothing, hair, jewelry, bracelets, necklaces, etc.
6. Use all applicable safety equipment, goggles, face masks, gloves, etc.
7. Check the machine to be used for improper functioning, worn parts, wrong parts, wrong rotation, secure and correct tooling installed, damaged, etc.
8. Do not alter the machine, operate outside of design limits or use, etc.
9. During use do not put hands, or anything else, under guards, shields, covers, etc.
10. When not using the machine, leaving the area or cleaning the area, turn the machine off.
11. Do not clean, adjust, maintain or service the machine unless it is turned off and all power sources disconnected.
12. Keep the machine in good, safe repair and cleanliness.

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INSTRUCTIONS FOR VEE NAILER MODEL VN-A

UPON RECEIPT OF MACHINE

Check box or crate for any damage. Check that all parts ordered are included. Report irregularities to the delivery carrier, or so note on their copy of the bill of lading. The carrier is solely responsible for any transit damage or losses.

Machines are coated with a rust inhibitor on bare steel surfaces, this inhibitor should be removed prior to using machine.

INSTALLATION

Pick a location that is suitable for the work flow and safe for the operator with ample unobstructed freedom of movement.

Machine should stand solidly and be reasonably level.

Connect a clean, dry incoming air line to the inlet side of the Filter-Oiler-Regulator, which is mounted on the right machine support leg. For proper functioning a minimum air line of 3/8" ID is required.

Fill the oiler cup with Pneumalube or a light weight hydraulic oil. This lubricator cup is the second one from the incoming air connection.

To activate air into machine, push down PRESSURE RELEASE VALVE. Check to make sure all regulator gages (#1 & 9) are functional. All regulators are pre-set and tested at factory. They can, however, be adjusted according to customers needs.

After checking gages, pull PRESSURE RELEASE VALVE UP. Machine will now be inoperable.

NAIL LOADING

IN ORDER TO INSURE PROPER USAGE AND TO VALIDATE WARRANTY, PISTORIUS VEE NAILS MUST BE USED. USE OF ANY GENERIC NAIL NEGATES WARRANTY.

Make sure the black PRESSURE RELEASE VALVE is pulled UP.

Determine the height of the nail to be used. The moulding will determine height of nail. The 4 3/4" x 6 1/2" opening on the left side of the machine table will allow access to the nail fixture. Pull back the NAIL PUSHER ARM (S-6112-4) using the extended pin of the NAIL PUSHER (S-6111-4). Allow the push arm to seat at the beveled end of the NAIL MAGAZINE FEED TRACK (S-6126-4). Slide the black knob of the nail firing handle (#2) forward bringing the nail track under the opening. On the nailing fixture loosen the two allen head screws on the NAIL SIDE GUIDE (S-6126-7), slide the NAIL MAGAZINE FEED TRACK up or down according to the dictates of the nail size to be used allowing for approximately 1/32" to 1/16" clearance between the underside of

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the table and the top of the nail strip. Re-tighten the two allen head screws. Make sure these screws are tight, as they also set the side guide that forms the nail tunnel. Nails must be free feeding and set all the way into the fixture. Push nail stick in firmly making sure first nail seats flush against the DRIVER GUIDE (S-6376-1). Slide the NAIL PUSHER forward until it nest firmly against the nail stack.

CLAMP SETTING

Make sure PRESSURE RELEASE BUTTON is pulled UP.

For safety purposes the transparent PLASTIC GUARD (#7) should be in place directly over the TOP CLAMP PADS (#6).

Place two pieces of mitered corners into the nesting vee and butted together.

Loosen the TOP CLAMP LOCKING HANDLE located on the adjustable top clamp rod block.

Push the top clamp pads down until they contact the material and set pads to the most condusive holding area on the moulding. While holding this position, re-tighten the holding block via the locking handle. It may be necessary to temporarily slide plastic shield out of the way. The locking handle is a ratchet type handle and can be re-positioned by pulling UP and turning. Pushing IN re-positions handle into ratchet. If guard was removed, replace over clamps.

To set top clamp into UP position, activate PRESSURE RELEASE VALVE.

On models equipped with RABBIT JAWS (#4), open locking handle and slide jaw up into rabbit of moulding then slide back enough to allow for clearance for removal of material after joining (approx 1/2"). Lock jaw handle at this position.

To check the postion of the top clamps and inside jaw relative to the moulding, place SELECTOR SWITCH (#8) into CLAMP ONLY mode and step on foot pedal. Clamps will contact material on previous set positions. After checking, release foot pedal.

NOTE: ON NEWER MODELS SELECTOR SWITCH HAS 2 MODES - CLAMP ONLY & AUTO FIRE. IT IS NO LONGER NECESSARY TO HAVE "HARD"- "SOFT" MODES.

NAIL LOCATION

The position of the nail firing lock stop determines the position of the nail closest to the rabbit. There is a fixed dead stop for the location of the nail at the tip of the miter. This position is pre-set approximately 1/8" from the edge of the moulding. If necessary this can be adjusted by loosening the allen head clamp screw located above the pivot shaft, re-position the handle block on the shaft to suit and re-tighten. If two or more nails are to be driven along one miter, the adjustment handle, movement stop, should be set. This will position the nail

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furthest from the tip of the miter. Nails may subsequently be fired anywhere between these two points.

OPERATION

After loading nails, setting top clamp, rabbet clamp, and nail locations, you are ready to join frames.

For safety purposes, make sure the plastic guard is in position over top clamps.

Place your material against the fences with the mitered faces butted firmly together.

Make sure the "PRESSURE RELEASE VALVE" is activated to allow air into the machine.

Place SELECTOR SWITCH (#8) into clamp only or auto mode.

When you set selector switch for AUTO FIRE mode, step on the foot pedal, the top and rabbet clamps* will contact the material and almost simultaneously a nail will be driven from the nailing fixture into the moulding at the previously set nail location. For additional nails, move the FIRING HANDLE (#2) to pre-selected area for second nail and push FIRING HANDLE to the left. To piggyback or stack nails, repeat firing at same stop location. After corner is completed release foot pedal. All clamps will release allowing you to continue to next corner. Repeat process for each corner.

When you set select switch for CLAMP ONLY mode, the above sequence will follow except for the auto firing of the nail. At this point the auto fire is negated and all nail firing can be accomplished from the FIRING HANDLE (#2).

The interval between clamping and nailing is pre-set at the factory and cannot be adjusted.

When the nails are almost depleted, the machine will automatically shut down via the LOW NAIL SENSOR SWITCH and the PRESSURE RELEASE VALVE will pop up. Pull NAIL PUSHER back to resting area on NAIL FEED TRACK and reload with a new stack of nails. Re-activate the "PRESSURE RELEASE VALVE".

Note: * On models equipped with inside jaws, the jaws work independent of the top clamp. The normal setting is approximately 60 psi. This can be adjusted via the "PRESSURE REGULATOR" (#9). For harder woods this pressure should be increased to full line.

ADJUSTMENTS

The oiler on the FILTER-OILER-REGULATOR should be adjusted, via the knurled brass knob, so that one drop of oil is released for approximately 20 nail firings.

The amount that the nail is recessed into the wood can be adjusted by loosening the 3/8" allen head bolt on the drive cylinder block holding the cylinder. Pre-mark the the cylinder with a marking pencil and open only the bolt where the slit in the collar is located. Adjust to desired height and re-lock bolt. Access is through drop door in front of machine.

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The entire table may be re-positioned out of the horizontal plane and into a inclined (easel) position of 30 degrees. This is accomplished by removing the lower two (2) bolts, of the three, from each leg. Rotate the body to the vertical position and re-install the four bolts. Tighten bolts.

The filter-oiler is equipped with a regulator which controls the nailing pressure. This is factory set at 90 psi and should not need adjusting.

SAFETY

Make sure the clear plastic guard is in place before using the machine.

Keep hands from underneath the clamping guard.

Always de-energize air into machine by pulling "PRESSURE RELEASE VALVE" to the UP position when not using machine or when making any changes.

Use only Pistorius VEE NAILS to insure proper functioning of the nailing fixture and to protect warranty.

MAINTENANCE

When performing maintenance always disconnect the incoming air line.

When empty refill the oiler bowl with PNEUMALUBE OIL. The bowl can be unscrewed from its housing being careful to reset the rubber "O" ring into the housing.

Moisture accumulated in the filter bowl can be drained either by opening the black knurled screw located at the bottom of the bowl or by pressing in the drain button also located at the bottom of the bowl. This process is dictated by the type of filter-oiler-regulator used on your machine.

Clean the NAIL DRIVER (S-6366-1) and the DRIVER TUNNEL of any glue or foreign matter with lacquer thinners or a strong solvent.

When the lip of the driver no longer has sharp corners it should be replaced or re-ground. If re-grinding, the driver face must be ground flat and square with the sides.

Upon receipt of machine and as a maintenance procedure exposed metal parts should be protected with a light oil (WD-40).

Maintain the work area as clean as possible. Using a cotton swab dipped into lacquer thinners or equivalent, wipe the inside of the nail track to remove any residue left by the nails. Clean the NAIL DRIVER with thinners and a clean rag. REMOVE NAILS PRIOR TO THIS CLEANING. DO NOT REPLACE NAILS UNTIL DRIVER AND TUNNEL ARE DRY. BLOW OR AIR DRY ALL PARTS CLEANED.

Lubricate the driver and tunnel with a light weight machine oil. Four or five drops of oil into the drive tunnel daily is sufficient. Oiling will not harm the operation. On heavy production runs the machine should be cleaned and lubricated more often.

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The most common area of glue build-up is the fence nesting vee, Any glue build-up should be remove before it dries. If glue hardens it can be removed by using thinners and a razor blade

Re-fill the oiler bowl when indicated on bowl housing. This can be done either by unscrewing the bowl from its housing or by removing the oil filler plug located on the top of filter- oiler-regulator housing.

Drain the air filter bowl by opening the knurled screw at the bottom of the bowl until empty of fluid and re-tighten.

VEE NAIL TROUBLE SHOOTING

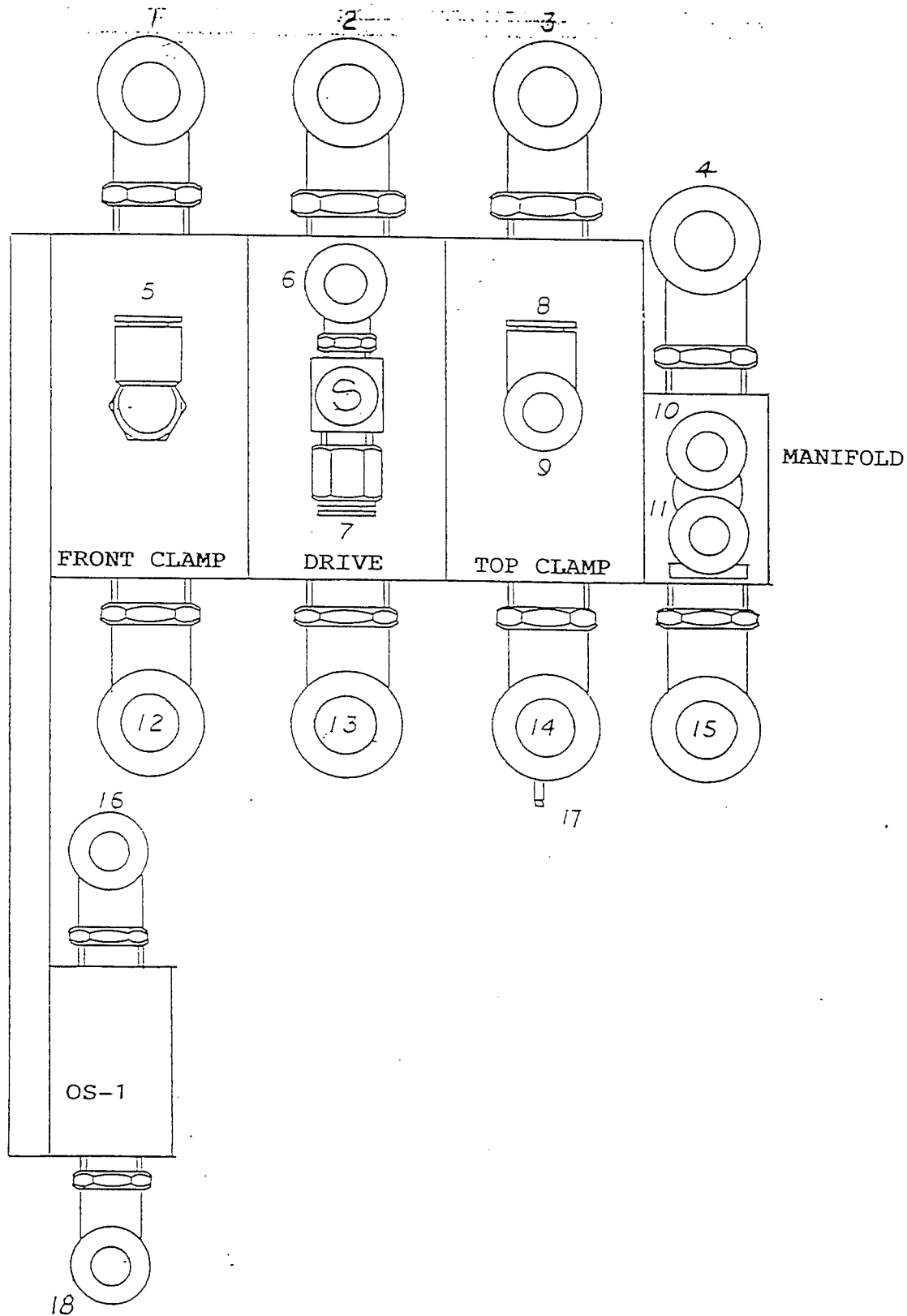
<u>PROBLEM</u>	<u>CORRECTION</u>
1.- Machine does not cycle.....	Main air valve stuck. Air pressure set below 20 psi. low nail sensor switch off.
2.- No nail driving.....	Nail stick binding in feed track. First nail not against driver guide.
3.- Two nails entering track.....	Nail stripper opening too large. Fixture needs reworking or replacing.
4.- Nail protruding from wood.....	Drive cylinder set to low. Nails not sharp or wood too hard. Driver pushing edge not sharp/ cornered. Nail stripper opening too large.
5.- Nail driver jamming.....	Slanted nail stack causing driver to strick middle of nail.
6.- Machine cycling to slow.....	Sticking main valve.
7.- Excessive oil exhausting.....	Reduce oil flow at oil lubricator.
8.- Not able to stack nails.....	Worn fixture. Replace

TROUBLE SHOOTING AIR SYSTEM ON MODEL VN-A

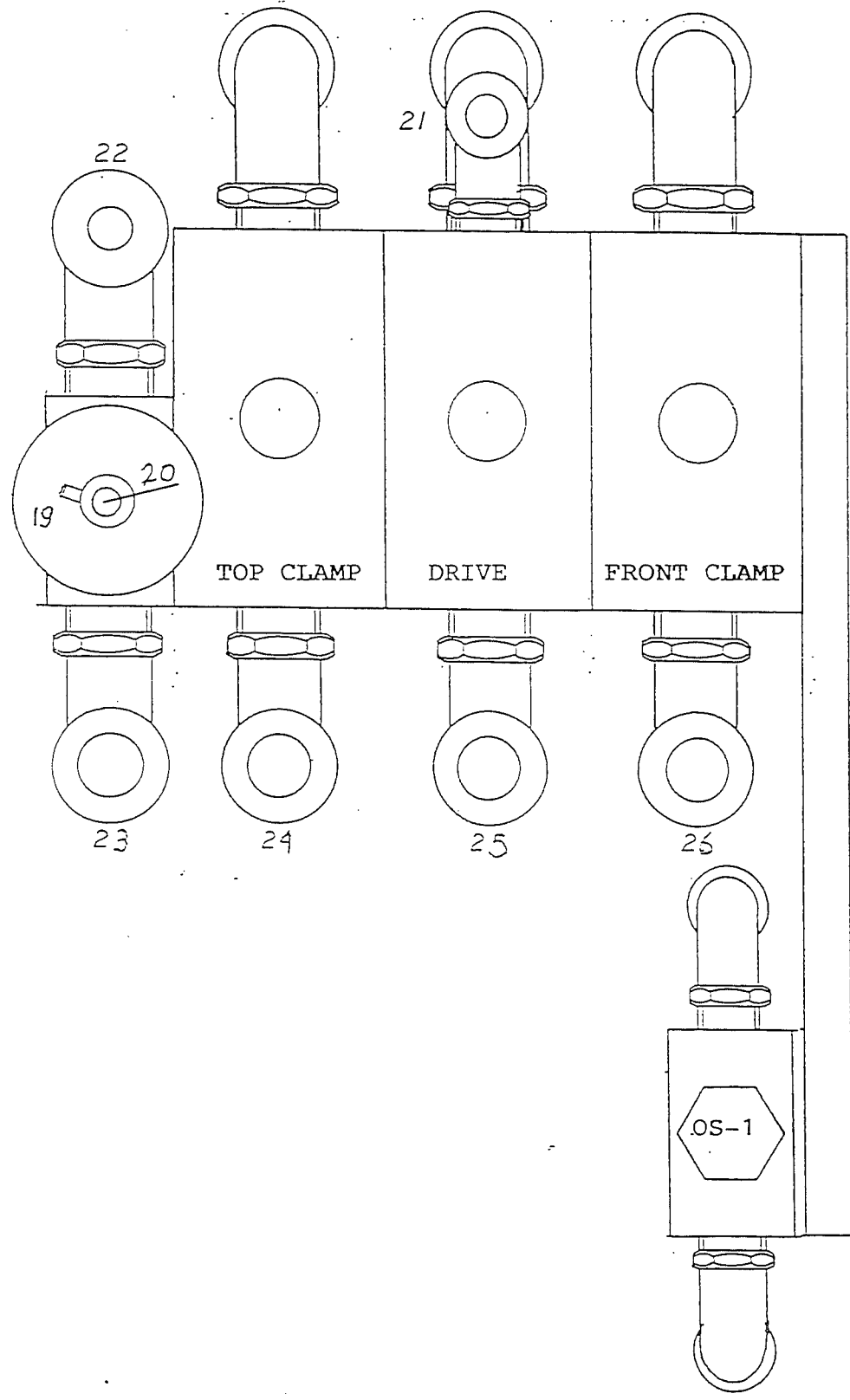
1. Remove nails from magazine, keep air connected.
2. With the air connected into machine, depress foot valve to activate air system. Selector switch must be set on "CLAMP ONLY".
3. Activate FIRING HANDLE towards the left hand side of the machine, and keep it activated for more than few seconds. No air leaks must be present.
4. If air starts to exhaust out of system, check the location.
 - a) Air exhausting from any open port at valve #1 (check diagram), RABBIT CLAMP CYLINDER must be checked.
 - b) Air exhausting from open port at valve #2, DRIVE CYLINDER must be checked (drive cylinder trouble shooting list).
 - c) Air exhausting from any open port at valve #3, TOP CLAMP CYLINDER must be checked.
5. Any other areas where air leaks are present, they must be found, and rectified.
6. If the air is exhausting out of the open ports on the valves check the condition of the valves, internal spools must be checked, by removing the end cups of valves (check diagram) carefully remove SPRING and SPOOL, inspect condition of "O" rings and springs.

Any scars, or if the spool does not slide smoothly in the valve, spools must be replaced. They can be checked by reversing the position inside the valves, assemble complete valve and activate machine again. If condition does not improve, replace the complete valve. Before removing the hoses out of bad valve, make a schematic list to prevent mistakes.
7. The small diameter hose connected to the PILOT side of DRIVE VALVE (check diagram on #2 valve) may be removed to prevent back pressure from a "weak valve" to interfere with the performance of the DRIVE CYLINDER, this will speed up the operation, and machine can be used in this mode.

PNEUMATIC ASSEMBLY (VIEW LEFT)



PNEUMATIC ASSEMBLY (VIEW RIGHT)



7A

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REFENCE NUMBERS.

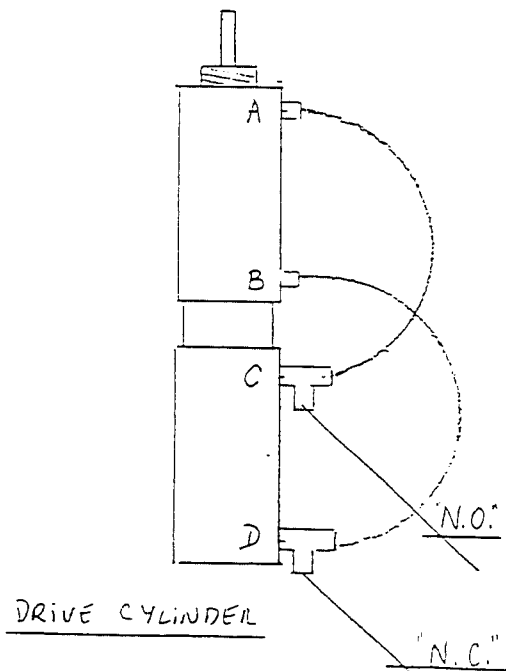
- 1.-IN LINE FRONT CLAMP REGULATOR.
- 2.-IN LINE FROM MANIFOLD.
- 3.-IN LINE FROM MANIFOLD.
- 4.-SUPPLY LINE INTO DRIVE VALVE. (PORT#2)
- 5.-SUPPLY LINE FROM TOP CLAMP.(PORT#8)
- 6.-SUPPLY LINE FROM FIRING HANDLE.
- 7.-SUPPLY LINE FROM OS-1 VALVE.(CYL.PORT#18)
- 8.-SUPPLY LINE INTO FRONT CLAMP.(PORT #5)
- 9.-N.C. LINE FROM FOOT PEDAL.
- 10.-SUPPLY LINE INTO FOOT PEDAL.
- 11.-SUPPLY LINE INTO LOW LIMIT NAIL SWITCH.(M.S.V. IN)
- 12.-N.C.LINE INTO FRONT CLAMP CYLINDER.
- 13.-N.C. LINE INTO DRIVE CYLINDER.
- 14.-N.C. LINE INTO TOP CLAMP CYLINDER.
- 15.-MAIN SUPPLY LINE INTO AIR CIRCUIT.
- 16.-SUPPLY LINE FROM SELECTOR SWITCH.
- 17.-SUPPLY LINE INTO BOOSTER VALVE.(PORT# 20)
- 18.-AUTO MODE SUPPLY INTO DRIVE VALVE (PORT# 7)
- 19.-BOOSTED SIGNAL INTO SELECTOR SWITCH.
- 20.-SUPPLY LINE FROM TCP CLAMP VALVE (PORT #17)
- 21.-NOT USED
- 22.-SUPPLY LINE INTO FRONT CLAMP REGULATOR.
- 23.-SUPPLY LINE INTO TOP CLAMP REGULATOR.
- 24.-LINE INTO TOP CLAMP CYLINDER. (N.O.)
- 25.-LINE INTO DRIVE CYLINDER (N.O.)
- 26.-LINE INTO FRONT CLAMP (N.O.)

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TROUBLE SHOOTING DRIVE CYLINDER

VN SERIES

- 1.-Disconnect air into machine, and remove nails.
- 2.-Remove hose from "N.C" fitting on the DRIVE CYLINDER ("D").
- 3.-Connect air into machine, if air exhausts out of:
 - a) Removed hose, DRIVE VALVE should be replaced.
 - b) Fitting at the cylinder, DRIVE CYLINDER must be replaced.
- 4.-Disconnect air into machine again. Reverse connection of hoses at the drive cylinder. Hose marked N.C connect at the port "C", and hose N.O into port "D".
- 5.-Connect air into machine DRIVE CYLINDER will activate. Remove hose connected to port "A", air SHOULD NOT exhaust out of hose or the fitting at the cylinder. If air is present DRIVE CYLINDER MUST BE REPLACED.





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INSTRUCTIONS ON FIXTURE REPLACEMENT VN-A

- 1.-Disconnect air into machine.
- 2.-Remove TOP air line and fitting from drive cylinder, loosen 3/8" allen screw (see diagram A) at the mounting block, this will release drive cylinder assembly complete with the driver and linkage still attached.
- 3.-To disengage handle linkage out of nailing fixture slide firing handle towards the back of machine as far as possible. Using a 9/16" closed end wrench, reach from top of machine (open tray area) and remove rear locking nut from threaded rod only (see diagram B). Push nailing fixture towards back of machine this will release threaded rod out of the HEIM joint.

* Machines build after JULY 1990 handle linkage is attached *
* to the nailing fixture with a 3/8 allen screw and a spacer*
- 4.-Remove low nail sensing switch (M.S.V) attached to fixture underneath nail magazine.
- 5.-To disengage NAILING FIXTURE out of mounting bracket remove the TWO 3/8 allen screws located to the right side of assembly (above slide bar #1). Nailing fixture can be removed tilting bottom of plate to the left hand side of slide bar #2, using some force then pull towards the front of machine. After fixture is out of machine remove HEIM joint with locking nut without disturbing the setting. If nailing fixture does not release from machine loosen slide bars #1 and #2, back off height adjustment screw few turns until the nailing fixture drops out of machine.
- 6.-Install rod end bearing (HEIM joint) in the NEW FIXTURE, and fasten locking nut against plate without disturbing the original setting.
- 7.-Place NEW NAILING FIXTURE into machine, using the two (2) allen screws assemble with cylinder mounting bracket. Make sure fixture assembly slides front to back of machine on top of bar #2 with minimum play. If you backed off height adjustment screw, you must reset bar #2 after complete assembly is locked in place, taking out excessive play on top of the nailing fixture.
- 8.-Replace M.S.V into fixture. Insert threaded rod of handle linkage through eye of rod end bearing and fasten locking nut at the back of assembly (HEIM joint).

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- 9.-Before replacing DRIVE CYLINDER ASSEMBLY into machine you must replace driver, and inspect complete linkage. If pins are bent or broken replace assembly at this time. Insert drive cylinder through mounting block, notice lip of driver must be towards back of machine, fasten 3/8 allen screw to lock cylinder in place. Remember to re-set height of the drive cylinder to original position to prevent damage.
- 10.-Before starting operation lubricate sliding bars, and NEW DRIVER with oil. Make sure firing handle moves front to back with the complete assembly.
- 11.-Excessive play between firing handle and nailing fixture is cause by worn linkage and should be replaced.

CAUTION:

TO INCREASE PERFORMANCE OF NEW FIXTURE REMEMBER TO LUBRICATE DRIVER ON REGULAR BASIS DEPENDING OF PRODUCTION RATE.

USE ONLY PISTORIUS MATCHED NAILS OR WARRANTEE WILL BE VOID.

ORDER REPAIR PARTS

BY:

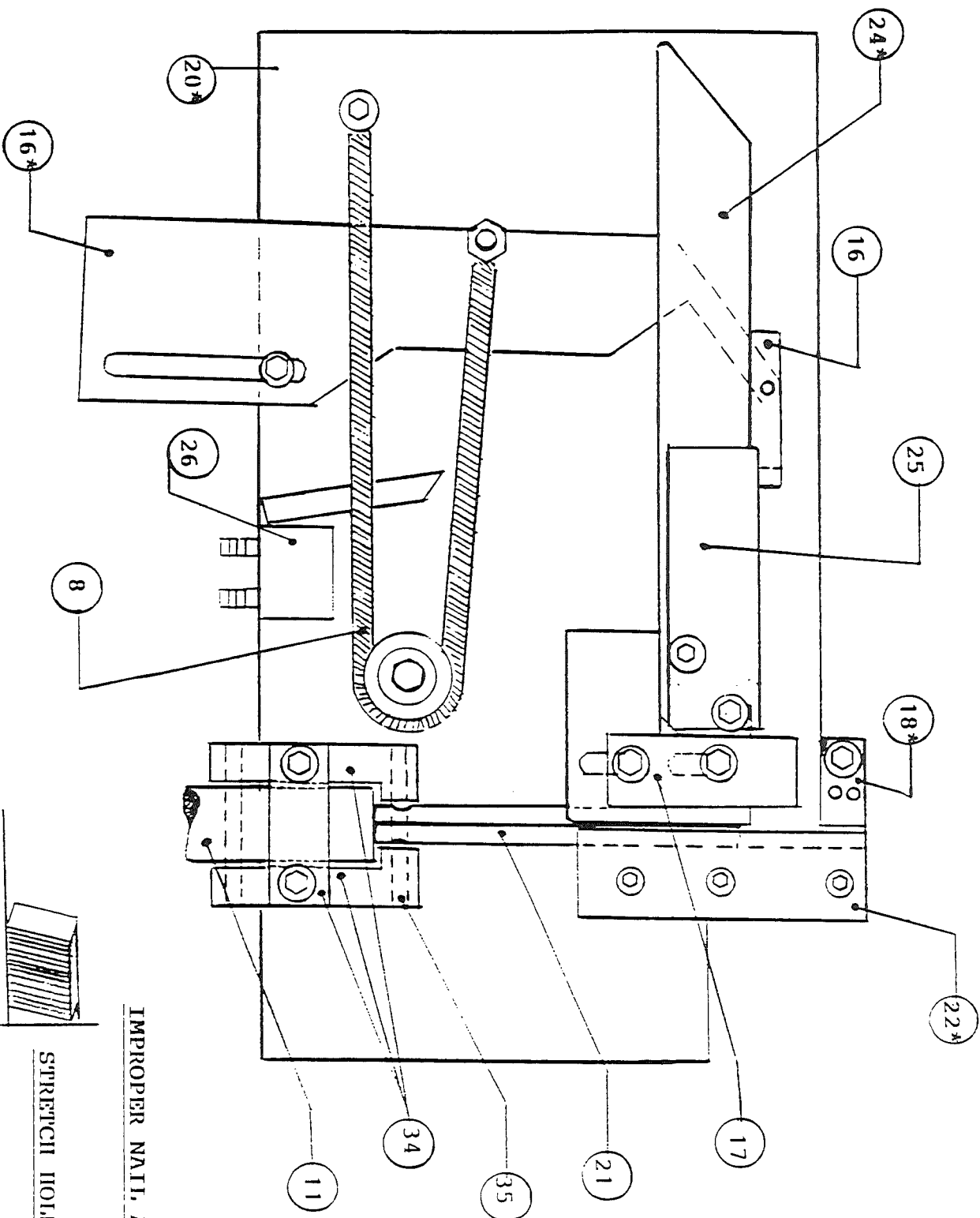
MACHINE MODEL NUMBER

MACHINE SERIAL NUMBER

PART NUMBER

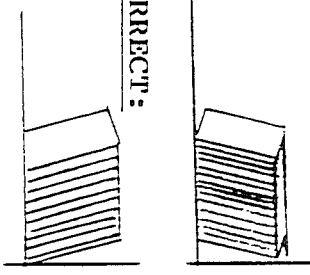
PART NAME

QUANTITY



NON REPLACEABLE
REPLACEMENT ONLY AS COMPLETE ASSY.

TO CORRECT:

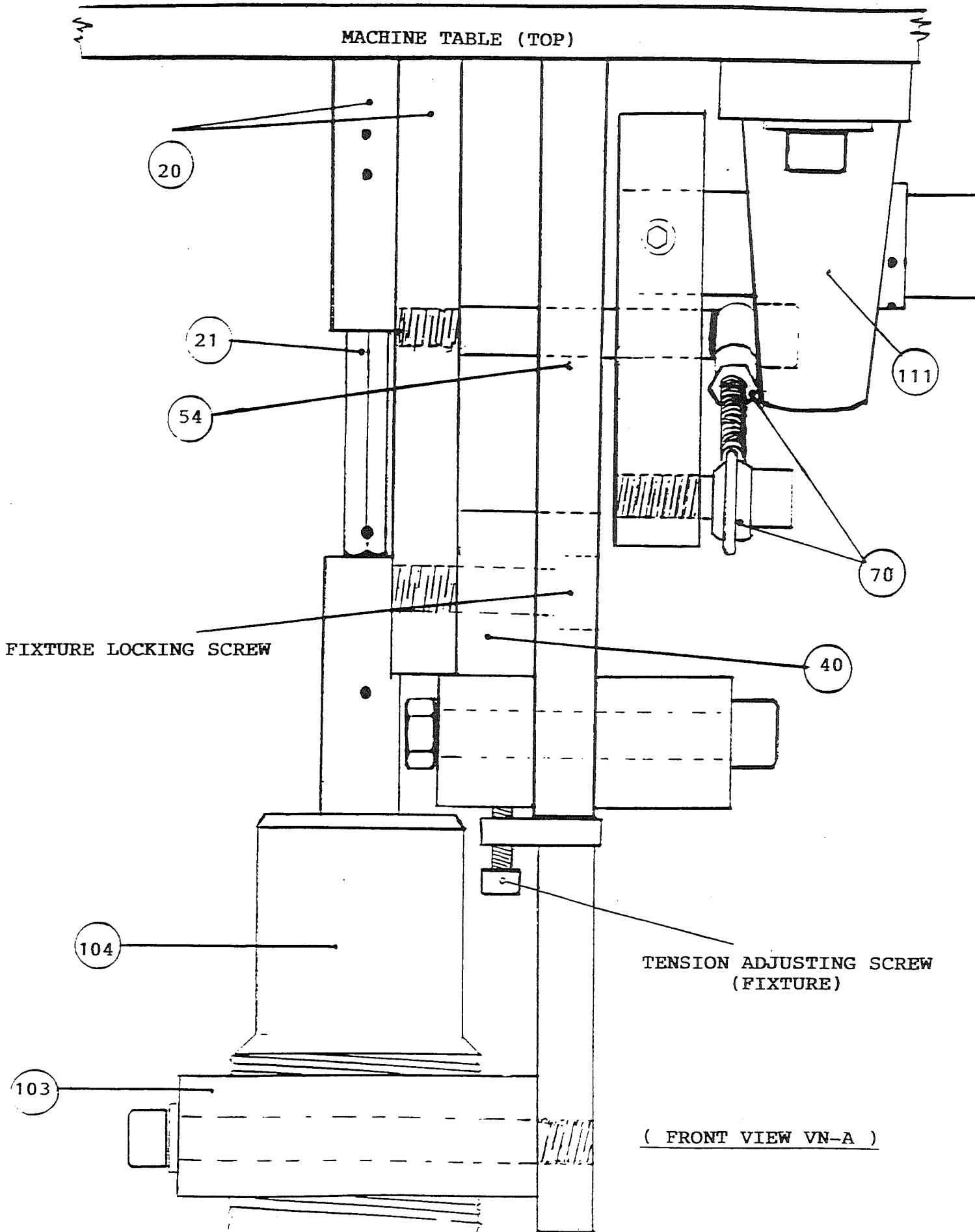


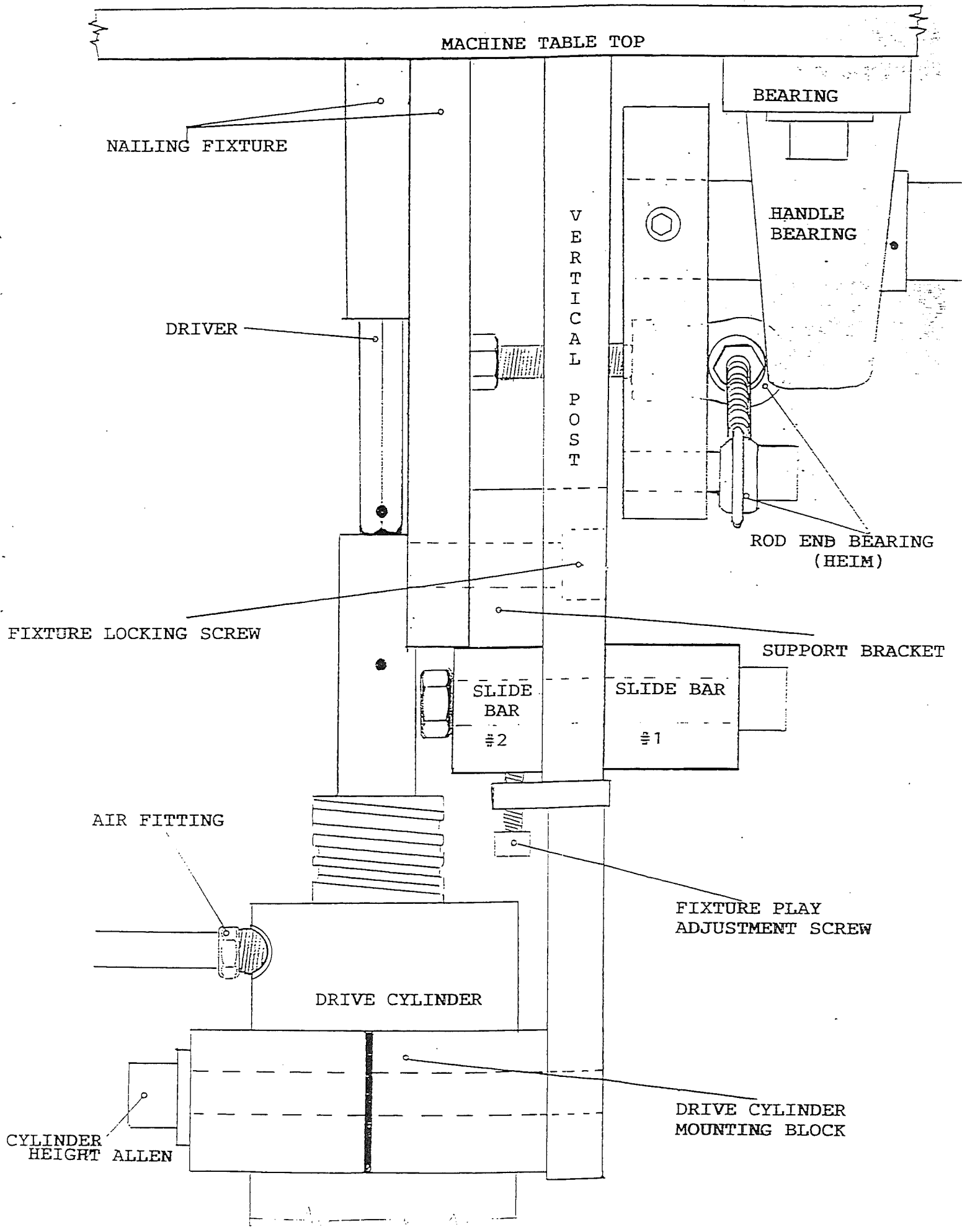
**PUSH NAIL AGAINST
 DRIVER GUIDE (#22)**

STRETCH HOLDING TAPE

IMPROPER NAIL ALIGNMENT

MACHINE TABLE (TOP)





MACHINE TABLE TOP

NAILING FIXTURE

DRIVER

FIXTURE LOCKING SCREW

AIR FITTING

DRIVE CYLINDER

CYLINDER HEIGHT ALLEN

VERTICAL POST

BEARING

HANDLE BEARING

ROD END BEARING (HEIM)

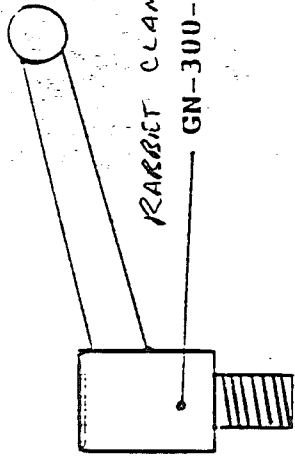
SUPPORT BRACKET

SLIDE BAR #2

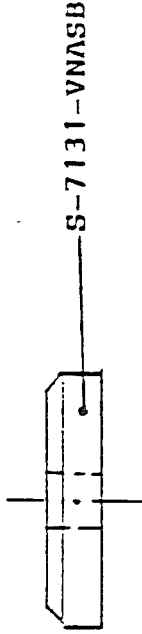
SLIDE BAR #1

FIXTURE PLAY ADJUSTMENT SCREW

DRIVE CYLINDER MOUNTING BLOCK

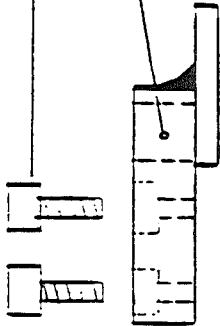


RABBIT CLAMP LOCKING HANDLE
GN-300-92



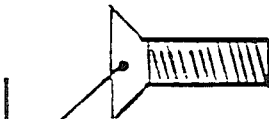
S-7131-VNASB

10/32 x 1/2 SCREENS



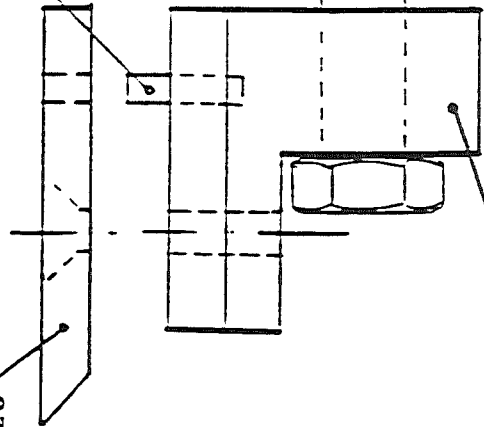
VNI00027
VNA SB RABBIT CYLINDER MOUNT

5/16 18 FLAT HEAD SCREW

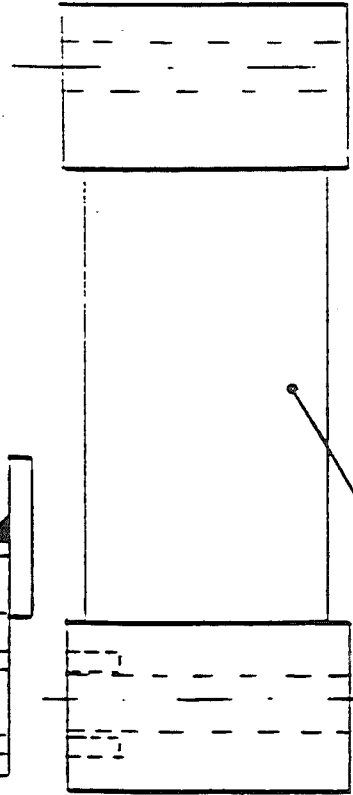


SETTING PIN

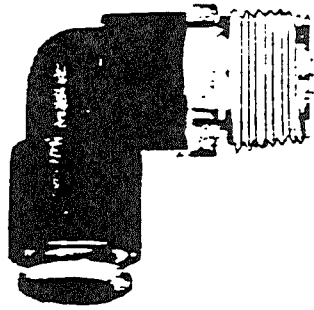
VNA SB RABBIT CLAMP JAW
VNI00028



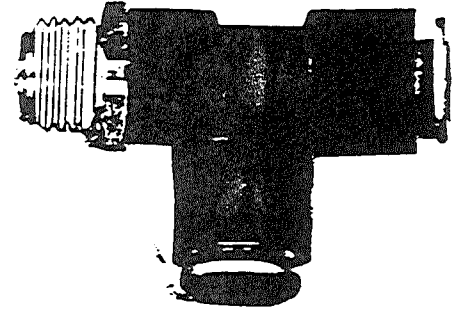
VNI00026



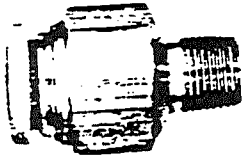
1/2 x 1 AIR CYLINDER



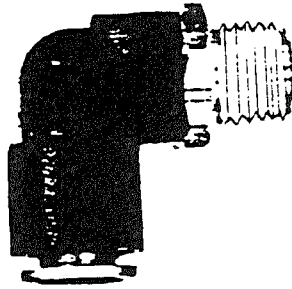
KQL-11-36S



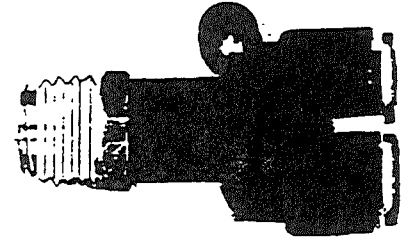
KQY-11-35S



68PL-6-2



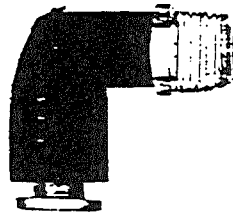
KQL-11-35S



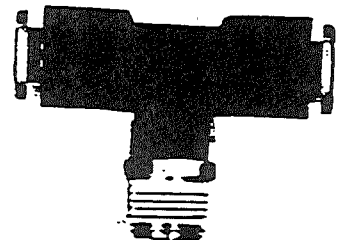
KQU-07-35S



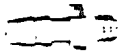
KQH-07-34S



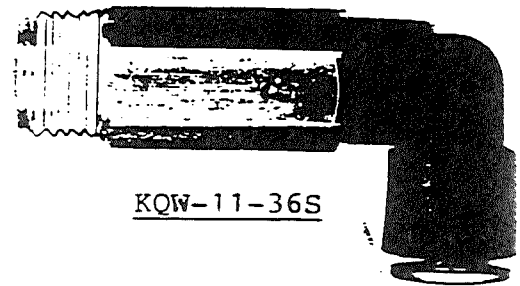
KQL-07-34S



KQT-07-34S



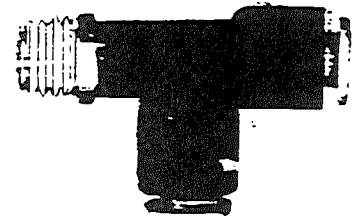
BF-1



KQW-11-36S



KQH-11-35S



PISTORPUS

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AIR FITTINGS VN-A

A) ELBOW CONNECTORS

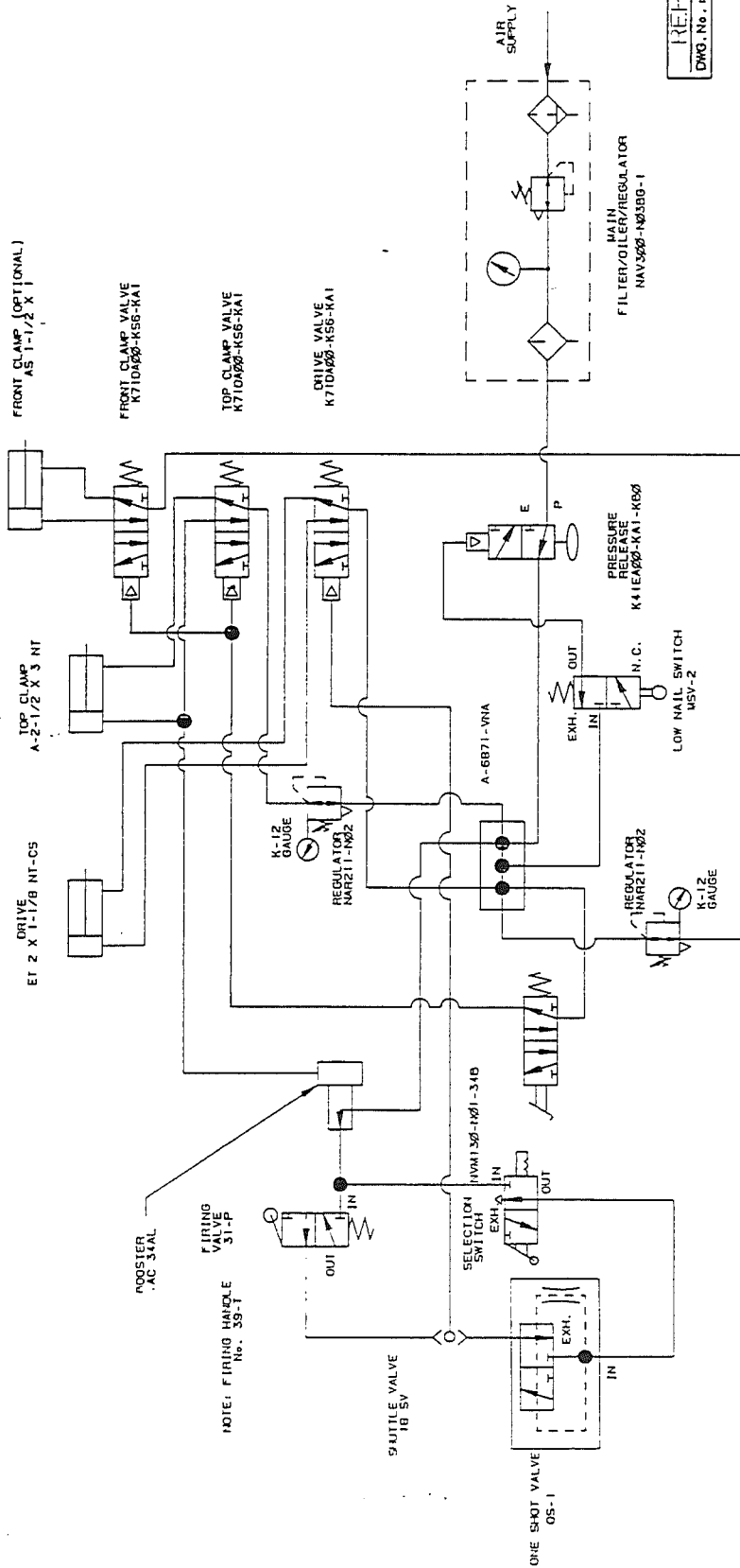
1-	KQL-07-34S	1/8" NPT - HOSE DIAMETER 1/4"	8
2-	KQL-07-35S	1/4" NPT - HOSE DIAMETER 3/8"	19
3-	KQL-11-36S	3/8" NPT - HOSE DIAMETER 3/8"	5

B) "TEE" FITTINGS

1-	KQY-07-34S	1/8" NPT - HOSE DIAMETER 1/4"	1
2-	KQT-07-34S	1/8" NPT - HOSE DIAMETER 1/4"	1
3-	KQU-07-53S	1/4" NPT - HOSE DIAMETER 1/4"	1
4-	KQY-11-35S	1/4" NPT - HOSE DIAMETER 3/8"	2

C) STRAIGHT CONNECTORS

1-	68PL-6-2	1/8" NPT - HOSE DIAMETER 3/8"	1
2-	KQH-07-34S	1/8" NPT - HOSE DIAMETER 1/4"	3
3-	BF-1	10 32 THD- 1/8" I.D HOSE 1/4" LONG	4



REPLACES
 DWG. NO. 1 ADV1002B

PISTORIUS MACHINE CO., INC.
 1785 EXPRESS DRIVE NORTH, HAUPPAUGE N.Y. 11788, USA

CUSTOMER: -	MACHINE: VNI-A	SCALE: -
DATE: 10/12/1990	DRAWN BY: RST	INVOICE NO: -
DRWG. NO. 1 ADV1002B THIS IS A PROPRIETARY DRAWING. ALL DESIGN DETAILS ARE THE EXCLUSIVE AND CONFIDENTIAL PROPERTY OF PISTORIUS MACHINE CO.		

ALL UNSPECIFIED TOLERANCES

.XX	+/- .01
.XXX	+/- .005
FRACTIONS	+/- 1/64
ANGLES	+/- 1 DEG

NAME: PNEUMATIC DIAGRAM (CUSTOMER COPY)

QUANTITY: -
MATERIAL: -
TREATMENT: -

1785 EXPRESS DRIVE NORTH • HAUPPAUGE, NEW YORK, U.S.A. 11788
PARTS LIST

MODEL SERIES VN-A

REF #	PART #	DESCRIPTION	EA #
1	AS-1 1/2 x1	RABBET CLAMP CYLINDER	1
2	A 2 1/2 x3 NT	TOP CLAMP CYLINDER	1
3	A-6871-VNA	AIR MANIFOLD (VN-A)	1
4	AU300-1R	VNA NAU300 REG. REPAIR KIT	1
5	B-32	MOUNTING BRACKET NAU300	1
6	B-34	REID 1 5/8" PLASTIC HANDLE BALL	1
7	BF-1	HUMPREY 10/32 1/4" BARB. FITTING	3
8	E .029	6 3/4" LONG MAGAZINE SPRING	1
9	CW-10 6	TOP CLAMP CYLINDER ROD END BRG.	1
10	E .037	M/W SPL SPRING CLAMP PADS	2
11	ET2x1x1/8-NT	DRIVE CYLINDER (OLD 5/92)	1
12	ET-2-P	DRIVE CYL. REPAIR KIT	1
13	GN-300-92	RABBET CLAMP LOCKING HANDLE	1
14	GN-300-78	TOP CLAMP AND STOP ADJ. HANDLE	1
15	S-6111-4-VN	MAGAZINE SPRING ROLLER	1
16	S-6112-4-VN	VNASB NAIL PUSHER ARM (ASSY)	1
17	S-6126-3-VN	NAIL SIDE GUIDE	1
18	S-6211-2-VN	NAIL STRIPPER (NON REPLACEABLE)	1
19	K-12	1/4" CBM 0-160 PSI SMC GAUGE	2
20	S-6363-VN	VNASB COMPLETE NAILING FIXTURE	1
21	S-6366-1-VN	VNASB DRIVER	1



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22	S-6376-1-VN	DRIVER GUIDE (NON REPLECEABLE)	1
23	LP000030	CLAMP ONLY-AUTO FIRE LABEL	1
24	S-6432-4&5	NAIL MAGAZINE TRACK (L & R)	1
25	S-6485-4-VN	NAIL TRACK SIDE GUIDE (SS)	1
26	MSV-2	VNAS LOW NAIL SENS. VALVE	1
27	K41DA00-KS1	NORGREN 3 WAY VALVE (OLD SYS)	1
28	K71DA00-KS6	NORGREN 4 WAY VALVE	3
29	K41EA00-KA1	NORGREN 3 WAY PRESS. RELEASE	1
30	P-6376-2-VN	R/H POLYURETHANE CLAMP PAD	1
31	P-6376-4-VN	L/H POLYURETHANE CLAMP PAD	1
32	NAR211-N02	PANEL REGULATOR 1/4" SMC	2
33	NAU300-1R	NAU300 REG. REP[AIR KIT	1
34	S-6918-1-2-3	DRIVER LINKAGE ASSY.	1
35	S-6918-4-VN	DRIVER LINKAGE REPLACE PINS	2
36	S-6124-2-VN	L/H CLAMP PAD HOLDER	1
37	S-6124-3-VN	R/H CLAMP PAD HOLDER	1
38	S-6124-4-VN	TOP CLAMP ADJUSTABLE ARM	1
39	S-6124-5-VN	TOP CLAMP PIVOT BLOCK	1
40	S-6126-1-VN	CYLINDER MOUNT	1
41	S-6126-2-VN	CLAMP CYLINDER PIVOT MOUNT	2
42	NAU300-NO3BG	FIL.OIL.REG W/GAGE & BRACKET	1
43	NVM130-NO1	3 WAY SELECTOR SWITCH SMC	1
44	S-6128-VN	VNA-FA SUPPORT LEG	2
45	S-6137-1-VN	VNA MULTIFIRE HANDLE MOUNT	1
46	S-6137-2-VN	VNA MULTIFIRE HANDLE	1

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47	S-6137-3-VN	VNA MULTIFIRE STOP	1
48	S-6137-5-VN	VNA MULTIFIRE WAYS MOUNT REAR	1
49	S-6137-6-VN	VNA MULTIFIRE WAYS MOUNT FRONT	1
50	S-6137-7-VN	VNA MULTIFIRE WAYS	1
51	S-6143-1-VN	RIGHT HAND WORK SUPPORT	1
52	S-6143-2-VN	LEFT HAND WORK SUPPORT	1
53	S-6216-1-VN	DRIVE CYLINDER MOUNT	1
54	S-6218-1-VN	VNA GUIDE STRAP	1
55	S-6218-2-VN	VNA GUIDE TRACK BACK UP	1
56	LP000033	FRONT CLAMP LABEL	1
57	LP000029	PRESSURE RELEASE LABEL	1
58	S-6115-6-VN	VNAFA TOP CLAMP SPACERS	2
59	S-6124-1-VN	VNAFA FORKED CLAMP HOLDER	1
60	S-6218-6-VN	VN OCTAGON NEST VEE	1
61	S-5290	FOOT PEDAL GUARD	1
62	34AL/3P/BF1	BOOSTER VALVE ASSEMBLY	1
63	S-6432-7-VN	DRIVER PINS W/GROOVE (OLD)	2
64	S-6478-1-VN	VNA-FA L/H SIDE PLATE	1
64	S-6874-2-VN	VNA-FA R/H SIDE PLATE	1
65	S-5481-VN	VNA-FA TOP TABLE	1
66	S-6485-1-VN	VNA POSITION ARM SHAFT LINK	1
67	S-6485-2-VN	VNA LINKAGE POSITION ARM	1
68	S-6485-3-VN	VNA POSITIONING SHAFT	1
69	3W 250	VNFA FOSTER PRESSURE RELEASE	1
70	SA-7069-VNA	MULTI-POSITION LINKAGE KIT	1

PETROLAUS

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71	S-6488-VN	VNASB RABBET CLAMP ASSY.	1
72	S-6529-1-VN	VNA TOP CLAMP MOUNT	1
73	V-3108	VNA AIRMITE FOOT PEDAL	1
74	31 P	VNA FIRING VALVE	1
75	T 2.5	TOP CLAMP TRUNION MOUNT	1
76	VNF00048	ADJ. FRONT CLAMP GUIDE (NEW STYLE)	1
77	VNF00049	VNAFA RABBET JAW SUPP MNT(NEW S)	1
78	UCP205-100T	PIVOT CLAMP BEARING	2
79	VNF00050	VNA-FA RABBET CLAMP JAW (NEW S)	1
80	VNA00025	VNA PLASTIC SHIELD (OLD)	1
81	VNA00026	VNA-FA PLASTIC NAIL PAN	1
82	VNA00027	VNA-FA PLASTIC FRONT DOOR	1
83	VNA00028	VNA ABS CONTROL PANEL DOOR	1
84	VNI00026	VNASB CLAMP JAW SUPPORT MNT	1
85	VNI00028	VNASB RABBET CLAMP JAW	1
86	VNI00027	VNASB RABBET CYLINDER MOUNT	1
87	VNI00031	VNASB NEST VEE (BLACK OX)	1
88	113079-3F	SMC AU300 BOWL/GUARD (FILTER)	1
89	113079-3L	SMC AU300 BOWL/GUARD (CILER)	1
90	125 SH	NOVIMATIC SHUTTLE VALVE	1
91	1400-5	FABCO (14SP) RETURN SPRING	3
92	1400-904	FABCO SPOOL (14SP OLD SYSTEM)	3
93	14SP-4	FABCO 4 WAY VALVE (OLD SYSTEM)	3
94	250-SH	NOVIMATIC SHUTTLE VALVE (OLD)	1
95	68PL-6-2	GLUE TANK CONNECTOR FITTING	1

RETORFUS

MACHINE CO., INC.

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96	54261-03	NORGREN SPOOL CUP	3
97	5/8-11x 4"	TOP CLAMP ALLEN SOCKET SCREW	1
98	54237-56	NORGREN SPOOL ASSY. (K71)	3
99	54237-59	NORGREN SPOOL ASSY. (K41)	1
100	54261-02	NORGREN SPOOL PLUG TUBING	1
101	S-6137-8-VN	MULTIPOSITION HANDLE SPACER	1
102	S-6128-8-VN	CLAMP PAD PIN	2
103	A-7150-VN	VNASFA DRIVE CYL. MOUNT (THD)	1
104	D-45014-A	VNAS NEW DRIVW CYLINDER (THD)	1
105	S-6124-9-VN	CLAMP SHAFT EXTENSION	1
106	5/8x11 NUT	TOP CLAMP LOCKING NUT	1
107	S-6115-5L	VNA LEFT HAND GUIDE TRACK	1
108	S-6115-5R	VNA RIGHT HAND GUIDE TRACK	1
109	S-7131-VN	RABBET HANDLE WASHER	1
110	113414	REPLCMENT KNOB FOR NAR211 REG.	2
111	UCP204-012	PILLOW BLOCK BEARINGS	2
112	S-6218-5-VN	FENCES (BLACK OX)	2

