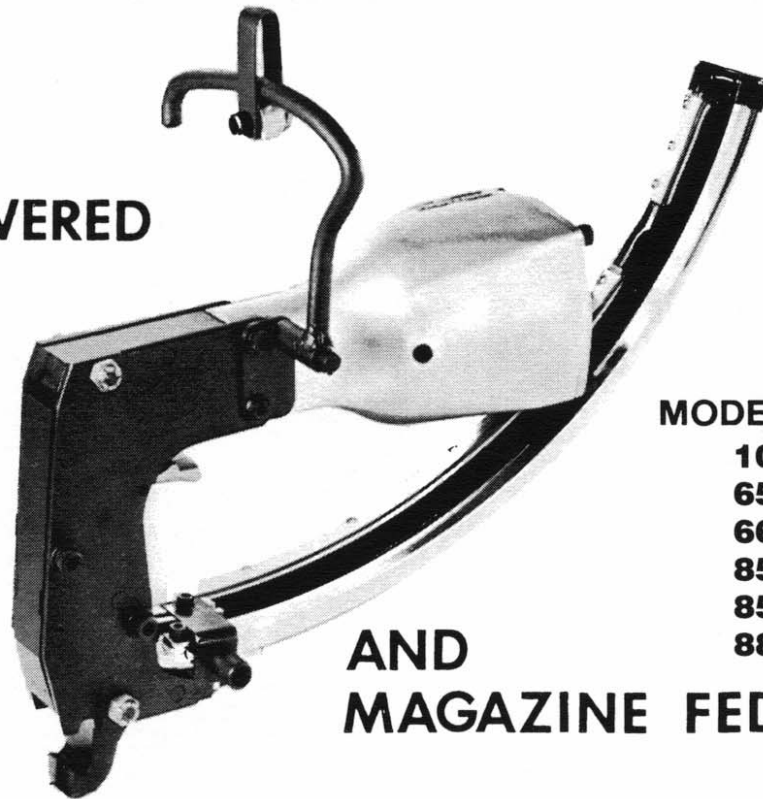


# HARTCO CLINCHING TOOLS

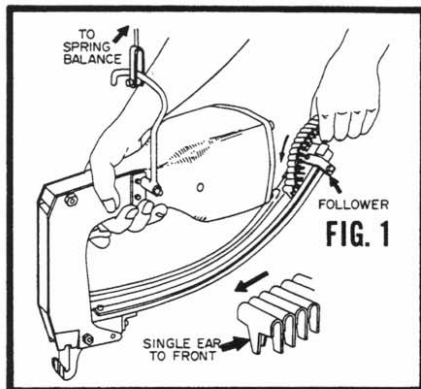
## Instruction and Parts Manual

**AIR  
POWERED**



**MODELS:  
100(55)  
65AT  
66  
85  
85S  
88**

**AND  
MAGAZINE FED**

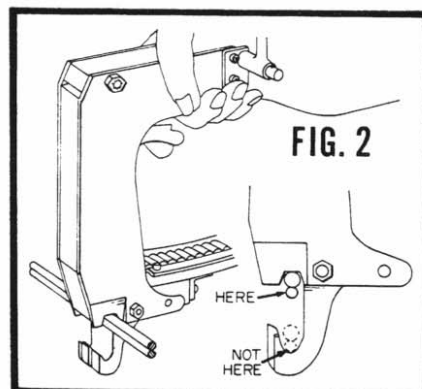


**FIG. 1**

### Operation

Clips may be loaded into the magazine by pulling the follower to the rear of the magazine where it latches (Fig. 1). Insert clips **with single ear to the front** and release follower latch. The tool is now ready for clinching. Simply locate the wires in the side plate notch and squeeze the trigger.

**IMPORTANT:** Place wires in notch of side plates by pushing tool **down** onto wires as shown in Fig. 2.

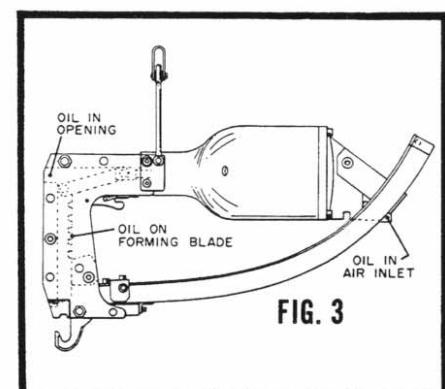


**FIG. 2**

### Installation & Air Supply

As this tool weighs approximately 7 pounds, it can be balanced on a suspension cable using a 5-10 pound spring balancer (Fig. 1). Recommended air pressure for the Hartco Clinching Tool is a minimum of 80 PSI and maximum of 110 PSI.

A 3/8" I.D. flexible hose should be attached to the tool by means of a quick-disconnect fitting. When tightening the quick-disconnect fitting, place a wrench on the hex end of the main valve assembly and tighten the fitting against this wrench. **DO NOT APPLY TORQUE TO THE MAIN VALVE ASSEMBLY AS THIS CAN BREAK THIS VALVE.**



**FIG. 3**

### Maintenance

The Hartco Clinching Tool is of simple design with a minimum of parts and will give long years of service when used correctly. Oil daily (Fig. 3) with 30 weight oil and maintain the tool as follows:

- 1) A drop or two of oil in the air inlet of the tool is recommended on a daily basis. Oil blade at same time.
- 2) The front of the driver blade should be well greased whenever the tool is disassembled.
- 3) Tighten bolts as necessary.
- 4) Use wire to clean tape from blade slot.

**STANLEY**

**HARTCO**

Stanley Fastening Systems

# APPLICABLE WIRE GAUGE COMBINATIONS

## FURNITURE CLIP AND WIRE GAUGE COMBINATIONS

For these wire sizes . . . . . Use this tool and clip

12 ga. to 8, 9, 10, 11 & 12 ga.	Model 65AT-CL-23 or
11 ga. to 9, 10, 11 & 12 ga.	
10 ga. to 10, 11 & 12 ga.	Model 66-CL-3
Paper covered to 8, 9, 10, 11 & 12 ga.	
10 ga. to 8, 9 & 10 ga.	Model 65AT-CL-24 or
9 ga. to 8, 9, 10 & 11 ga.	
8 ga. to 8, 9, 10 & 11 ga.	
7 ga. to 8, 9, 10 & 11 ga.	
6 ga. to 10 & 11 ga.	

There are two models of tools to choose from for the furniture applications. the model 65AT or Model 66.

The Model 65AT performs best when clipping over two wires that are straight and parallel at the section where the wire is applied.

The Model 66 performs best in the clipping of coil springs to border wires or the clipping of non parallel sinuous wire.

## BOX SPRING CLIP AND WIRE COMBINATIONS

For these wire sizes . . . . . Use this tool and clip

6 ga. border to 8, 9, 10, 11 ga. coil	Model 85-CL-34
4 ga. border to 8, 9, 10, 11 ga. coil	
3 ga. border to 9, 10, 11 ga. coil	
3 ga. border to 8, 9, 10, 11 ga. coils	Model 85S-CL-36
2 ga. border to 9, 10, 11 ga. coils	
00 ga. to 8, 9, 10, 11 coils	Model 88-CL-38

## AUTOMOTIVE SPRING CLIP AND WIRE COMBINATIONS

For these wire sizes . . . . . Use this tool and clip

8 ga. flat to 11, 12 ga. rd.	Model 100(55)-CL-3
11 ga. rd. to 10, 11 & 12 ga. rd.	
8 ga. flat to 8, 9, 10 ga. rd.	Model 100(55)-CL-4
8 ga. rd. to 8, 9, 10 ga. rd.	
9 ga. rd. to 8, 9, 10 ga. rd.	

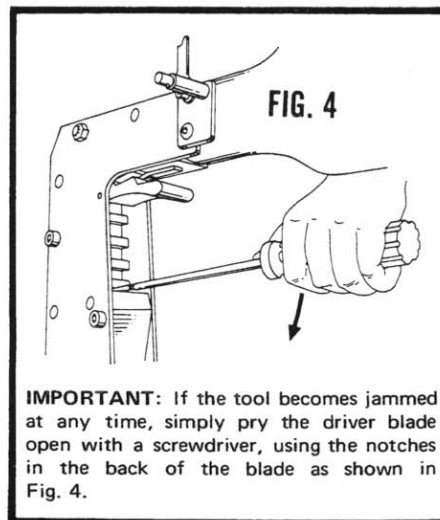
NOTE: Items 1 through 7 must be specified when ordering a Model 100 clipping tool.

**Clipping is our only business — If you have a special application, ask us for a special clip.**

HARTCO FASTENERS AND CLINCHING TOOLS ARE COVERED BY ONE OR MORE OF THE FOLLOWING U.S. PATENTS, AS WELL AS OTHER FOREIGN PATENTS:

3,613,878	4,508,220
D-220,467	4,546,528
3,641,656	5,165,146
3,647,593	

OTHER U.S. AND FOREIGN PATENTS PENDING.



**IMPORTANT:** If the tool becomes jammed at any time, simply pry the driver blade open with a screwdriver, using the notches in the back of the blade as shown in Fig. 4.

## Trouble Shooting

- If clips are loaded backward into the magazine with double ears forward, they will not be wrapped and jamming will occur. The first check of jammed tool should be to see that the clips are properly loaded in the magazine.
- Repeated jamming is usually caused by the operator placing the wires at the bottom of the anvil hook. This prevents the clip from passing around the wires and wrapping them. Wires must be located in the side plate notches for jam-free clinching.
- If tool does not actuate when trigger is depressed, the rear pilot valve may be stuck. To correct this, depress the trigger for an extended time and after the tool finally actuates, add a drop or two of oil at the air inlet.
- If the driver blade does not return freely, oil driver blade mechanism. If blade still does not return freely, disassemble one side plate to determine if binding occurs. If the problem continues, replace O-ring #43 in front of the housing.

UNITED STATES:  
7707 N. Austin Ave.  
Skokie, IL 60077

Tel: 847 967-1122  
Toll Free: 800 323-1484  
Fax: 847 967-9808

**STANLEY** **HARTCO**  
Stanley Fastening Systems