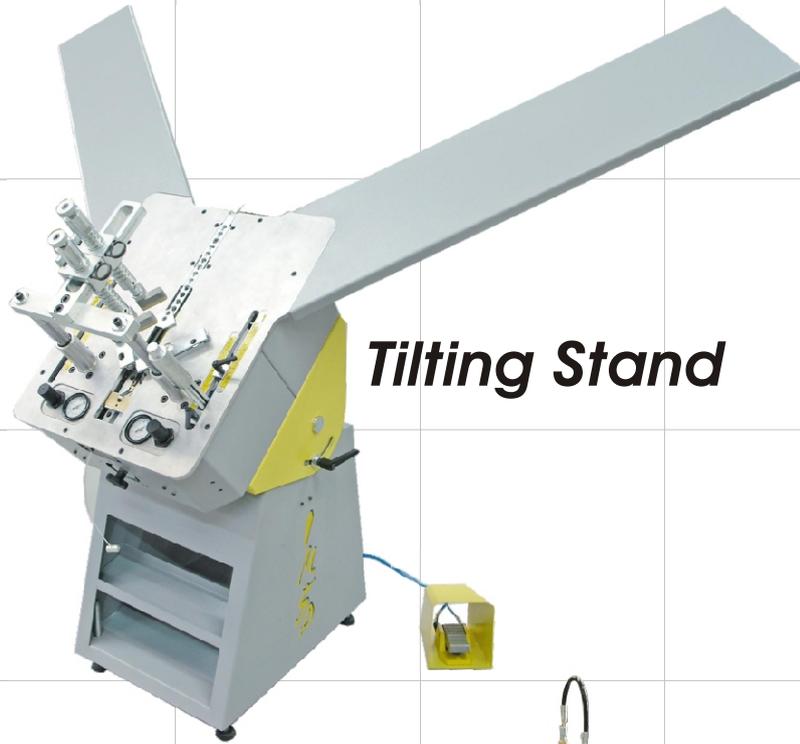


# OPERATIONS MANUAL

## IM-5P UNDERPINNER



*Tilting Stand*



*Closet Stand*





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## **1.GENERAL INFORMATION**

### **1.1 INTRODUCTION**

Congratulations on your purchase of the IM-5P! It benefits from our long of experience acquired during years of designing frame assembly machines for the picture framing industry.

The IM-5P developed by Inmes is a pneumatic frame assembly machine which is designed to be operated on a work table or a tilting stand, in front of the machine or behind it. This versatile underpinner can be supplied with double mechanical clamps **or** double hydraulic clamps allowing you to provide proper support for wide frames with complex profiles.

### **1.2 MAIN COMPONENTS**

The main components including with the machine are:

- Front Clamp
- Allen Wrenches
- Tilting or Closet Stand
- Instructions Manual
- Counterweight Balancer (for use with tilting stand only)
- Leveling Bolts

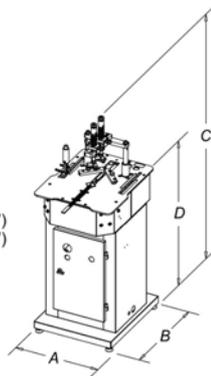
### **1.3 OPTIONAL ACCESSORIES**

- |                            |                  |
|----------------------------|------------------|
| - Double Mechanical Clamps | Part No. 0101334 |
| - Double Hydraulic Clamps  | Part No. 0101335 |
| - Extension Wings          | Part No. 0101133 |
| - Hexagonal Fence          | Part No. 0301001 |
| - Octagonal Fence          | Part No. 0301002 |
| - Twelve Sided Fence       | Part No. 0301086 |
| - Eighteen Sided Fence     | Part No. 0301085 |

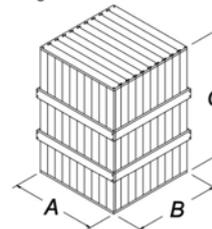
## 1.4 TECHNICAL SPECIFICATIONS

Dimension

A = 476mm (18,7")  
 B = 571mm (22,4")  
 C = 1283mm (50,5")  
 D = 900mm (35,43")



Package



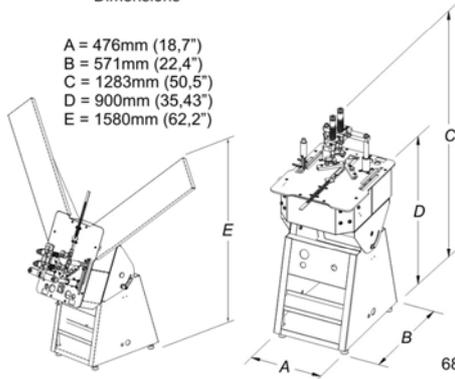
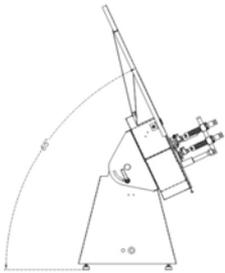
A = 710mm (27,95")  
 B = 710mm (27,95")  
 C = 1300mm (51,18")

66 Kg (145,20 lb)

86 Kg (189,20 lb)

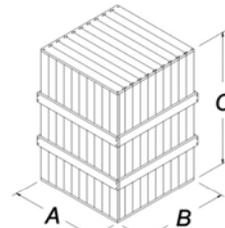
Dimensions

A = 476mm (18,7")  
 B = 571mm (22,4")  
 C = 1283mm (50,5")  
 D = 900mm (35,43")  
 E = 1580mm (62,2")



Package

Volume: 0,66 m<sup>3</sup> (23,14 ft<sup>3</sup>)

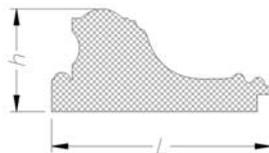
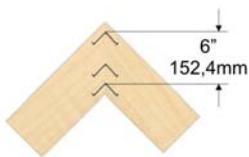


A = 710 mm (27.95")  
 B = 710 mm (27.95")  
 C = 1300 mm (51.18")

68,60 Kg (150,92 lb)

88,60 kg (194,92 lb)

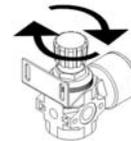
Joining Capacity



Lmin = 5mm (0,19")  
 Lmax = 145mm (5,70")

hmin = 8mm (0,31")  
 hmax = 125mm (5")

Working pressure and consumption



Pressure .....6 bar  
 Consumption ..... 2,5 ft<sup>3</sup>/min (20 cycles)

## 1.5 WARRANTY

INMES products are built to have long durability and are tested one by one before leaving the factory. The IM-5P is covered by one (1) year warranty to be free from defects in parts and manufacturing defects only, providing the machine has been under normal use. Labor is not included with the warranty, the return of the equipment is fully at the purchaser's expenses. The repair will be effected where you have bought the machine and the freight of the shipment will be entirely charged to the customer.

The warranty does not cover damages caused by inappropriate use of the machine, or by use not in conformity with the terms of this instructions described in this owner's manual.

The warranty is not valid in case of unauthorized modifications or because of accidental damages effected by unqualified personnel.

## 1.6 AUTHORIZED SERVICES

INMES is represented by numerous and prepared organizations in every country that we sell. Please feel free to contact us at +55 (48) 3658-2064 [export\\_dept@inmes.com.br](mailto:export_dept@inmes.com.br) to be informed concerning the Closest Authorized Dealer Service.

## 2. SAFETY

Always remember that careless fraction of a second is enough to cause a severe injury.

### 2.1 GENERAL WARNINGS

For the operator's safety and durability of your equipment the instruction manual must be followed with great care when installing and operating your machine, staying alert and learn how to use the IM-5P.



If the safety instruction is not followed the operator will be seriously injured.



It means if the safety instruction is not followed the operator could be seriously injured.



Safety instruction if not carried out with care might injury the operator.

## WARNING

- Read the Instruction Manual before operating the equipment;
- Do not remove or change the warning adhesive signs;
- Wear adequate clothing to avoid clothes that could get stuck in the moving parts;
- Long hair has to be tied up;
- Keep hands away from the working area;
- Disconnect air pressure supplying during any maintenance intervention;
- Keep the feet away from the foot pedal during machine regulation;
- The machine must be mounted on a flat surface in an appropriate work area, well lighted;
- The user guarantee the machine is operated only by trained operators;
- The user must prevent access to the machine by non-authorized people;
- In order to obtain high performance of the machine, make sure that you read the instruction manual;
- Keep children and visitors away

## 2.2 TO REDUCE THE RISK OF INJURY

- Never place your hands under the vertical clamps;
- Never place your hands in front of the front clamp;
- Hold the profile firmly against to the fence with your hands outside of the clamping area;
- Before using the machine be sure that no objects have been left on the working table
- If any part is missing, bent or broken in anyway, do not use the equipment;
- Never use your machine if you observe something which can cause an accident or damage the equipment;
- Keep work area around the machine clean;
- Keep visitors and children away when using;

**Note:** Always remember that a careless fraction of a second is enough to cause a severe injury.

## 3. HANDLING AND STORAGE

### 3.1 HANDLING

Two people are required to locate the machine. The machine has to be shipped in a safe way to avoid any damage. Mount it securely on a proper floor. The machine has to be shipped like positioned for installation.

### 3.2 STORAGE

The machine must be stored with cautions, as per information below:

- Store the machine indoors;
- Protect the machines from accidental impacts;
- Protect the machine from humidity;
- Avoid the machine to come in contact with corrosive materials;

## 4. UNPACKING

Unpack the machine and verify all components to make sure the following parts are included:

- IM-5P Underpinner
- Front clamp
- Wrenches
- Instructions Manual
  
- Optional Accessories:
  - Tilting Stand
  - Closet Stand
  - Double upper Hydraulic clamps or Mechanical clamps
  - Extension Arms
  - Hexagonal, Octagonal, Twelve sided and eighteen sided fences

## 5. MACHINE DESCRIPTIONS AND ADJUSTMENTS

Before using the machine it is necessary to make some adjustments according to the profile moulding to join.

### 5.1 WORKING PRINCIPLE

The Inmes frame assembling machine IM-5P is versatile and extremely easy to use. It can be supplied with double mechanical clamps or double hydraulic clamps allowing the operator to provide proper support for wide frames. It can join with absolute precision any kind of moulding by means of special steel v-nails. The machine can be supplied in either tilting or closet stand model.

### 5.2 NAILING HEAD

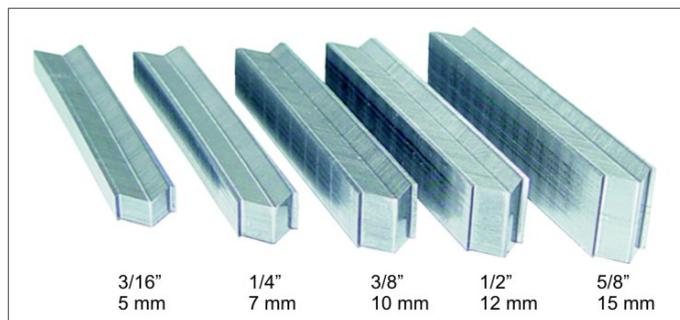
The nailing head is moved from one position to the next position by sliding the joystick, while the moulding remains clamped and locked in one position.

### 5.3 USING THE CLAMPS

Use the foot pedal to immediately activate the front clamp followed by the upper clamps, while the Joystick activates the nail pusher to insert the nail.

### 5.4 SELECTING THE V-NAIL

The Inmes nails are specially designed to hold the frames pieces firmly together creating a tight joint. There are 5 different sizes of 5-7-10-12-15mm, as shown in fig 1. Each nail size is available for either hardwood or softwood. For maximum strength, place two or more nails along the frame.



**Fig. 1**

### 5.5 LOADING AND CHANGING V-NAIL INTO THE MAGAZINE

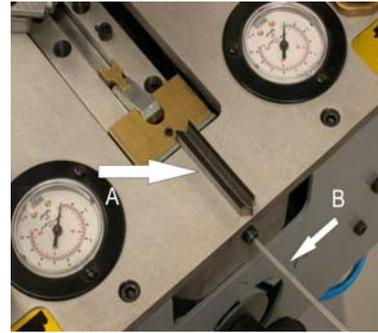
There is a quick change nail device located at the rear of the machine for changing the nail, just rotate the knob clockwise and choose the nail size showed by the knob arrow fig 3. And then pull on the spring loaded cable as show in fig. 4 arrow “B” and insert one v-nail stick into the magazine fig 5 arrow “C”, make sure the “V” of the v-nail is pointing in the direction indicated by the arrow “A” in fig 4. Finally release the spring loaded cable.



**Fig. 3**



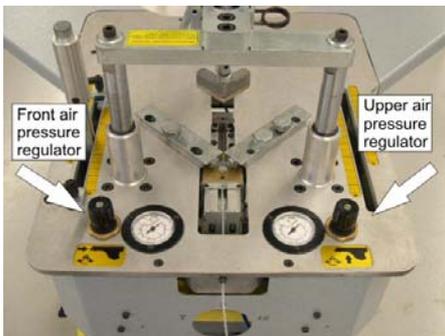
**Fig. 4**



**Fig. 5**

### 5.6 AIR PRESSURE REGULATOR FOR FRONT AND UPPER CLAMPS

The working pressure must be adjusted to the hardness of the moulding to be assembled. The pressure regulation allows changing the clamping pressure of moulding to be assembled. When the working pressure is too high this may cause a poor joining and the moulding crushing. When the working pressure is too low this may cause incomplete insertion of V-nail into the frame.

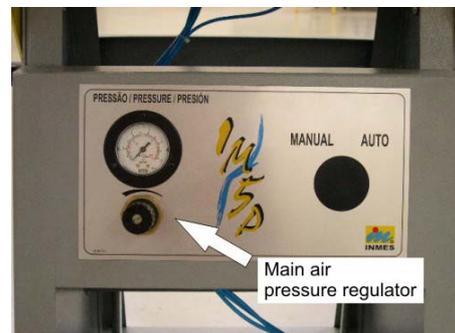


**Fig. 6**

pressure regulator fig 7 at 6 BAR by turning it clockwise to increase the pressure and counterclockwise to decrease the pressure and follow the same procedure to set the front and upper clamps air pressure regulator as shown fig. 6 at 6 BAR.

Both the front and upper clamps have independent air pressure regulator, as shown fig. 6 while the nail insertion pressure is adjusted by the main air pressure regulator, fig. 7. Attach the compressed air source to the machine with appropriate “quick disconnect fitting”. The source should be filtered and lubricated and not exceed 6 BAR (85 PSI).

Then, first set the main air



**Fig. 7**

### 5.7 HEIGHT ADJUSTMENTS FOR THE MECHANICAL UPPER CLAMPS

To perform this adjustment remove each quick pins fig 8 (J), and raise both cylinders, and then place two pieces of moulding against the fences, now push up the quick locks fig. 9 (D) and slide both cylinders so they are positioned above the frame corner as suggested in fig 8, be sure the quick locks are tightened to prevent slippage. Set the pads at 3/8" (10mm) above the frame.

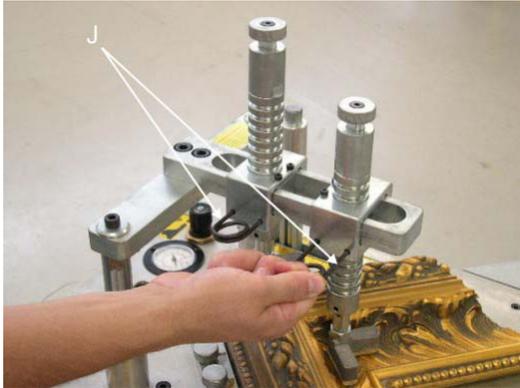


Fig.8

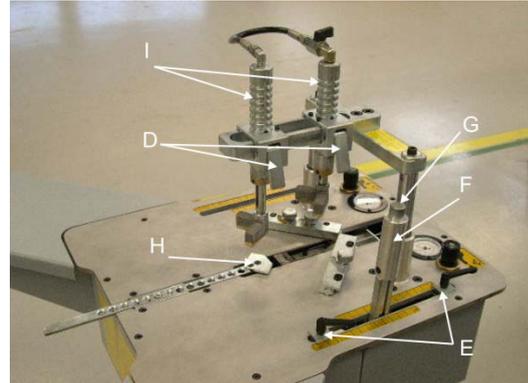


Fig. 9

### IMPORTANT

If a small frame is being joined, remove the “quick pin” and take one of the clamps out.

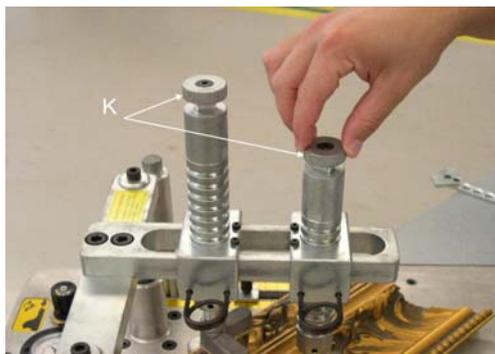


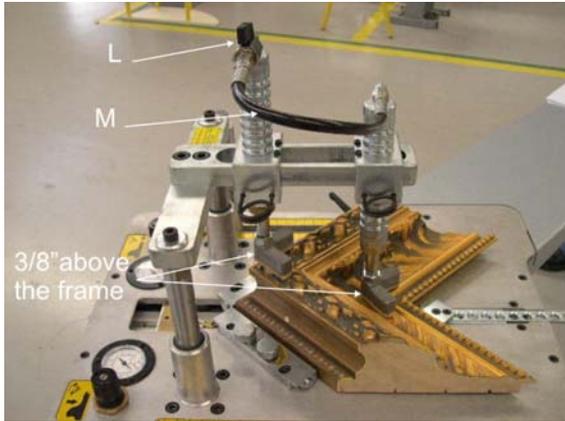
Fig. 10

### 5.8 SLIGHTLY ADJUSTMENT FOR THE MECHANICAL CLAMPS

In case you need to slightly adjust the height of the cylinders above the frame, the mechanical clamps offer a device that you can move the pads down till about 3/4" (19mm) to the top of the moulding, by turning anticlockwise the knobs of each pad as shown in fig 10.

## 5.9 VERTICAL HYDRAULIC CLAMPS ADJUSTMENT

Instead of using the two mechanical clamps a double hydraulic clamps can be mounted on the IM-5P. The Hydraulic clamps can be useful when changing frequently the profiles or



joining profiles that have complicated shapes. In fact thanks to the oil circuit the hydraulic clamps descend and clamp the top of the moulding self-adjusting their vertical position. In order to adjust the hydraulic clamps use the same procedure describe above on item 5.7

If a small frame is being joined, slide the rear clamp out of position and close the valve fig 11 (L) on top of the rear cylinder. Position the other cylinder pad over the corner of the frame.

**Fig.11**

### 5.9.1 ADJUSTMENT FOR THE FRONT CLAMP

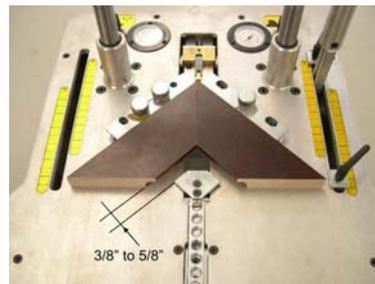
The front clamp has a series of holes in the flat bar fig 12. Lift the bar to take it out of its initial position and make it move forward and backward. To lock the bar it is sufficient to insert it into the proper peg located in the middle of the guide channel.

Proceed as follow to position the front clamp properly:

- Remove the bar from the peg (lifting it by about 10-15mm) and move it forward up to reach the moulding to be assembled, as shown in fig. 13.
- Lower the bar to allow the insertion of tracking screw and the locking in the next position.
- Place the front clamp at 3/8" (10mm) in front of the frame rabbet.



**Fig. 12**



**Fig. 13**

### 5.9.2 FIXED FENCE POSITION

The IM-5P is equipped with a fixed fence at 90°. The fence and the moulding remains clamped and the “nailing head” is moved from one position to the next position by sliding the joy-stick.

## IMPORTANT

It is possible to supply as optional Hexagonal, Octagonal, 12 sided and 18 sided fences.

### 5.9.3 FENCE ADJUSTMENT

The IM-5P underpinner is equipped with adjustable fences in order to obtain always the best results, even with twist mouldings.

### 5.9.4 PERPENDICULARITY ADJUSTMENT

This operation can be performed by turning clockwise or anticlockwise the proper knobs, as show in fig 14, knobs “A” and “B” it is very useful in those cases when the base of the moulding is not perfectly perpendicular compared with the part of the moulding that leans against the fence. The adjustable fence can be tilted +/- 2°.



Fig. 14

Before joining the moulding follow this procedure:

- a. Place the two legs of the moulding against the adjustable fence and set the vertical clamp so that, when pedal is depressed, they can hold the moulding properly.
- b. Press the pedal and check the quality of the joint. In case the joint is not good, release the pedal and adjust the perpendicularity of each fence by turning the knobs “A” and “B” and repeat the operation over described joint.

## 5.9.5 FENCE ANGLE ADJUSTMENT

If during the test above, the corner of the frame remains open forward or backward, it is possible to adjust the fence angle of about 1°. Rotate clockwise or anticlockwise the knob of the left fence in fig 14 “C” till the right adjustment is founded. Adjust only left fence. Do not move right fence, it is possible to loose the exact position.

## 6. IM-5P OPERATION

### 6.1 POSITIONING THE JOYSTICK

To perform the joining process follows here under procedure:

- Place one of the two moulding legs in position against the fence and position the joy stick **F** so the first nail will be inserted about 3/16” (5mm) from the rabbet. Loosen stops **E** slide it against the joy stick and tighten. This becomes the rear stop. Slide the joy stick **F** toward the front to locate the second nail about 3/16” (5mm) from the frame corner. Loosen and slide the stop **E** against the joy stick **F** and tighten the stops, this becomes the front stop;
- Slide the joy stick **F** to the rear stop for the insertion of the first nail. Place both frame pieces against the fence.

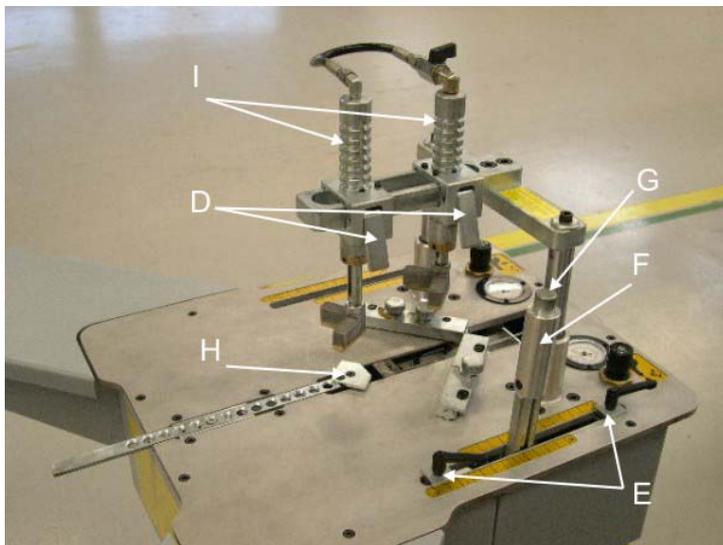


Fig.15

and the first nail will be inserted. Slide the joy stick **F** to the front against its stop and push the fire button **G** to insert the second nail. Since the frame is higher near the corner, you can insert another v-nail at this same location which stacks two nails one on top of the other. If the frame is wide you can move the joy stick **F** to ONE or more intermediary positions, push the fire button **G just half way down** which will lock the joy stick **F** in place and then push the fire button **G** full down to insert the nail in the third position

- Set the front clamp **H** in place about 3/8” (10mm) from the rabbet of the frame;
- Adjust the vertical clamps height and position **I**;
- Depress the foot pedal full down and the front clamp will operate immediately followed by the upper clamps, continue to hold the foot pedal down and push the fire button **G**

## 7. MAINTENANCE

### ATTENTION

**In order to avoid danger before performing any of the operations described below the machine must be absolutely disconnected from air pressure source!**

This machine will provide years of quality performance if maintained carefully. For operator safety before cleaning, lubricating and maintenance remove the plug from air source to avoid unexpected start-up.

Cleanliness and care guarantee not only a longer life time of the machine, but also less risks to operators. So we advise to keep the machine clean and lubricate weekly.

The most important maintenance requirement is cleanliness. Use a brush or clean cloth to wipe the table surface, shafts and pads.

If glue accumulates on the nailing head fig (xx), 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.

### 7.1 EVERY 10 WORKING HOURS:

- a. Check compressed air condensation in the filter glass;
- b. Blow air pressure to eliminate pieces of staples or wood dust that can go inside the movable parts of the machine;

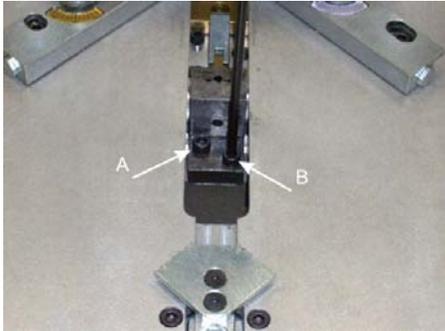
### 7.2 EVERY WEEK:



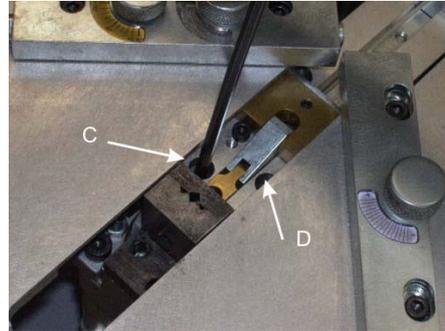
**Fig. 16**

- a. Check oil level inside the filter lubricator fig 16;
- b. In case oil is needed add for pneumatic circuits low density;

### 7.3 HOW TO REMOVE THE NAILING HEAD AND CLEAN IT



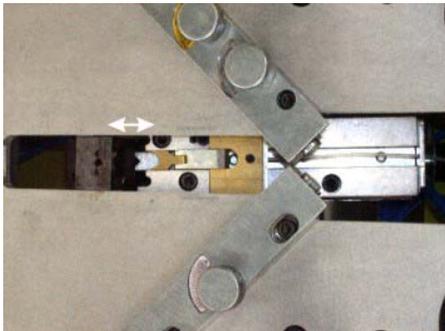
**Fig. 16**



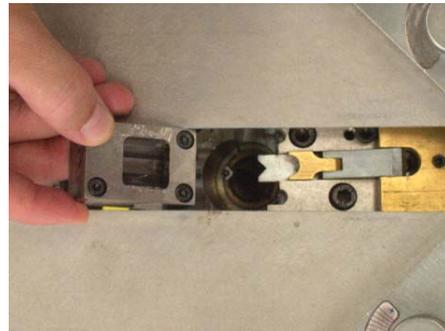
**Fig. 17**

For operator safety, always disconnect the air source before cleaning, lubricating or performing any maintenance.

- a. Using the 5mm Allen key, loosen the locking screws A and B of the nailing head, fig 16. Then loosen the locking screws C and D of the magazine, fig 17.
- b. Then using your hands pull back the magazine a little bit fig 18. Now you are able to remove the nailing head and accomplish your regular maintenance, as show in fig 19 .



**Fig. 18**

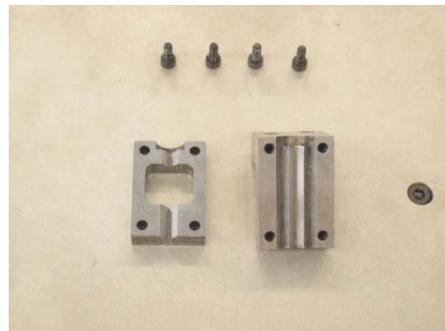


**Fig. 19**

- c. 3. Once you have the nailing head out of the machine, place it on a flat surface with a 4mm Allen wrench, loosen and remove the four screws, as shown in figs. 20/21

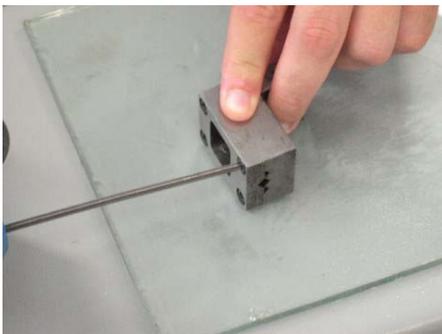


**Fig. 20**

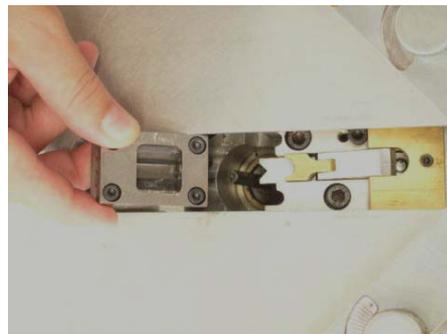


**Fig. 21**

- d. Clean the inside of the nailing head using a cloth and a drop or two of pneumatic oil. After cleaning, wipe down the nailing head with a dry cloth. Then put one drop of pneumatic oil on the inside of the nailing head.
- e. Before mounting the nailing head, we suggest you use a flat surface (like a mirror) in order to give a precise alignment of the two parts. If the top and sides are not in precise alignment, it will not work properly, as shown in fig 22.
- f. When attaching the nailing head over the drive pin make sure to place it according to fig 23



**Fig.22**



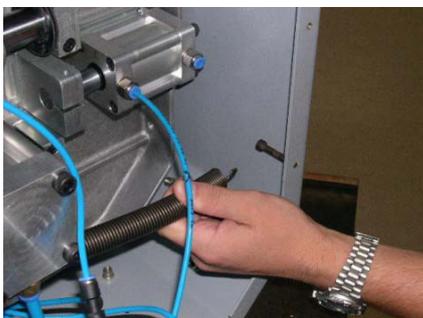
**Fig. 23**

- g. Place the nailing head on its original position and using the 5mm Allen key tighten the locking screws A and B of the nailing head, fig 16. Then place the magazine on its original position fixed to the nailing head and tighten the locking screws C and D of the magazine, fig 17;

#### **7.4 HOW TO ASSEMBLE THE COUNTERWEIGHT BALANCER**

For operator safety, always disconnect the air source before cleaning, lubricating or performing any maintenance.

The IM-5P underpinner is designed to be operated on a closet stand or a tilting stand. The counterweight balancer spring is provide with the machine for using just with the tilting stand in order to set the weight of the hammer block assembly when the machine is tilted. Proceed as follow to attach the counterweight balance on the machine. See fig 24 how to assemble the spring.



**Fig. 24**

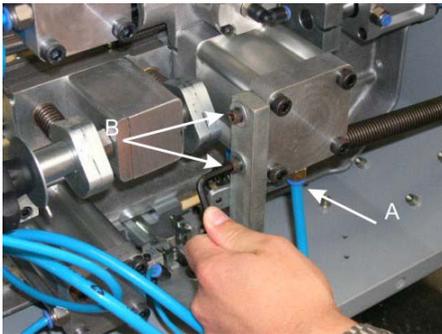
1. Tilt the working table by loosen the knobs on the left and right sides of the stand ;
2. Then attach one end of the spring over the bolt as shown in fig. 24 and the other end of the spring attaches to another bolt located beside the cylinder.

## 7.5 HOW TO CHANGE THE NAIL PUSHER

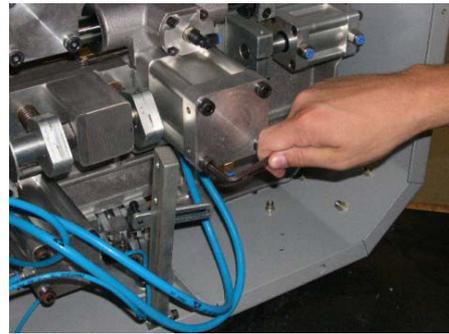
For operator safety, always disconnect the air source before cleaning, lubricating or performing any maintenance.

In order to remove the nail pusher, follow these procedures:

- Tilt the working table
- Disconnect the air hose source fig. 25 arrow "A" and loosen the two locking screws B;
- Now using a 6mm Allen key, loosen the (4) four locking screws and remove the cylinder lid, as show in fig 26/27 ;
- Then using a pair of pliers remove the complete device for the nail pusher cylinder, as show in fig 28;
- Once you have the nail pusher out, add a small amount of pneumatic oil around the new rubber gasket;
- Carefully place the new one back inside the cylinder fig 28, making sure the top edge of the rubber gasket is inside the cylinder before pushing, if not, damage may occur to the rubber gasket. Also, make sure the nail pusher is in the nailing head;
- Once you have the complete nail pusher device into the cylinder, reassemble the cylinder lid with the 6mm Allen key and tighten the (4) four screws as shown in fig 26. Then tighten the other two screws B and C as shown in fig 25;
- Finally attach the air hose to the cylinder, and with the nails out, make a few tests before you start production.



**Fig. 25**



**Fig. 26**



**Fig. 27**



**Fig. 28**

## 7.6 HOW TO CHANGE THE JOYSTICK FROM THE RIGHT TO THE LEFT.

### CAUTION

For operator safety, always disconnect the air source before cleaning, lubricating or performing any maintenance. In order to change position for the joy stick, follow these procedures:

- Disconnect the air source;
- There are 4 hoses connected to two valves, disconnect and mark them before changing the side of the joy stick
- Using the 3mm Allen key loosen the locking screws of the joystick handle fig 29 and take the housing out as shown in fig 30, then pull up and rotate the joystick arm in order to take it out;
- Then under the working table there is a support bracket attached to the cylinder, using the 5mm Allen key loosen the two locking screws; as shown in fig. 31;
- Once you have done this procedure you are ready to move the joystick to the opposite side.
- Pull bracket down, and then rotate to the other side.
- Unscrew and move locking levers to other side.
- Reassemble

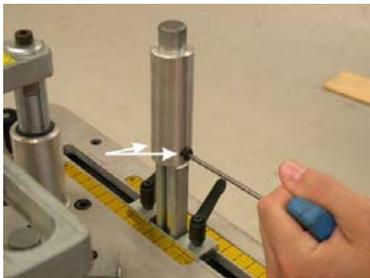


Fig. 29



Fig. 30



Fig. 31

## 7.7 AIR FILTER LUBRICATOR AND OIL LUBRICATOR

### CAUTION

For operator safety, always disconnect the air source before cleaning, lubricating or performing any maintenance.

## 7.8 OIL LEVEL ON LOWER EDGE OF OIL GLASS

INMES products are constructed to have a long duration and are tested one by one. However, we ship the machines without oil inside the lubricator glass and it is necessary to fill the lubricator glass to obtain good performance of the equipment. The number of drops of pneumatic oil is adjusted at the factory. It is usually not necessary to adjust afterwards. We recommend that the customer verify that after every 25to30 actions of the foot pedal, ONE drop should fall. In order to refill the lubricator glass, proceed as follow:

- Shut air supply, fig 32 “D”
- Unscrew the lubricator glass by turning anticlockwise direction, fig 33
- Fill the lubricator glass with pneumatic oil, a little more than half glass
- Screw the lubricator glass back on making sure the O-ring is sitting correctly in the housing

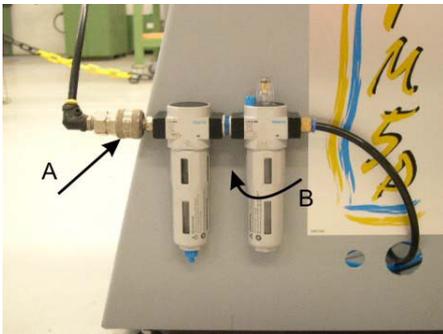


Fig. 32



Fig. 33

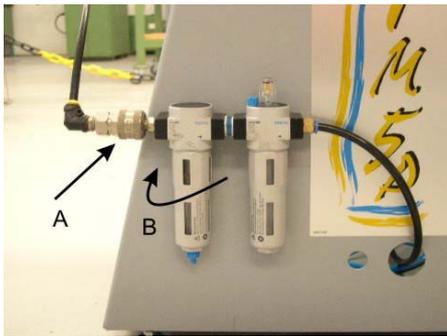
## 7.9 AIR FILTER LUBRICATOR

### CAUTION

**For operator safety, always disconnect the air source before cleaning, lubricating or performing any maintenance.**

When the compressed air leaves the air source it comes with water, impurity and dust, so the function of the filter lubricator is to filter the compressed air eliminating water and collecting dust and other impurities inside the filter glass. Every source of compressed air differs from one another, so consecutively, quantity of water and impurities are collected. That is why we strongly recommend that the customer verify daily, the oil level and water inside the air filter lubricator. When it is necessary to empty the water inside the filter glass, (it is not necessary to shut air supply) just loosen the drain located under the bottom of the filter, as shown in fig 34. However, we recommend cleaning the filter lubricator located inside the filter glass at least once a week. In order to clean it up, proceed as follow:

- Shut air supply,
- Unscrew the filter glass by turning anticlockwise direction,
- Unscrew the filter (black piece) as shown in fig 35;
- Then unscrew the black piece showed in fig 35, inside this part you will find a white piece fig 35, then clean inside both parts using air
- Once these procedures are done then screw filter back to its original position;
- Screw the lubricator glass back on making sure the O-ring is sitting correctly in the housing



**Fig. 34**



**Fig. 35**



**Fig. 36**

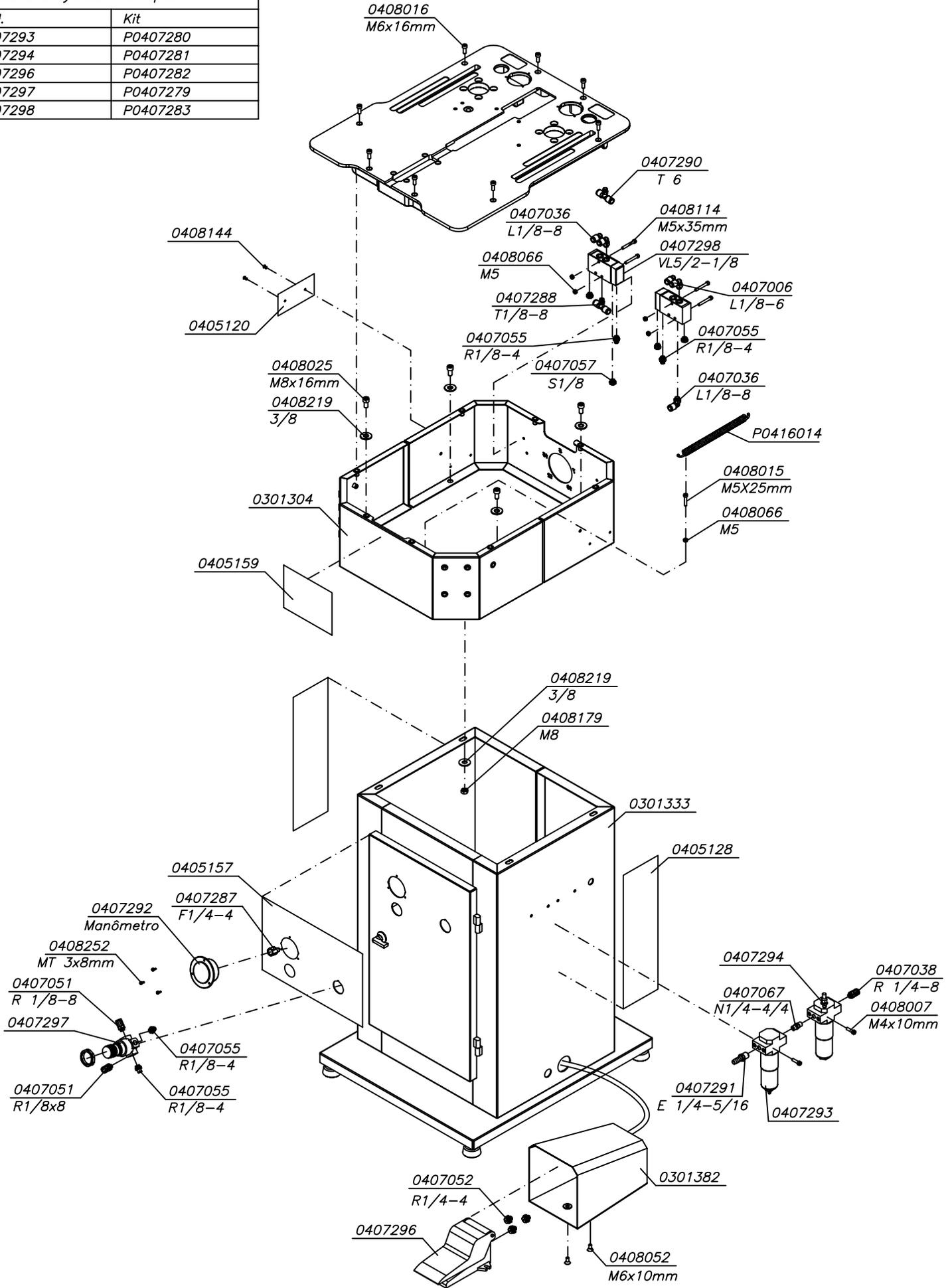
**10 –PART LIST IM-5P**

<b>Code</b>	<b>Descriptions</b>	<b>Code</b>	<b>Descriptions</b>
0101334	Mechanical clamps IM-5P	0407289	Connection 4MM
0101335	Hydraulic clamps IM-5P	0407290	Connection 6MM
0301038	Allen screw M5 (Z)	0407291	Male connector 1/4POLX5/16MM
0301213	Tilting stand IM-5P	0407292	Manometer FMA 50-1/4
0301225	Support counterweight balancer IM-5 (Z)	0407293	Air filter lubricator MINI 1/4"
0301229	Longer guide shaft IM-5	0407294	Oil lubricator LOE-D-MINI 1/4"
0301230	Shorter guide shaft IM-5	0407295	Activator R-3-M5
0301232	Support for the guide shaft IM-5P	0407296	Foot pedal F-5-1/4-B
0301238	Magazine base IM-5P (Z)	0407297	Air pressure regulator LR-1/8-F
0301240	Pin IM-5P (Z)	0407298	Valve VL-5/2 VIAS-1/8
0301242	Nail definer IM-5P (Z)	0408007	Allen screw Internal M4X10MM DIN 912
0301245	Shaft IM-5	0408009	Allen screw Internal M4X20MM DIN 912
0301247	Washer (Z)	0408015	Allen screw Internal M5X25MM DIN 912
0301249	Washer for the knob IM-5P (Z)	0408016	Allen screw Internal M6X16MM DIN 912
0301259	Cylinder support IM-5P (Z)	0408018	Allen screw Internal M6X20MM DIN 912
0301261	Guide IM-5P (Z)	0408019	Allen screw Internal M6X25MM DIN 912
0301263	Guide peg IM-5P (Z)	0408020	Allen screw Internal M6X30MM DIN 912
0301265	Movement bar IM-5P (Z)	0408021	Allen screw Internal M6X35MM DIN 912
0301266	Activator for the valve IM-5	0408025	Allen screw Internal M8X16MM DIN 912
0301269	Washer IM-5P (Z)	0408026	Allen screw Internal M8X20MM DIN 912
0301270	Shaft Housing IM-5	0408031	Allen screw Internal M8X45MM DIN 912
0301274	Support for the activator SU IM-5P (Z)	0408038	Allen screw Internal M10X30MM DIN 912
0301283	Upper support IM-5P (Z)	0408052	Allen screw Internal M6X10MM
0301285	Washer IM-5P (Z)	0408053	Allen screw Internal M6X16MM
0301287	Clamps support IM-5P (Z)	0408054	Allen screw Internal M8X16MM
0301292	IM-5P Working table	0408066	Nut MA M5 ZINC
0301297	Right stop washer IM-5P (Z)	0408086	Nut M16 DIN 934
0301304	Base for the working table IM-5	0408089	Allen screw Internal M6X10MM DIN 912
0301306	Tilting plate IM-5P	0408114	Allen screw Internal M5X35MM DIN 912
0301309	Tilting axle IM-5 (Z)	0408143	Allen screw Internal M5X10MM DIN 912
0301310	Washer IM-5 (Z)	0408144	Rivet 3,2X10,2MM
0301318	Cylinder vertical clamps D50MM IM-5P	0408177	Nut MA 6MM ZINC.DIN 934
0301319	Housing for the vertical clamps	0408179	Nut MA 8MM ZINC
0301333	Closet Stand IM-5	0408200	Washer 1/4" zinc steel
0301346	Right arm extension IM-5P	0408219	Washer 3/8" zinc steel
0301348	MARCADOR DA BITOLA DO GRAMPO IM-5 (Z)	0408250	Allen screw Internal M5X10MM DIN 7991
0301350	Left arm extension. IM-5P	0408252	Phillips screw MT M3X8MM PAN ZINC PRET.
0301352	Vertical bar IM-5 (Z)	0408256	Allen screw Internal M5X05MM
0407254	Connection L. 1/8-4	0408012	Allen screw Internal M5x8MM
0301354	Spring support IM-5 (Z)	0408257	Allen screw Internal M6X45MM
0301357	Stop for the nails strip pusher IM-5 (Z)	0408259	Allen screw Internal M6X16MM
0301360	Cylinder IM-5P D63MM	0415020	Knob M8
0301371	Nails guide complete with bushing IM-5	0416053	Spring IM-5
0301372	Housing with bushing IM-5	0416056	Spring IM-5
0301375	Cylinder for the front clamp D40MM IM-5P	0416059	Spring IM-5P
0301378	Tracking screw IM-5 (Z)	0417070	Cotter 5X5X12MM T-A
0301380	Support for the cylinder IM-5 (Z)	0417074	Flexible Ring 20MM
0301382	Foot pedal guard IM-5P	0419100	Table measure in inches (6") IM-5P
0301387	Longer support (complete) IM-5P with bushing	0419102	Table measure in millimeter 152MM IM-5P

	and cilinder		
0301388	Shorter support IM-5P	0504085	Operator's Manual IM-5P
0301399	Left stop washer IM-5P (Z)	P0301223	Complete nail pusher IM-5P
0301406	Shaft IM-5P COMPLETE	P0301253	Nail strip pusher IM-5P
0301411	Spring stop IM-5P (Z)	P0301291	Front clamp IM-5P COMPLETE
0405031	Caution label 28,0X72,0MM	P0301299	Right moulding fence IM-5P COMPELTE
0405120	Serial number label	P0301313	Single hydraulic clamps IM-5P
0405128	LATERAL label IM-5P closet stand	P0301320	Pad IM-5P
0405154	Main pressure regulator label IM-5P tilting stand	P0301362	Left moulding fence IM-5P COMPLETE
0405155	Vertical clamps label IM-5P	P0301369	Nut IM-5P COMPLETE
0405156	Front clamp label IM-5P	P0301373	Complete Nailing head IM-5P
0405157	Label IM-5P	P0301389	Rubber Stop IM-5P
0405158	Lateral Label IM-5P tilting stand	P0301390	Loaded cable IM-5P
0405159	Safety Label IM-5P	P0301408	Washer IM-5P (Z)
0407005	Hose 6MM	P0301413	Kit gasket cylinder D50MM IM-5P
0407006	Connection 1/8POLX6MM	P0301414	Kit gasket cylinder D40MM IM-5P
0407008	Hose 4MM	P0301415	Kit gasket cylinder D63MM IM-5P
0407027	Hose 8MM	P0302045	Aluminum handle M6X19MM
0407036	Connection 1/8POLX8MM	P0407276	Kit hydraulic oil hose IM-5P
0407038	Connection 1/4POLX8MM	P0407279	Kit gasket air pressure regulator LR 1/8POL F FESTO
0407049	Connection 1/8POLX6MM	P0407280	Kit gasket filter LF 1/4POL D MINI FESTO
0407051	Connection 1/8POLX8MM	P0407281	Kit gasket lubricator 1/4 D MINI FESTO
0407052	Connection 1/4POLX4MM	P0407282	Kit gasket foot pedal valve F 5-1/4 FESTO
0407055	Connection 1/8POLX4MM	P0407283	Kit gasket valve VL 5/2-1/8 FESTO
0407057	Muffler 1/8POL	P0415003	Butterfly handle M6X20MM
0407254	Connection 1/8POLX4MM	P0415021	Locking handle with washer M10X25MM
0407067	Jointer 1/4"	P0416014	Spring
0407286	Connection M5X4MM	P0416055	Locking pin IM-5P
0407287	Connection FEMEA 1/4POLX4MM	P0416057	Spring IM-5
0407288	Connection 1/8POLX8MM	0408029	Allen screw Internal M8x35MM

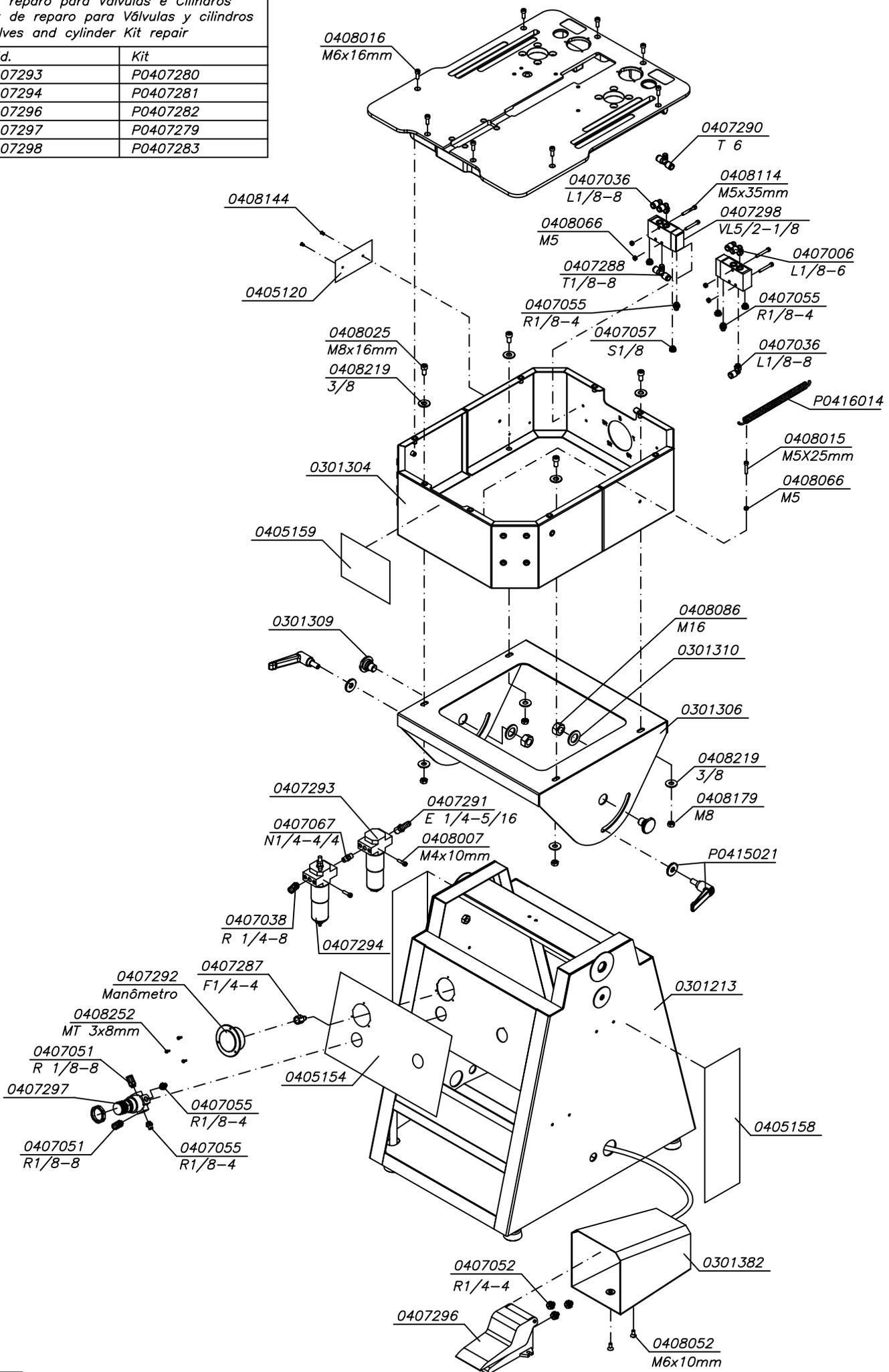
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 Kit de reparo para Válvulas y cilindros  
 Valves and cylinder Kit repair

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0407294	P0407281
0407296	P0407282
0407297	P0407279
0407298	P0407283



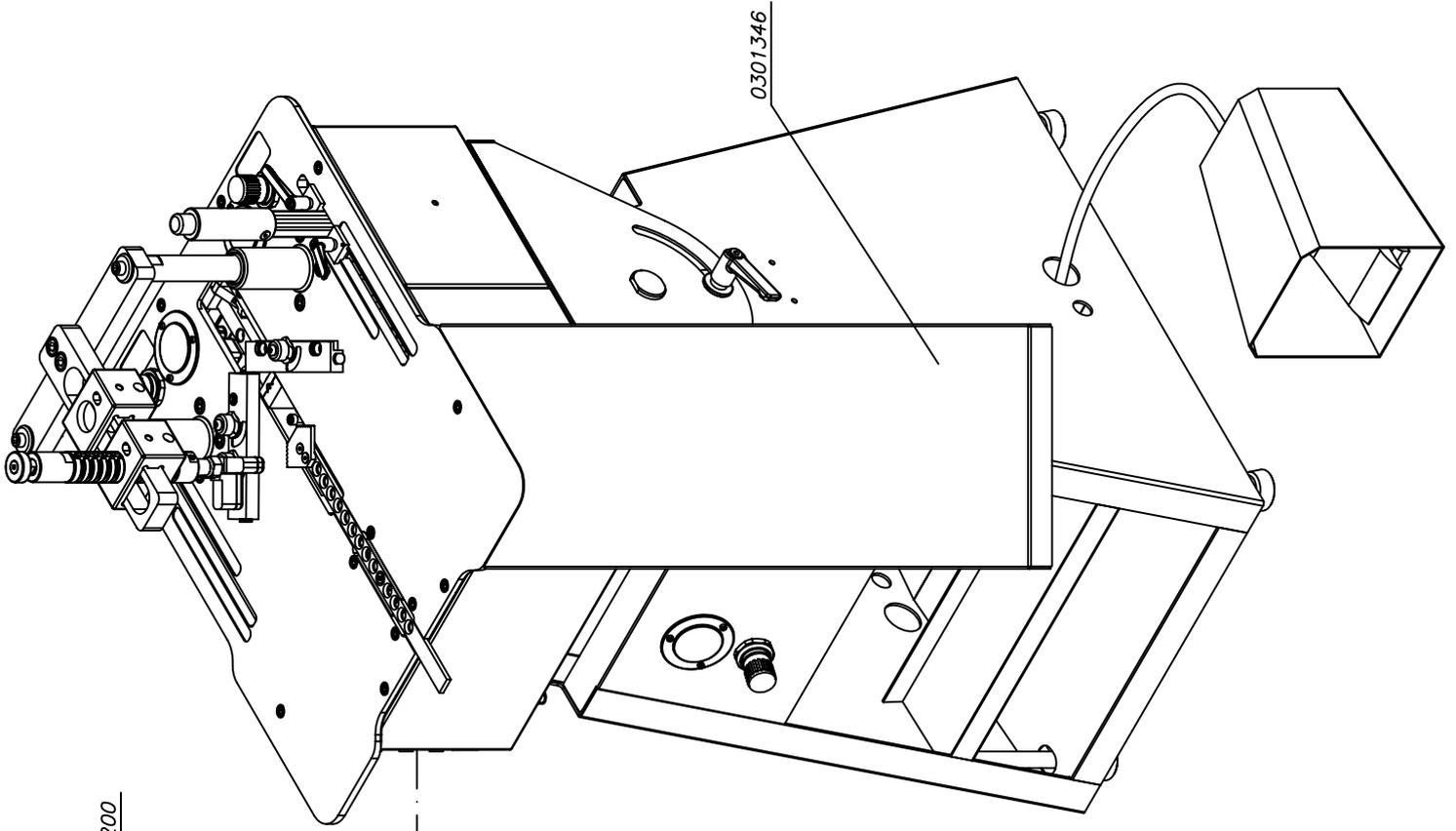
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Cód.	Kit
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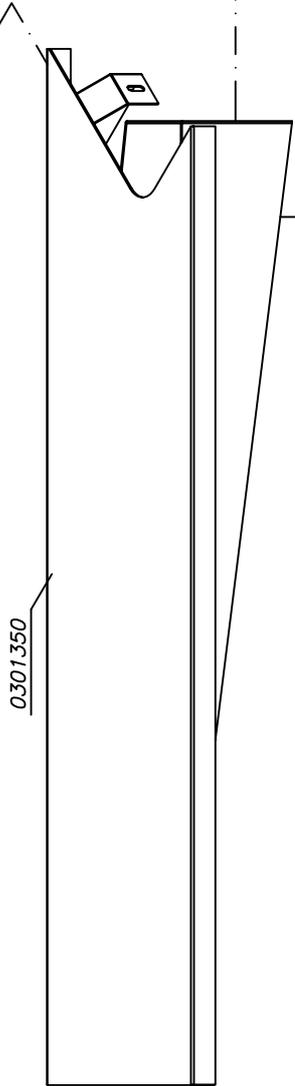




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1/4"

0408016  
M6x16mm



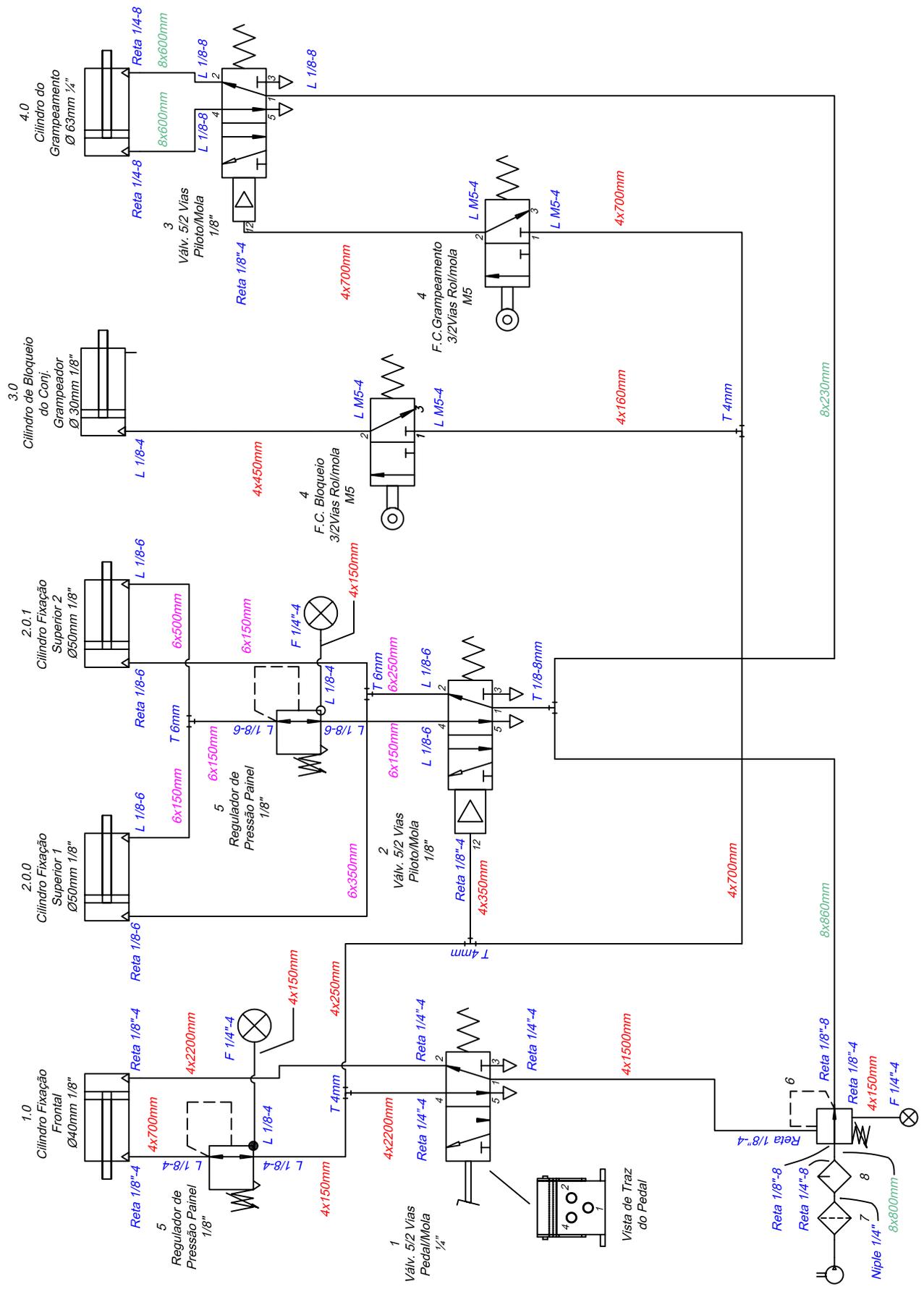
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0408200  
1/4"

0408016  
M6x16mm

# Esquema Pneumático Grampeadora IM-5 – INMES

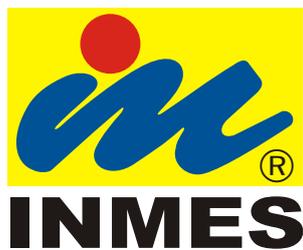
Mangueiras Pneumáticas	
Pneumatic hose	Ø 6mm
Manguera Neumática	Ø 4mm
0407005	Ø 6mm
0407008	Ø 4mm
0407027	Ø 8mm











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