

# Operator's Manual

# **CRAFTSMAN**<sup>®</sup>

**1/4" Crown**

**18 Gauge**

**1/2 - 1 1/2" Length**

**CROWN STAPLER**

Model No.  
**351.183670**

**CAUTION:** Read and follow all Safety Rules and Operating Instructions before First Use of this Product.

- **Safety Rules**
- **Operation**
- **Maintenance**
- **Parts List**

**Sears, Roebuck and Co., Hoffman Estates, IL 60179 U.S.A.**

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## WARRANTY

### FULL ONE YEAR WARRANTY ON CRAFTSMAN AIR-DRIVE TOOLS

If this Craftsman air-drive tool fails due to a defect in material or workmanship within one full year from the date of purchase, return it to the nearest Sears Service Center in the United States, and Sears will repair it free of charge.

If this air-drive tool is used for commercial purposes, this warranty applies for only 90 days from the date of purchase.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

Sears, Roebuck and Co., Dept. 817WA, Hoffman Estates, IL 60179

## SAFETY RULES

- Air tool operators and all others in work area should always wear safety goggles complying with United States ANSI Z87.1 to prevent eye injury from fasteners and flying debris when loading, operating or unloading this tool.
- Never exceed operating pressure of 100 PSI.
- Always keep hands and body away from the fastener discharge area when air supply is connected to tool.
- Always disconnect tool from air supply when servicing or adjusting tool and when tool is not in use.
- Do not operate when nose of tool is not in contact with work.
- Never load the tool until you are ready to use it.
- Never depress tool trigger when loading.
- Always load with nose of tool pointing away from you and others.
- Never point tool at yourself or others.
- Never carry tool with trigger depressed.
- Do not use oxygen, combustible gas or high pressure compressed gas as the air supply for the tool.
- Always use tool at safe distance from other people in work area.
- Do not attempt to discharge fastener into hard or brittle materials such as concrete, steel or tile.
- Do not connect female quick-disconnect coupling to tool side of air line.
- Connect male, free-flow nipple to tool side of air line connection so that tool is depressurized when hose is disconnected.
- Do not use a hose swivel with this tool.
- Use Sears recommended fasteners only.

## OPERATION

### DESCRIPTION

The Craftsman ¼" Crown Stapler drives ¼" crown, 18 gauge staples from ½ to 1½" long. Die cast aluminum body with textured grip minimizes operator fatigue. Large capacity, top loading magazine with positive quick action latch makes loading easy. Safety feature disables tool unless contact trip is pressed against workpiece. Tapered nosepiece provides operator with greater visibility for precise fastener placement. Rigid nosepiece reduces jamming. Quick-release nose cover allows for easy removal of jammed fasteners. The ¼" Crown Stapler is excellent for furniture making, upholstery, cabinetry and picture framing.

### SPECIFICATIONS

Capacity . . . . .	160 staples
Staple crown width . . . . .	¼"
Staple lengths . . . . .	½ to 1½"
Staple size . . . . .	18 gauge (.049 x .040")
Operating pressure . . . . .	60-100 PSI
Air inlet . . . . .	¼" N.P.T.
Length . . . . .	10½"
Height . . . . .	9½"
Width . . . . .	2¼"
Weight . . . . .	2.6 lbs.

### STAPLES

18333 . . . . .	¼" crown, ½" long
18334 . . . . .	¼" crown, ¾" long
18336 . . . . .	¼" crown, 7⁄8" long
18371 . . . . .	¼" crown, 1" long
18372 . . . . .	¼" crown, 1 1⁄8" long
18373 . . . . .	¼" crown, 1 ¼" long
18374 . . . . .	¼" crown, 1 ½" long

### AIR SUPPLY LINE

Refer to Figure 1 (page 3).

- The air tool operates on compressed air at pressures from 60 to 100 PSI.
- Never exceed maximum pressure.

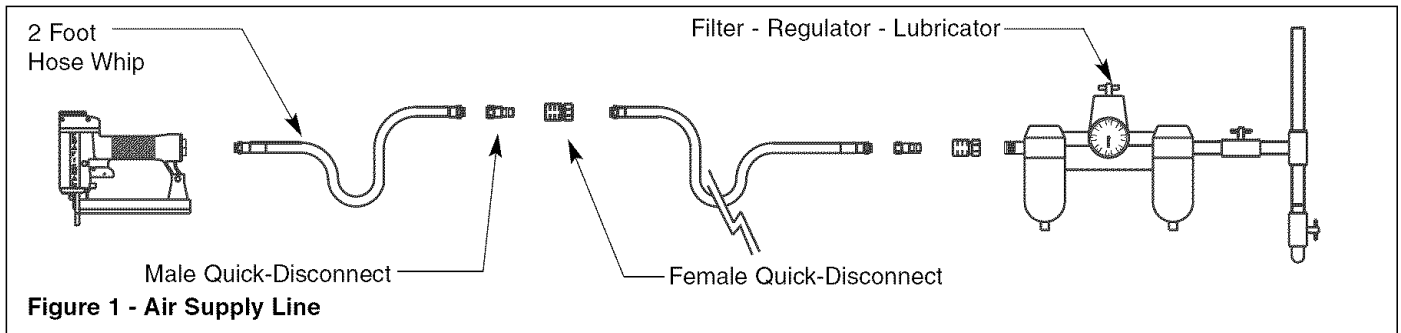
**Air Delivery Required:** 0.71 SCFM @ 90 PSI (30 shots per minute).

**WARNING:** Keep hands and body away from discharge area of tool when connecting air supply. Always disconnect tool from air supply when servicing or adjusting tool and when tool is not in use.

- Air operated tools require clean, dry, lubricated compressed air to ensure top performance, low maintenance and long life.
- Dirt and abrasive materials present in all air lines will damage tool O-rings, valves and cylinders.
- Moisture will reduce tool performance and life if not removed from compressed air.
- A filter-regulator-lubricator system is required and should be located as close to tool as possible (see Fig. 1, page 3). A distance of less than 15 feet is recommended.

- Keep air filter clean. A dirty filter will reduce the air pressure to the tool causing a reduction in power and efficiency.
- The air supply system must be able to provide air pressure of 60 to 100 pounds per square inch at tool.
- All hoses and pipes in the air supply system must be clean and free of moisture and foreign particles.
- Do not mount swivel connector in air supply line.
- The air pressure should be properly regulated.
- Different workpiece materials and different fastener lengths will require different operating pressure.
- Be sure all connections in air supply system are sealed to prevent air loss.
- Never connect a female quick-disconnect coupling to the tool side of air line connection. A male, free-flow coupling should be connected to the tool side of air line connection.

**WARNING:** The female coupling provides a seal preventing loss of compressed air from compressor tank when disconnected from male coupling. If connected to tool side of air supply, the female coupling could seal a compressed air charge in the tool which could discharge if the tool trigger is actuated.



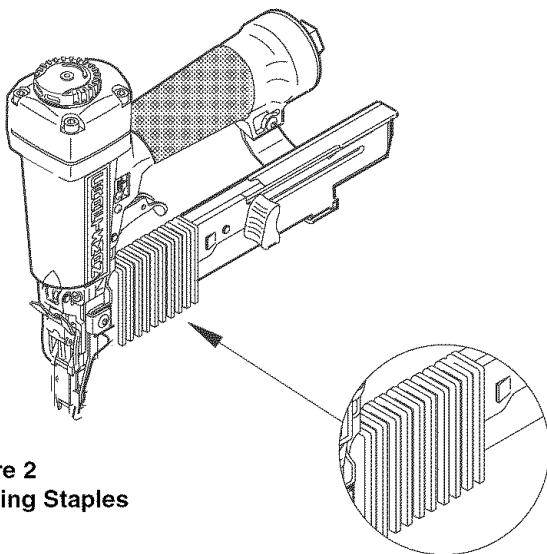
## LOADING

Refer to Figures 2 & 5 (pages 3 and 6).

**WARNING:** Disconnect tool from air supply. Always load with nose of tool pointing away from you and others. Always wear safety goggles that comply with United States ANSI Z87.1.

**NOTE:** For best results use Sears fasteners only.

- Slide pusher (Fig. 5, No. 48) back until it engages the latch. Tilt magazine cover (Fig. 5, No. 51) back to allow fasteners to be installed onto magazine (Fig. 5, No. 55). Tilt pusher to release and gently slide pusher forward against fasteners as shown.



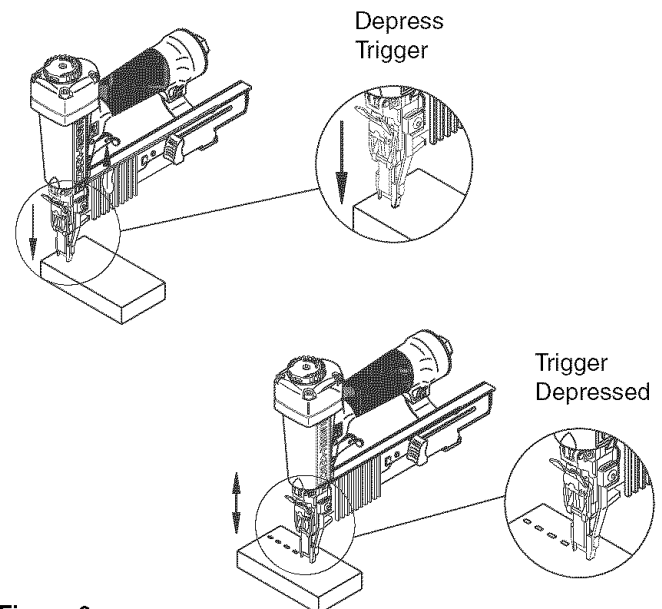
**Figure 2**  
Loading Staples

## STAPLING OPERATION

Refer to Figure 3 below.

**WARNING:** Never operate tool unless contact trip is in contact with workpiece. Do not operate tool without fasteners or damage to tool may result. Never fire fasteners into the air because fasteners may injure operator or others and damage to tool may result.

- The air tool is equipped with a contact trip safety mechanism (see Figure 3) that disables tool unless contact trip is pushed against work. Hold tool handle firmly and press contact trip on workpiece where fastener is to be applied. Pull trigger to drive fastener into workpiece.
- The tool can also be operated by holding trigger depressed and pushing contact trip against workpiece. This operating procedure provides rapid-fire fastener driving. Never operate tool unless contact trip is in contact with workpiece.
- The tool is equipped with a push-button switch that can change the operating mode from rapid-fire to single fire. When the red stop button (Fig. 5, No. 37) is pushed in from the fastener loading side, the tool will fire one fastener only. To fire the next fastener, both the trigger (Fig. 5, No. 30) and the contact trip (Fig. 5, No. 63) must be released.



**Figure 3**  
Contact Trip Operation

## QUICK RELEASE NOSE

Refer to Figure 5 (page 6).

The tool is equipped with a quick release nose for clearing jammed fasteners.

- If a fastener jams in the tool, disconnect the air supply from the tool. Open the magazine and remove any fasteners. Pull the nose cover latch (Fig. 5, No. 61) down and release the nose cover. Remove the jammed fastener and secure the latch. Reload the fasteners and reconnect the air supply.

## OPERATING PRESSURE

- Use only enough air pressure to perform the operation. Air pressure in excess of that which is required will make the operation inefficient and may cause premature wear or damage to the tool.
- Determine minimum air pressure required by driving some test fasteners into the workpiece. Set air pressure so that test fasteners are driven down flush with the work surface. Fasteners driven too deep may damage workpiece.
- Air pressures should be adjusted to account for different material densities, grain structures and moisture content. Longer fasteners will require more air pressure to drive flush with the surface of the workpiece.
- All fastener lengths should drive easily into pressure-treated lumber, pine, SPF and plywood. Hardwoods (such as oak) and engineered polymer lumber might require maximum pressure (for the air tool) to drive flush. For optimum combinations of lumber and fastener, consult lumber professionals and/or manufacturers.

## EXHAUST DEFLECTOR

Refer to Figures 4 & 5 (pages 4 and 6).

- Exhaust deflector can be positioned to point in any direction (full 360° movement). Reposition deflector (Fig. 5, No. 2) by grasping firmly and rotating to the desired position.

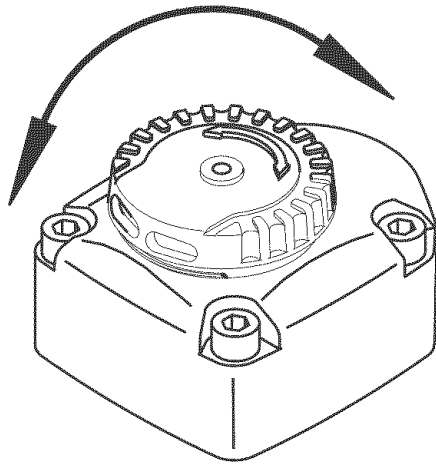


Figure 4 - Exhaust Deflector Adjustment

## MAINTENANCE

Refer to Figure 5 (page 6).

### LUBRICATION

Lubricate tool daily with quality air tool oil. If no air line lubricator is used, place five or six drops of oil into air inlet cap (Fig. 5, No. 23) of tool every day.

### MAGAZINE AND PISTON-RAM

- Keep magazine and nose clean and free of any dirt, lint or abrasive particles.

The tip of the ram (Fig. 5, No. 17) can become dented or rounded over time.

- Square off the tip of the ram with a clean, fine hand file to extend the life of the ram and tool. Fastener firing will be more consistent if the ram tip is kept clean and square.

### SAFETY MECHANISM

Inspect contact trip safety mechanism daily for proper operation. Do not operate tool if mechanism is not operating properly.

With the red push-button switch in the rapid-fire mode, perform the following procedures to test safety mechanism:

- Leave trigger untouched while pushing contact trip into workpiece. **Tool must not fire.**
- Pull trigger while contact trip is clear of work and pointed away from operator and others. **Tool must not fire.**
- Depress and hold trigger. Push contact trip against work where fastener is needed. The tool should drive only one fastener each time the contact trip is pushed against workpiece.

**If contact trip mechanism does not operate properly, repair tool immediately through Sears Service Center.**

Replace any damaged or missing parts. Use the parts list to order parts.

### REBUILD KITS

Rebuild kits are available as spare parts, (see page 7). Tools should be rebuilt if tool fails to operate properly after extended use. See troubleshooting to determine required replacement parts.

**Disconnect tool from air supply before attempting repair or adjustment.**

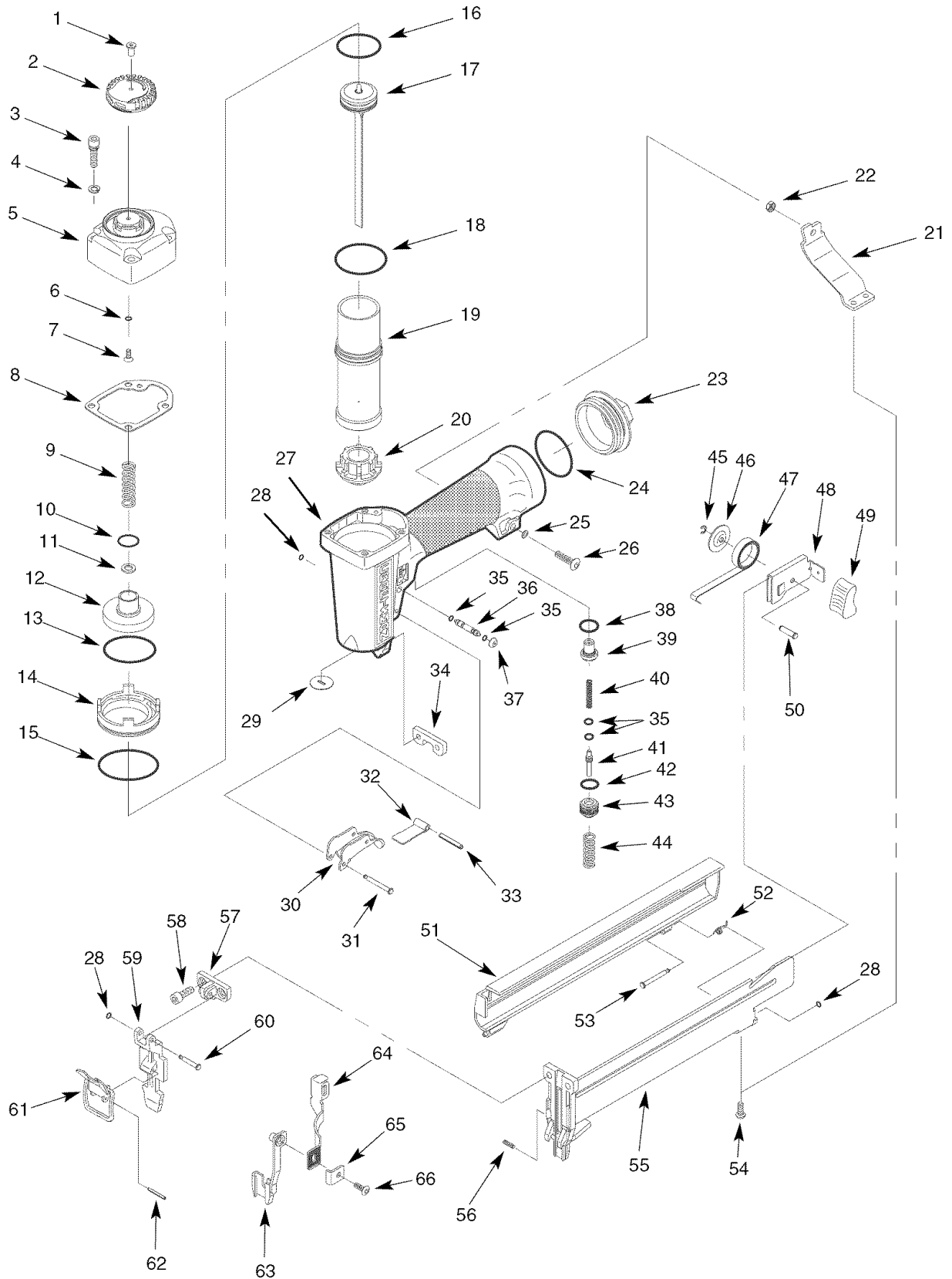
**NOTE:** When replacing O-rings or cylinder, lubricate with air tool oil before assembly.

## TROUBLESHOOTING

SYMPTOM	POSSIBLE CAUSE(S)	CORRECTIVE ACTION
Trigger cap leaks air	<ol style="list-style-type: none"> <li>1. O-ring damaged</li> <li>2. Valve stem, seal or O-rings damaged</li> </ol>	<ol style="list-style-type: none"> <li>1. Check and replace damaged O-ring (Fig. 5, No. 42)</li> <li>2. Check and replace damaged stem, seal or O-rings (Fig. 5, Nos. 35, 38, 41 and 42)</li> </ol>
Cap leaks air	<ol style="list-style-type: none"> <li>1. Cap bolts loose</li> <li>2. Damaged O-ring or gasket</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten bolts (Fig. 5, No. 3)</li> <li>2. Check and replace damaged O-ring or gasket (Fig. 5, Nos. 6 and 8)</li> </ol>
Nose leaks air	<ol style="list-style-type: none"> <li>1. Damaged O-ring</li> <li>2. Damaged bumper</li> <li>3. Ram guide damaged</li> </ol>	<ol style="list-style-type: none"> <li>1. Check and replace damaged O-ring (Fig. 5, No. 18)</li> <li>2. Check and replace damaged bumper (Fig. 5, No. 20)</li> <li>3. Check and replace guide (Fig. 5, No. 29)</li> </ol>
Tool will not operate	<ol style="list-style-type: none"> <li>1. Insufficient air supply</li> <li>2. Damaged or worn head valve O-rings</li> <li>3. Broken head valve spring</li> <li>4. Head valve binding in cap</li> <li>5. Insufficient lubrication</li> </ol>	<ol style="list-style-type: none"> <li>1. Check air supply</li> <li>2. Replace damaged or worn O-rings (Fig. 5, Nos. 10 and 13)</li> <li>3. Replace damaged spring (Fig. 5, No. 9)</li> <li>4. Clean and lubricate cap and head valve (Fig. 5, Nos. 5 and 12)</li> <li>5. Place five or six drops of air tool oil into inlet cap</li> </ol>
Tool operates slowly or loses power	<ol style="list-style-type: none"> <li>1. Damaged head valve spring</li> <li>2. Damaged or worn O-rings</li> <li>3. Damaged trigger assembly</li> <li>4. Build-up on ram</li> <li>5. Cylinder not sealed on bumper properly</li> <li>6. Insufficient air supply</li> <li>7. Insufficient lubrication</li> <li>8. Head valve poorly lubricated</li> </ol>	<ol style="list-style-type: none"> <li>1. Check and replace damaged spring (Fig. 5, No. 9)</li> <li>2. Check and replace damaged or worn O-rings</li> <li>3. Check and replace trigger assembly</li> <li>4. Clean piston/ram assembly (Fig. 5, No. 17)</li> <li>5. Disassemble cylinder and assemble properly</li> <li>6. Check air supply</li> <li>7. Place five or six drops of air tool oil into inlet cap</li> <li>8. Disassemble head valve (Fig. 5, No. 12) clean, lubricate, and assemble properly</li> </ol>
Tool skips fasteners or inconsistent operation	<ol style="list-style-type: none"> <li>1. Worn or damaged bumper</li> <li>2. Build-up on ram</li> <li>3. Insufficient air supply</li> <li>4. Damaged or worn piston O-ring</li> <li>5. Damaged magazine spring</li> <li>6. Fasteners too short</li> <li>7. Damaged fasteners</li> <li>8. Incorrect fastener size</li> <li>9. Cap leaks</li> <li>10. Damaged trigger valve seal and O-rings</li> <li>11. Bent or damaged ram</li> <li>12. Dirty magazine</li> <li>13. Damaged or worn magazine</li> <li>14. Insufficient lubrication</li> </ol>	<ol style="list-style-type: none"> <li>1. Check and replace bumper (Fig. 5, No. 20)</li> <li>2. Clean and lubricate piston/ram assembly (Fig. 5, No. 17)</li> <li>3. Check air supply</li> <li>4. Check and replace O-ring (Fig. 5, No. 16)</li> <li>5. Check and replace spring (Fig. 5, No. 47)</li> <li>6. Use Sears recommended fasteners only</li> <li>7. Discard damaged fasteners</li> <li>8. Use Sears recommended fasteners only</li> <li>9. Tighten cap bolts (Fig. 5, No. 3). Check and replace damaged cap O-ring (Fig. 5, No. 6) or gasket (Fig. 5, No. 8)</li> <li>10. Check and replace damaged seal and O-rings (Fig. 5, Nos. 35, 38 and 42)</li> <li>11. Check and replace damaged piston/ram assembly (Fig. 5, No. 17)</li> <li>12. Clean magazine and lubricate with air tool oil</li> <li>13. Check and replace magazine (Fig. 5, No. 55)</li> <li>14. Place five or six drops of air tool oil into inlet cap (Fig. 5, No. 23)</li> </ol>

# Model 351.183670

## Figure 5 - Replacement Parts Illustration for 1/4" Crown Stapler



## REPLACEMENT PARTS LIST FOR STAPLER

KEY NO.	PART NO.	DESCRIPTION	QTY.
1	4157.00	Flange Nut	1
2	4159.00	Deflector	1
3	4434.00	5-0.8 x 32mm Socket Head Bolt	4
4	STD852005	5mm Lock Washer*	4
5	4435.00	Cap	1
6	4165.00	3 x 1.5mm O-Ring	1
7	5990.00	3-0.5 x 6mm Pan Head Screw	1
8	4195.00	Cap Gasket	1
9	4210.00	Head Valve Spring	1
10	4300.00	14.8 x 2.4mm O-Ring	1
11	4301.00	Spacer	1
12	4302.00	Head Valve Piston	1
13	4303.00	33.5 x 2mm O-Ring	1
14	4304.00	Collar	1
15	4305.00	41 x 1.8mm O-Ring	1
16	4436.00	22.4 x 3.1 O-Ring	1
17	4437.00	Piston Ram Assembly	1
18	4309.00	31.5 x 1.8mm O-Ring	1
19	4438.00	Cylinder	1
20	4412.00	Bumper	1
21	4439.00	Magazine Bracket	1
22	6349.00	5-0.8mm Fiber Hex Nut	1
23	4440.00	Inlet Cap	1
24	4316.00	40 x 3mm O-Ring	1
25	STD851005	5mm Flat Washer*	1
26	4441.00	5-0.8 x 18mm Socket Head Screw	1
27	4442.00	Body	1
28	4313.00	1.2 x 2.6mm O-Ring	3
29	4487.00	Ram Guide	1
30	4322.00	Trigger	1
31	4323.00	Clevis Pin	1
32	4321.00	Trigger Lever	1
33	6163.00	3 x 16mm Spring Pin	1
34	4414.00	Support Plate	1

\* Standard hardware item available locally

Δ Not Shown

Recommended Accessories		
Δ	Staples, 1/4" crown - 1/2" Long	18333
Δ	Staples, 1/4" crown - 3/4" Long	18334
Δ	Staples, 1/4" crown - 7/8" Long	18336
Δ	Staples, 1/4" crown - 1" Long	18371
Δ	Staples, 1/4" crown - 1 1/8" Long	18372
Δ	Staples, 1/4" crown - 1 1/4" Long	18373
Δ	Staples, 1/4" crown - 1 1/2" Long	18374

KEY NO.	PART NO.	DESCRIPTION	QTY.
35	4318.00	2.5 x 1.4mm O-Ring	4
36	4320.00	Throttle	1
37	4319.00	Stop Button	2
38	6136.00	8.8 x 1.9mm O-Ring	1
39	4324.00	Trigger Valve Head	1
40	4325.00	Trigger Valve Spring	1
41	4326.00	Valve Stem	1
42	4327.00	9.8 x 1.9mm O-Ring	1
43	4328.00	Trigger Cap	1
44	4329.00	Trigger Spring	1
45	46-221596-9	CMI-3 E-Ring	1
46	4444.00	Capstan	1
47	4445.00	Magazine Spring	1
48	4446.00	Pusher	1
49	4447.00	Pusher Knob	1
50	4448.00	Clevis Pin	1
51	4449.00	Magazine Cover	1
52	4450.00	Cover Spring	1
53	4451.00	Clevis Pin	1
54	4417.00	4-0.7 x 6mm Socket Head Screw	1
55	4452.00	Magazine	1
56	4453.00	3-0.5 x 10mm Socket Set Screw	1
57	4461.00	Nose Plate	1
58	6045.00	5-0.8 x 20mm Socket Head Bolt	2
59	4454.00	Latch Plate	1
60	4455.00	Clevis Pin	1
61	4456.00	Latch Assembly	1
62	3378.00	2.5 x 14mm Spring Pin	1
63	4457.00	Contact Trip	1
64	4458.00	Trip Lever	1
65	4459.00	Adjusting Plate	1
66	7537.00	4-0.7 x 10mm Socket Head Screw	1
Δ	4460.01	Operator's Manual	1

Rebuild Kits			
Δ	3097.00	Trigger Rebuild Kit Fig. 5, Nos. 38, 41, 42, 44 and two 35	1
Δ	4407.00	Head Valve Rebuild Kit Fig. 5, Nos. 8, 10, 13 and 15	1
Δ	4464.00	Piston-Ram Assembly Rebuild Kit Fig. 5, Nos. 16, 17, 18 and 20	1

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