

User Manual

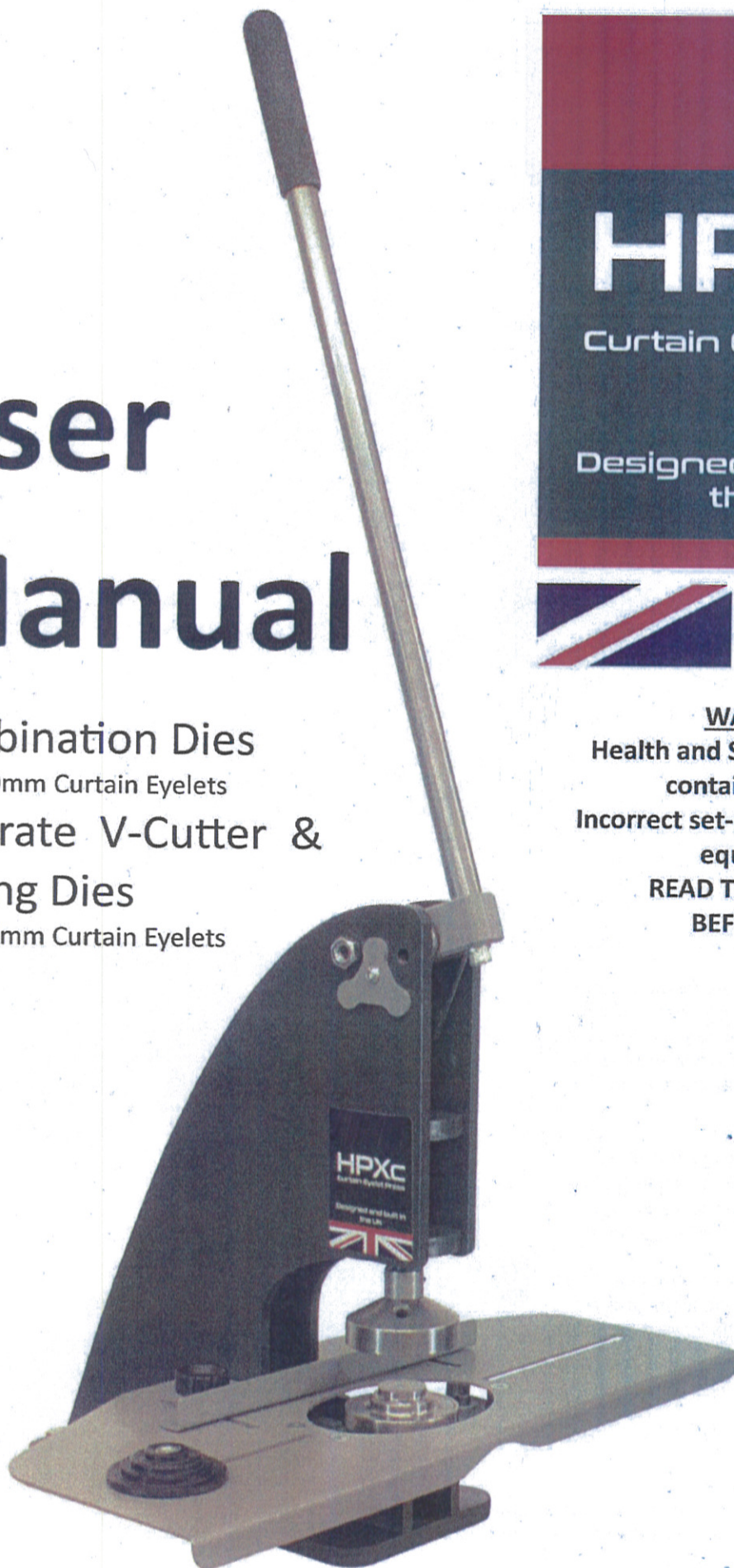
Combination Dies

Up to 40mm Curtain Eyelets

Separate V-Cutter & Setting Dies

Up to 66mm Curtain Eyelets

19-3



HPXc

Curtain Eyelet Press

Designed and built in
the UK

WARNING!

Health and Safety information
contained within.

Incorrect set-up can damage this
equipment.

**READ THIS MANUAL
BEFORE USE!**

ABOUT THE MACHINE.

Fig 1

Remove the machine and other parts from the packaging. In addition to this booklet and the setting dies you have ordered the following should also be included:

1. 1 x HPXc Press body
2. 1 x Operating handle
3. 1 x Base plate with back stop and eyelet distance regulator
4. 3 x hexagon keys (3mm, 5mm and 6mm)
5. 1 x 19mm x 24mm Spanner
6. 1 x M8 cap screw & washer
7. 2 x M6 cap screws & washers

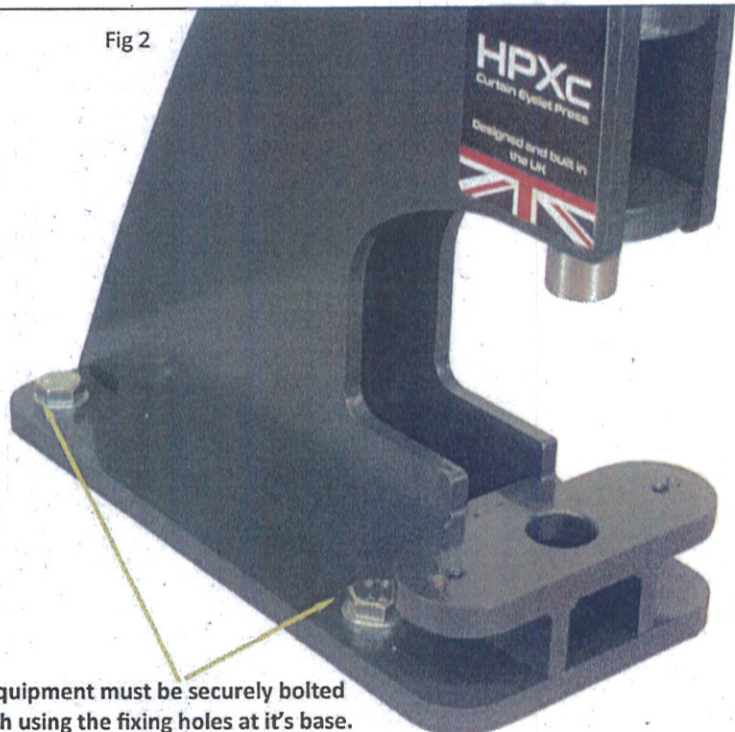


The HPXc machine cannot be operated without being first being bolted down to a suitable work bench. If you have purchased our self-assembly bench with this machine then please assemble this first and bolt the HPXC to it using the nuts and bolts that are supplied with the bench.

Alternatively, fasten the machine to a suitably solid bench by drilling through the top surface and bolting the HPXC to it securely using good quality fixings. The holes in the base will take 4 x M12 size bolts.

If you do not fasten the machine down in one of the above methods, then it will not cut material or set the eyelets. It will also want to tip forward potentially injuring the operator!

Fig 2

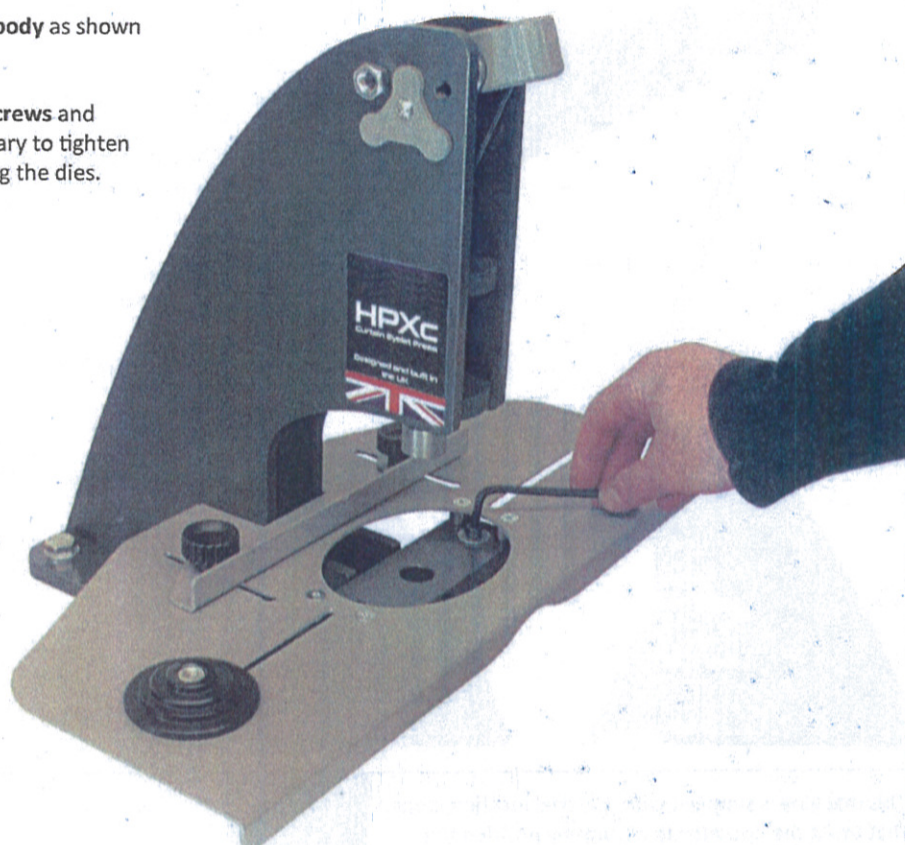
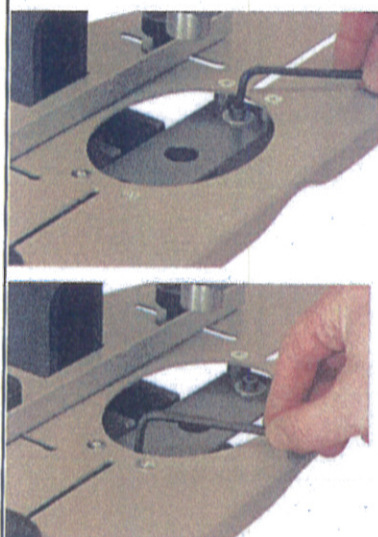


Before use, this equipment must be securely bolted to a suitable bench using the fixing holes at it's base.

BASIC MACHINE SETUP FOR FIRST USE.

Place the **base plate** on to the **press body** as shown below.

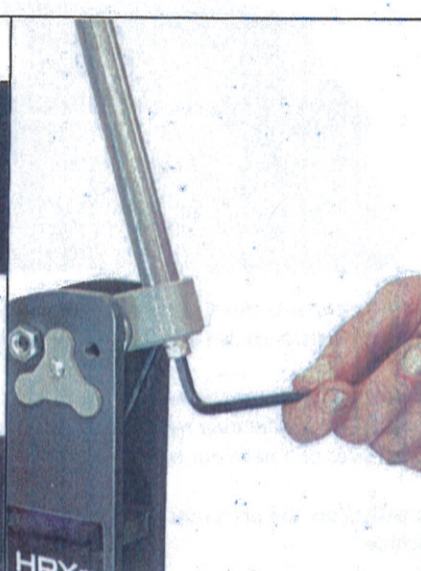
Fix in position using the 2 x **M6 cap screws** and **washers**, at this point it is not necessary to tighten these fully as this is done when setting the dies.



Insert the **operating handle** in to the hole in the drive unit at the top of the machine



Screw the **M8 cap screw** into the underside of the drive unit.



Tighten the **M8 cap screw** with the **6mm hex key**. The machine is now ready to fit the dies.

BASIC OPERATION OF THE PRESS



When viewed from the left hand side of the machine (see left and below) in its normal REST position when waiting to be used the handle is held at an "11 o'clock" position.

We operate the press by pulling the handle forward until it is at the "3 o'clock position" or horizontal position (below right)

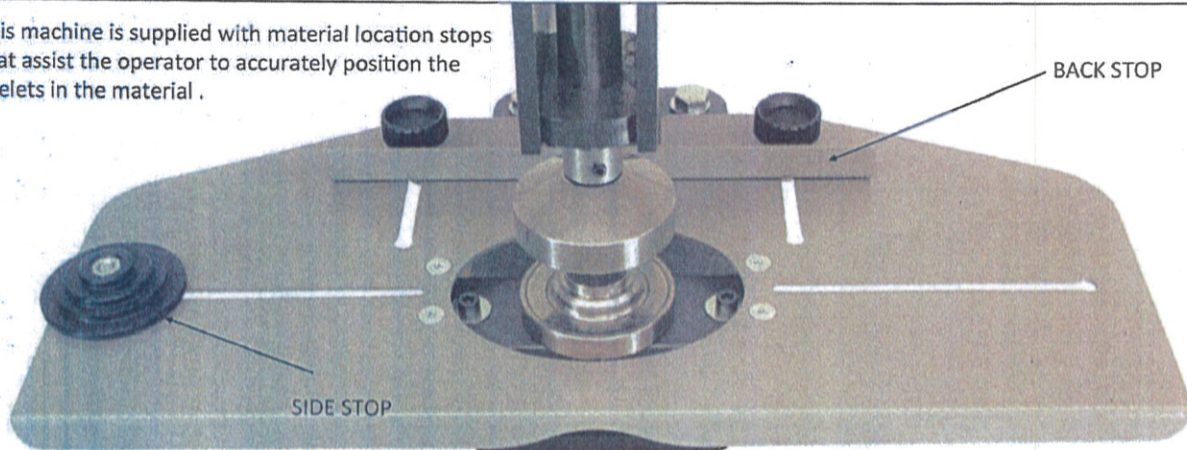
When the dies have been fitted correctly you will notice relatively free movement of the handle until it reaches just past the "2 o'clock" position.

Pressure then needs to be applied to the handle in order to complete the rotation to "3 o'clock" to complete its cycle

The handle will not move further past the 3 o'clock.



This machine is supplied with material location stops that assist the operator to accurately position the eyelets in the material.



The **back stop** sets the distance from the top of the curtain, while the **side stop** controls the distance between each of the eyelets, the distance can be set between 10cm and 25cm centres.

This is achieved by un-screwing (turn anti-clockwise) and positioning the **side stop** to the desired distance then placing the previously set eyelet over nylon stop while the next hole is cut. The steps in the stop correspond to the diameters of the various sizes of hole in our range of curtain eyelets.

Depending on the preference of the operator the **side stop** can be used on either the left or the right hand side of the machine.

It is recommended that the operator practices with some waste material first to prevent errors in calculating the position of the eyelets.

As an alternative, you can use the back stop on its own, and mark the position of the eyelets with pins, however please ensure that any pins are removed from the material before cutting as they will damage the dies.

MACHINE USE

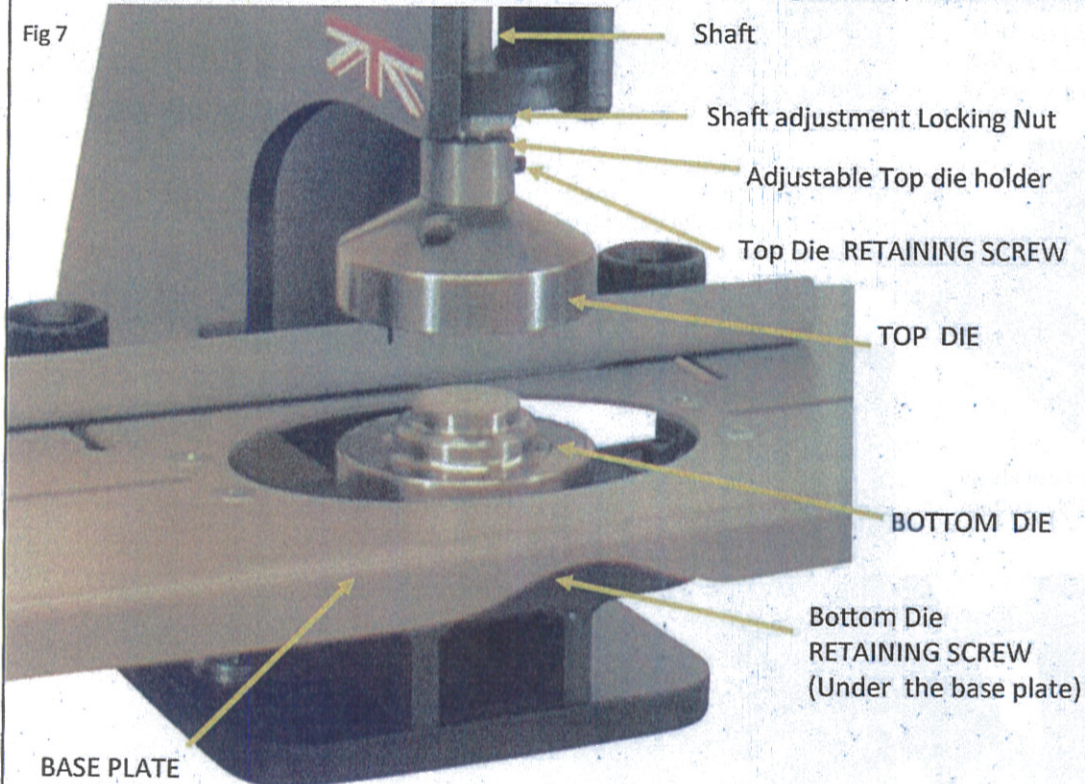
This machine allows the user to insert eyelets in their chosen material. By changing the dies (see fig 6) different size eyelets can be fitted.

Depending on your order requirements this machine will have been supplied with either combination type dies that both cut the material and fit the eyelet in one sequence with out the need to change the dies (see Fig 7) or separate V-cutter and setting dies (see Figure 7).

This manual describes and illustrates the setup and operation procedure to insert 40mm curtain eyelets using a HPXc Eyelet Machine using the combination dies; the process is the same for all sizes of eyelet when using combination dies.

Alternate instructions are available if you are using separate V-cutter & Setting dies in Appendix A at the back of this manual.

Fig 7



Separate V-Cutter & Setting Dies
(See Appendix A for setup and operation)



IMPORTANT SAFETY INFORMATION

- Be aware that there are sharp cutting edges on the dies.
- Keep hands away from dies when applying pressure.
- Follow the setup routines explained in this manual before first use.
- Always follow maintenance routines explained in the maintenance section.

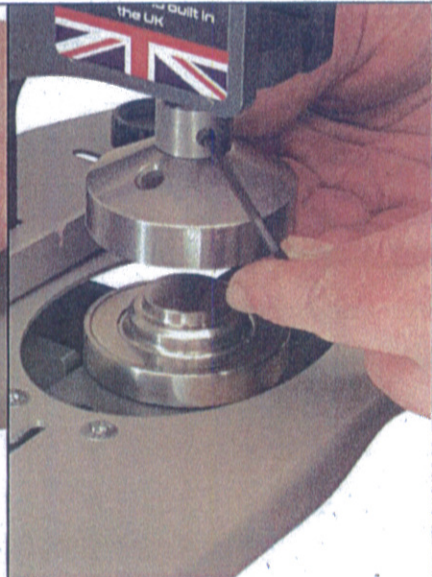
COMBINATION DIES - INSTALLATION OF THE DIES



Step 1- The dies must now be centralised and the height adjusted. Firstly lower the operating handle and with the supplied spanner loosen the shaft locking nut (turn clockwise) so the top die holder can turn freely. Then wind the top die holder anti clockwise upwards so it is fully wound up to the top.



Step 3 - Fit the bottom die in to the base of the machine and tighten the retaining screw (if there is a flat edge on the die it should be towards the screw). Ensure the die is sat flat on the base.



Step 4 - Fit the top die in to the shaft & tighten the retaining screw (again any flat edge on the die should be towards the screw). Ensure the die is flat against the underside of the shaft.
DO NOT OVERTIGHTEN AS THIS WILL DAMAGE THE SETTING DIES



Step 2 - Loosen the two base plate screws on either side of the bottom die.



Step 5 - Gently lower the handle to the "3 o'clock" position.

Then turn the top die clockwise until the it touches the bottom die whilst adjusting the base plate to move the bottom die so that both dies come together until there is no further movement.

When there is no further movement retighten the base plate screws while keeping the dies together.



Step 6 - Lift the operating handle slightly to release the top die and give it a further 180 degree turn, when you lower the handle again it should now sit at approximately 2 o'clock.



Finally retighten the locking nut (anti-clockwise) with the spanner and your dies should be ready to use.

It is important to do these steps each time the dies are changed or when any other part of the machine is adjusted!

COMBINATION DIES - OPERATION OF THE MACHINE



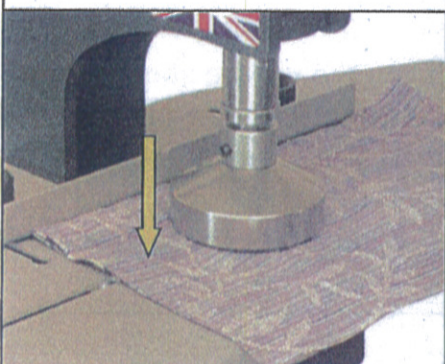
Step 1 - After aligning the dies as shown on the previous page, Place a backing ring with its spikes facing upwards on to the bottom die (it should locate in the recess of the bottom die).....



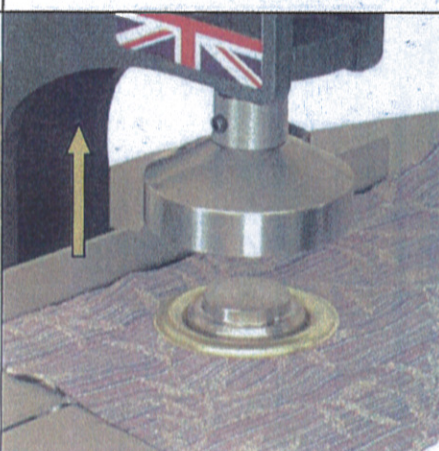
Step 2 - ...Place the material in the desired position where you want the eyelet over the bottom die and ring, the material should be face side up. Lower the top die on to the material and apply firm pressure until it cuts the material (there should be a positive click as it cuts) then lift the top die clear, this should reveal a hole in the material with the bottom die protruding through



Step 3 -take an eyelet and sit it on the bottom die that is now visible through the material....



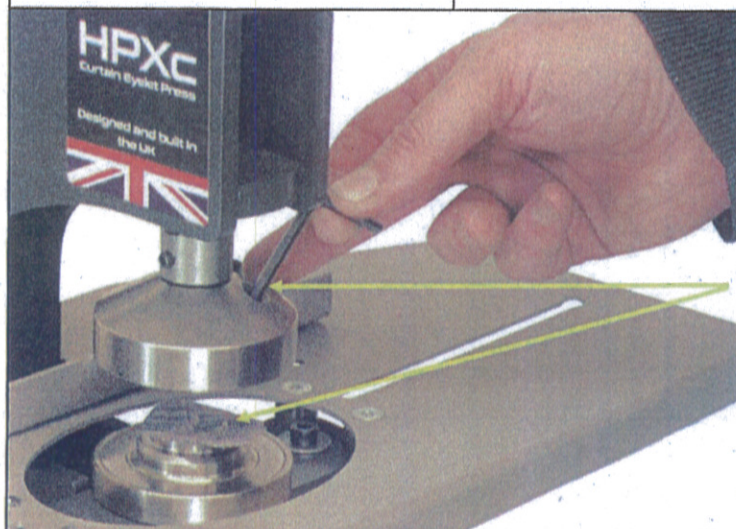
Step 4 - ...Lower the top die down again until it makes contact with the eyelet then apply firm pressure with the lever to cause the eyelet to push through the material and roll around the ring.....



Step 5 - ..Lift the top die clear of the base die to release the fitted eyelet from the dies.



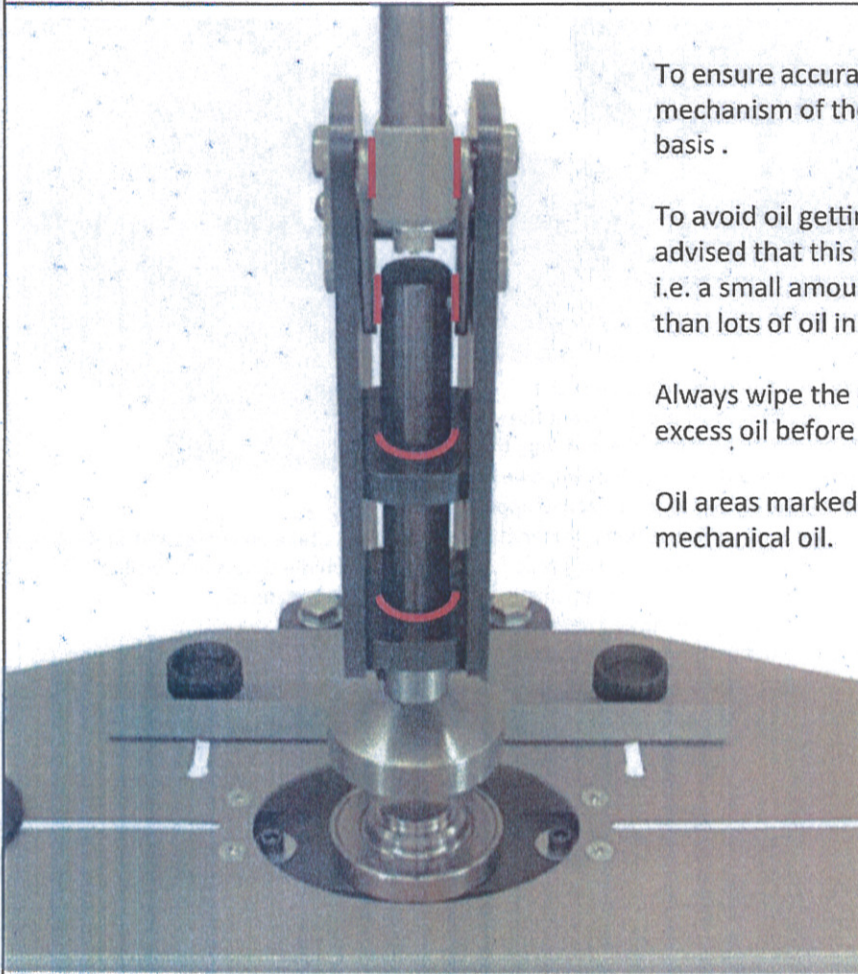
Step 6 - Inspect the eyelet to ensure it has correctly rolled and firmly gripped the material. (If necessary, you can re-apply pressure if the eyelet is still loose).



Simply repeat these steps for each eyelet in the curtain.

As you cut the holes, waste material will collect within the body of the top die, use the hexagon key supplied to push this waste material out. If waste material is allowed to build up in the top die it will affect the ability of the dies to set the eyelet.

MAINTENANCE



To ensure accuracy and long life the shaft and mechanism of the press should be oiled on a regular basis .

To avoid oil getting on to any work material it is advised that this is done on a "little and often basis". i.e. a small amount of oil applied frequently rather than lots of oil in one go.

Always wipe the dies and work area to remove any excess oil before commencing work.

Oil areas marked in red using a general purpose mechanical oil.

If you are unsure about any aspect of the set-up and operation or maintenance of this machine then please contact your supplier.

NOTES:

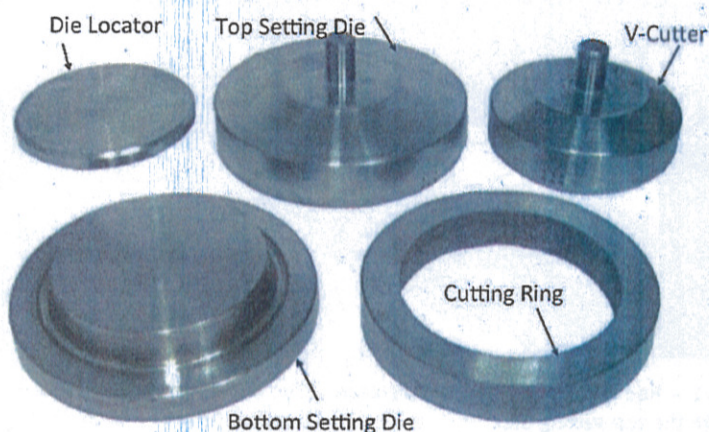
Appendix A

Inserting eyelets with the Separate V-Cutter & Setting Dies

This section covers the slightly different method of fitting eyelets with the separate V-Cutter & Setting Dies as shown right.

Although suitable for the vast majority of materials, certain types of material do not lend themselves to being cut using the combination type dies as illustrated in the main part of the manual. Some voils, silks and certain heavy duty theatrical blackout materials can snag and pull threads when cut.

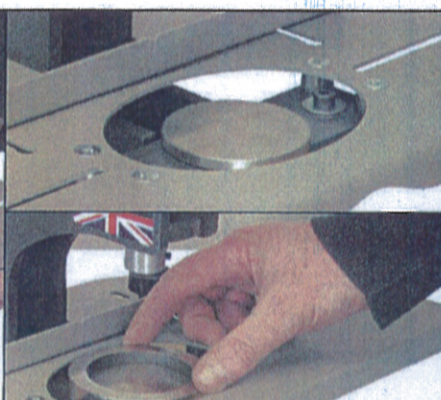
In this situation pre-cutting the hole with a V-cutter will eliminate this problem in most cases.



SETTING UP AND USING THE V-CUTTER



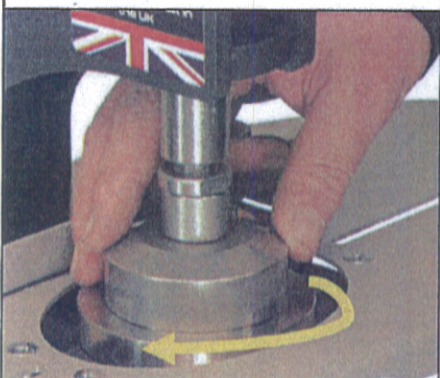
Step 1 - As with all die setups start by loosening the 2 M6 cap screws that hold the base plate in position as well as the shaft locking nut and screw the die holder up into the shaft.



Step 2 - Fit the die locator in to the base plate of the HPXC and tighten the retaining screw. Then place the cutting ring over the die locator



Step 3 - Insert the v cutter in to the shaft & tighten the retaining screw



Step 4 - Using the operating handle gently lower the V-cutter until the handle is at "3 o'clock" then screw the die down until it makes contact with the cutting ring, move the baseplate at the same time to allow the dies to centralise with each other. When no further movement is possible retighten the 2 M6 Cap screws.

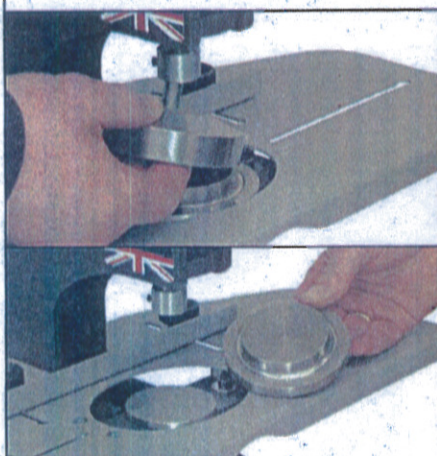


Step 5 - Use the operating handle to lift the top die slightly, then rotate it a further half a turn clockwise. Then tighten the locking nut by turning it anti-clockwise and nip it tight with the spanner, then return the operating handle to the rest position.

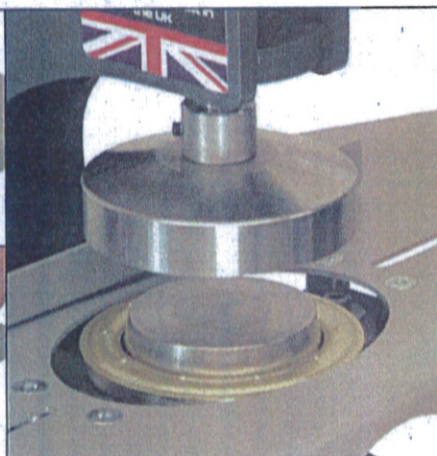


Step 6 - Place the material over the cutting ring in the desired position, lower the V-cutter down until it makes contact. Then apply firm pressure to cut the material. As it cuts it should make a firm click noise.

SET UP AND USE OF THE SETTING DIES



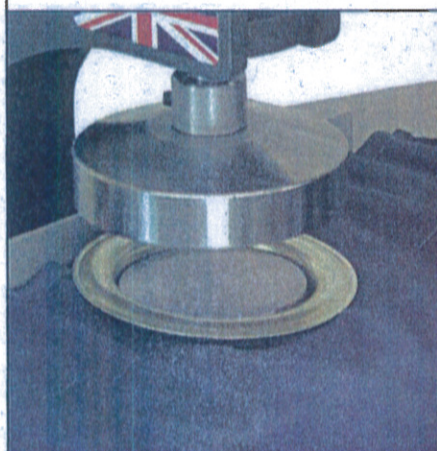
Step 1 - Remove the V-cutter and replace it with the **top setting die**. Lift the **cutting ring** off the die locator and replace that with the **bottom setting die**.



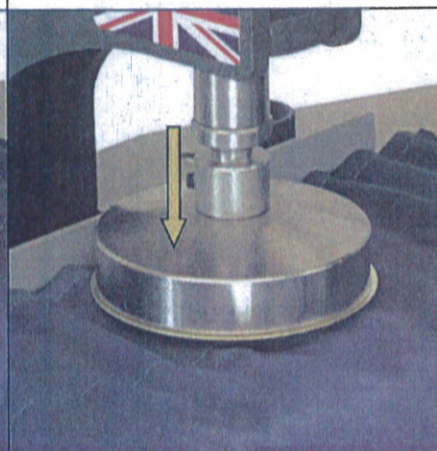
Step 2 - Place a backing ring with its spikes facing upwards on to the **bottom setting die**.



Step 3 - Place the material on the machine and locate one of the holes that you have just cut over the **bottom die** with the material face side up.



Step 4 - Take an eyelet and sit it on the **bottom setting die**, try not to trap any material between the eyelet and the **bottom setting die**.



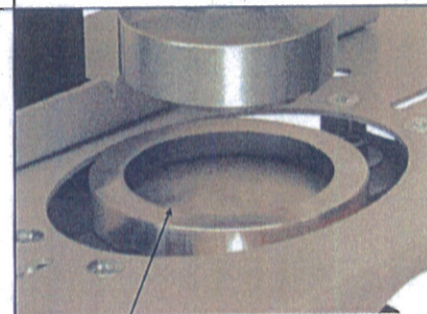
Step 5 - Lower the **top setting die** down until it makes contact with the eyelet then apply firm pressure with the lever to cause the eyelet to push through the material and roll around the ring.



Step 6 - Lift the **top setting die** up to reveal the set eyelet



Step 7 - Inspect the eyelet to ensure it has correctly gripped the material. If necessary put the eyelet back on the machine and apply more pressure to achieve a tighter grip.



The **cutting ring** has two cutting edges, when one side becomes blunt simply turn the ring over and use the other side.

When both sides have become blunt they can be re-sharpened this is best done by returning them to your supplier