



# Handolex™ HPX2&3

Eyelet Press

Designed and built in  
the UK



# User Manual

“V” Hole Cutting Dies,  
Eyelet Setting Dies  
&  
Combination Cutting  
and Setting Dies

**WARNING!**

Health and Safety information  
contained within.

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## IMPORTANT SAFETY INFORMATION

- Be aware that there can be sharp cutting edges on the dies.
- Keep hands away from dies when applying pressure.
- Keep hands away from the internal mechanism of the press.
- Follow the setup routines explained in this manual before first use.
- Always follow maintenance routines explained in the maintenance section.
- Please contact your supplier if there is anything you don't understand.

## BEFORE FIRST USE

- Wipe off any excess oil from the machine that would have been applied during assembly and storage
- **Unless the machine has been supplied with the dies fitted and ready to use "out of the box" the dies need to be fitted or you are changing the dies for another size for example you must follow the set up procedure laid out in these instructions.**
- Failure to follow the setup procedure could damage the dies and invalidate the warranty.

# ABOUT THE MACHINE.

This machine allows the user to insert eyelets and other fasteners in various types of fabric, leather and other materials, by changing the dies different size eyelets can be fitted.

This manual describes and illustrates the setup and operation procedure to insert eyelets using a HPX2 Eyelet Machine using separate V-cutter & Setting Dies, and also Combination (Combi) dies that contain both a cutter and setting function in the same set of dies.

The process is the same for all sizes of eyelet when using combination dies.

Remove the machine and other parts from the packaging. The standard machine is usually supplied assembled and ready for use. In addition to this booklet and the setting tools you have ordered the following should also be included:

1. 1 x HPX2 Press body
2. 1 x Operating Handle
3. 1 x Lower Die Positioning Plate
4. 1 x Adjustable Material Back Stop
5. 2 x Hexagon keys (3mm, 5mm)

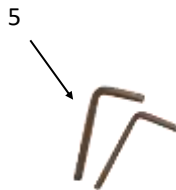
Also shown are typical tools

6. Upper Die (Design will vary depending on order)
7. Lower Die (Design will vary depending on order)

## IF REQUIRED THIS MACHINE CAN BE FIXED TO A SUITABLE SURFACE IF REQUIRED

However this is not necessary for normal operation and can prove more convenient if kept mobile.

If you wish to fix the machine to a suitable surface there are 4 mounting holes provided in the base of the press for this purpose.



## MAINTENANCE

### Lubrication

The mechanism of the press should be oiled to keep it working correctly.

A basic machine oil such as 3in1 Oil for example is sufficient, apply it to the areas indicated in red on the image to the right.

The best rule of thumb is "little and often" applying too much oil will cause it to drip down on to the setting dies and could mark your material.



## "V" CUTTING DIES - Setup

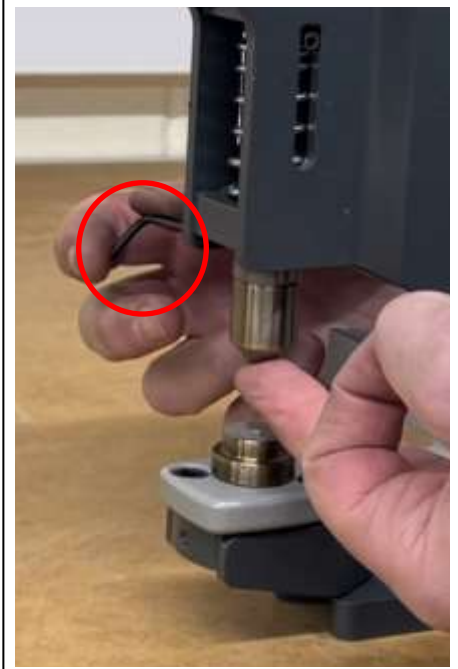


V Cutters will cut holes in most materials

**Step 1.** Loosen the 2 die alignment plate (DAP) screws so that the DAP is loose and able to move.



**Step 2.** Insert the lower cutting die into the hole in the DAP and tighten the locking screw.



**Step 3.** Insert the top cutter into movable shaft and tighten the retaining screw.



**Step 4.** Applying light pressure to the handle to lower the top die down so its tip enters the hole in the lower die. As you lower the top die ensure the lower die is centralised around it.



**Step 5.** Holding the dies in position re-tighten the 2 DAP screws to fix the lower die in to a central position in relation to the top die.



**Step 6.** Then lift the handle up to raise the top die clear, the dies are now ready to be used.

## "V" CUTTING DIES - Operation



**Step 1.** Place the material over the lower die where you want to make a hole.



**Step 2.** lower the top die down and touch the material, then continue to apply pressure until you hear and feel a click as the material is cut.



**Step 3.** lift the die to reveal the cut hole. Repeat as required.



## Setting Dies - Setup & Use



After cutting your holes you will now change the dies to set the eyelets

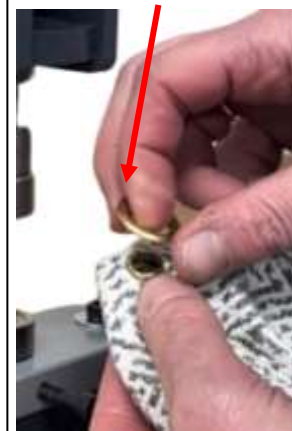
**Step 1. Remove both of the cutting dies**



**Step 2. Fit the setting dies into the press, as the DAP has already been aligned this should not need adjusting. Be careful not to mix the cutting and setting dies together.**



**Step 3. Inset the barrel of the eyelet into the hole in the material, add a washer (if used) over the barrel on the back of the material.**



**Step 4. with the eyelet side to the bottom and the washer side to the top place them on the lower die.**



**Step 5. lower the top die and apply pressure to set the eyelet, for larger eyelets remember the press applies the most pressure when the handle is almost horizontal.**



**Step 6. lower the top die and apply pressure to set the eyelet, for larger eyelets remember the press applies the most pressure when the handle is almost horizontal.**

## COMBINATION DIES - Operation

Combination or “combi” eyelet dies first cut the material with the first pull of the handle and then set the eyelets with a second pull.



Step 1. Place a flat ring over the pin on the lower die so it sits in the recess.



Step 2. Place the material between the dies where you want to fit the eyelet. Lower the top die down and apply firm pressure to cut a hole in the material.



Step 3. Lift up the die, the pin will now be protruding through the material. The waste material is ejected through the slot in the top die.



Step 4. Place an eyelet on the pin protruding through the material (note the correct way round)



Step 5. Now lower the top die again and apply firm pressure to set the eyelet.



Step 6. When you lift the top die clear the fitted eyelet will be sat on the lower die and can be removed from the die and the operation repeated.

## COMBINATION DIES - Installation



**Step 1.** To install new dies , first make sure that you have the correct "M Type" dies from Hanolox that are compatible with the machines fittings.



**Step 2.** Using the 5mm hexagon key loosen the two screws on the lower die adjustment plate.



**Step 3.** This will allow the lower die adjustment plate to move a few millimeters in all directions.



**Step 4.** Insert the lower die in to the lower die adjustment plate and fasten in place using the 3mm hexagon key to tighten the screw on the side.



**Step 5.** Next, place the top die onto the lower die as above.



**Step 6.** Carefully lower the shaft down onto the spigot of the top die. Move the lower die adjustment plate to allow the dies to centralise with the shaft.



## COMBINATION DIES - Installation



**Step 7.** Keeping the dies together tighten the top die retaining screw.



**Step 8.** Then tighten the two screws on the lower die adjustment plate.



**Step 3.** Lift the top die clear



**Step 4.** Check that the dies are aligned by lowering the top die on to the lower die. It should lower smoothly without the dies catching on each other. If they do catch repeat the previous steps. **PLEASE NOTE IF THE DIES CATCH THEY CAN EASILY BECOME DAMAGED.**

The logo for Hanolex, featuring the word "Hanolex" in a bold, white, sans-serif font with a small "TM" trademark symbol. The text is centered within a dark blue rounded rectangular background.

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