



Hanolex™ HPX4&5

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 HPX5 Eyelet Machine using the combination dies; the process is the same for all sizes of eyelet when using combination dies.

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

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 HPX5 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.

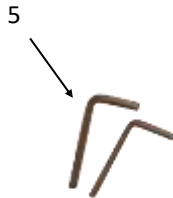


Fig 1

MAINTENANCE

Lubrication



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

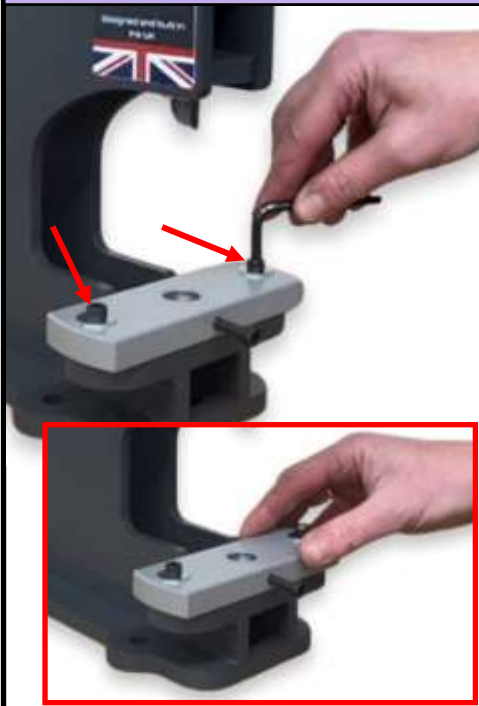
To avoid oil getting on to any work material it is advised that this is done on a "little and often basis". i.e. a small amount of oil applied frequently rather than lots of oil in one go.

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

Oil the 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.

"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. Loosen the upper die holder (UDH) this is done by loosening the locking nut with the supplied spanner. Then screw the UDH up in to the machines shaft.



Step 3. Insert the lower cutting die into the hole in the DAP and tighten the locking screw.



Step 4. Insert the top cutter into the top die holder (TDH) and tighten the retaining screw.



Step 5. Lower the handle down to the horizontal position then screw the TDH containing the top die down so it touches the lower die and wont move any further. As you lower the top die ensure the lower die is centralised around it.



Step 6. lift the handle slightly raising the top die and give it another 1/4 to 1/2 a turn.

"V" CUTTING DIES - Setup & Use



Step 7. lower the top die back down on to the lower die. Making sure it is still centralised with the lower die.



Step 8. lock the TDH in place by tightening the locking nut up against the machine shaft.



Step 9. tighten the 2 DAP screws. Then lift the handle up to raise the top die clear, the dies are now ready to be used.



Step 10. Place the material over the lower die where you want to make a hole.



Step 11. 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 12. 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 and replace with the setting dies



Step 2. if required adjust the upper die holder UDH to allow the handle to sit horizontally when the dies are together



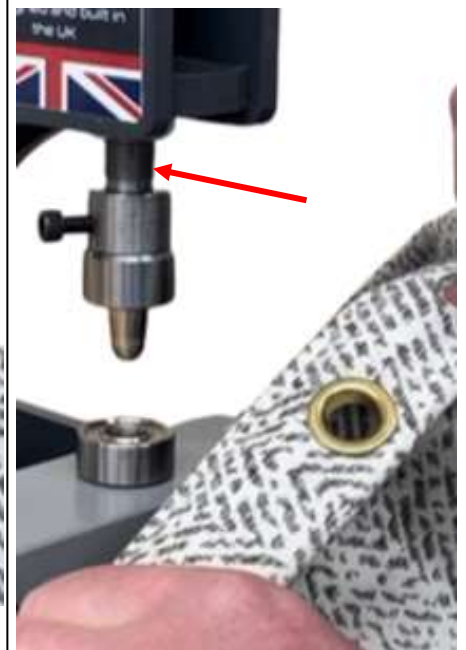
Step 3. Inset the barrel of the eyelet into the hole in the material, add a washer (if used) over the barrel on the back of the material.



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. remember you can adjust the UDH to achieve a tighter or looser set.

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.

FOLLOW ALIGNMENT PROCEDURE ON PAGE 8 BEFORE USING COMBI DIES

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 the 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 - Setup and Alignment



Step 1. To install new dies, first make sure that you have the correct "B Type" dies from Hanolex 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.



Loosen the locking nut on the shaft with the supplied spanner to free up the top die holder.



Step 6. Carefully pull the handle and lower the machine shaft down onto the spigot of the top die so the handle is horizontal. Screw the top die holder down so the die spigot fully engages in it

COMBINATION DIES - Installation



Step 7. Before lifting the handle, tighten the locking nut, the 2 Die adjustment plate screws AND the screw that holds the top die on the top die.



Step 8. Check that the dies are correctly aligned by lifting then 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.



Step 9. When you are satisfied that there is no catching, Lift the handle up and the machine is now ready to use with the combination dies.

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