HP1000
HP2000

Curtain Eyelet Machines

25mm, 40mm & 66mm Eyelets

User Manual
For The HP Range of Curtain Eyeleting Machines with:

COMBINATION DIES

IMPORTANT
Health & safety information contained within; read this manual before use

March 05

MACHINE USE

This manual describes and illustrates the setup and operation to insert 40mm curtain eyelets using an HP1000 machine; however the process is the same for all sizes of eyelet and machine.

This machine allows the user to insert eyelets in their chosen material. By changing the dies (fig 1) different size eyelets can be fitted.

This machine has been supplied with combination type dies that both cut

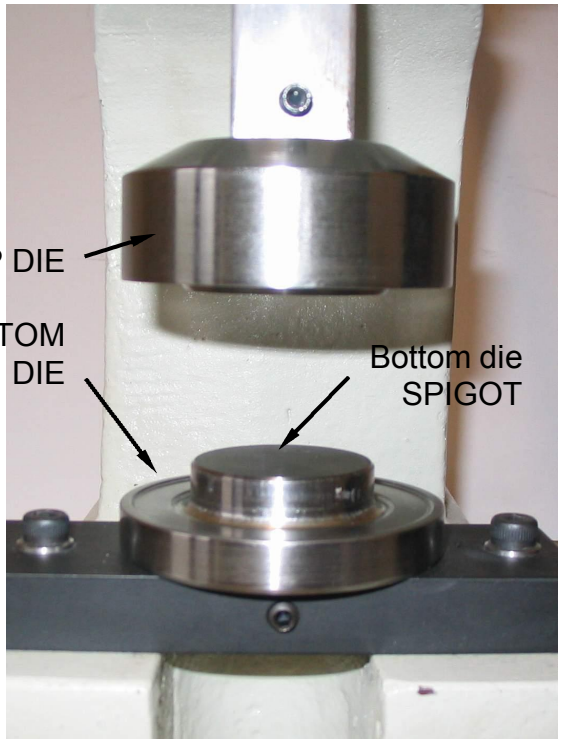


Figure 1

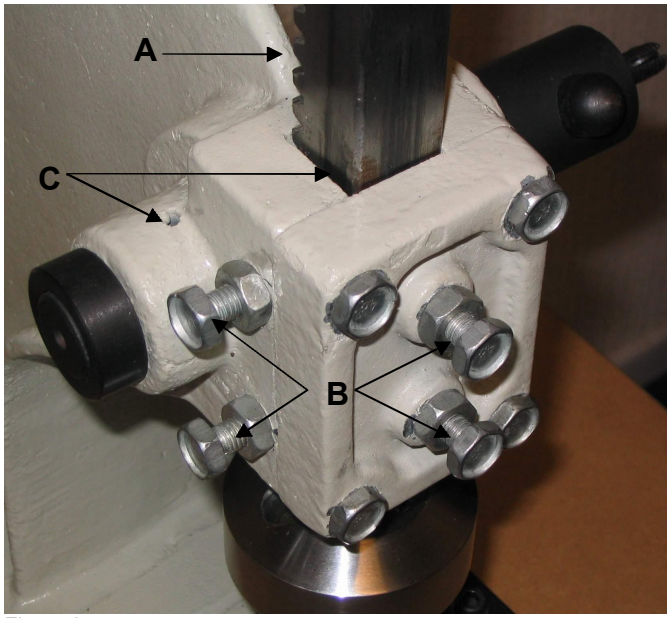


Figure 2

To ensure accuracy and the long life of the dies the main column (A) must not be allowed to become slack; before use, always check there is no sideways movement (front to back or left to right) in the column; if there is tighten the 4 adjusting screws (B) on the front and side.

Oil points marked with a C regularly, but do not over oil as this may cause drips onto your fabric.

IMPORTANT SAFETY INFORMATION

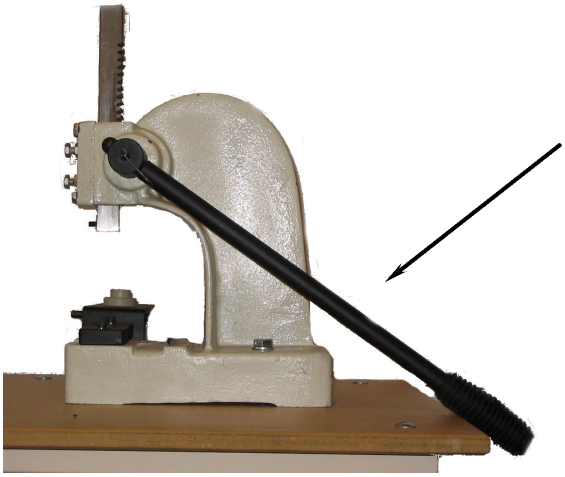


figure 3

THE SAFE POSITION
Ensure the operating arm is fully rotated to the rear of the press (known as the Safe Position see fig 3) to prevent it falling forward before changing or adjusting toolage or placing material and eyelets for setting.

- Be aware that there are sharp cutting edges on the dies
- Keep hands away from dies when applying pressure.
- We advise that when using any machinery suitable gloves and eye protection should be worn.
- Always follow maintenance routines explained in the maintenance section.

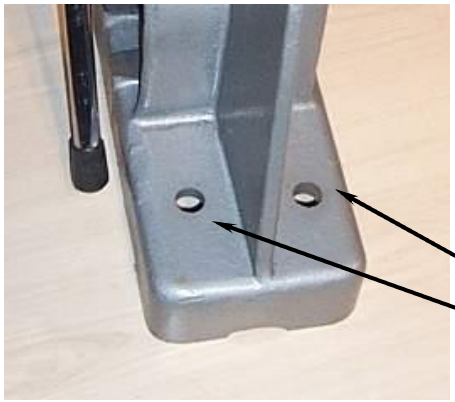


Figure 4

For machines supplied without standard base

Before use, this equipment must be securely bolted to a suitable bench using the fixing holes at the rear of its base

If you are unsure about using any aspect of this equipment, please consult your supplier.

SETTING UP AND USING THE DIES

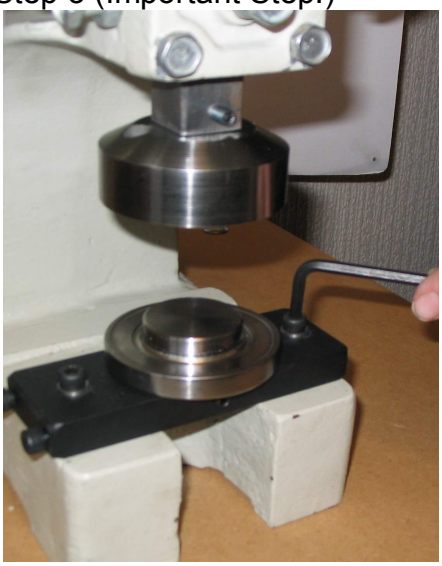
Step1

Fit the bottom die in to the base of the machine and tighten the retaining screw (the flat edge on the die should be towards the screw). Ensure the die is sat flat on the base.

Step 2

Fit the top die in to the column & tighten the retaining screw (again the flat edge on the die should be towards the screw). Ensure the die is flat against the underside of the column.

Step 3 (Important Step!)



IMPORTANT
The dies must now be centralised. To do this, loosen the two base plate screws. So the plate can move.

Step 4 (Important Step!)

Gently lower the top die on to the bottom die spigot so that the two parts fit together….

Step 5

…..then retighten the base plate screws
If this centralisation step is not carried out correctly it will lead to a damaged cutter!

Step 6

Finally lift the top die clear and then re-lower to make sure the dies are correctly aligned; they should close and open smoothly without bumping or deflecting off one another.

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

USING THE TOOLS TO CUT AND SET

Step 1

Place a ring with its spikes facing upwards on the bottom die (it should locate in the recess)…..

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 then lift the top die clear…..

Step 3

……take an eyelet and sit it over the bottom die spigot that is now visible through the material….

Step 4

Lower the top 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…..

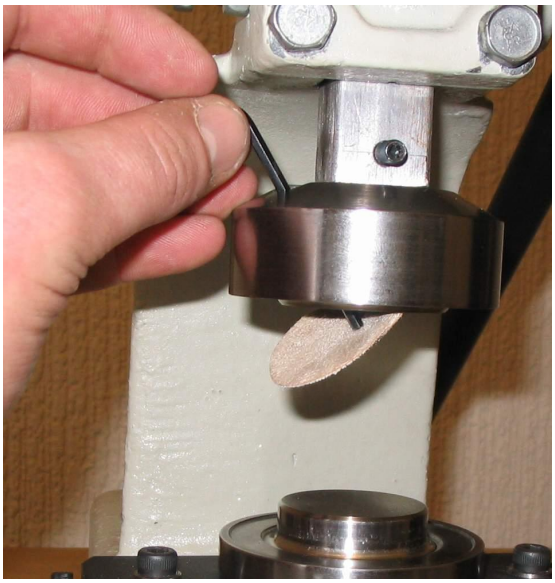
Step 5

…..Lift the closing punch clear of the base die to reveal the fitted eyelet

Step 6

Inspect the eyelet to ensure it has correctly rolled and firmly gripped the material.

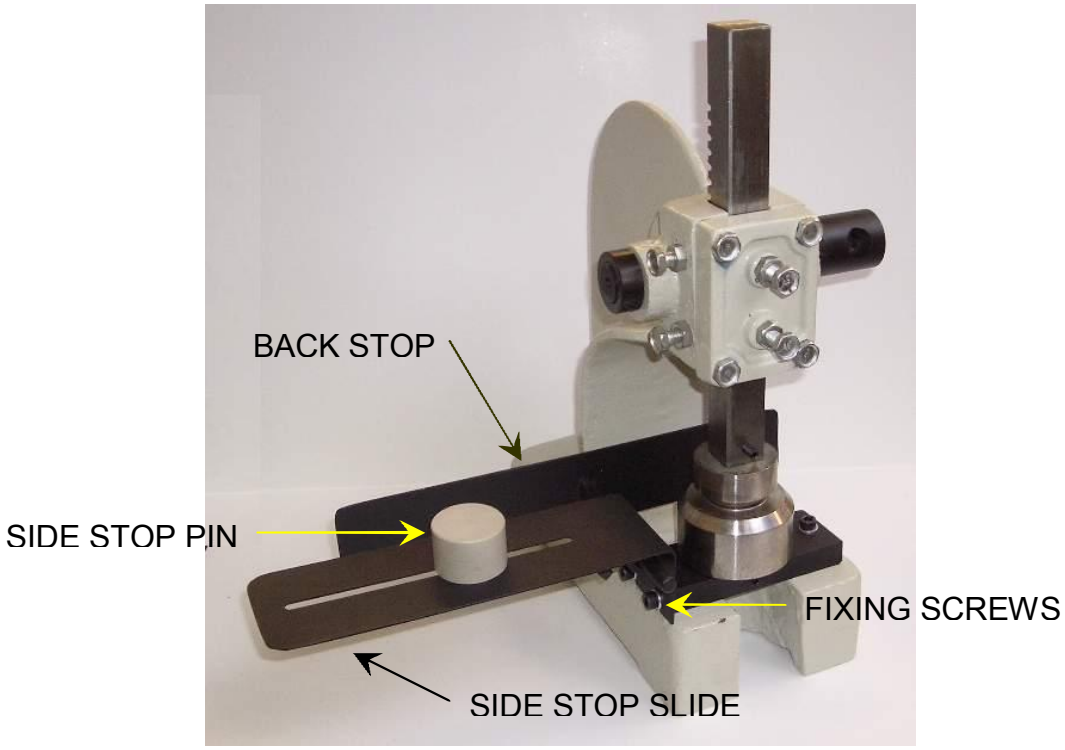
SUPPLEMENTARY INFORMATION



As you cut the holes, the 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.

SETTING UP AND USING THE MATERIAL LOCATION STOPS.

(Cost option available for models sold after Oct 2004)



This machine can be supplied with the optional material location stops that assist the operator in correctly positioning the holes in the material.

The stop assembly is attached to the machine with two fixing screws on the base plate.

To adjust either stop use the 5mm hexagon key supplied with the machine.

The **back stop** is used to set the distance of the hole from the edge of the material.

The **side stop** controls the distance between each of the eyelet holes. This is achieved by setting the **side stop pin** to the desired distance then placing the previously cut hole over this pin while the next hole is cut.

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

MAINTENANCE

1. Regularly oil moving part lightly (be careful not allow oil to come into contact with areas that may touch curtain fabric)

2. To ensure correct and safe operation there must be no sideways movement in the vertical square rod that holds the top dies. With use over time the adjusting screws on the front and side of the machine may need to be tightened to remove any looseness in the rod and also to prevent the handle from falling