



Model PG-20
Manual Grommet Machine
Operating Manual



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INTRODUCTION

MANUAL MACHINE MODEL PG-20 FOR PLACING APPLICATIONS BY HAND

The function of this machine is the placement of applications or to punch holes (interior diameter of tube grommet 8mm or 12mm) in materials that need these applications.

Specially recommended for placing grommets and washers in: awnings, curtains, advertising signs, etc.

THIS MACHINE WILL PUNCH THE MATERIAL WHILE SIMULTANEOUSLY SETTING THE GROMMET.

WARNINGS!

We hope you will take notice of these warnings and we would like to thank you for the purchase of this machine.

User unawareness of the machine leads on many occasions to elementary doubts about its operation.

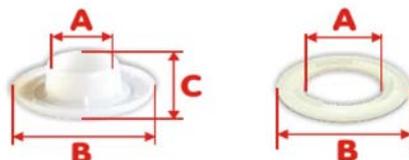
Please read this instruction manual carefully for your guidance, in order to make the most of your machine.

Always use extreme caution when operating machine. Keep hands free of cutting surfaces.

SINCLAIR EQUIPMENT DECLINES ALL RESPONSABILITY ON THE INCORRECT USE OF THIS INSTRUCTION MANUAL.



Grommet	Grommet Measurements	Washer Measurements
8mm Plastic Grommet	A: 8mm B: 15mm C: 8mm	No washer is used for 8mm grommet.
12mm Plastic Grommet	A: 12mm B: 26mm C: 8.3mm	A: 15mm B: 24mm



Installation of PG-20

Install grommet machine on secure table top with the front of machine base flush with table edge. Use four bolts with lock nuts/washers to secure machine.

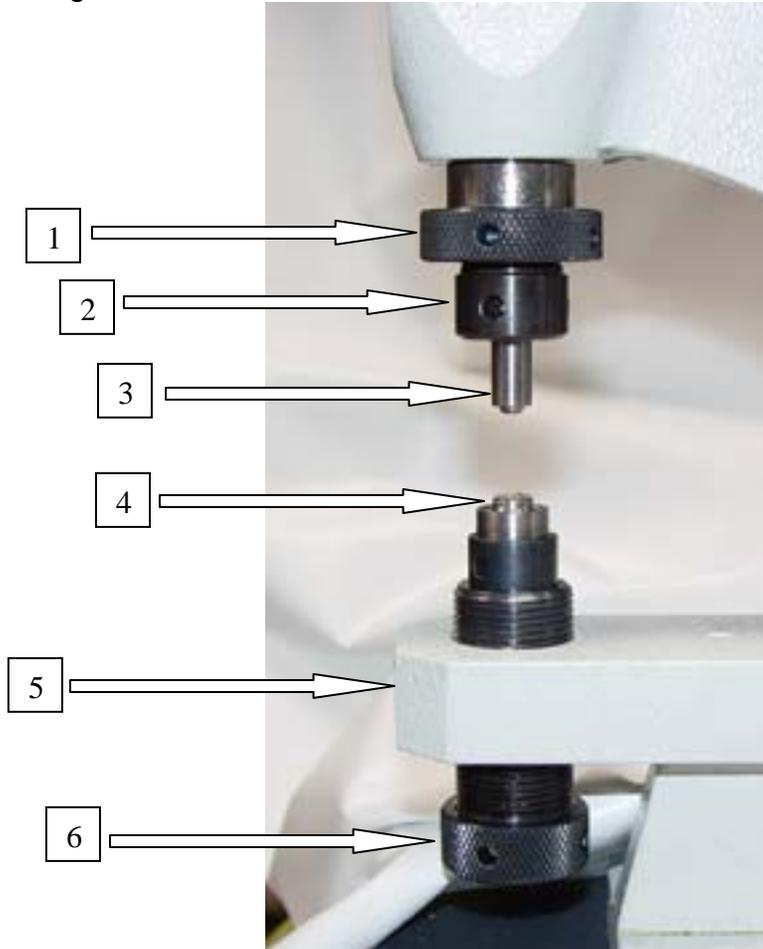
Adjusting both the cutting and the grommet pressure.

ALWAYS ADJUST FIRST THE CUTTING PRESSURE, NEVER TRY DO CUTTING AND SETTING AT THE SAME TIME.

Each time you change material or change grommet sizes, it will be necessary to adjust the pressure for the machine to work properly.

In order to adjust the cutting pressure: (Refer to diagram below)

- Loosen lock nut #1 with the supplied punch tool.
- Tighten die #2 close to top with the supplied punch tool.
- Loosen #5 set screw
- Loosen #6 away from upper die #3
- **AVOID DAMAGES ON THE DIES. IF THE DIES COME TOO CLOSE AND YOU TRY TO SET A GROMMET, YOU WILL BREAK THE EDGE OF THE LOWER ONE.**
- While frequently pulling lever, adjust #6 up gradually $\frac{1}{4}$ turns until two die pieces #3 & #4 come together just enough to cut material in use.
- Test cut material to make sure cutting is properly adjusted.
- Tighten set screw #5



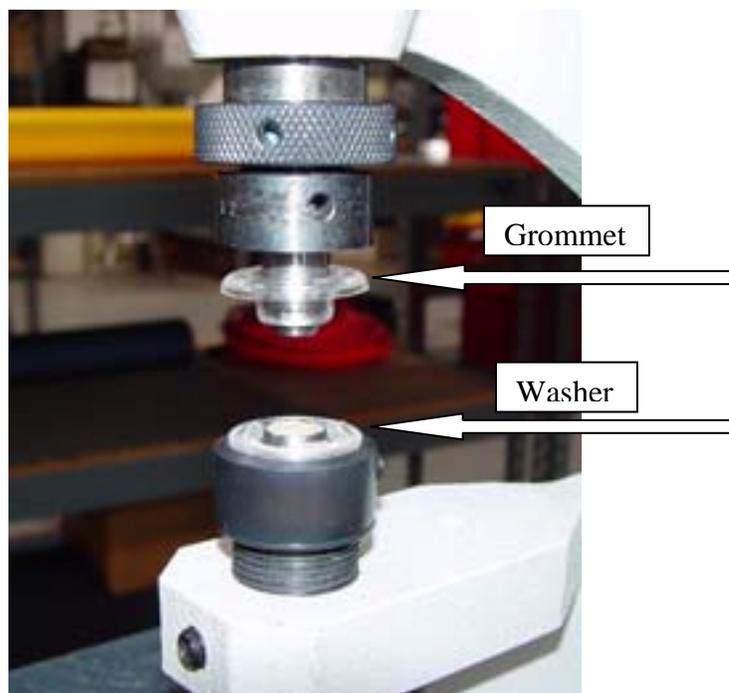
In order to adjust the grommet pressure.

- Insert grommet on die #3 as shown in figure 1 below. Make sure bottom of grommet is up above bottom of top die. No washer is needed for 8mm grommets. For 12mm grommets, insert washer on die #4 as shown in figure 2.
- Do a test grommet with the material you are using,
- Slowly loosen #2 die to tighten grommet fit. Use $\frac{1}{4}$ turns or less at a time.
- Try to spin grommet in material. If grommet is loose, continue to bring die #2 down until grommet is secure in material and won't spin.
- When grommet tension is correct, tighten tension nut #1

FIG 1



FIG 2



Change Of Dies

The PG-20 will take two die sets. If you want to change out sizes, you will need to replace parts. Please refer to the following diagrams.

8mm Die Set



12mm Die Set



Only used in 12mm die set.



<u>Schematic #</u>	<u>Part #</u>	<u>Description</u>
30	PGR2030	Machine Head
31	PGR2031	Die Holder Pin
32	PGR2032	Driving Stem
33	PGR2033	Driving Stem Guide Wheel Pin
34	PGR2034	Driving Stem Guide Wheel
36	PGR2036	Eccentric Part
37	PGR2037	Connecting Rod
38	PGR2038	Connecting Rod Pin
39	PGR2039	Adjusting Nut For Top Die
40	PGR2040	Screw For Fixing Lever
41	PGR2041	Lever Pin
42	PGR2042	Draw Back Spring
43	PGR2043	Driving Stem Control Part
44	PGR2044	Driving Stem Control Pin
45	PGR2045	Pin For Top Set Spindle
46	PGR2046	Lever
48	PGR2048	Die Holder For Machine
49	PGR2049	Top Die
50	PGR2050	Bottom Die
51	PGR2051	Top Set Spindle
52	PGR2052	Top Set Spindle Spring
58	PGR2058	Screw For Fixing Die Holder

NOTES