


## Operating Instruction Eyeleter



<b>Model</b>	102 - 00
<b>Part no.</b>	701 - 0060
<b>Eyelet</b>	24 / 25
	For future use, take note and keep on hand with the Eyeleter.

**Contents**

1	Introduction .....	1
2	Before you use the device .....	1
3	Notes and explanation of terms .....	1
4	Intended use .....	1
5	Warranty .....	1
6	Scope of delivery .....	1
7	Commissioning .....	2
8	How to operate .....	2
9	Setting the side stop .....	3
10	Setting the rear stop .....	3
11	Refilling with eyelets .....	3
12	Pressure setting (eyelet pressure) .....	4
13	Replacing the lower stamp .....	4
14	Replacing the upper stamp.....	5
15	Malfunctions in the eyelet feed .....	5
16	Replacing the bristle disk.....	6
17	Maintenance and servicing.....	7
18	Cleaning.....	7
19	Lubrication .....	8
20	Recommended lubricants.....	8
21	Servicing .....	8

© 2018 Constantin Hang, Maschinen - Produktion GmbH

Jahnstraße 82, D-73037 Göppingen

All rights reserved

Reproduction, in whole or in part, is permissible only with the prior consent of the manufacturer.

## 1 Introduction

By purchasing this Eyeleter, you have chosen a robust, reliable, proven model from Hang. We constantly strive to improve Hang products. This also includes the operating manual. Please notify us of any deficiencies, errors or ambiguities you notice in our products. Send us your comments, criticisms and opinions by mail or fax. You will find a form in the appendix.

## 2 Before you use the device

Read this operating manual carefully and follow the instructions. The Eyeleter will thank you by providing a long, trouble-free service life.

## 3 Notes and explanation of terms:



*Indicates a potentially hazardous situation that may lead to minor physical injuries. This signal word may also be used for warnings related to property damage.*



*Indicates a potentially damaging situation in which the product or an object near it may be damaged.*



*Indicates usage notes and other useful information.*

## 4 Intended use

The Eyeleter is for inserting eyelets.



*Any other application is considered unintended use. The manufacturer assumes no liability for unintended use that causes property damage or injury. In such cases the user bears the risk.*

## 5 Warranty

12 months from the date of delivery.



*The General Business Conditions of Constantin Hang Maschinen-Produktion GmbH as published at [www.hang.de](http://www.hang.de) apply, and are accepted upon conclusion of the contract.*

## 6 Scope of delivery

1	Eyeleter	2	Tool
---	----------	---	------

## 7 Commissioning

The Eyeleter is delivered in stable packing.



*Keep the packing for possible return dispatch for reconditioning purposes.*



- Put the Eyeleter in a stationary position on a stable surface according to the purpose of use. Work surface, desk, etc.

## 8 How to operate



**Vorsicht**

*Do not operate the hand lever without first inserting a stack of paper. The stamp can be damaged by multiple eyelets!*



- Insert the material to be eyeleted against the end stops [1] through the lower stamp. Figure A.
- Pull the hand lever [2] quickly forward. The eyelets are inserted.
- Let go of the hand lever [2]. Spring force will pull it back to its original position.
- The eyeletting process is complete.

*Depending on the eyelet size, use more or less force.*

The favourable gear ratio allows even heavy eyelets to be inserted easily.

Figure A

## 9 Setting the side stop

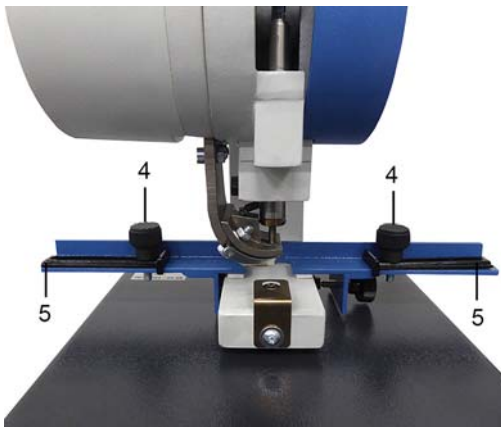


Figure B

- Loosen the knurled screw [4] and set the distance by sliding the side stop [5].
  - Then tighten the knurled screw [4].
- Figure B.

## 10 Setting the rear stop

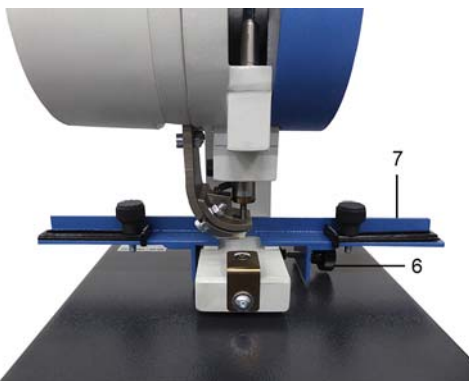


Figure C

- Loosen the screw [6] and set the distance by sliding the rear stop [7].
  - Then tighten the screw [6].
- Figure C.

## 11 Refilling with eyelets



Figure D

- Fill the eyelet holder [8] about 2/3 with eyelets by loosening the knurled screw [10] and turning the cover [9] to the side.
- Figure D.



**The Eyeleter is set up for a single eyelet size.**

Always refill it only with the prescribed eyelets.

The wrong eyelets can cause malfunction or damage the device.

## 12 Pressure setting (eyelet pressure)

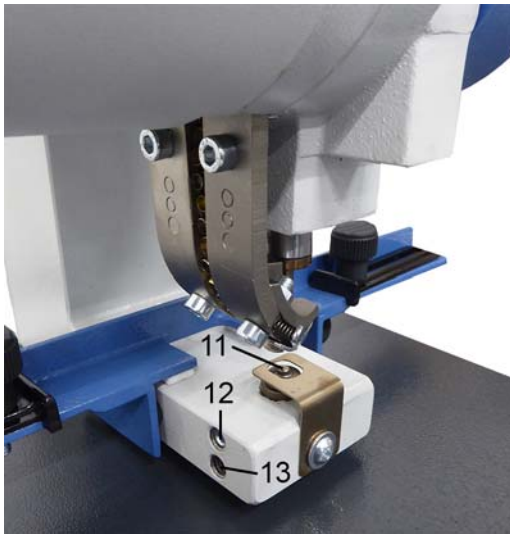


Figure E

If you wish the eyelets to be pressed harder or if the eyelets are being pressed too hard, you must regulate the pressure by moving the lower stamp [11].

Figure E.

- Release the threaded pin [12].
- Use the threaded pin [13] to move the lower stamp [11].
- Use the threaded pin [12] to clamp the lower stamp [11] tight again.



To increase the pressure: ⇒ Turn the threaded pin clockwise.

To decrease the pressure: ⇒ Turn the threaded pin anticlockwise.

## 13 Replacing the lower stamp



Press the eyelet channel to the side to allow easier handling.

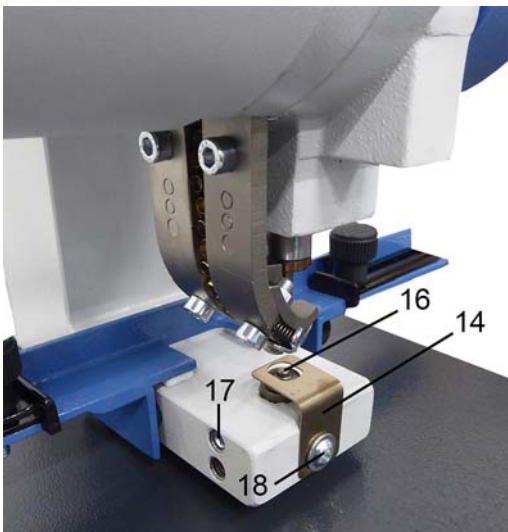


Figure F

- Loosen the clamping screw [15] on the stripping spring [14] and swivel it aside. Figure F.
- Release the clamping screw [17] on the lower stamp [16].
- Pull out the lower stamp [16] upwards.
- Install the new lower stamp in the opposite sequence.

## 14 Replacing the upper stamp



Press the eyelet channel to the side to allow easier handling.

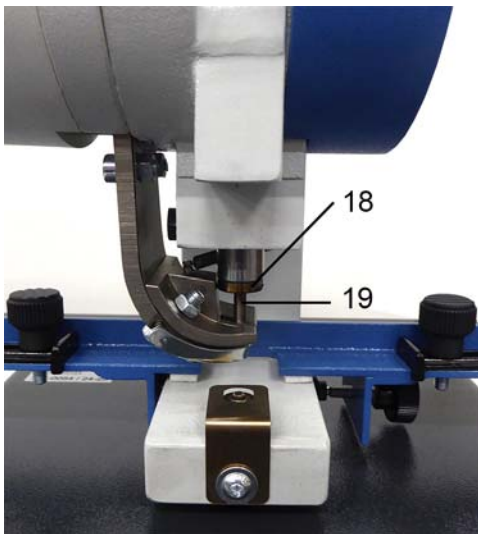


Figure G

- Screw out the upper stamp [18] using the (size 12) open-ended spanner provided.  
If the catch pin [19] also has to be replaced, use pliers to pull it down and out. Figure G.
- Insert the new catch pin through the new upper stamp and turn both of them together into the tappet.
- Do an eyeleting test and, if necessary, readjust the pressure. (See “Adjusting the pressure”).

## 15 Malfunctions in the eyelet feed



***The eyelet feed is set up for a single eyelet size. If eyelets of a different size, defective eyelets, dirt or other foreign objects get into the eyelet container or the feed, malfunctions will occur.***

- Remove the tension spring that holds the eyelet channel to the body.
- Remove the eyelet container (see “Replacing the bristle disk”). (Figures H–K)



***First empty the eyelet container, or the eyelets will scatter everywhere.***

- Repair the cause of the malfunction.
- Reinstall the eyelet container.



## 16 Replacing the bristle disk



*Caution: The worm spring is pre-tensioned!*

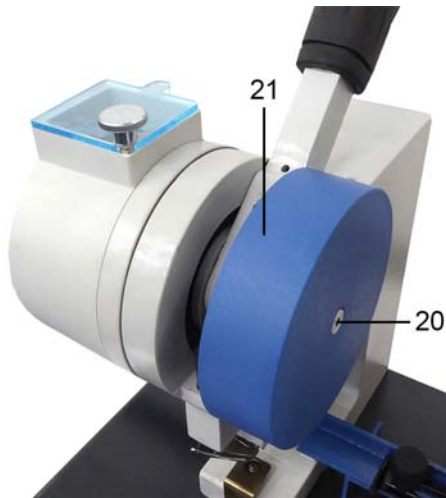


Figure H

- There will also be malfunctions if the bristles on the bristle disk are worn.
- Loosen and remove the screw [20].
  - Remove the cover [21].
- Figure H.



Figure I

- Loosen and remove the screws [22].
- Figures I and J.

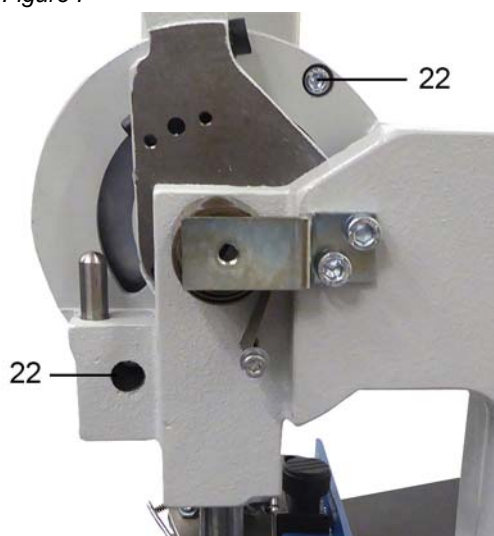


Figure J



- Remove the eyelet container [23] by pulling it off to the left.  
Figure K.



Figure K

- Loosen the screw [24].
- Pull off the bristle disk [25].  
Figure L.
- Install in the opposite sequence.



Figure L

## 17 Maintenance and servicing

Cleaning and lubrication are the only maintenance the eyeleting machine requires.

## 18 Cleaning

Clean the Eyeleter at regular intervals. Make sure that no dirt deposits in the slide grooves of the eyelet feed.

## 19 Lubrication

- If the Eyeleter machine is used daily, oil it once a week.
- Carefully use an oil can to put one drop of oil at each location [26].  
Figure M.
- Wipe up excess oil with a rag.



Figure M

## 20 Recommended lubricants:

	ARAL	BP	ESSO	SHELL	MOBIL	DEA
Machine oil	Dural MR 68	Energol EM 68	Coray 68	Carnea 68	Heavy Medium	Viscoma,68

## 21 Servicing

- Check the condition of the stamp and bristle disk at regular intervals (every three months).
- If parts are worn, order new ones from the replacement part list.

