

**BASIC OPERATION MANUAL
INSTRUCTION MANUAL
PARTS BOOK**

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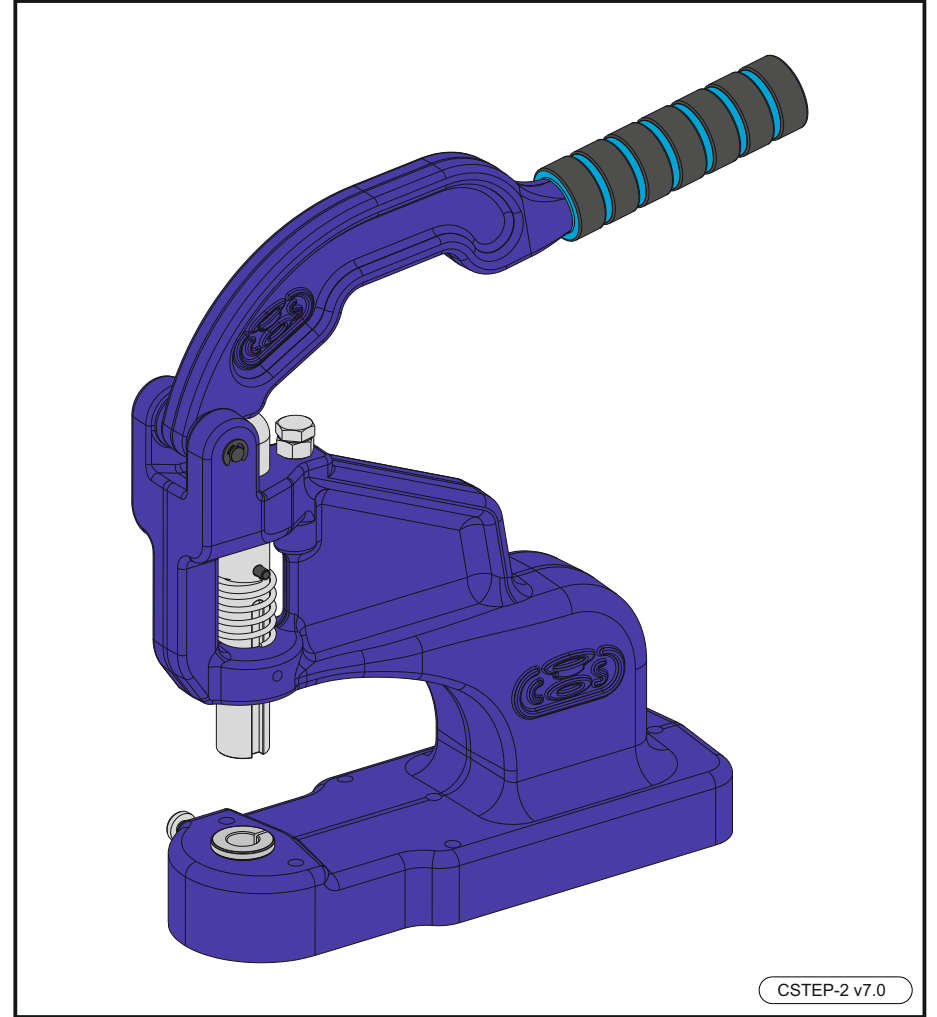
Hand Press
CSTEP-2v07

CSTEP-2 **Hand Press**

**BASIC OPERATION MANUAL
INSTRUCTION MANUAL
PARTS BOOK**

GROMMET ATTCHING HAND PRESS

Please read this manual before using the equipment.
Please keep this manual within easy reach for quick reference.



CSTEP-2 v7.0

Thank you very much for buying **CS-TIDY-FRL** filter-regulator-lubricator accessory for TIDY Machines .
ClipsShop **CS-TIDY-FRL** accessory is the filter –regulator-lubricator unit with specially designed stainless steel mounting adaptor to be installed to your CS-TIDY series pneumatic machines in a couple of minutes.

Before using your new **CS-TIDY-FRL** equipment, please read the safety instructions below and the explanations given in the instruction manual.

Follow the instructions from training person and instructors regarding safe and correct operation before using the **CS-TIDY-FRL** so that you will know how to use it correctly.

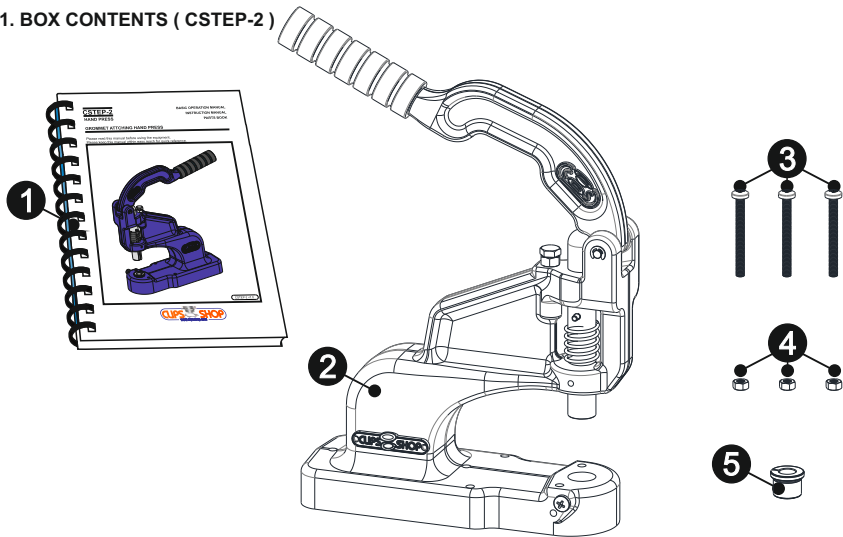
Notes for using this book

1. This book was prepared based on information available in November 2018.
2. Parts are subject to changes in design without prior notice.
3. Parts supplied as complete assemblies are circled by a dotted line.

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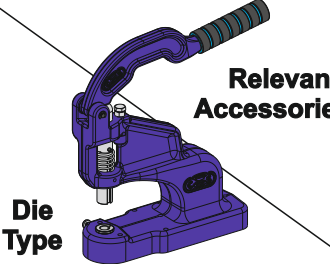
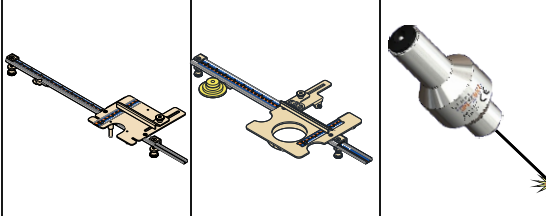





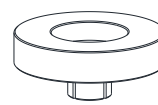
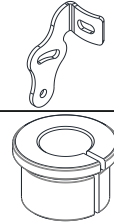


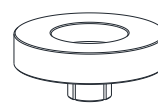

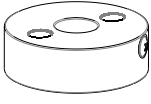



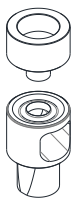



1. BOX CONTENTS (CSTEP-2)



REF NO	CODE	QTY	NAME OF PARTS	REF NO	CODE	QTY	NAME OF PARTS
1	138651	1	INSTRUCTION MANUAL				
2	CSTEP-2	1	HAND PRESS				
3	750660	3	SCREW, ISO 7045 - M6 x 60 - Z --- 60S				
4	216489	3	NUT, ISO 4032 - M6 - W - S				
5	110202	1	LOWER DIE BUSHING				

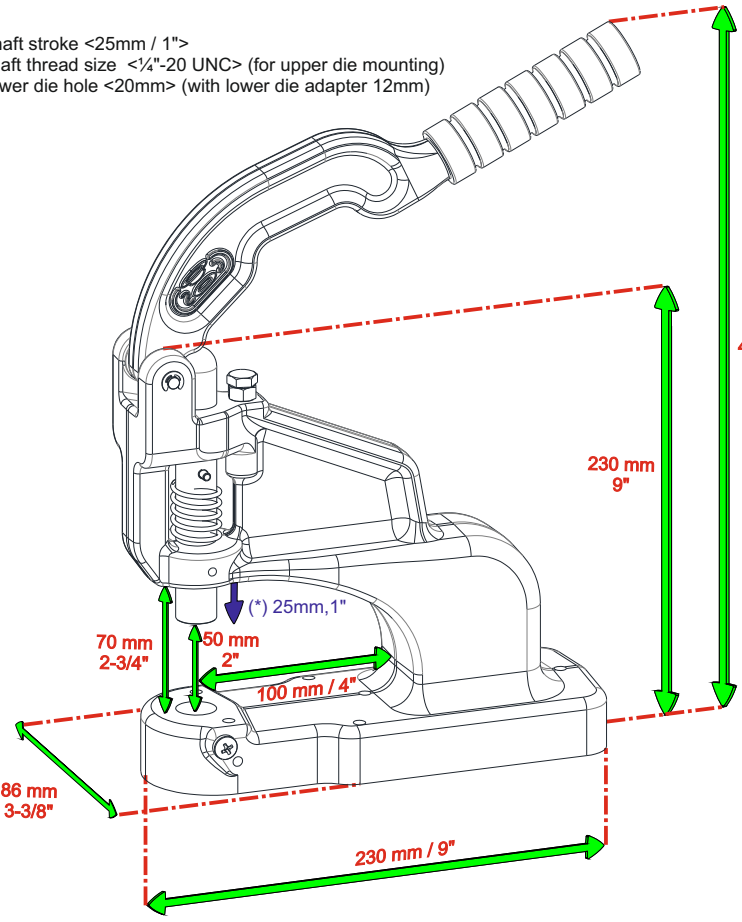
Problem	Possible Season	Solution	Ref.
My grommets do not crimp all the way.	It may be caused by the stop screw.	If you are setting the grommet on a very thin material the length of the grommet could be too long for the material. You can test for this by setting a grommet into a thicker test material, or into multiple layers of the thin material, or by trying to use 2 or 3 washers. If you can set the grommet without a problem using one of the test methods, you will need to compensate for thin material. Extra washers are sold separately when multiples are needed on thin material.	P.15
	It may be caused by the lower die.	Try cleaning the bottom die (anvil). Extensive use may have caused the finish from your grommets to build up in the groove on your bottom die. It is minor, but can make a big difference.	P. 9
	The pressure of the air may not be sufficient.	Ensure proper pressure is used. The CSTEP-2 is a hand press, and the amount of pressure applied to the grommet is directly proportional to the force you exert and you may have to press harder.	P.12
When I set my grommets, the finished product is not round or the grommet splits.	It may be caused by the stop screw.	When too much pressure is used to crimp the grommet, it can deform or break the grommet or washer. Try using less pressure. Your material may also be too thick, which requires extra pressure to pierce the material and crimp the grommet. The stop screw may also be an option to correct this issue.	P.15
	The lower die may be loose or the lower die does not stand flat in the bushing.	If you are setting the grommet on a very thin material the length of the grommet could be too long for the material. You can test for this by setting a grommet into a thicker test material, or into multiple layers of the thin material, or by trying to use 2 or 3 washers. If you can set the grommet without a problem using one of the test methods, you will need to compensate for thin material. Extra washers are sold separately when multiples are needed on thin material.	P. 9
	The upper die may be loose.	Verify that your top die is screwed all the way in to the press so the flat part of the die is flush on the shaft. If you press too hard with a partially installed die, it is possible to bend the threaded rod on the top die shaft and you may overcrimp the grommets. If the rod is bent the die needs to be repaired or replaced. Tip: use a little plumber's Teflon tape on the threads for a tight fit that will not easily come loose with repeated use.	P.10
	The material and the eyelet can be incompatible.	If you are setting the grommet on a very thin material the length of the grommet could be too long for the material. You can test for this by setting a grommet into a thicker test material, or into multiple layers of the thin material, or by trying to use 2 or 3 washers. If you can set the grommet without a problem using one of the test methods, you will need to compensate for thin material. Extra washers are sold separately when multiples are needed on thin material.	P.11
	Your material can be very thick.	Is your material too heavy for self piercing? Make a hole in a piece of the material and try setting a grommet through the existing hole. If you set a nice round grommet through the hole, but do not have the same success when trying to self-pierce, then the fibers of your particular material are too strong for the self-piercing. Pre-piercing your holes should correct the problem.	P.11
My grommet is falling off the top die, or my washer doesn't sit properly on the bottom die.	The die set and the eyelet can be incompatible.	Be sure you are using the correct size die for the grommets you are trying to set. If your grommet is too large, it will fall off of the smaller top die. If the washer is the wrong size it won't sit properly on the bottom die.	P.15
	It may be caused by the upper die.	Debris may have become clogged inside your top setting die from possibly trying to set a grommet upside down or extended use. A new die may be necessary if it is damaged internally or if the threads are stripped or bent.	P.11

8. ACCESSORIES COMPATIBILITY GUIDE (CSTEP-2)

 <p>Die Type</p>		 <p>Relevant Accessories</p>		
		 <p>CSGSP-1 Grommet Snlper</p>	 <p>CSGSP-2 Large Grommet Snlper</p>	 <p>CSEDP-2 Eyeled Pointer</p>
	CSDIE #XX00 CSDIE #X00 CSDIE #00 CSDIE #0 CSDIE #1 CSDIE #2 CSDIE #3 CSDIE #4 CSDIE #5 CSDIE #5.5			
<p>Standard ClipsShop Attacher Dies</p>		110202-000	CSGSP-2ADP2	378655-006 110202-000
	CSHPD #XX00 CSHPD #X00 CSHPD #00 CSHPD #0 CSHPD #1 CSHPD #2 CSHPD #3 CSHPD #4 CSHPD #5 CSHPD #5.5			
<p>Standard ClipsShop Piercer Dies</p>		110202-000	CSGSP-2ADP2	378655-006 110202-000
	CSDIE-7.5PA CSDIE-8.5PA CSDIE-12PA			
<p>Attacher & Piercer Dies</p>		Not Applicable	Applicable	Not Applicable
	CSDIE 3T2PSS			
<p>Plastic Grommet Dies</p>		Applicable	Not Applicable	378655-006

2. SPECIFICATIONS (CSTEP-2)

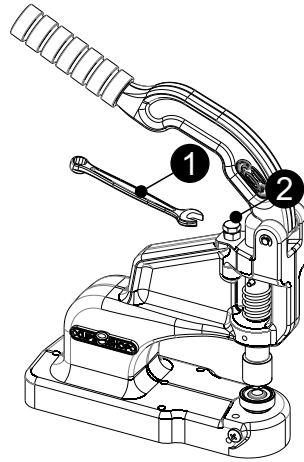
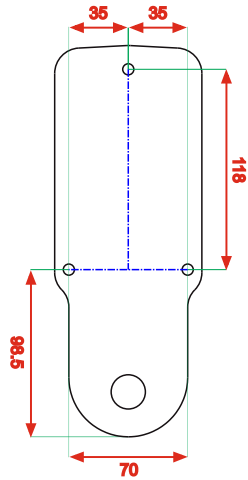
(*) Shaft stroke <25mm / 1">
 A: Shaft thread size <1/4"-20 UNC> (for upper die mounting)
 B: Lower die hole <20mm> (with lower die adapter 12mm)



400 mm / 15-3/4"
 230 mm / 9"
 230 mm / 9"
 86 mm / 3-3/8"
 70 mm / 2-3/4"
 50 mm / 2"
 100 mm / 4"
 (*) 25mm, 1"

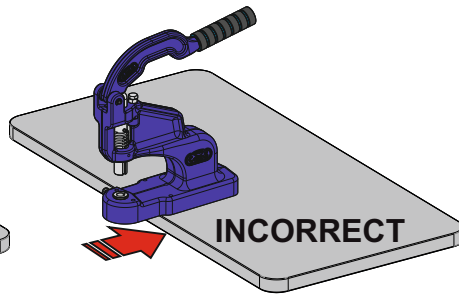
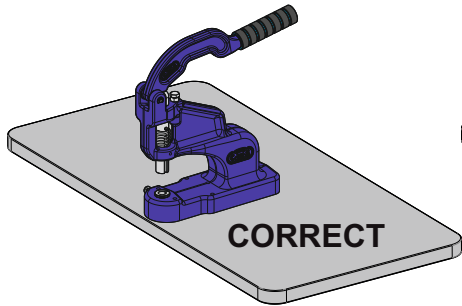
CSTEP-2v07	Grommet attaching hand press
APPLICATION AREAS	Attaching grommets on different substrates such as tarpaulins, banners etc.
FEEDING	Manual grommet & washer feed
STROKE	1" / 25mm
WORK HEIGHT (Max.)	2" / 50mm (From shaft end to lower die bushing plate top.)
THROAT DEPTH	4" / 100 mm (from eyelet center)
POWER TRANSMISSION RATIO	1*9.5 (.....)
MACHINE FORCE	6.5kN / 662 kgf / 1461 lbf (@ 70 kg - 154 lbf working pressure)
NET WEIGHTH	16 lbs - 7.25 kg
DIMENSIONS (W*D*H)	3 3/8"~ 9" / 86mm*230mm*230mm
OPTIONAL ACCESSORIES	EyeleD Pointer , GrommetSnlper, Large GrommetSnlper

8. OPTIONAL ACCESSORIES (CSEDP-02) Eyeled Pointer™



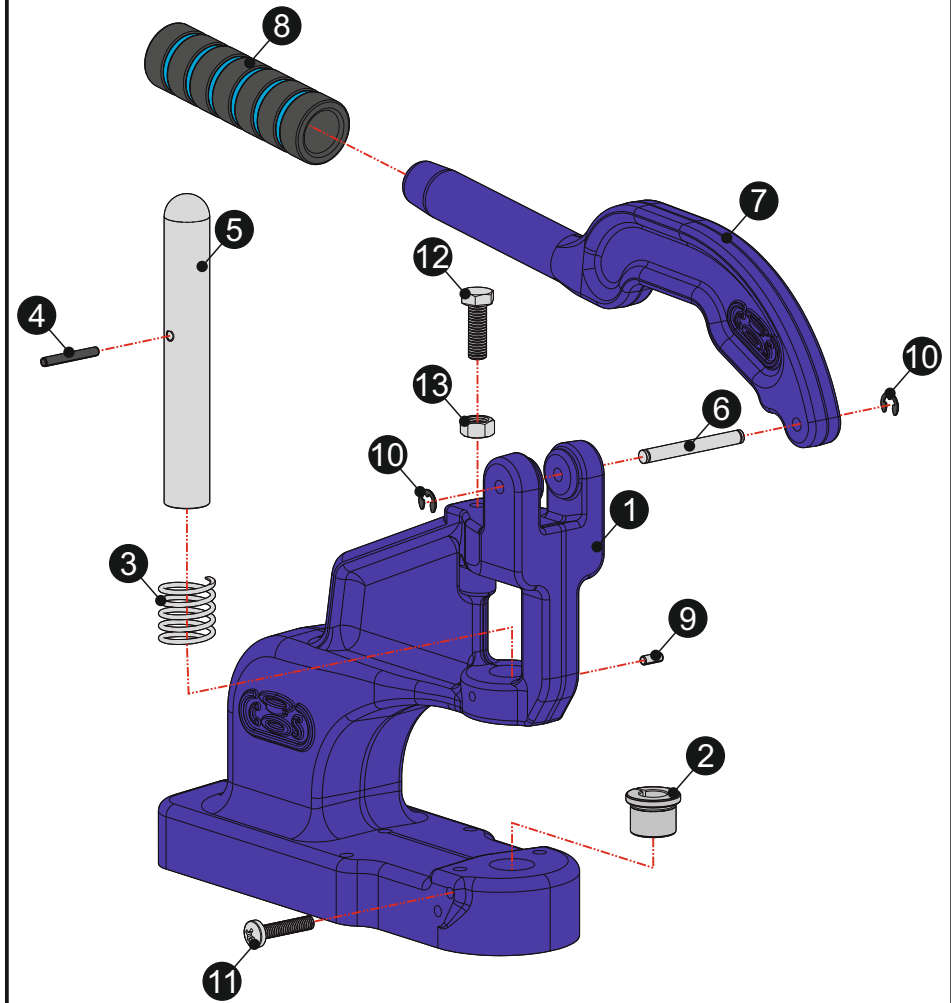
All dimensions of millimeter.

Slide a grommet onto the top die, flange side up, shaft down.



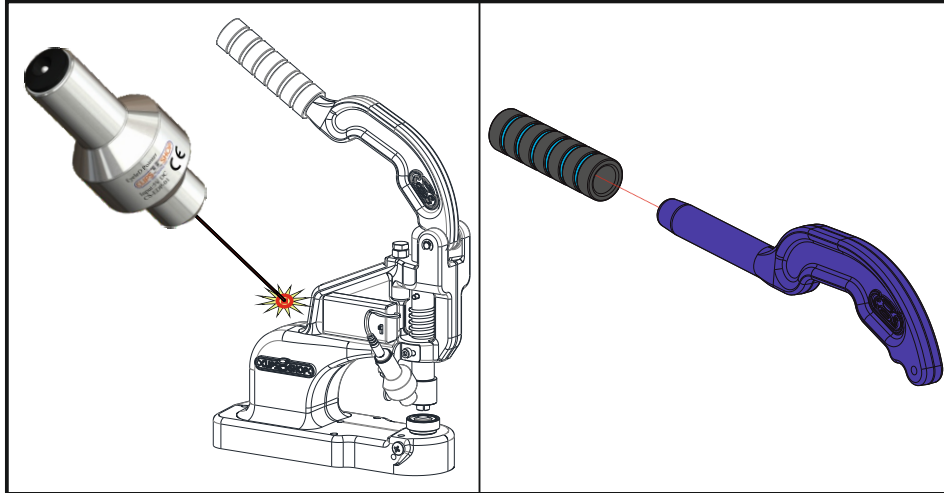
For your safety, we strongly recommend that the CSTEP-2 is fully secured over your work table or bench. Attaching the machine to a table or bench will help prevent accidental damage or injury.

3. SPARE PART LIST (CSTEP-2)



REF NO	CODE	QTY	NAME OF PARTS	REF NO	CODE	QTY	NAME OF PARTS
1	110201	1	BODY	8	110209	1	HANDLE GRIP
2	110202	1	LOVER DIE BUSHING	9	720410	1	SPRING PIN, ISO 13337 - 4 x 10 - St
3	110203	1	SPRING	10	154885	2	LOCK WASHER, DIN 6799-5
4	110204	1	SPRING PIN, ISO 13337 - 4 x 30 - St	11	750630	1	SCREW, ISO 7045 - M6 x 30 - Z --- 30S
5	110205	1	SHAFT	12	387825	1	BOLT, ISO 4017 - M8 x 25-S
6	110206	1	HANDLE PIN	13	403208	1	HEXAGON NUT, ISO 4032-M8-D-S
7	110207	1	HANDLE				

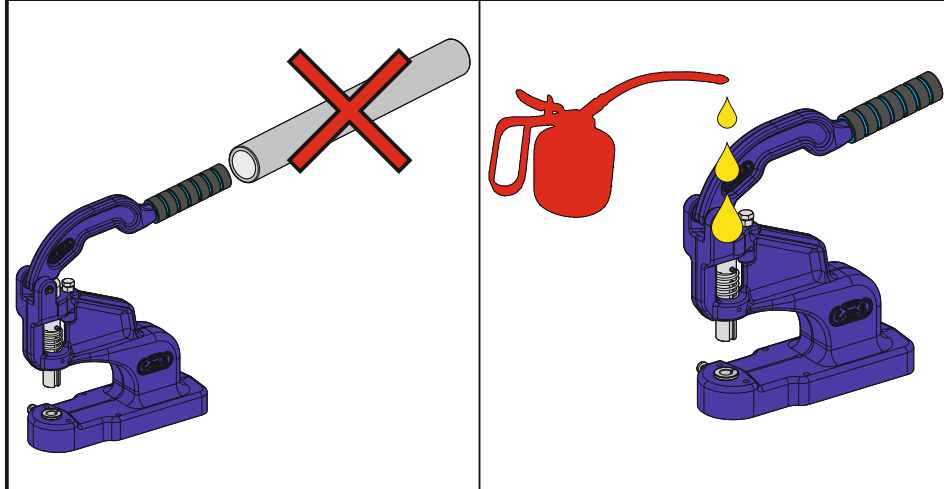
7. OPTIONAL ACCESSORIES (CSGSP-2)



Make sure there is no air in the system and the acrylic safety guard is the correct one to fit to large size die installation. Please refer to "Accessories Compatibility Guide" section for further information.

Attach the upper die ❶ to the upper die adaptor by manually rotating.

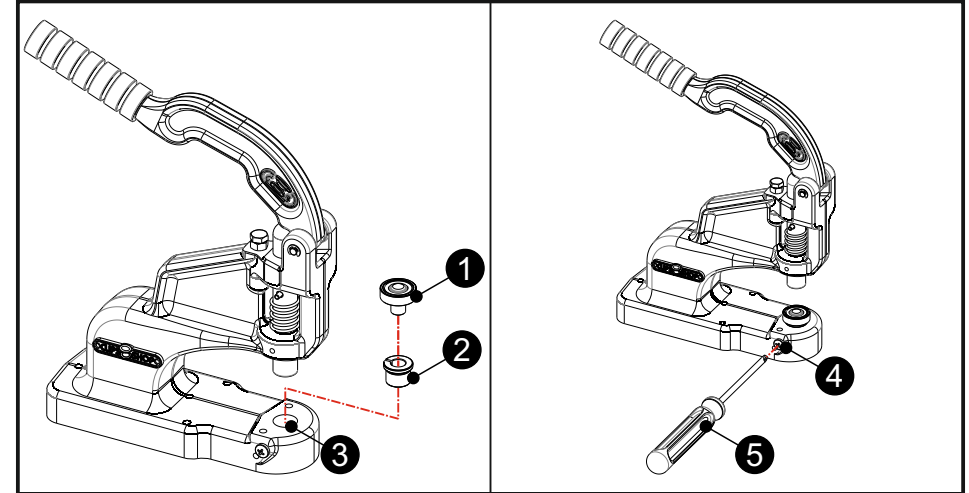
Heavy use could eventually wear out the grip of your handle. Contact your dealer to purchase spare grips. – Cut away the old grip and clean the handle before reapplying. Wet the new grip and slide it onto the handle (add a bit of liquid soap to the water for an easier slide)



Slide a grommet onto the top die, flange side up, shaft down.

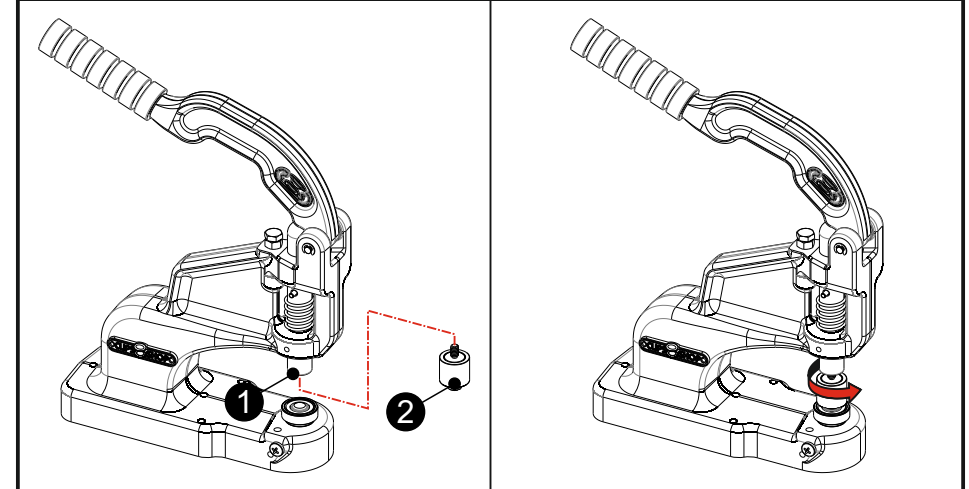
Lubricating the moving parts of your machine with MoS2 or machine oil will improve performance and lengthen the life of the CSTEP-2. Once a month (minimally) is recommended.

7. OPTIONAL ACCESSORIES (CSGSP-2)



In case there is lower die bushing installed in the lower die holder❸, first loosen the fixing screw❹ and remove the lower die bushing. Then, install the lower die❶ into the lower die holder❸.

Securely fix the set screw ❹ comes with your die set with the allen key ❺ to stabilize the position of the lower die.

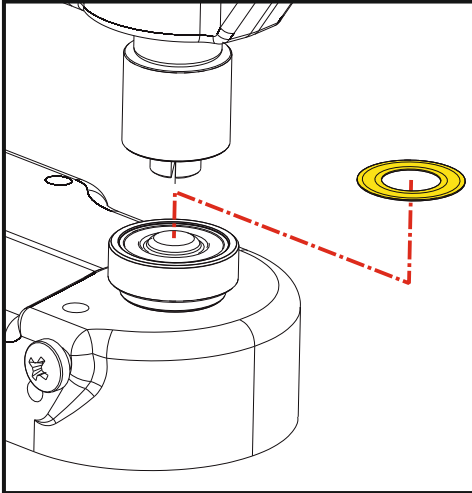


Once the acrylic safety guard blocks, pull the manual starting mechanism downwards to access the upper die ❶ to securely fix it.

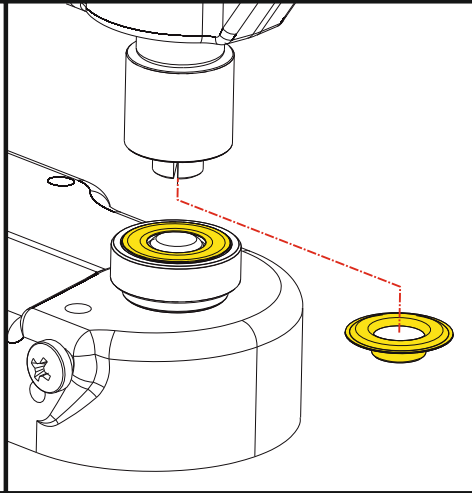
Make sure there is no air in the system and the acrylic safety guard is the correct one to fit to large size die installation. Please refer to "Accessories Compatibility Guide" section for further information.

Attach the upper die ❶ to the upper die adaptor by manually rotating.

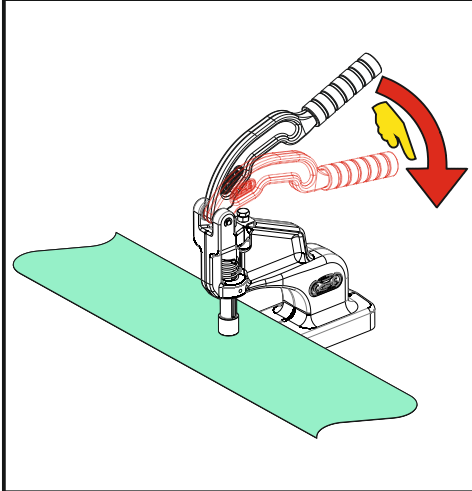
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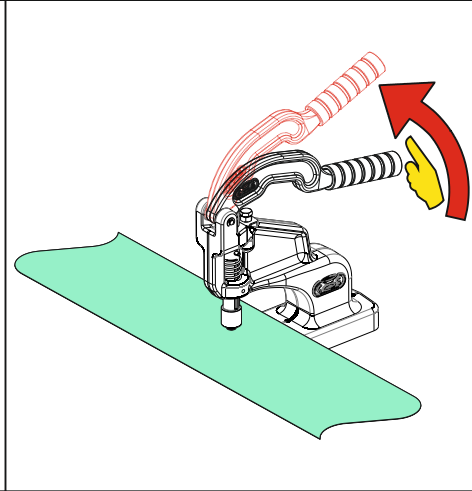
Place a washer groove side down into the bottom die.



Slide a grommet onto the top die, flange side up, shaft down.



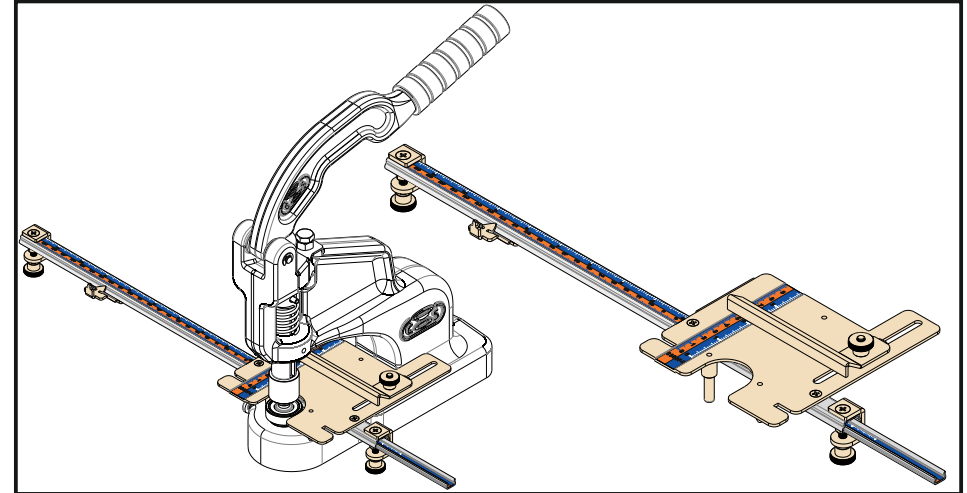
Once the acrylic safety guard blocks, pull the manual starting mechanism downwards to access the upper die ❶ to securely fix it.



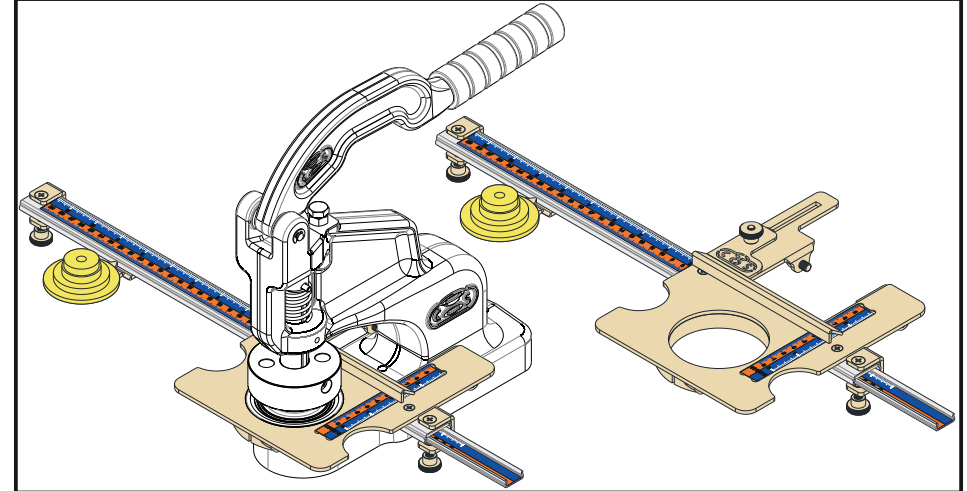
Make sure there is no air in the system and the acrylic safety guard is the correct one to fit to large size die installation. Please refer to "Accessories Compatibility Guide" section for further information.

Attach the upper die ❶ to the upper die adaptor by manually rotating.

7. OPTIONAL ACCESSORIES (CSGSP-2)



Place the pins ❶ of GrommetSniper™ ❶ on the holes ❶ of CSTEP-2 ❷ as shown in the figure. Gently tighten it manually. After making sure that there is no tightness or irregular connection, tighten the fixing screw ❸ with a Philips head screwdriver.



Install the EyeD Body ❸ to the mounting bracket ❶ in a way where the wing screw ❹ corresponds to the channel of the bracket and the other screw ❺ stays in the lower position. Install the already EyeD pointer body mounted mounting bracket to the threaded hole on the left side of your CSTEP-2 machine with the set screw ❷ by using the allen key ❸.