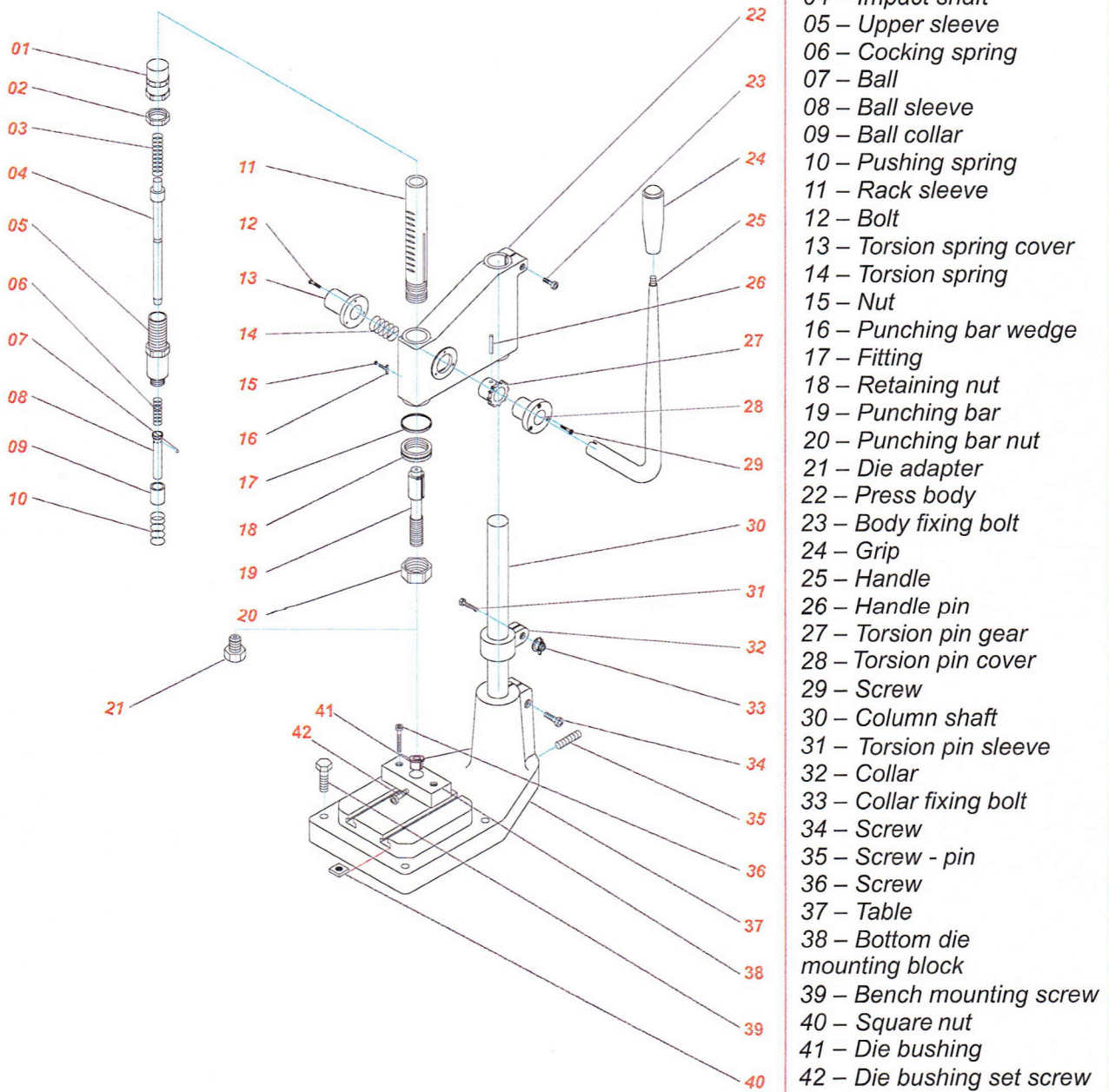


INSTRUCTION MANUAL

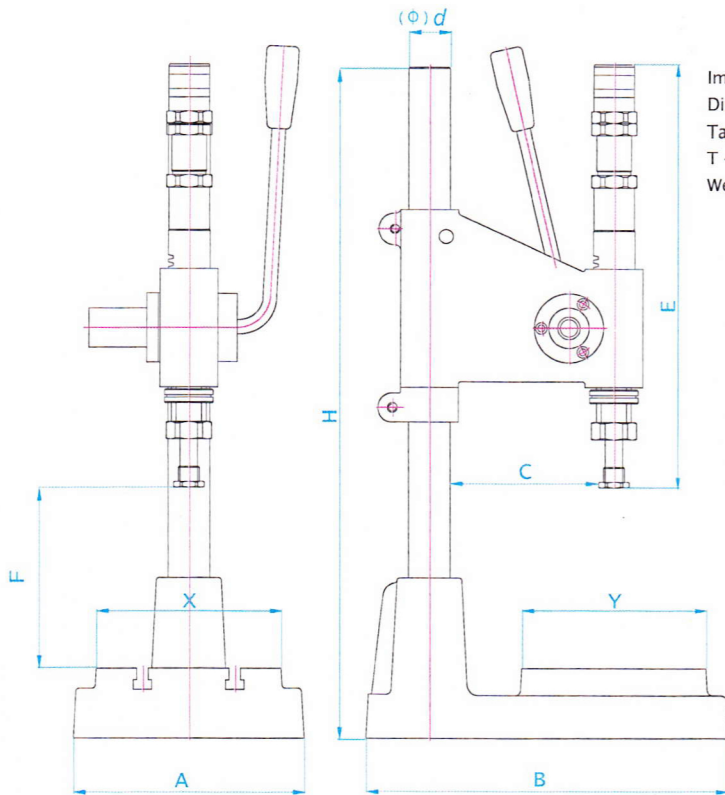
CSTON-1 STROKING HAND PRESS

SPARE PART LIST



INSTRUCTION MANUAL

CSTON-1 STROKING HAND PRESS



TECHNICAL SPECIFICATIONS :

Impact Force	: 18 kN(1800 kgf)(max)
Die Adapter Hole	: 1/4"-20
Table Fixing Size	: 165 x 165 mm / 6 1/2 x 6 1/2"
T - Slots	: 8 (12 H , DIN 650)
Weight	: 25 kg/ 55 lbs.

Symbols Length(mm)

H	520
A	200
B	315
C	140
X	160
Y	160
F (max.)	300
d (Φ)	36
E	365

Positioning the Press Body (how to move the body part (22) upward)

The vertical position of the body part (22) of CSTON-1 is adjustable.

In order to move the body up:

- 1) First, loosen the body fixing bolt (23) with the allen wrench.
- 2) Adjust the vertical position of the body(22). When needed, rotate the body(22) around column shaft(30) to get the requested positioning.
- 3) Release collar (32) by loosening collar fixing bolt (33). Adjust the height of collar(32) in accordance with the new vertical position of the body(22) and fix collar(32) by tightening collar fixing bolt(33).
- 4) Precisely align the top and bottom die. It's critical that the alignment of the top die and the bottom die is perfect or the grommets will not set with a round hole. You can put a grommet in the die and lower it part way with the handle ensuring not to make the spring pop. In this position you can ensure the exact alignment of the top and bottom die.

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CSTON-1 STROKING HAND PRESS

Positioning the Press Body(how to move the body part (22) downward)

In order to move the body down:

- 1) Release collar (32) by loosening collar fixing bolt (33).
- 2) Then place the collar(32) in the desired height and tighten the collar fixing bolt(33).
- 3) Loosen the body fixing bolt(23). Move the body(22) down till it connects to the collar(32). When needed, rotate the body(22) around column shaft(30) to get exact positioning.
- 4) Precisely align the top and bottom die as described in the previous section.
- 5) In order to fix the position of the body(22), tighten body fixing bolt(23).

Attach the Die

- 1) Insert the bottom die into the die bushing (41) located in the bottom die mounting block (38).
- 2) Tighten die bushing set screw (42) in front of bottom mounting die block (38) making sure the split in the die bushing (41) is facing to the right.
- 3) Attach the upper die to the bottom of the shaft by screwing the die counter-clockwise. Be careful not to damage the threads on the die during this process.

Note: 1) Be sure that the die adapter(21) is securely fixed to the shaft and the upper die is securely fixed to the die adapter(21) at all times. During a production run check that the upper die has not loosened from the die adapter. Using the machine with a loose upper die can damage the threads of the die and the die adapter.

2) Before attaching the upper die, you may use an allen wrench to ensure the small set screw on the die is tightly secured.

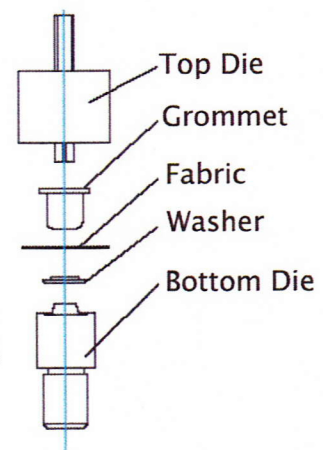
3) When removing the upper die be careful not to remove or loosen the die adapter (21).

4) Do not disassemble the die. The small black Allen screw should not be loosened or the die will come apart. If pieces are lost or not put together in the correct order then the die will not work. If you notice that the Allen screw is loose then it should be tightened.

How to Apply Grommet & Washer

- 1) Push the grommet on the upper die and place washer on the lower die.
- 2) Place the substrate/banner between the dies and apply the grommet and washer by pulling the handle(25) towards you.
- 3) The spring will pop as the machine applies the grommet. Give the handle(25) an extra push to ensure complete application.

Note: For many applications the self piercing dies and grommets will work fine without a need of pre-piercing a hole. However, when the fabric is too thick or too strong there maybe a need for pre-piercing before the grommet application. For such cases, contact your supplier to purchase the appropriate piercing dies.



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CSTON-1 STROKING HAND PRESS

Impact Force Adjustment

To change the impact force of the spring which assists in the grommet application follow the following steps.

1. Loosen spring press sleeve lock-nut (02).
2. Tighten spring press sleeve (01) clockwise to increase impact force or loosen it counter-clockwise to decrease impact force.
3. When you get the appropriate impact force for your specific application, tighten spring press sleeve lock-nut tightly to the bottom of the spring press sleeve to lock in a consistent impact pressure.

Note: Be sure to adjust the impact force properly for your specific operation and avoid using the machine at its maximum force at all times. That would increase the operational life time of your CSTON-1.

Maintenance

For increasing the operational life time and to ease the usage, the moving parts of CSTON-1 must be lubricated frequently. The user should lubricate the area where rack sleeve (11) meets press body (22) and then move the handle up and down for a few times. That would help on lubrication of the moving parts.

Caution

- 1) Be sure that the grip (24) is strictly tightened to the handle (25) all times.
- 2) Since the stroking power of the machine is obtained by the springs; the handle(25) will move up after attaching the grommet. The operator should not release his/her hand from the grip(24) till the handle(25) returns to its initial position.
- 3) Do not disassemble the top part of the self piercing die. Ensure that the small black allen set screw is tightly secured.

