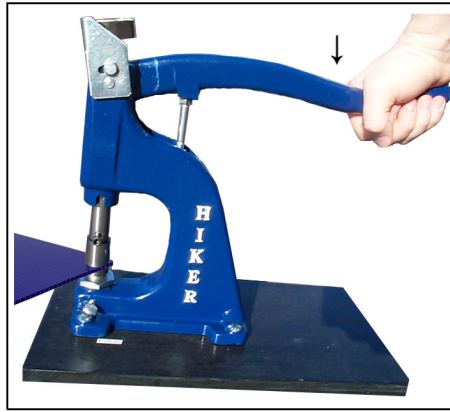
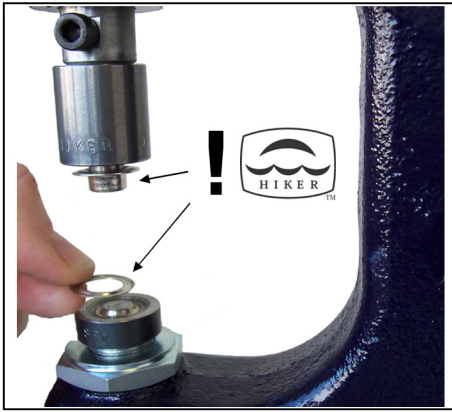


OPERATION



STEP-BY-STEP ADJUSTMENTS AND TIPS

RAISING OR LOWERING THE BOTTOM DIE TO ADJUST FOR VARIOUS MATERIAL THICKNESSES:

1) **CLOSE THE DIE BY LOWERING THE HANDLE.** THE DISTANCE BETWEEN THE DIE WHEN CLOSED SHOULD BE SLIGHTLY LARGER THAN THE THICKNESS OF THE MATERIAL YOU WILL BE INSERTING THE GROMMET INTO.

2) **IF THE GAP BETWEEN THE DIE NEEDS TO BE MORE OR LESS, LOOSEN THE WINGED SCREW THAT IS ON THE SIDE OF THE PRESS AND THEN TURN THE NUT-LIKE DIAL THAT IS JUST BELOW THE BOTTOM DIE.** TURNING THE DIAL COUNTER CLOCKWISE WILL LOWER THE BOTTOM DIE FOR A LARGER GAP AND TURNING THE DIAL COUNTER CLOCKWISE WILL RAISE THE BOTTOM DIE FOR LESS GAP. **HAVING THE GAP TOO TIGHT TO BEGIN WITH CAN CAUSE PROBLEMS, SO IT IS ALWAYS BETTER TO START WITH A LITTLE EXTRA GAP.**

3) **ONCE YOU HAVE ADJUSTED THE GAP TO APPROXIMATELY THE THICKNESS OF THE MATERIAL TO BE GROMMETED, INSERT A GROMMET INTO A SAMPLE RESEMBLING THE INTENDED APPLICATION.** THE GROMMET GOES ON THE TOP DIE WITH THE BARREL SIDE POINTING DOWN AND THE WASHER GOES ON THE BOTTOM DIE WITH THE CURVED SIDE DOWN.

4) **GROMMETS WITH FLAT WASHERS:** AFTER YOU'VE INSERTED A GROMMET CHECK TO SEE IF THE GROMMET SPINS IN ITS HOLE. IF SO, TURN THE DIAL THAT IS AT THE BASE OF THE BOTTOM DIE $\frac{1}{2}$ TURN CLOCKWISE, PUT THE LOOSE GROMMET YOU JUST INSERTED BACK ON THE DIE IN THE CORRECT DIRECTION AND PRESS THE GROMMET AGAIN. THIS WILL CLOSE THE GROMMET FURTHER. CHECK THE GROMMET AGAIN TO SEE IF IT STILL SPINS IN THE MATERIAL. REPEAT THIS PROCESS UNTIL THE GROMMET HAS A TIGHT FIT AND DOES NOT SPIN.

WHEN USING LONG BARREL GROMMETS ON THICKER MATERIAL, SUCH AS 10MM THICK CORRUGATED PLASTIC, LOWER THE BOTTOM DIE ALL THE WAY DOWN AND STOP PUSHING THE HANDLE DOWN WHEN THE TOP DIE TOUCHES THE MATERIAL YOU ARE GROMMETING. NOTE: THE GROMMET ONLY NEEDS TO CURL OVER ENOUGH TO GRAB THE WASHER.

ROLLED-RIM GROMMETS WITH SPUR WASHERS: MAKE SURE THE GROMMET AND WASHER ARE TIGHT TOGETHER WITH LITTLE TO NO SPACE BETWEEN GROMMET, MATERIAL AND WASHER.

5) **ONCE YOU HAVE ADJUSTED THE DIE TO PRODUCE A PERFECT SETTING IN THE DESIRED MATERIAL THICKNESS, TIGHTEN THE WINGED SCREW THAT IS ON THE SIDE OF THE PRESS.** THIS WILL HOLD THE DIE SLEEVE AND YOUR SETTING FIRMLY IN PLACE.

ONCE FAMILIAR WITH HOW TO CHANGE THE DIE SETTING ON THE **HIKER H-901** HAND PRESS, INSERTING GROMMETS IN VARYING MATERIAL THICKNESSES WILL BE A QUICK AND EASY PROCESS THAT WILL PRODUCE QUALITY RESULTS.

THANK YOU FOR CHOOSING **HIKER**.