

# How to change die-set on the HM-307AS Grommet Machine



1. Unplug the machine before performing any adjustment or maintenance.



2. Remove the transparent safety guard and small table (if equipped).



3. Remove the spring that pull the track from the hook.



4. Replace the bottom die. Adjust the ring nut to keep the die low. Do not tighten the locking bolt at this time.



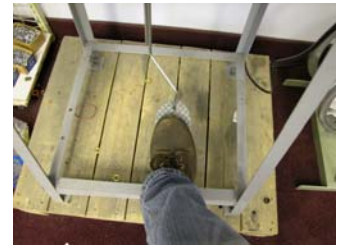
5. Replace the top die. Note the notch should face the set screw and the spring should be riding on the



6. Put the spring that pull the track back on the hook.



7. Check if the pin of the top die is in the middle of the opening at the end of the track.



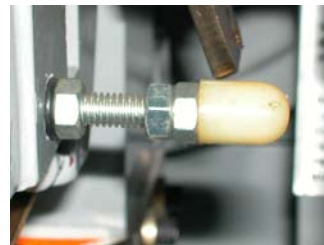
8. Step on the paddle to engage the clutch.



9. Open the side door and turn the flywheel clockwise.



10. The shaft start to move down and the pin of the top die will go through the hole of the grommet.



11. If necessary, adjust this bolt for best alignment. Tighten the nut after you find the best position.



12. The pin of the top die grab the grommet from the track as the track being pushed away.



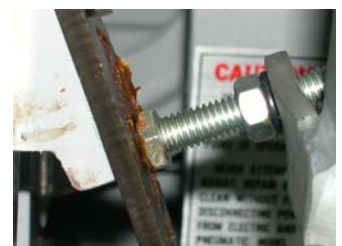
13. If the track is pushed away too early, the grommet may fall from the pin. Adjust this bolt for right timing.



14. Remove the grommet. Stop the flywheel when the top die reach the bottom dead center.



15. Use the ring nut to adjust the bottom die until you have proper gap between the top and bottom dies.



16. At this time the track should be totally pushed out of the way of the top die. If not, adjust this bolt.



17. Turn the flywheel clockwise. The track should return without contacting the die.



18. If the track come back too early, the track may hit the top die. Adjust this bolt for right timing.



19. Repeat steps 8-18. This time check if the bottom die is centered properly with the top die.



20. If everything looks O.K., tighten the nut on the locking bolt and re-install the safety guard and small table.