

FROM: ~~From:~~ Hiker USA ATTN: Christopher Fax: 480-981-5940
 TO: ~~From:~~ Calvin 3 Pages

H-901 Hand Press Check Procedure

How to check handle assembly

1. Check the width of the handle at the machined portion.
2. Check the mobility of the joints.
3. Check the size of the shaft.
4. Check the size of the hole on the shaft.
5. Check if the hole is on the same center line as the shaft.
6. Check the size of the pin hole.

How to check press body

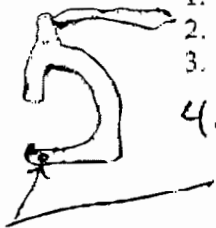
1. Check the size of the shaft hole.
2. Check if the centers of the up and down holes are on the same line.
3. Check the size of the opening for the handle.
4. Check the size of the pin hole.
5. Check if there is any crack on the cast.

How to check assembly

1. Check if the height of the stop bolt is set before bottom dead center of the shaft.
2. Check if the handle receiver spring is positioned properly.
3. Check if the bottom die seat is flush with the adjusting nut.

4. check set screw & nut on side - Not too tight, Not too loose

- When vertical movement of shaft stops.



How to pack

1. Check if the surface of the hand press is clean and shining.
2. Check if there is any rust on the unpainted part.
3. Check if all parts are protected from scratching each other.
4. Check if the handle receiver are protected from bending as a result of touching the side of the box.
5. Check if proper label is attached to the box.

Calvin, also see the attached list that we use here for further ideas.
 Christopher



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H-901B PREPARATION & PACKAGING GUIDE

PREPARING HAND PRESSES

1. Preparing Top Half
 - a. Handle should move smoothly and freely up and down.
 - b. Clip that holds handle upright should be set so handle goes into center of clip.
 - c. Bolt under handle should be set so that the handle stops just before the downward motion of the top shaft stops.
 - d. Lightly oil top of top shaft.
2. Preparing Bottom Half
 - a. Surface of press where lower die nut (dial) sits should be free of paint and lightly oiled.
 - b. Lightly oil surface of lower die sleeve.
 - c. The bottom die sleeve set screw should be set just tight enough to prevent the sleeve from turning when turning the nut (dial), but loose enough to keep the sleeve from binding up. The lower die sleeve should move freely up and down and within margin left to right.
3. Testing Die / Shaft Centering
 - a. Insert a die set and lower handle until center post of top die touches center of bottom die. If centers are off by 1/32" or less the press is okay. If centers are off by 1/32" to 1/16" insert a couple of test grommets. If the grommets cut and roll without any problems, the press is okay. If the centers are off by 1/16" or more make note and set aside for re-work.
4. Adjusting Die
 - a. While a die set is in the press adjust the bottom die so that the grommet will spin lightly in its hole after being closed. Too loose is better than too tight.
 - i. FOR HAND PRESSES SHIPPING WITH DIE INSERTED – Insert screw with wing-nut and washer through bottom of press and up into the bottom die. Tighten screw as deep into bottom die as possible then tighten wing-nut snug against washer.
 - ii. FOR HAND PRESSES SHIPPING WITHOUT DIE INSERTED – Remove test die.
5. Apply Caution Label to Back of Hand Press
 - a. FOR AMERICAN SHIPMENTS – Use entire label with American phone number.
 - b. FOR ALL OTHER SHIPMENTS – Use only the HIKER logo and below. Save top half of label for American grommet boxes.
6. Put Hand Press in Clear Plastic Bag
 - a. Apply quality sticker to outside of bag so it faces up when hand press is lying inside box.



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H-901B PREPARATION & PACKAGING GUIDE – cont'd.

PACKAGING HAND PRESSES

1. Verify Correct Contents for Package
 - a. Wooden base with legs and cut out both in correct direction.
 - b. Hand press in bag – with or without die inserted.
 - c. Zipper bag with 4 carriage bolts, 4 washers and 4 nuts.
 - d. Grommets – Depending on order.
 - e. Instruction Manual
2. Placement of Contents in Box
 - a. Wooden base sits across box on top end with legs to the left.
 - b. Top of hand press lies on top of legs with handle to the right and the bottom of the press lies on foam.
 - c. Place foam between the hand press and all sides of the box.
 - d. Place cardboard insert over handle of press.
 - e. Place hardware zipper bag in box.
 - f. Depending on order, place either cardboard insert or grommets in open space in lower right corner of box.
 - g. Place foam strip on top of press.
 - h. Place instruction manual on top of all contents.
 - i. Close box and tape all 6 open joints with TAN packing tape.
3. Label Hand Press Box – Dealers Only
 - a. FOR HAND PRESSES WITH DIE INSERTED – Place H-901B and appropriate die sticker on side of box.
 - b. FOR HAND PRESSES WITHOUT DIE INSERTED – Place only H-901B sticker on side of box.
4. Place finished product on appropriate stock shelves.