

MODEL: HM-308HN

DUAL-FEED AUTOMATIC GROMMETS MACHINE

FOR GROMMETS:

SP1 WITH SPUR WASHER,
SPW WITH H-1027 WASHER

SPECIFICATION:

MOTOR: 1/2 HP

VOLTAGE: 110V 60HZ AC

THROAT DEPTH: 5"

WEIGHT: 400 LBS

PACKIN SIZE: 27"X29"X67"



Feature:

- Automatic dual feeding of top and bottom pieces
- Use self-piercing grommets hole punching NOT NEEDED.

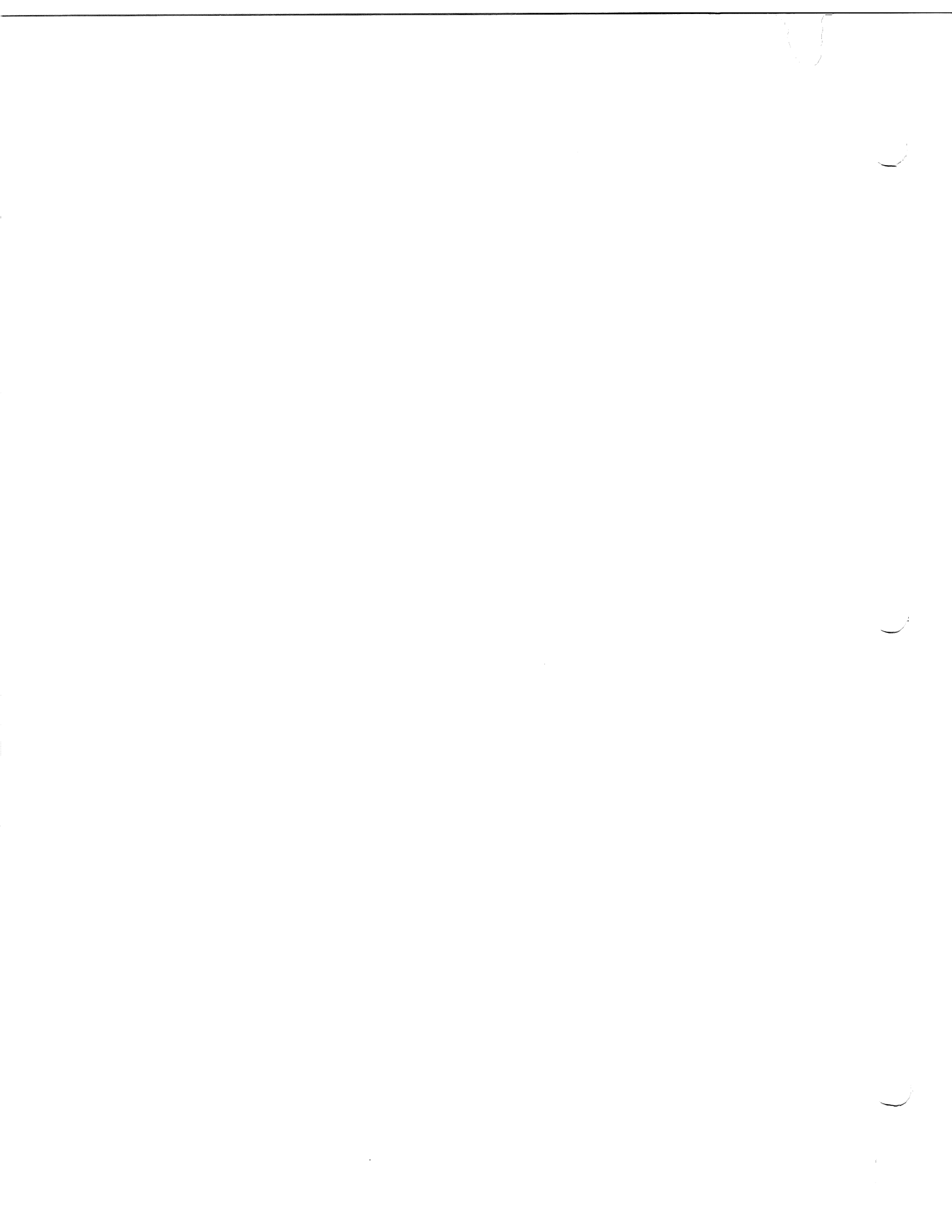


Hiker Enterprises Ltd.

3375 14th Ave. Unit #3, Markham, Ontario , Canada L3R 0H2

Phone: 905-479-5390 Fax: 905-479-0530

Email: info@hikereyelets.com Web: www.hikereyelets.com



OPERATING INSTRUCTIONS

TO BE READ BEFORE OPERATING

HIKER ENTERPRISES LTD.

~~3375 14TH AVE. Unit #3~~ *107 Ferris St.*

MARKHAM, ONTARIO, CANADA L3R-0H2 *3K6*

Tel: 905-479-5390 Fax: 905-479-0530

WEB SITE: www.hikereyelets.com

EYELETTING MACHINE

MODEL: HM - 308 *BA*

Serial No:

Year of Manufacture

INDEX

1	SPECIFICATION	3
2	FORESEEN USE	3
3	WORKSTATIONS	3
4	HANDLING & TRANSPORTING	3
5	INSTALLATION & FIXING	3
6	SETTING UP	4
7	PUTTING INTO SERVICE	4
8	USE (Operating Do's and Don'ts)	4
9	ADJUSTMENT	5
	- Tools	5
	- Feeder Arms	5
	- Feed Hoppers	5
	- Belts	5
	- Brakes	6
10	MAINTENANCE (Service & Repair)	6
11	SPARES & ADVICE	6
12	TRAINING INSTRUCTIONS	6
13	TOOLS (Essential Characteristics)	6
14	HOPPERS	7
15	DO NOT'S	8

EC DECLARATION OF CONFORMITY

This machine is certified as conforming with EC legislation namely:

The Supply of Machinery (Safety) Regulations 1994.

1) Specification

Fully Automatic Eyeletting Machine - Model No: As shown on the Identification Plate

HIKER ENTERPRISES LTD.
~~3375 14TH AVE. Unit #3~~ 107 Teirier
MARKHAM, ONTARIO, CANADA L3R 0H2 3166
Tel: 905-479-5390 Fax: 905-479-0530
WEB SITE: www.hikereyelets.com

Serial No: As shown on the Identification Plate.

Year of Manufacture: As shown on the Identification Plate

2) Foreseen Use

This machine is suitable for the insertion of eyelets or rivets into a wide range of materials, such as: PVC, Bunting, Coated Cloths, Polythene, Canvas, Cotton and Woven materials. It has been designed for use in a DRY AND STABLE ENVIRONMENT. It should always be used in accordance with the relevant regulations and good workshop practises.

3) Workstations

The machine should firmly fixed to the floor and sufficient space around it to allow easy movement of the materials used. Do not allow rubbish or spare materials to accumulate under the machine near the pedal operating area. Keep it clean and clear at all times.

4) Handling & Transporting

When being transported, the machine should be fixed with 4 set bolts, 3/8" dia. x 2 1/2", through the fixing holes in the feet, to a suitably sized pallet. To load the machine onto a pallet, it is recommended that four (4) men undertake the task. Tilt the machine backwards until the front feet are higher than the level of the pallet. Place the pallet in front of the machine and lever the front feet onto it. Slide the machine further onto the pallet, making sure the pallet cannot slide, until the machine is situated in the middle of the pallet; evenly spaced and balanced. Use a Fork-Lift truck to load the pallet onto the vehicle. When on the vehicle, the machine **must be secured with ropes or ties**. The machine with the guard fixed, is **NOT** suitable to be lifted with slings.

5) Installation & Fixing

The machine can be manoeuvred into a suitable working position by means of a hand pallet truck. Remove the machine from the pallet and secure into position by using 10 m.m. Rawl Bolts, through the fixing down holes in the machine feet and drilled into the floor.

6) Setting Up

Always check the machine before use, to ensure it has the correct tools and feed mechanisms to insert the size of eyelet you wish to use.

Note: Every size of eyelet and washer requires its corresponding tools, feed units and hoppers. (Instructions for aligning tools and feed units is given in section 9.1.) The Material Support Plate should be marked out for position of eyelets. e.g. The centre of the eyelet from the edge of the material and the distance required between each eyelet. Eyelets, washers and material for use should be ready to hand, but free movement of the latter should not be obstructed when the machine is in use.

7) Putting into Service

Before switching on the machine, check that there is no damage to the electric cables or electric fittings. If the machine has been adjusted or the eyelets changed in size, make sure all eyelets and washers of the previous size have been removed from the hoppers, feed units and under the punch and die. Great care must be taken to ensure the **correct sized** eyelets and washers have been put into the hoppers. The wrong size can damage your machine, punches and dies. The Operator should wear ear defenders.

CHECK LIST BEFORE OPERATING

- a Check power supply at correct voltage
- b Check for damaged or broken cables and fittings
- c Check for loose or missing screws/fittings
- d Check for damaged or worn tools
- e Check machine is empty/clear of eyelets/washers
- f Check the eyelets and washers correspond to the correct size of Hoppers

8) Use (Operating & Dos)

Before connecting the machine to the power supply and proceeding with normal operation, go through a procedure of operating the machine manually to ensure the correct alignment of the tools and slideways, (feeder units). Do this by depressing the foot pedal and rotating the flywheel by hand for one whole revolution. If the flywheel will not rotate fully, the bottom tool may be set too high, thereby stopping the full cycle. Ensure the slideways are in line with the tools, the eyelets and washers feed correctly and adjust as required. (see section 9 "Adjustment").

The machine has a Guard Safety Limit Switch and an Emergency Stop Button, (RED). To start the machine, switch the lever to ON and push the Green Start Button. For Emergency Stop, push the Red button, but switch the machine to OFF if it is to be left for a while.

When manually turning the machine keep alert to ensure there is only one eyelet and one washer between the tools at any one time. Once this testing procedure is complete, remove the eyelet and washer left in the tool.

9) Adjustment

Always isolate the machine from the power supply before undertaking any work on the machine. In order to work on the machine or to effect many of the initial adjustments, it will be necessary to remove the Main Guard. To do so remove 10 screws from the top and two sides of the Main Guard. The guard can now be lifted off.

To gain access to the Flywheel, loosen the two clamps to the side of the flywheel and open the guard door.

9.1. Adjusting the Tools

The tool adjustment screw, located underneath the bottom tool is screwed up or down to ensure the correct setting height is achieved.

9.2. Adjustment of the Feeder Hoppers.

Ensure the Hopper Cone is able to rotate freely, (but not loosely), adjusting the tension by tightening or loosening the tension spring on the Hopper Cone. Too much pressure can cause damage to the eyelet or washer. Too little pressure can cause double feeding.

9.3. Adjustment of the Feeder Arms, (Slideways).

It is most important to ensure the alignment of the Feeder Arms is correct.

To adjust the feeder arms from side to side, loosen and/or tighten the adjusting screws located front and back of hopper, aligning the feeder central to the punch.

To align the feeder arms inwards or outwards, loosen off the nut and adjust the feeder slide stopper in the direction required to align the eyelet directly under the punch.

Manual
N.B. A washer may fail to locate correctly in the Bottom Tool. When this occurs, a washer can be released manually by use of the Lever, positioned to the right below the feeder table. Move the lever once up and down, which should allow one washer to drop and locate in the Jaw Fingers.

9.4. Adjusting the Belts.

All belts should be taught, but not too tight and not loose or slack. Taughtness can be tested by ensuring the belts have approximately 1-2c.m. of play.

The Flywheel Belt can be adjusted by raising or lowering the Motor Fixing Plate.

The Hopper Drive Belts are adjusted by raising or lowering the keyed slideway located at the rear and in the middle of the two Hoppers.

9.5. Adjusting the Brake.

Either tighten or loosen the butterfly nut to increase or decrease tension on the Brake Spring.

10) Maintenance (Service and Repair)

Always isolate the machine from the power supply before undertaking any work on the machine.

All oil and grease wells should be kept full.

The tightness and condition of the belts should be checked frequently.

The Operator should check periodically for the tightness of all nuts, screws and bolts.

All slideways should be kept clean.

Wiring should be regularly checked for damage or breakage.

All worn parts should be replaced.

11) Spares and Advice

There is a spare parts list at the rear of this manual.

When new parts are required, quote the Part No., Machine Model No. and Serial No.

12) Training Instruction (Where Necessary)

Initial training in the use of the machine will be provided by the supplier of the machine, free of charge. Further training where required, is available by the supplier and will be charged for.

13) Tools (Essential Characteristics)

The setting tools must be kept clean at all times and the piercing parts of the tools kept sharp.

Whenever the tools are damaged, they must be replaced or repaired.

Depending upon the amount of wear and re-sharpening, the Bottom Tool may need to be adjusted or replaced.

13.1. To adjust the height of the tool.

a) Turn the adjustment bolt, which is located under the Bottom Tool.

N.B. It is important NOT to over adjust the Bottom Tool.

13.2. To remove the Top Tool:

a) Remove the material support plate, by means of Cap Head screws at front of machine and loosen Butterfly nut on right side

b) Loosen two 6 m.m. Hexagon Head set screws, to remove the second small Support Plate.

c) Two Jaw Fingers will show; remove the springs first and then the Fingers.

d) Loosen Hexagon Head bolt and swing away the Material Clamping Foot

e) Loosen Grub screw at front of machine and remove the Bottom Tool.

13.4. To remove the Bottom Tool

a) Loosen Grub screw in shaft holding the Punch

b) Push Eyelet Feeder Arm to one side

c) Pull down Top Punch and remove.

13.5. To REPLACE the tools follow the procedures in reverse order.

N.B. There is a spring inside the Top Tools Shaft **which must be replaced** when the Top Tool is replaced.

After the Tools have been adjusted or removed and replaced, always conduct a manual test, as described in Section 8.

14. Removal & Replacement of Hoppers and Feeder Arms

If/When the machine is needed to work with different types/sizes of eyelets, contact your supplier for the Hoppers and Feeder Arms to suit. The machine cannot be operated with Hoppers and Feeder Arms which have not been made to match. When the correct sizes have been supplied, the instructions are as follows:

14.1. To remove Hopper & Feeder Arms (Eyelet)

- a) Remove the round belt from Hopper
- b) Remove long expansion spring from Feeder Arm
- c) Loosen two (2) adjustment bolts, one either side of Hopper
- d) Move Feeder Arm to one side
- e) Remove two (2) hexagon headed bolts directly under the Hopper Unit
- f) Hopper and Feeder Arm may now be removed.

14.2. To replace the Hopper & Feeder Arms (Eyelet)

- a) Position Hopper, careful to align with the bolt holes
- b) Replace bolts and secure to the machine frame
- c) Align the Feeder Arm, using the procedure described in Section 9.3.
- d) Replace long expansion spring to bottom of Feeder Arm
- e) Replace round belt to Hopper

14.3. To remove Hopper and Feeder Arm (Washer)

- a) Remove round belt from Hopper
- b) Remove two (2) hexagon head bolts from directly under the Hopper
- c) Hopper and Feeder Arm may now be removed

14.4. To replace Hopper and Feeder Arm (Washer)

- a) Position Hopper, careful to align with the bolt holes
- b) Replace bolts and secure to the machine frame
- c) Realign the Feeder Arm by loosening and tightening adjustment screws in the direction required. Fine adjustment could be required to position correctly.

15. Attention to "Do Nots"

Do not place hands under the tools when the machine is connected to the power supply.

Do not carry out work on the machine while it is connected to the power supply.

Do not overfill the Hoppers.

Do not apply too much pressure to the springs on the Hopper Cones.

Do not operate the machine again if a washer or eyelet has not inserted correctly. Switch the machine off to clear the failed unit.

Do not try to operate the machine without the Main Guard fixed correctly.

INTRODUCTION

THIS BOOKLET IS PUBLISHED BY *HIKER* ENTERPRISES CO., LTD. TO PROVIDE THE USERS WHO HAVE PURCHASED THE HM-208B MACHINES FOR PERFORMANCE AND PARTS SUPPLY.

THIS MACHINE IS A FULL-AUTOMATIC SAFETY FASTENING MACHINE, ITS SPEED FAST AS WELL AS SAFETY IS PERFECT. OUR PRODUCTS HAVE GOOD SALE, COMMENTS AND CONFIDENCE FROM THE USERS OF HOME AND ABROAD RECENTLY FOR A DECADE.

GENERAL DESCRIPTION

1. DATA :

- (1) MOTOR : 1/4 HP
- (2) VOLTAGE : 110V - 220V - 3PH - 50~60HZ.
- (3) SUITABLE : TUBULAR RIVETS, SNAPS, PLASTIC BUTTONS, SNAPPER FASTENERS, PRONGS, TACKS.
- (4) PIECEWORK : RAINCOAT, GARMENT, STATIONERY, RUBBER ITEMS, PLASTIC ITEMS, LEATHER BAGS.
- (5) THROAT DEPTH : 5"
- (6) GROSS WEIGHT : 240KG
- (7) PACKING SIZE : 27" X 29" X 67"

2. CAUTION :

- (1) IN THE CASE OF CHANGING OTHER KIND OF SNAP BUTTONS, SHOULD CHANGE A COMPLETE SET OF FEEDING SYSTEM TO FIT BUTTONS SIZE WHICH YOU DESIRE.

CONTENTS

BASE SUPPORT SYSTEM EXPLODED VIEW (FIG. 1)	4
PARTS LIST (FIG. 1)	5
DIES AND DIE SEATS LINKING SYSTEM EXPLODED VIEW (FIG. 2) ...	6
PARTS LIST (FIG. 2)	7
DIE AND DIE SEAT SYSTEM EXPLODED VIEW (FIG. 3)	8
PARTS LIST (FIG. 3)	9
PUSHER SYSTEM EXPLODED VIEW (FIG. 4)	10
PARTS LIST (FIG. 4)	11
BODY, PULLEY AND MAIN SHAFT EXPLODED VIEW (FIG. 5)	12
PARTS LIST (FIG. 5)	13
CLUTCH CONTROL SYSTEM EXPLODED VIEW (FIG. 7)	14
PARTS LIST (FIG. 7)	15
CLUTCH SYSTEM EXPLODED VIEW [OLD TYPE] (FIG. 8)	16
PARTS LIST (FIG. 8)	17
HEAD, COMPONENT CASE SYSTEM EXPLODED VIEW (FIG. 10)	18
PARTS LIST (FIG. 10)	19
RIGHT FEEDING SYSTEM EXPLODED VIEW (FIG. 11)	20
PARTS LIST (FIG. 11)	21
LEFT FEEDING SYSTEM EXPLODED VIEW (FIG. 12)	22
PARTS LIST (FIG. 12)	23
ASSEMBLIES REPLACEMENT (FIG. 13)	24
PARTS LIST (FIG. 13)	25
NORMAL WARNOUT PARTS LIST	26
WIRE DIRGRAM	27

目 次

底座支架系統分解圖（圖 1）	4
圖 1 零件表	5
模及模座連動系統分解圖（圖 2）	6
圖 2 零件表	7
模及模座系統分解圖（圖 3）	8
圖 3 零件表	9
推槽系統分解圖（圖 4）	10
圖 4 零件表	11
本台、滑輪及主軸系統分解圖（圖 5）	12
圖 5 零件表	13
安全裝置系統分解圖（圖 6）	14
圖 6 零件表	15
離合器控制系統分解圖（圖 7）	6
圖 7 零件表	17
離合器系統分解圖（舊型）（圖 8）	18
圖 8 零件表	19
離合器系統分解圖（新型）（圖 9）	20
圖 9 零件表	21
分件箱系統分解圖（圖 10）	22
圖 10 零件表	23
右邊選料系統分解圖（圖 11）	24
圖 11 零件表	25
左邊選料系統分解圖（圖 12）	26
圖 12 零件表	27
常用損耗零件表	28
總成及總成零件更換零件表	29
正常損耗另件表	30
電路圖	31

ORDERING REPLACEMENT PARTS

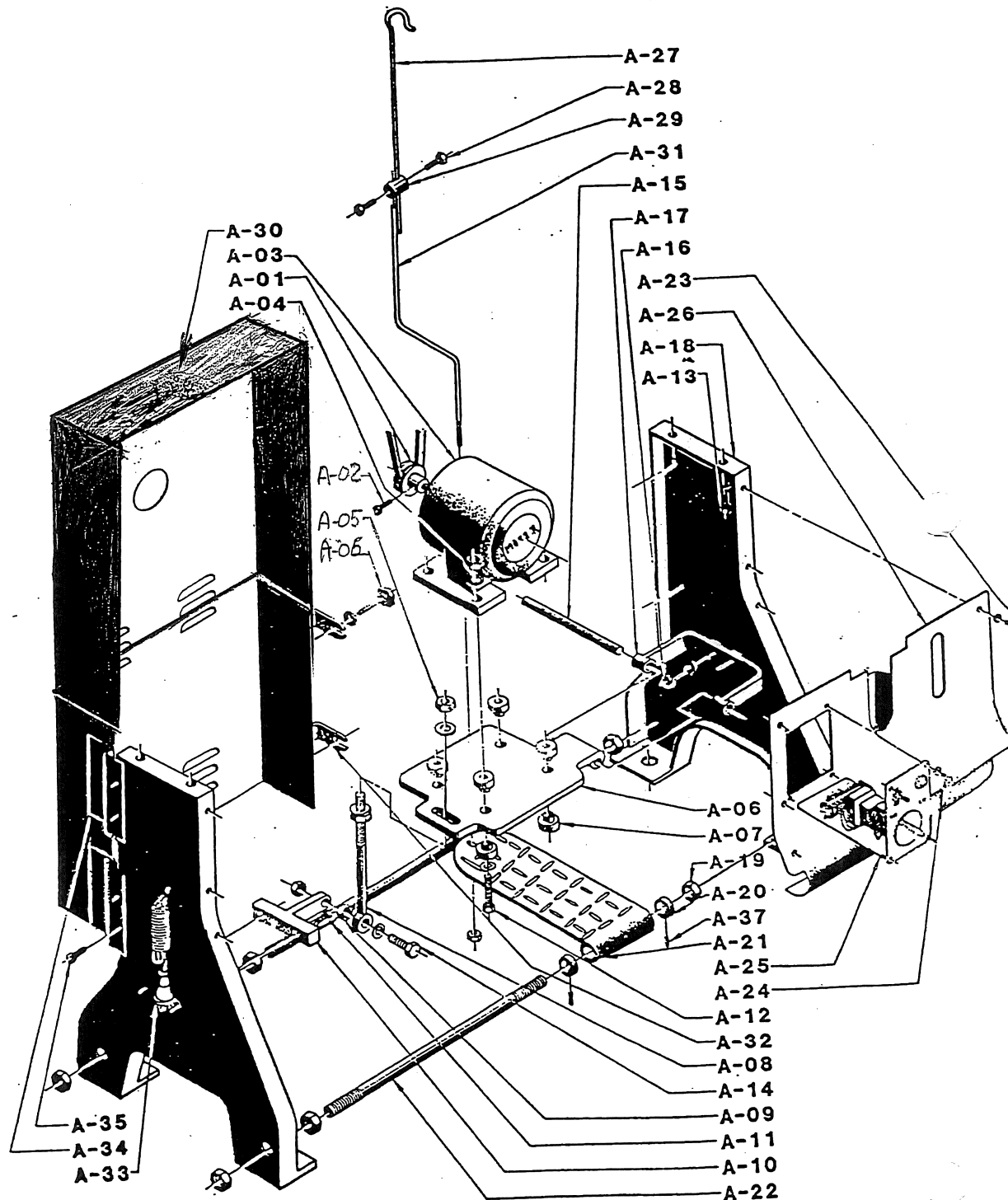
ALL PARTS OF THIS MACHINE HAVE BEEN ASSIGNED PARTS NUMBER IN THE CATALOG BOOK. THESE PARTS ARE SHOWN IN THE EXPLDED VIEW DRAWINGS.

WHEN ORDERING ANY PART, THE FOLLOWING INFORMATION MUST BE SUPPLIED :

- A. YOUR COMPANY'S NAME AND ADDRESS.
- B. MACHINE MODEL AND SERIAL NUMBER.
LOCATED ON NAME PLATE OF MACHINE.
- C. THE STYLE AND CARD NUMBER OF THE FASTENERS BEING USED.
- D. WRITE DOWN FIG. NO., ITEM NO. AND PART NO. NAME OF PART DESIRED, UNIT AND QUANTITY. THOSE OF WHICH ARE SHOWN IN THE CATALOG BOOK.
- E. IF POSSIBLE, RETURN WORN OR BROKEN PART WITH YOUR PURCHASE ORDER WHEN YOU ARE NOT SURE.



BASE SUPPORT SYSTEM EXPLODED VIEW (FIG. 1)



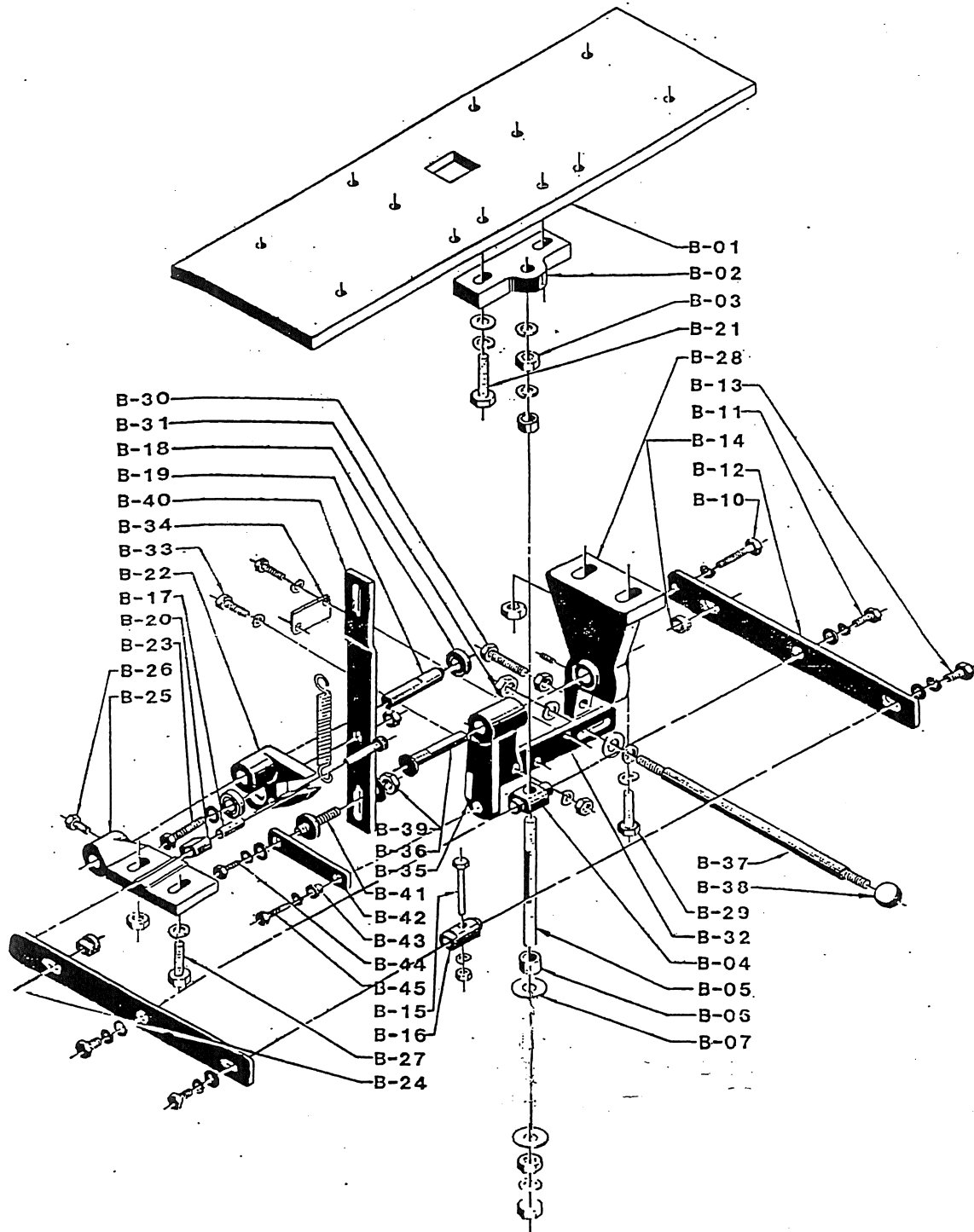
HIKER

Figure 1. Parts List

ITEM NO.	DESCRIPTION	QTY	REMARKS
A-01	MOTOR PULLEY	1	
A-02	SET SCREW MOTOR PULLEY	1	5/16"φ x 3/4"L
A-03	MOTOR	1	
A-04	NUT	4	
A-05	NUT	2	
A-06	MOTOR BEARER	1	
A-07	RUBBER WASHER	8	
A-08	BEARER SUPPORTING ROD	1	
A-09	NUT	2	
A-10	HOLDER, BEARER SUPPORTING ROD	1	
A-11	FIXED SCREW	2	3/8"φ x 3/4L
A-12	FIXED SCREW, MOTOR	4	5/16"φ x 1 1/2"L
A-13	FIXED SCREW	4	3/8"φ x 1"L
A-14	SCREW, MOTOR BEARER SUPPORTING ROD	1	
A-15	PIN, MOTOR BEARER	1	
A-16	FIXED SCREW	2	3/8"φ x 1 1/2"L
A-17	PIN HOLDER, MOTOR BEARER	1	
A-18	BASE SUPPORT, RIGHT	1	
A-19	NUT	8	
A-20	STOP RING PEDAL	2	3/4"φ x 1 1/4"Φ16t
A-21	PEDAL	1	
A-22	CROSS BAR, BASE SUPPORT	2	
A-23	FIXED SCREW	6	1/4"φ x 1 1/2"L
A-24	FIXED SCREW	4	3/16"φ x 1 1/2"L
A-25	POWER SWITCH PLATE	1	
A-26	FRONT PANEL	1	
A-27	UPPER TREADLE ROD	1	
A-28	FIXED SCREW	2	5/16"φ x 1 1/2"L
A-29	CONNECTOR, LOWER AND UPPER PEDAL ROD	1	
A-30	FLYWHEEL COVER	1	
A-31	LOWER TREADLE ROD	1	
A-32	LOCK PLATE, FLYWHEEL	2	
A-33	POWER PLUG	1	
A-34	HINGE, FLYWHEEL COVER	2	
A-35	FIXED SCREWS	6	1/4"φ x 1 1/2"L
A-36	FIXED SCREWS	2	
A-37	FIXED SCREWS	2	
A-38	PLUG	1	For Laser Light
A-39	BASE	1	1



DIES AND DIE SEATS LINKING SYSTEM EXPLODED VIEW (FIG. 2)

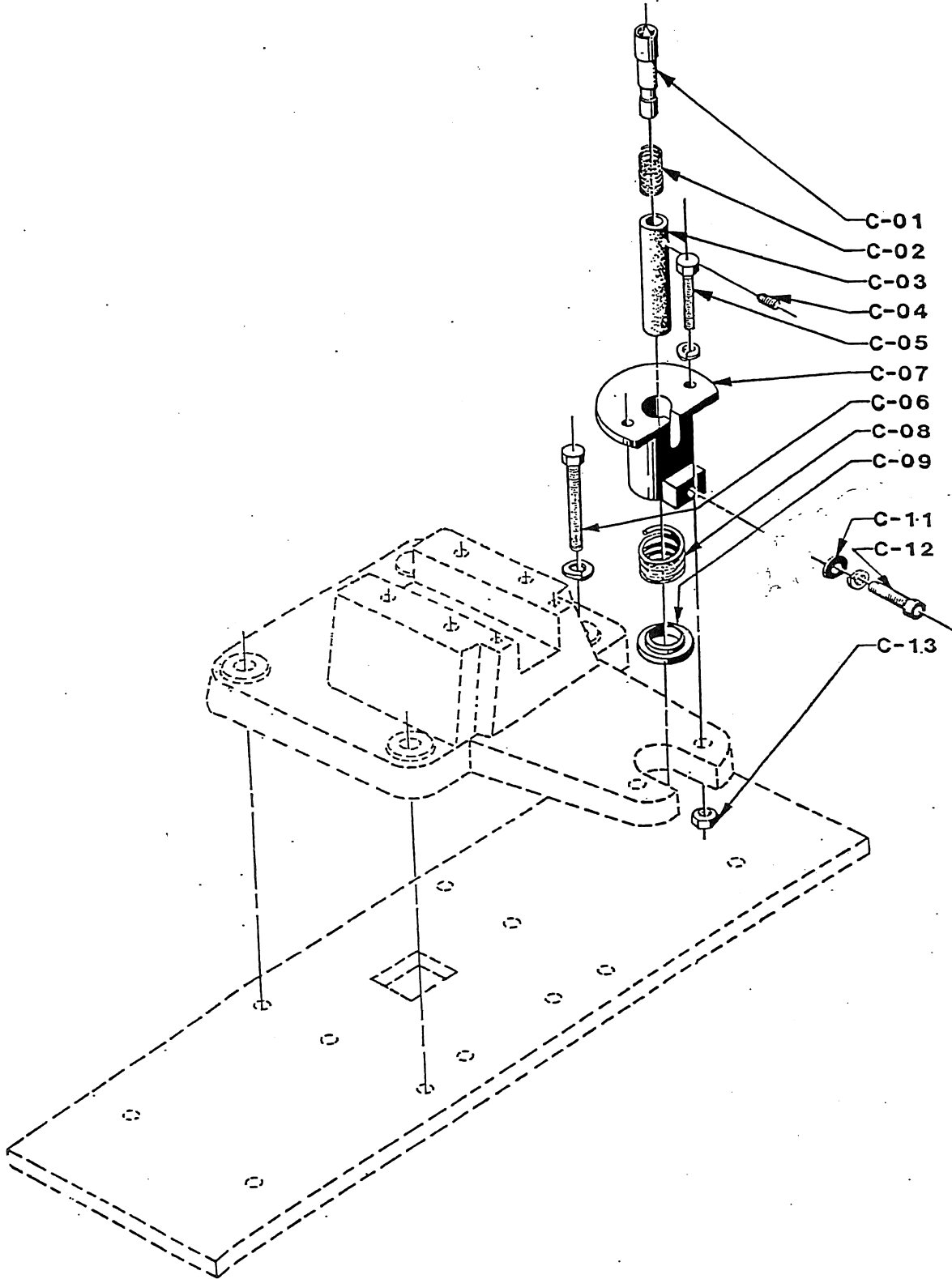


HIKER**Figure 2 Parts List**

ITEM NO	DESCRIPTION	QTY	REMARKS
B-01	WORK BENCH	1	
B-02	TAPPET STOP PLATE	1	
B-03	NUT	3	
B-04	JOINT, FULCRUM ROD	1	
B-05	FULCRUM ROD	1	1/2"φ x 1401L
B-06	COLLAR, FULCRUM ROD	1	
B-10	TAPPET ARM SCREW	1	
B-11	SCREW	2	
B-12	TAPPET ARM	2	
B-13	SCREW	2	1/4"φ x 11/2"L
B-14	BUSHING-SHAFT	2	3/8"φ INSIDE DIA.
B-15	TAPPET ADJUSTING SCREW	1	3/8"φ x 2"L
B-16	TAPPET ADJUSTER	1	
B-17	BUSHING-SHAFT PIPE	1	
B-18	BEARING	2	6000#, 26φ x 10φ x 8t
B-19	SHAFT PIN, OSCILLATING HEAD	1	5/8"φ
B-20	SLIDING KEY, OSCILLATING HEAD	1	
B-21	FIXED SCREW	2	3/8"φ x 11/2"L
B-22	OSCILLATING HEAD	1	
B-23	SCREW	1	5/16"φ x 11/4"L
B-24	ROCKER ARM PIN	1	5/16"φ x 50L
B-25	HANGING BRACKET	1	
B-26	FIXED SCREW	1	5/16"φ x 3/4"L
B-27	FIXED SCREW	2	
B-28	LINK PUSHING BRACKET	1	
B-29	FIXED SCREW	1	
B-30	ADJUSTING SCREW, PUSHING PLATE	1	5/16"φ x 2"L
B-31	NUT	1	
B-32	PUSHING PLATE	1	
B-33	FIXED SCREW	1	3/8"φ x 11/4"L
B-34	WASHER	1	50 x 30 x 1/8"t
B-35	PUSHER LINK PIECE	1	
B-36	PUSHER SHAFT	1	
B-37	HAND PUSHING ROD	1	
B-38	KNOB, HAND PUSHING ROD	1	
B-39	NUT	1	
B-40	ROCKER ARM	1	
B-41	ADJUSTING SHAFT	1	
B-42	CONNECTING PLATE	1	
B-43	BUSHING-SHAFT CONNECTING PLATE	1	
B-44	SCREW	1	1/4"φ x 1/2"L
B-45	SCREW	1	5/16"φ x 11/4"L



DIE AND DIE SEAT SYSTEM EXPLODED
VIEW (FIG. 3)



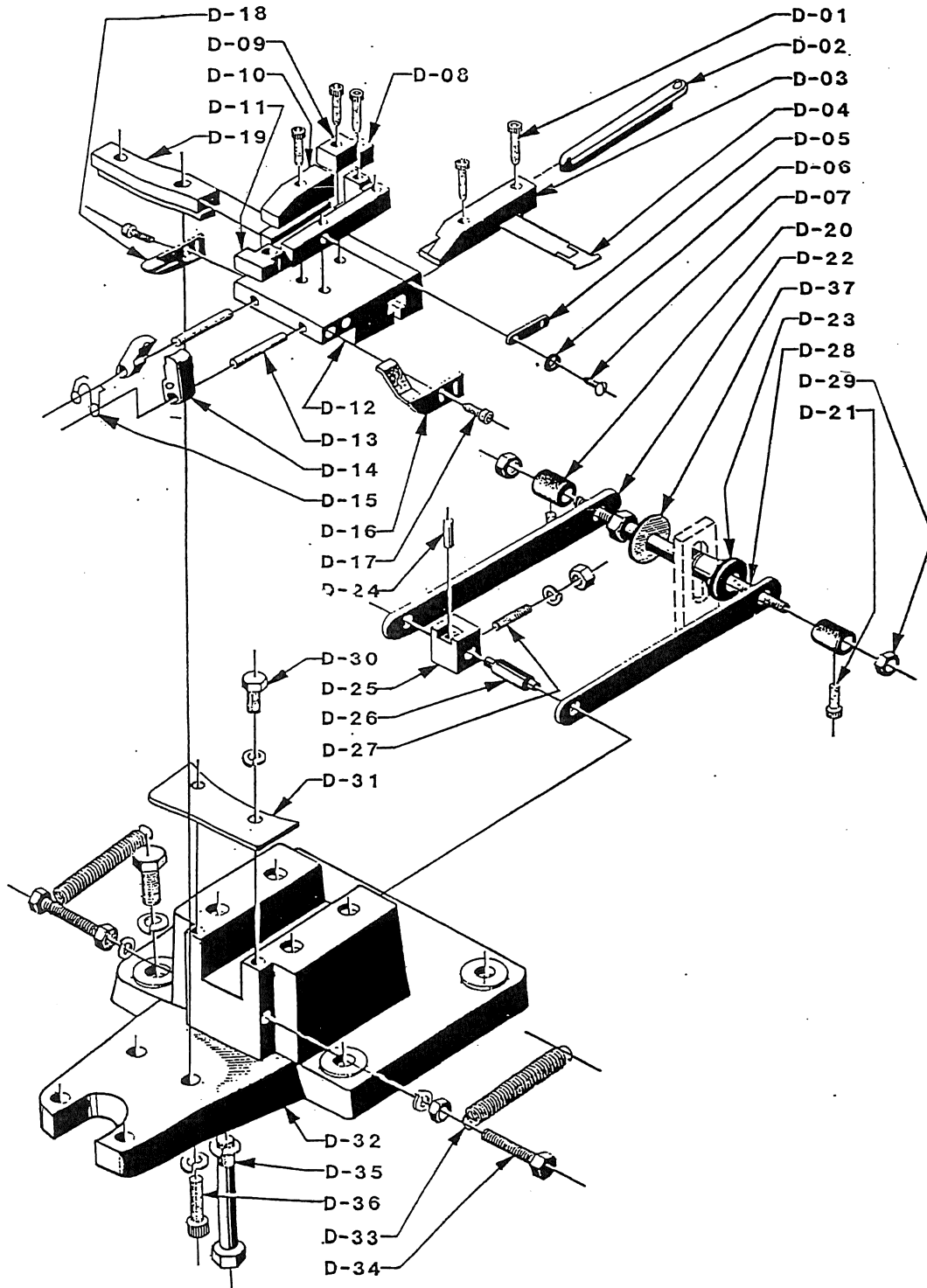
HIKER**Figure 3****Parts List**

ITEM NO.	DESCRIPTION	QTY	REMARKS
C-01	DIE (SIZES ARE REPLACEABLE)	1	
C-02	SPRING, DIE	1	1 x 66 x 3.5 x 19
C-03	PIPE SOCKET, DIE	1	
C-04	SETCREW, DIE PIPE SOCKET	1	1/4"φ x 3/4"
C-05	SCREW, DIE SEAT	2	5/16"φ x 2"
C-06	SCREW, PUSHER SLOT, BASE	4	3/8"φ x 3"
C-07	GUIDE-WAYS BASE	1	
C-08	COIL SPRING	1	3 x 37φ x 60x 14 x 5
C-09	SEAT, COIL SPRING	1	
C-11	FLAT WASHER	1	
C-12	SOCKET HEAD SCREW SIDE PLATE	1	5/16"φ x 3/4"
C-13	NUT, DIE SEAT SCREW	2	



PUSHER SYSTEM EXPLODED VIEW

(FIG. 4)



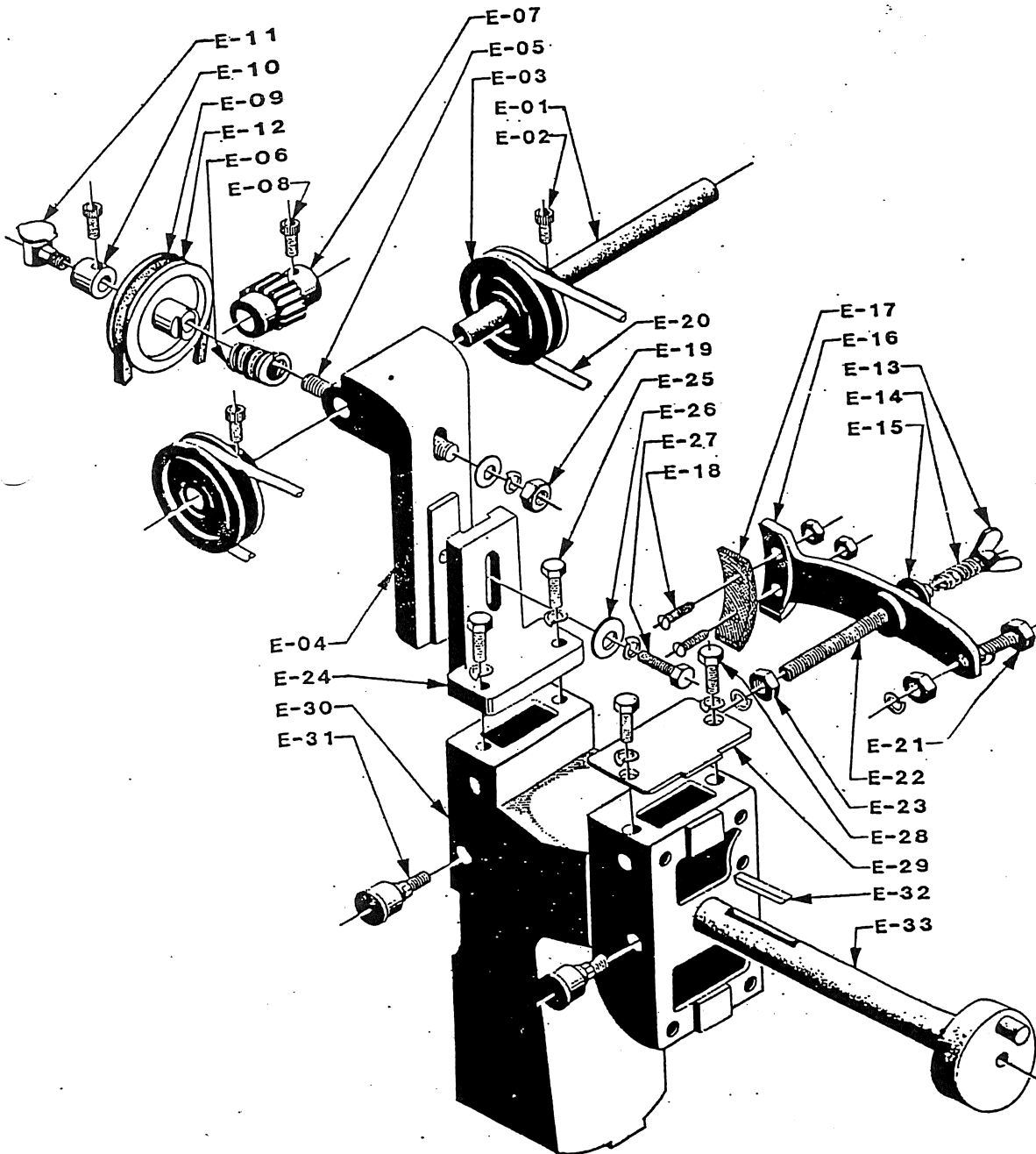
HIKER

Figure 4 Parts List

ITEM NO	DESCRIPTION	QTY	REMARKS
D-01	SOCKET CAP SCREW, GUIDE BLOCKS	4	3/16" ^φ x 11/4" ^L
D-02	SNAP PUSHING ROD	1	
D-03	GUIDE BLOCK, SNAP PUSHING ROD	1	
D-04	CONTROL SLICE, TRACK FEEDINGS	1	
D-05	SPRING LEAF, CONTROL SLICE	1	
D-06	WASHER	1	
D-07	SPRING LEAF SCREW	1	3/16" ^φ x 1/4" ^L
D-08	SQUARE BLOCK, SIDE	1	
D-09	SQUARE BLOCK, MIDDLE	1	
D-10	GUIDE BLOCK, TRACK	1	
D-11	GUIDE-WAYS SEAT	1	
D-12	MILLING BENCH(FOR PRONG EYE-LET)	1	
D-13	JAW PIN	2	5 ^φ x 45L
D-14	LOWER JAW	1	
D-15	JAW SPRING	1	
D-16	JAW COVER	1	
D-17	SCREWS	2	1/4" ^φ x 1/2" ^L
D-18	JAW COVER	1	
D-19	SLOT KEY, MILLING BENCH	1	
D-20	SLEEVE, SLIDING ARM	2	3/4" ^φ x 1/2" ^L
D-21	SCREWS	2	1/4" ^φ x 1/2" ^L
D-22	SLIDING ARM	2	
D-23	ADJUSTER	1	
D-24	PIN, SNAP PUSHING ROD	1	
D-25	MOVING PIVOT, SNAP PUSHING ROD	1	
D-26	PIN, MOVING PIVOT	1	
D-27	THREAD PIN, MOVING PIVOT	1	5 ^φ x 24L
D-28	SLIDING ARM PIN	1	
D-29	NUTS	2	5/16" ^φ x 6t
D-30	SCREWS	2	1/4" ^φ x 1/2" ^L
D-31	PROTECTIVE PLATE	1	
D-32	GUIDE-WAYS BASE	1	
D-33	SPRING, SLIDING ARM	2	1.2 ^d x 146L x 1.2 ^p x 119
D-34	SCREW, SLIDING ARM SPRING	2	5/16" ^φ x 11/2" ^L
D-35	BOLT, HEAD BODY	4	3/8" ^φ x 11/2"
D-36	SOCKET CAP SCREW, SLOT KEY	2	3/8" ^φ x 11/4"



BODY, PULLEY AND MAIN SHAFT EXPLODED VIEW (FIG. 5)



HIKER**Figure 5 Parts List**

ITEM NO	DESCRIPTION	QTY	REMARKS
E-01	PULLEY SHAFT	1	5/8" ^φ x 200
E-02	SOCKET CAP SCREW, PULLEY	2	5/16" ^φ x 3/4"
E-03	PULLEY	2	
E-04	PULLEY STAND	1	
E-05	WORM GEAR SHAFT	1	
E-06	WORM GEAR	1	
E-07	BUSHING-SHAFT GEAR	1	
E-08	SOCKET CAP SCREW, BUSHING SHAFT	1	5/16" ^φ x 5/16"
E-09	PULLEY, WORM GEAR SHAFT	1	
E-10	OUTER COLLAR, WORM GEAR SHAFT	1	
E-11	OIL CUP	1	
E-12	PULLEY BELT	1	
E-13	THUMB-NUT	1	3/8" ^φ
E-14	COIL SPRING	1	2.3 ^d x 15 ^d x 6 ^d x 43.3 ⁱ
E-15	FLAT WASHER	1	3/8" ^φ
E-16	BRAKE ANCHOR	1	
E-17	BRAKE LINING	1	
E-18	SCREW, BRAKE LINING	2	3/16" ^φ x 1"L
E-19	NUT, WORM GEAR SHAFT	1	
E-20	PULLEY BELT	1	
E-21	SCREW, BRAKE ANCHOR	1	1/4" ^φ x 1 1/2"L
E-22	THREADED STUD, BRAKE ANCHOR	1	3/8" ^φ x 4"L
E-23	NUT, THREADED PIN	1	3/8" ^φ
E-24	SUPPORTING STAND	1	
E-25	FIXED SCREW	2	5/16" ^φ x 1"L
E-26	FLAT WASHER	1	
E-27	SCREW, SUPPORTING STAND	1	3/8" ^φ x 1 3/4"L
E-28	SCREW, HEAD COVER PLATE	2	5/16" ^φ x 1/2"L
E-29	COVER PLATE, HEAD	1	
E-30	HEAD BODY	1	
E-31	GREASE CUP	2	
E-32	KEY, DRIVE SHAFT	1	
E-33	DRIVE SHAFT	1	



CLUTCH CONTROL SYSTEM EXPLODED VIEW

(FIG. 7)

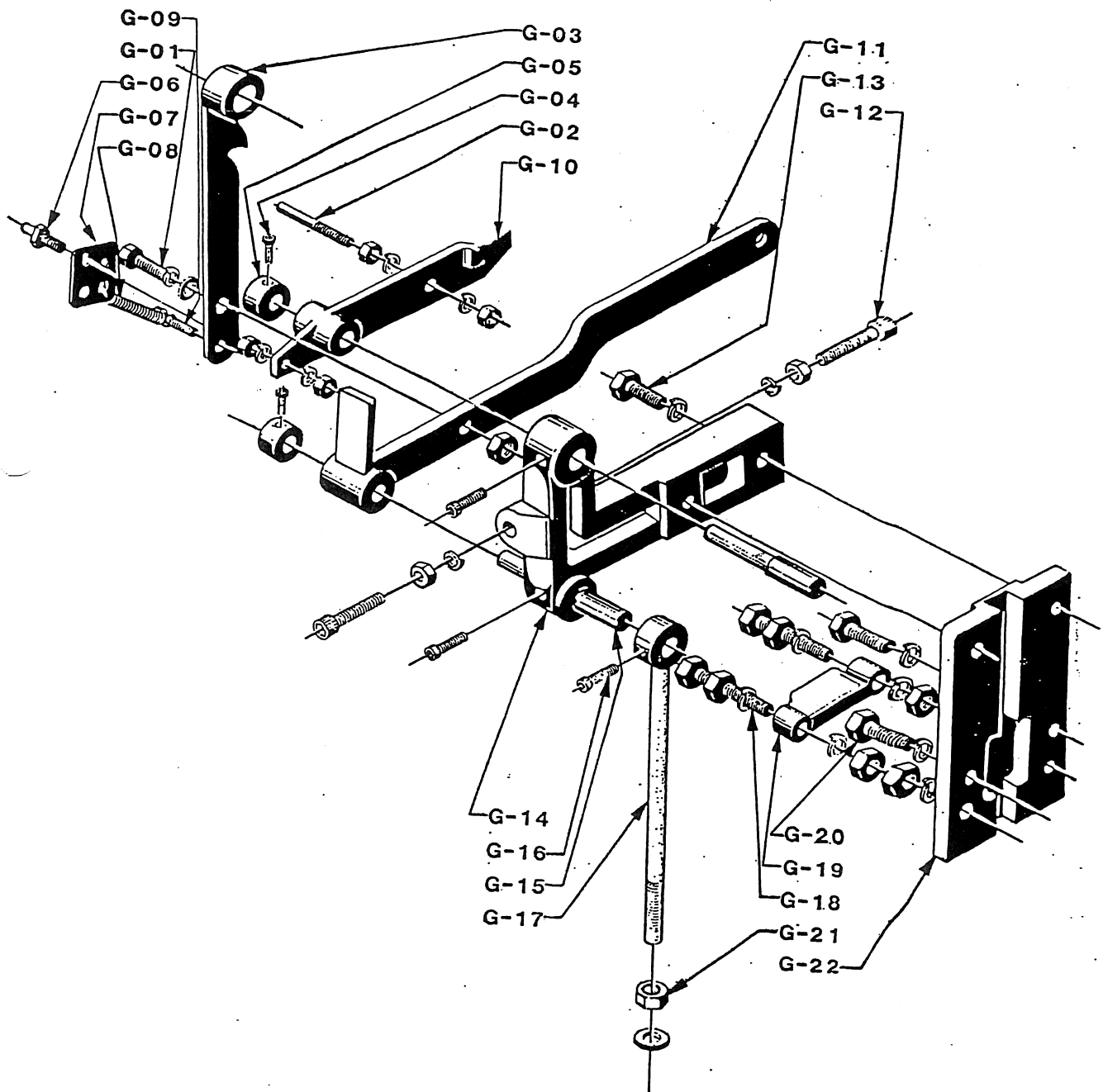




圖7 零件表

件號 Item No.	名稱 Description	數量 Qty	附記 Remarks
G-01	固定螺絲SCREW, CLUTCH LEVER HOOK	1	3/8"φ×1 1/4"ℓ
G-02	螺紋梢STOP PIN, CLUTCH LEVER	1	
G-03	離合器勾頭CLUTCH LEVER HOOK	1	
G-04	固定螺絲SCREW, STOP COLLAR	2	5/16"φ×1/2"ℓ
G-05	固定圓套 STOP COLLAR	2	1"φ×1/2"φ×15'
G-06	勾簧板固定螺絲SCREW, HOOK PLATE	1	
G-07	勾彈簧簧板HOOK PLATE	1	
G-08	離合桿拉簧SPRING, CLUTCH LEVER	1	12°×77ℓ
G-09	彈簧拉斧頭螺絲SCREW, CLUTCH LEVER HOOK SPRING	1	3/8"φ×3/8"ℓ
G-10	斧頭CLUTCH LEVER	1	
G-11	斧頭拉桿臂(吊臂) TREADLE ROD ARM	1	
G-12	調位螺絲ADJUSTING SCREW, TREADLE ROD ARM	1	5/16"φ×1 1/4"ℓ
G-13	固定螺絲SCREW, BRACKET	2	5/16"φ×2 1/2"ℓ
G-14	支持架BRACKET, TREADLE ROD ARM	1	
G-15	二節心CLUTCH LEVER PIN	2	
G-16	固定螺絲SCREW, SUPPORT ROD	1	5/16"φ×1/2"ℓ
G-17	支撐螺桿SUPPORT ROD, BRACKET	1	
G-18	合鉤距離調整螺絲ADJUSTING SCREW, PINCH	1	3/8"φ×3"ℓ
G-19	後止TIE BAR, GUIDE BOARD	1	
G-20	固定螺絲SCREW, GUIDE BOARD TIE BAR	2	5/16"φ×1 1/4"ℓ
G-21	螺帽NUT, BRACKET SUPPORT ROD	1	3/8"φ
G-22	帶動下模滑道板GUIDE BOARD, SQUARE CONNECTING ROD	1	



CLUTCH SYSTEM EXPLODED VIEW (OLD TYPE) (FIG. 8)

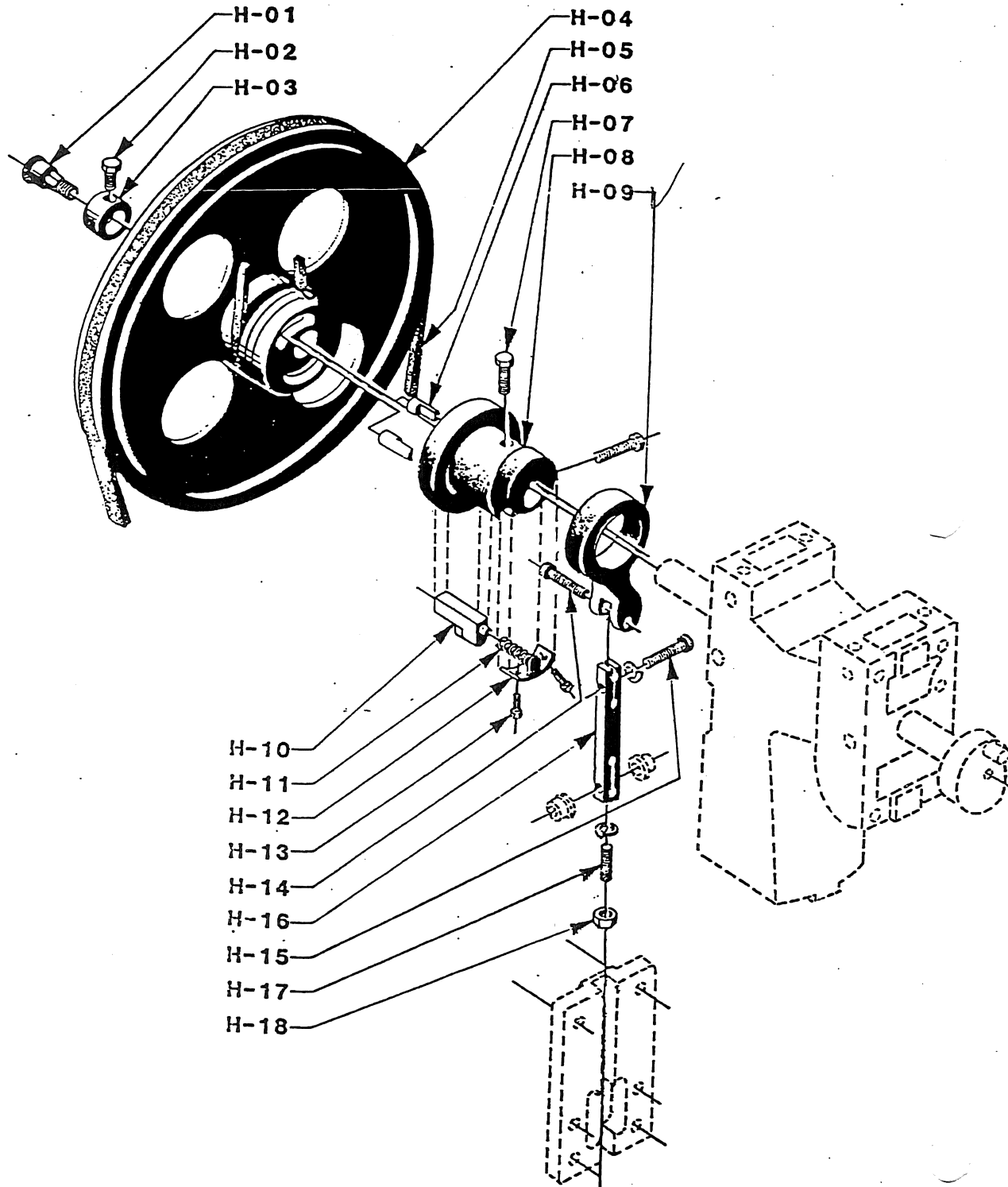


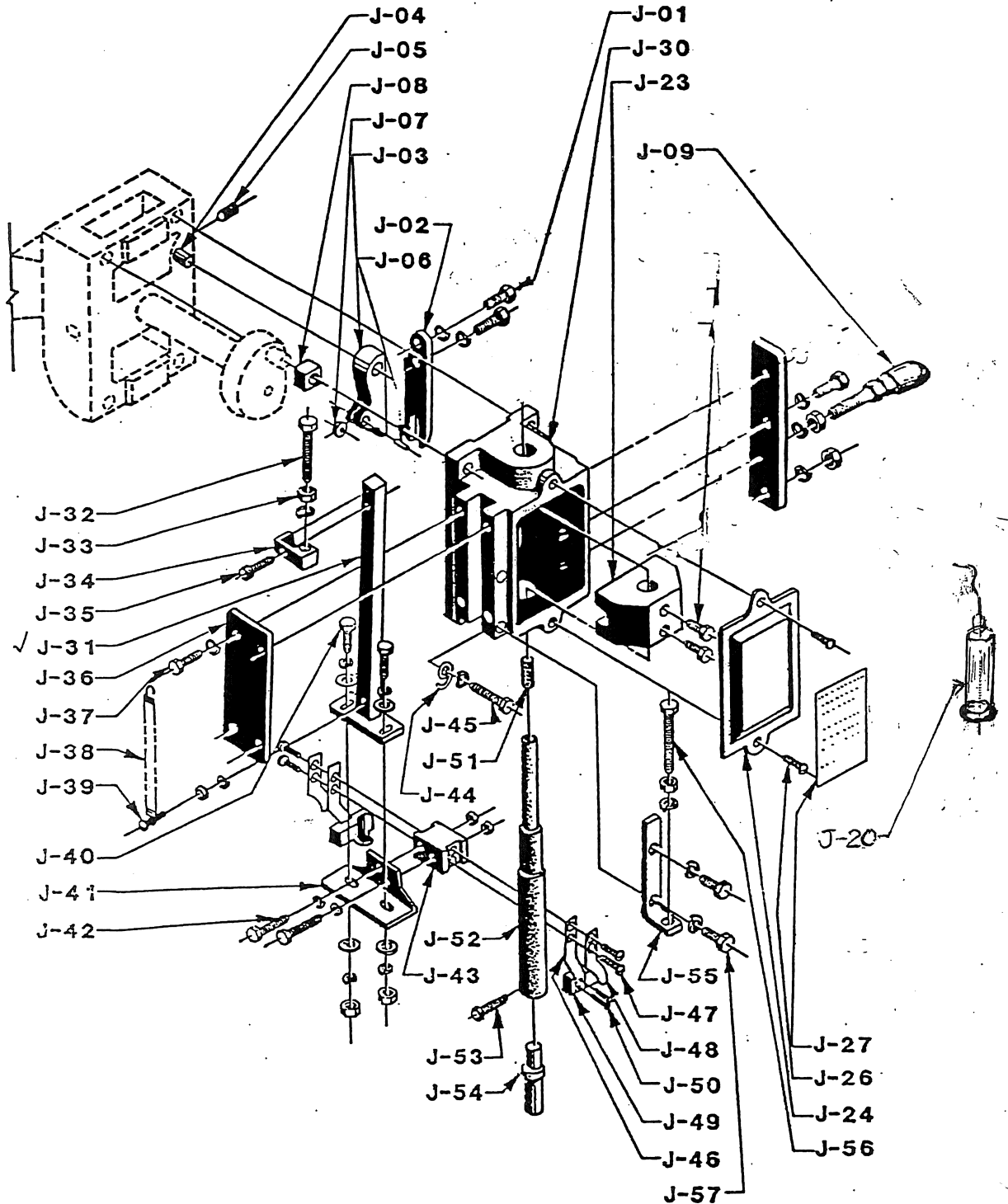


圖8 零件表

件號 Item No.	名稱 Description	數量 Qty	附記 Remarks
H-01	黃油杯GREASE CUP	1	
H-02	固定螺絲SOCKET CAP SCREW, OUT COLLAR	1	5/16"×1/2" l
H-03	固定環套OUTER COLLAR, FLYWHEEL	1	1 1/4"×1"×16"
H-04	飛輪FLYWHEEL	1	A-74
H-05	皮帶FLYWHEEL BELT	1	
H-06	飛輪離合卡梢INSERT, FLYWHEEL	2	
H-07	固定螺絲SCREW, CLUTCH CAM	2	3/8"×1" l
H-08	離合器CLUTCH CAM	1	
H-09	曲桿OUTRE RING FLANGE, CRANK	1	
H-10	離合梢CAM KEY, CLUTCH	1	
H-11	頂離合梢彈簧SPRING, CAM KEY	1	1.2"×10"×4.3"×38 l
H-12	離合梢止擋片COVER CAM KEY SPRING	1	
H-13	固定螺絲FIXED SCREW	2	1/4"×1/2" l
H-14	曲桿滑條連接梢心PIN SCEW, OUTER RING FLANGE	1	5/16"×2" l
H-15	固定螺絲SCREW, SQUARE ROD	1	5/16"×3/4" l
H-16	四角連桿SQUARE CONNECTING ROD	1	
H-17	固定螺絲THREADED PIN, SQUARE ROD	1	5/16"×1" l
H-18	螺帽NUT, THREADED PIN	1	5/16"



HEAD, COMPONENT CASE SYSTEM EXPLODED VIEW (FIG. 10)



RIGHT FEEDING SYSTEM EXPLODED VIEW

(FIG. 11)

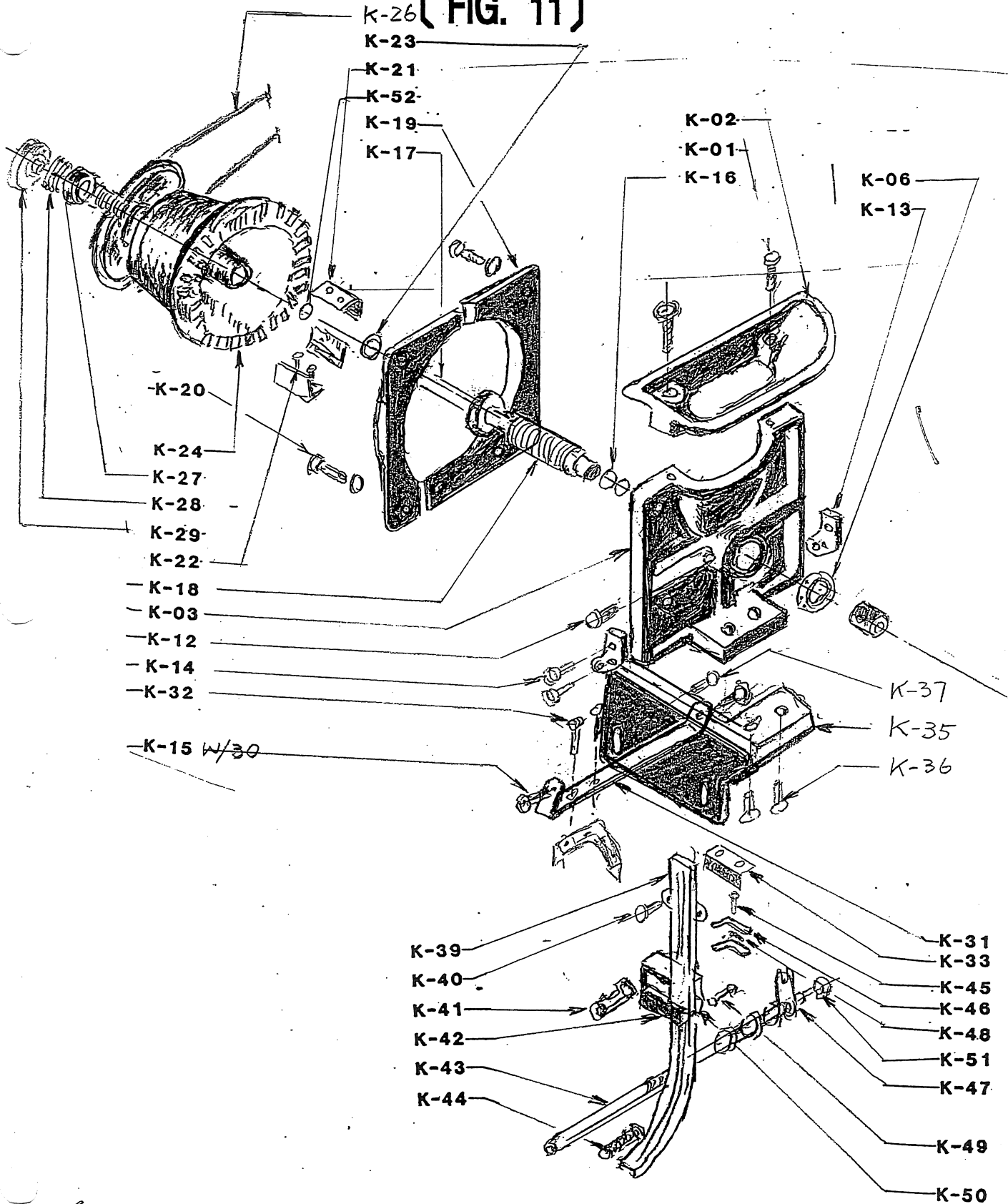


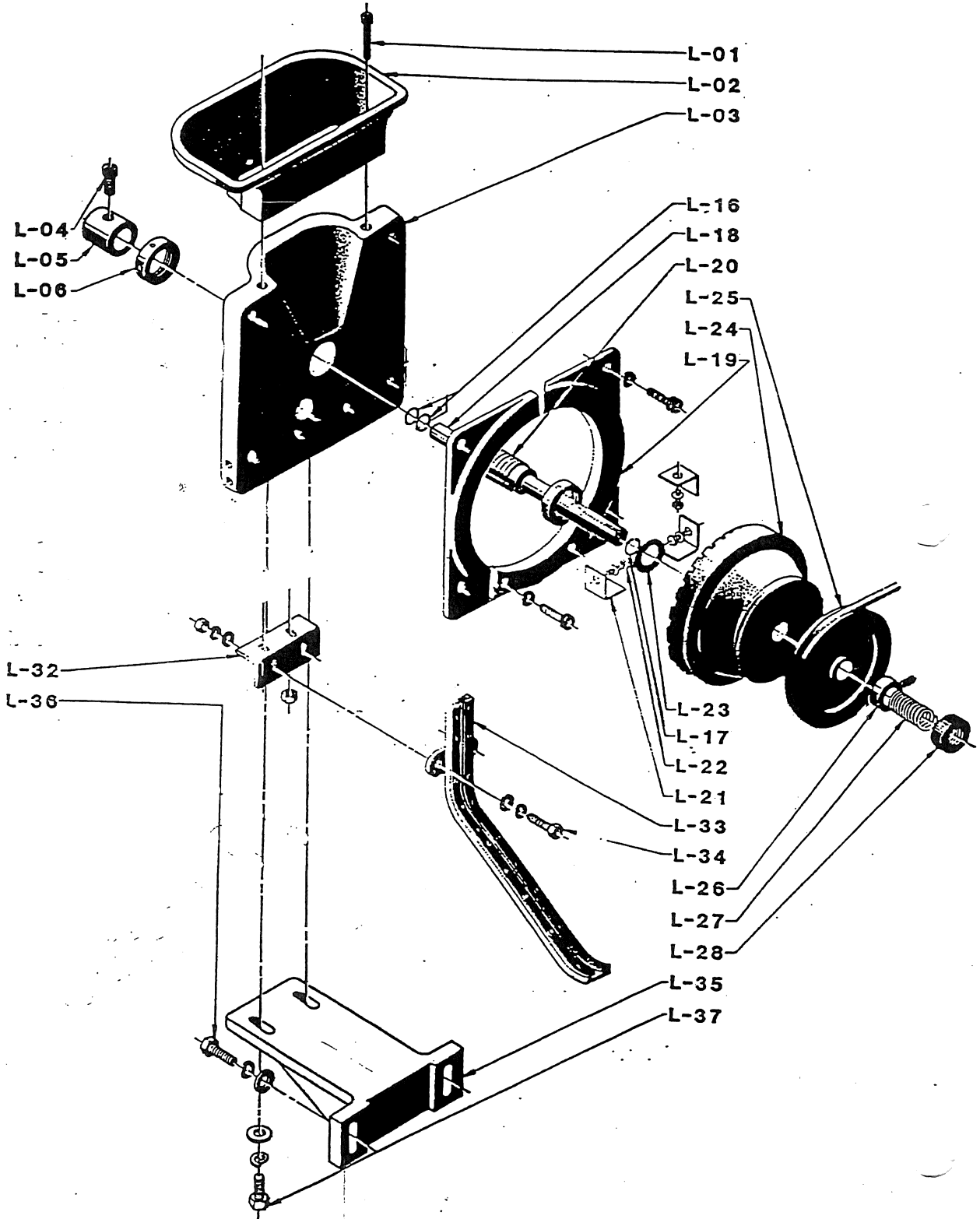


圖11 零件表

件號 Item No.	名 稱 Description	數量 Qty	附 記 Remarks
K-01	漏斗入口固定螺絲SOKET CAP SCREW, HOPPER	2	1/4"×1"ℓ
K-02	漏斗入口HOPPER	1	
K-03	四角板LOADING CHUTE PLATE 加裝培林	1	
K-05	螺帽NUT	6	
K-06	螺紋套固定螺母RING NUT, THREADED PIPE	2	
K-07	把手HANDLE KNOB	1	
K-08	清潔孔塞壓片CONNECTING PIECE, CLEANING PLUG	1	
K-09	清潔孔塞CLEANING PLUG	1	
K-10	SCREW	1	1/4"×1 1/4"ℓ
K-11	墊環RING	1	3/8"×7.0"×15'
K-12	固定螺絲FIXED SCREW	1	5/16"×1"ℓ
K-13	頂心板LEFT (RIGHT) EDGE SUPPORT	2	右左各一
K-14	頂心板固定螺絲SIDE SCREWS	4	1/4"×3/4"ℓ
K-15	頂心螺絲ADJUSTING SCREW, SUSPENSION BRACKET	2	
K-16	橡膠油封RUBBER SEAL	2	
K-17	選料齒輪心軸SPINDLE (LONG)	1	
K-18	螺紋套THREADED PIPE, SPINDLE 用培林	1	
K-19	四角環HOPPER CONE RING SHIELD	1	1組
K-20	固定螺絲FIXED SCREW	6	1/4"×1 1/4"ℓ
K-21	撥片STIRRERS	3	
K-22	SCREW, STIRRED PLATE	3	1/4"×3/8"ℓ
K-23	特殊墊片SPECIAL WASHER	1	
K-24	選料齒輪HOPPER CONE	1	視鈕釦而定
K-25	圓皮帶ROUND BELT	2	左右各一
K-26	皮帶輪PULLEY	1	
K-27	傳力圓套THREADED RING, SPINDLE	1	
K-28	彈簧COIL SPRING, SPINDLE	1	37ℓ×3.75"×9"
K-29	壓花螺母RING NUT, SPINDLE	1	
K-31	流道吊架SUSPENSION BRACKET, TRACK	1	
K-32	固定螺絲FIXED SCREW	2	1/4"×1"ℓ
K-33	直角接片TRACK HOLDER PLATE	1	
K-34	螺帽NUT	2	
K-35	支架BRACKET, LOADING CHUTE PLATE	1	
K-36	固定螺絲FIXED SCREW	2	
K-38	FIXED SCREW, LOADING CHUTE PLATE	2	3/8"×1 1/4"ℓ
K-39	流道組TRACK SECTIEN	1	
K-40	流道固定螺絲FIXED SCREW, TRACK SECTION	2	1/4"×1"ℓ
K-41	控制條CONTROL BLOCK, EXIT CONTROLLER	1	
K-42	流道控制架CAGE SEAT	1	
K-43	拍動心PATTING ROD	1	
K-44	流道拉簧TRACK SPRING	1	1"×11.5"×72ℓ
K-45	控制勾固定梢EXIT CONTROLLER PIN	1	
K-46	控制勾EXIT CONTROLLER PIECE	2	
K-47	拍動叉PATTING SPANNER PLATE	1	(短)
K-48	彈簧EXIT CONTROLLER SPRING	2	0.5"×1.5"×4.5"×18ℓ
K-49	固定螺絲FIXED SCREW	2	
K-50	蓋板EXIT CONTROLLER CAGE	1	
K-52	鋼環STEEL RING	1	



LEFT FEEDING SYSTEM EXPLODED VIEW (FIG. 12)



HIKER

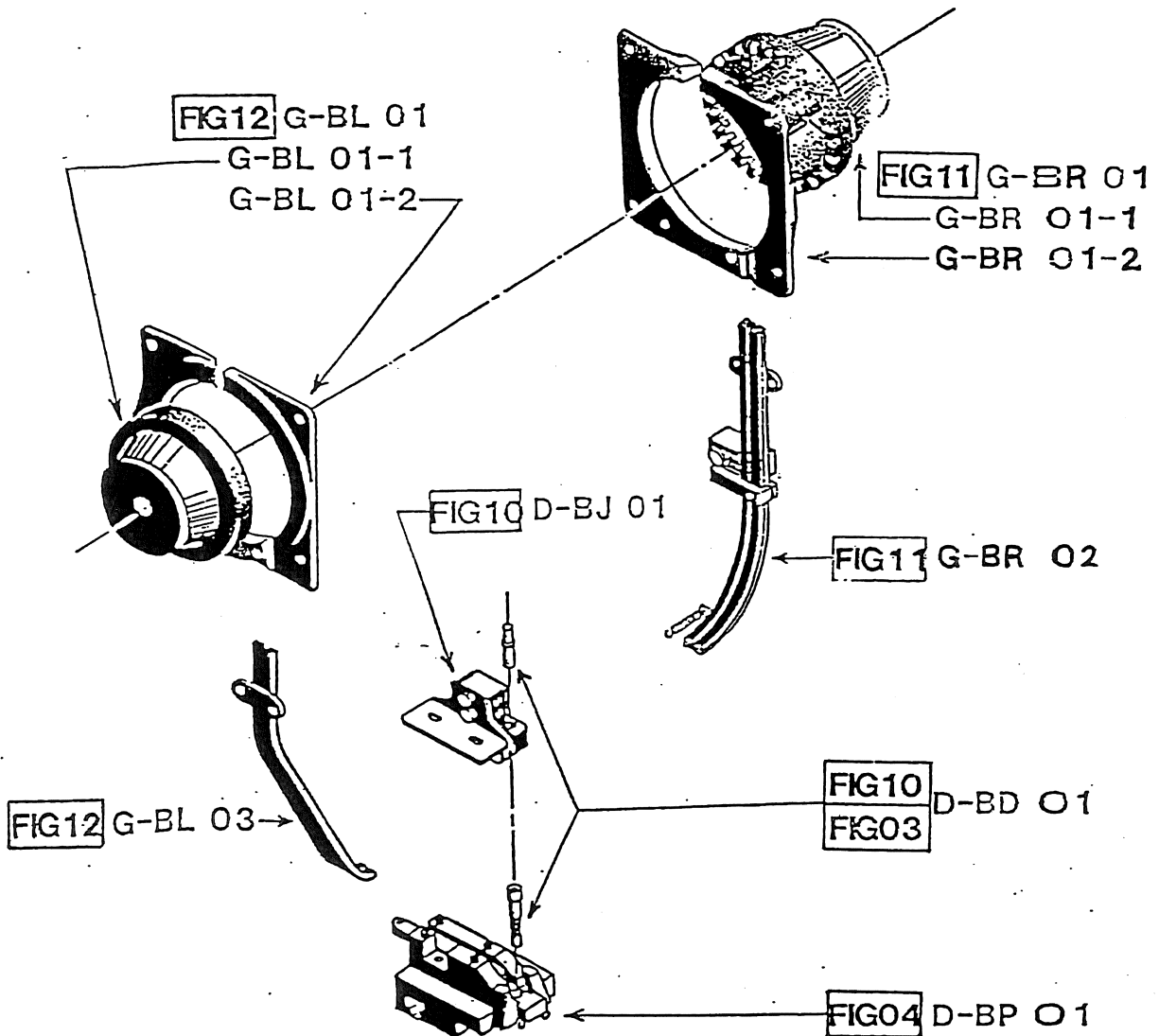
Figure 12 Parts List

ITEM NO	DESCRIPTION	QTY	REMARKS
L-01	SOCKET CAP SCREW, HOPPER	2	1/4" x 1" L
L-02	HOPPER	1	
L-03	LOADING CHUTE PLATE	1	
L-04	FIXED SCREW	1	5/16" x 3/4" L
L-05	RETAINING SLEEVE, SPINDLE	1	1 1/4" x 5/8" x 30L
L-06	RING NUT THREADED PIPE	2	
		4	1/4" x 3/4" L
L-16	RING LOCK	2	
L-17	RUBBER SEAL	1	
L-18	SPINDLE(SHORT)	1	
L-19	HOPPER CONE RING SHIELD	1	OR MODEL 100019
L-20	THREADED PIPE, SPINDLE	1	
L-21	STIRRERS	3	
L-22	SCREW STIRRERS	3	1/4" x 3/8" L
L-23	SPECIAL WASHER	1	
L-24	HOPPER CONE	1	depend on button size
L-25	PULLEY	1	
L-26	THREADED RING, SPINDLE	1	1 1/4" x 16" x 10L
L-27	COIL SPRING, SPINDLE	1	3.75" X 9" x 37 x 5
L-28	RING NUT SPINDLE	1	
		4	
		1	
		2	1/4" x 1"
L-32	TRACK Bracket	1	
L-33	TRACK SECTION	1	
L-34	TRACK PLATE	2	1/4" x 1"
L-35	BRACKET (LONG LOADING CHUTE PLATE)	1	
L-36	FIXED SCREW BRACKET	2	3/8" x 1 1/4" L
L-37	FIXED SCREW, LOADING-CHUTE-PLATE	2	3/8" x 1 1/4" L

GROUP PARTS LIST

請依照各式圖型及各式組件號碼，提供資料。

THE INDIVIDUAL GROUP PARTS OF HM-208B
BE SUPPLIED WITH YOUR PURCHASE ORDER


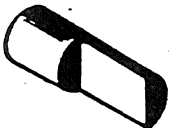
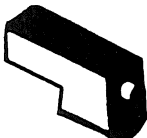
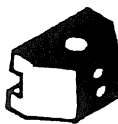
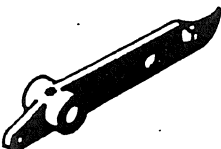




總成及總成零件更換零件表

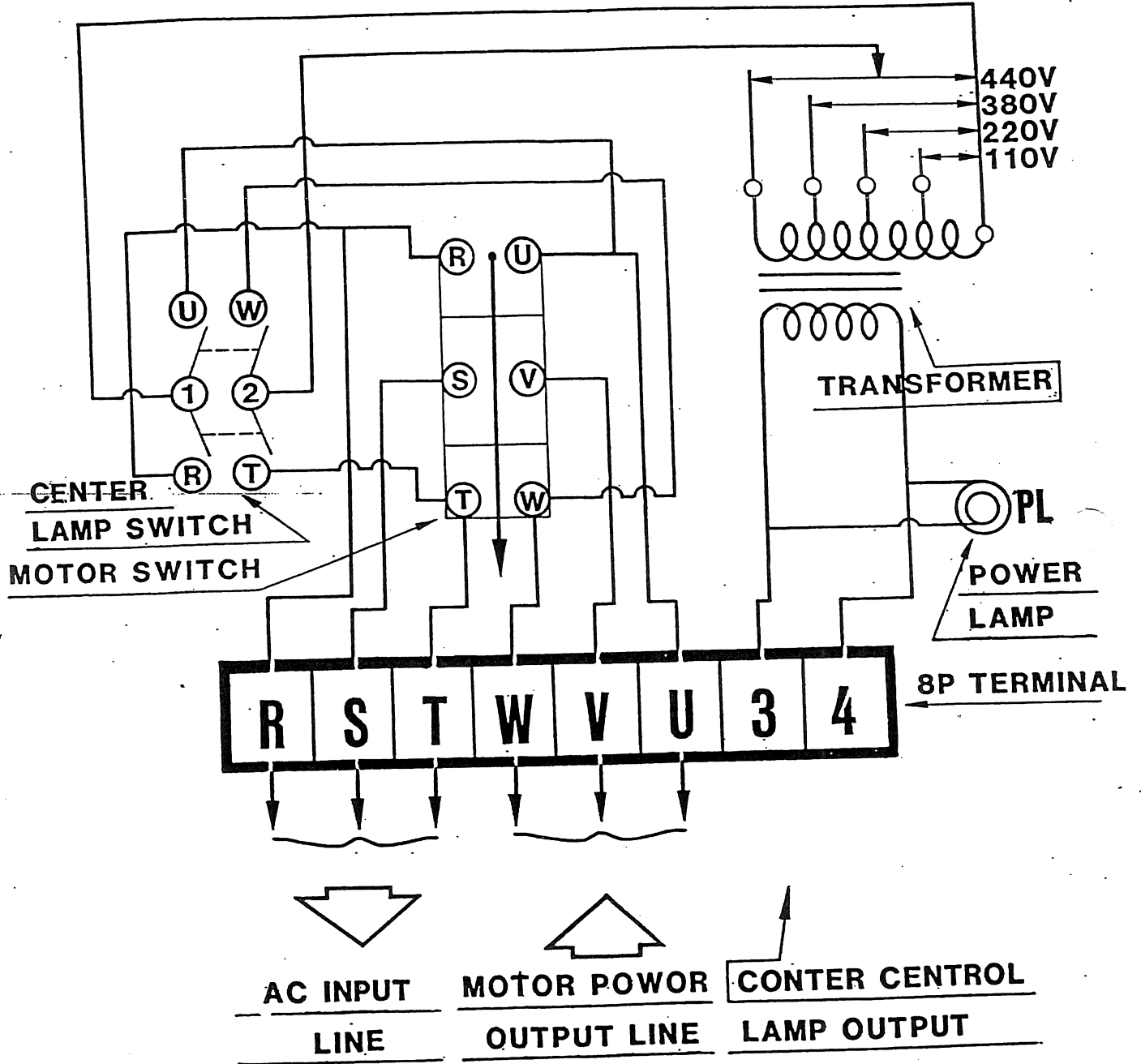
THE INDIVIDUAL GROUP PARTS OF HM-208B
BE SUPPLIED WITH YOUR PURCHASE ORDE

圖號 Fig No.	件號 Item NO.	名 稱 Description	備 註
4	D-BP 01	推槽總成PUSHER UNIT	<p>以上所有零件 可以更換，在訂購 之前你必須確認所 使用的釘型及號碼 ，同時我們需要您 寄上200個釘子以使 機械試用。</p> <p>ALL ITEMS OF THESE GROUP PARTS ARE REPLACEABLE.</p> <p>BEFORE ORDERING YOU HAVE TO BE DEFINITE THE KIND AND SOME SUITABLE TO THE FASTENERS LIGNE ARE BEING USED.</p> <p>MEANWHILE WE NEED YOUR BUTTONS ABOUT 200 PIECES ROF OUR MACHINE TRIALS.</p>
10, 3	D-BD 01	上下模DIES, UPPER & LOWER	
10	D-BJ 01	夾頭UPPER JAW SET	
11	G-BR 01	右選料齒輪總成HOPPER CONE SET	
11	G-BR 01-1	右選料齒輪HOPPER CONE	
11	G-BR 01-2	四角環RING SHIELD	
11	G-BR 02	流道TRACK SET	
12	G-BL 01	左選料齒輪總成HOPPER CONE SET	
12	G-BL 01-1	左選料齒輪HOPPER CONE	
12	G-BL 01-2	四角環RING SHIELD	
12	G-BL 03	流道TRACK SET	

正常損耗另件表
Normal Wornout Parts List

零件圖 Parts	件號 Item No.	數量 Qty	損耗 (工/時) Worn Out (W/Hr)	附 記 Remarks
	J-08	1	9000Hrs	<p style="text-align: center;">注意飛輪離 合器之定期保養</p> <p style="text-align: center;">WITH CARE OF THE FLYWHEEL, CLUTCH, AND SHAFT LUBRIC- ATING PERFORMANCE IN REGULAR MAINTENANCE.</p>
	H-06	2	3000Hrs	
	H-10	1	3000Hrs	
	J-23	1	3000Hrs	
	G-10	1	3000Hrs	
	J-54	1		
	C-01	1		

WIRE DIAGRAM



Aligning the Self Piercing Die

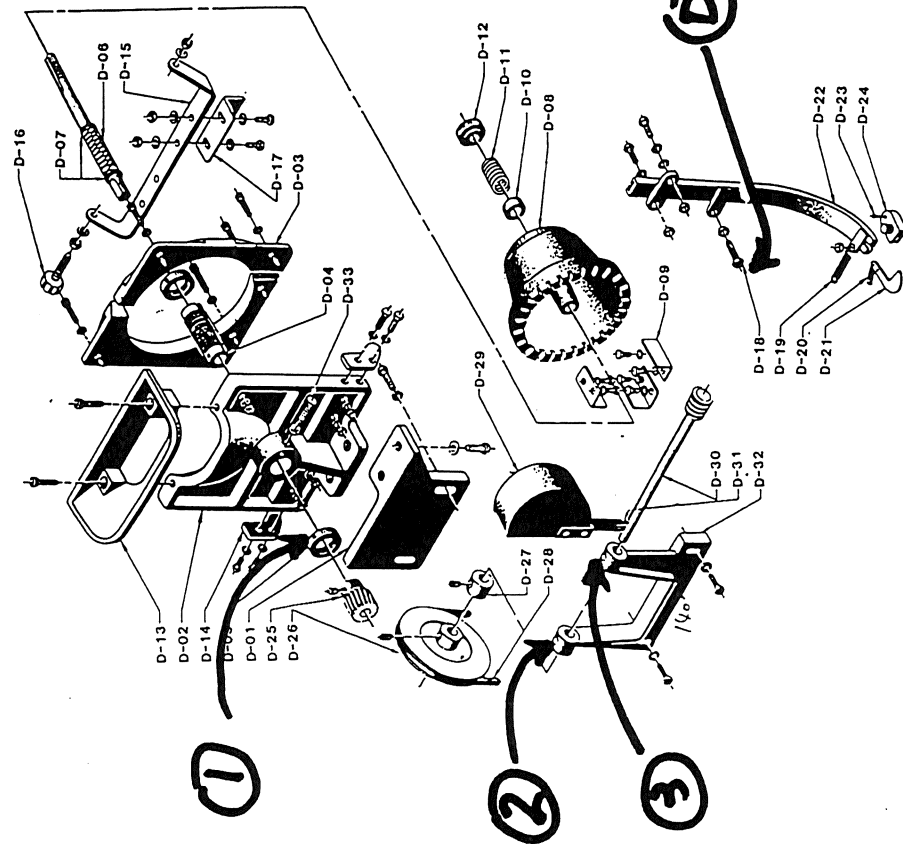
1. With the power DISCONNECTED and the Die Holder (E-15) in the OPEN position, install the Self Piercing Die in the machine holder. The bottom holding bolt should be finger tight.
2. Open flywheel access door located on the right side of the flywheel cover.
3. Engage the clutch with the foot pedal.
4. Move the flywheel down with your hand (clockwise) until the die closes.
5. Using your fingers, feel the die edges at the front & back, left & right. The bottom and top die edges should be flush with each other.
6. If the edges are not flush, use a mallet to tap the bottom dye into alignment.
7. Tighten the bottom holding bolt when the bottom and top die edges are flush.
8. Close the flywheel access door. The Self Piercing die is now aligned.

Oil and Grease Feeding Points



HOPPER COMPLETE SET EXPLODED VIEW

(FIG.5)



① ~ ⑤ add oil

Ⓐ ~ Ⓓ add grease



CLUTCH TRANSVER SHAFT EXPLODED VIEW

(FIG.6)

