

## Instruction on Joining Button Forms

### Introduction

With proper cutting and joining die, the Heavy Duty Large Grommet Press can be used to cut fabric for covering and join #24, #30, #36, #45, #60, #75 and #100 fabric button forms. The cutting operation is similar to that of cutting fabric for grommets. If you do not know how to use cutting die with the press, please refer to the instructions on the Heavy Duty Hand Press. This instruction is intended for using Button Form Joining Dies. We suggest testing with a few scraps of fabric on button forms before using customer's fabric.

1. **Take the Handle Extension off (see Figure 1). Because the force to join a button form is small, and using a long handle could damage the button forms.**
2. Lift the Moving Head up by turning the Handle fully counterclockwise. Loosen the Nylon Bolt on the Moving Head, and insert the Button Back Die completely into the Moving Head as shown in Figure 2. Tighten the Nylon Bolt by using a screw driver to hold the Button Back Die in place. Place the Shell Die on the press base.

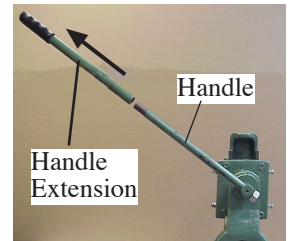


Figure 1. Press Handle

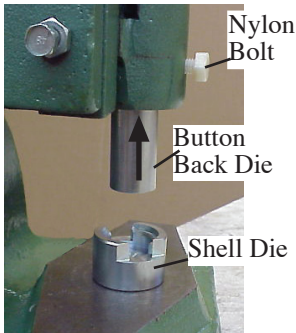


Figure 2. Install die

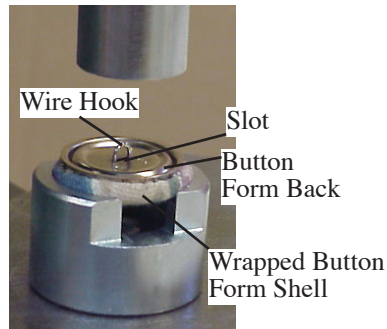


Figure 3. Lay button form

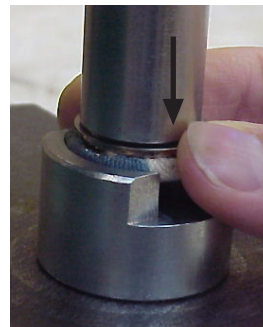


Figure 4. Lower back die



Figure 5. Join button form

3. Put the fabric wrapped Button Form Shell on the Shell Die and the Button Back on top of the Button Form Shell as shown in Figure 3. Make sure the Back is aligned with the Shell and the wire hook goes through the slot on center of the Back.
4. Use one hand to rotate the Handle clockwise to lower the Button Back Die while using the other hand to hold the Shell Die as shown in Figure 4. **Stop lowering the Button Back Die when it touches the Button Form Back. Align the Shell Die with the Button Back Die.**
5. Further rotate the handle clockwise a **small amount** to join the Button Form Shell and Back together (you can see it and feel more resistance). **It is important** not to lower the Back Die all the way down, which could over-crimp the Button Form Back. Small size button forms require very little force. Figure 5 shows a joined #45 fabric button form.