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HOW TO ADJUST A PAIR OF POCKETS

When the Pockets on a 489 Machine are out of alignment, the result will be a mis-feed of the eyelet. The mis-feed will result in the eyelet being spit out of the machine onto the floor. This occurs when the spindle in the Top Die does not go directly into the center of the eyelet. The pockets must be positioned so that when an eyelet is fed from the raceway it is correctly positioned in the pockets (figure 2). The following is the procedure to align the pockets correctly:



Figure 1

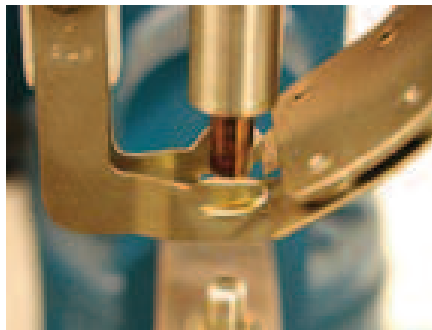


Figure 2



Figure 3

1. UNPLUG THE MACHINE BEFORE MAKING ANY ADJUSTMENTS. All adjustments should be made & checked with the machine being turned over by hand only.
2. The first thing that needs to be checked is the alignment of the raceway & top die. With the pockets off the machine, first check the raceway alignment as follows: When the top die is at its furthest point of travel down, it should be directly in the center of the rails. If it is not, loosen the raceway screws that hold it to the machine and adjust accordingly. Once the raceway is centered, attach the pockets to the pocket holder & attach it to the machine.
3. On the diagram above (figure 1) part A should be lined up just below the raceway about 1/32 to 1/16 of an inch gap.
4. In Figure 3, the two arms of the pockets should be in line with the two rails on the outside of the raceway. Part B above should NOT TOUCH the Raceway at all. It should be approx 1/16" from the tip of the raceway. If after lining up the pockets so the spindle fits inside of the eyelet correctly (see below) part B is touching the raceway, Part B will need to be ground down so the pockets can be brought closer in toward the raceway if necessary.
5. As the top Die comes down, it should split the two arms of the pockets equally - the spindle should go straight thru the center of the eyelet. When the eyelet is sitting in the pockets, the eyelet should be all the way against the inside edge of the pockets as in Figure 2. When top die comes down thru its cycle, the spindle inside the top die should pass directly thru the center of the eyelet. If it does not and hits the flange of the eyelet, it will usually toss the eyelet onto the floor. To correct this, you may have to shim the pocket holder to move it out away from the raceway or tap the holder with a hammer to bring it closer to the raceway. BE CAREFUL NOT TO BREAK THE POCKET HOLDER OR THE POCKETS THEMSELVES. Tap lightly. Call us if you need help: 800-393-5381.

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