



SISKA, INC
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MODEL J-231



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J-231 #AUTOMATIC#PNEUMATICMACHINE#FOR#PLACING#EYELETS.



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INTRODUCTION

AUTOMATIC PNEUMATIC MODEL J-231 MACHINE FOR PLACING EYELETS.

The function of this machine is the fixing of eyelets on footwear, leather goods, or on any other product or material which should require this application.

WARNINGS.-

- User unawareness of the machine leads, on many occasions, to elementary doubts about its workings.
- Please read this instruction manual carefully for your guidance, in order to obtain optimum performance from the machine.
- Please pay attention to these warnings, and express our thanks for your confidence in us on purchasing this machine.

SISKA INC. DISCLAIMS ALL RESPONSIBILITY DERIVING FROM
INCORRECT USE OF THIS INSTRUCT ON MANUAL OR FROM
ERRONEOUS TRANSLATION.

MACHINE IDENTIFICATION AND MARKINGS.-

The machine incorporates an aluminium plaque, attached with four rivets, indicating the following:

Name of manufacturer
Year of manufacture
Model and manufacturer's number
Power in kw
Maximum pressure in bars (pneumatic equipment)
EC mark
Weight

JOPEVI ® S.L.			
Elche Parque Industrial			
C/ Nicolas De Bussi, 32			
Tel.: 34-96 66510 08 - Fax: 34-96 665 10 03			
Modelo	<input type="text"/>	Nº	<input type="text"/>
Pot.Kw.	<input type="text"/>	Pres.Max.Bars.	<input type="text"/>
Año Fab.	<input type="text"/>	Peso	<input type="text"/>
		CE	

SERIAL Nº

PAGE

YEAR OF MANUFACTURE

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CHAPTER I

CHARACTERISTICS

1.1. MACHINE DESCRIPTION AND OPERATION.

AUTOMATIC PNEUMATIC MACHINE MODEL J-231 TO PLACE EYELETS ONE BY ONE.
(See figure 1)

The machine is composed by a metallic table with a wooden board over the head is placed:

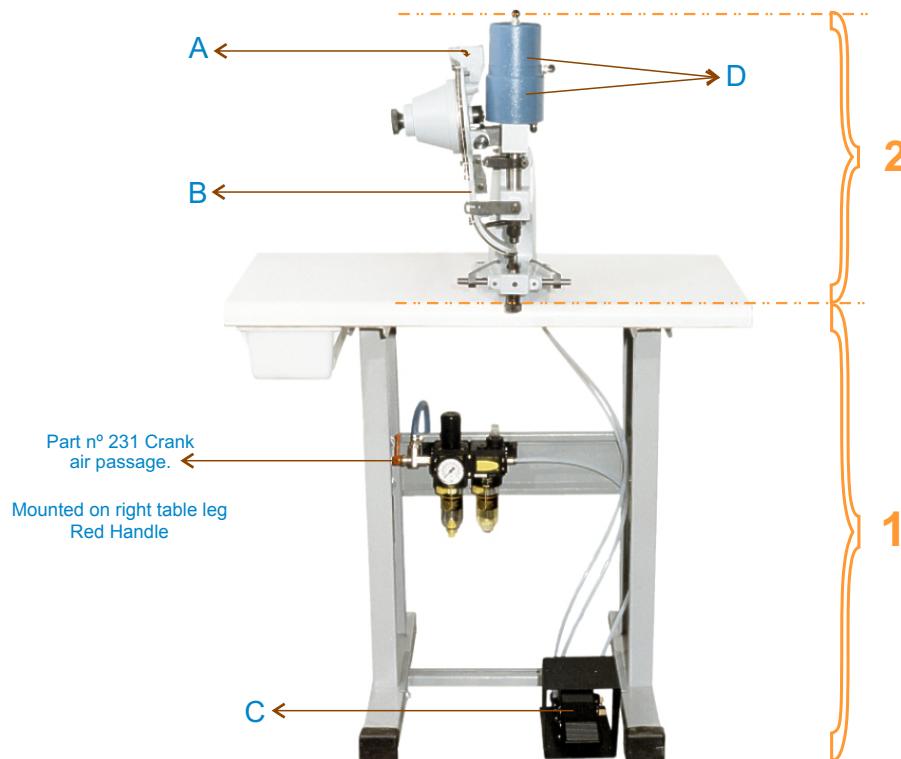
- 1) In the table is placed the pneumatic foot pedal, the air filter, the oil filter, the crank air passage (part n° 231), the manometer, etc.
- 2) The head is composed by a central base and a raceway.
 - In the base are situated the most of parts that permit the machine movements such as: pneumatic cylinders, axis, dies, etc.
 - Eyelets descend by the raceway.

After placing the machine in the definitive location and connect the air hose to the compressor opening, but not already open the crank air passage n° 231 to avoid the run of air, we will put the eyelets into the deposit "A" that descend by the raceway "B" and are stopped by a trigger that avoid the eyelets to fall.

We will open the air passage (part n° 231 crank air passage). Putting the foot pedal "C" the pneumatic cylinders "D" star working and make descend the vertical axis that come united in the bottom part to the punch n° 330 and the top die n° 328. This descending movement of the axis has the purpose that the punch n° 330 picks up the eyelet, located at the end of the raceway, and rivets it by the pressure made by the top die n° 328 against bottom die n° 329.

After this cycle, machine comes back to its first position ready to a new riveting when the foot pedal "C" was stepped.

FIGURE 1

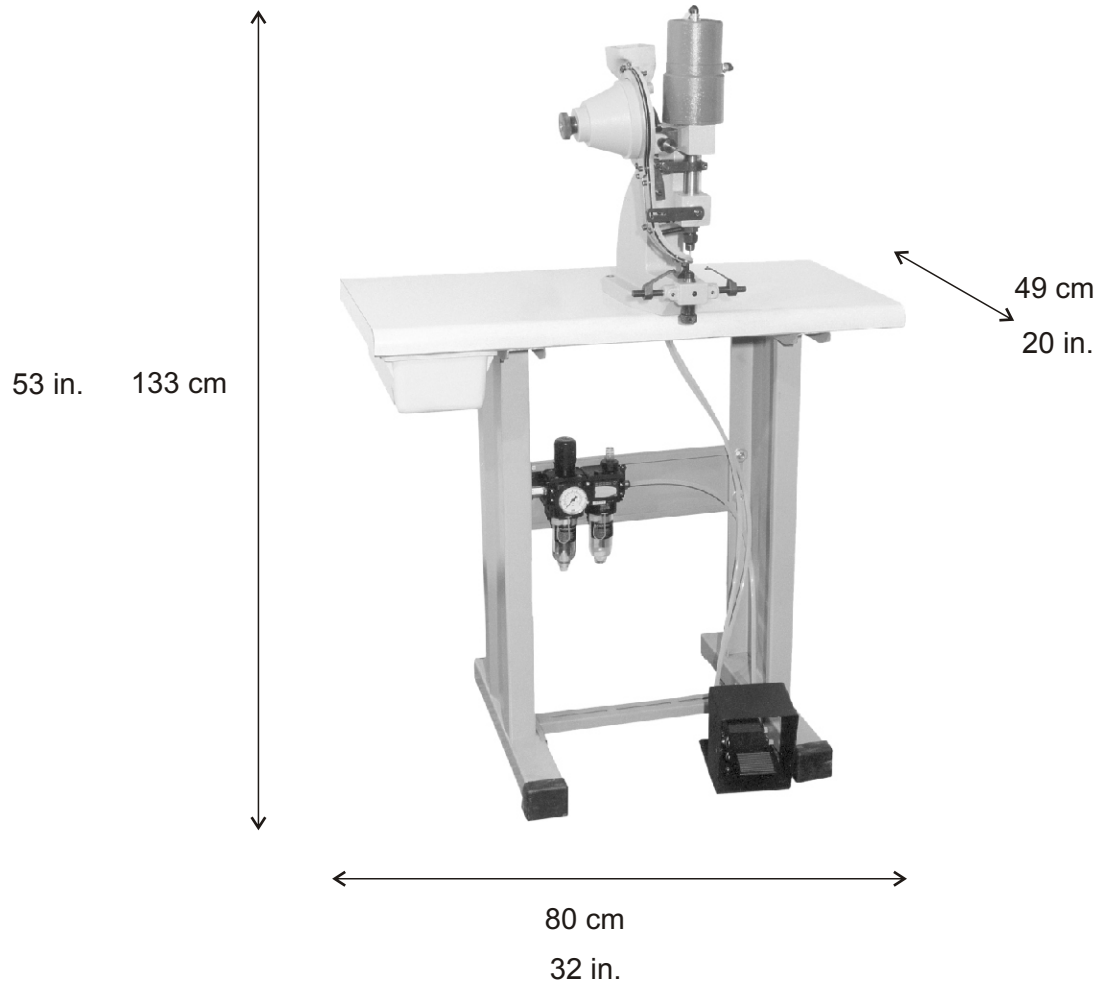


SERIAL N°

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1.2. TECHNICAL DATA.**DIMENSIONS.-**

DEPTH: 49 cm 20 in.
WIDTH: 80 cm 32 in.
HEIGHT: 133 cm 53 in.
WEIGHT: 57 Kg 126 lbs.

BARS (work pressure): 6 Bar. Around 88 PSI
ELECTRIC APPLIANCES: Laser pointer (optional).

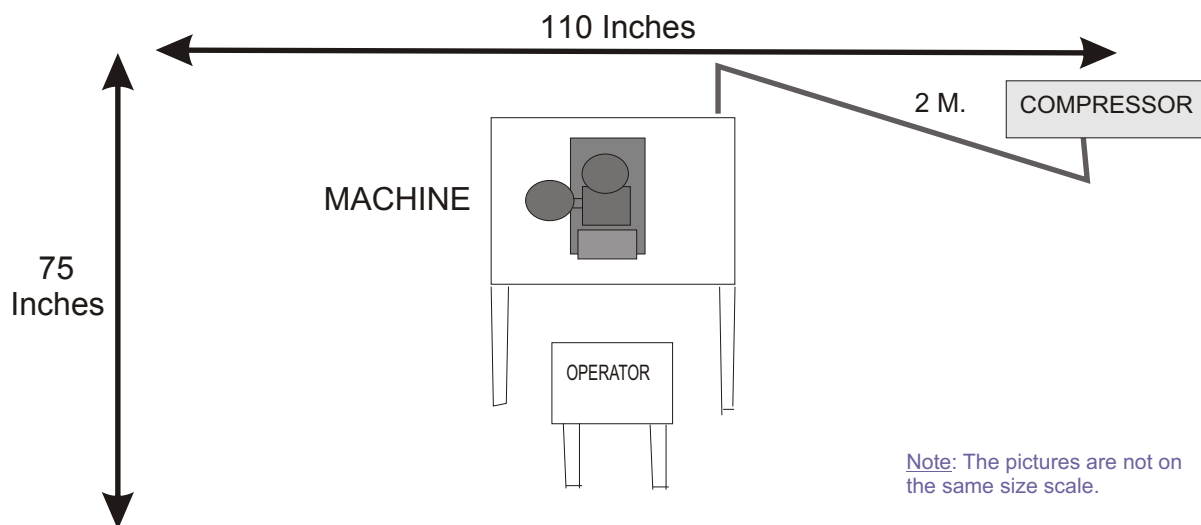
CHAPTER II**INSTALLATION****2.1. MINIMUM SPACE, ELECTRIC-PNEUMATIC INSTALLATION, POSITIONING THE MACHINE.**

As we indicate in the lower figure, the operator can work in a seated position. The minimum space recommended is 110 inches width 75 inches depth.

The machine model J-231 needs the pneumatic compressor to provide it with 6 atmospheres of pressure. 88-95 psi.

THE MACHINE COMES WITH A 2 METER LONG HOSE TO CONNECT TO THE COMPRESSOR.

WARNING: WE RECOMMEND NOT TO HAVE THE PNEUMATIC WIRE TOTALLY STRETCHED.

**2.2. MACHINE HANDLING.**

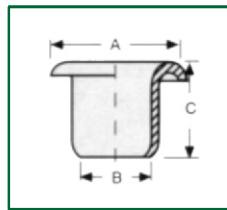
The transportation of this machine requires a series of operations. Some of these operations may imply dangerous situations so please follow the following advise:

- Never stand beneath the cargo.
- Always lift the cargo gently.
- Avoid balancing the cargo.
- No brisk movements.
- Do not place yourself in the cargo moving trajectory.
- Use the correct equipment to move cargos.
- Check this equipment periodically.

CHAPTER III**MACHINE USE****3.1. MACHINE DESCRIPTION.**

The automatic pneumatic model J-231 machine is designed for the fixing of eyelets, or the punching of holes in material, always one-by-one.

Each machine fixes a single eyelet model, or makes one type of hole. Eyelet models may differ in the size of the head "A", the length "C", the interior diameter of tube "B", thickness, etc.



EYELET

In order for the machine to fix different eyelet models, or to make different types of hole, certain parts need to be changed. SEE CHAPTER IV - ADJUSTMENTS.

JOPEVI, S.L. will accept no responsibility arising from the use of this machine in any way different from that which is described in this instruction manual.

3.2. PREPARATION OF MACHINE FOR USE.

**THESE ADJUSTMENTS MUST BE CARRIED OUT BEFORE
CONNECTING THE MACHINE TO THE POWER SUPPLY.**

Before start working for the first time, and each time when machine changes location or any adjustment or parts change is made, we recommend to follow the next instructions.

After placing and leveling the machine in its definitive location "**ALREADY NOT PLUGGED TO COMPRESSOR**", grease it with oil SAE 30 WT in the greasers and points marked in red. Give oil time to cover the parts, after, clean the oil excess.

Check the machine not to be blocked or have suffered a knock or break.

3.3. OTHER USES OF THE MACHINE.

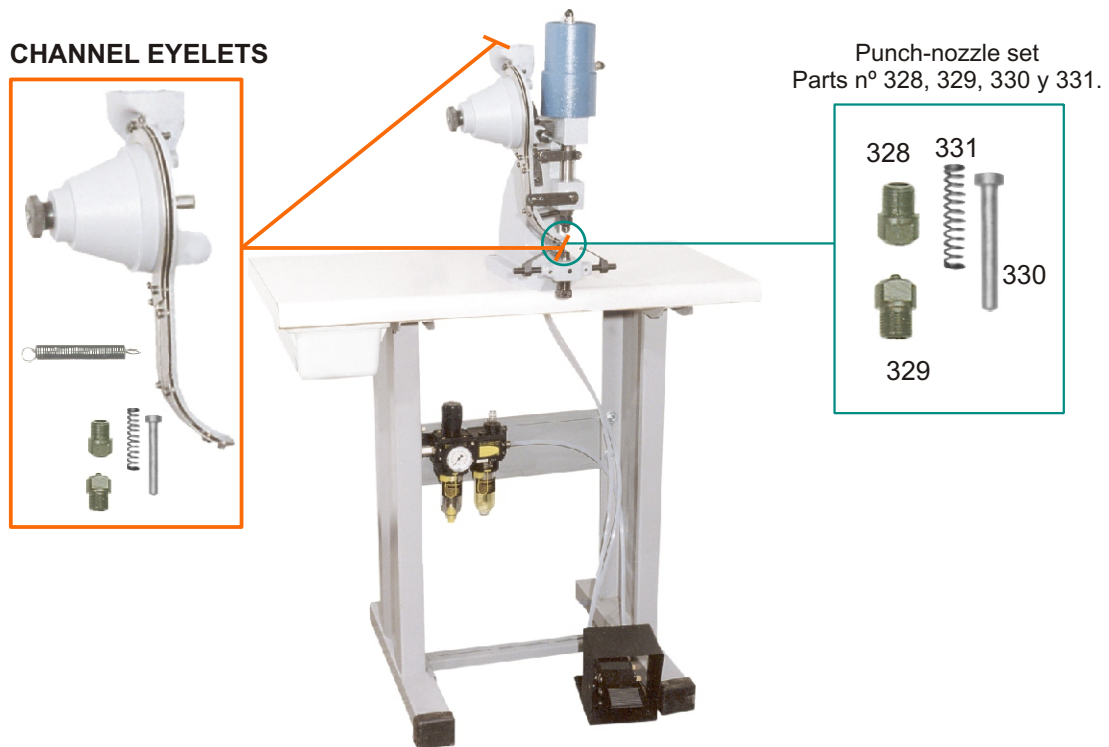
If it is to be used only to punch holes in the material without fixing eyelets, the rail must be removed and the eyelet dies (parts nº 328, 329, 330 and 331) must be replaced with other parts specific to this task. See Chapter IV - Adjustments - 4.3. Hole punching only, page 9.

THIS MACHINE MUST NOT BE USED FOR ANY FUNCTION OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY DESIGNED AND WHICH IS SPECIFIED IN THIS INSTRUCTION MANUAL: THE AUTOMATIC FIXING OF EYELETS, OR HOLE PUNCHING.

JOPEVI, S.L. DECLINES ALL RESPONSIBILITY ARISING FROM THE INCORRECT USE OF THIS MACHINE.

FIGURE 2

Note: The pictures are not on the same size scale.



CHAPTER IV

ADJUSTMENTS

DISCONNECT FROM THE POWER SUPPLY BEFORE CHANGING THE EYELET MODEL, PUNCHIN HOLES, ADJUSTING THE PRESSURE, INSTALLING OPTIONAL ACCESORIES OR ANY OTHER MANIPULATION.

For a correct work of the machine, it has to be adjusted for each material type and eyelet, and the riveting parts (dies and punch) must be in good condition.

The parts to replace for the normal use of the machine are the bottom die n° 329 and the punch n° 330. We will notice that they must be replaced when the machine does not cut, and/or the eyelets are not properly riveted. We recommend always to have available a supply of the spare parts.

In order to carry out any of these adjustments, if any part designed for workers safety, such the transparent methacrylate cover or the safety ring, should be removed, be sure to subsequently replace and screw firmly in place.

4.1. CHANGE OF EYELET MODEL.

Each J-231 machine fixes one model of eyelet, although other eyelet dimensions may be fixed by replacing the corresponding parts. This change is quick and simple.

To fix a different eyelet model is needed a whole new raceway with the appropriate size of punch and dies set (see figure 2 page 7).

With the machine disconnected from the compressor (and the power supply if there are electric devices):

- Remove spring n° 134M from screw n° 94,
- Remove the bolt for the raceway n° 79 by loosening the allen acrew which holds it,
- Remove the raceway very carefully and place it again,
- Fix it again with the bolt for the raceway n° 79 tightening the allen screw,
- Place spring n° 134M on screw n° 94,
- Unscrew the bottom die n° 329 and the top die n° 328, with this one punch n° 330 and spring n° 331 will come away,
- Put the set of dies parts n° 328, 329, 330 y 331 corresponding to the new raceway,
- Adjust pressure. (See 4.2. Pressure and riveting adjustments, dies replacement).

4.2. PRESSURE AND RIVETING ADJUSTMENTS, DIES REPLACEMENT.

The model J-231 can be adjusted to set eyelets in different types of material and different thicknesses.

Each time that dies or raceway would be changed, or it is going to be used a different material where placing the eyelets, it will be necessary to adjust the machine for a correct performance.

The model J-231 has two vertical shafts:

n° 113 "Central axis" to adjust cutting pressure (to make the hole in the material), and

n° 114 "Nozzle axis" to adjust riveting pressure (to set eyelet in the material with more or less strength).

CAUTION: To adjust the machine pressure, is need to connect the air hose to the compressor and keep the air passage n° 231 opened. Have the most care and caution doing these adjustments, checking that hands and fingers are out the riveting zone, and the worker or no one could step the foot pedal, avoiding machine stars working and trapping hands or fingers.

Adjusting cutting pressure (makes the hole in the material), put up or down the bottom die n° 329 so that, when the machine is at work and stepping the foot pedal, the punch n° 330 grazes minimally with the top part of bottom die n° 329. This graze must be minimum, as both parts could broke with more contact. To turn the bottom die n° 329 in one sense or the other, we will use the bottom die holder n° 98 until to reach the optimum height of the bottom die n° 329,

An easy way to know if the cutting pressure is correct, is placing a paper sheet between the bottom die n° 329 and punches n° 330 and making a hole.

Adjusting the riveting pressure, unscrew a bit nut 118 and turn the top die holder n° 117 (in sense 117) in one sense or the other depending if we want to put up or down the top die n° 328. The higher positions of top die n° 328, the less riveting pressure. We could get the ideal pressure stepping the foot pedal and adjusting the machine so that the distance that remains between the lower point of top die n° 328 and the bottom die n° 329 will be the thickness of the material to use.

Machine is produced and goes out from our facilities ready to work with the sample eyelet and material received with the order.

Once both pressures are adjusted, check that all screws and nuts are fastened and tightened.

4.3. HOLE PUNCHING ONLY.

If only hole punching is required, a specific set of dies must be placed (parts n° 328, 329, 330 and 331), and make the following adjustments:

With the machine disconnected from the compressor (and the power supply if the are electric devices):

- Remove the eyelet rail and block it with the raceway bracket n° 89 or placing a small bar between the rail and the body n° 50.
- Place the set of dies to make holes and adjust pressure (see page 8 point 4.1 and point 4.2).

4.4. OPTIONAL ACCESORIES.

An optical laser pointer may be incorporated for specific functions of the machine, providing a point of red light that allows greater precision in the fixing of eyelets and the punching of holes.

The power of this laser is very low, however may be dangerous.

NEVER LIGHT UP DIRECTLY TO THE EYES, AS THIS MAY BE HARMFUL. KEEP OUT OF REACH OF CHILDREN.

Part n° 155 Laser pointer
(optional)



CHAPTER V

MAINTENANCE

5.1. MECHANICAL PART OF THE MACHINE.

For optimum performance, it is recommended that certain parts of the machine be kept clean and lubricated. Cleaning of the machine must always be carried out with machine disconnected.

The pedal which is depressed to action the machine must be clean and free from obstacles which may hinder or jam its normal movement.

The machine housing should be cleaned with a cloth which does not leave fibres stuck to the casing.

The rail via which the eyelets drop must "always" be kept clean and free from any imperfections which may impede the free movement of the eyelets. Do NOT Lubricate the Raceway.

The machine head has lubrication points and other points marked in red to indicate where it should be lubricated. This should be done with a hand-held oil can, using type SAE 30 weight oil.

During the first month of use this should be carried out twice a week. After the first month, however, it will only be necessary to lubricate once a week.

When the machine is to be out of use for prolonged periods, it should be given an overall cleaning, lubricating the appropriate points, disconnecting from the power supply, and covering the machine to protect it from damp and dust.

5.2. PNEUMATIC PART OF THE MACHINE.

Air filter is automatic and does not need maintenance.

Add oil type "SAE 10" to the oil filter before remaining empty. (Air Tool Oil Parker F442 or Equivalent)

5.3. ELECTRIC PART OF THE MACHINE.

In case of having an optic laser pointer n° 155 (optional), it does not need cleaning or maintenance.

Remember nor point to the eyes, nor let it a children reach.

Part n° 155 Laser pointer
(optional)



CHAPTER VI

TROUBLE SHOOTING

<u>TROUBLE</u>	<u>CAUSE</u>	<u>SOLUTION</u>
THE MACHINE DOES NOT WORK WHEN PRESSING THE PEDAL.	Check that the machine is connected to air compressor.	Connect.
	Check if Crank air passage nº 231 is opened.	Open the air passage.
	Check that the machine is connected to the compressor with a pressure of 6 atmospheres.	
DEFECTIVE RIVETING OF LOWER PART OF EYELET.	The bottom die nº 329 is worn out or broken.	Replace.
	Pressure adujstment incorrect.	See Chapter IV- Adjustments. Point 4.1 and 4.2 pages 8 - 9.
NOT CUTTING OR LEAVING SCRAPS OF MATERIAL.	The bottom die nº 329 or punch nº 330, is worn out or broken.	Replace.
	Cuttting pressure adjustment incorrect.	See Chapter IV - Adjustments. Point 4.1 and 4.2 pages 8 - 9.
JAMMED MACHINE.	Bottom die nº 329 and punch nº 330 are worn.	Replace. See Chapter IV - Adjustments. Point 4.1 and 4.2 pages 8 - 9.
	Adjustment of cutting pressure is correct.	See Chapter IV - Adjustments. Point 4.1 and 4.2 pages 8 - 9.

<u>TROUBLE</u>	<u>CAUSE</u>	<u>SOLUTION</u>
FAULTY PICK-UP OF EYELET FROM CHANNEL.	Part n° 75 raceway finger or cut off and part n° 75m spring, are broken or worn away.	Replace.
	Raceway guides n° 73 and n° 74 are worn away or twisted, and the eyelet cannot be placed at the extreme.	Lift the bottom extreme of raceway guides n° 73 and n° 74 until remain at the height of raceway finger cut off n° 75, or replace by new guides.
	The punch n° 330 is worn.	Replace. See Chapter IV - Adjustments. Point 4.1 and 4.2 pages 8 - 9.
NOT ENOUGH STRENGTH OF RIVETING	Air loss by the joints.	Replace. Call SSKA directly.

Difficulties may generally arise from the incorrect use of the machine by personnel not properly trained, who are liable to alter and upset essential mechanisms.

FOR ANY MATTER NOT COVERED IN THIS MANUAL, CALL SSKA DIRECTLY
800-393-5381

CHAPTER VII

SAFETY

*As we have indicated throughout this manual, the model J-231 machine incorporates a series of features which prevent the worker from manipulating or gaining access to parts of the machine where he/she may be vulnerable to accidents. **DO NOT REMOVE THESE FEATURES.***

*The most hazardous part of the machine is the riveting area “**C**”, where there the operator’s fingers or hands could be vulnerable to accidents.*

In order to avoid such occurrences, a series of features have been installed:

FIGURE 4

Note: Part nº 163 Transparent methacrylate protection cover and part nº 165 Security ring, does not appear at the picture (figure 4).

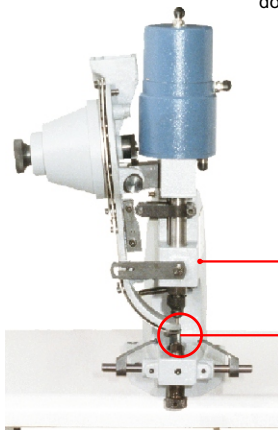


FIGURE 5



FIGURE 6



Note: The pictures are not on the same size scale.

*In figure 4, at point “**C**”, we indicate the area which is considered to be the most dangerous for the operator. This area is protected by means of a transparent methacrylate shield (part nº 163) which facilitates vision, but prevents the insertion of fingers.*

Also incorporated is the safety ring nº 165 as illustrated in figure 6, which restricts the insertion on fingers in the riveting area.

All these features are firmly held in place with screws which prevent their detachment.

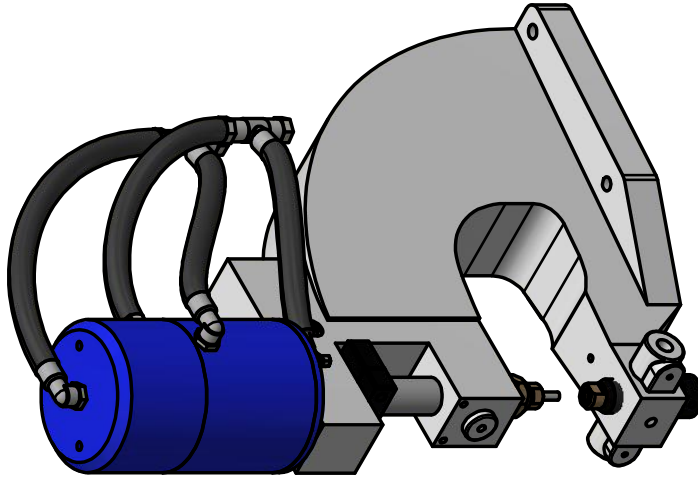
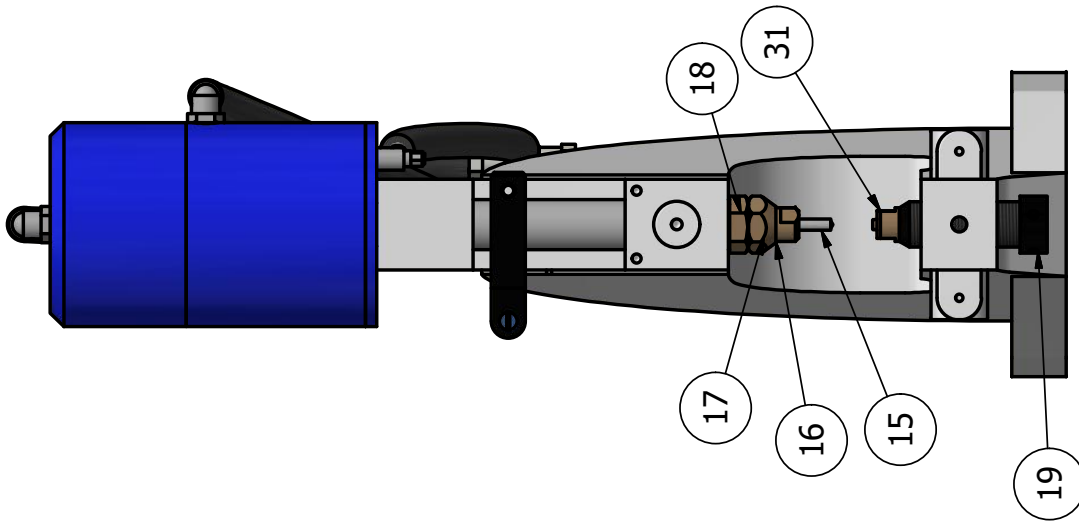
All potentially hazardous areas are indicated by a symbol or specific instructions.

*The sticker illustrated in figure 5 warns that the riveting area “**C**” is a potentially hazardous point, the manipulation of which requires the machine to be disconnected from the power supply.*

All mechanical and electrical sections of the machine are held closed with screws.

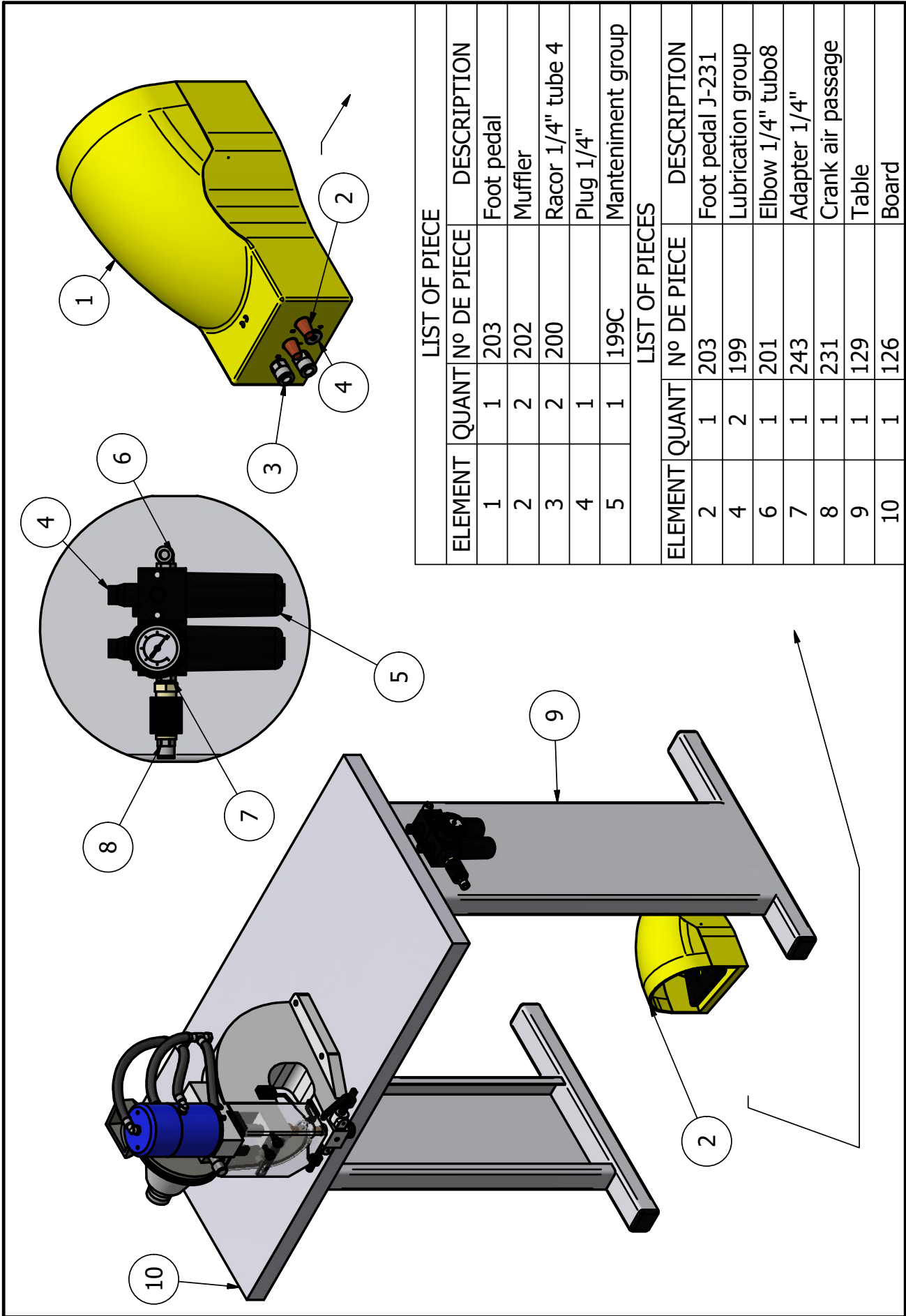
We reiterate that any manipulation of the machine requires the machine to be disconnected from the power supply.

For whatever problem which may occur and which may not be readily solved, remember to contact the authorized distributor of the machine, or contact the manufacturers directly.



LIST OF PIECES

ELEMENT	QUANT	Nº DE PIECE	DESCRIPTION
15	1	330	Punch
16	2	328	Top die
17	1	117	Top holder-die
18	1	118	Nut for top die holder
19	1	98	Bottom holder-die
31	1	329	Bottom die

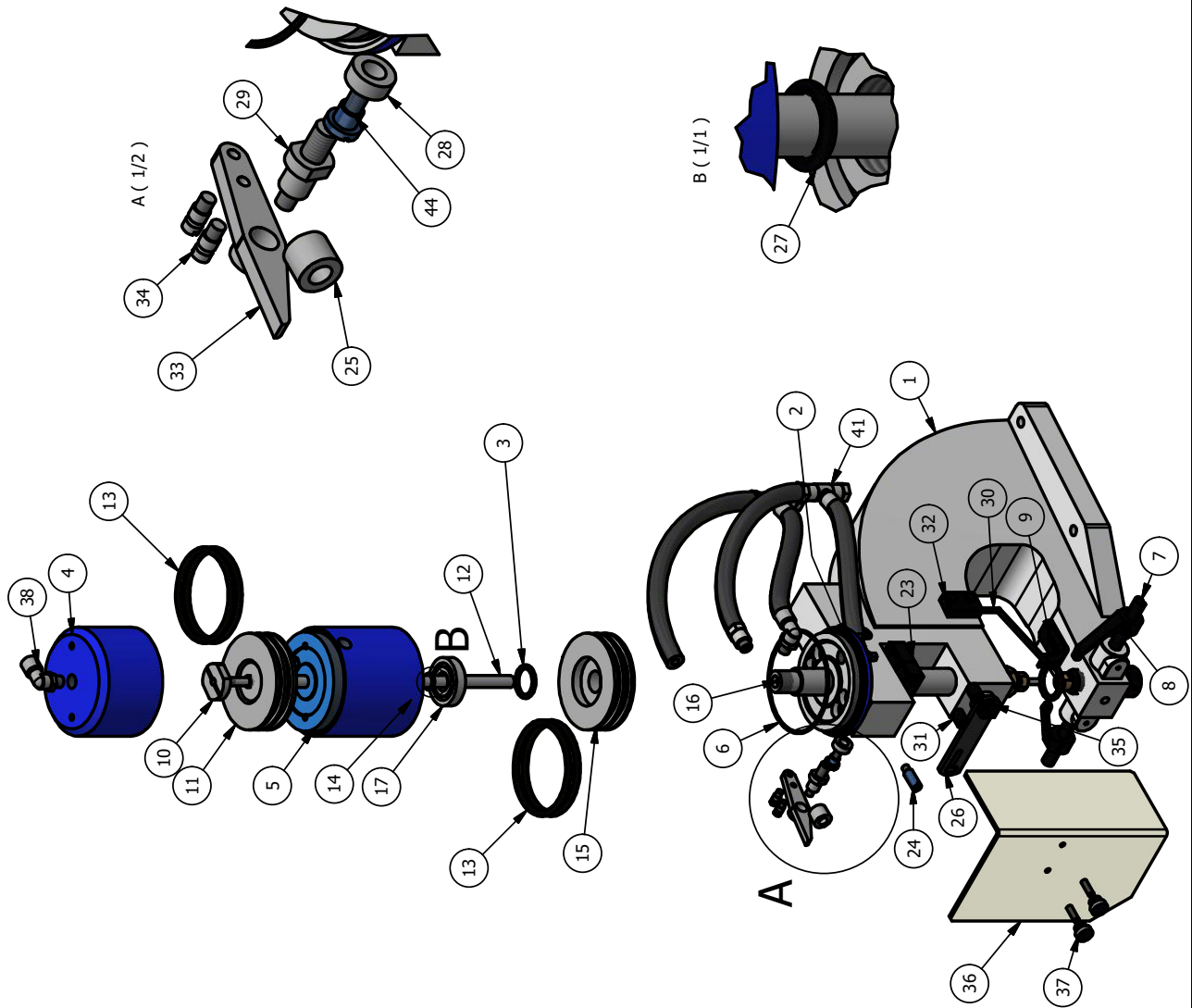


LIST OF PICEE

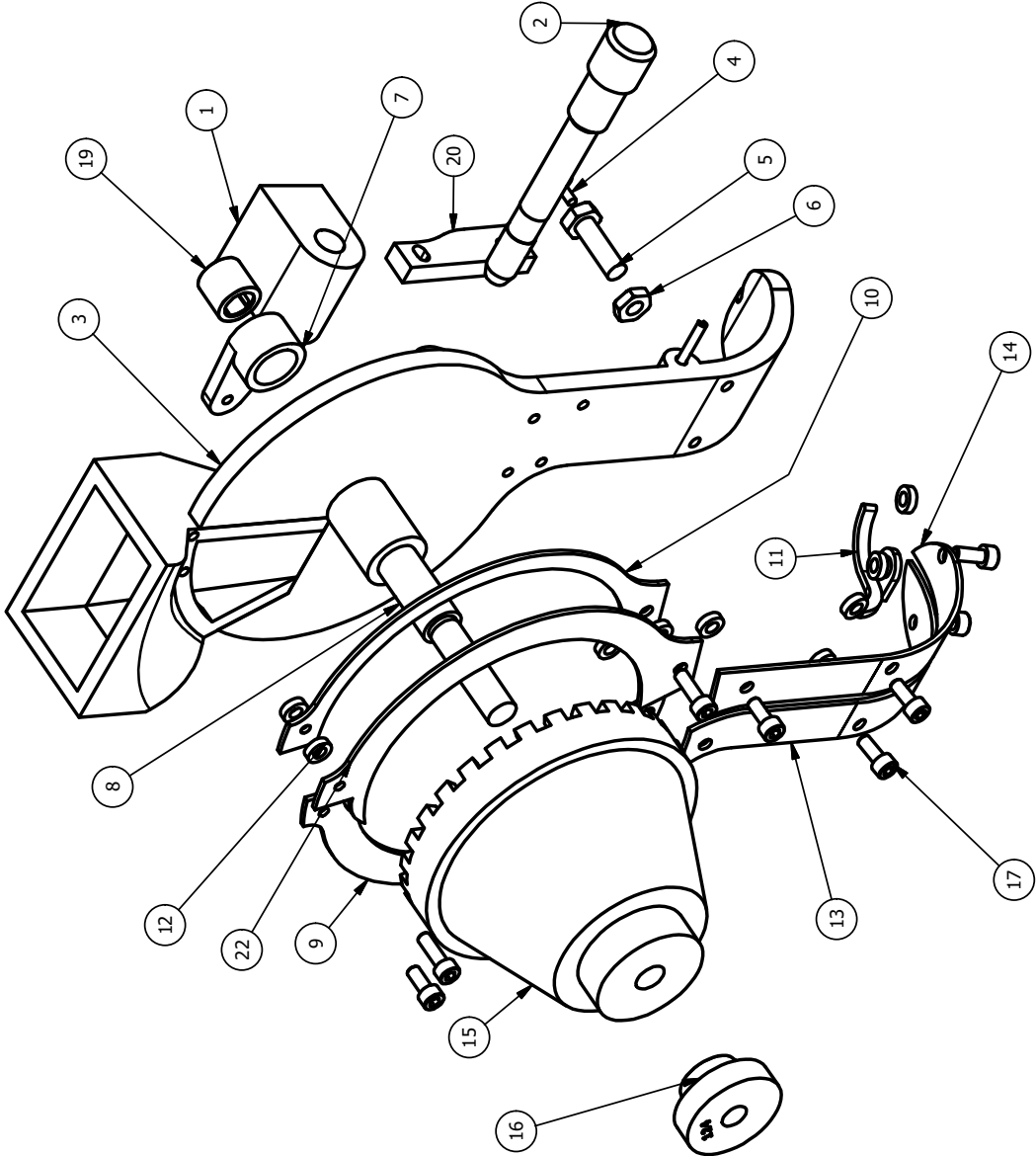
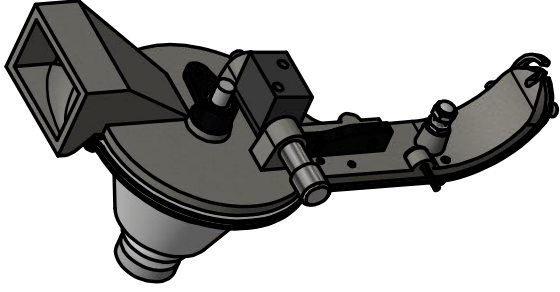
ELEMENT	QUANT	N° DE PICEE	DESCRIPTION
1	1	203	Foot pedal
2	2	202	Muffler
3	2	200	Racor 1/4" tube 4
4	1		Plug 1/4"
5	1	199C	Manteniment group

LIST OF PICES

ELEMENT	QUANT	N° DE PICEE	DESCRIPTION
2	1	203	Foot pedal J-231
4	2	199	Lubrication group
6	1	201	Elbow 1/4" tubo8
7	1	243	Adapter 1/4"
8	1	231	Crank air passage
9	1	129	Table
10	1	126	Board



LIST DE PIECES			
ELEMENT	QUANT	N° DE PIECE	DESCRIPTION
1	1	50	Body
2	1	107	Flat part of the cylinder
3	1	102	Inside joint of piece n° 107
4	1	111	Top of the cylinder
5	1	108	Round part of the cylinder
6	1	63	Outside joint of the piece n° 107
7	2	101	Sideways shafts guides
8	2	100	Sideways guides
9	1	99	Back-stop of material
10	1	115	Nut of central shaft
11	1	112	Small piston
12	1	113	Central axis
13	4	66	Joints of piston
14	1	132	Joint of die shafts stop
15	1	64	Piston
16	1	114	Nozzle axis
17	1	116	Nut of dies shaft
23	1	130	Plunge collar
24	1	109	Roller bolt
25	1	110	Roller displace raceway
26	1	89	Raceway bracket
27	2	131	Joint of the central shaft
28	1	139	Drag bearing
29	1	88	Bolt for the slide rocker
30	1	165	Security ring
31	2	Sep_Protector	Displace protector
32	1	165H	Support of security ring
33	1	87	Slide rocker
34	2	78	Short coupling
35	1	103	Screw for piece n° 89
36	1	163	Methacrylate protector
37	2	168	Screw support protector
38	2	200	Elbow 1/4 tubo8
41	2		"T" tube 8
44	1	224	Screw support piece n°86 y n°139



LIST DE PIÈCES			
ELEMENT	QUANT	N° DE PIÈCES	DESCRIPTION
1	1	68	Raceway bearing
2	1	79	Bolt for raceway
3	2	69	Raceway support
4	1	151-3	Nylon stop
5	1	t217	Screw Stop
6	1	151-2	Nut stop
7	1	84	Ratchet drag
8	1	80	Raceway shaft
9	1	128	Raceway guide
10	2	71	Raceway guide
11	1	75	Raceway finger cut off
12	10		Washers guides
13	1	73	Raceway guide
14	1	74	Raceway guide
15	1	122	Deposit of eyelets
16	1	124	Nut support deposit of eyelets
17	8	M5 x 12	Srew
18	2	M5 x 16	Srew
19	1	85	Bearing
20	1	77	Piece displace raceway
22	1	72	Raceway guide

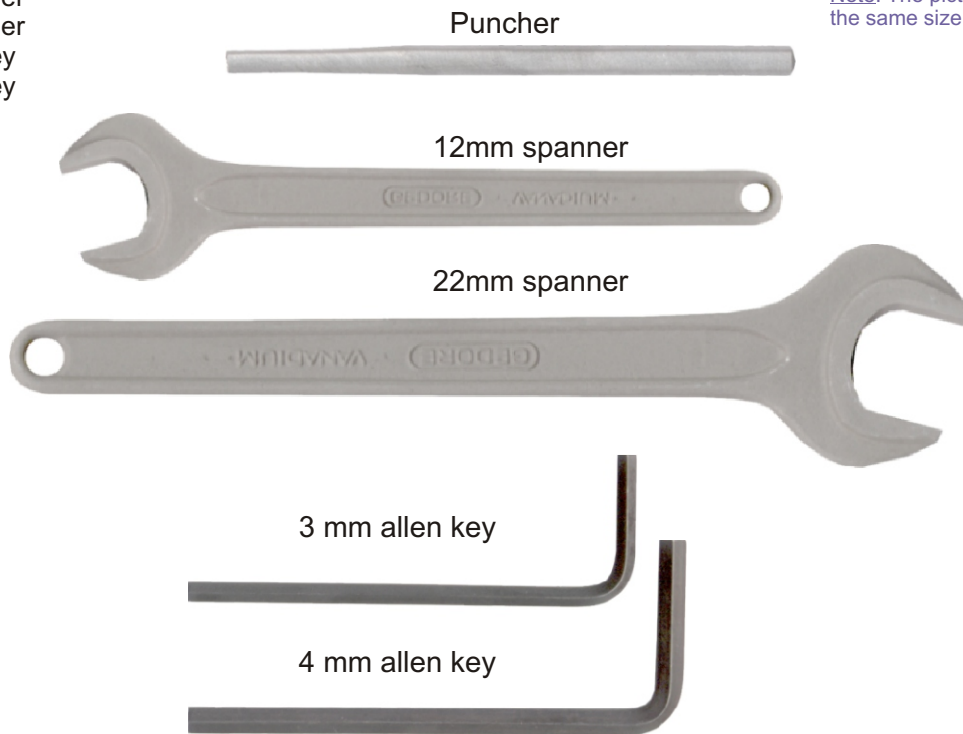
TOOLS AND PARTS SUPPLIED

TOOLS SUPPLIED.

The J-231 machine is supplied together with the following series of tools required for necessary maintenance and adjustments:

- Puncher
- 1 x 12 mm spanner
- 1 x 22 mm spanner
- 1 x 3 mm allen key
- 1 x 4 mm allen key

Note: The pictures are not on the same size scale.

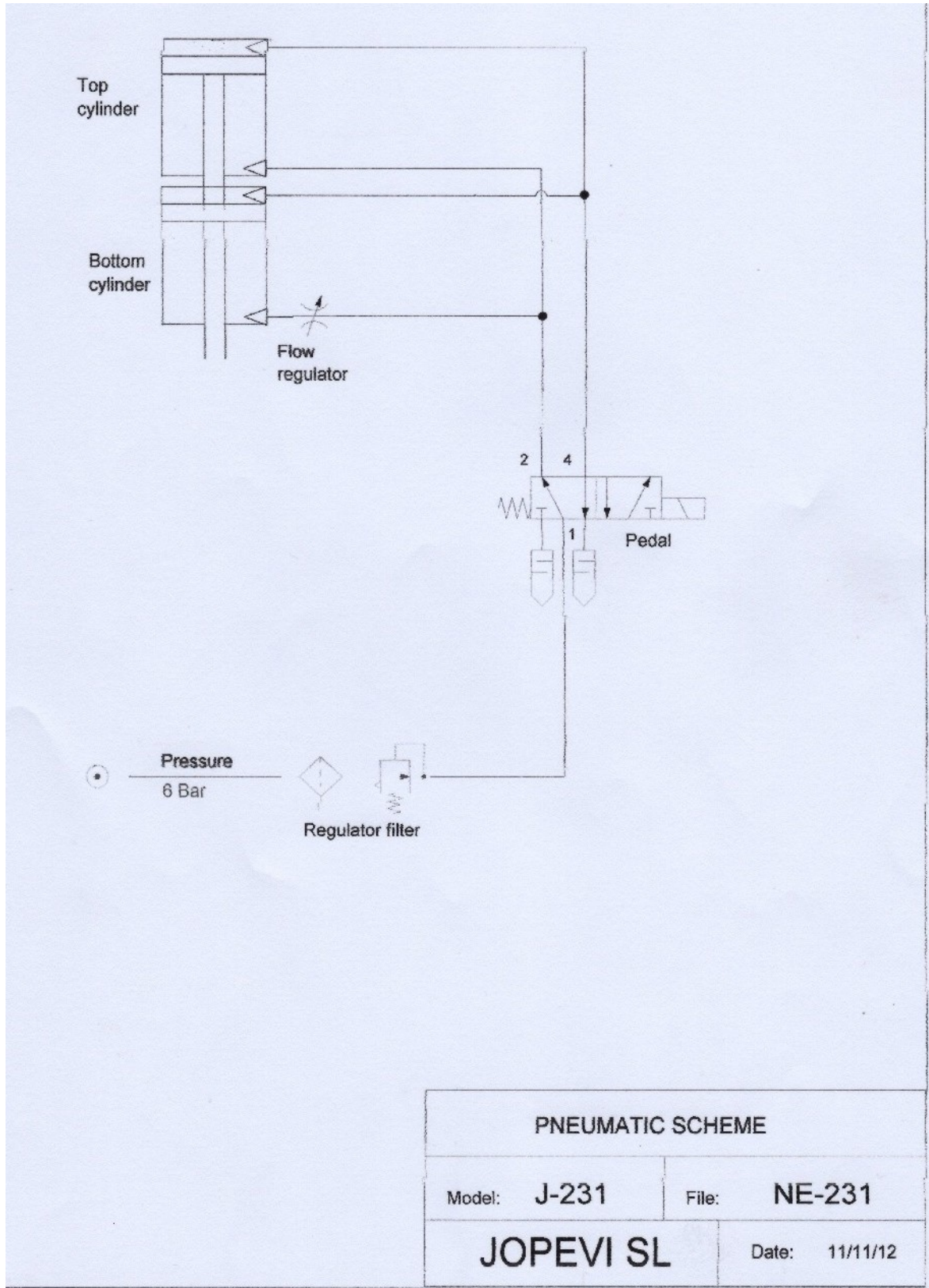


PARTS SUPPLIED.

A bottom die n° 329 is included by way of an indispensable replacement. It is recommended that users always have a stock of at least one replacement, since in normal and continuous use of the machine, this part will need to be replaced periodically.



PNEUMATIC INSTALLATION



EC APPROVAL DECLARATION

Manufacturer: JOPEVI, S.L.

Address: C/ Nicolas de Bussi, 32 Elche Parque Industrial (Alicante) – Spain

It declares under his own responsibility, that the machine::

Name: Automatic Machine for the placement of eyelets

Modell: J-231

Serial number:

Year of manufacturer: 2018

Object of this declaration, it expires with the requirements of the Board 2006/42/CE of the European Parliament and of the Advice, of May 17, 2006, relative to the machines and for that the Board modifies 95/16/CE (remelting), and his later modifications.

In his design the following procedure have used:

- UNE-EN ISO 12100:2012
- UNE-EN ISO 14120:2016
- UNE-EN ISO 983:1996+A1:2008
- UNE-EN ISO 13857:2008

Object of this declaration, it fulfills the requirements of the Board 2006/95/CE relative to the approximation of the legislations of the members states on the electrical material destined to be in use with certain limits of tension, and his later modifications.

In his design the following procedure have used UNE-EN 60950-1:2007/AC:2012.

In his name D. Lucio Jaén Andreu as manager of JOPEVI, S.L., he signs the present declaration.

Signed.: _____

Elche, 03 of April, 2018

SISKA INC.

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Saddle Brook, NJ 07663

Telephone: 1-800-393-5381

e-mail: sales@siska.com
www.siska.com