



SISKA, INC  
800-393-5381

MODEL J-237



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**J-237 SINGLE FEED AUTOMATIC ELECTRONIC GROMMETING MACHINE.  
USES 110 V OUTLET**



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## INDEX

	PAGE
<b><u>INTRODUCTION</u></b>	
WARNINGS.....	2
MACHINE IDENTIFICATION AND PLATES.....	2
<b><u>CHAPTER I.</u></b>	
CHARACTERISTICS	
1.1. DESCRIPTION OF THE MACHINE AND ITS OPERATION.....	3
1.2. TECHNICAL DATA.....	4
<b><u>CHAPTER II.</u></b>	
INSTALACIÓN	
2.1. MINIMUM SPACE; ELECTRICAL INSTALLATION, POSITIONING THE MACHINE.....	5
2.2. MACHINE HANDLING.....	5-6
2.3. UNLOADING AND LEVELING.....	6
2.4. LOCAL CONDITIONS.....	6
2.5. LEARNING INSTRUCTIONS.....	6-7
<b><u>CHAPTER III.</u></b>	
MACHINE USES	
3.1. MACHINE DESCRIPTION.....	8
3.2. SETTING UP THE MACHINE FOR ITS OPERATION.....	8-9
3.3. OTHER MACHINE USES.....	10
<b><u>CHAPTER IV.</u></b>	
ADJUSTMENTS	
4.1 CHANGE OF GROMMET TYPE.....	11-12
4.2. ADJUSTING THE TIGHTNESS OF SETTING, CHANGING DIES.....	12
4.3. SETTING GROMMETS WITH THE WASHERS.....	12
4.4. PERFORATING ONLY.....	13
4.5. PLACEMENT LASER LIGHT (OPTIONAL ACCESSORIES).....	13
4.6. ADJUSTMENT QUICK REFERENCE GUIDE.....	14
<b><u>CHAPTER V.</u></b>	
MAINTENANCE	
5.1. MECHANICAL PART OF THE MACHINE.....	15
5.2. ELECTRICAL PART OF THE MACHINE.....	15
<b><u>CHAPTER VI.</u></b>	
TROUBLE SHOOTING.....	16-18
<b><u>CHAPTER VII.</u></b>	
SECURITY.....	19
<b><u>ANNEXES.</u></b>	
PARTS INDEX.....	20-24
SUPPLIED TOOLS AND REPLACEMENT PARTS.....	25
ELECTRICAL INSTALLATION.....	26
"EC" APPROVAL DECLARATION.....	27



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MODEL J-237

## **INTRODUCTION**

### **MACHINE MODEL J-237 AUTOMATIC TO PLACE GROMMETS.**

The object of this machine is to place grommets in canvas, curtains, or any other material that requires this kind of reinforcement, or to simply perforate the material.

### **WARNINGS.-**

- Lack of familiarity with the machine usually leads the operator to elemental doubts about its operation.
- Read this operations manual carefully to securely operate and optimize the machine's capability.
- We urge you to follow this advice, and appreciate your trust at the moment of buying the machine.

**JOPEVI, S.L. ASSUMES NO RESPONSIBILITY ABOUT THE INCORRECT USE  
OF THIS MANUAL OR INCORRECT INTERPRETATION OF THE INSTRUCTIONS PROVIDED.**

### **MACHINE IDENTIFICATION AND PLATES.-**

This machine includes an aluminum plate attached with four rivets indicating the following:

Factory Name  
Manufacturing Year  
Model and Manufacturing number  
Power in kw  
Air pressure (on pneumatic machines)  
CE Mark  
Weight in Kilograms

<b>JOPEVI®</b> , 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"/> <b>CE</b>
Pot.Kw.	<input type="text"/>	Pres.Max.Bars. <input type="text"/>
Año Fab.	<input type="text"/>	Peso <input type="text"/> Kg.

Version: Abril 2007



## CHAPTER I      CHARACTERISTICS

### 1.1 DESCRIPTION OF THE MACHINE AND ITS OPERATION.-

MACHINE MODEL J-237 AUTOMATIC ELECTRONIC FOR PLACING GROMMETS.

The machine consists of a metallic stand with a wood base on which the machine is mounted. The pedal and the electronic equipment that control the machine are located in the stand.

The head of the machine is comprised of a machine housing and a channel. The moving parts in the machine are located inside the housing, such as: the main motor, axles, eccentrics, bearings, etc.; The grommets use the a channel to descend.

The J-237 model is designed to automatically place the grommets, or to punch holes in the material. Facing the machine, the grommets are placed in the left hopper box “D”. The hopper box are rotated by individual 24 V motor.

The grommets that descend along the left raceway “E” are held by a small finger, which stops them from falling.

The machine is controlled by an electronic unit designated IMO V3 “A”, located inside the mounting stand.

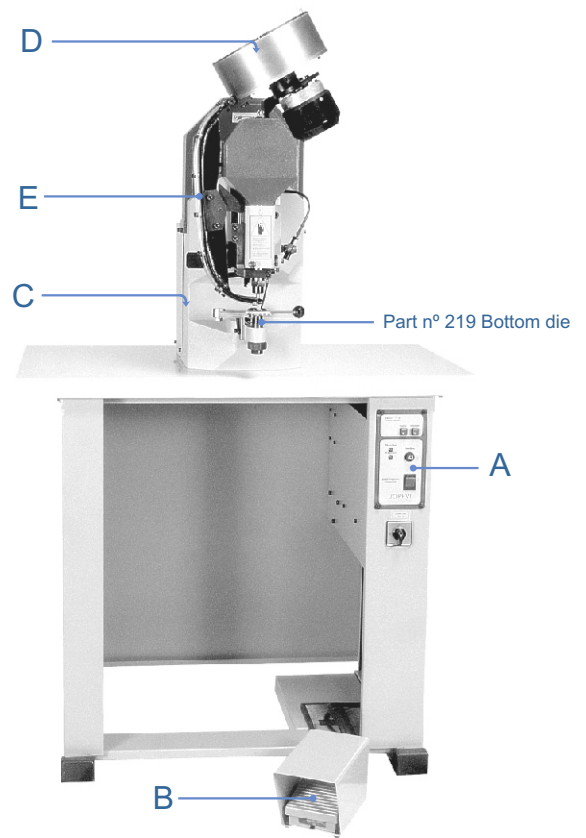
The IMO V3 unit receives an electric signal through pedal “B” that allows the main motor “C” located behind the head, to quickly rotate and haul the flywheel (part no. 274) with a belt making a 360° rotation causing the motor to stop sharply.

The flywheel (part no. 274) has a mainshaft (part no. 207) that joins the plunger with the other moving parts. By rotating 360°, it exerts pressure on the driving stem and therefore the grommeting action is completed.

The top set spindle (part no. 218) inside the top set (part no.217) inserts itself inside the grommet and pulls it down from raceway “E”.

After this cycle, the machine returns to its initial state, in readiness for another 360° turn, as soon as pedal “B” is depressed.

FIGURE 1



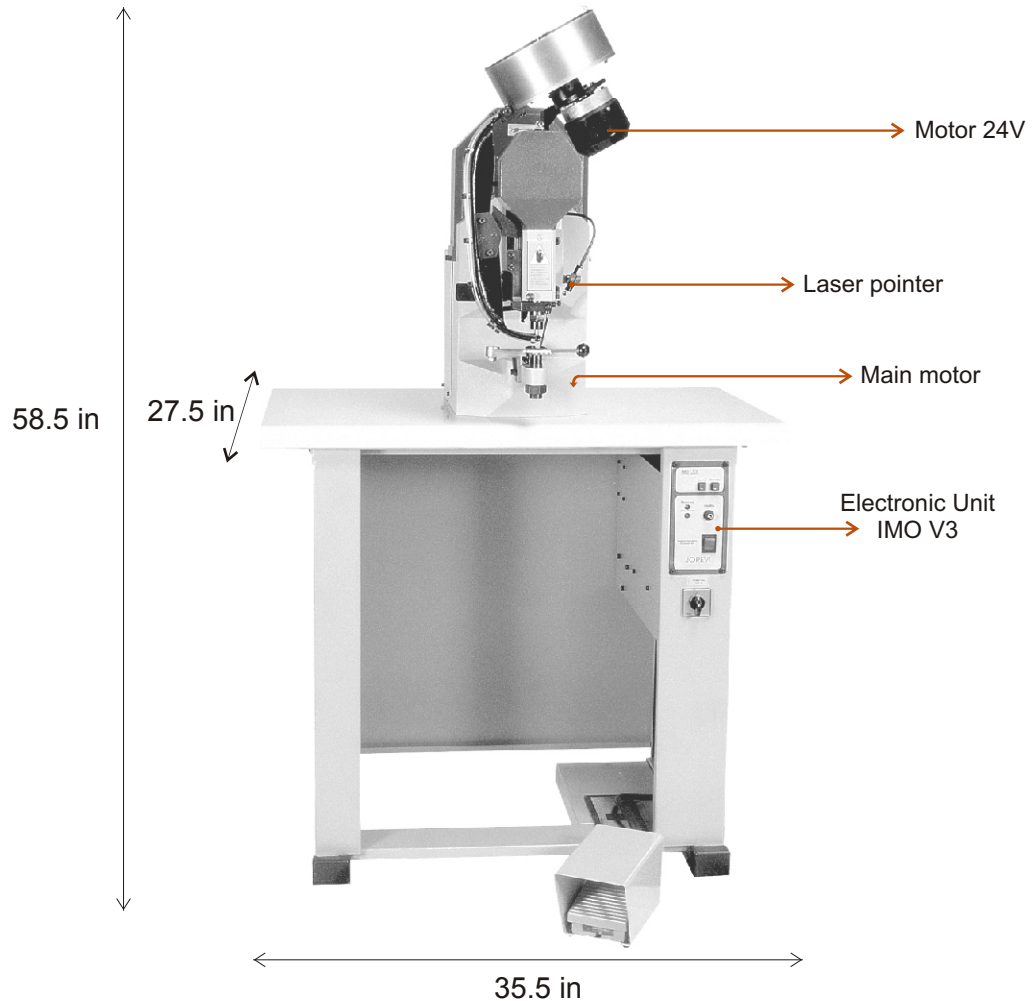
Grommet 



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MODEL J-237

## 1.2. TECHNICAL DATA.-



## MEASUREMENTS.-

DEPTH: 70 cm  
WIDTH: 90 cm  
HEIGHT: 149 cm  
WEIGHT: 125 kg

MAIN MOTOR THREE-PHASE-110V.1HP  
INPUT POWER: 110V  
POWER IN KW: 0.75 KW.  
BARS (PNEUMATIC EQUIPMENT): -----

1-24V MOTOR FOR HOPPER BOX.

CONTROL PANEL.- ELECTRONIC CONTROLLER IMO V3.

This machine is to be connected to 110V current.





## CHAPTER II

### INSTALLATION

#### 2.1. MINIMUM SPACE, ELECTRIC INSTALLATION, POSITIONING THE MACHINE.-

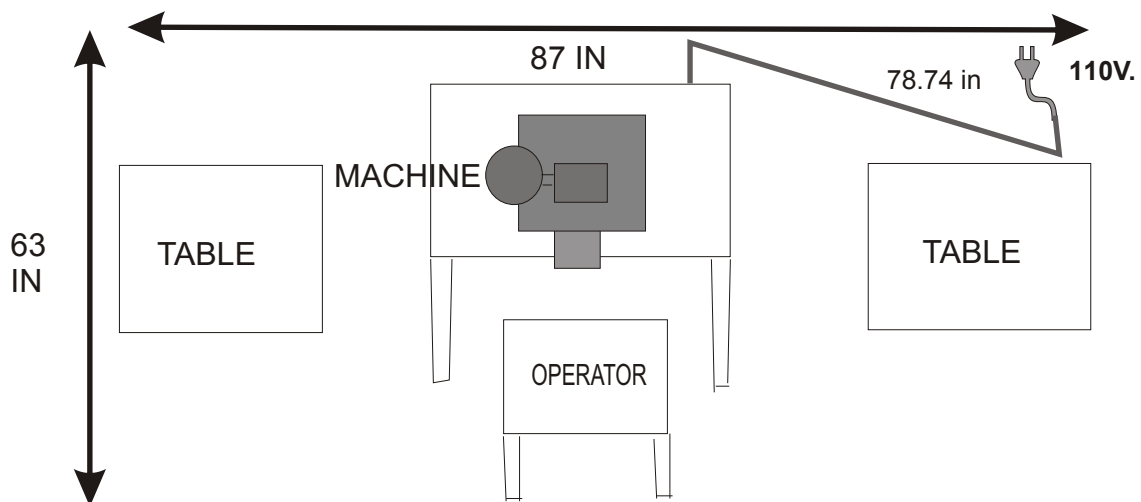
As we indicate in the lower figure, the operator can work in a seated position.  
The minimum space recommended is 87" width by 63" depth.



THIS MACHINE MUST BE CONNECTED TO A 110V POWER SOURCE.

The machine comes with a 2 meter long cable.

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



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

#### 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.
- Do not place yourself in the cargo moving trajectory.
- Use the correct equipment to move cargos.
- Check this equipment periodically.





The machine will carry packaging which is sufficient to avoid knocking or scraping any of its components. We advise that wooden packaging, in box or cage form, should always be used, always with adequate protection and the machine properly secured. The machines should always travel in the vertical position and never be overturned.

**REMEMBER**

**THE MACHINE MUST NOT BE OVERTURNED.**

**2.3. UNLOADING AND LEVELING.-**

The machine should be unloaded by means of a crane, using ropes at both sides of the box. If the machine comes in a box or cage, it can be unloaded using a fork lift.

When the machine is on the floor, totally unpacked, it is to be transported by means of a pallet jack to its permanent location.

The machine comes out of the factory totally leveled, and does not need to be secured to the floor.

It incorporates rubber leg tips for it not to move with vibration during use.

The floor underneath should be firm and strong.

**2.4. LOCAL CONDITIONS.-**

In order to create optimum working conditions, the machine should be situated beneath a light source of 300 lux minimum

**2.5. LEARNING INSTRUCTIONS.-**

**[BEFORE STARTING THE MACHINE, READ THESE WARNINGS CAREFULLY.](#)**

The following are a series of instructions and warnings which must be taken into account with regard to the model J-237.

**The machine must be connected to a 110V power supply.**

- Before connecting the machine to the electrical outlet or the compressor, it should be placed in its permanent location. Do not connect any electrical devices to the machine before it has been placed in its permanent location.

- Cleaning, manipulation and replacement of parts of the machine must always be carried out with the machine disconnected from the mains power supply.

- Do not remove from the machine any parts which protect the user from possible accidents, or adhesive labels or signs indicating electrical or hazardous components.

- The machine must be connected to a 110V power supply.



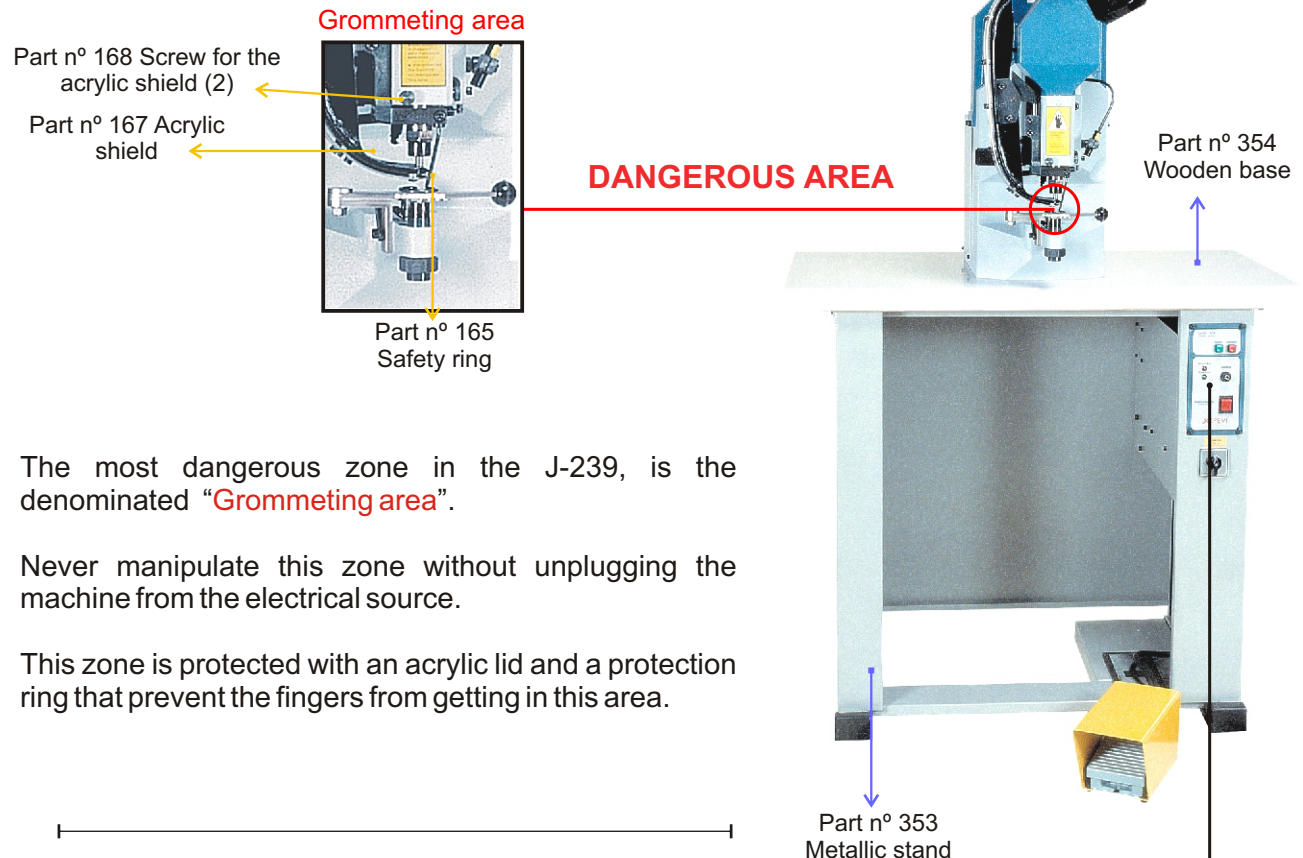


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## MODEL J-237

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

### BEFORE STARTING THE MACHINE READ THESE WARNINGS CAREFULLY.



The most dangerous zone in the J-239, is the denominated "Grommating area".

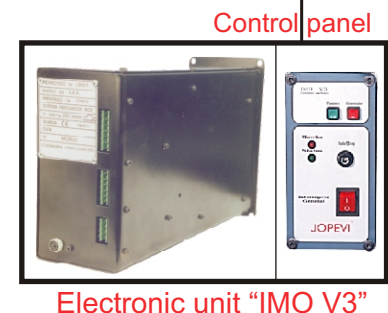
Never manipulate this zone without unplugging the machine from the electrical source.

This zone is protected with an acrylic lid and a protection ring that prevent the fingers from getting in this area.

The **IMO V3 controller** is the piece that governs all the functions in the J-239 machine. On it's front end are located the control panel with the switches and indication leads. The controller goes in from the front and is attached with 4 allen screws.

The controller is never to be manipulated or opened. In case of an IMO V3 unit breakdown, bring out the whole unit through the cover which is situated on the right-hand side of the metallic stand, removing the electric cables in its back side, and after this install a new IMO V3 UNIT.

The IMO V3 controller has a serial number located at the back for identification.





## CHAPTER III

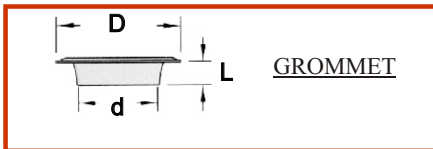
### MACHINE USES

#### 3.1. MACHINE DESCRIPTION.-

The J-237 model is an automatic electronic machine designed to set grommets or to make holes in the material.

Each machine is manufactured for a specific size of grommet. Grommet models may differ in: the head size "D", the length "L", the interior diameter of tube "d", the thickness, etc.

JOPEVI, S.L. RECOMMENDS YOU TO USE ALWAYS THE SAME TYPE OF GROMMET FOR WHICH THE MACHINE WAS DESIGNED. In order for the machine to set different grommet model, certain parts need to be changed (the raceway and the top and bottom sets); but you always have to use the same washer the machine was manufactured for.



In order for the machine to set different grommet models, 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. SETTING UP THE MACHINE FOR ITS OPERATION.-

PLEASE VERIFY THESE ADJUSTMENTS BEFORE CONNECTING THE MACHINE.

Before starting the machine for the first time, and each time the location of the machine is changed, or any changes are made in parts or any adjustments are done to it, we recommend the following steps:

After placing and making the machine level in its permanent location **"STILL WITHOUT PLUGGING IT IN"**, lubricate it with 30W motor oil in the grease cups and red marks. Let the oil have enough time to cover the parts and then clean the excess oil that might remain or drip.

To verify the machine is not blocked or might have suffered a blow or breakage, See figure 3 page 10:

- 1- Remove the cap nº 158 "pulley cover" that covers the flywheel by loosening the 4 allen screws that tighten it.
- 2- Rotate the flywheel nº 274 manually one cycle of 360° in the direction that the red arrow points (clockwise).
- 3- Verify that the machine is moving freely.
- 4- Put the cap on again (nº 158) and tighten it with the 4 allen screws.



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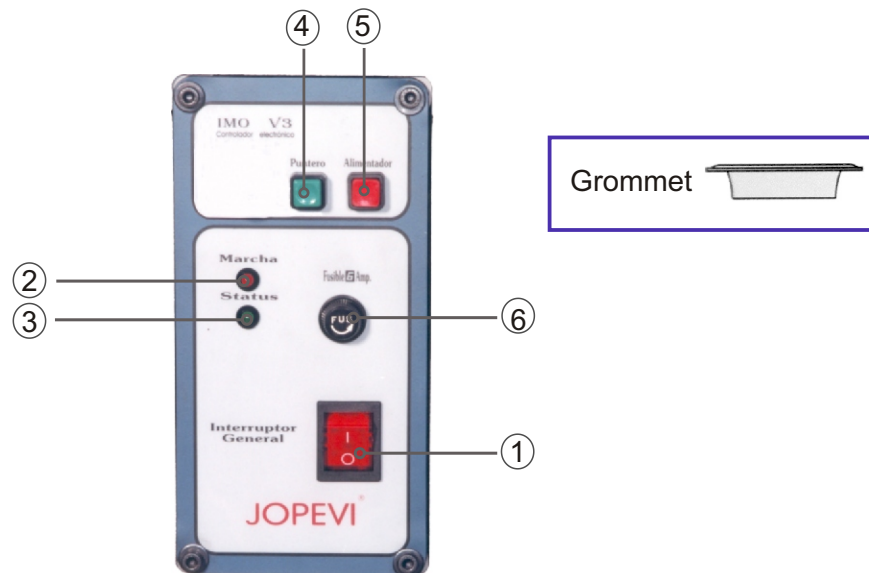
## MODEL J-237

The machine is equipped in the base with an electronic device “IMO V3” and a control panel described in figure 2, showing the following features:

- 1- Main Switch:** connects or disconnects all of the machine systems. When the switch is pushed towards the symbol “I”, the led will light showing that the machine is “ON”.
- 2- Marcha:** red led shows that the machine is connected and in stand-by mode.
- 3- Status:** green led will light every time we press the pedal indicating that the machine is in operation. If illuminated in a pulsating fashion, it indicates failure, disconnect the machine immediately.
- 4- Green pointer or switch:** turns the lighted pointer on or off. Only in those machines equipped with this device (optional).
- 5- Red switch or feeder:** connects or disconnects the 24V motor that make the grommets rotate in the deposit.
- 6- 6Amp fuse.** Fuse holder. Uses a 6 amp fuse to protect the machine from high voltage.

FIGURE 2

ELECTRONIC CONTROLLER “IMO V3”<sup>®</sup>  
Patented by JO PE VI.





The IMO V3 device is responsible for the electrical working of the machine.

It must not be opened or manipulated except by an authorized technician, or with the consent of JOPEVI, S.L.

### **3.3. OTHER MACHINE USES.-**

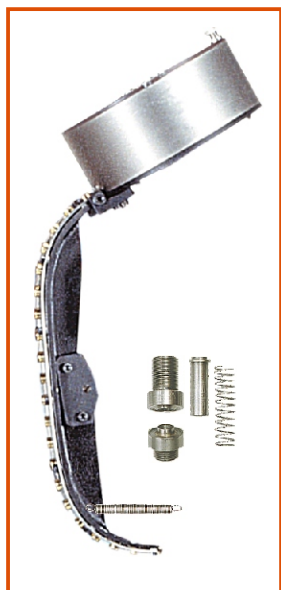
If it is to be used only to punch holes in the material without fixing grommets, the channel must be removed and the set of dies (parts n° 217, 218, 219 and 229) must be replaced by other parts specific to this task.  
See chapter IV - Adjustments - Point 4.4. Perforating only (page 13).

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 SETTING OF GROMMETS, OR HOLE PUNCHING ONLY.

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

FIGURE 3

CHANNEL GROMMETS  
complete with the set of dies.



Part n° 158  
Flywheel cover

360° TURN →



Part n° 274  
Flywheel



Complete set of dies.  
Parts n° 217, 218, 219 and 229.



## CHAPTER IV

## ADJUSTMENTS

**UNPLUG THE MACHINE BEFORE CHANGING THE GROMMET MODEL, ADJUSTING THE TIGHTNESS OF THE SETTING OF THE GROMMET, INSTALLING OPTIONAL ACCESORIES, OR CARRYING OUT ANY OTHER KIND OF MANIPULATION.**

The machine J-237 model place grommets automatically.

JOPEVI, S.L recommends to use always the same kind of grommet which the machine was prepared for. For placing other grommet model, other than that the machine was prepared for, it will be necessary to contact JOPEVI, S.L, and they will study this possibility. If there is a way to solve this problem, your machine should be sent over to our factory for some modifications.

### **4.1. CHANGE OF GROMMET MODEL.-** (See page 14, [4.6. ADJUSTMENT QUICK REFERENCE GUIDE](#)).

Each J-237 machine places a grommet model, although other grommet dimensions may be placed by replacing the corresponding parts. This replacement is quick and simple. In order to fix a different grommet model a whole new raceway is needed (see figure 3 page 10) together with the appropriate set of dies.

With the machine unplugged:

- 1- Remove the stripper plate spring n° 237 from the raceway spring nut n° 238 which holds it in place ① ,
- 2- Loosen both mounting screws n° 244 ② which are holding the front hopper box mounting bracket n° 240 ⑥ ,
- 3- Use both hands for holding the grommet hopper box housing n° 242 ③ and the grommet hopper box bottom plate n° 241 ⑤ and begin to push upwards (with slight clockwise rotations) in order to remove the whole raceway ④ from the front hopper box mounting bracket n° 240 ⑥ ,

The whole set of dies or some of its parts (part n° 217, 218, 219 y 229) ⑨ ⑩ ⑪ will have to be replaced according to the different grommet models.

The dealer that sold you this machine or directly JOPEVI, S.L, will let you know about the parts that should be replaced. If no part of the set of dies needs to be replaced, continue at point 6.

Changing the whole set of dies:

- 4- Unscrew the top die n° 217 ⑨ , remove the top set spindle n° 218 and the top set spindle spring n° 229 ⑩ , which are inside the top die. Unscrew the bottom die n° 219 ⑪ ,
- 5- Replace the set of dies corresponding to the new grommet size, in the same order in which the other parts were removed. Firstly the top die n° 217 ⑨ with the top set spindle n° 218 and the top set spindle spring n° 229 ⑩ ; and then remove the bottom die n° 219 ⑪ ,

Before starting the machine, it is necessary to adjust the tightness of your setting (Point 4.2. Adjusting the tightness of setting, change of dies; page 12).

- 6- Fit the new grommet raceway into the front hopper box mounting bracket n° 240 ⑥ while manually rotating it back and forth, so that the driving stem n° 243 which is in the lower part, gets into the hopper box motor spin axis n° 239 ⑪ ,



- 7- Tighten both 6 allen screws n° 244 for holding (2) the part n° 240 (6),
- 8- Hold the stripper plate spring n° 237, which is held in place by the raceway spring nut n° 238 (1),
- 9- The lower part of the raceway (4) where the grommet you are going to set is placed, must be on the same vertical line as the spindle n° 218 (10) so the spindle can take the grommet while coming down,
- 10- Adjust the tightness of setting (Point 4.2. Adjust the tightness of setting and changing dies).

## **4.2. ADJUSTING THE TIGHTNESS OF SETTING, CHANGING DIES.-**

Machine model J-237 can set grommets in different types of material of different thicknesses. For a perfect grommeting action you can adjust the pressure that the dies put on the grommets. Each time the dies are changed, or a different material is used, it may be necessary to adjust the machine so that a proper setting is achieved.

(See page 14, **4.6. ADJUSTMENT QUICK REFERENCE GUIDE**).

Machine model J-237 has two vertical axles:

- N° 230 "Driving stem" (14), that governs the cutting pressure, and,
- N° 215 "Plunger" (13), that governs the pressure of the grommeting.

If you want to change the whole set of dies, you must follow the instructions from number 4 to number 5 shown at point 4.1. Change of grommet model; page 11. You must always change the dies with the machine disconnected from power source.

With the machine unplugged.

### **CUTTING PRESSURE:**

- Remove the flywheel cover part n° 158A (18),
- Manually rotate flywheel n° 274 (clockwise) (19) until top set spindle n° 218 (10), is in its lowest part,
- Unscrew nut that holds the bottom die in place, then rotate the bottom die holder part n° 220 (12) until the bottom die part n° 219 (11) barely touches the top set spindle part n° 218 (10). Secure the bottom die holder part n° 220 through nut (12). The pressure of the spindle n° 218 (10) against the bottom die n° 219 (11) must be minimum, the pressure which is sufficient for punching a hole on a piece of paper.

### **PRESSURE OF THE GROMMETING:**

- By unscrewing nut part n° 216 (16) you will be able to turn the top set n° 217 (9) to the right or left, until the distance between the bottom die n° 219 (11) and the top die n° 217 (9) equals approximately the thickness of the material used for setting the grommets,
- Manually rotate flywheel n° 274 (19) (clockwise) and check whether the adjustment of the dies is correct,
- Secure the top set n° 217 (9) through nut n° 216 (16),
- Replace the flywheel cover n° 158A (18).

## **4.3. SETTING GROMMETS WITH THE WASHERS.-**

Machine model J-237 can also place grommets without the washers.





#### **4.4. PERFORATING ONLY.-** (See page 14, [4.6. ADJUSTMENT QUICK REFERENCE GUIDE](#)).

If what you want is simply to make perforations in the material, you must place a new complete set of dies and make the following adjustments:

With the machine disconnected from the power source,

- Empty both the deposit and railings of any grommets.
- Move the grommet railing to the left and secure it with a small puncher to the front raceway bracket part n° 272 <sup>(21)</sup>.
- Next place the new complete set of dies and adjust the machine's pressure as explained in page 11- 12, point 4.1 and point 4.2.

#### **4.5. PLACEMENT LASER LIGHT (OPTIONAL ACCESSORIES).-**

(See page 14, [4.6. ADJUSTMENT QUICK REFERENCE GUIDE](#)).

- Your machine has an optional laser light that emits a red laser beam that can help with the placement of the grommet and washer. (See page 14 <sup>(15)</sup>).

The machine includes a switch for this device, in the "IMO V3" (See page 9, figure 2, point 4). For connecting the switch see instructions at page 26, Electric installation.

Note: Although the light power of this laser is very small. **DO NOT SHINE THIS LIGHT DIRECTLY IN ANYONE'S EYES SINCE IT COULD BE HARMFUL. KEEP IT AWAY FROM CHILDREN.**

- For small grommets, the machine may come with a little air pipe attached to the grommet raceway, which blows the grommet down onto their right position, by means of an air compressor.
- For placing grommets in materials such as: canvas, sailcloth, etc, a small metallic tray may be attached to the machine, in order to be used as a base for the material.
- If you wish to know the amount of grommets that you set each day, you can use a grommet meter.
- The back side of the grommet may have two shapes after having been placed in the material: 1) ring shaped grommeting, 2) star-flower shaped grommeting, depending on the kind of bottom die n° 219 <sup>(11)</sup> that you use:

1) ring,



2) star-flower.



Ask for the flower-shaped or ring-shaped bottom die n° 219 <sup>(11)</sup> according to the kind of grommeting that you wish to obtain.

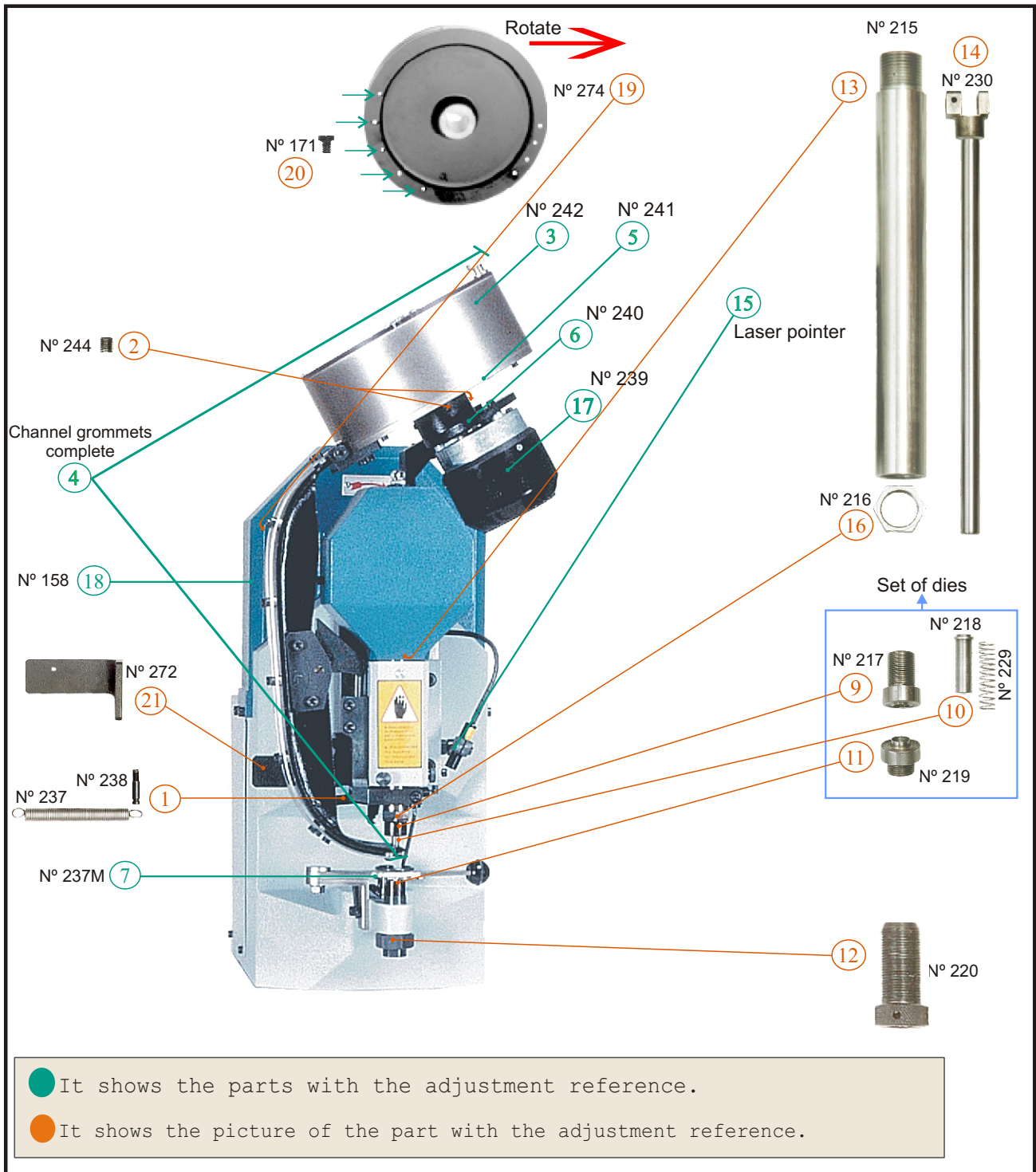
- Due to differences in the tension of different supply systems, the top-set spindle stop-position n° 218 <sup>(10)</sup> may not be correct, and the spindle stops at a point lower than normal. If you change the position of the detector screw n° 171 <sup>(20)</sup> by screwing it into another hole (generally the one next to it) of the flywheel n° 274 <sup>(19)</sup>, we will be able to stop the top set spindle n° 218 <sup>(10)</sup> in another position. The correct position is as high as possible.





#### 4.6. ADJUSTMENT QUICK REFERENCE GUIDE.-

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





## CHAPTER V

### MAINTENANCE

#### 5.1. MECHANICAL PART OF THE MACHINE.-

For an optimal operation of the machine, it is recommended that you keep some parts clean and always lubricated. The cleaning should ALWAYS be done with the machine disconnected from the electrical power source and the compressor.

The pedal we press to operate the machine, should always be clean and clear of any debris that could prevent its normal operation.

The exterior of the machine should be cleaned with a rag that will not leave threads, so that the threads can not be stuck to the machine.

The head of the machine has exterior grease cups. You must use a manual pressure oil can to inject oil (the oil type to be used should be "30W") into the grease cups two or three times a week. We recommend to do this at the end of the journey, and clean up the possible excess oil next day.

During the first month of operation it must be done twice per week. After the first month it only needs to be done once a week.

If the machine is going to go for a long period of time without use, it will be necessary to do a general cleaning, and greasing in the indicated spots, disconnecting it from the compressor or from the power source (if it has any electrical devices), and then cover it so that it is protected from the dust and/or humidity.

#### 5.2. ELECTRICAL PART OF THE MACHINE.-

The electrical part of the machine the IMO V3 is clearly marked with a yellow triangle and does not need any type of maintenance. Do not open unless directed to do so by JOPEVI.

The electrical parts of the machine: motors, cables, etc, come completely sealed and secured through nuts. The electrical parts need no maintenance, do not open or manipulate them.

Part n° 149 flywheel detector, should be cleaned using a dry cloth.

If an optional laser light n° 155 has been installed, it needs no cleaning or maintenance, **and remember that you must never shine it directly in anybody's eyes, since it could be harmful.**

Both the main motor and the hopper box motor are totally sealed and do not require any maintenance.

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

Part n° 149 Flywheel detector



Part n° 155 Laser pointer (optional)



ELECTRICAL PART





**CHAPTER VI**

**VERY IMPORTANT**

Machine disconnected from the electrical and pneumatic source.

**TROUBLE SHOOTING**

<b><u>PROBLEM</u></b>	<b><u>CAUSE</u></b>	<b><u>SOLUTION</u></b>
<b>THE MACHINE DOES NOT WORK WHEN PRESSING THE PEDAL.</b>	Check that the machine is correctly connected to 110V current and the main switch (page 9 figure 2 point 1) is in the "On" position.	Connect and turn switch to "On" until red light is on.
	The main switch (page 9 figure 2 point 1) is lit and the fuse (page 9 figure 2 point 6) is burnt out.	Replace the 6 amp fuse.
	If the main switch is lit (page 9 figure 2 point 1) and the lights "On" and "Status" (page 9 figure 2 points 2 - 3) are flashing, verify that the home position detector part n° 149 is clean and next to screw n° 171 on flywheel n° 274 (approximately 1'5 mm.).	Clean part n° 149, adjust so that it is separated from the flywheel by aprox 1'5mm or replace it with a new one. When adjusting or replacing, care should be taken to manually rotate the flywheel in order to verify that it will <b>NOT TOUCH</b> the detector. If it continues not to work the IMO V3 is broken. <b>DO NOT OPEN IT.</b> Call the authorized distributor or directly to JOPEVI S.L.
<b>DEFECTIVE GROMMETING.</b>	Part n° 219 bottom set is worn out or broken.	Replace the bottom die n° 219 with a new one. See chapter IV. Pressure adjustments. Points 4.1. Change of grommet model and 4.2. Adjusting the tightness of setting, and changing dies pages 11 and 12.
	Incorrect adjustment of pressure.	See chapter IV. Pressure adjustments. Point 4.2. Adjusting the tightness of setting, and changing dies, page 12.
<b>IT GIVES SEVERAL BLOWS SIMULTANEOUSLY.</b>	Home position detector n° 149 dirty or broken.	Clean part n° 149, adjust so that it is separated from the flywheel by aprox 1'5mm, or replace it with a new one. When adjusting or replacing, care should be taken to manually rotate the flywheel in order to verify that it will not touch the detector screw n° 171.
	"IMO V3" electronic controller broken.	<b>DO NOT OPEN IT.</b> Call an authorized distributor or directly to JOPEVI, S.L.



**VERY IMPORTANT**

Machine disconnected from the electrical and pneumatic source.

<u>PROBLEM</u>	<u>CAUSE</u>	<u>SOLUTION</u>
<b>JAMMED MACHINE.</b>	Parts n° 218 and 219 worn out.	Replace with a new one. See Chapter IV. Adjustments. Points 4.1. Change grommet model, and 4.2. Cutting and grommeting pressure. Change dies, pages 11 and 12.
	The machine has too much cutting or grommeting pressure.	Adjust the pressure. See Chapter IV. Adjustments. Points 4.1. Change grommet model, and 4.2. Cutting and grommeting pressure. Change dies, pages 11 and 12.
	The drive belt n° 361 may be worn out or not too taut.	Lower the motor n° 160 a little bit with the 4 mount bolts n° 204. You must not tauten the drive belt n° 361 too much and if it is too worn out replace it with a new one.
<b>FAILURE TO PICK UP GROMMETS.</b>	The spindle n° 218 does not pick up the grommet from the raceway.	Part n° 268 and 132 are broken or worn out, replace them with new ones.
<b>THE MACHINE CRUSHES THE HEAD OF THE GROMMETS.</b>	The top die n° 217 or the grommet spindle n° 218 does not correspond to that grommet model.	Replace it with a new one, and adjust the machine pressure. See Chapter IV. Adjustments. Points 4.1 and 4.2. Change of dies, page 11 and 12.
<b>IT WILL NOT CUT OR LEAVE MATERIAL RESIDUALS.</b>	Part n° 218 top set spindle or part n° 219 bottom set, is worn out or broken.	Replace it with a new one. See Chapter IV. Adjustments. Points 4.1 and 4.2, pages 11 and 12.



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## MODEL J-237

### VERY IMPORTANT

Machine disconnected from the electrical and pneumatic source.

<u>PROBLEM</u>	<u>CAUSE</u>	<u>SOLUTION</u>
<b>IT WILL NOT CUT OR LEAVE MATERIAL RESIDUALS.</b>	Incorrect tightness of setting.	Check the cutting pressure.  See Chapter IV. Adjusting the tightness of setting, and changing dies, page 12.

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 THE NEAREST DISTRIBUTOR, OR CONTACT US DIRECTLY.



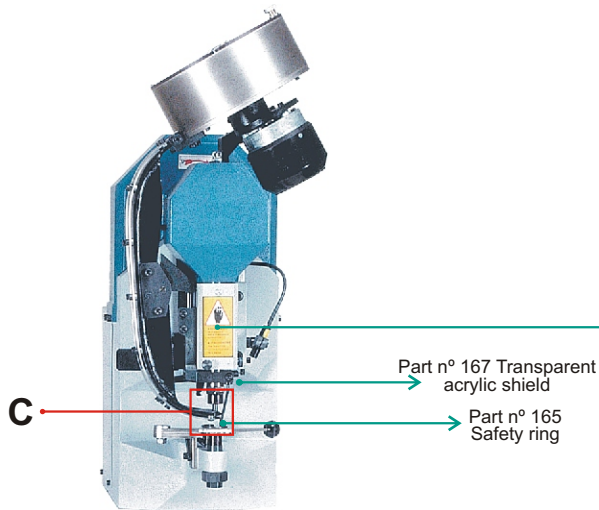
## **CHAPTER VII**

## **SECURITY**

*As we have indicated in the manual, the J-237 machine has a series of protection devices to prevent the operator from getting his fingers caught or any other kind of accident. PLEASE DO NOT REMOVE THESE PROTECTION DEVICES.*

*The most dangerous area in the J-237 is the grommeting area “C” where the operator may get his fingers or his hands caught. In order to prevent this, some protection devices have been installed:*

**FIGURE 4**



**FIGURE 5**



**FIGURE 6**



**FIGURE 7**



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

*In figure 4 “C” we indicate the area we consider dangerous for the operator.*

*This area “C” is protected by:*

- *A part n° 167 transparent acrylic shield that allows vision but does not permit the worker to introduce his hands, indicated in figure 4.*
- *A safety ring part n° 165 indicated in figure 7, that prevents the worker from accidentally introducing fingers or hands in the grommeting area.*
- *The waste material pipe n° 350 is used for absorbing the remaining pieces of material that are left after the grommeting action. This pipe allows the operator to work more comfortably (without photo).*

*These protection devices are tightly held through screws, that prevent them from becoming detached.*

*All areas considered dangerous are marked and securely enclosed.*

*The sticker shown in figure 5 warns you that the grommeting area “C” is a dangerous area, and the machine must always be unplugged before making any adjustments in that area.*

*All mechanical, electric and pneumatic parts are securely enclosed and tightly screwed up.*

*When the machine includes an optional device such as a laser pointer part n° 155C, you must not shine this pointer directly in anyone’s eyes since it could be harmful, and keep it away from children.*

*We strongly warn you that for any adjustment or any other manipulation that needs to be done, the machine must be disconnected from the electrical power source and the compressor air inlet.*

*For any problem that may arise and can not be solved, please call the nearest distributor or get in contact directly with JOPEVI, S.L.*





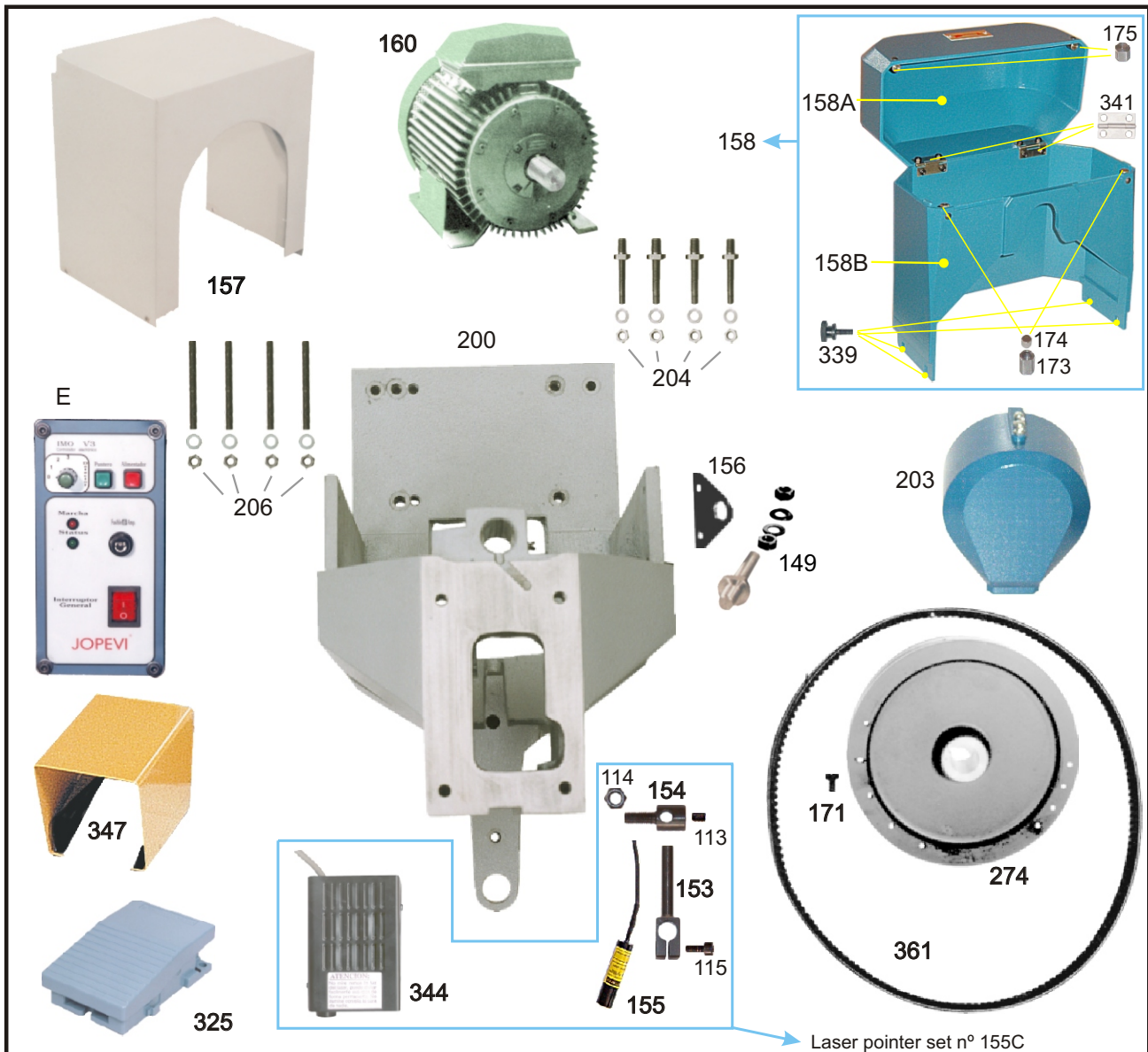
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## MODEL J-237

### ANNEXES

### PARTS INDEX

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



Part n° E Electronic device IMO V3  
Part n° 113 Threaded pin for part n° 153  
Part n° 114 Nut for part n° 154  
Part n° 115 Screw for part n° 153  
Part n° 149 Flywheel detector  
Part n° 153 Laser pointer bracket  
Part n° 154 Laser pointer threaded support  
Part n° 155 Laser pointer (optional)  
Part n° 155C Laser pointer set (optional)  
Part n° 156 Flywheel detector bracket  
Part n° 157 Motor cover  
Part n° 158 Flywheel cover  
Part n° 158A Upper part of flywheel cover n° 158  
Part n° 158B Bottom part of flywheel cover n° 158

Part n° 160 Main motor  
Part n° 171 Flywheel detector screw  
Part n° 173 Bracket for part n° 174 (2)  
Part n° 174 Magnet 7 mm (2)  
Part n° 175 Part to fix with magnet n° 174 (2)  
Part n° 200 Housing for machine  
Part n° 203 Cover for plunger unit  
Part n° 204 Motor mount bolts, nuts and washers (4)  
Part n° 206 Machine house bolts, nuts and washers (4)  
Part n° 274 Flywheel  
Part n° 325 Electrical foot pedal  
Part n° 339 Screw for plastic cover (4))  
Part n° 341 Hinge (2)  
Part n° 344 Transformer laser (optional)  
Part n° 347 Foot pedal protector  
Part n° 361 Drive belt

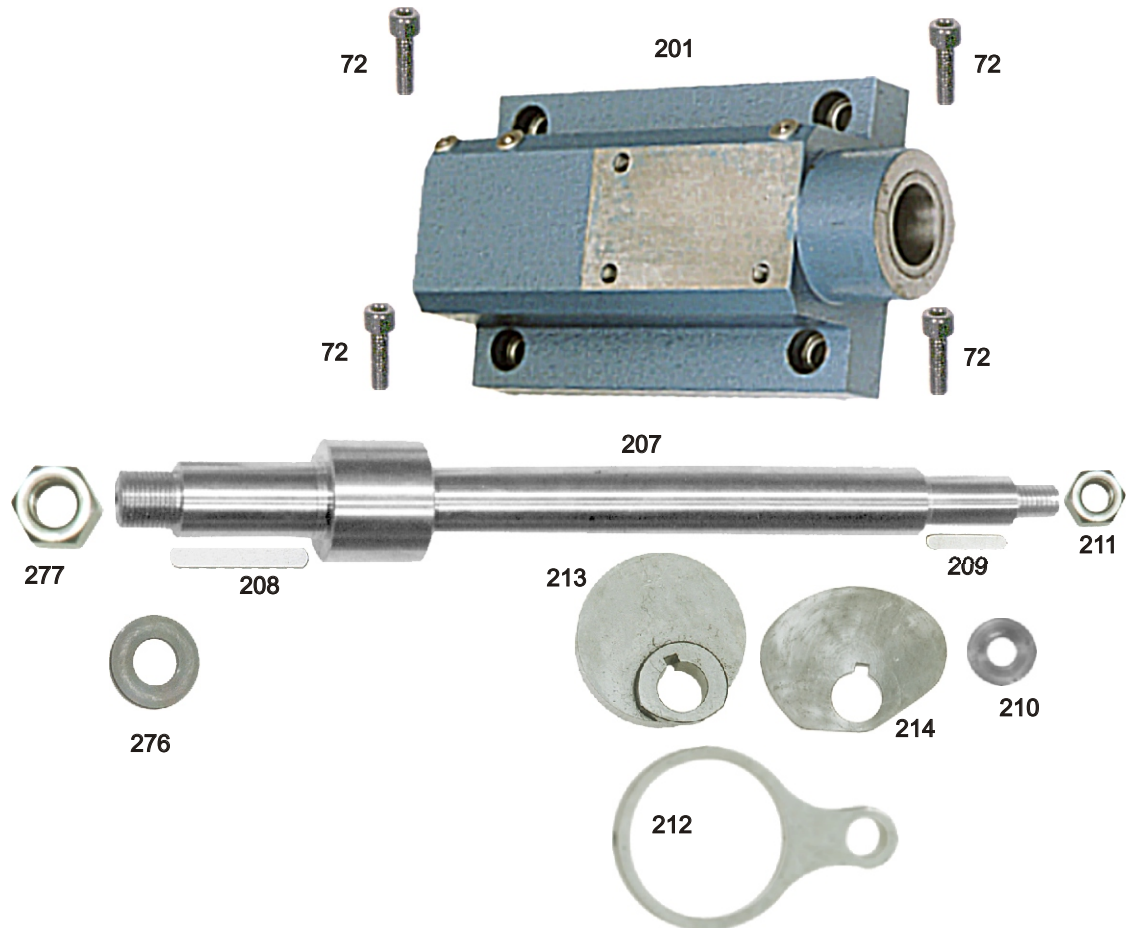




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## MODEL J-237

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



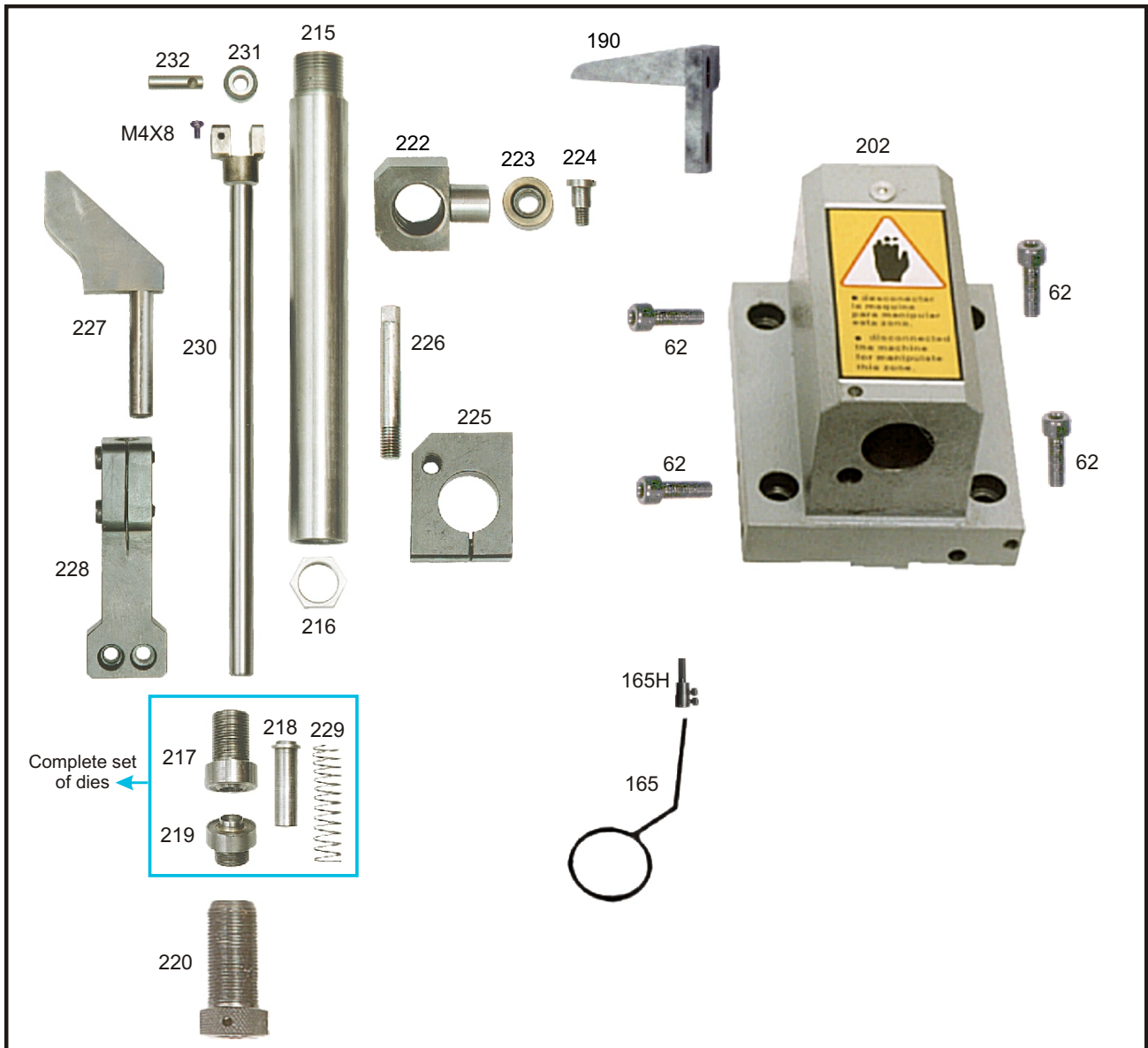
Part n° 72 Screw for part n° 201 (4)  
Part n° 201 Mainshaft housing  
Part n° 207 Crankshaft  
Part n° 208 Crankshaft key way  
Part n° 209 Front crankshaft key way  
Part n° 210 Front washer  
Part n° 211 Front crankshaft nut  
Part n° 212 Collar  
Part n° 213 Collar insert  
Part n° 214 Plunger cam  
Part n° 276 Flywheel spacer  
Part n° 277 Flywheel nut



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



Part n° 62 Screw to fix plunger housing (4)  
Part n° 165 Ring guard  
Part n° 165H Ring guard bracket  
Part n° 190 Plunger  
Part n° 202 Plunger housing  
Part n° 215 Upper guide collar  
Part n° 216 Lock nut  
Part n° 217 Top die  
Part n° 218 Top set spindle  
Part n° 219 Bottom die  
Part n° 220 Bottom die holder  
Part n° 222 Upper guide  
Part n° 223 Plunger guide wheel for part n° 222  
Part n° 224 Screw for part n° 223

Part n° 225 Bottom plunger collar  
Part n° 226 Bottom plunger guide pin  
Part n° 227 Raceway cam  
Part n° 228 Raceway cam bracket  
Part n° 229 Top set spindle spring  
Part n° 230 Driving stem  
Part n° 231 Driving stem guide wheel  
Part n° 232 Driving stem pin  
Part n° M4x8 Screws M4x8 to fix part n° 232

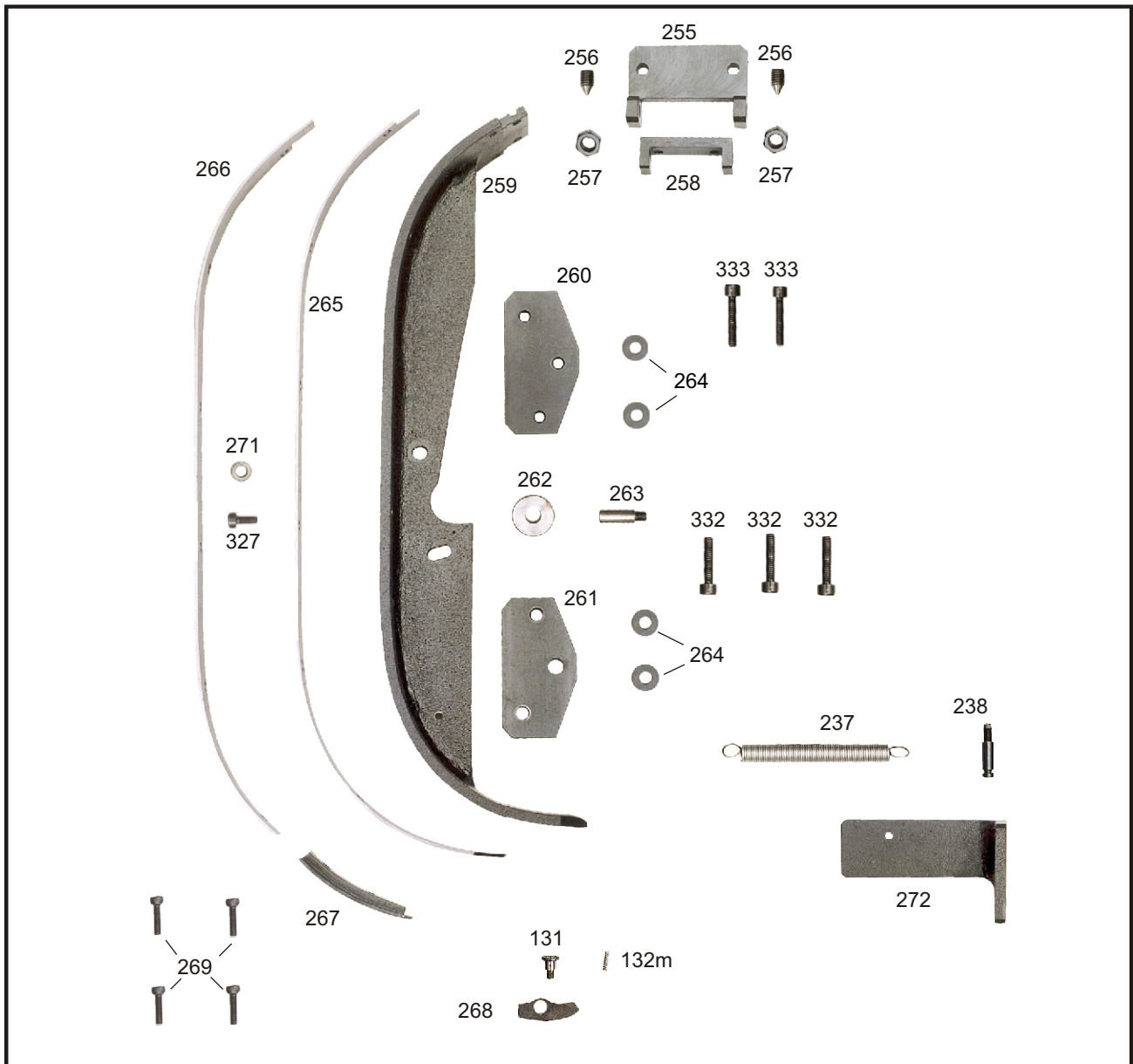


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MODEL J-237

## GROMMETS CHANNEL

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



Part n° 131 Finger (cut off) screw  
Part n° 132m Spring for part n° 268  
Part n° 237 Stripper plate spring  
Part n° 238 Raceway spring nut  
Part n° 255 Front hopper lower bracket  
Part n° 256 Mounting studs (2)  
Part n° 257 Mounting stud nut (2)  
Part n° 258 Front hopper lower bracket support  
Part n° 259 Raceway support  
Part n° 260 Outer raceway bracket  
Part n° 261 Inner raceway bracket  
Part n° 262 Raceway bracket spacer  
Part n° 263 spacer stud  
Part n° 264 Mounting spacers (4)

Part n° 265 Right strip  
Part n° 266 Left upper strip  
Part n° 267 Fixed guide  
Part n° 268 Finger (cut off)  
Part n° 269 Hopper box assembly screws (4)  
Part n° 271 Raceway strip spacers (12)  
Part n° 272 Front raceway bracket  
Part n° 327 Raceway screws (12)  
Part n° 332 Mounting screws (3)  
Part n° 333 Mounting screws (2)

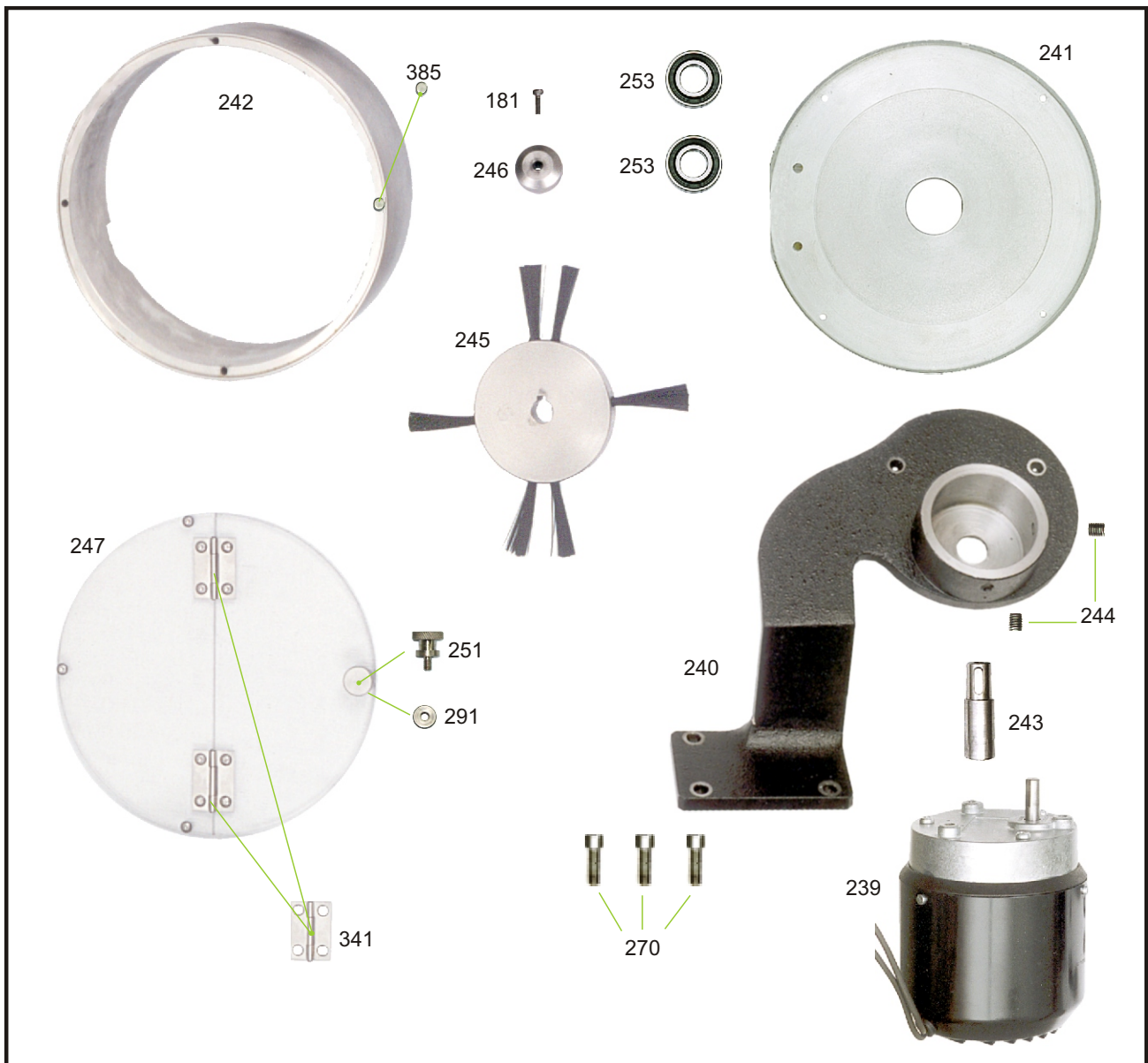


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## MODEL J-237

### GROMMETS CHANNEL

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



Part n° 181 Screw for part n° 246  
Part n° 239 Hopper box motor  
Part n° 240 Front hopper box mounting bracket  
Part n° 241 Hopper box bottom plate (grommet)  
Part n° 242 Hopper box housing (grommet)  
Part n° 243 Brush pin  
Part n° 244 Threaded pin for holding hopper box (4)  
Part n° 245 Brushes  
Part n° 246 Brush spacer  
Part n° 247 Acrylic box cover  
Part n° 251 Knob for opening the hopper box cover  
Part n° 253 Upper box bearing (2)  
Part n° 270 Mounting studs (3)  
Part n° 291 Knob washer

Part n° 341 Acrylic box hinge n° 247 (2)  
Part n° 385 Magnet for holding the hopper box cover knob



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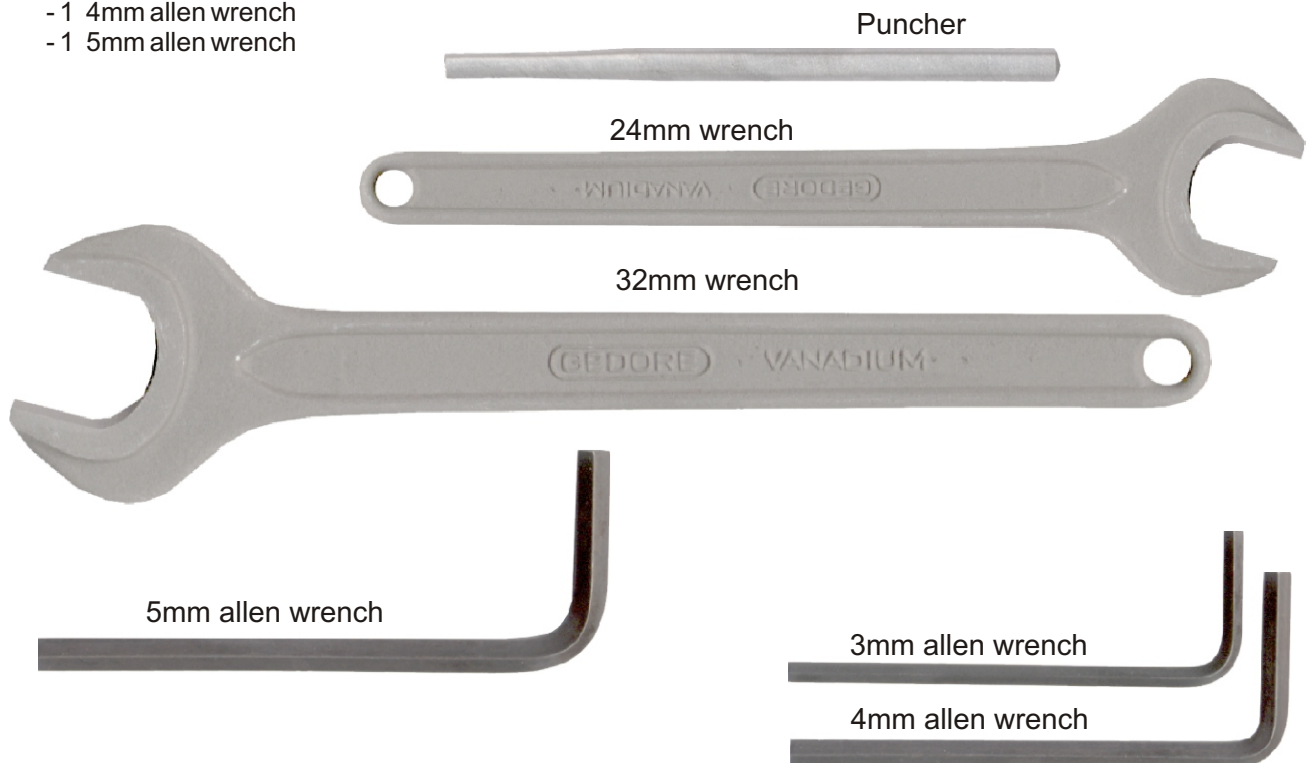
## SUPPLIED TOOLS AND REPLACEMENT PARTS.

### TOOLS.

Along with your machine, you will find all the necessary tools to do the required maintenance and adjustments as follows:

- 1 Puncher
- 1 24mm wrench
- 1 32mm wrench
- 1 3mm allen wrench
- 1 4mm allen wrench
- 1 5mm allen wrench

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



### PARTS.

Included with the machine is a part n° 219 bottom die.

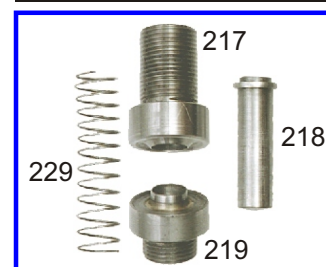
JOPEVI, S.L recommends to have a complete set of dies in stock parts n°: 217 - 218 - 219 and 229.

#### Part included



Part n°219  
Bottom die

#### Parts recommended



Complete set  
of dies





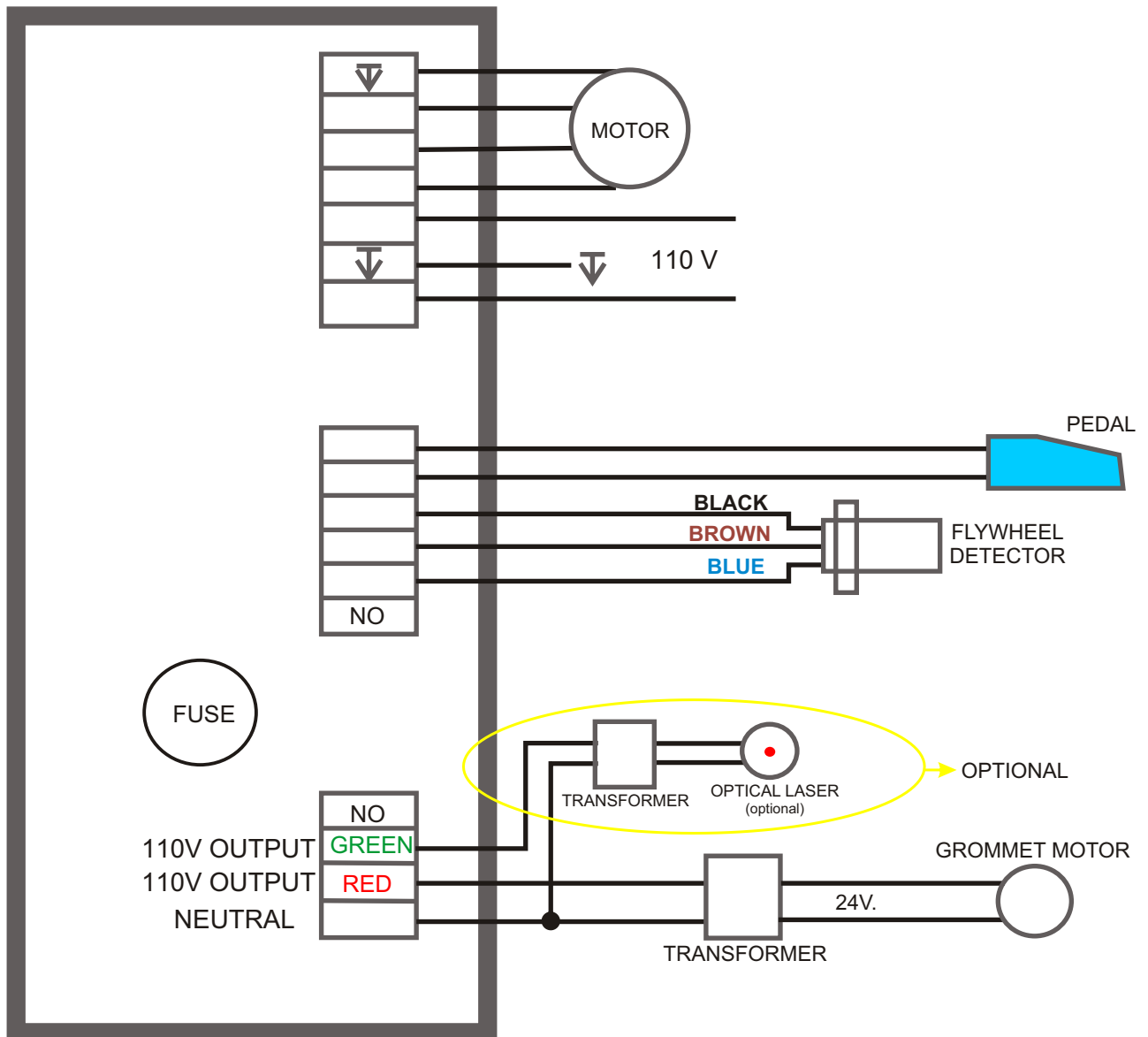
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MODEL J-237

## ELECTRICAL INSTALLATION

ELECTRONIC UNIT "IMO V3"<sup>®</sup>

Patented by JO PE VI





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MODEL J-237

## **“EC” APPROVAL DECLARATION**

MR. LUCIO JAEN ANDREU, MANAGER OF THE COMPANY JOPEVI S.L. MANUFACTURERS OF MACHINERY FOR THE FOOTWEAR SECTOR, WITH REGISTERED OFFICE AT C/.NICOLAS DE BUSSI Nº 32, ELCHE PARQUE INDUSTRIAL, ELCHE (ALICANTE) ESPAÑA.

### **DECLARES:**

- THAT WITH THE OBJECT OF THAT WHICH IS ESTABLISHED IN ARTICLE 8 OF THE COUNCIL DIRECTIVE OF 14 JUNE 1989 RELATING TO THE APPROXIMATION OF MEMBER STATES (89/392/CEE), THE MACHINE WITH THE FOLLOWING CHARACTERISTICS:

**MODEL: J-237**

**SERIAL NUMBER:**

**YEAR OF MANUFACTURE:**

- MEETS WITH THE ESSENTIAL HEALTH AND SAFETY REQUIREMENTS RELATING TO DESIGN, AS ESTABLISHED IN ANNEX I OF THE ABOVE MENTIONED DIRECTIVE.

- THAT THE MACHINE IS NOT INCLUDED AMONG THOSE LISTED IN ANNEX IV.

- THAT THE FOLLOWING UNIFIED NORMS HAVE BEEN RESPECTED IN FULL DURING DESIGN AND MANUFACTURE:

NORM UNE-EN 292-1  
NORM UNE-EN 292-2  
NORM UNE-EN 349  
NORM UNE-EN 60204-1  
PRENORM PREN953

AND FOR ALL OPPORTUNE RECORDS EMITS THIS DECLARATION OF APPROVAL IN ELCHE, ON \_\_\_\_\_ OF \_\_\_\_\_, 20\_\_\_\_.

**SIGNED:**