JOPEVI®

MODEL J-239

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J-239 AUTOMATIC MOTOR POWERED MACHINE WITH TWO CHANNELS FOR PLACING GROMMETS AND WASHERS **USES 110V OUTLET**

INDEX

INTRODUCTION

MACHINE MODEL J-239 AUTOMATIC WITH TWO DEPOSITS TO PLACE GROMMET AND WASHER.

The object of this machine is to place grommet and washer in canvas, curtains, or any other material that requires this kind of reinforcement, can be used to place the grommet and washer, only the grommet 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.

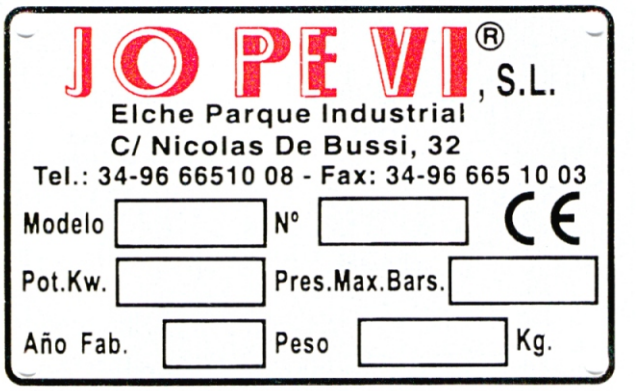
JOPEVI, S.L. ASSUMES NO RESPONSIBILITY ABOUT THE INCORRECT USE

OF THIS MANUAL OR INCORRECT INTERPRETATION OF THE INSTRUCTIONS PROVIDED.

MACHINE IDENTIFICATION AND PLATES.-

This machine includes an alumminum 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



Version 30-05-2006

CHAPTER I

CHARACTERISTICS

1.1 DESCRIPTION OF THE MACHINE AND ITS OPERATION.

MACHINE MODEL J-239 AUTOMATIC ELECTRONIC WITH TWO HOPPER BOXES FOR PLACING GROMMET AND WASHER.

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 two raceways (one on each side). The moving parts in the machine are located inside the housing, such as: the main motor, axles, eccentrics, bearings, etc.; The grommets and the washers use the two raceways to descend.

The J-239 model is designed to automatically place the grommets with washers, the grommet without the washer, or to punch holes in the material.
Facing the machine, the grommets are placed in the left hopper box **" A "** and the washers in hopper box **" B ".** Both hopper boxes are rotated by individual 24 V motors.
The grommets that descend along the left raceway **" A' "** are held by a small finger, which stops them from falling. Lower horizontal guides hold the washers descending along the right raceway **" B' "**.

The machine is controlled by an electronic unit designated IMO V3 **" C "**, located inside the mounting stand.
The IMO V3 unit receives an electric signal through pedal **" D "** that allows the main motor **" E "** 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 **" A' ".** At the same time the slide (part no. 297) pushes the washer from the slide track and places it exactly on top of the bottom set (part no. 219).

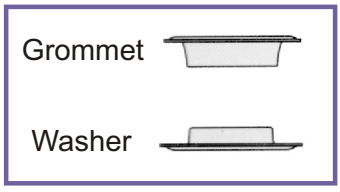
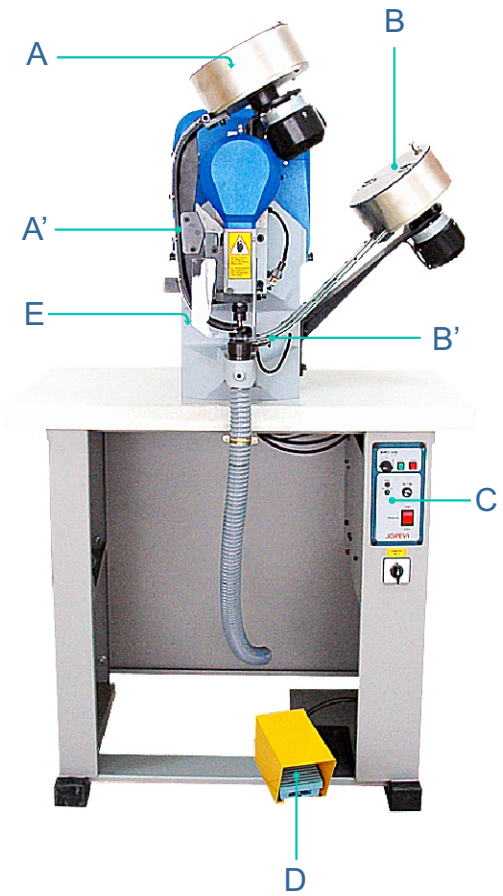
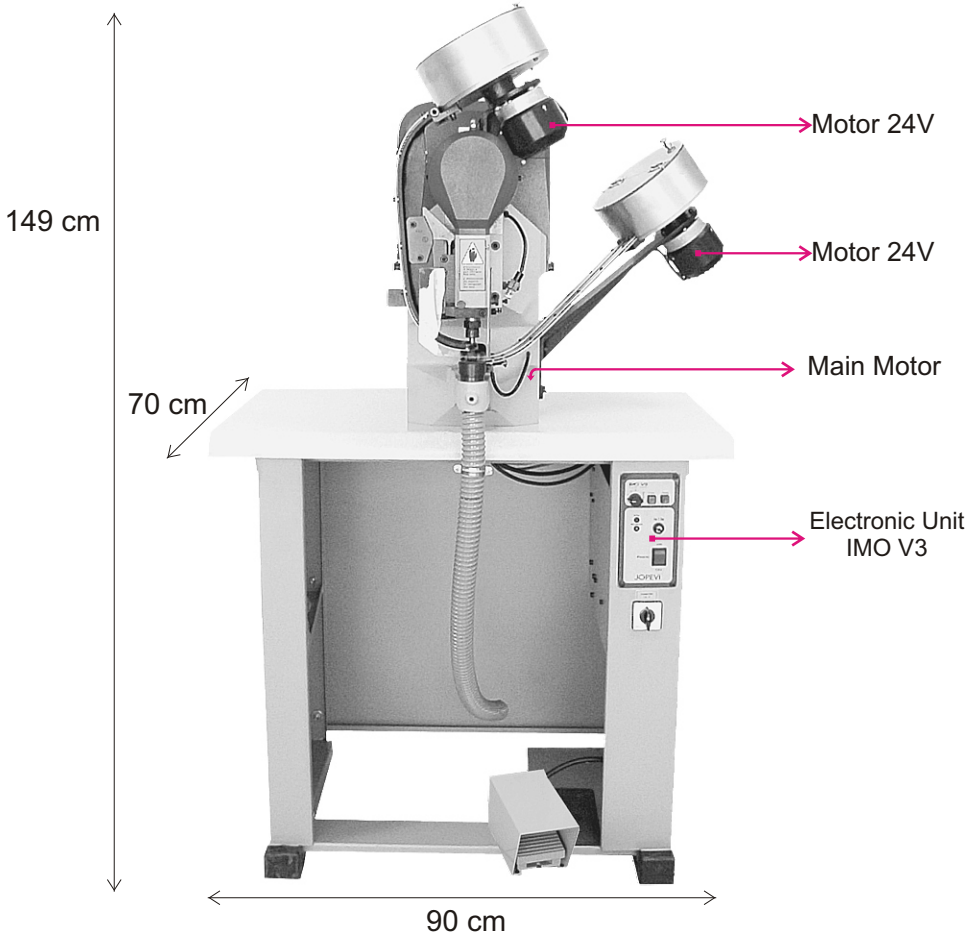


FIGURE 1



1.2. TECHNICAL DATA.



MEASUREMENTS.-

DEPTH: 70 cm
WIDTH: 90 cm
HEIGHT: 149 cm
WEIGHT: 138 kg

This machine is to be connected to 110V current.

MAIN MOTOR THREE-FASE 220/380 1HP
INPUT POWER 110V. (Unless otherwise specified)
POWER IN KW: 0'75 KW.

2 - 24V MOTORS FOR HOPPER BOXES.

CONTROL PANEL.- ELECTRONIC CONTROLLER IMO V3.

CHAPTER II

INSTALLATION

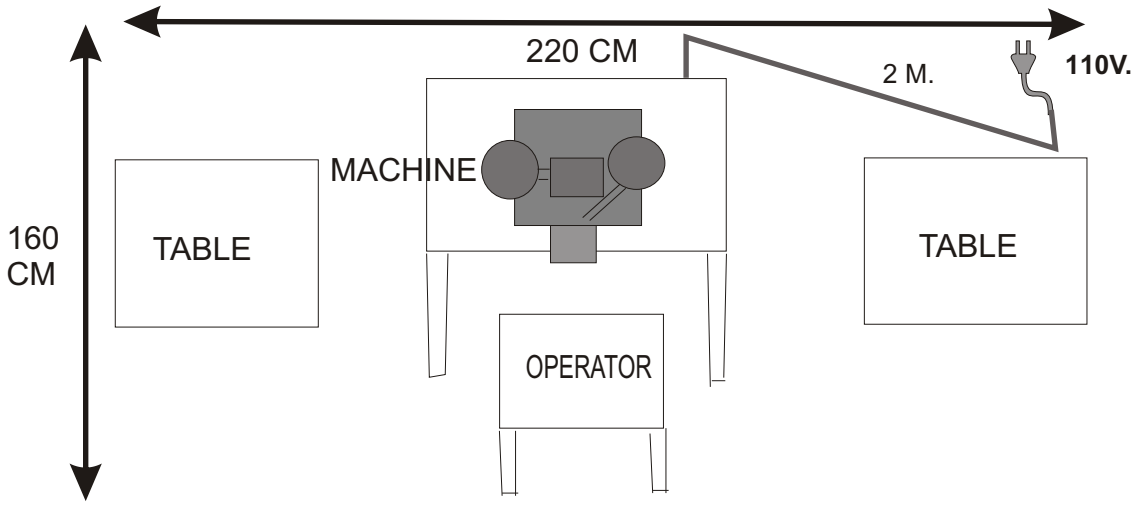
2.1. MINIMUM SPACE, ELECTRIC INSTALLATION, POSITIONING THE MACHINE.

As we indicate in the lower figure, the operator can work in a seated position.
The minimum space recommended is 220 cm width by 160 cm 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.
- No brisk movements.
- 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 LEVELLING.

The machine should be unloaded with a forklift and placed on a the floor. After the machine is un-crated and unpacked, it can be transported by 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 so it will not move with vibration during use. The floor underneath the machine should be strong and level.

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!

This machine must be plugged into a 110V power outlet

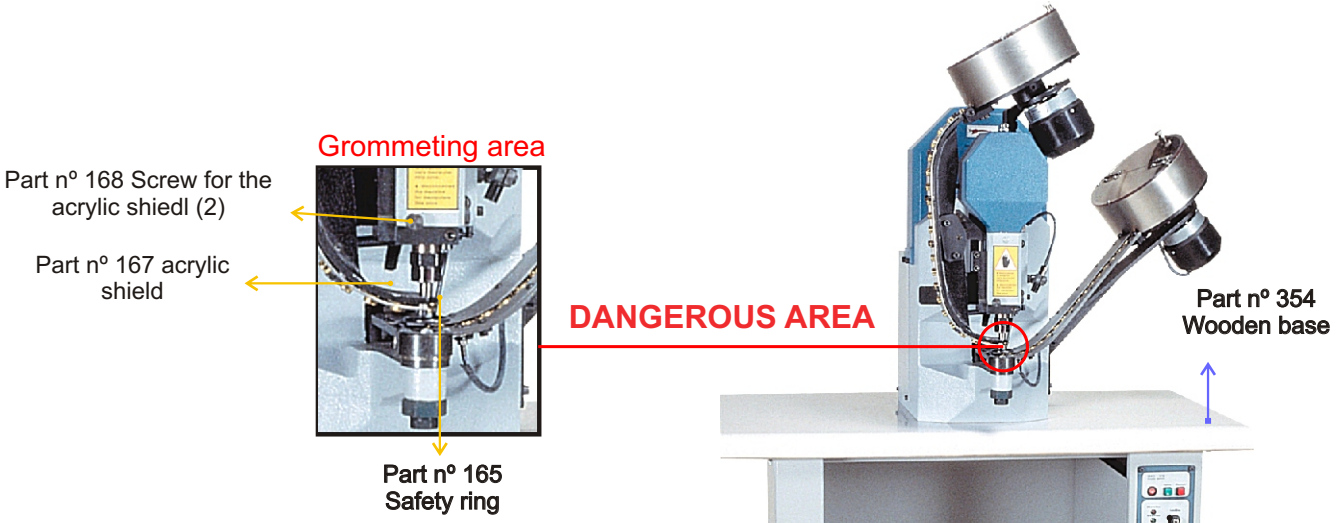
-Before connecting the machine to the electrical outlet or the compressor, it should be placed in its permanent location. Do not connect any electrical devices to the machine before it has been placed in its permanent position.

-Cleaning,manipulation or replacement of any parts of the machine must always be carried out with the machine disconnected from the main 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 always be connected to a 110V outlet (power supply).

BEFORE STARTING THE MACHINE READ THESE WARNINGS CAREFULLY.



The most dangerous zone in the J-239, is the denominated "Grommeting 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 controler 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.

Electronic unit "IMO V3"

CHAPTER III

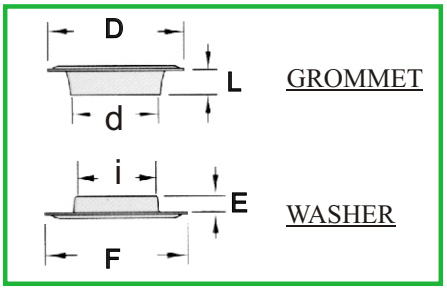
MACHINE USES

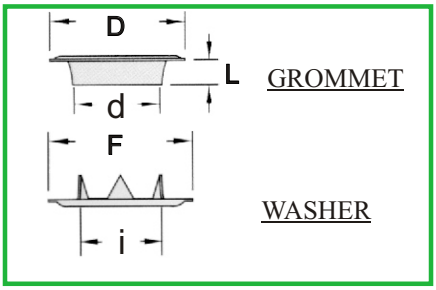
3.1. MACHINE DESCRIPTION.

The J-239 model is an automatic electronic machine designed to set grommets with washers, grommets without washers or to make holes in the material.

Each machine is manufactured for a specific size of grommet and washer. Grommet models may differ in: the head size "D", the lenght "L", the interior diameter of tube "d", the thickness, etc; and the washer models may differ in: the exterior diameter "F", the length "E", the interior diameter of washer hole "i", the washer shape, etc.

JOPEVI, S.L. RECOMMENDS YOU TO USE ALWAYS THE SAME TYPE OF GROMMET AND WASHER FOR WHICH THE MACHINE WAS DESIGNED. In order for the machine to set different grommet and washer models, 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 SAE 40 type 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 cicle of 360º 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.

The machine is equiped 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 equiped with this device (optional).

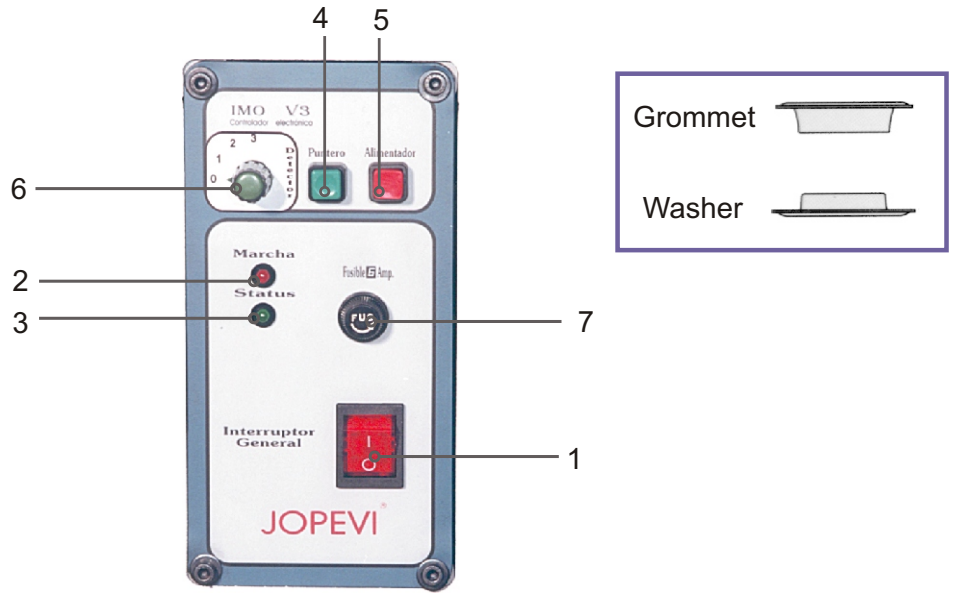
5- Red switch or feeder: connects or disconnects the two 24V motors that make the grommets and washers rotate in the deposits.

6- Washer detector: detects the flow of washers in the railing. When selected with the position “0”, it does not detect the washers in the railing, and the machine may place only grommets or punch holes. When pulsated to the outermost position “1”, it detects the washers, and will not allow to place the grommet without a washer or to punch holes. The railing must have at least 8 washers for this feature to work properly.
The position" 2" and" 3" doesn't have application in this model of machine, we therefore will always indicate" 0" or "1”.

7- 6 Amp fuse. Fuse holder. Uses a 6 amp fuse to protect the machine from high voltage.

FIGURE 2

ELECTRONIC CONTROLLER “IMO V3” ®
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.

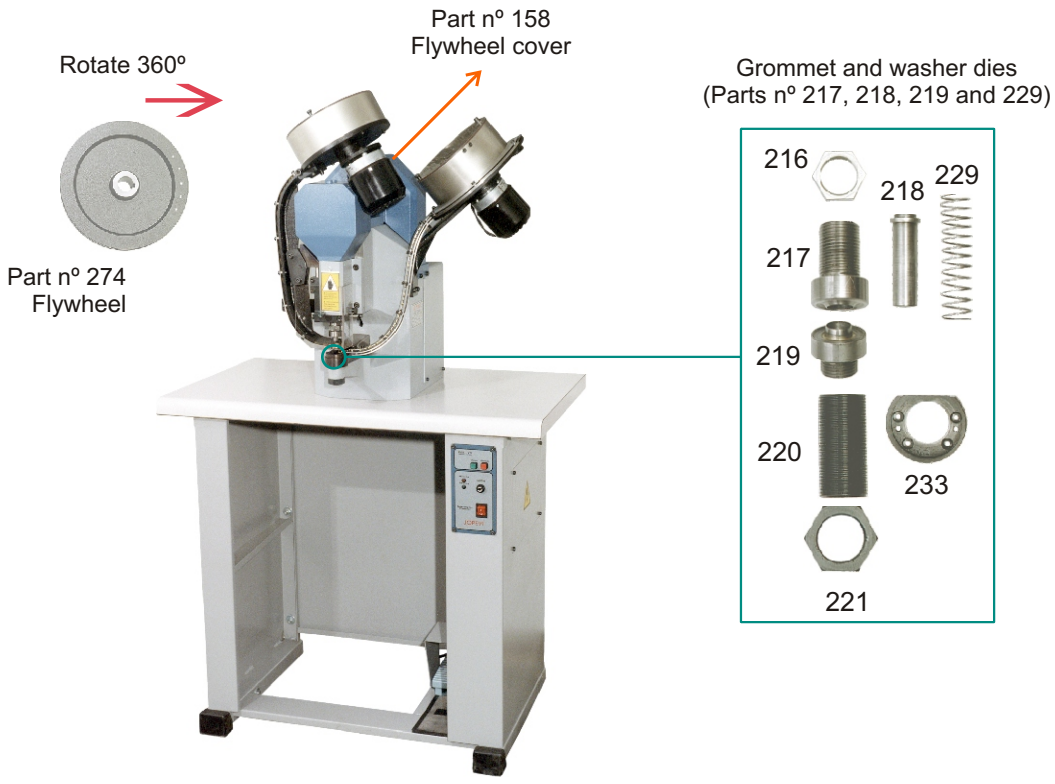
3.3. OTHER MACHINE USES.

For setting grommets without the washers, or punching out holes, all the washers must be removed from the hopper box and the guides, the grommet raceway must be moved back and the top and bottom dies (parts nº 217, 218, 219 and 229) must be replaced by other parts specific to this task.
See chapter IV - Adjustments - Point 4.3. Setting the grommet without the washer, Point 4.4. Perforating only (pages 12-13).

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 WITHOUT WASHERS, GROMMETS ONLY, OR HOLE PUNCHING ONLY.

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

FIGURE 3



CHAPTER IV

ADJUSTMENTS

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

The machine J-239 model places grommets and washers automatically, and it can also place grommets only. Grommets differing in size can be placed with the same kind of washers by replacing some machine parts.
JOPEVI, S.L recommends to use always the same kind of washer which the machine was prepared for. For placing other washer models, 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-239 machine places a grommet model and a washer, 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 appropiate set of dies.

With the machine unplugged:

1- Remove the stripper plate spring nº 237 from the raceway spring nut nº 238 which holds it in place (1),
2- Loosen both mounting screws nº 244 (2) which are holding the front hopper box mounting bracket nº 240 (6),
3- Use both hands for holding the grommet hopper box housing nº 242 (3) and the grommet hopper box bottom plate nº 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 nº 240 (6),

The whole set of dies or some of its parts (part nº 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 8.
Changing the whole set of dies:
4- Pull upwardsthe ring compensator nº 233C (7) by moving the compensator base latch nº 196 (8) that holds it,
5- Unscrew the top die nº 217 (9), remove the top set spindle nº 218 and the top set spindle spring nº 229 (10), which are inside the top die. Unscrew the bottom die nº 219 (11),
6- 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 nº 217 (9) with the top set spindle nº 218 and the top set spindle spring nº 229 (10); and then remove the bottom die nº 219 (11),
7- Replace the ring compensator nº 233C (7) around the bottom die nº 219 (11), fit the compensator base latch nº 196 (8) into the ring compensator groove nº 233C (7) in order to hold it in place,

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).

8- Fit the new grommet raceway into the front hopper box mounting bracket nº 240 (6) while manually rotating it back and forth, so that the driving stem nº 243 which is in the lower part, gets into the hopper box motor spin axis nº 239 (17),

9- Tighten both 6 allen screws nº 244 for holding (2) the part nº 240 (6),
10- Hold the stripper plate spring nº 237, which is held in place by the raceway spring nut nº 238 (1),
11- 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 nº 218 (10) so the spindle can take the grommet while coming down,
12- Adjust the tightness of setting (Point 4.2. Adjust the tightness of setting and changing dies).
Remember you have to keep using the same washer model, you must not change it.

4.2. ADJUSTING THE TIGHTNESS OF SETTING, CHANGING DIES.

Machine model J-239 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-239 has two vertical axles:
- Nº 230 "Driving stem" (14), that governs the cutting pressure, and,
- Nº 215CA "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 7 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 nº 158A (18),
- Manually rotate flywheel nº 274 (clockwise) (19) until top set spindle nº 218 (10), is in its lowest part,
- Unscrew nut that holds the bottom die in place, then rotate the bottom die holder part nº 220 (12) until the bottom die part nº 219 (11) barely touches the top set spindle part nº 218 (10). Secure the bottom die holder part nº 220 through nut (12). The pressure of the spindle nº 218 (10) against the bottom die nº 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 nº 216 (16) you will be able to turn the top set nº 217 (9) to the right or left, until the distance between the bottom die nº 219 (11) and the top die nº 217 (9) equals approximately the thickness of the material used for setting the grommets,
- Manually rotate flywheel nº 274 (19) (clockwise) and check wether the adjustment of the dies is correct,
- Secure the top set nº 217 (9) through nut nº 216 (16),
- Replace the flywheel cover nº 158A (18).

4.3. SETTING GROMMETS ONLY, WITHOUT THE WASHERS.

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

Machine model J-239 can also place grommets without the washers.

With the machine unplugged:

- Empty the hopper box and the raceway of washers,
- On the "IMO V3" turn the washer detection switch to the "0" position. (See page 9, figure 2, point 6),

- Adjust the pressure of the grommeting and the cutting pressure (See page 12, point 4.2. Adjusting the tightness of setting, changing dies).

For placing grommets without washers, we advice you to replace the bottom die nº 219 (11) by another one specific to this task.

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 deposits and railings of any grommets and washers,
- Move the grommet railing to the left and secure it with a small puncher to the front raceway bracket part nº 272 (21).
- Next place the new complete set of dies and adjust the machine's pressure as explained in page 11, point 4.1 and point 4.2.
- In the control panel "IMO V3" the washer detector switch must be set to the "0" position. (See page 9, figure 2, point 6).

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 (15)).
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 28, 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 and washers, the machine may come with a litle air pipe attached to the washer raceway, which blows the washer down onto their right position, by means of an air compressor.
- For placing grommets and washers 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 and washers that you set each day, you can use a grommet and washer 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 nº 219 (11) that you use:

1) ring,  With washer

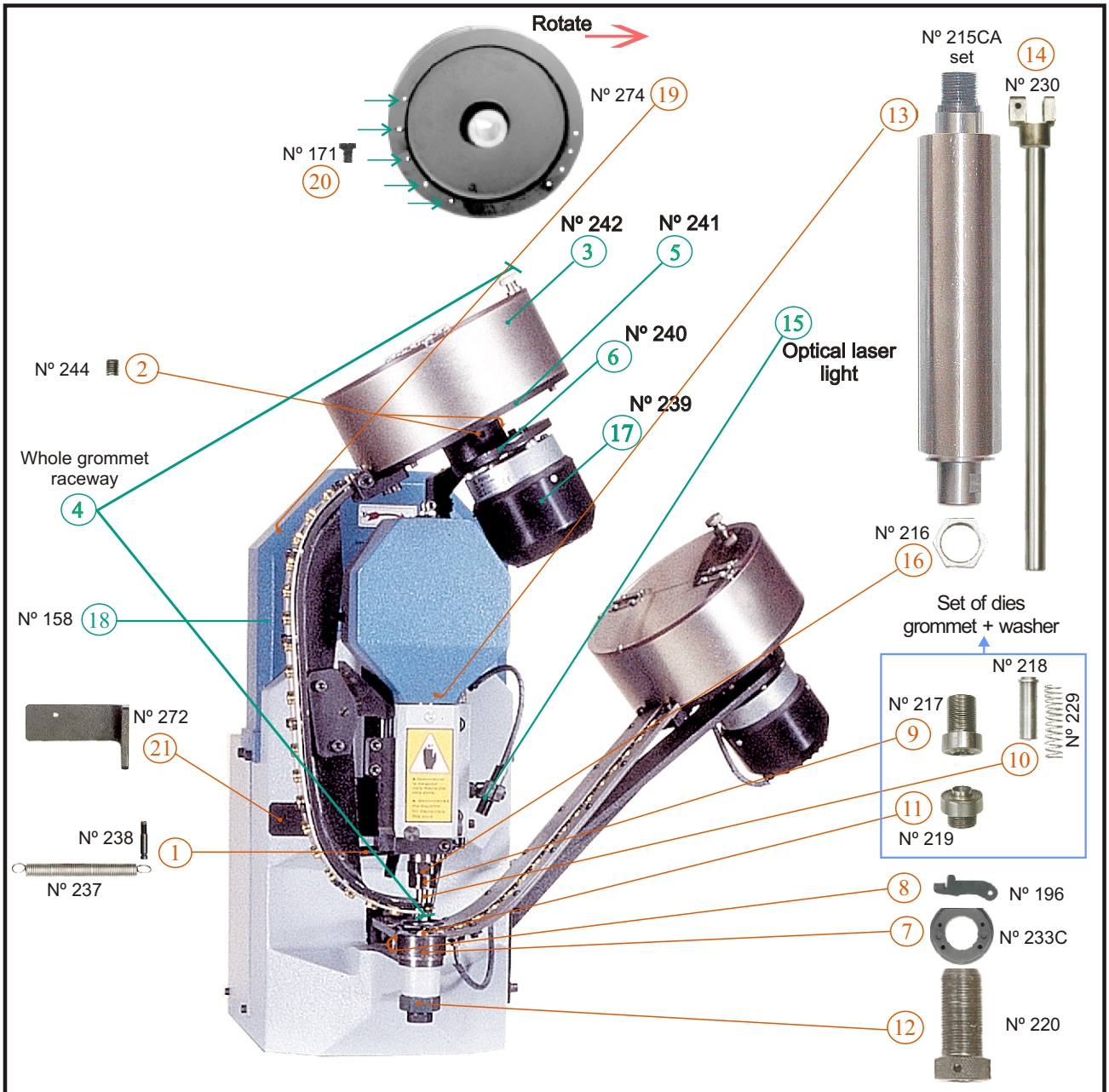
2) star-flower.  With washer

Ask for the flower-shaped or ring-shaped bottom die nº 219 (11) 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 nº 218 (10) may not be correct, and the spindle stops at a point lower than normal. If you change the position of the detector screw nº 171 (20) by screwing it into another hole (generally the one next to it) of the flywheel nº 274 (19), we will be able to stop the top set spindle nº 218 (10) 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.



It shows the parts with the adjustment reference.

It shows the picture of the part with the adjustment reference.

Pages 11, 12, 13.

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 “SAE 40”) 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.

Parts nº 149 flywheel optical detector and nº 338 optical washer detector, should be kept clean, and to achieve this, they should be wiped with a dry cloth.

If an optional laser light nº 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 two hopper box motors are totally sealed and do not require any maintenance.

Part nº 149 Flywheel optical detector

Part nº 338 Optical washer detector

Part nº 155 Laser light (optional)

ELECTRICAL PART

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

CHAPTER VI

VERY IMPORTANT
Machine disconnected from the electrical and pneumatic source.

TROUBLE SHOOTING

PROBLEM	CAUSE	SOLUTION
THE MACHINE DOES NOT WORK WHEN PRESSING THE PEDAL.	Check that the machine is correctly connected to a 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 7) 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 nº 149 is clean and next to screw nº 171 on flywheel nº 274 (approximately 1’5 mm.).	Clean part nº 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. If it continues not to work the IMO V3 is broken. DO NOT OPEN IT. Call the authorized distributor or directly to JOPEVI S.L.
DEFECTIVE GROMMETING.	Part nº 219 bottom set is worn out or broken.	Replace the bottom die nº 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.
IT GIVES SEVERAL BLOWS SIMULTANEOUSLY.	Home position detector nº 149 dirty or broken.	Clean part nº 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 nº 171.
	“IMO V3” electronic controller broken.	DO NOT OPEN IT. Call an authorized distributor or directly to JOPEVI, S.L.

VERY IMPORTANT
Machine disconnected from the electrical and pneumatic source.

PROBLEM	CAUSE	SOLUTION
JAMMED MACHINE.	Parts nº 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 nº 361 may be worn out or not too taut.	Lower the motor nº 160 a little bit with the 4 mount bolts nº 204. You must not tauten the drive belt nº 361 too much and if it is too worn out replace it with a new one.
FAILURE TO PICK UP GROMMETS.	The spindle nº 218 does not pick up the grommet from the raceway.	Part nº 268 and 132 are broken or worn out, replace them with new ones.
THE MACHINE CRUSHES THE HEAD OF THE GROMMETS.	The top die nº 217 or the grommet spindle nº 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.
SETTING BOTH GROMMETS AND WASHERS.	The machine fails to place washers.	Turn the washer detector to position “1”. See Chapter III. Point 6, page 9. Check that the pusher nº 297 is not jammed, due to oil.

VERY IMPORTANT
Machine disconnected from the electrical and pneumatic source.

PROBLEM	CAUSE	SOLUTION
SETTING BOTH GROMMETS AND WASHERS.	The machine fails to place the washers.	Clean washer detector nº 203 with a dry cloth. See Chapter V. Maintenance. Point 5.2. Electrical part of the machine, page 15.
SETTING GROMMETS WITHOUT WASHERS.	The machine sets grommets and washers.	Empty the hopper box and the raceway of washers. Turn the washer detector switch to position "0". See page 9, Point 6. Washer detector switch.
	The lower part of the grommet is not properly riveted.	Replace the bottom die nº 219 by a new one for grommets only. See Chapter IV. Adjustments. Point 4.3. Setting grommets only, pages 12 and 13. Adjust the tightness of setting.
IT WILL NOT CUT OR LEAVE MATERIAL RESIDUALS.	Part nº 218 top set spindle or part nº 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.
	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-239 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-239 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

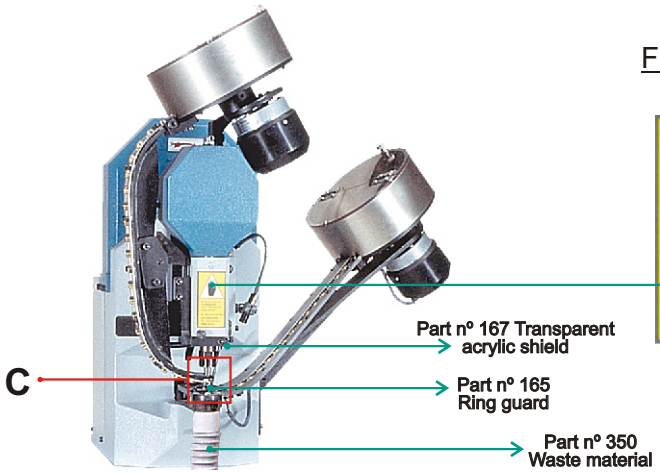


FIGURE 5

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 nº 167 transparent acrylic shield that allows vision but does not permit the worker to introduce his hands, indicated in figure 4.
- A ring guard part nº 165 indicated in figure 7, that prevents the worker from accidentally introducing fingers or hands in the grommeting area.
- The waste material pipe nº 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.

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.

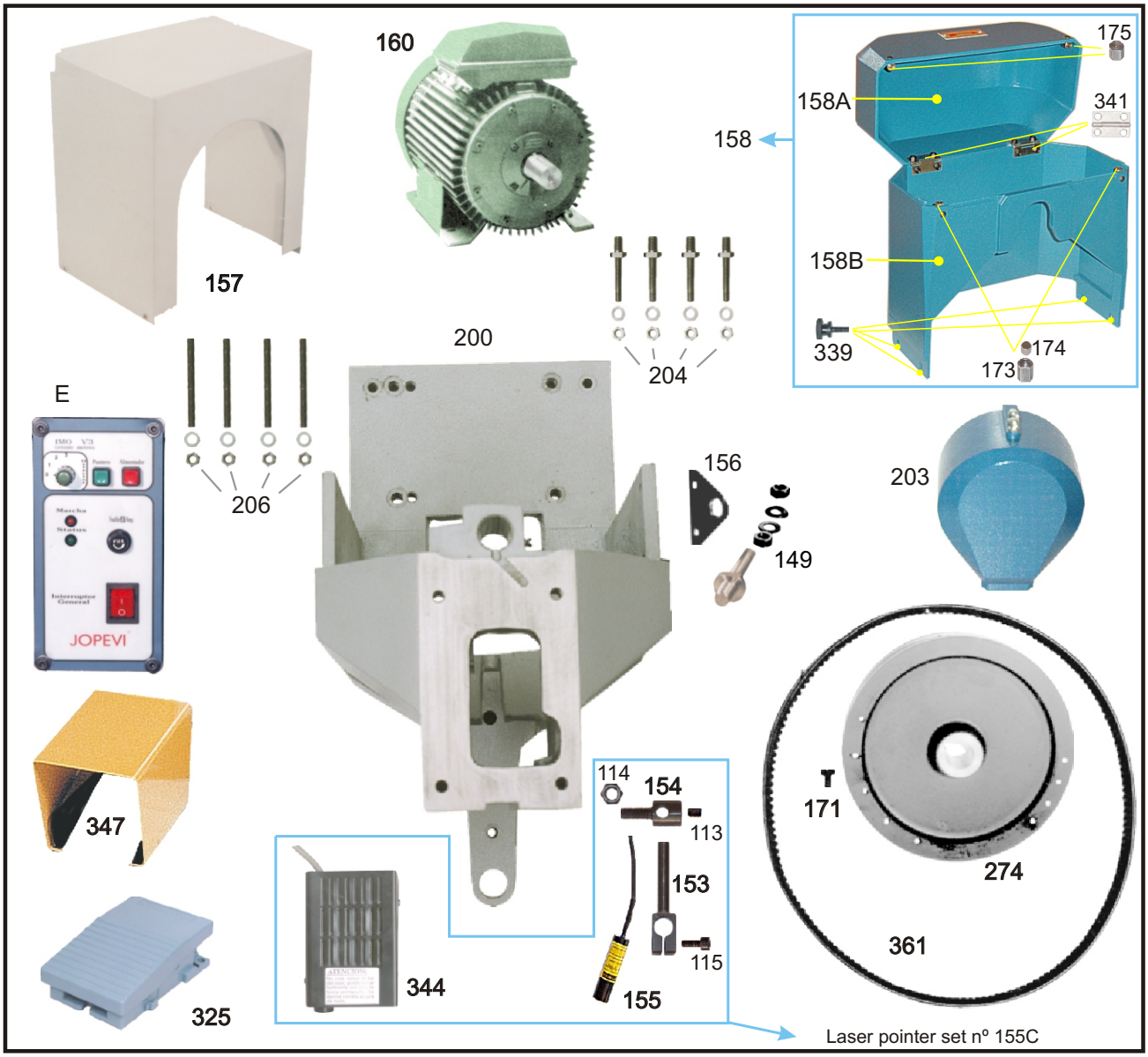
When the machine includes an optional device such as a laser pointer part nº 155C, you must not shine this pointer directly in anyone's eyes since it could be harmful, and keep it away from children.

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.

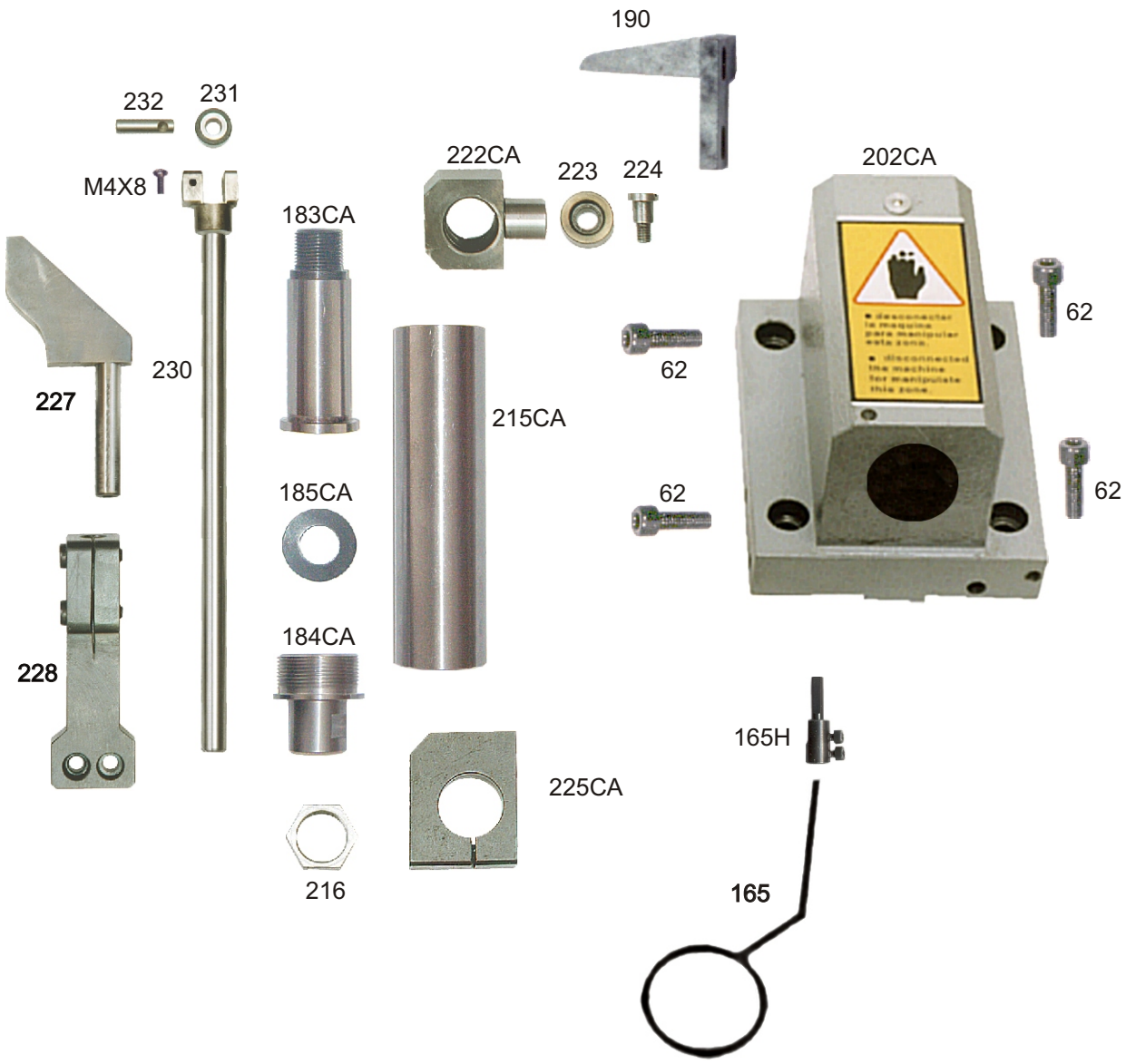
PARTS INDEX

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



Part nº E Electronic device IMO V3	Part nº 160 Main motor
Part nº 113 Threaded pin for part nº153	Part nº 171 Flywheel detector screw
Part nº 114 Nut for part nº 154	Part nº 173 Bracket for part nº 174 (2)
Part nº 115 Screw for part nº 153	Part nº 174 Magnet 7 mm (2)
Part nº 149 Flywheel detector	Part nº 175 Part to fix with magnet nº 174 (2)
Part nº 153 Laser pointer bracket	Part nº 200 Housing for machine
Part nº 154 Laser pointer threaded support	Part nº 203 Cover for plunger unit
Part nº 155 Laser pointer (optional)	Part nº 204 Motor mount bolts, nuts and washers (4)
Part nº 155C Laser pointer set (optional)	Part nº 206 Machine house bolts, nuts and washers (4)
Part nº 156 Flywheel detector bracket	Part nº 274 Flywheel
Part nº 157 Motor cover	Part nº 325 Electrical foot pedal
Part nº 158 Flywheel cover	Part nº 339 Screw for plastic cover (4))
Part nº 158A Upper part of flywheel cover nº 158	Part nº 341 Hinge (2)
Part nº 158B Bottom part of flywheel cover nº 158	Part nº 344 Transformer laser (optional)
	Part nº 347 Foot pedal protector
	Part nº 361 Drive belt

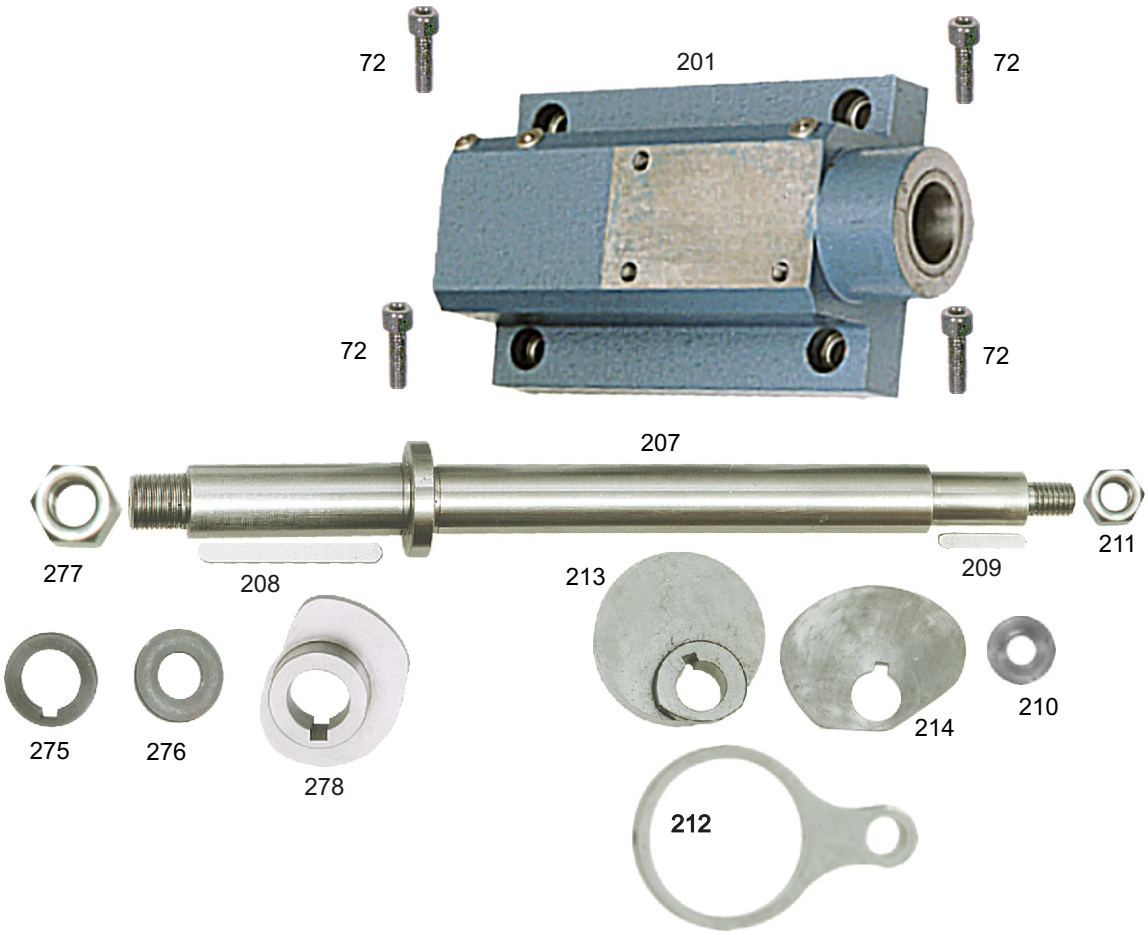
Note: The pictures are not on the same size scale.



Part nº 62 Screw to fix plunger housing (4)
Part nº 165 Ring guard
Part nº 165H Ring guard bracket
Part nº 190 Plunger
Part nº 183CA Upper part of washer compensator axle
Part nº 184CA Lower part of washer compensator axle
Part nº 185CA Washer for compensator axle
Part nº 202CA Plunger housing for part nº 215CA
Part nº 215CA Upper guide collar washer compensator
Part nº 216 Lock nut
Part nº 222 Upper guide
Part nº 223 Plunger guide wheel for part nº 222
Part nº 224 Screw for part nº 223

Part nº 225CA Bottom plunger collar for part nº 184CA
Part nº 227 Raceway cam
Part nº 228 Raceway cam bracket
Part nº 230 Driving stem
Part nº 231 Driving stem guide wheel
Part nº 232 Driving stem pin
Part nº M4x8 Screws M4x8 to fix part nº 232

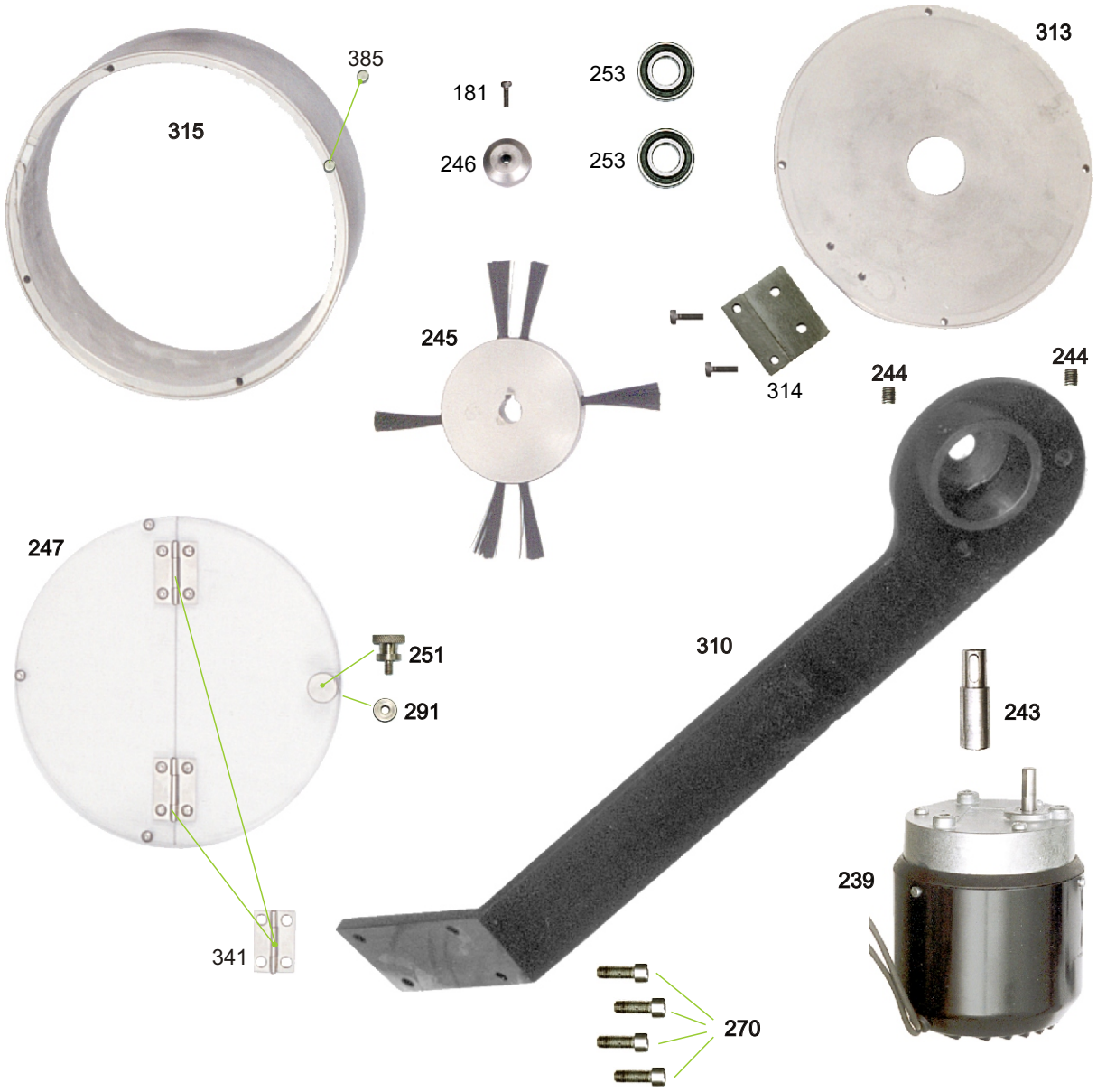
Note: The pictures are not on the same size scale.



Part nº 72 Screw for part nº 201 (4)
Part nº 201 Mainshaft housing
Part nº 207 Crankshaft
Part nº 208 Crankshaft key way
Part nº 209 Front crankshaft key way
Part nº 210 Front washer
Part nº 211 Front crankshaft nut
Part nº 212 Collar
Part nº 213 Collar insert
Part nº 214 Plunger cam
Part nº 275 Flywheel washer
Part nº 276 Flywheel spacer
Part nº 277 Flywheel nut
Part nº 278 Washer slide cam

WASHERS RACEWAY

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

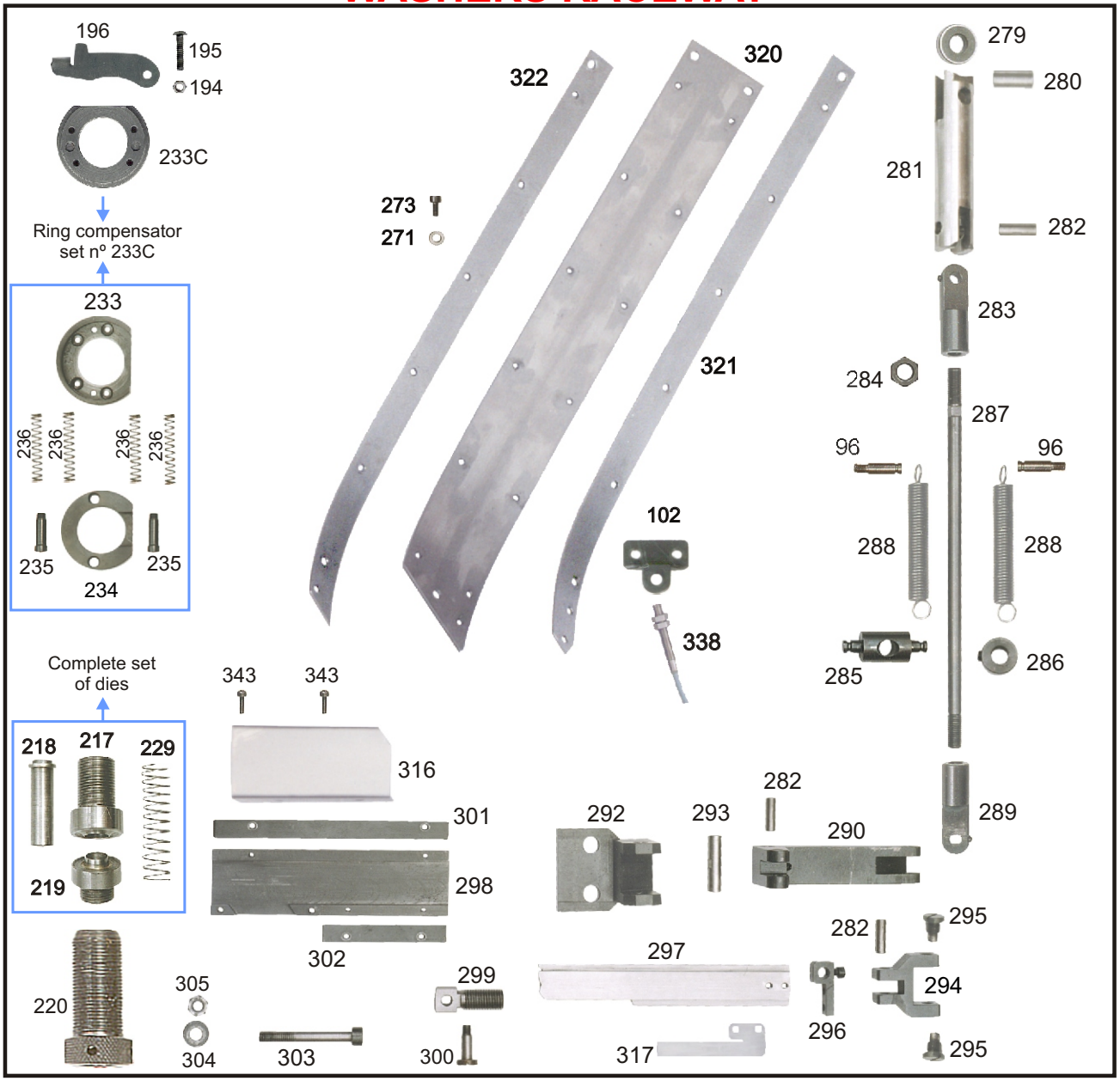


Part nº 181 Screws for part nº 246
Part nº 239 Hopper box motor
Part nº 243 Brush pin
Part nº 244 Threaded pin for holding hopper box (4)
Part nº 245 Brushes
Part nº 246 Brush spacer
Part nº 247 Acrylic box cover
Part nº 251 Konb for opening the hopper box cover
Part nº 253 Upper box bearing (2)
Part nº 270 Mounting studs (4)
Part nº 291 Knob washer

Part nº 310 Rear hopper box mounting bracket
Part nº 313 Hopper box bottom plate (washers)
Part nº 314 Rear hopper box mounting
Part nº 315 Hopper box housing (washers)
Part nº 341 Acrylic box hinge nº 247 (4)
Part nº 385 Magnet for holding the hopper box cover knob

WASHERS RACEWAY

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

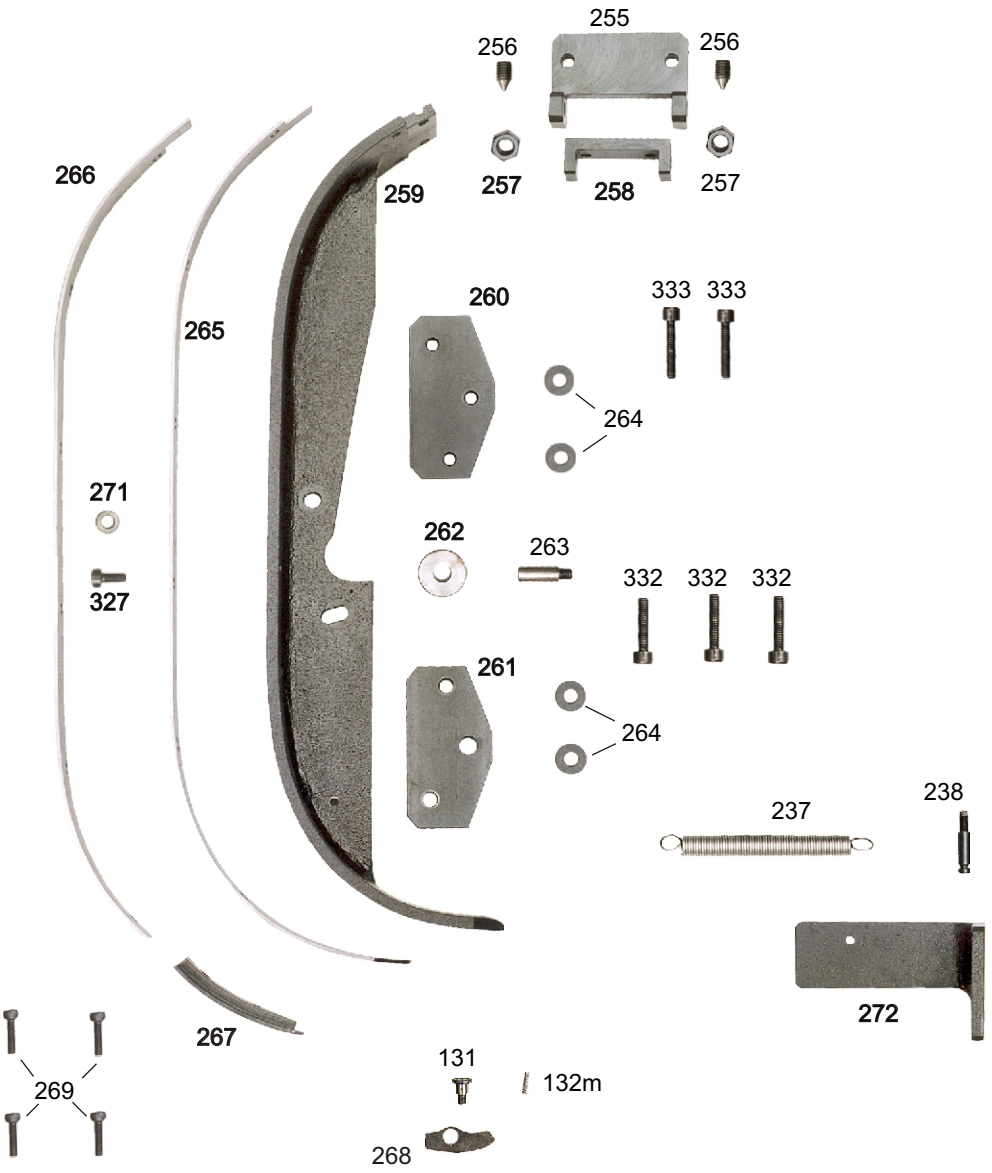


Part nº 96 Driving stem spring holder (2)
Part nº 102 Washer detector bracket
Part nº 194 Nut for part nº 195
Part nº 195 Screw for part nº 196
Part nº 196 Compensator base latch
Part nº 217 Top die
Part nº 218 Top set spindle
Part nº 219 Bottom die
Part nº 220 Bottom die holder
Part nº 229 Top set spindle spring
Part nº 233 Die base
Part nº 233C Ring compensator set
Part nº 234 Base washer
Part nº 235 Screw for base (2)
Part nº 236 Base spring (4)
Part nº 271 Raceway strip spacers
Part nº 273 Raceway screws
Part nº 279 Guide wheel slide cam
Part nº 280 Guide wheel pin (cam)
Part nº 281 Plunger for slide
Part nº 282 Connector pin (3)
Part nº 283 Top connector for part nº 287
Part nº 284 Driving stem nut for nº 283
Part nº 285 Spring holder
Part nº 286 Driving stem collar
Part nº 287 Driving stem for pusher

Part nº 288 Spring for pusher (2)
Part nº 289 Bottom connector
Part nº 290 Slide rocker
Part nº 292 Slide rocker bracket
Part nº 293 Slide rocker pin
Part nº 294 Slide yoke
Part nº 295 Slide yoke screw (2)
Part nº 296 Slide yoke bracket for nº 297
Part nº 297 Pusher
Part nº 298 Slide track
Part nº 299 Slide track stud
Part nº 300 Slide stud screw
Part nº 301 Long slide track rail
Part nº 302 Short slide track rail
Part nº 303 Slide track attachment screw
Part nº 304 Washer for nº 303
Part nº 305 Lock washer for nº 303
Part nº 316 Slide track cover
Part nº 317 Slide track cover spring
Part nº 320 Washer raceway strip
Part nº 321 Right raceway strip
Part nº 322 Left raceway strip
Part nº 338 Washer detector
Part nº 343 Screw (2)

GROMMETS RACEWAY

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

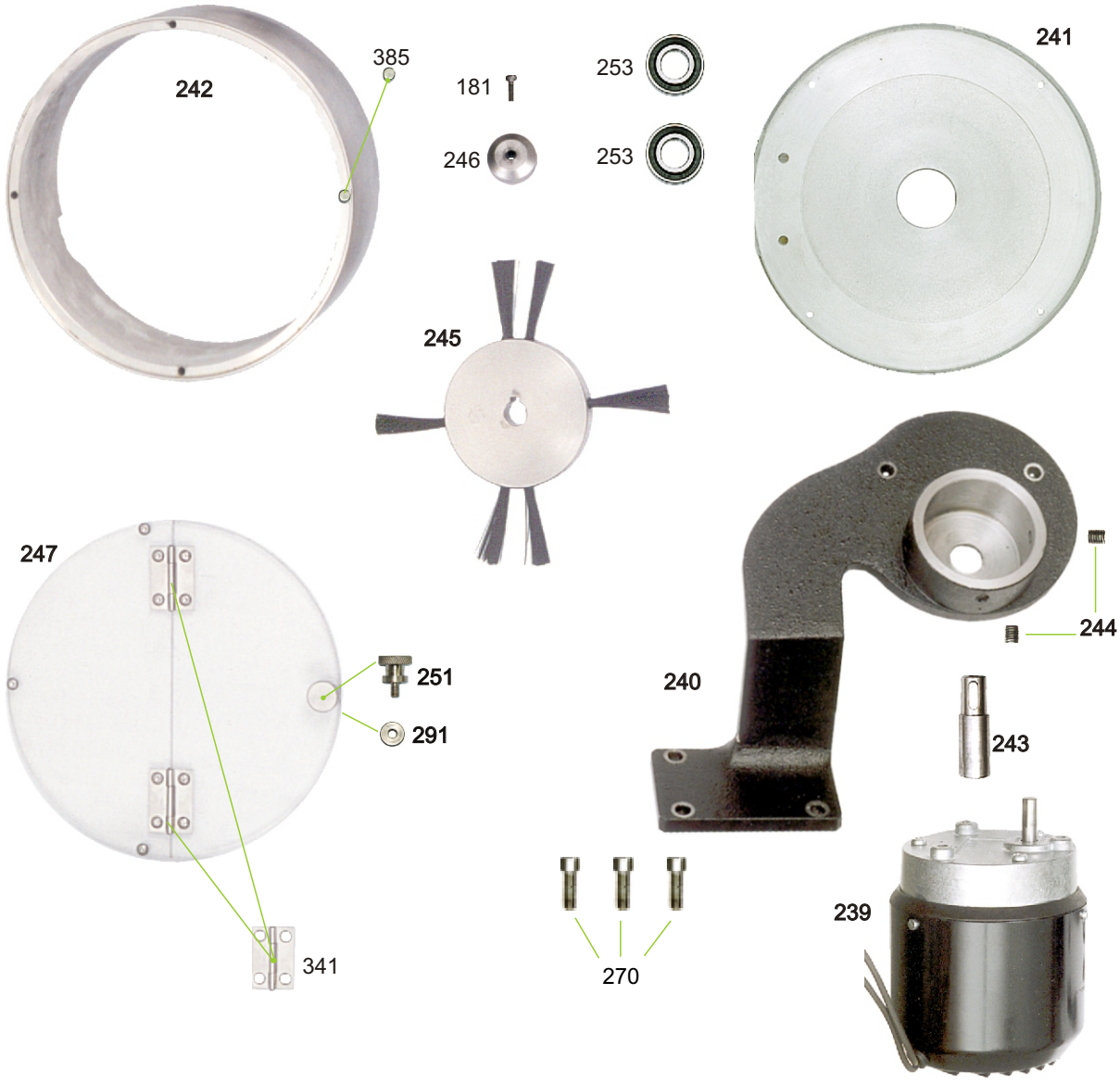


Part nº 131 Finger (cut off) screw
Part nº 132m Spring for part nº 268
Part nº 237 Stripper plate spring
Part nº 238 Raceway spring nut
Part nº 255 Front hopper lower bracket
Part nº 256 Mounting studs (2)
Part nº 257 Mounting stud nut (2)
Part nº 258 Front hopper lower bracket support
Part nº 259 Raceway support
Part nº 260 Outer raceway bracket
Part nº 261 Inner raceway bracket
Part nº 262 Raceway bracket spacer
Part nº 263 spacer stud
Part nº 264 Mounting spacers (4)

Part nº 265 Right strip
Part nº 266 Left upper strip
Part nº 267 Fixed guide
Part nº 268 Finger (cut off)
Part nº 269 Hopper box assembly screws (4)
Part nº 271 Raceway strip spacers (12)
Part nº 272 Front raceway bracket
Part nº 327 Raceway screws (12)
Part nº 332 Mounting screws (3)
Part nº 333 Mounting screws (2)

GROMMETS RACEWAY

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



Part nº 181 Screw for part nº 246
Part nº 239 Hopper box motor
Part nº 240 Front hopper box mounting bracket
Part nº 241 Hopper box bottom plate (grommet)
Part nº 242 Hopper box housing (grommet)
Part nº 243 Brush pin
Part nº 244 Threaded pin for holding hopper box (4)
Part nº 245 Brushes
Part nº 246 Brush spacer
Part nº 247 Acrylic box cover
Part nº 251 Konb for opening the hopper box cover
Part nº 253 Upper box bearing (2)
Part nº 270 Mounting studs (3)
Part nº 291 Knob washer

Part nº 341 Acrylic box hinge nº 247 (4)
Part nº 385 Magnet for holding the hopper box cover knob

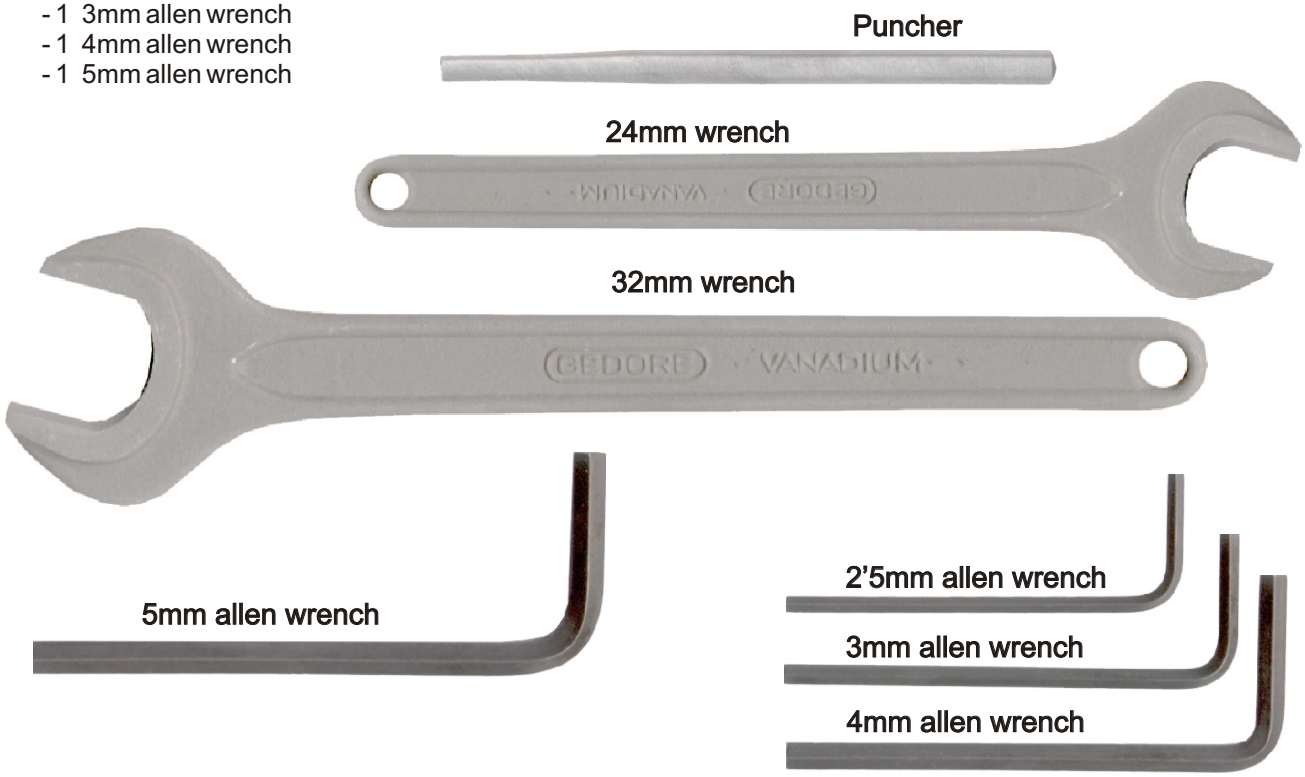
SUPPLIED TOOLS AND REPLACEMENT PARTS.

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 2'5mm allen wrench
- 1 3mm allen wrench
- 1 4mm allen wrench
- 1 5mm allen wrench

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



PARTS.

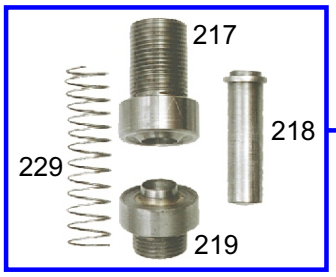
Included with the machine is a part nº 219 bottom die.

JOPEVI, S.L recommends to have a complete set of dies in stock parts nº: 217 - 218 - 219 and 229.

Part included

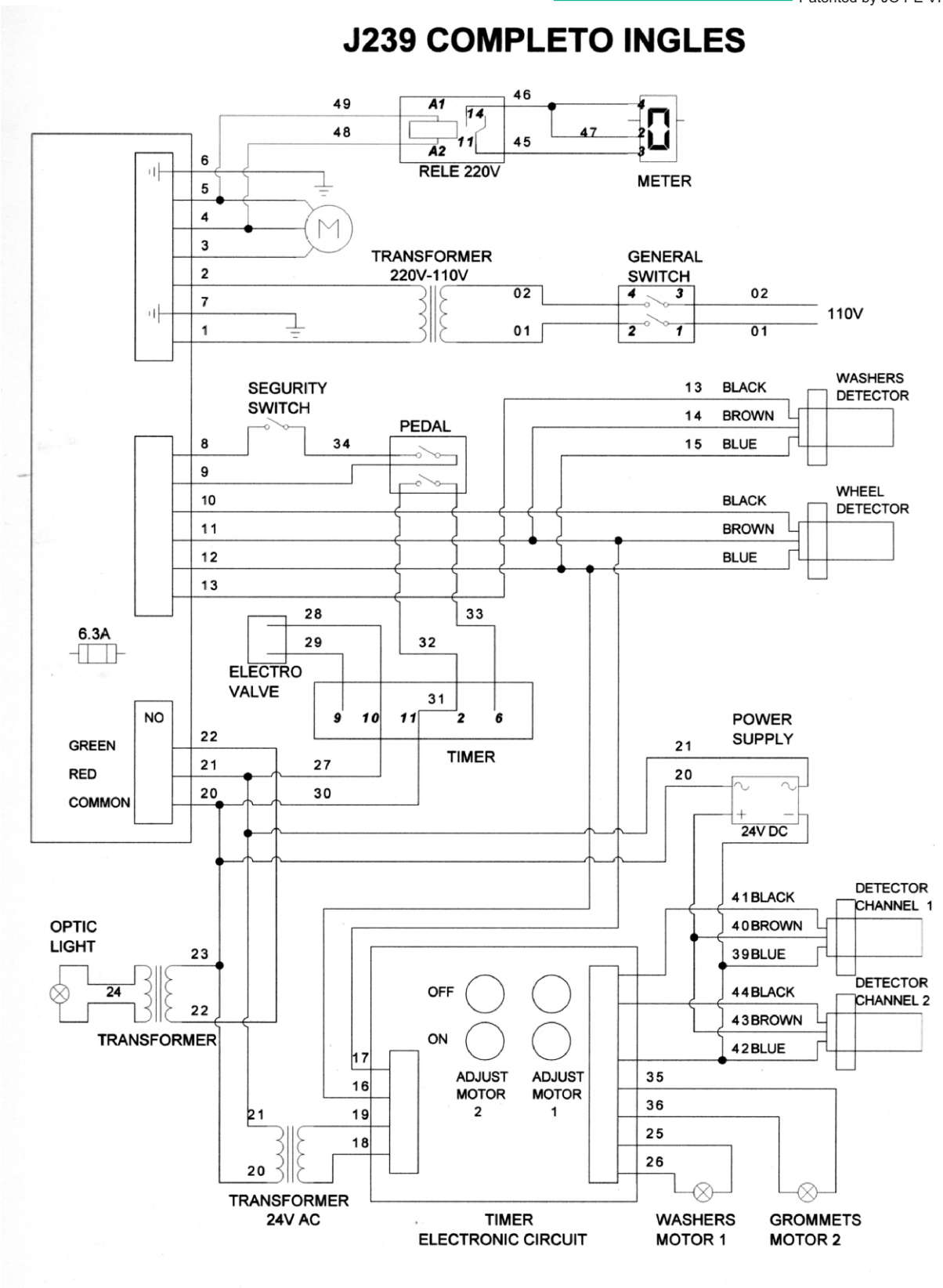
Part nº219
Bottom die

Parts recommended



ELECTRICAL INSTALLATION

ELCTRONIC UNIT "IMO V3"® Patented by JO PE VI



"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-239

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: