

# M165

## Double eyeletting machine





▶ Please read before using

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We are pleased that you have chosen the eyeletting machine M165. Your new machine has been carefully produced by the manufacturer and delivered to you in a ready-to-operate condition.

Please read this manual carefully before using.

Please keep these operating instructions carefully as a reference guide and for resolving problems.

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▶ The eyeletting machine comes in two versions

▶ Model OE.M.PM.M165.24\_25

for eyelets OE.65.45.32.06/15 (No. 24) + OE.65.45.40.06/15 (No. 25) and best price eyelets OE.69.45.36.06.381 + OE.69.45.36.15.381  
Scope of delivery: Eyeletting machine, tool, outlet hopper, replacement of channel spring, replacement of locking lever spring

On request with additional conversion kit OE.WKZ.M165.8E\_8E4

Eyeletting tool set suitable for eyelet machine M165  
Type: suitable for eyelets 8E and 8E 4  
Complete set comprises of:  
1 upper punch, 1 lower punch, 1 pilot pin, 1 eye channel, 1 magazine cover

▶ Model OE.M.PM.M165.8E\_8E4

for eyelets OE.80.62.35.06/15 (No. 8E) + OE.80.60.43.06/15 (No. 8E 4 long) and best price eyelets OE.80.59.36.06.381 + OE.80.59.36.15.381  
Scope of delivery: Eyeletting machine, tool, outlet hopper, replacement of channel spring, replacement of locking lever spring

On request with additional conversion kit OE.WKZ.M165.24\_25

Eyeletting tool set suitable for eyelet machine M165  
Type: suitable for eyelets 24 and 25  
Complete set comprises of:  
1 upper punch, 1 lower punch, 1 pilot pin, 1 eye channel, 1 magazine cover



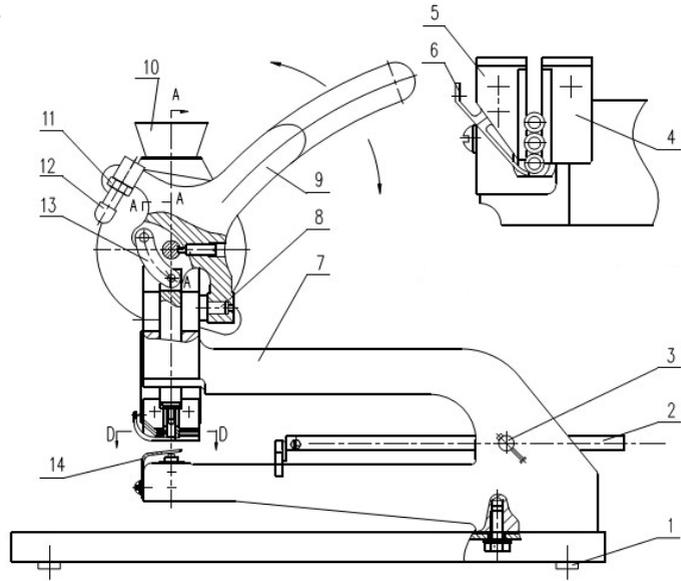
▶ First steps

- ▶ As soon as you release the hand lever, it returns to its original position.
    - ! Make sure there are no eyelets in the magazine and eye channel.
  - ▶ Put a drop of oil into the lubricating hole.
    - ! Use oil very sparingly, otherwise there is a risk of defiling the material to be eyed.
  - ▶ Now select the eyelet suitable for the machine and suitable for the thickness of the material to be eyed.
    - Fill the eyelets into the magazine.
      - ! Fill the magazine to a maximum of 2/3 to ensure reliable operation and low wearing.
  - ▶ Pull the eyelet channel to the left away from the eyelet tool and use the hand lever several times until there are a sufficient number of eyelets in the eyelet channel.
  - ▶ In order to achieve perfect results, the distance between the upper punch and the lower punch must be set.
    - ! CAUTION: Always leave the setting of the upper punch unchanged. (This is adjusted optimally at the factory.) If ever necessary, change the position of the lower punch only.
  - ▶ To do this, loosen the clamping screw and carefully adjust the height of the lower punch using the adjusting screw:
    - Turn the adjustment screw to the left to shift the position downwards.
    - Turn the adjustment screw to the right to shift the position upwards.
  - ▶ It would be best to push down the hand lever as far as it will go.
    - ! Please make sure beforehand that the lower punch is not set too high.
  - ▶ With the hand lever pressed, carefully bring the lower punch to the desired height and re-tighten it with the clamping screw.
    - ! Please ensure that your machine is regularly cleaned and lubricated with appropriate machine oil.
- ... and off you go.



Side view and front view

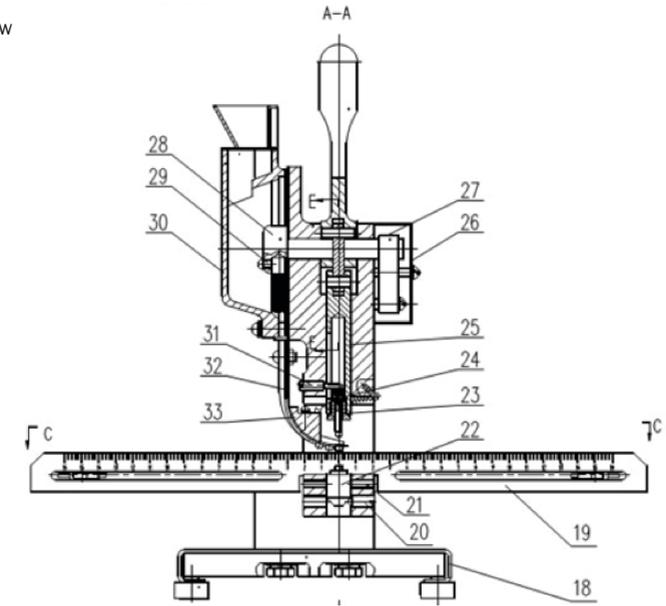
Side view



Parts list for drawing 1 – side view

Number	Description	Item number
1	Rubber base	JYS 0-3-8
2	Stop rod	JYSC 0-1-2
3	Tommy screw	JYS 0-5
4	Channel rail, left	JYS 0-2-3
5	Channel rail, right	JYS 0-2-2
6	Looking lever	JYS 0-2-6
7	Cast body	JYSC 0-1-1
8	Rubber buffer	JYS 0-1-3
9	Hand lever	JYS 0-1-1
10	Outlet hopper	JYS 0-9-7
11	Hexagon nut	GB807-88
12	Screw with rubber buffer	GB79-58
13	Clip	JYS 0-1-2
14	Wiping spring	JYS 0-9-12

Front view



Parts list for drawing 2 – front view

Number	Description	Item number
16	Butterfly nut	(GB62-88)
17	Side-gauge	JYSC0-1-3 (4)
18	Floor plate	JYS 0-3
19	Back-gauge	JYJ 0-3
20	Adjusting screw	(GB71-85)
21	Clamping screw	(GB77-85)
22	Lower punch	JYS 0-9-4
23	Upper punch	JYS 0-9-3
24	Pilot pin	JYS 0-4
25	Cylinder	JYS 0-1-4
26	Spring guard	JYS 0-9-6
27	Volute spring	JYJ 0-2
28	Brush wheel	JYS 0-8
29	Brush	JYS 0-8-1
30	Magazine cover	JYS 0-9-2
31	Catching pin impact screw	JYS 0-17
32	Channel plate	JYS 0-2-1
33	Trunking	JYS 0-2-5



## Possible problems and their solution

Problem	Possible cause	Solution
<b>1. No eyelets in eyelet feed</b>	Replace magazine cover	Remove the wrong eyelets from the magazine and replace them with suitable eyelets
	Bottom magazine opening blocked	Remove damaged eyelets or dirt from the magazine opening
	Loose magazine brushes	Tighten the magazine brushes again
	Worn out bristles of the magazine brushes	Replace magazine brushes
	Lower magazine opening worn out	Replace magazine cover
<b>2. Eyelets do not regularly slip in the feed channel when</b>	The distance between both channel rails is not correct	The distance is adjusted such, that the eyelets are well managed and can still slip easily (CAUTION: It is set at the factory – re-adjust only in exceptional cases)
<b>3. Eyelets are not taken over by the pilot pin</b>	Position of the locking lever is not correct	Adjust the locking lever such, that the eyelet is positioned exactly under the pilot pin
	Pilot pin pushing screw is damaged	Replace pilot pin pushing screw
	Pilot pin is damaged	Replace pilot pin
<b>4. Eyelet result not satisfactory</b>		
<b>Eyelet is closed too tightly</b>	Distance between upper and lower punch too short	Increase the distance between the upper and lower punches
<b>Eyelet is too loose</b>	Distance between upper and lower punch too much	Reduce distance between upper and lower punch
<b>Eyelet does not perforate the material</b>	Material to be eyed not suitable for self-punching processing	Pre-punch material
<b>Eyelet is not neatly formed</b>	Distance between upper and lower punch too much	Reduce distance between upper and lower punch
	Inserted shaft length too short for material to be eyed	Select an eyelet with sufficient shaft length
	Material to be eyed not suitable for self-punching processing	Pre-punch material
	Upper stamp, or lower stamp damaged	Replace upper stamp, or lower stamp
<b>Eyelet breaks during forming</b>	Inserted shaft length for material to be eyed is too long	Select an eyelet with shorter shaft length
<b>5. Hand lever does not return to its home position</b>	Volute spring defective	Replace volute spring



## Retrofitting to other eyelet diameters



1. Remove the eyelets from the magazine.



2. Loosen both fastening screws on the magazine cover and remove the magazine cover.

! (For example with the help of a magnet)



3. Loosen the two M3 screws securing the eyelet channel on the machine and carefully lower the eyelet channel.



4. Now loosen the fastening of the return spring and remove the eye channel.



5. Unscrew the upper punch from the cylinder using the spanner.



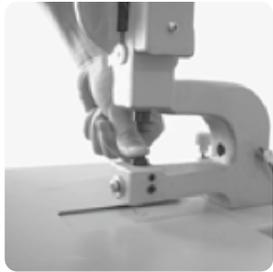
6. Now carefully pull the pilot pin out of the cylinder with pliers.



7. Loosen the screw connection of the wiping spring and remove the wiping spring.

8. Now remove the lower punch. To do this, loosen the fastening screw (top) and set and remove the lower punch as far up as possible using the adjusting screw (bottom).

❗ (If necessary, carefully aid the situation with suitable tools.)

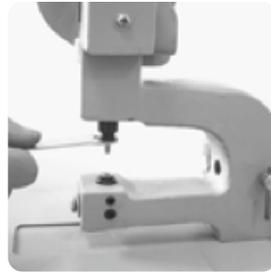


9. Insert the lower punch from the conversion kit and set it as far down as possible with the adjusting screw.

❗ (But do not clamp it yet with the fastening screw.)



10. Now carefully insert the corresponding pilot pin into the cylinder. Make sure that it is in the proper place.



11. Then screw the matching upper punch into the cylinder and tighten it with the spanner.

12. Now re-install the eyelet channel. First screw the return spring back to the machine and then carefully fasten the eye channel with both M3 screws.

❗ (Leave the screws slightly loose, as the eyelet channel must first be aligned with the pilot pin.)

Now align the eyelet channel such that the pilot pin moves exactly in the middle of the channel end piece

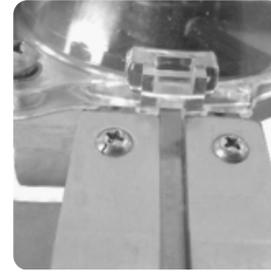
❗ (The pilot pin must not touch the eyelet channel!! and screw the eyelet channel firmly to the machine in this position.)



Correct



Incorrect



13. Now re-attach the magazine cover with both screws. Make sure that the lower magazine opening is positioned exactly above the eye channel.



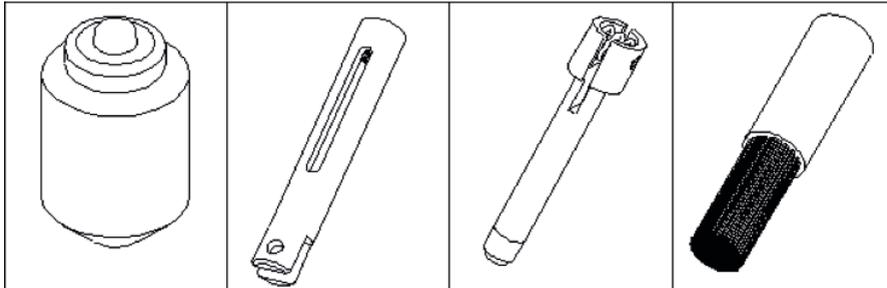
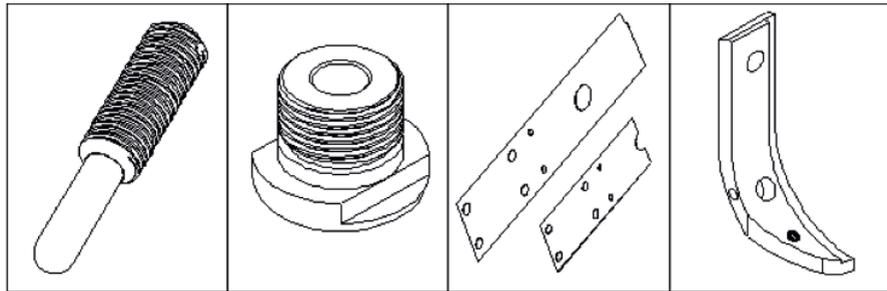
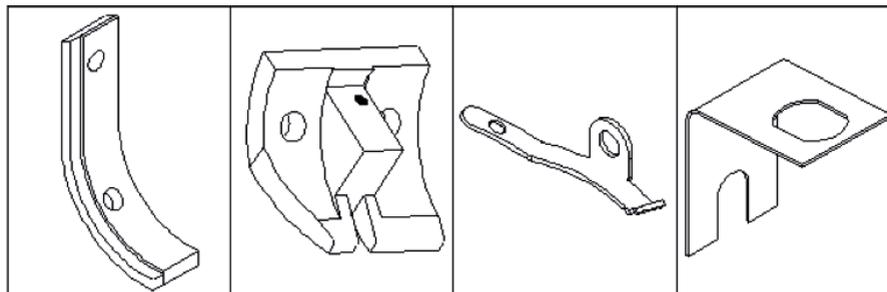
14. Now adjust the lower punch with the adjusting screw such that there is the correct distance for the material to be eyed and lock it in this position with the fastening screw.



15. Finally, insert the wiping spring, align it with the lower punch and secure it.



## Spare parts

Lower punch  
JYS 0-9-4Cylinder  
JYS 0-1-4Pilot pin  
JYS 0-4Magazine brushes  
JYS 0-8-1Pilot pin pushing screw  
JYS 0-9-4Lower punch  
JYS 0-9-3Limiting plate  
long + short  
JYS 0-2-1Channel rail, right  
JYS 0-2-2Channel rail, left  
JYS 0-2-1Channel end piece  
JYS 0-2-5Locking lever  
JYS 0-2-6Wiping spring  
JYS 0-9-12

## Matching metal eyelets

## Eyelets Nr. 24

OE.65.45.32.06  
3.2 mm shaft length, nickel-plated  
Head diameter: 6.5 mm  
Shaft diameter: 4.5 mm

OE.65.45.32.15  
3.2 mm shaft length, brass-plated  
Head diameter: 6.5 mm  
Shaft diameter: 4.5 mm

## Eyelets Nr. 25

OE.65.45.40.06  
4 mm shaft length, nickel-plated  
Head diameter: 6,5 mm  
Shaft diameter: 4,5 mm

OE.65.45.40.15  
4 mm shaft length, brass-plated  
Head diameter: 6,5 mm  
Shaft diameter: 4,5 mm

## Eyelets similar Nr. 24/25

OE.69.45.36.06.381  
3.65 mm shaft length, nickel-plated  
Head diameter: 6,9 mm  
Shaft diameter: 4,5 mm

OE.69.45.36.15.381  
3.65 mm shaft length, brass-plated  
Head diameter: 6,9 mm  
Shaft diameter: 4,5 mm

## Eyelets Nr. 8E

OE.80.62.35.06  
3.5 mm shaft length, nickel-plated  
Head diameter: 8 mm  
Shaft diameter: 6.2 mm

OE.80.62.35.15  
3.5 mm shaft length, brass-plated  
Head diameter: 8 mm  
Shaft diameter: 6.2 mm

## Eyelets Nr. 8E 4 long

OE.80.60.43.06  
4.3 mm shaft length, nickel-plated  
Head diameter: 8 mm  
Shaft diameter: 6 mm

OE.80.60.43.15  
4.3 mm shaft length, brass-plated  
Head diameter: 8 mm  
Shaft diameter: 6 mm

## Eyelets similar Nr. 8E

OE.80.59.36.06.381  
3.6 mm shaft length, nickel-plated  
Head diameter: 8 mm  
Shaft diameter: 5.9 mm

OE.80.59.36.15.381  
3.6 mm shaft length, brass-plated  
Head diameter: 8 mm  
Shaft diameter: 5.9 mm

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