

➤ Knee lever press for manual operation of eyelets, metal cord clips, rivets, corner protectors or press fasteners / pillar press fasteners

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Stand 12/2018

Your contact person



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Model



Pedal: version with mechanical's action with toggle, economic version, very versatile which allows the utilisation of dies called dies „C“, as spherical punches and hollow punches, dies for eyelets, rivets, presson's buttons in all the forms and dimensions.

Cod. S80010981

Technical features	Pedal
Theor speed rate	// c/1'
Working clearance	55-80 mm
Depth of application	130 mm
Working plan	1080 mm
Overall dimensions	850x600x1600 mm
Weight	55kg

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### Generality

Machines whose sole source of energy is direct human force, are not subject to EEC regulations (Art.1, paragrafo 3 – Direttiva 98-37 CE) (Art.2 “lettera a” Direttiva 2006/42 CE)

The recipients of this publication, generically defined as ‘users’, are all those who, for the part of their competence, have the need and/or the obligation to provide instructions or to intervene operatively on the machines. These subjects can be identified as follows:

- administrators;
- responsible for operational areas;
- department managers;
- operators directly involved in the transport, storage, installation, use and maintenance of the machines from the moment they are put on the market until the day they are scrapped;
- private direct users.

### Store the manual

This manual must be kept in a protected and dry place and must always be available on the machine for consultation. It is advisable to make a copy and keep it in the archive. In case of exchange of information with the manufacturer or with assistance personnel authorized by the manufacturer, refer to the plate data and to the machine serial number.

**The manual must be kept for the whole life of the machine** and in case of necessity (eg damage that partly compromises the consultation, etc.) the user is required to acquire a new copy to be requested exclusively from the manufacturer.

### Manual update

The manual reflects the state of the art when the machine is placed on the market, which is an integral part of it and complies with all the laws, directives and standards in force at that time; it can not be considered inadequate just because subsequently updated on the basis of new experiences.

Any changes, adjustments, etc. that they were made to the machines marketed subsequently do not oblige the manufacturer to intervene on the previous supplies and to consider the same and the relative manual deficient and inadequate.

Any additions to the manual that the manufacturer deems appropriate to send to users must be kept together with the manual of which they will be an integral part.

### Packaging removal & disposal

Open the packaging and access the machine without demolishing the base pallet; Recover the documents supplied with the machine, checking that there are no discrepancies between what is shown on the shipping documents and what is contained in the packaging itself; Dispose of the packaging as described.

The components of the packaging are products similar to normal urban solid waste so they can be disposed of without any difficulty. It is advisable to dispose of the products separately (separate collection) for proper recycling, however, in compliance with the specific regulations in force in the place of installation.

**DO NOT DISPOSE OF PACKAGING PRODUCTS IN THE ENVIRONMENT.**

### Preliminary checks

Removed the machine from the eventual packaging move it as instructed. Check that the machine and any accessories provided for in the scope of supply are intact and in perfect condition (no trace of rust, humidity, no bruising, etc.);

Check that the lane provided for reaching the installation site (moving the machine) is clear of all possible obstacles (things and people), provide for any protection barriers and reach the chosen installation site.

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### Storage

Storage can be carried out at the machine reception and is allowed for a maximum period of six months provided that:

upon receipt, any packaging (cash, protection, etc.) is intact as described in the previous paragraph. If situations are found that do not conform to what has been said, it will be necessary to free the machine from the packaging, verify its integrity and restore a new packaging.

**The place of storage must be a closed environment with a temperature not lower than -5 ° C, not higher than + 40 ° C and with a moisture content that does not exceed the value of 80% any packaging is not subjected to shocks, vibrations and heavy loads.**

### Subsequent machine recovery

In case of subsequent recovery of the machine after use, to maintenance operations carried out (cleaning and lubrication as provided in the specific paragraphs in this manual) this can be stored for a period of time **not exceeding three months** as long as:

in a closed environment, not dusty, free of aggressive agents and with the following characteristics:  
minimum temperature **not lower than -5 ° C**,  
maximum temperature **not higher than + 40 ° C**;  
humidity **not higher than 80%**;  
positioned so that deformations, crushing, breakage can not occur; not subjected to impacts, vibrations and overhanging loads.

**WARNING:** For storage periods longer than three months or in environmental conditions other than those specified above, request storage procedures from the manufacturer.

### Checking machine and supply kit

The machine and relative supply kit (as agreed with the manufacturer) must be in perfect condition. The supply is subjected to an accurate control procedure before shipment, however it is always advisable to verify that it is complete and in order when the material is received. In case of defects and / or incompleteness, immediately notify the manufacturer and follow the instructions before starting the machine.

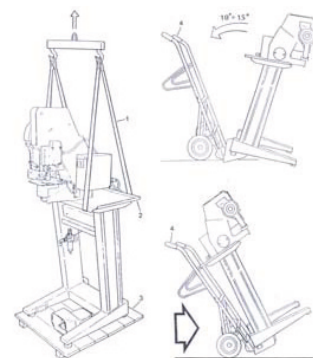
### Moving the machine

To remove the base pallet, lift the machine with fabric or nylon harness with a load capacity of at least 200 kg to be positioned under the base table. Remove the pallet.

Move the machine and position it in the chosen installation location. Not having suitable handling equipment, use a manual car with loading platform.

**ATTENTION:** The operation in this case requires the presence of two people for loading and unloading.

**Do not tilt the machine more than 10 ° ÷ 15 because the higher weight of the same is concentrated at the top (machine body).**



### Characteristics & functional description

The machines of this manual, intended for the use of , ' C , ' model spare parts, essentially consist of a body, cast in cast iron and mechanically machined, complete with all the leverages necessary for the subsequent re-packing operation.

The application is carried out with a mechanical drive (operator pedal force) which acts on a kinematic system that ensures the spindle travel for the execution of the application cycle.

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### Intended use

The machine is designed exclusively for the use of , ' C , ' spare parts for small metal parts (eyelets or rivets in general) or for the use of perforators. The application can be done on paper, cardboard, plastic materials, composites, leather, natural and synthetic fabrics. The small parts (such as eyelets or rivets) must be fed only manually by positioning them correctly on the application spare parts. **Application means the fixing of the article on the material or materials being processed by riveting.**

**The manufacturer declines all responsibility, direct and indirect, deriving from the use of unforeseen application articles. The indicated use is the only one admitted by the manufacturer.**

#### How to use

For models 80115981M, 80009981M, 80009982M, 80010981, the machine can only be activated by manually actuating the mechanical pedal.

**The above-mentioned mode of use is the only one allowed by the manufacturer.**

#### Unlicensed use mode:

It is not allowed to use for processing, on products that due to their nature (structural characteristics) can cause projections, fragments or splinters, caused by their breakage. It is not allowed to use on products subjected to pressure, compression, cutting and / or deformation can explode or explode.

The use is not allowed to people unfit for work, according to the physical aspect (cause of impairments), the psychological aspect (mental balance, sense of responsibility) and above all to the minors of 16 years.

It is not allowed to carry out maintenance work by unqualified personnel.

### Operating environment

The expected operating environment must have the following characteristics:

Temperature -5 - +40° C  
Maximum relative humidity **80%**  
Altitude **1000 m s.l.m.**

The machine must not be used in open areas and / or exposed to atmospheric agents and in the environment with corrosive and/or abrasive vapors, fumes or dust, with the risk of fire or explosion and in any case where the use of explosion-proof components is prescribed.

### User

**Who operates on the machine must necessarily be a person who has the following requirements:**

- Person integrates physically
- Person integrates psychologically
- Person with a sense of responsibility
- Person over the age of 16
- Person with adequate education, training, knowledge of the rules and regulations for the prevention of accidents
- Person with sufficient training and acquired experience on the operation of the machine and the products that it can apply.

### Dimensional technical characteristics

Overall dimensions (AxBxC)	550x650x1370mm
Working table height (D)	965mm circa
Area of application light x depth	50-80x130mm
Model mass	55 kg

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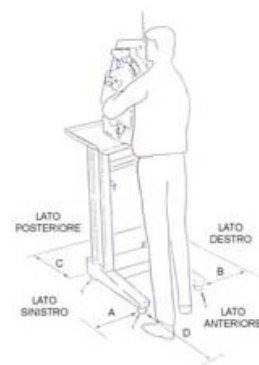
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## Installation

The machine must be installed following the information provided scrupulously. **Do not fall below the indicated dimensional values**, which represent the minimum space necessary for the operator or qualified personnel, when required, to carry out every sequence of work and / or maintenance. Position the appliance in the area designated for it and proceed with the bubble leveling operation by acting appropriately on the height adjustable support feet.

### Operator

The expected position of the operator, during normal work is in front of the machine.



## Lighting

The machine is not normally equipped with its own lighting system. The ambient lighting level must always be such as to guarantee operation in the maximum possible security, in relation to the type of use for which it is intended.

On request, (for applications on non-perforated materials) a spotlight projector is provided, capable of projecting a light cross to highlight the point of application (Voltage 12 V DC 5 W)

**In the case of maintenance operations, located in parts that are not sufficiently illuminated, it is mandatory to have portable lighting systems, taking care to avoid cones of shade that prevent or reduce the visibility of the point where you are going to work or the surrounding areas.**

## After installation

Before performing the functional tests of the machine, carry out the following checks:  
Check that the intended work area is free of obstacles (things and people);  
Check that the area involved in the application (under the spindle axis of the spare parts spindle) is free of tools and/or other foreign objects.

## Operation

**ATTENTION: Before starting any operation, it is mandatory to read this instruction manual completely. The guarantee of good operation and full performance compliance of the machine, in absolute safety, at the service provided is strictly dependent on the correct application of all the instructions contained in this manual.**

**Operator:** The operator must be a person psychophysically suitable for the operation of the machine in its intended use. The operator must not allow anyone to approach during the use of the machine and must prevent its use by personnel unrelated to activities in progress at the place of use. It must follow the instructions given in this manual to obtain maximum performance, minimum consumption and greater safety for itself and for others when using the machine.

**In particular, the indications concerning:**

**Article of application:** each machine can apply several items, check that the application parts are intended for the small parts in use. Quality and dimensional constancy of this are the first prerequisites for the good functioning;

**Adjustments:** adjustments, especially those requiring intervention with removed and / or particular protection / attention by the operator, must be carefully evaluated before the operation is carried out.

**ATTENTION:** it is recommended to read the specific paragraph several times and, if in doubt, consult the manufacturer indicating the passage in the text that is difficult to understand.

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## During use

### Intended use - Criteria and precautions for use

The correct use of the machine allows full use of the performances that the same is able to provide **in complete safety**. These potentialities are guaranteed **only** by following the instructions below, and therefore:

**ALWAYS** follow the instructions and instructions given in the manual and check the integrity of the machine components before starting production.

**ALWAYS** ascertain the adequacy of the state of conservation (cleaning, lubrication) and maintenance of the machine and its main components.

**ALWAYS** operate in the best lighting conditions with regard to the entire installation and in particular in the area of application.

**ALWAYS** for all operations, use suitable work clothing, in compliance with safety regulations in the workplace.

**ALWAYS** keep the floor, around the machine clean and dry.

**ALWAYS** report malfunctions (suspected of breakage, incorrect movements and noise outside the norm, etc.) to the department manager and put the machine in an out of service condition

**ALWAYS** respect the scheduled maintenance schedule

**ALWAYS** use the machine indoors, in an operating environment as prescribed in this manual.

**ALWAYS** use original spare parts and application articles that comply with the manufacturer's technical requirements.

**ALWAYS** in case of doubtful interpretation of the operating sequences described in this manual, contact the manufacturer; do not perform any operations unless the operating procedures are well understood.

## Regulation

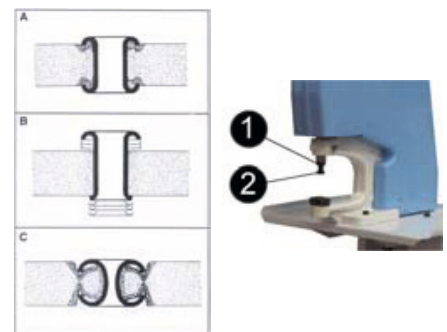
### Adjustment of application pressure

Adjustment is necessary when the part rather than adhering perfectly to the work material (item **A**) fails to penetrate the material, (**insufficient pressure, dic.B**), or causes incisions of the same (**excessive pressure, details C**), and in any case **when material of different thickness must be used**. To carry out this adjustment, act on the threaded spigot holder protruding from the lower part of the spindle.

Remove the fixed transparent protection, loosen the locking nut (1); screw (**to decrease the pressure**) or unscrew (**to increase the pressure**) the threaded codule (2) 1/4 of a turn at a time.

Once the adjustment has been made, lock the nut and reassemble the transparent protection.

**Do not approach the area where the spare parts are applied with your fingers; the operator, only responsible, must prepare the most appropriate measures to eliminate the risk of injury.**



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#### Unintended use

#### CONTRAINDICATION OF USE - IMPROPER IMPROPER USE AND NOT FORESEEABLE

The use of the machine for unauthorized maneuvers and its improper use and lack of maintenance can result in dangerous situations for personal safety as well as compromising the functionality and intrinsic safety of the machine.

The actions signed, which obviously can not cover the whole range of potential possibilities of 'improper use', constitute those that are reasonably more predictable, and are to be considered absolutely prohibited, therefore:

**NEVER** use the machine in unexpected environmental conditions.

**NEVER** allow the use of the machine to inexperienced personnel and especially to minors of 16 years.

**NEVER** allow the use of the machine to non-psychophysically suitable personnel.

**NEVER** use the machine if not equipped with suitable work clothes in compliance with the safety regulations in force in the place of installation.

**NEVER** modify and / or tamper with the safety devices of the machines and the machine itself.

**NEVER** use the machine for a service other than the one for which it is intended.

**NEVER** apply eyelets, rivets, or tools to drill metal materials

**NEVER** use the machine for applications on materials not provided for the class of the article used.

**NEVER** modify the functional / performance characteristics of the machine and / or its components in order to increase its production potential.

**NEVER** use the machine or perform maintenance operations on it under insufficient lighting and/or visibility conditions.

**NEVER** use the machine if you have not fully understood the contents of the instruction manual.

**NEVER** perform provisional repairs or restoration work that does not comply with these instructions.

**NEVER** use non-original spare parts not provided by the manufacturer.

**NEVER** entrust repair work to inexperienced personnel.

#### Ordinary maintenance

The maintenance program includes ordinary operations, ie operations to be carried out daily, before the start of the activity and which do not require particular use of tools and equipment and of a periodic type which may involve partial dismantling of components and also removal of protections.

#### Daily interventions, before start-up.

General visual check of the whole machine (evident deformations or breakings of structure, protections, etc.).

**ATTENTION:** If there are evident breakages, deformations, irregularities in operation, etc., interrupt any operation in progress requiring the intervention of specialized and authorized personnel of the manufacturer.

Daily interventions at the end of production stop.



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Carry out a thorough cleaning generated of the entire machine using only compressed air, removing dust and residues of materials. To perform this operation, wear eye protection.

#### Interventions every 200 hours of operation

Lubricate with a few drops of oil the articulated parts and the pins of the levers.

**WARNING:** After working on oils, greases, consumables, cleaning materials, etc., they must be recovered and disposed of in compliance with the current provisions of the law. It is absolutely forbidden to disperse these products in the environment as they could cause damage to the environment and to people.

#### Replacements

##### Replacement of spare parts

Remove the fixed transparent protection.  
Loosen the upper spare and replace it  
Loosen the locking nut of the lower spare;  
Remove the lower part and replace it with the new one;  
Screw the wheel back on  
Adjust the application pressure if necessary  
Replace the fixed transparent protection.

**ATTENTION:** Any other intervention to replace components due to breakage or due to wear limits, to be carried out by qualified personnel authorized by the manufacturer.  
In particular cases, subject to the manufacturer's authorization, personnel with proven ability to experience the user may receive extraordinary interventions for substitutions and / or repairs.

#### Replacements

**The eyelet is crushed and does not exceed the material**

The material is not perforated and the eyelet is not perforating.  
The eyelet is not suitable for the perforation of that material.  
The material is pre-punched but the hole is too small for the eyelet.

Pre-drill the material.

Use an eyelet that is more suitable for perforation.

**The eyelet is rebounded too little**

The eyelet is too short for the material used  
The eyelet is too light and not suitable for the material used because it can not cross it  
The rivet has a narrow throat; it can not widen the edge of the eyelet but only causes it to be crushed

Use a longer eyelet  
Use an eyelet of greater thickness or more resistant material

**The eyelet is broken in the rejecting phase**

Eyelet engraved for star riveting  
Worn out riveter or with too wide throat not suitable for that eyelet

Use an eyelet for double edge riveting  
Use a new or suitable rivet for the eyelet used

**The eyelet makes it from the material**

The eyelet is too little reiterated because the rivet has a too narrow throat not suitable for the eyelet used  
The eyelet is repeated too much and has affected the material

Replace the rivet with one suitable for the eyelet used

Decrease the application pressure

#### Scrapping

Should the machine be scrapped, its parts must be disposed of separately, taking into account the different nature of the same (eg metals, oil, grease, plastic and rubber, etc.) by assigning specialized and qualified companies for the purpose and in any case in compliance with the provisions of the law in force in the place of installation regarding the disposal of industrial waste.  
**WARNING:** Do not leave the machine in transit areas as this could be a serious danger for people and animals; any responsibilities will be attributed to the owner of the machine.