Two-part eyelets DEN0615

Instructions for use and safety information

Self-piercing eyelets with matching washers for reinforcing holes in leather, textiles, tarpaulins, banners, paperboard and cardboard.



Representative product image.
See the pack and table for the size.

Eyelet and washer

Design: two-part

Finish: nickel-plated

Pack contents: 100 pieces with matching washers

Sizes, item numbers and GTINs

Inside Ø	Outside Ø	Shank length	Item no.	GTIN / EAN
6 mm	12 mm	5 mm	**10110-1**	4260606870827
8 mm	16 mm	6 mm	**10110-2**	4260606870841
10 mm	18 mm	6 mm	**10110-3**	4260606870858
12 mm	21 mm	6 mm	**10110-4**	4260606870872
15 mm	27 mm	6 mm	**10110-5**	4260606870889

Series item 10110 · GTIN 4260606870834

NOTE - Match the shank length to the material

Allow for all material layers, hems and reinforcements. Enough shank must remain exposed to roll over the washer. Inside diameter and shank length do not specify the maximum material thickness.

1 Safety instructions

CAUTION - Small parts can be swallowed

Keep eyelets and washers away from small children. Pick up dropped parts immediately and close the pack after use. Eyelets and washers are not toys.

CAUTION - Risk of cuts and punctures

The shanks of self-piercing eyelets may have sharp edges. Discard damaged, bent or burred parts. Even if the eyelet head is rounded, do not run bare fingers over possible burrs.

CAUTION - Crushing hazard at the tool

Keep hands and fingers clear of the tool area when punching and pressing. Guide the material only by its edges. Do not operate the lever while loading, changing dies or removing scraps.

CAUTION - Secure mounting and lever movement

Secure the press to a stable workbench as described in its instructions. Keep other people clear of the lever area. Return the lever in a controlled manner; stop if a blockage occurs and do not force it.

NOTICE - Use matching eyelets, washers and dies

Use only a washer suitable for DEN0615 and a matching upper and lower die set. The sizes must match. The same nominal diameter alone does not guarantee die compatibility.

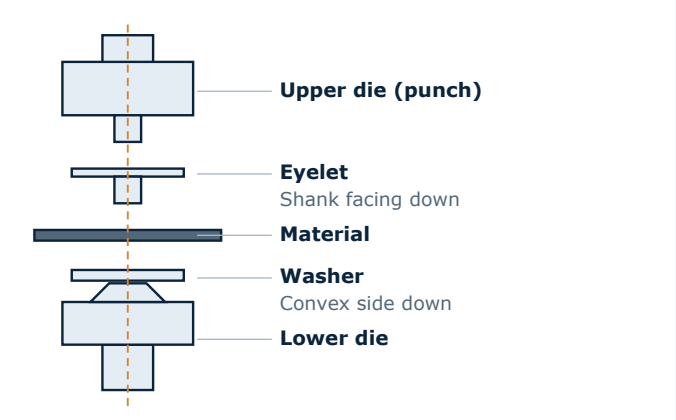
NOTICE - Check the material and the result

First work on a test piece of the same thickness. Do not use assemblies that are loose or crooked, have protruding edges or show tears in the material. A larger opening alone does not indicate a higher load capacity.

Read before use, retain for future reference and pass on with the product. Also follow the instructions for the press or setting tool used.

2 Preparation and fitting the eyelet

Example using the HP-3M with the matching DDIE0615 die set.



Arrangement for pressing

The eyelet sits on the upper die, the material is between the parts and the washer rests on the lower die. Pressing forms the shank over the washer.

01

Prepare the press and dies

Secure the press and check it for damage. Fit the matching upper and lower DDIE0615 dies securely. Use the appropriate set for 6, 8, 10, 12 or 15 mm.



02

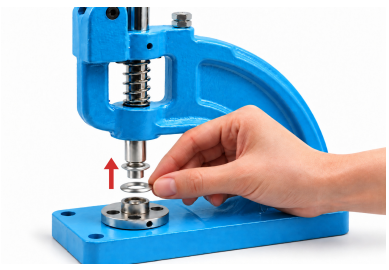
Check the material and pre-punch a hole

Mark the position, reinforce thin material if necessary and check the total thickness. For a clean result, we recommend a suitable pre-punched hole even with self-piercing eyelets: the shank should fit through without distorting the material; the hole must not be unnecessarily large.

03

Fit the eyelet to the upper die

With the lever at rest, push the eyelet onto the pin from below. The eyelet head rests against the upper die and the shank points downwards. The eyelet must sit straight and securely.



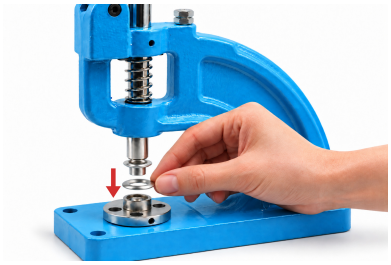
Application images: setting a two-part eyelet with washer using the HP-3M.

3 Setting and checking the eyelet

04

Position the washer

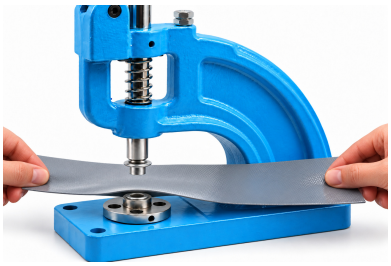
Place the matching washer centrally on the lower die. In the HP-3M arrangement shown here, the convex side faces downwards. The washer must sit level in its seat.



05

Insert the material flat

Place the material between the eyelet and washer. Align the pre-punched hole exactly with the centre of the dies. Avoid folds and hold the material by its edges. Keep fingers clear of the pressing area.



06

Press evenly

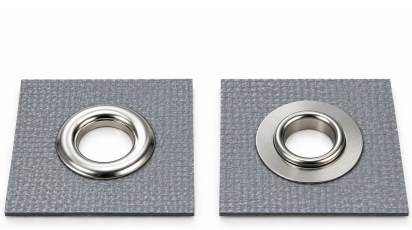
Lower the lever evenly and in a controlled manner until the eyelet and washer are joined. Stop if you feel unusual resistance. Then return the lever in a controlled manner.



07

Check the front and back

The eyelet and washer must sit firmly and flush. The shank must be formed evenly over the washer. Check for protruding edges, loose parts and tears in the material; discard faulty joints.



i

NOTE - Make a test setting first

First check the dies and adjustment on an offcut of the same material.

4 Storage, disposal and contact

Storing eyelets

Store in the closed, labelled pack in a dry place out of children's reach. Keep the five sizes separate and do not mix eyelets and washers when replenishing stock.

If the result is faulty

Stop work. Check the die size, washer position, hole size, material thickness and adjustment. Replace damaged or unevenly formed eyelets. Do not try to correct them by applying more force; make a new test setting before continuing.

Cleaning and disposal

Remove material scraps only when the tool is at rest and secured against accidental operation. Follow the equipment instructions for maintenance. Collect loose or damaged metal parts in a closed container and dispose of them in accordance with local collection requirements. Sort empty packaging by material.

Manufacturer and distributor

Mario Goetz · oesen-de.de

Habichtstrasse 22 · 81827 München · Germany

Telephone +49 8121 999 9 771

info@oesen-de.de · www.oesen-de.de

NOTE - Product enquiries

Please state the item number and size shown on your pack. The details for all five sizes are listed on page 1.

Further information: DEN0615 in the shop (German) · Two-part eyelet fitting FAQ (German)