Operating instructions

HANG 102-15 eyelet press

Manufacturer: **Hang GmbH.** This manual eyelet press sets two eyelets simultaneously, spaced 80 mm apart, in a stack of paper.



Machine overview

1, 2	Stops · Fig. A
3	Lower die · Fig. A
4	Hand lever · Fig. A
5	Rear stop wing handle · Fig. B
6	Rear stop screw connection · Fig. B
7	Rear stop adjusting handle · Fig. B
8	Clamping lever · Fig. C
9	Side stop · Fig. C
11	Eyelet hopper · Fig. D
12	Eyelet hopper lid · Fig. D
13	Knurled lid screw · Fig. D
21	Upper die · Fig. J
29	Lubrication points · Fig. O

Further item numbers are explained in the relevant work steps.

IMPORTANT – Read before first use

- Read these instructions in full and follow the guidance.
- **CAUTION:** Keep fingers out of the area beneath the dies.
- **NOTICE:** Operate the hand lever only with material inserted. Repeated eyelet setting without material can damage the dies.
- **NOTICE:** Use only the eyelet size for which the machine is set up.
- **NOTICE:** Observe the marking when fitting the hand lever.
- **CAUTION:** The spiral spring is preloaded. Proceed carefully during disassembly. Empty the eyelet hoppers beforehand.

Getting started

Notices and symbols

CAUTION	Possible risk of injury.
NOTICE	Possible damage to the machine or other property.
NOTE / TIP	Helpful information on use.

Use: The machine sets two eyelets, spaced 80 mm apart, in a stack of paper. Other applications are not intended uses.
Items supplied: Eyelet press and tool.

01

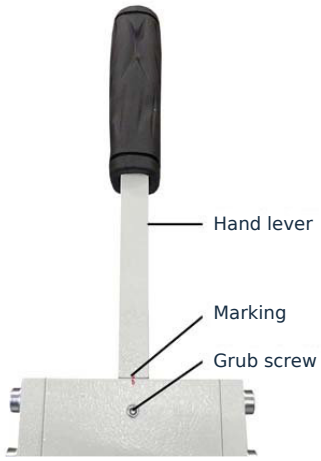


Setting up the machine

Place the machine on a stable surface, such as a worktop or desk.

Keep the shipping packaging for returning the machine for an overhaul at a later date.

02



Fitting the hand lever

Fit the hand lever.

Align the hand lever with the marking.

Tighten the grub screw using the supplied spanner.

NOTICE - Observe the marking

Observe the marking in the illustration when fitting and aligning the hand lever.

Operation and stops

01

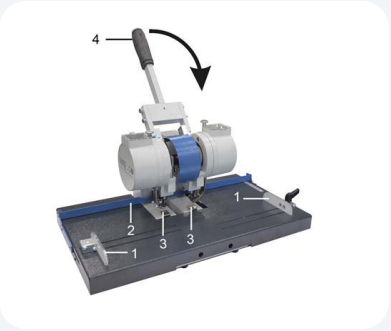


Fig. A

Inserting material and setting eyelets

Place the material against the stops [1] and [2], over the lower die [3].

Pull the hand lever [4] briskly forwards. Both eyelets are set.

Release the hand lever [4]. The spring returns it to its starting position.

NOTICE – Protect the dies

Operate the hand lever only with material inserted. Repeated eyelet setting without material can damage the dies.

02

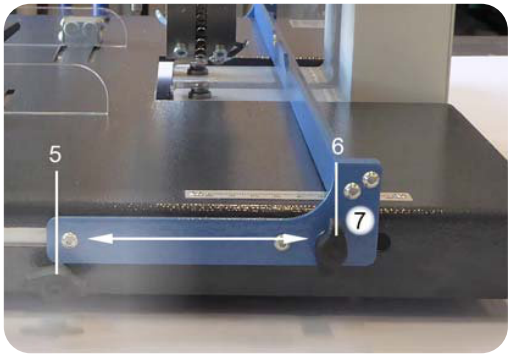


Fig. B

Adjusting the rear stop

Loosen the wing handle [5] and screw joint [6].

Move the rear stop to the required depth using the adjusting handle [7].

Retighten the wing handle [5] and screw connection [6].

03

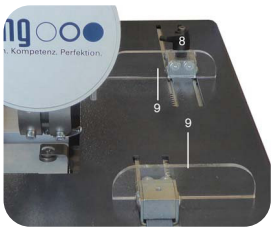


Fig. C

Adjusting the side stop

Loosen the clamping lever [8].

Move the side stop [9] to the required distance.

Retighten the clamping lever [8].

TIP - Check the result first

Before starting the job, set a test eyelet in a scrap piece. The force required varies with the eyelet size. The leverage makes setting easier.

Eyelets and setting pressure

01



Fig. D

Refilling eyelets

Loosen the knurled screw [13].

Turn the lid [12] to one side.

Fill both eyelet hoppers [11] to about **2/3 full.**

NOTICE – Use the correct eyelets

The machine is set up for a single eyelet size. Use only the specified eyelets. Incorrect eyelets can cause malfunctions or damage.

NOTE - Factory setting

The setting pressure is factory-set for **5 sheets with eyelet 272** and **10 sheets with eyelet 271.**

02

Adjusting the setting pressure

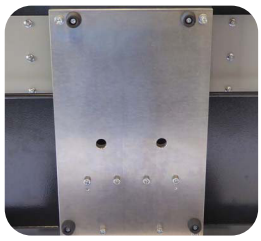


Fig. E

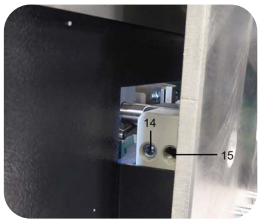


Fig. F

If the eyelets are set too loosely or too tightly, adjust the pressure via the lower die.

Lift the machine and lay it on its back (Fig. E).

Loosen the grub screw [14] using the supplied spanner.

Adjust the lower die using the grub screw [15].

Clamp it in place again using the grub screw [14] (Fig. F).

CAUTION - Lay the machine down safely

Carefully lay the machine on its back and secure it against slipping.

NOTE – Direction of rotation of grub screw [15]

More pressure: turn clockwise.
Less pressure: turn anticlockwise.

Replacing the lower die

CAUTION - Lay the machine down safely

Carefully lay the machine on its back and secure it against slipping.

01

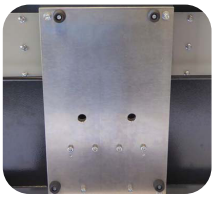


Fig. G

Laying the machine on its back

Lift the machine.

Carefully lay it on its back so that you can access the underside (Fig. G).

02 Swinging the stripper spring aside

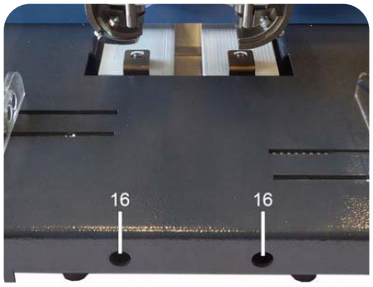


Fig. H · Hole [16]

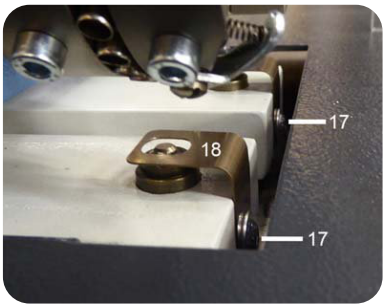


Fig. H · Clamping screw and stripper spring

Using the supplied socket spanner through the hole [16], loosen the clamping screw [17] of the stripper spring [18].

Swing the stripper spring [18] to one side.

03



Fig. I

Replacing the lower die

Loosen the clamping screw [19] of the lower die.

Insert a screwdriver through the hole [20] and push out the lower die.

Fit the new lower die in reverse order.

Upper die and eyelet feed

NOTE - Push the eyelet feed channel aside

Push the eyelet feed channel to one side for better access to the upper die.

01

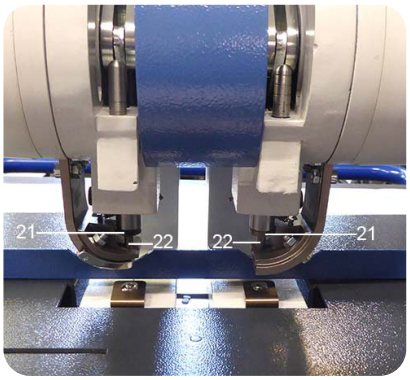


Fig. J

Replacing the upper die

Unscrew the upper die [21] using the supplied **SW12** open-ended spanner.

If the locating pin [22] is also being replaced, pull it downwards and out with pliers.

Insert the new locating pin through the new upper die.

Screw both together into the ram.

TIP – Completing the replacement

Set a test eyelet. Readjust the setting pressure if necessary (see page 4).

02 Clearing eyelet feed faults

Incorrect or defective eyelets, dirt and other foreign matter in the hopper or feed mechanism can disrupt operation. Worn bristles can also be the cause.

First empty the eyelet hoppers.

Remove the tension spring that pulls the eyelet feed channel towards the machine body.

Remove the eyelet hopper as described on page 7 (Fig. K to M).

Eliminate the cause of the fault.

Refit the eyelet hopper.

CAUTION – Preloaded spiral spring

During disassembly, observe the warnings on replacing the brush disc on page 7.

Replacing the brush disc

CAUTION – Preloaded spiral spring

The spiral spring is under tension. Proceed carefully during disassembly.

NOTE - Empty the eyelet hoppers

Empty the eyelet hoppers before disassembly to prevent eyelets from falling out.

01 Removing the cover and fasteners

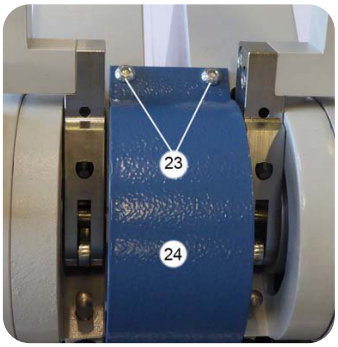


Fig. K

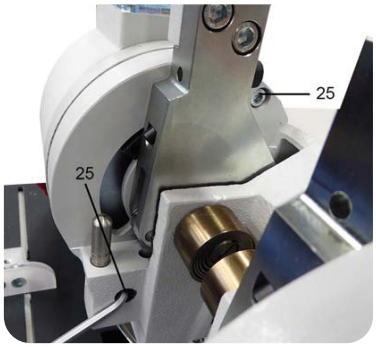


Fig. L

Loosen and remove the screws [23].

Remove the cover [24] (Fig. K).

Loosen and remove the screws [25] (Fig. L).

02 Removing the hopper and replacing the brush disc

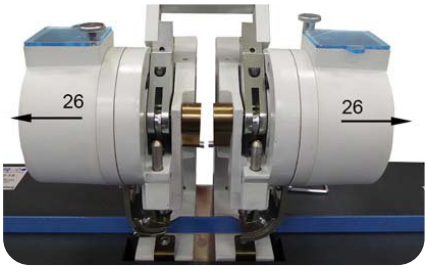


Fig. M

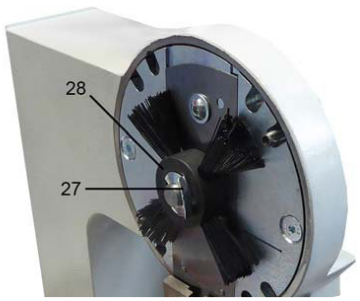


Fig. N

Pull off the eyelet hopper [26] (Fig. M).

Remove the retainer [27].

Pull off the brush disc [28] (Fig. N).

Fit the new brush disc and reassemble the parts in reverse order.

Cleaning and lubrication

01 Cleaning the machine

Clean the machine regularly.

Remove all dirt deposits, especially from the guide grooves of the eyelet feed mechanism.

02

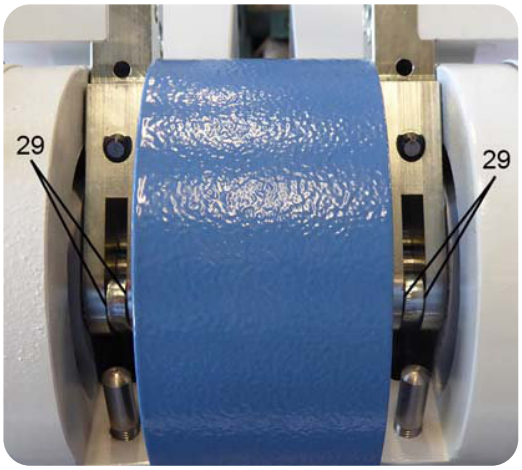


Fig. O

Oiling the lubrication points

If the machine is used daily, oil it **1× weekly.**

Using an oil can, carefully apply **1 drop of oil** to each lubrication point [29].

Wipe off excess oil with a cloth.

Suitable machine oils are listed on page 9.

03 Checking wear quarterly

Check the condition of the dies and brush disc **quarterly.**

Order replacements for worn parts using the spare parts list.

Routine maintenance comprises cleaning and lubrication.

Service and contact

Lubricant recommendation

Use one of the listed oils or an equivalent machine oil.

Brand	Machine oil
ARAL	Dural MR 68
BP	Energol EM 68
ESSO	Coray 68
SHELL	Carnea 68
MOBIL	Heavy Medium
DEA	Viscoma 68

TIP – Reordering eyelets and spare parts

When ordering, state the machine type and the eyelet size it is set up for. Eyelets and spare parts are available from oesen-de.de. Please also report any unclear points or errors in these instructions.

Statutory warranty: See the terms and conditions of oesen-de.de at www.oesen-de.de/agb.

Manufacturer and distributor

MANUFACTURER

Hang GmbH

Adolf-Safft-Str. 10
73037 Göppingen
Germany

DISTRIBUTOR

oesen-de.de | We have the solution!
Habichtstrasse 22
81827 München
Germany
Tel.: +49 8121 999 9 771
Fax: +49 89 999 50 921
Email: info@oesen-de.de
www.oesen-de.de

Liability notice

All information is provided without guarantee. Subject to technical changes, errors and misprints. Images may differ from the items supplied. The manufacturer’s specifications are authoritative. To the extent permitted by law, oesen-de.de accepts no liability for damage due to improper use, unauthorised modifications or failure to follow these instructions. Mandatory statutory liability remains unaffected.

Technical content and illustrations based on the manufacturer’s documentation, edited and designed by oesen-de.de. Version: October 2026.