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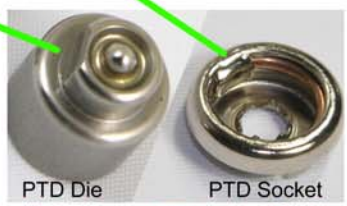
Instructions:
Professional Snap Setting Tools

For Use with MILSPEC Snap Components : MIL - MS27980-1N,6N,7N,8N, MIL - MS27981-1N, 3N, 4N, 5N MIL-MS27983-1N,2N,3N

Note Directional Notch ONLY on Directional "Pull the Dot" type snap components



Regular Size 24 Snaps (Standard Size) shown here

Before beginning, become familiarized with the with the four different snap components and their corresponding dies. Installing Snaps is easy but does require technique. We suggest that you practice on scrap material first before attempting to install on actual work piece. Removing snaps cleanly can be done by precise drilling with a power drill and drill bit (using a drill press is recommended), or very carefully with a pair of pliers. It is much easier to practice and perfect your installation technique rather than correcting mistakes later on the work piece.

IF using Directional ("Pull the Dot") type snaps Substitute the PTD Socket & PTD Socket Die (sold separately).All other dies remain the same for PTD Snap Components.Installation procedures for PTD snaps are the same EXCEPT for observing the directional notch on the PTD Socket to determine the pull direction.

1. Mark Location for holes on your material where snaps will be installed. After completing this step wear safety goggles for remaining steps

2. Punch holes for eyelet & button cap posts Use size 3 on our Rotary punch tool (sold separately) or use another method to cut or melt holes in the material about the same size as the post on the Eyelets. Snaps will not install properly without first making holes in material.

3. Attach correct dies for setting Eyelets & Studs.

4. Adjust Clearance using thumbscrew at handle of tool. When lever is fully closed dies should be touching each other lightly. Additional adjustment may be needed later if snaps are found to be installed too loosely. Clearance must be adjusted each time dies are changed

5. Seat the Stud in the Die When properly seated, the stud should be retained in the Stud die lightly. When viewed from the side only the edge of the base of the stud should be visable.

6. Seat the Eyelet in the Die Slip the eyelet into the retaining ring by pushing down on one side first then the other. When properly seated, the Eyelet should be retained by the rubber retaining ring as shown. Seat Both the Stud and Eyelet before crimping.

7. Crimp the Stud & Eyelet together. When properly crimped the Stud / Eyelet assembly should be tightly attached to the material. Spinning or shifting the stud should not be possible after crimping. If the Stud shifts or spins, align the tool back onto it and re-crimp it. Try re-adjusting the clearance by tightening the thumbscrew at the end of the handle after each re-crimp until the components are properly crimped. Don't over crimp.

8. Switch out the dies after installing Studs & Eylets. Dies should come out by hand if not, gently tap the eyelet die from the top with a mallet and small wooden dowl or metal rod. Use care when removing the stud die using a screw driver to wedge under the side, or by using a pair of pliers with tissue or cloth covering the jaws to avoid damaging the die.

9. Seat Socket & Button / Cap onto their corresponding dies. When properly seated the socket should lightly snap onto the top of the die. The Button / Cap is seated the same way the Eyelet gets seated: held in the rubber retaining ring. Seat Both the Socket and the Button / Cap in their dies before attempting to crimp onto the material.

10. Crimp Socket & Button / Cap Using the same procedure as crimping the Stud & Eyelet in Step 7. The Socket & Button / Cap should not spin when properly crimped.

This Section For PTD ("Pull The Dot") Type Snaps Only

This "DOP" ("Direction Of Pull") tab on bottom of PTD Socket determines the Direction of Pull. Be sure to align this tab to your desired Pull open direction.

AHH Form 135, Jan. 2010