

Crimp Style Button form Die Instructions

In order to make crimp style fabric button forms, you need Heavy Duty Grommet/Button press, **GL**, Button Die Adapter, **GLA**, as well as the proper size of cutting die and button die.

Cutting Fabric

Please refer to the Cutting Fabric Section on page 2 in Grommet/Button Form Hand Press Instructions. **You can cut up to 20 layers of medium heavy fabric at a time.** For delicate fabrics or when using larger size cutting dies, such as **GLA45/C** and **GLA60/C**, you may have to put a sheet of chipboard from Rowley Co., **Stk# GLC/P**, under your fabric to obtain a clean cut.

Making Crimp Style Button Forms (Setter Adapter, **GLA**, is required.)

Note: Make sure to use Heavy Button Form Die, **GLH/S**, for thick fabric, and Regular Button Form Die, **GLA/S**, for light and medium thick fabric. For very thin fabric, you should add a layer of interlining, **LN11**, to the back side of your fabric.

1. Take the Handle Extension off (see Figure 1). The force to make a crimp button form is small, and using a long handle could damage the button forms.
2. Lift the Moving Head to the top position and loosen the Nylon Bolt on the Moving Head. Screw the Setter Adapter completely into the Moving Head, put the Bottom Die at the base of the Press and the Top Die upside down on your work table as shown in Figure 2.
3. Drop the button back with wire loop facing down in the bottom die, and place a piece of the cut fabric on the Top Die, then center the shell on top of the fabric as shown in Figure 3.
4. While holding the shell firmly against the Top Die with push dowel, slide the outer part of the Top Die all the way up as shown in Figure 4a so that the shell and the cut fabric will be completely inside the outer part of the Top Die as shown in Figure 4b. **Make sure all fabric edges are inside the outer part of the Top Die as shown in Figure 4b.**
5. Turn the Top Die right side up and put it on top of the Bottom Die as shown in Figure 5.
6. Rotate the Press Handle clockwise to crimp the button form together. Rotate the press Handle counterclockwise to lift moving head to its top position, take the top die out, and a button is made as shown in Figure 6.

Note: Press harder if the button form is not crimped fully, and press lighter if the button form is over crimped.

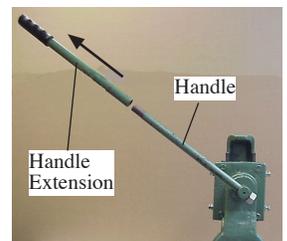


Figure 1. Press Handle

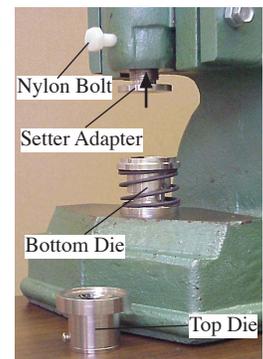


Figure 2

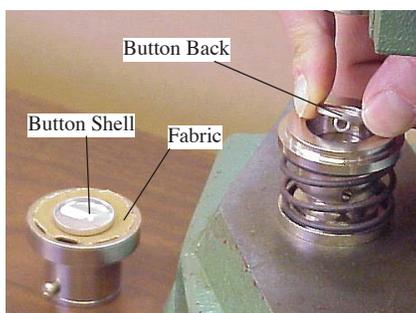


Figure 3

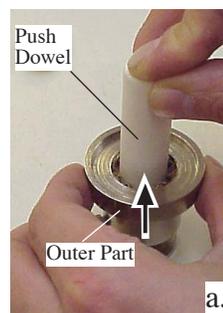


Figure 4



Figure 5



Figure 6