

Tecre Company, Inc.

Model 600 Button Maker Machine and Button Making Supplies: How to Use the Clock Punch to Make a Clock Button

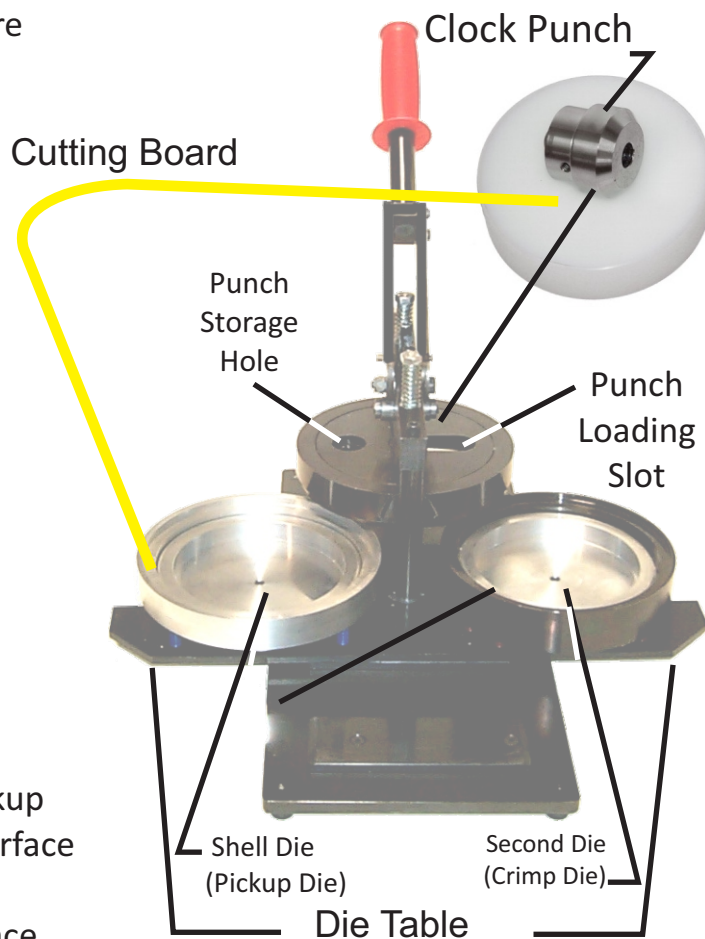
When not in use, the button punch is stored in the punch storage hole as illustrated in the picture at the right.

To punch a hole through a finished button, the punch is removed from its storage position and moved to the opposite side of the top of the button maker machine and placed into the punch loading slot as indicated. Then slide the punch in the slot toward the center of the button maker as far as it will to position it under the press frame. In this position the punch is ready to make a hole in a button for installation of a clock body.

Place the cutting block into the pickup die. The cutting block is sized so that no matter where it rests in the die, a portion of it will support the underside of the button where the punch penetrates it. Because the top surface of the cutting block suffers some damage from the punch every time it is used, its random position in the pickup die permits the damage to occur all over the top surface thereby maximizing its useful life.

With the punch and cutting block in position, place the finished button into the pickup die over the cutting block. Then rotate the die table so the button is under the upper die. The press handle can then be stroked to punch the hole. It is not necessary to force the handle all the way to its lower limit of its travel to complete the hole. With some experience the operator will feel the punch break through the button before the handle is all the way down. By stopping at this point and returning the handle to the top of the stroke, deterioration of the cutting block and distortion of the button near the hole will be minimized.

After punch the hole remove the punch from the slot and return it to its punch storage hole. In the process of doing so tip the punch upside down to discard any loose pieces from inside the punch. It is very important to avoid having any of these small round pieces of mylar, paper, and metal get into the dies as they can jam the dies and prevent them from operating. Before making the next button be sure to remove the cutting block from the pickup die.



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