

# HANDLER

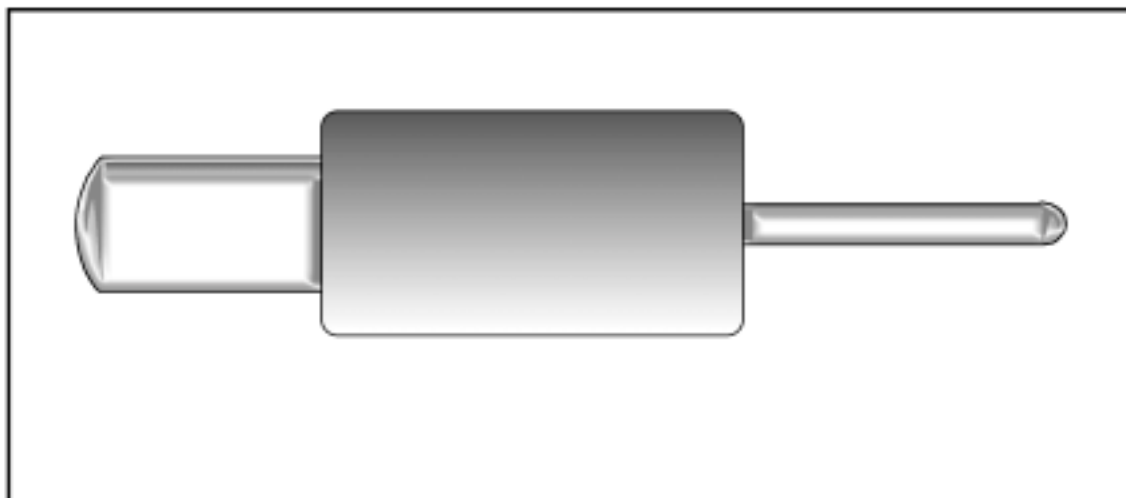


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## #21 CROWN SWAGER OPERATING MANUAL

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**IMPORTANT INSTRUCTIONS  
DO NOT DISCARD**



**HANDLER** 

*Over Eighty Years of Quality Manufacturing and Service...*

**MANUFACTURING CO., INC.**

612 NORTH AVENUE EAST, WESTFIELD, N.J. 07090

Ph: (908) 233-7796 • Fax: (908) 233-7340 • 800-27-HANDL • E-Mail: info@handlermfg.com • web site: www.handlermfg.com

## **INSTRUCTIONS FOR USE OF #21 CROWN SWAGER**

Thank you for purchasing the Handler #21 Crown Swager. Open the package and inspect its contents. The "Crown Swager" has been inspected prior to being shipped. Should damage have occurred in transit, contact the freight forwarder immediately. Do not contact the shipper as the receiver of a product must file a damage claim if necessary.

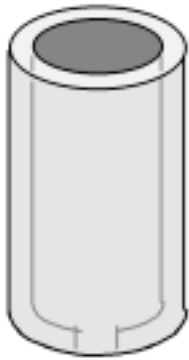
Be certain to note any damage which may have occurred, and report it promptly to the forwarder. Failure to file a claim in a timely manner could result in the loss of your rights of recovery for possible damages. Should you require assistance, please contact Handler Manufacturing at: 1-908-233-7796 or 1-800-274-2635.

### **STEPS:**

1. Fill concave die holder with a blackout compound type of material.
2. Place die with the foil in place in the center of a piece of plastic wrap so the ends of the plastic wrap can be twisted around the dowel pin or tail piece of die.
3. Position the wrapped die into the concave die holder with the dowel pin or tail piece embedded into the compound enough to hold the die in a vertical position.
4. Place the blank disk in the bottom of the compression cylinder.
5. Place the concave die holder with die in position into the inner chamber of the compression cylinder, with the die in the upright position.
6. Fill the compression cylinder with swagging (blockout) compound to at least 1" above the top of the die. Slide the swagging cylinder concave end first into the compression cylinder, which contains the swagging compound.
7. Drive the swagging cylinder into the compression cylinder with the aid of a rubber or fiber hammer. This may take 5 - 7 strokes. This will swag the foil around and to the prepared area of the die. Additional strokes of the hammer may be necessary to complete this procedure.
8. Remove swagging cylinder. Insert the ejection rod through the hole in the bottom of the compression cylinder. Push against the blank disc to remove the concave die holder containing the swagged die. Push both the blank disc and the die holder from the compression cylinder.
9. Remove compound and plastic wrap from swagged die.
10. The foil matrix is ready for the next procedure.

# HANDLER

MANUFACTURING COMPANY, INC.



Compression  
Cylinder  
#21-01



Swagging  
Cylinder  
#21-02



Concave  
Die Holder  
#21-03



Blank  
Disk  
#21-04



Ejector  
Rod  
#21-05

